FLENDER DRAWING **F2E00754146A**

Minimum V-Block Gap for ⌀120mm diameter = 250 mm

G56

⌀130mm side

$11^{+0.2}_{-0.0}$

$32^{+0.0}_{-0.062}$

G54

⌀110mm side

$10^{+0.2}_{-0.0}$

$28^{+0.0}_{-0.052}$

G56 Gauge:

$31.94 = 1.44 + 10 + 20.5$

G54 Gauge:

$27.95 = 1.44 + 10.5 + 16$

TOLERANCE

Side	130mm - G56		110mm - G54	
	Actual	Tolerance	Actual	Tolerance
Width	32	+0 / -0.062	28	+0 / -0.052
Depth	11	+0.2 / -0	10	+0.2 / -0
Length	152		195	
Symmetry		0.055		0.055
Reference	17		7.5	
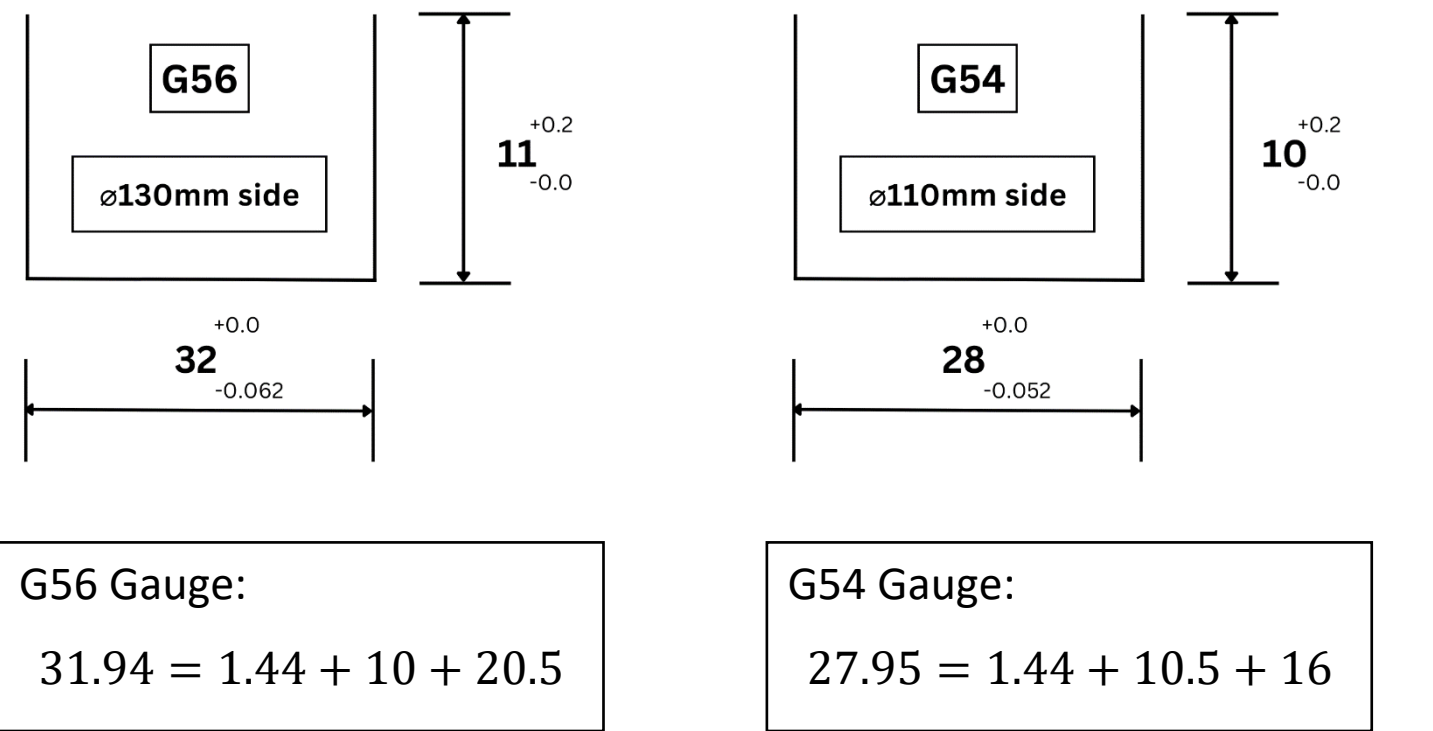
G56: ⌀130mm side – CLOSED SLOT (Left side)
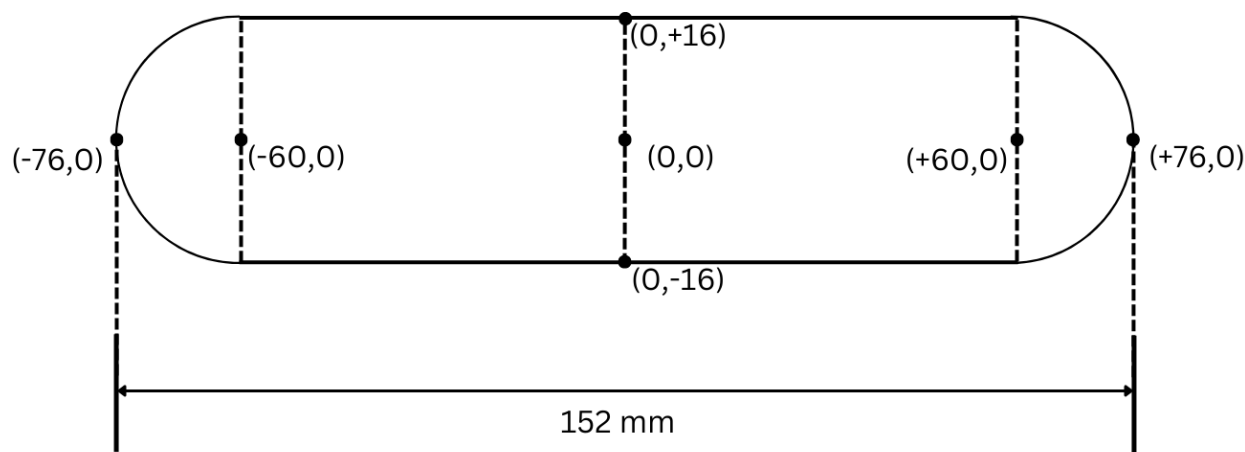
Drawing Reference	17 mm
Centre Distance from reference Collar	59 mm
Centre Distance from reference slot Edge	76 mm

G54: ⌀110mm side – CLOSED SLOT (Right side)
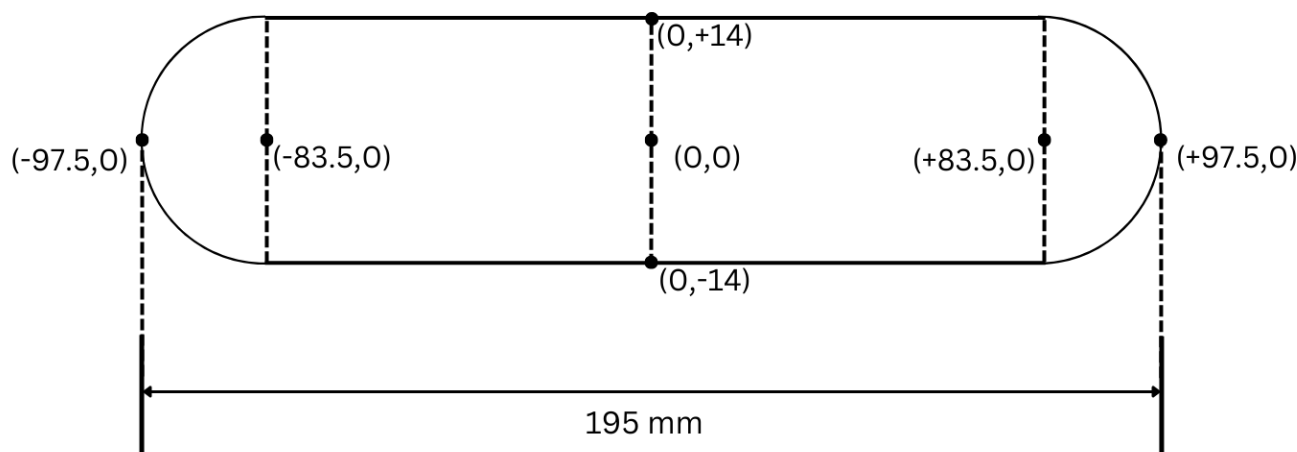
Drawing Reference	7.5 mm
Centre Distance from reference Collar	105 mm
Centre Distance from reference slot Edge	97.5 mm

OFFSETS

NUMBER	TOOL	SIDE	H LOCATION	D LOCATION
13	Marking Pencil	G56	H125	Not Required for Checking
13	Marking Pencil	G54	H126	Not Required for Checking
14	⌀26.5mm Insert DRILL	G56	H127	Not Required for Drilling
14	⌀26.5mm Insert DRILL	G54	H128	Not Required for Drilling
15	⌀25mm CUTTER (16mm Insert)	G56	H129	Not Required for Slotting
15	⌀25mm CUTTER (16mm Insert)	G54	H130	Not Required for Slotting
16	⌀25mm CUTTER (9mm Insert)	G56	H131	D131 = 13.0
16	⌀25mm CUTTER (9mm Insert)	G54	H132	D132 = 13.0
17	⌀16mm SC ENDMILL	G56	H133	D133 = 8.4
17	⌀16mm SC ENDMILL	G54	H134	D134 = 8.4
17	⌀16mm SC ENDMILL	G56	Not Required for Finishing	**D135** = 8.2
17	⌀16mm SC ENDMILL	G54	Not Required for Finishing	**D136** = 8.2

PROGRAMMING

O1461	Checking

* Check if Pencil Marking Tool is stopping at the edge of the Reference Collar. If not, please stop program and re-measure centre distance (x axis).

Program will stop before every tool dip to 1mm. Measure Z centring here if needed.
If any tool touches the job body, H value (height compensation) is deviating by more than 1mm. Please rectify the tool height and try again.

O1462	Roughing

Please **MEASURE SYMMETRY** after completion. If symmetry deviation is **30-micron** or more, shift Y-axis as required.
Only reduce tool radius after width measurement. Radius reduction will be according to stock material remaining.

O1463		Finishing	
G56	H133	**D135**	R = 8.2
G54	H134	**D136**	R = 8.2

Please **CHECK SLIP GAUGE AFTER G56** side completes. In case of deviation, stop program and report.
Slip gauge must go fully inside the keyway to pass. Reduce radius accordingly.

O1464	Depth

Depth slotting for middle bar with 16mm Diameter SC End-Mill.

CHECKLIST

O1462		Roughing		
Operation	Side	H Offset	D offset	Radius
Collar cut	G56	H131	**O1469**	
Drilling	G56	H127	Not Required for Drilling	
	G54	H128		
Slotting	G56	H129	Not Required for Slotting	
	G54	H130		
Semi roughing	G56	H131	**O1468**	
	G54	H132	**O1467**	
Semi finishing	G56	H133	D133	R = 8.4
	G54	H134	D134	R = 8.4

O1463		Finishing		
Operation	Side	H Offset	D offset	Radius
Wall finish	G56	H133	**D135**	R = 8.2
	G54	H134	**D136**	R = 8.2

O1464		Depth		
Operation	Side	H Offset	D offset	Radius
Depth finish	G56	H133	Not Required for Depth cut	
	G54	H134		

O1467		Semi Roughing		
Operation	Side	H Offset	D offset	Radius
Sub-program	**G54**		D132	R = 13.0

O8268		Semi Roughing		
Operation	Side	H Offset	D offset	Radius
Sub-program	**G56**		D131	R = 13.0

O8269		Collar Cut		
Operation	Side	H Offset	D offset	Radius
Sub-program	G56		D131	R = 13.0