FLENDER DRAWING **F2E00373225A**

Minimum V-Block Gap for ⌀190mm diameter = 280 mm

G56

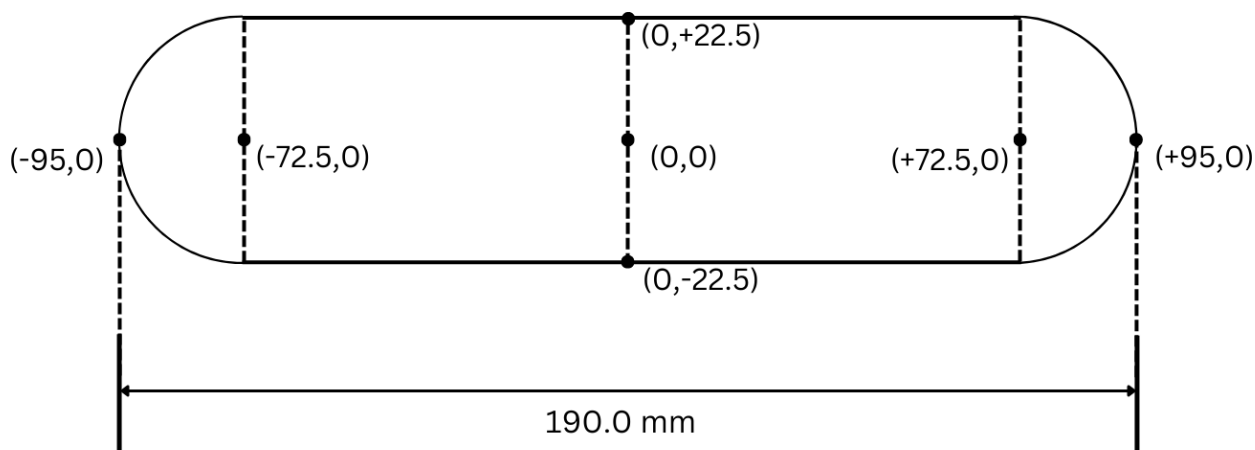⌀195mm side

$15\ ^{+0.3}_{-0.0}$

$45\ ^{+0.0}_{-0.062}$

G54

⌀160mm side

$13\ ^{+0.3}_{-0.0}$

$40\ ^{+0.0}_{-0.062}$

G56 Gauge:

$44.94 = 1.44 + 20 + 23.5$

G54 Gauge:

$39.94 = 1.44 + 18 + 20.5$
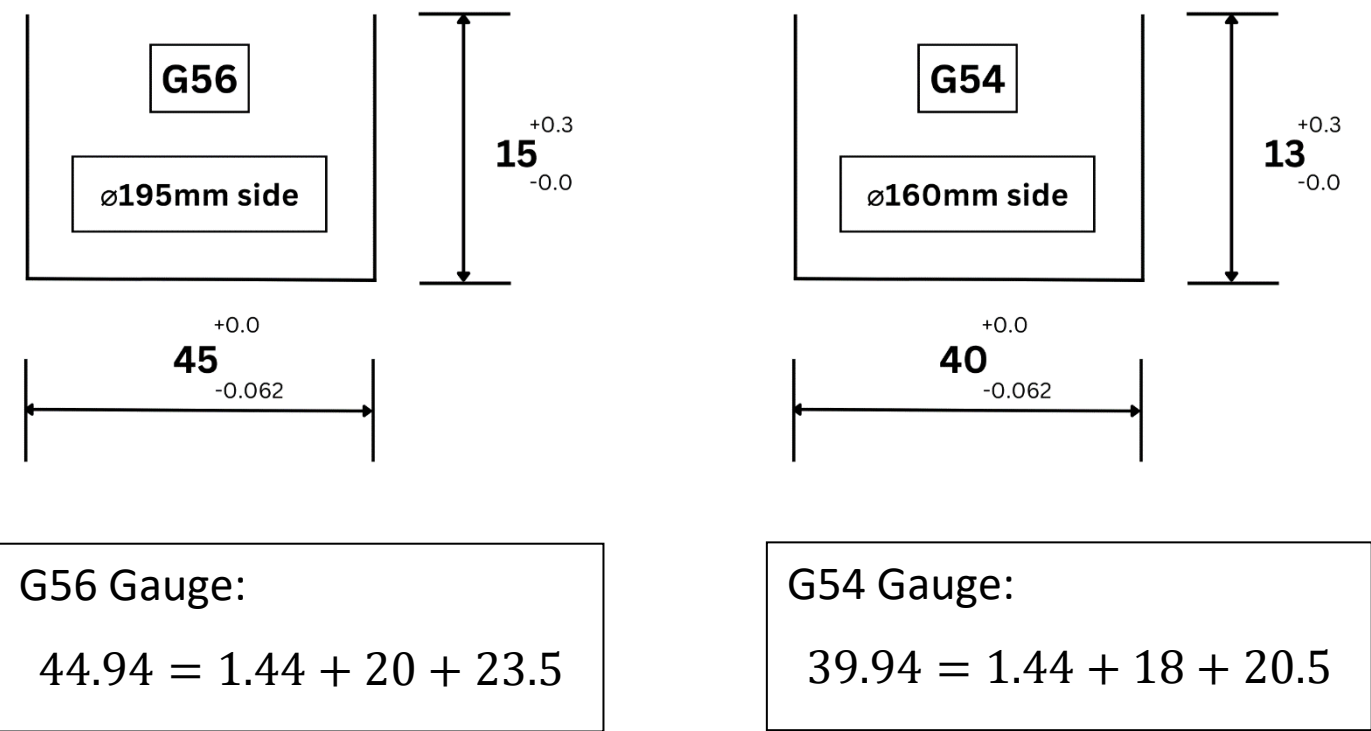
G54: ⌀160mm side – OPEN SLOT (Right side)

(0,+20)

(-156.25,0)   (-136.25,0)   (0,0)   (+136.25,0)

(0,-20)

292.5 mm
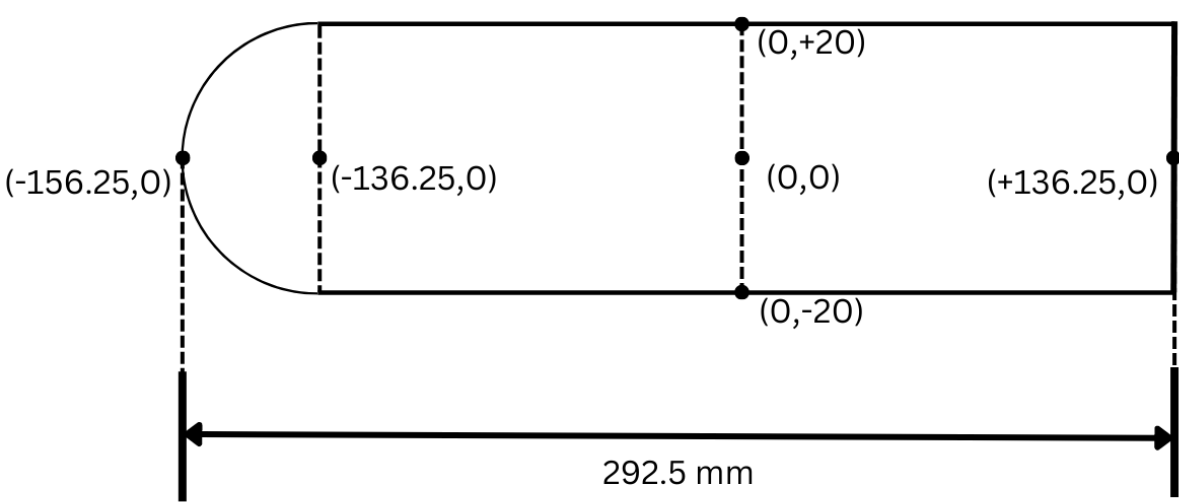
⇒ Drawing Reference = 7.5 mm
⇒ Centre distance from left collar = 163.75 mm

G56: ⌀195mm side – CLOSED SLOT (Left side)

⇒ Drawing Reference = 23.5 mm

⇒ Centre distance from right collar = 71.5 mm

OFFSETS

NUMBER	TOOL	SIDE	H LOCATION	D LOCATION
14	⌀26.5mm Insert DRILL	G56	H260	Not Required for Drilling
		G54	H261	
15	⌀25mm CUTTER (16mm Insert)	G56	H262	Not Required for Slotting
		G54	H263	
16	⌀25mm CUTTER (9mm Insert)	G56	H264	D264 = 13.0
		G54	H265	D265 = 13.0
17	⌀16mm SC ENDMILL	G56	H266	D266 = 8.4
		G54	H267	D267 = 8.4
		G56	Not Required for Finishing	**D268** = 8.2
		G54		**D269** = 8.2

PROGRAMMING

O2251	Checking

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.

O2252	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.

O2253		Finishing	
G56	H266	**D268**	R = 8.2
G54	H267	**D269**	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.

O2254	Depth

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

TOLERANCE

Side	195mm - G56		160mm - G54	
	Actual	Tolerance	Actual	Tolerance
Width	45	+0 / -0.062	40	+0 / -0.062
Depth	15	+0.3 / -0	13	+0.3 / -0
Length	190		292.5	
Symmetry				
Reference	23.5		7.5	

CHECKLIST

O2252		Roughing		
Operation	Side	H Offset	D offset	Radius
Collar cut	G56	H264	D264	R = 13.0
Drilling	G56	H260	Not Required	
	G54	H261		
Slotting	G56	H262		
	G54	H263		
Semi roughing	G56	H264	D264	R = 13.0
	G54	H265	D265	R = 13.0
Semi finishing	G56	H266	D266	R = 8.4
	G54	H267	D267	R = 8.4

O2253		Finishing		
Operation	Side	H Offset	D offset	Radius
Wall finish	G56	H266	**D268**	R = 8.2
	G54	H267	**D269**	R = 8.2

O2254		Depth		
Operation	Side	H Offset	D offset	Radius
Depth finish	G56	H266	Not Required	
	G54	H267		