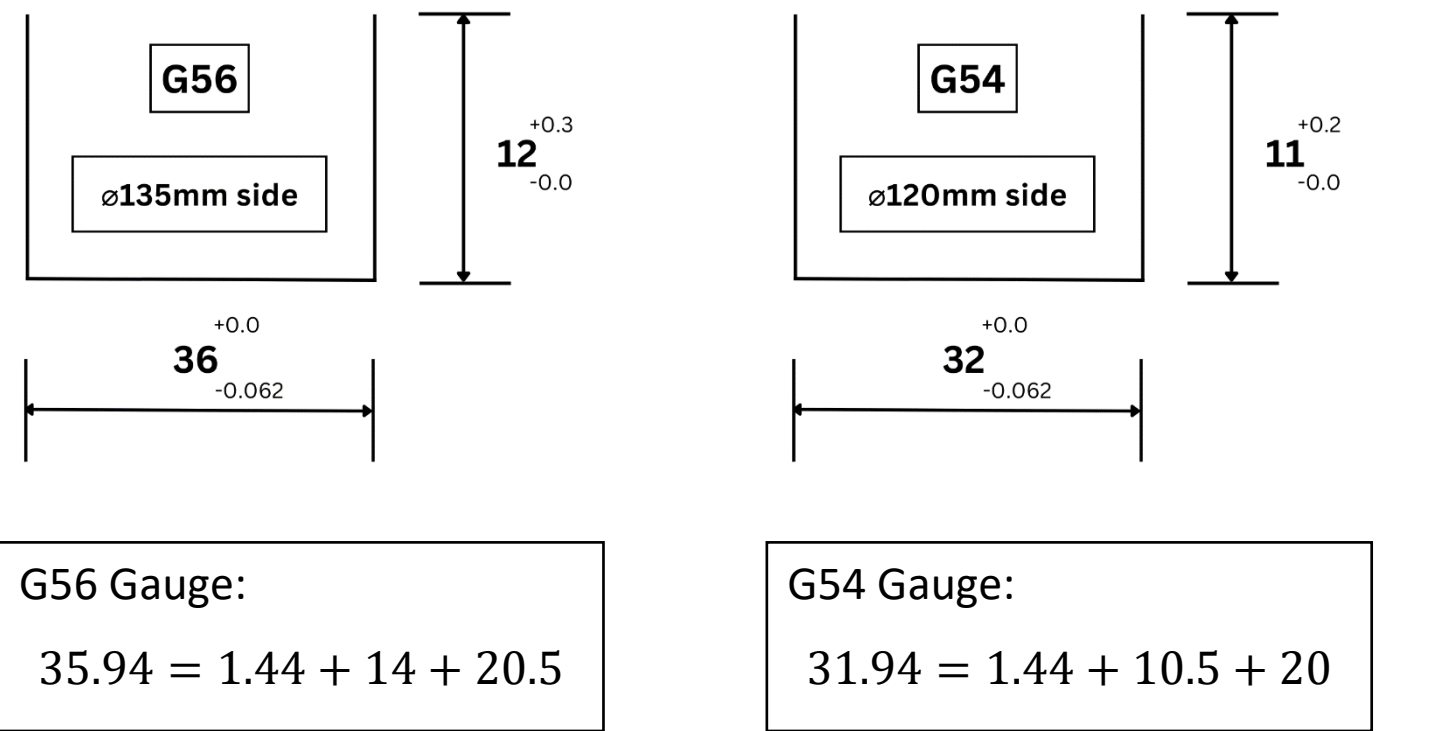


FLENDER DRAWING 5876656

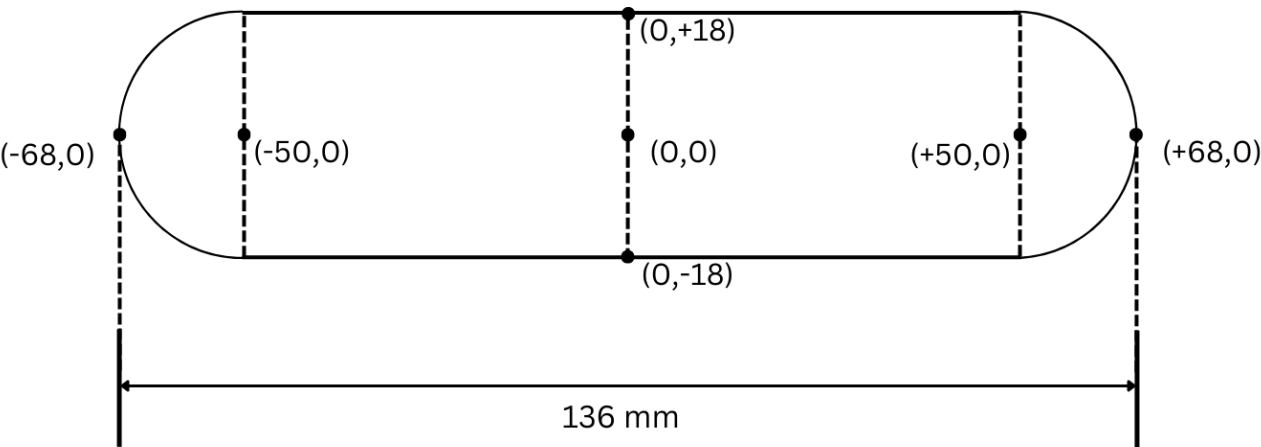
Minimum V-Block Gap for $\varnothing 130\text{mm}$ diameter = 180 mm



TOLERANCE

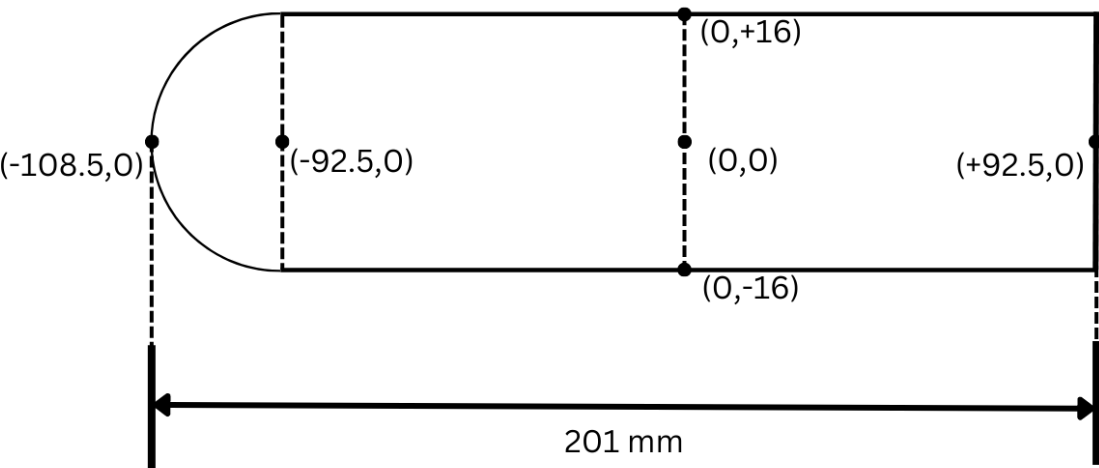
Side	135mm - G56		120mm - G54	
	Actual	Tolerance	Actual	Tolerance
Width	36	+0 / -0.062	32	+0 / -0.062
Depth	12	+0.3 / -0	11	+0.2 / -0
Length	136		201	
Symmetry		0.055		0.064
Reference	19		9	

G56: Ø135mm side – CLOSED SLOT (Left side)



Drawing Reference	19 mm
Centre Distance from reference Collar	49 mm
Centre Distance from reference slot Edge	68 mm

G54: Ø120mm side – OPEN SLOT (Right side)



Drawing Reference	9 mm
Centre Distance from reference Collar	117.5 mm
Centre Distance from reference slot Edge	108.5 mm

OFFSETS

NUMBER	TOOL	SIDE	H LOCATION	D LOCATION
13	Marking Pencil	G56	H340	Not Required for Checking
		G54	H341	
14	ø26.5mm Insert DRILL	G56	H342	Not Required for Drilling
		G54	H343	
15	ø25mm CUTTER (16mm Insert)	G56	H344	Not Required for Slotting
		G54	H345	
16	ø25mm CUTTER (9mm Insert)	G56	H346	D346 = 13.0
		G54	H347	D347 = 13.0
17	ø16mm SC ENDMILL	G56	H348	D348 = 8.4
		G54	H349	D349 = 8.4
		G56	Not Required for Finishing	D350 = 8.2
		G54		D351 = 8.2

PROGRAMMING

O6561	Checking
<p>* 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).</p> <p>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.</p>	

O6562	Roughing
<p>Please MEASURE SYMMETRY after completion. If symmetry deviation is 30-micron or more, shift Y-axis as required.</p> <p>Only reduce tool radius after width measurement. Radius reduction will be according to stock material remaining.</p>	

O6563		Finishing	
G56	H348	D350	R = 8.2
G54	H349	D351	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.			

O6564	Depth
Depth slotting for middle bar with 16mm Diameter SC End-Mill.	

CHECKLIST

O6562		Roughing		
Operation	Side	H Offset	D offset	Radius
Collar cut	G56	H346	O6569	
Drilling	G56	H342	Not Required for Drilling	
	G54	H343		
Slotting	G56	H344	Not Required for Slotting	
	G54	H345		
Semi roughing	G56	H346	O6568	
	G54	H347	O6567	
Semi finishing	G56	H348	D348	R = 8.4
	G54	H349	D349	R = 8.4

O6563		Finishing		
Operation	Side	H Offset	D offset	Radius
Wall finish	G56	H348	D350	R = 8.2
	G54	H349	D351	R = 8.2

O6564		Depth		
Operation	Side	H Offset	D offset	Radius
Depth finish	G56	H348	Not Required for Depth cut	
	G54	H349		

O6567		Semi Roughing		
Operation	Side	H Offset	D offset	Radius
Sub-program	G54		D347	R = 13.0

O6568		Semi Roughing		
Operation	Side	H Offset	D offset	Radius
Sub-program	G56		D346	R = 13.0

O6569		Collar Cut		
Operation	Side	H Offset	D offset	Radius
Sub-program	G56		D346	R = 13.0