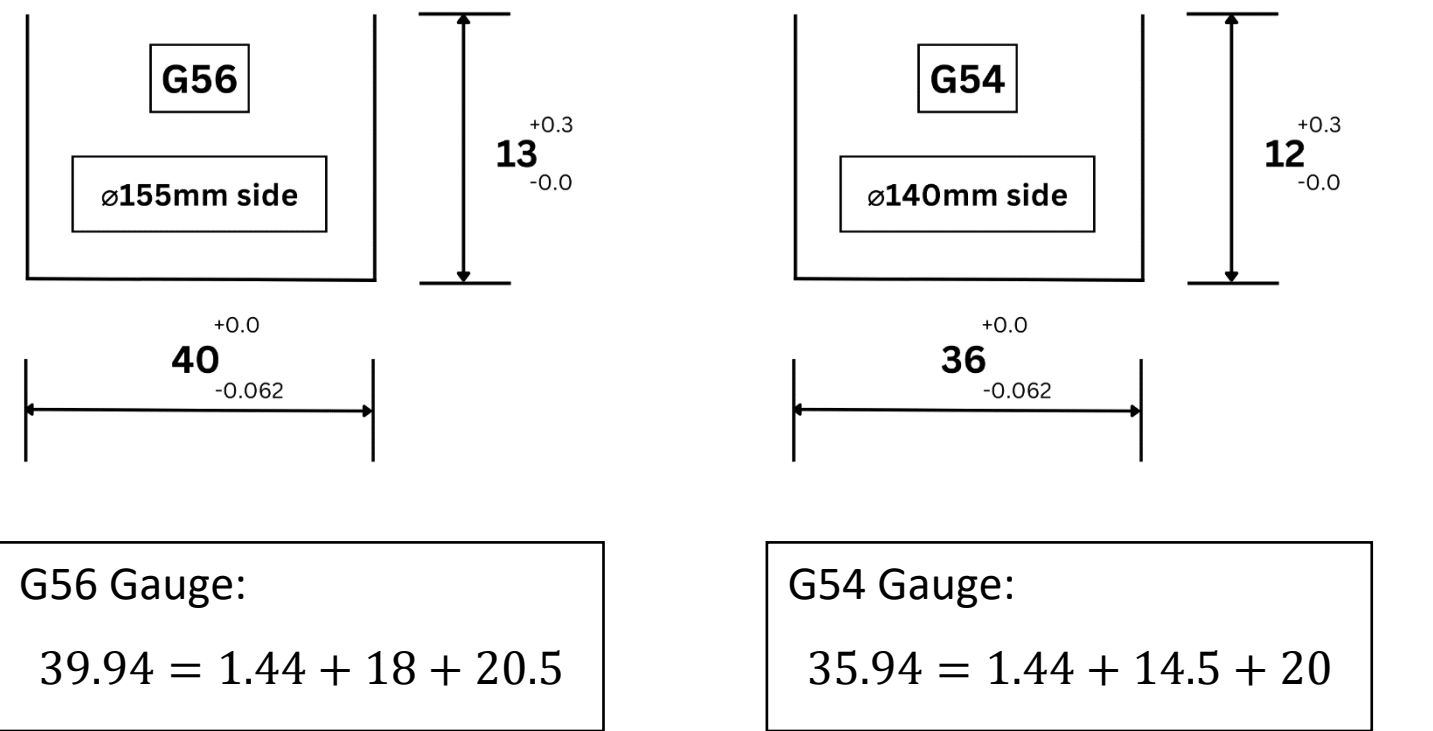


FLENDER DRAWING 5876658

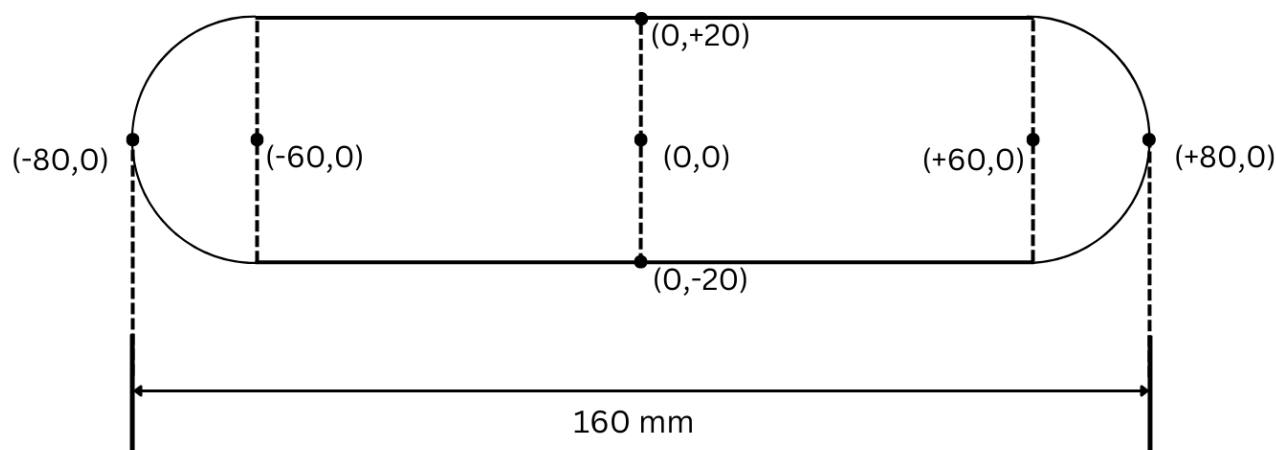
Minimum V-Block Gap for $\varnothing 140\text{mm}$ diameter = 355 mm



TOLERANCE

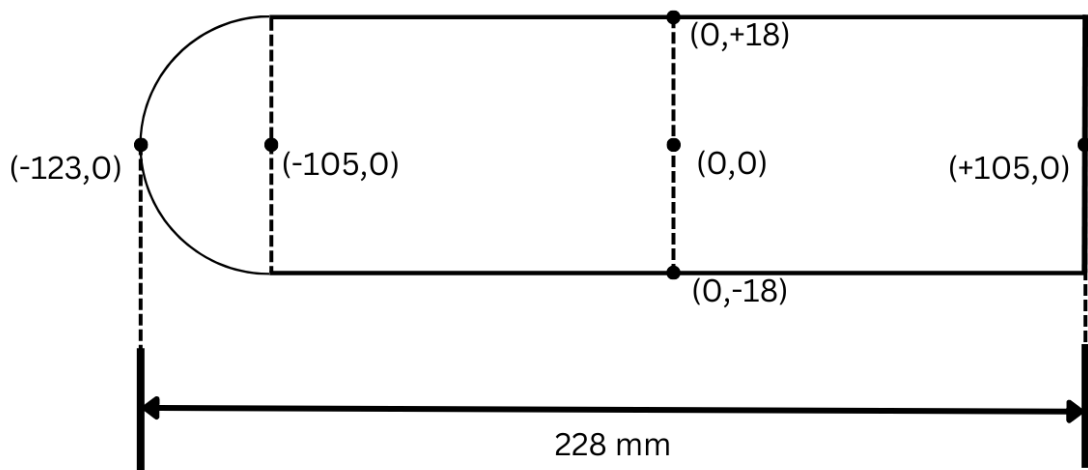
Side	155mm - G56		140mm - G54	
	Actual	Tolerance	Actual	Tolerance
Width	40	+0 / -0.062	36	+0 / -0.062
Depth	13	+0.3 / -0	12	+0.3 / -0
Length	160		228	
Symmetry		0.070		0.066
Reference	21		22	

G56: Ø155mm side – CLOSED SLOT (Left side)



Drawing Reference	21 mm
Centre Distance from reference Collar	59 mm
Centre Distance from reference slot Edge	80 mm

G54: Ø140mm side – OPEN SLOT (Right side)



Drawing Reference	22 mm
Centre Distance from reference Collar	145 mm
Centre Distance from reference slot Edge	123 mm

OFFSETS

NUMBER	TOOL	SIDE	H LOCATION	D LOCATION
13	Marking Pencil	G56	H325	Not Required for Checking
		G54	H326	
14	ø26.5mm Insert DRILL	G56	H327	Not Required for Drilling
		G54	H328	
15	ø25mm CUTTER (16mm Insert)	G56	H329	Not Required for Slotting
		G54	H330	
16	ø25mm CUTTER (9mm Insert)	G56	H331	D331 = 13.0
		G54	H332	D332 = 13.0
17	ø16mm SC ENDMILL	G56	H333	D333 = 8.4
		G54	H334	D334 = 8.4
		G56	Not required for Finishing	D335 = 8.2
		G54		D336 = 8.2

PROGRAMMING

O6581	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>	

O6582	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>	

O6583		Finishing	
G56	H333	D335	R = 8.2
G54	H334	D336	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.			

O6584	Depth
Depth slotting for middle bar with 16mm Diameter SC End-Mill.	

CHECKLIST

O6582		Roughing		
Operation	Side	H Offset	D offset	Radius
Collar cut	G56	H331	O6589	
Drilling	G56	H327	Not Required	
	G54	H328		
Slotting	G56	H329		
	G54	H330		
Semi roughing	G56	H331	O6588	
	G54	H332	O6587	
Semi finishing	G56	H333	D333	R = 8.4
	G54	H334	D334	R = 8.4

O6583		Finishing		
Operation	Side	H Offset	D offset	Radius
Wall finish	G56	H333	D335	R = 8.2
	G54	H334	D336	R = 8.2

O6584		Depth		
Operation	Side	H Offset	D offset	Radius
Depth finish	G56	H333	Not Required	
	G54	H334		

O6587		Semi Roughing		
Operation	Side	H Offset	D offset	Radius
Sub-program	G54		D332	R = 13.0

O6588		Semi Roughing		
Operation	Side	H Offset	D offset	Radius
Sub-program	G56		D331	R = 13.0

O6589		Collar Cut		
Operation	Side	H Offset	D offset	Radius
Sub-program	G56		D331	R = 13.0