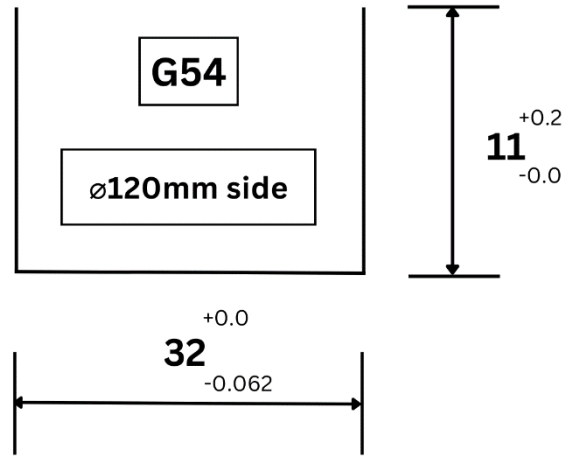
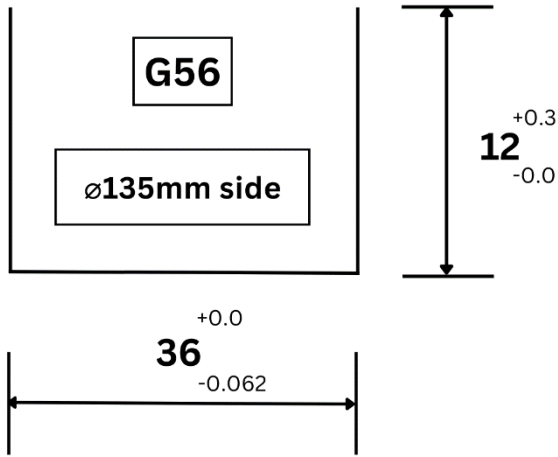


FLENDER DRAWING 5876622

Minimum V-Block Gap for $\varnothing 130\text{mm}$ diameter = 260 mm



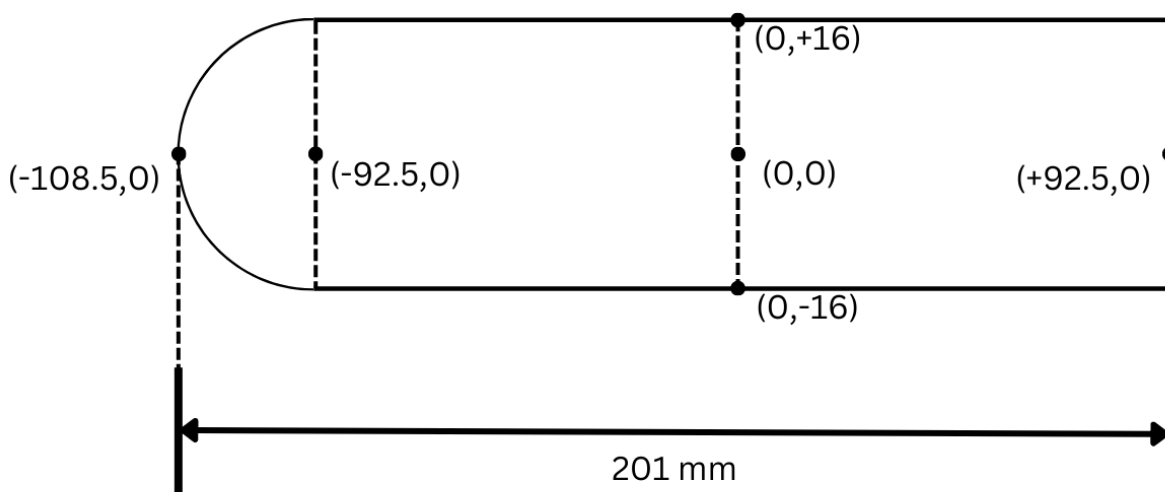
G56 Gauge:

$$35.94 = 1.44 + 14 + 20.5$$

G54 Gauge:

$$31.94 = 1.44 + 10.5 + 20$$

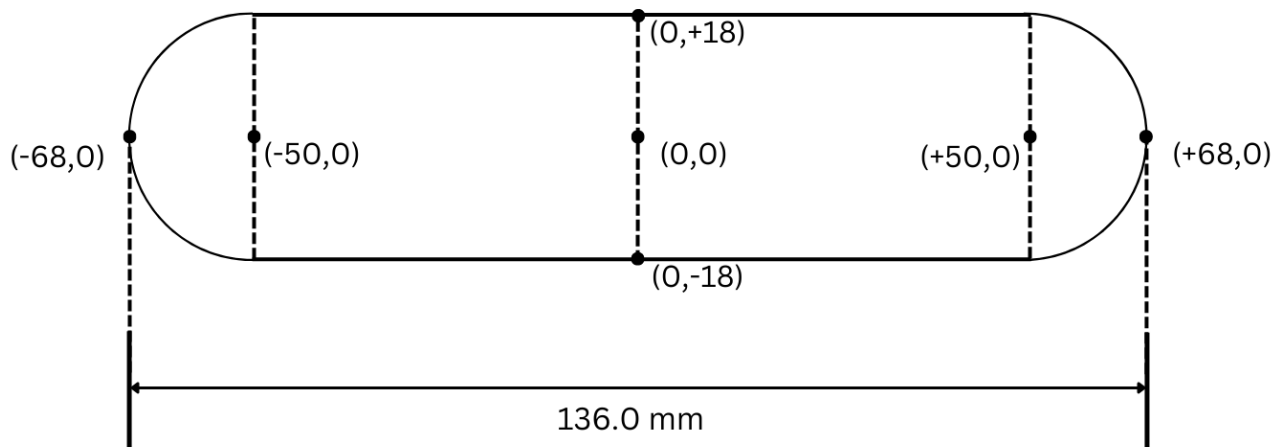
G54: $\varnothing 120\text{mm}$ side – OPEN SLOT (Right side)



⇒ Drawing Reference = 9 mm

⇒ Centre distance from left collar = 117.5 mm

G56: Ø135mm side – CLOSED SLOT (Left side)



⇒ Drawing Reference = 19 mm

⇒ Centre distance from right collar = 49 mm

OFFSETS

NUMBER	TOOL	SIDE	H LOCATION	D LOCATION
14	ø26.5mm Insert DRILL	G56	H300	Not Required for Drilling
		G54	H301	
15	ø25mm CUTTER (16mm Insert)	G56	H302	Not Required for Slotting
		G54	H303	
16	ø25mm CUTTER (9mm Insert)	G56	H304	D304 = 13.0
		G54	H305	D305 = 13.0
17	ø16mm SC ENDMILL	G56	H306	D306 = 8.4
		G54	H307	D307 = 8.4
		G56	Not Required for Finishing	D308 = 8.2
		G54		D309 = 8.2

PROGRAMMING

O6221	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.	

O6222	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.	

O6223		Finishing	
G56	H306	D308	R = 8.2
G54	H307	D309	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.			

O6224	Depth
Depth slotting for middle bar with 16mm Diameter SC End-Mill.	

TOLERANCE

Side	195mm - G56		160mm - 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	

CHECKLIST

O6222		Roughing		
Operation	Side	H Offset	D offset	Radius
Collar cut	G56	H304	D304	R = 13.0
Drilling	G56	H300	Not Required	
	G54	H301		
Slotting	G56	H302		
	G54	H303		
Semi roughing	G56	H304	D304	R = 13.0
	G54	H305	D305	R = 13.0
Semi finishing	G56	H306	D306	R = 8.4
	G54	H307	D307	R = 8.4

O6223		Finishing		
Operation	Side	H Offset	D offset	Radius
Wall finish	G56	H306	D308	R = 8.2
	G54	H307	D309	R = 8.2

O6224		Depth		
Operation	Side	H Offset	D offset	Radius
Depth finish	G56	H306	Not Required	
	G54	H307		