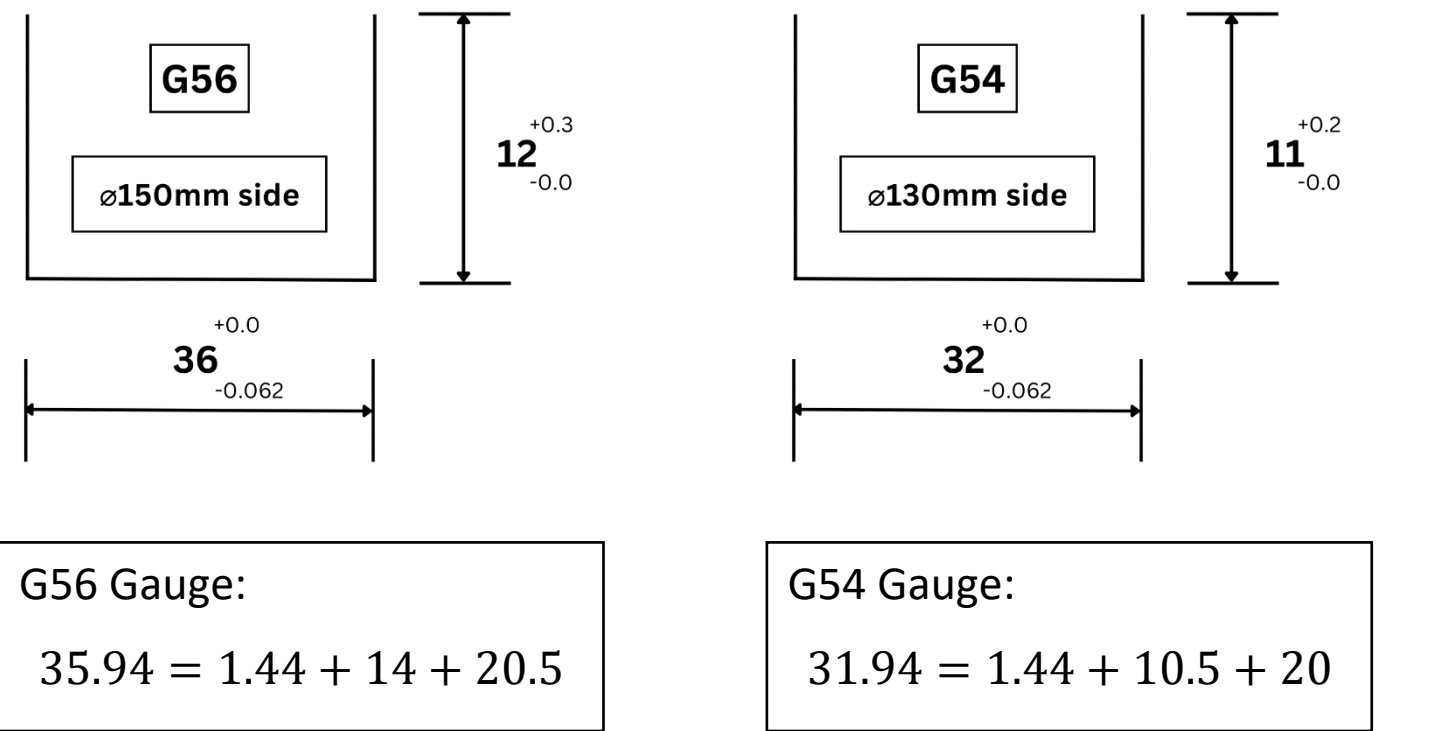


FLENDER DRAWING A5E40819146A

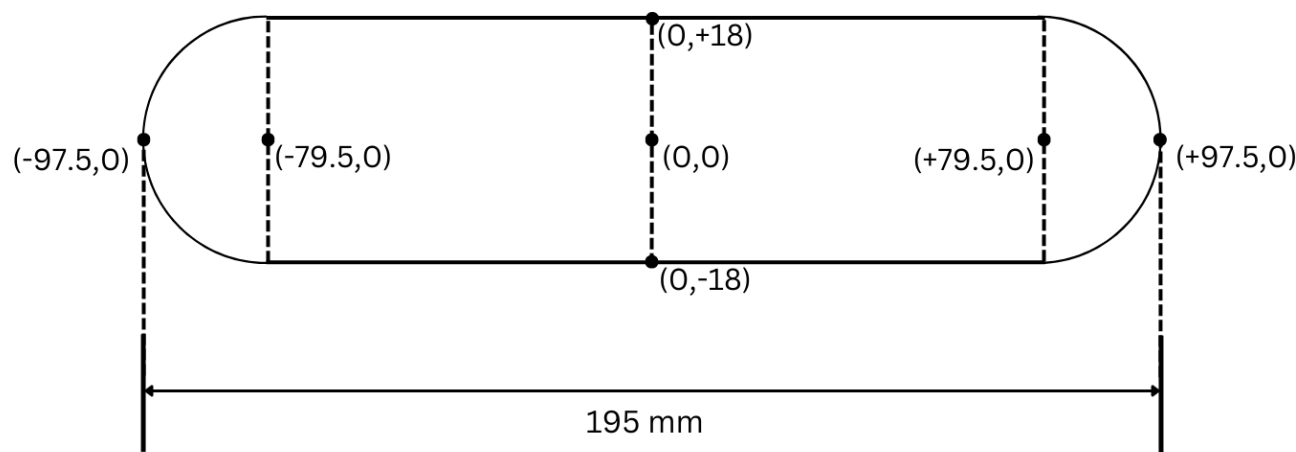
Minimum V-Block Gap for $\varnothing 140\text{mm}$ diameter = 330 mm



TOLERANCE

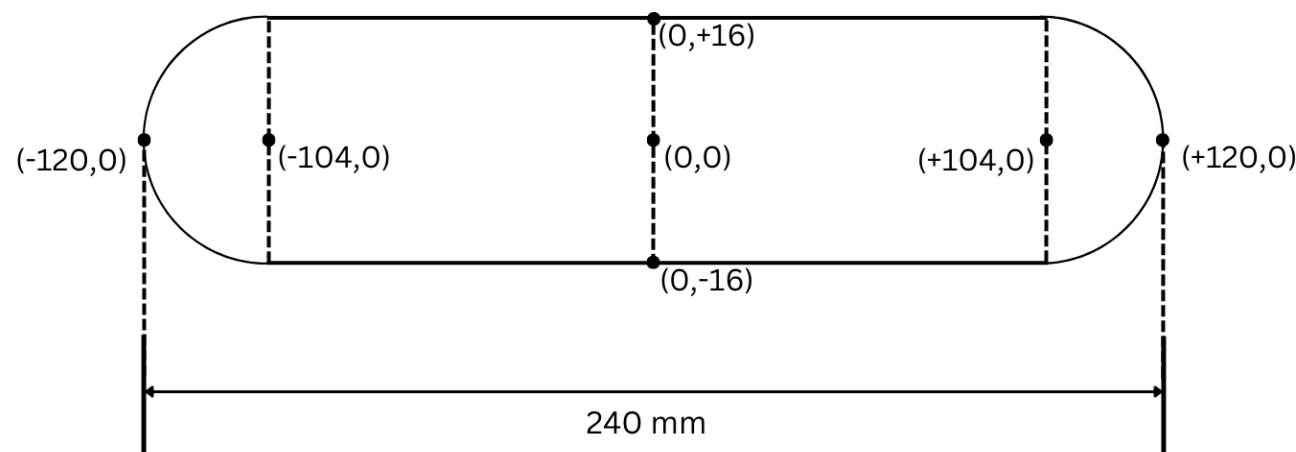
Side	150mm - G56		130mm - G54	
	Actual	Tolerance	Actual	Tolerance
Width	36	+0 / -0.062	32	+0 / -0.062
Depth	12	+0.3 / -0	11	+0.2 / -0
Length	195		240	
Symmetry		0.055		0.055
Reference	18		7.5	

G56: Ø150mm side – CLOSED SLOT (Left side)



Drawing Reference	18 mm
Centre Distance from reference Collar	79.5 mm
Centre Distance from reference slot Edge	97.5 mm

G54: Ø130mm side – CLOSED SLOT (Right side)



Drawing Reference	7.5 mm
Centre Distance from reference Collar	127.5 mm
Centre Distance from reference slot Edge	120 mm

OFFSETS

NUMBER	TOOL	SIDE	H LOCATION	D LOCATION
13	Marking Pencil	G56	H140	Not Required for Checking
		G54	H141	
14	ø26.5mm Insert DRILL	G56	H142	Not Required for Drilling
		G54	H143	
15	ø25mm CUTTER (16mm Insert)	G56	H144	Not Required for Slotting
		G54	H145	
16	ø25mm CUTTER (9mm Insert)	G56	H146	D146 = 13.0
		G54	H147	D147 = 13.0
17	ø16mm SC ENDMILL	G56	H148	D148 = 8.4
		G54	H149	D149 = 8.4
		G56	Not Required for Finishing	D150 = 8.2
		G54		D151 = 8.2

PROGRAMMING

O2461	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>	

O2462	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>	

O2463		Finishing	
G56	H148	D150	R = 8.2
G54	H149	D151	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.			

O2464	Depth
<p>Depth slotting for middle bar with 16mm Diameter SC End-Mill.</p>	

CHECKLIST

O2462		Roughing		
Operation	Side	H Offset	D offset	Radius
Collar cut	G56	H146	O2469	
Drilling	G56	H142	Not Required for Drilling	
	G54	H143		
Slotting	G56	H144	Not Required for Slotting	
	G54	H145		
Semi roughing	G56	H146	O2468	
	G54	H147	O2467	
Semi finishing	G56	H148	D148	R = 8.4
	G54	H149	D149	R = 8.4

O2463		Finishing		
Operation	Side	H Offset	D offset	Radius
Wall finish	G56	H148	D150	R = 8.2
	G54	H149	D151	R = 8.2

O2464		Depth		
Operation	Side	H Offset	D offset	Radius
Depth finish	G56	H148	Not Required for Depth cut	
	G54	H149		

O2467		Semi Roughing		
Operation	Side	H Offset	D offset	Radius
Sub-program	G54		D147	R = 13.0

O2468		Semi Roughing		
Operation	Side	H Offset	D offset	Radius
Sub-program	G56		D146	R = 13.0

O2469		Collar Cut		
Operation	Side	H Offset	D offset	Radius
Sub-program	G56		D146	R = 13.0