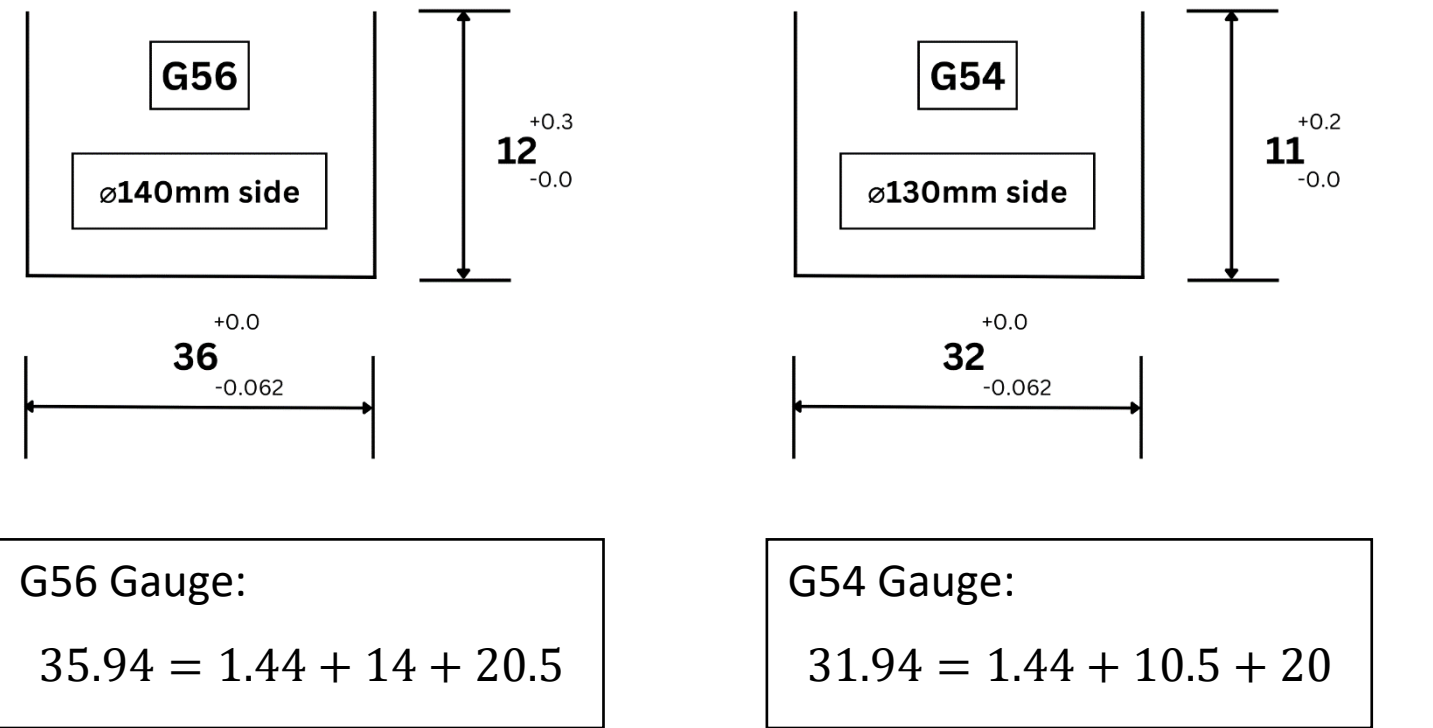


FLENDER DRAWING 5322695

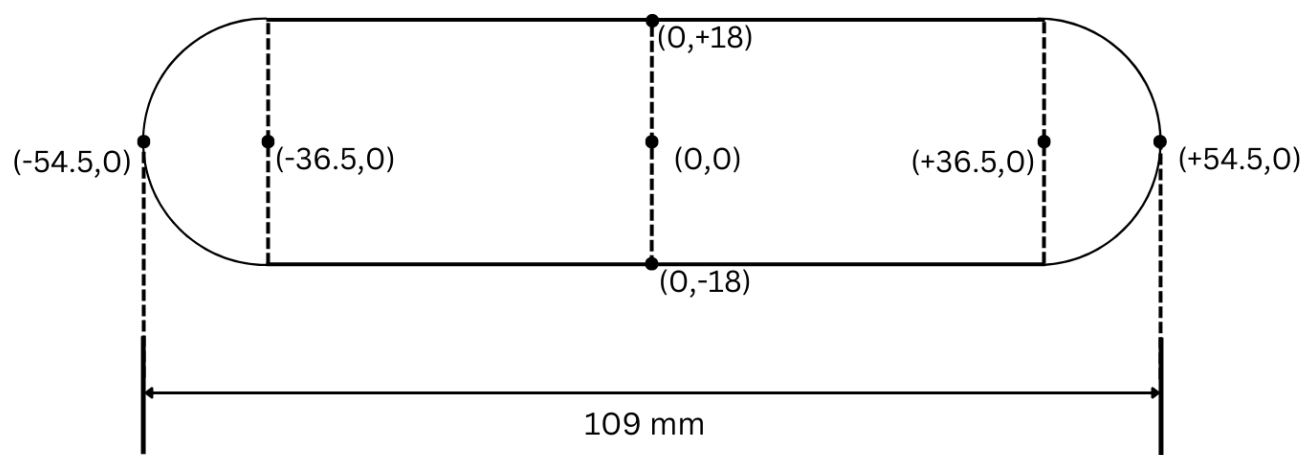
Minimum V-Block Gap for Ø140mm diameter = 45 mm



TOLERANCE

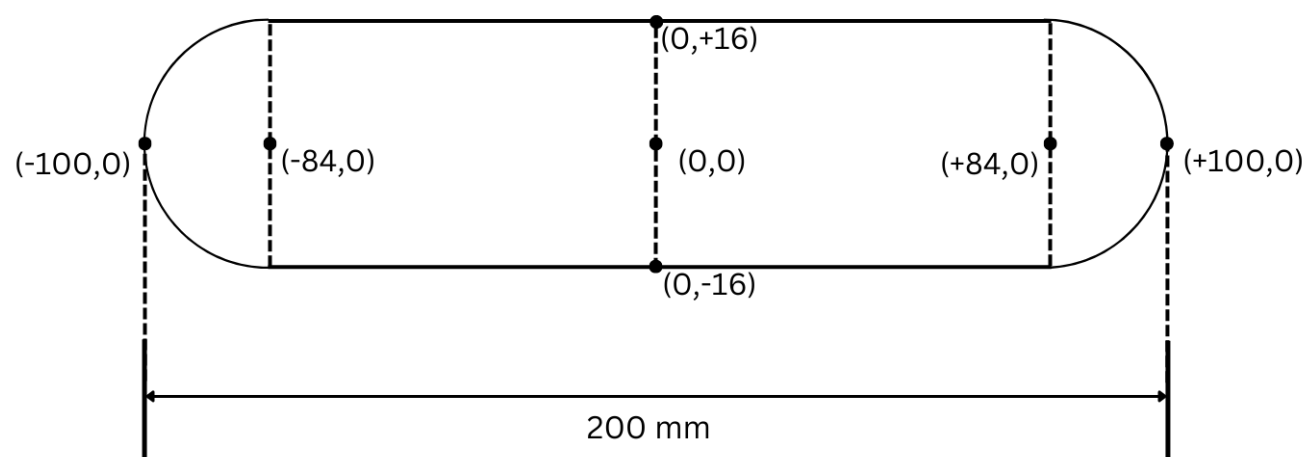
Side	140mm - G56		130mm - G54	
	Actual	Tolerance	Actual	Tolerance
Width	36	+0 / -0.062	32	+0 / -0.062
Depth	12	+0.3 / -0	11	+0.2 / -0
Length	109		200	
Symmetry		0.055		0.055
Reference	8		7.5	

G56: Ø140mm side – CLOSED SLOT (Left side)



Drawing Reference	8 mm
Centre Distance from reference Collar	62.5 mm
Centre Distance from reference slot Edge	54.5 mm

G54: Ø130mm side – CLOSED SLOT (Right side)



Drawing Reference	7.5 mm
Centre Distance from reference Collar	107.5 mm
Centre Distance from reference slot Edge	100 mm

OFFSETS

NUMBER	TOOL	SIDE	H LOCATION	D LOCATION
13	Marking Pencil	G56	H110	Not Required for Checking
		G54	H111	
14	ø26.5mm Insert DRILL	G56	H112	Not Required for Drilling
		G54	H113	
15	ø25mm CUTTER (16mm Insert)	G56	H114	Not Required for Slotting
		G54	H115	
16	ø25mm CUTTER (9mm Insert)	G56	H116	D116 = 13.0
		G54	H117	D117 = 13.0
17	ø16mm SC ENDMILL	G56	H118	D118 = 8.4
		G54	H119	D119 = 8.4
		G56	Not required for Finishing	D120 = 8.2
		G54		D121 = 8.2

PROGRAMMING

O6951	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>	

O6952	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>	

O6953		Finishing	
G56	H118	D120	R = 8.2
G54	H119	D121	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.			

O6954	Depth
Depth slotting for middle bar with 16mm Diameter SC End-Mill.	

CHECKLIST

O6952		Roughing		
Operation	Side	H Offset	D offset	Radius
Drilling	G56	H112	Not Required	
	G54	H113		
Slotting	G56	H114		
	G54	H115		
Semi roughing	G56	H116	O6958	
	G54	H117	O6957	
Semi finishing	G56	H118	D118	R = 8.4
	G54	H119	D119	R = 8.4

O6953		Finishing		
Operation	Side	H Offset	D offset	Radius
Wall finish	G56	H118	D120	R = 8.2
	G54	H119	D121	R = 8.2

O6954		Depth		
Operation	Side	H Offset	D offset	Radius
Depth finish	G56	H118	Not Required	
	G54	H119		

O6957		Semi Roughing		
Operation	Side	H Offset	D offset	Radius
Sub-program	G54		D117	R = 13.0

O6958		Semi Roughing		
Operation	Side	H Offset	D offset	Radius
Sub-program	G56		D116	R = 13.0