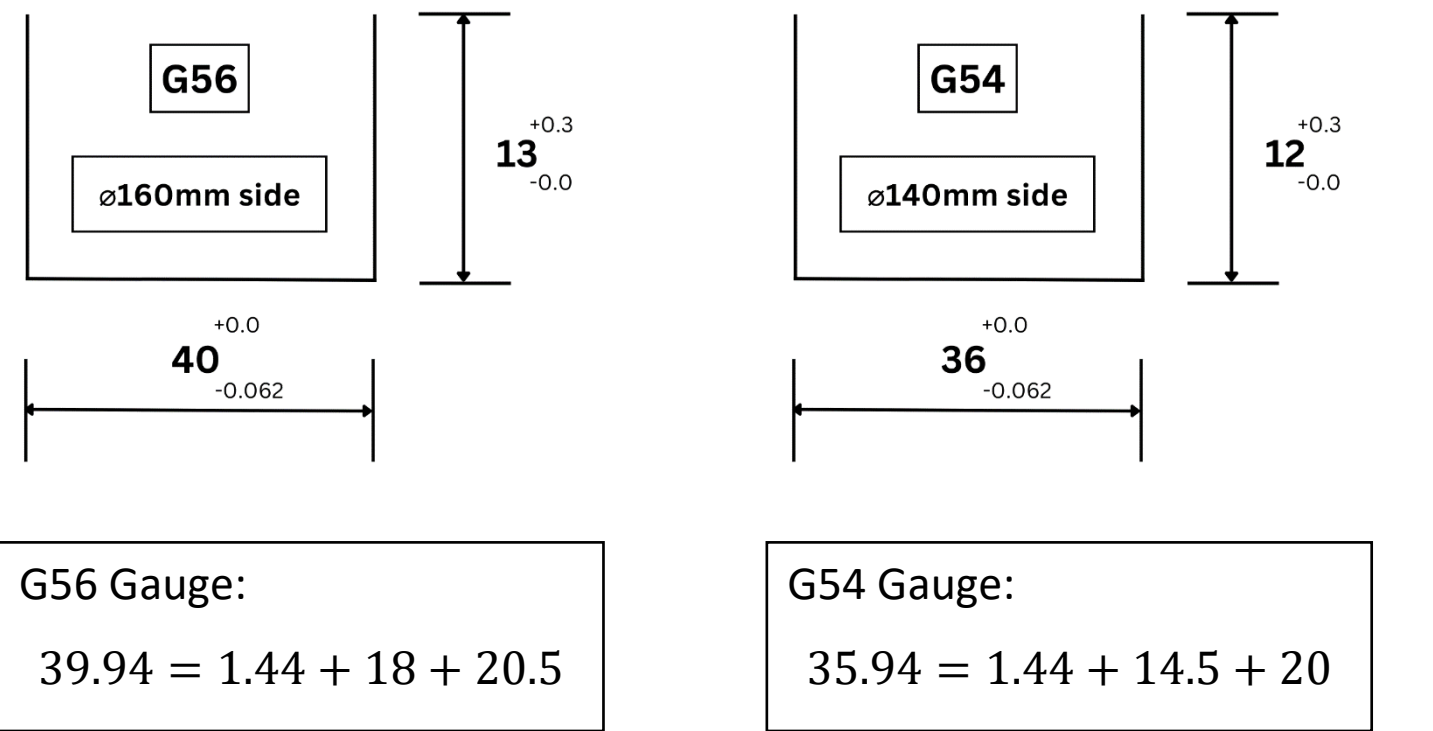


FLENDER DRAWING 5134736

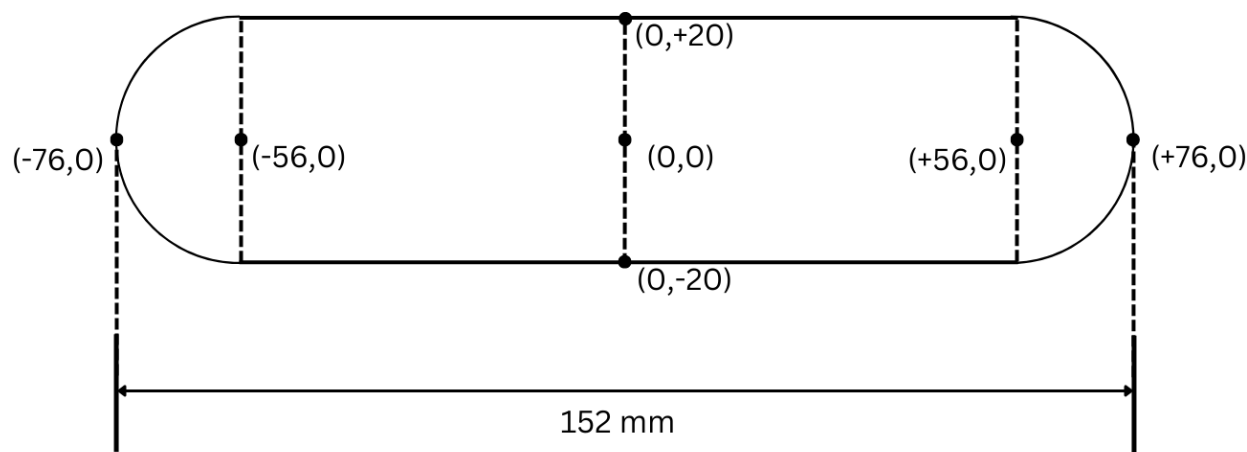
Minimum V-Block Gap for Ø150mm diameter = 215 mm



TOLERANCE

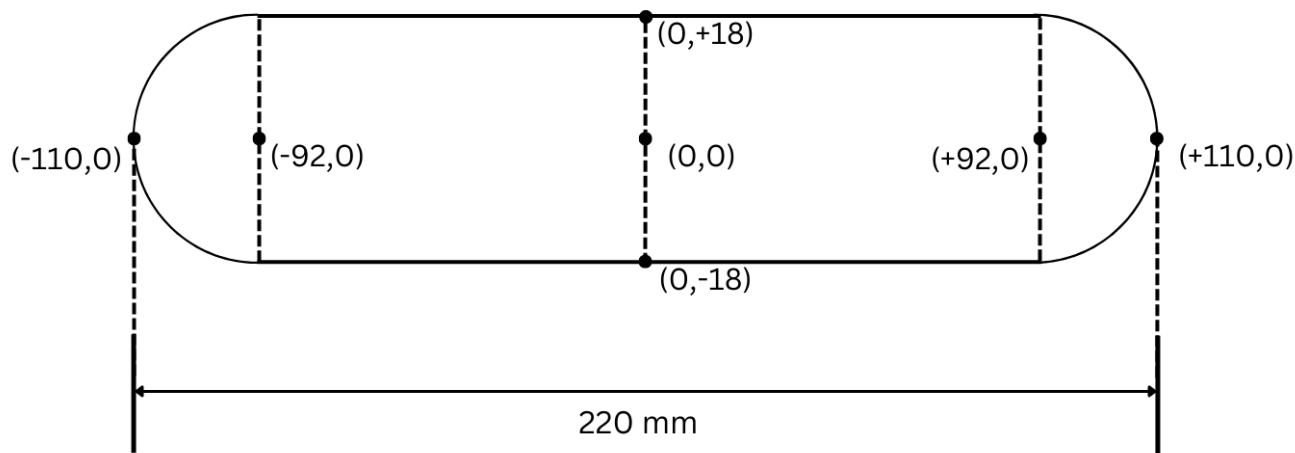
Side	160mm - G56		140mm - G54	
	Actual	Tolerance	Actual	Tolerance
Width	40	+0 / -0.062	36	+0 / -0.062
Depth	13	+0.3 / -0	12	+0.3 / -0
Length	152		220	
Symmetry		0.055		0.055
Reference	20		16	

G56: Ø160mm side – CLOSED SLOT (Left side)



Drawing Reference	20 mm
Centre Distance from reference Collar	56 mm
Centre Distance from reference slot Edge	76 mm

G54: Ø140mm side – CLOSED SLOT (Right side)



Drawing Reference	16 mm
Centre Distance from reference Collar	126 mm
Centre Distance from reference slot Edge	110 mm

OFFSETS

NUMBER	TOOL	SIDE	H LOCATION	D LOCATION
13	Marking Pencil	G56	H385	Not Required for Checking
		G54	H386	
14	ø26.5mm Insert DRILL	G56	H387	Not Required for Drilling
		G54	H388	
15	ø25mm CUTTER (16mm Insert)	G56	H389	Not Required for Slotting
		G54	H390	
16	ø25mm CUTTER (9mm Insert)	G56	H391	D391 = 13.0
		G54	H392	D392 = 13.0
17	ø16mm SC ENDMILL	G56	H393	D393 = 8.4
		G54	H394	D394 = 8.4
		G56	Not Required for Finishing	D395 = 8.2
		G54		D396 = 8.2

PROGRAMMING

O7361	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>	

O7362	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>	

O7363		Finishing	
G56	H393	D395	R = 8.2
G54	H394	D396	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.			

O7364	Depth
Depth slotting for middle bar with 16mm Diameter SC End-Mill.	

CHECKLIST

O7362		Roughing		
Operation	Side	H Offset	D offset	Radius
Collar cut	G56	H391	O7369	
Drilling	G56	H387	Not Required for Drilling	
	G54	H388		
Slotting	G56	H389	Not Required for Slotting	
	G54	H390		
Semi roughing	G56	H391	O7368	
	G54	H392	O7367	
Semi finishing	G56	H393	D393	R = 8.4
	G54	H394	D394	R = 8.4

O7363		Finishing		
Operation	Side	H Offset	D offset	Radius
Wall finish	G56	H393	D395	R = 8.2
	G54	H394	D366	R = 8.2

O7364		Depth		
Operation	Side	H Offset	D offset	Radius
Depth finish	G56	H393	Not Required for Depth cut	
	G54	H394		

O7367		Semi Roughing		
Operation	Side	H Offset	D offset	Radius
Sub-program	G54		D392	R = 13.0

O7368		Semi Roughing		
Operation	Side	H Offset	D offset	Radius
Sub-program	G56		D391	R = 13.0

O7369		Collar Cut		
Operation	Side	H Offset	D offset	Radius
Sub-program	G56		D391	R = 13.0