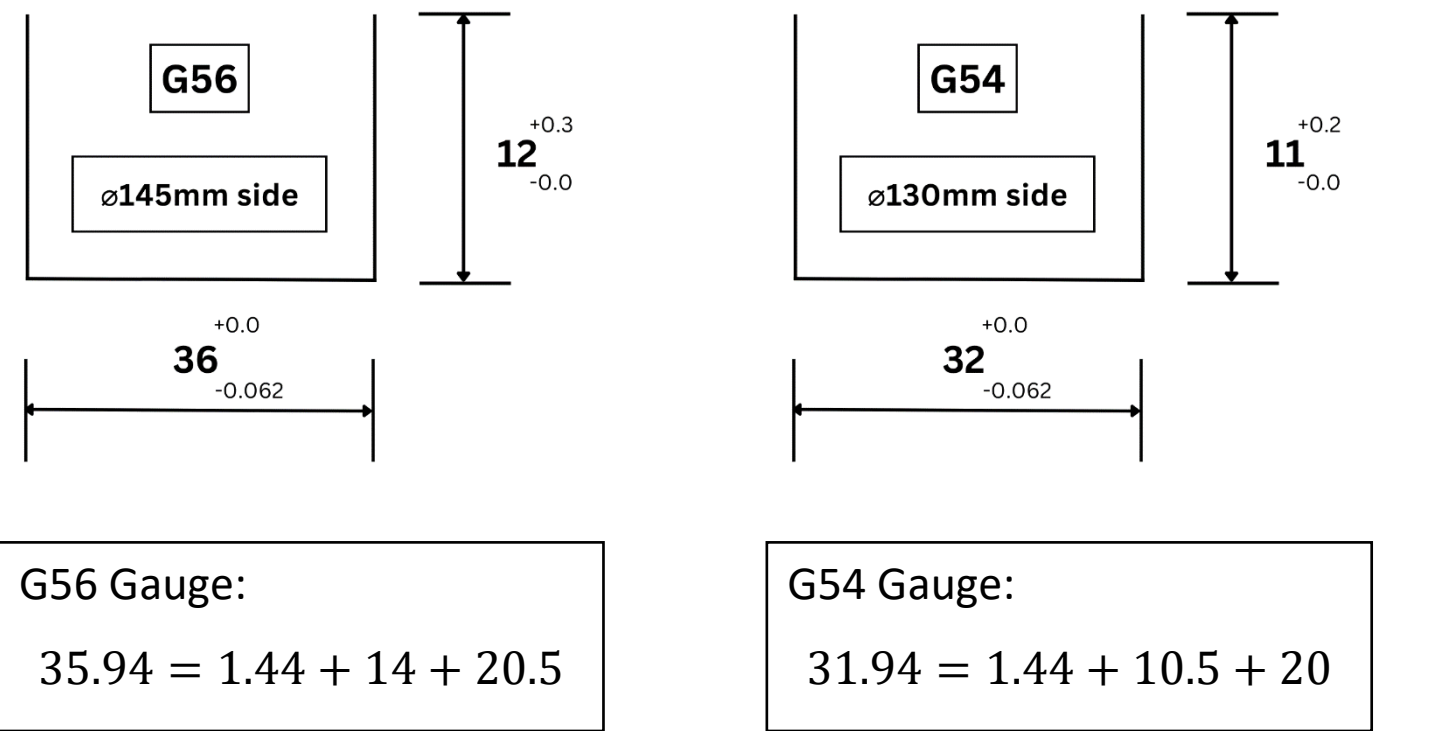


FLENDER DRAWING 5876657

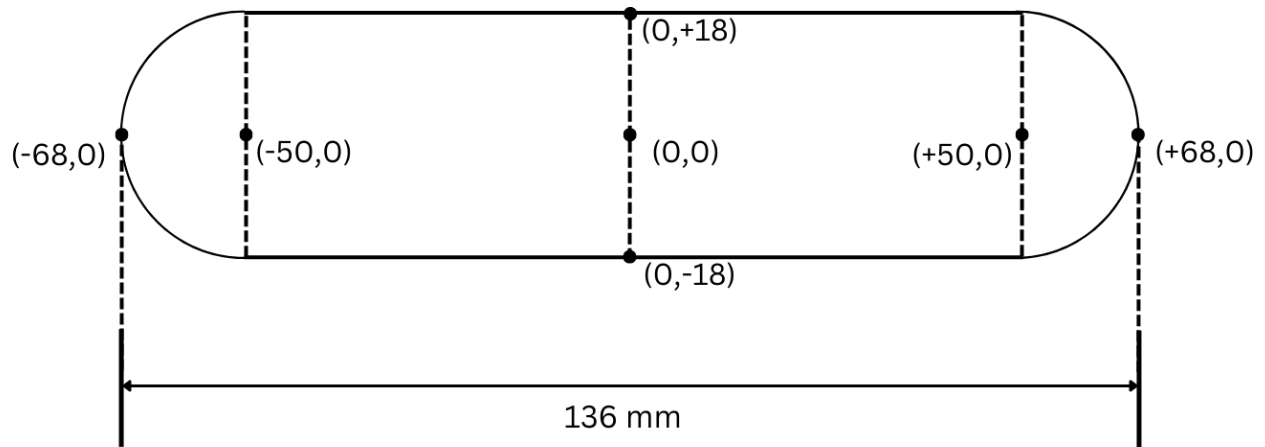
Minimum V-Block Gap for $\varnothing 130\text{mm}$ diameter = 295 mm



TOLERANCE

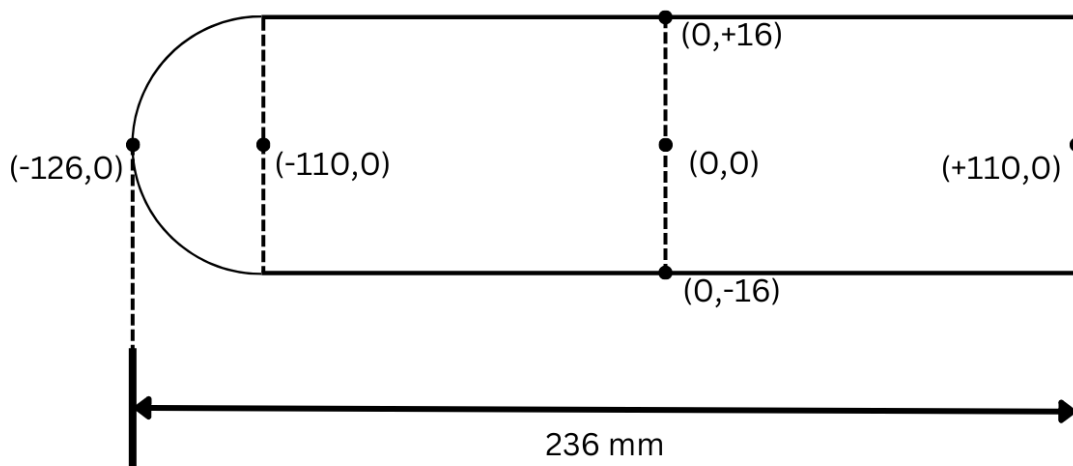
Side	145mm - G56		130mm - G54	
	Actual	Tolerance	Actual	Tolerance
Width	36	+0 / -0.062	32	+0 / -0.062
Depth	12	+0.3 / -0	11	+0.2 / -0
Length	136		236	
Symmetry		0.055		0.067
Reference	19		14	

G56: Ø145mm side – CLOSED SLOT (Left side)



Drawing Reference	19 mm
Centre Distance from reference Collar	49 mm
Centre Distance from reference slot Edge	68 mm

G54: Ø130mm side – OPEN SLOT (Right side)



Drawing Reference	14 mm
Centre Distance from reference Collar	140 mm
Centre Distance from reference slot Edge	126 mm

OFFSETS

NUMBER	TOOL	SIDE	H LOCATION	D LOCATION
13	Marking Pencil	G56	H370	Not Required for Checking
		G54	H371	
14	ø26.5mm Insert DRILL	G56	H372	Not Required for Drilling
		G54	H373	
15	ø25mm CUTTER (16mm Insert)	G56	H374	Not Required for Slotting
		G54	H375	
16	ø25mm CUTTER (9mm Insert)	G56	H376	D376 = 13.0
		G54	H377	D377 = 13.0
17	ø16mm SC ENDMILL	G56	H378	D378 = 8.4
		G54	H379	D379 = 8.4
		G56	Not Required for Finishing	D380 = 8.2
		G54		D381 = 8.2

PROGRAMMING

O6571	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>	

O6572	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>	

O6573		Finishing	
G56	H378	D380	R = 8.2
G54	H379	D381	R = 8.2
<p>Please CHECK SLIP GAUGE AFTER G56 side completes. In case of deviation, stop program and report.</p> <p>Slip gauge must go fully inside the keyway to pass. Reduce radius accordingly.</p>			

O6574	Depth
Depth slotting for middle bar with 16mm Diameter SC End-Mill.	

CHECKLIST

O6572		Roughing		
Operation	Side	H Offset	D offset	Radius
Collar cut	G56	H376	O6579	
Drilling	G56	H372	Not Required for Drilling	
	G54	H373		
Slotting	G56	H374	Not Required for Slotting	
	G54	H375		
Semi roughing	G56	H376	O6578	
	G54	H377	O6577	
Semi finishing	G56	H378	D378	R = 8.4
	G54	H379	D379	R = 8.4

O6573		Finishing		
Operation	Side	H Offset	D offset	Radius
Wall finish	G56	H378	D380	R = 8.2
	G54	H379	D381	R = 8.2

O6574		Depth		
Operation	Side	H Offset	D offset	Radius
Depth finish	G56	H378	Not Required for Depth cut	
	G54	H379		

O6577		Semi Roughing		
Operation	Side	H Offset	D offset	Radius
Sub-program	G54		D377	R = 13.0

O6578		Semi Roughing		
Operation	Side	H Offset	D offset	Radius
Sub-program	G56		D376	R = 13.0

O6579		Collar Cut		
Operation	Side	H Offset	D offset	Radius
Sub-program	G56		D376	R = 13.0