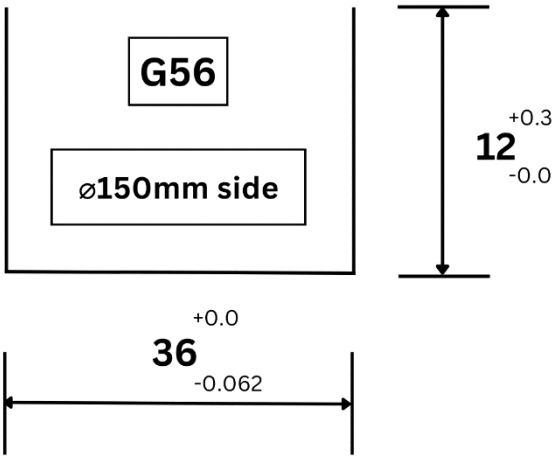
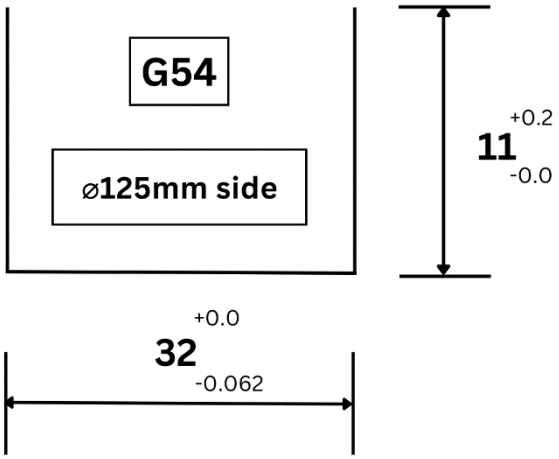
FLENDER DRAWING F2E00743793A

Minimum V-Block Gap for ⌀125mm diameter = 60 mm





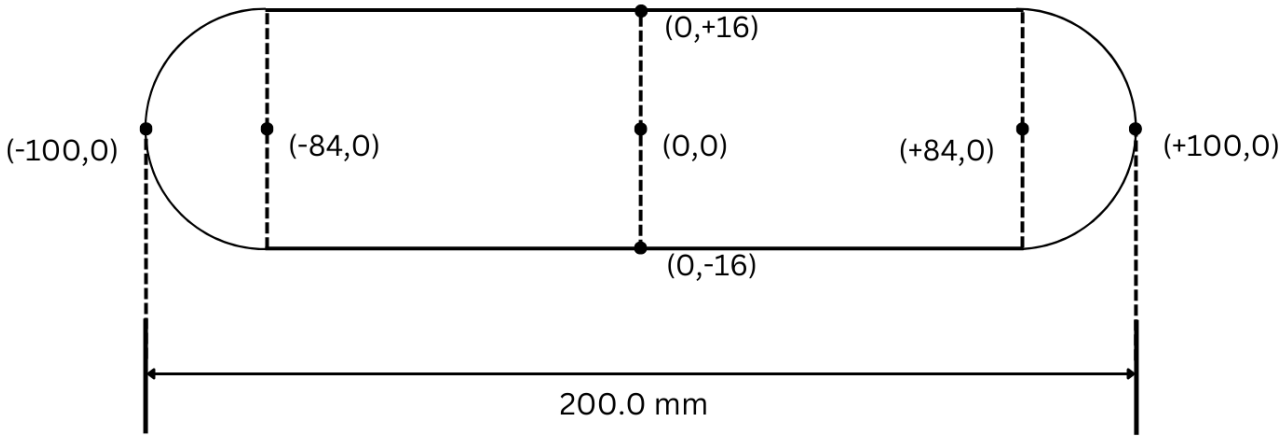
G56 Gauge:

$$35.94 = 1.44 + 14.5 + 20$$

G54 Gauge:

$$31.94 = 1.44 + 15 + 15.5$$

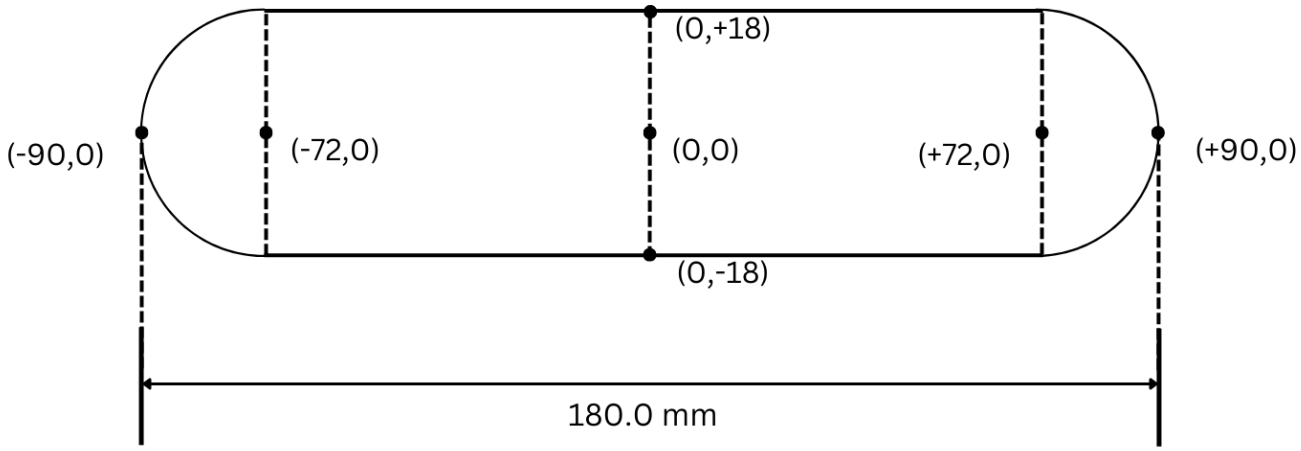
G54: ⌀125mm side – CLOSED SLOT (Right side)



⇒ Drawing Reference = 7.5 mm

⇒ Centre distance from collar = 107.5 mm

G56: ⌀150mm side – CLOSED SLOT (Left side)



⇒ Drawing Reference = 22 mm

⇒ Centre distance from collar = 68 mm

OFFSETS

NUMBER	TOOL	SIDE	H LOCATION	D LOCATION
14	⌀25.6mm Insert DRILL	G56	H210	
		G54	H211	
15	⌀25mm Insert CUTTER **R = 13.0**	G56	H212	D212
		G54	H213	D213
16	⌀16mm SC CUTTER **R = 8.4**	G56	H214	D214
		G54	H215	D215
		G56		D216
		G54		D217

PROGRAMMING

O7931 – 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.

O7932 – Roughing

Please **MEASURE SYMMETRY** after completion. If symmetry deviation is 4**0-micron** or more, shift Y-axis as required.

Only reduce tool radius after width measurement. Radius reduction will be according to stock material remaining.

O7933 – Finishing

Please **CHECK SLIP GAUGE AFTER G56** side completes. In case of deviation, stop program and report. Do not continue G54 side before checking.

Slip gauge must go fully inside the keyway to pass. Reduce radius accordingly.

O7934 – Depth finishing

This program is only for finishing cutter with less than 20mm Diameter. It is not required for 20mm Diameter and above.