FLENDER DRAWING 5876674

Minimum V-Block Gap for ⌀140mm diameter = 360 mm

G56	G54
⌀155mm side	⌀140mm side

$13 \; {}^{+0.3}_{-0.0}$

$12 \; {}^{+0.3}_{-0.0}$
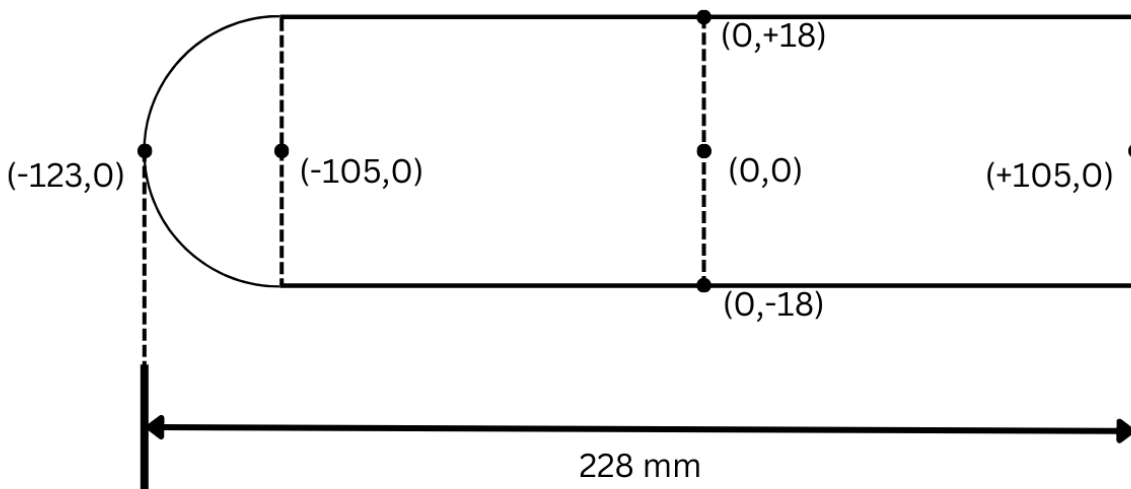
$40 \; {}^{+0.0}_{-0.062}$

$36 \; {}^{+0.0}_{-0.062}$
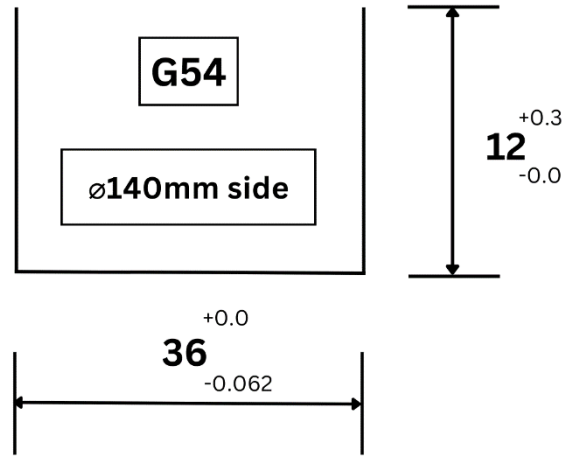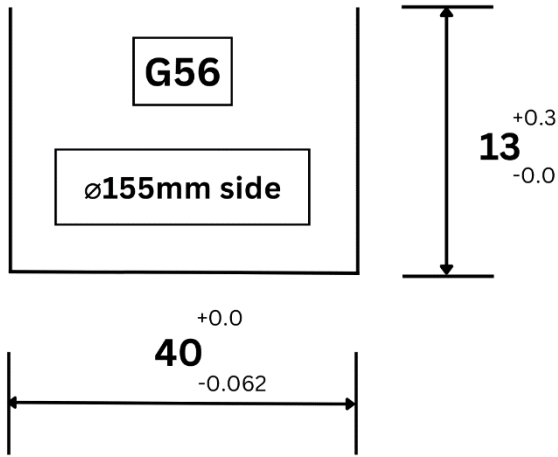
G56 Gauge:

$$39.94 = 1.44 + 18.5 + 20$$

G54 Gauge:

$$35.94 = 1.44 + 14 + 20.5$$

G54: ⌀140mm side – OPEN SLOT (Right side)

(0,+18)

(-123,0)   (-105,0)   (0,0)   (+105,0)

(0,-18)

228 mm

⟹ Drawing Reference = 22 mm
⟹ Centre distance from left collar = 145 mm

G56: ∅155mm side – CLOSED SLOT (Left side)
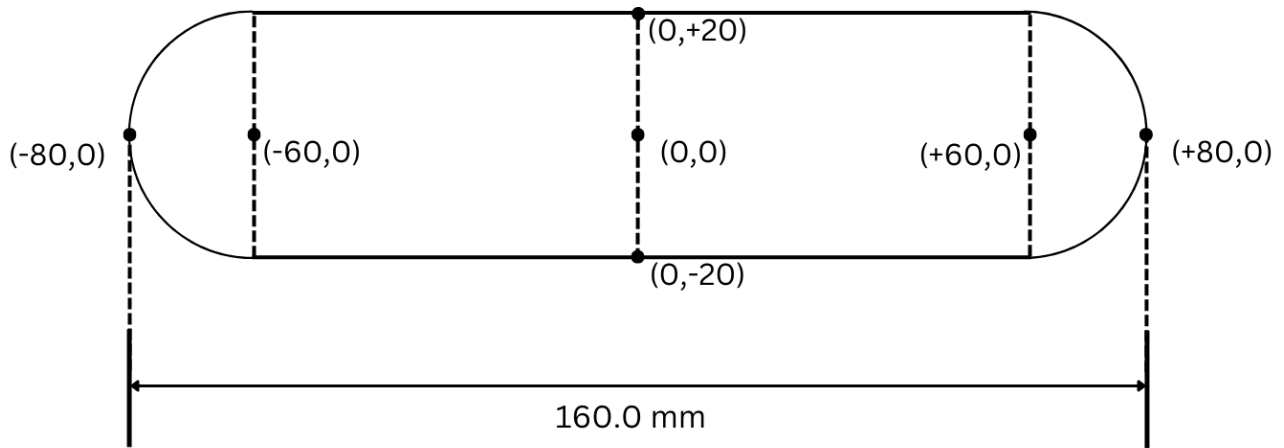
⇒ Drawing Reference = 21 mm

⇒ Centre distance from left collar = 59 mm

OFFSETS

NUMBER	TOOL	SIDE	H LOCATION	D LOCATION
14	∅26.5mm Insert DRILL	G56	H290	Not Required for Drilling
		G54	H291	
15	∅25mm CUTTER (16mm Insert)	G56	H292	Not Required for Slotting
		G54	H293	
16	∅25mm CUTTER (9mm Insert)	G56	H294	D294 = 13.0
		G54	H295	D295 = 13.0
17	∅16mm SC ENDMILL	G56	H296	D296 = 8.4
		G54	H297	D297 = 8.4
		G56	Not Required for Finishing	**D298** = 8.2
		G54		**D299** = 8.2

PROGRAMMING

O6741	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.

O6742	Roughing

Please **MEASURE SYMMETRY** after completion. If symmetry deviation is **30-micron** or more, shift Y-axis as required.
Only reduce tool radius after width measurement. Radius reduction will be according to stock material remaining.

O6743		Finishing	
G56	H296	**D298**	R = 8.2
G54	H297	**D299**	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.

O6744	Depth

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

TOLERANCE

Side	155mm - 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	160		228	
Symmetry		0.070		0.066
Reference	21		22	

CHECKLIST

O6742		Roughing		
Operation	Side	H Offset	D offset	Radius
Collar cut	G56	H294	D294	R = 13.0
Drilling	G56	H290	Not Required	
	G54	H291		
Slotting	G56	H292		
	G54	H293		
Semi roughing	G56	H294	D294	R = 13.0
	G54	H295	D295	R = 13.0
Semi finishing	G56	H296	D296	R = 8.4
	G54	H297	D297	R = 8.4

O6743		Finishing		
Operation	Side	H Offset	D offset	Radius
Wall finish	G56	H296	**D298**	R = 8.2
	G54	H297	**D299**	R = 8.2

O6744		Depth		
Operation	Side	H Offset	D offset	Radius
Depth finish	G56	H296	Not Required	
	G54	H297		