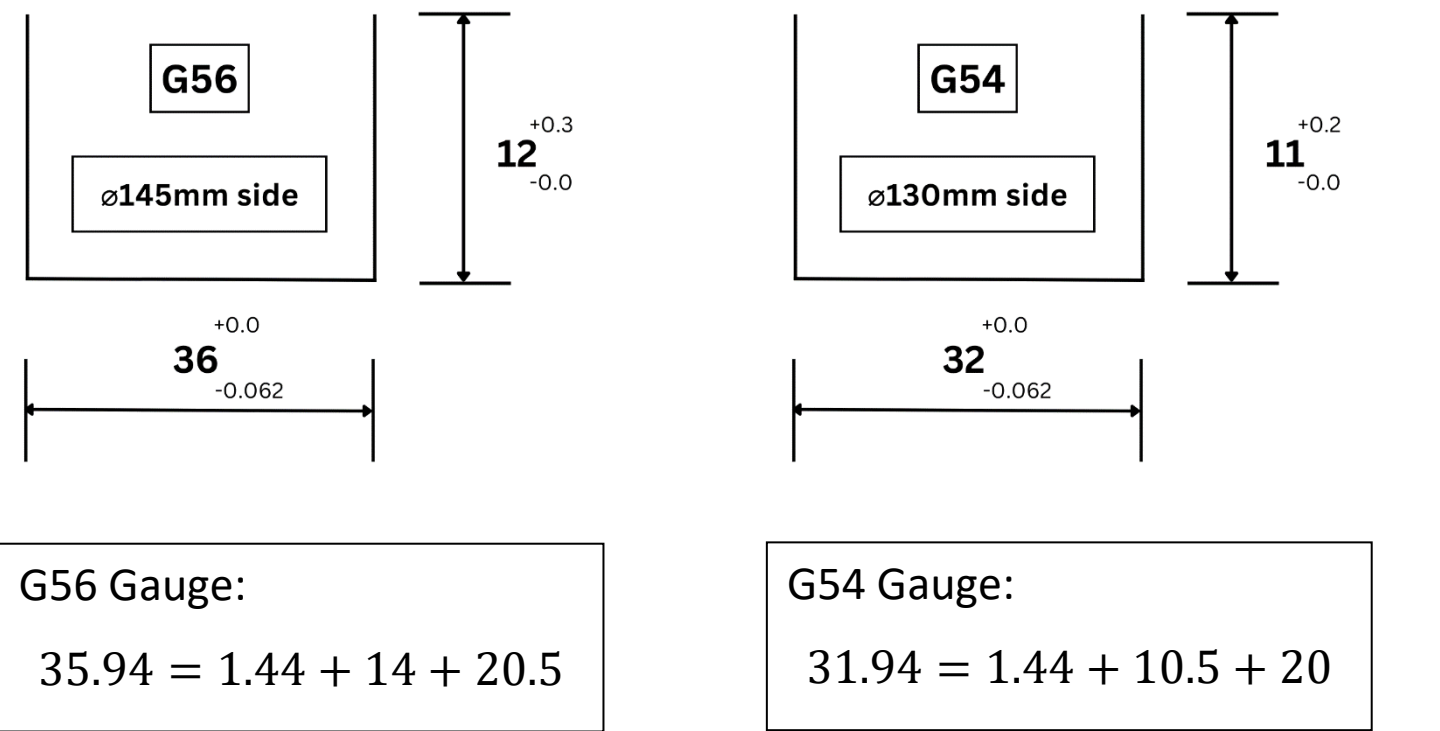
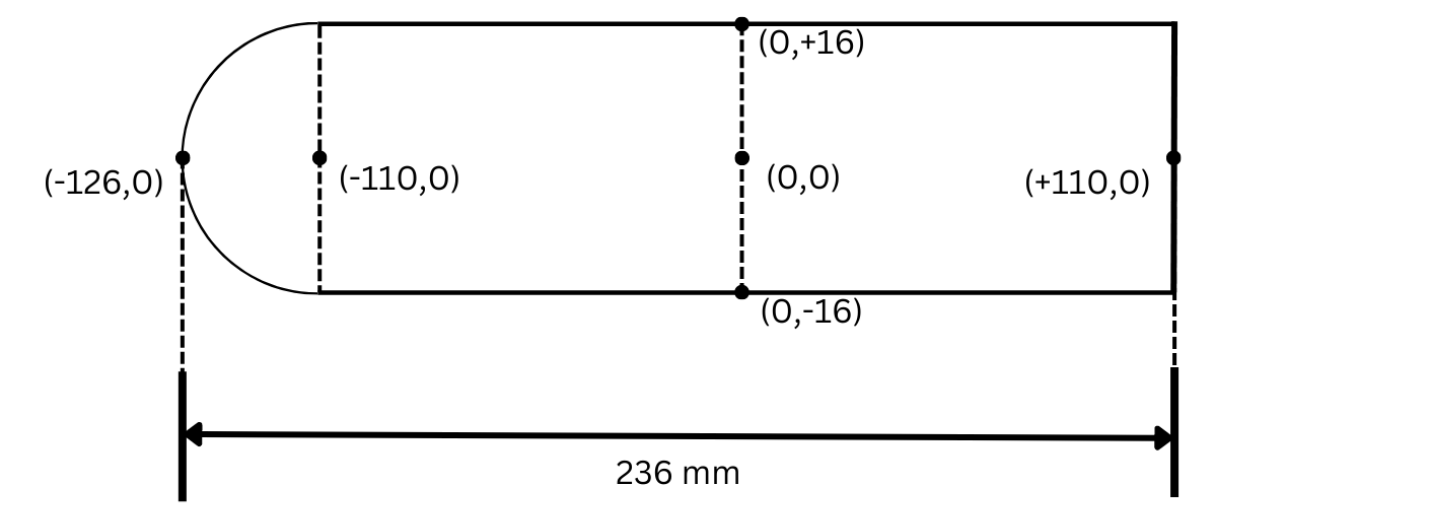


FLENDER DRAWING 5876673

Minimum V-Block Gap for $\varnothing 130\text{mm}$ diameter = 300 mm

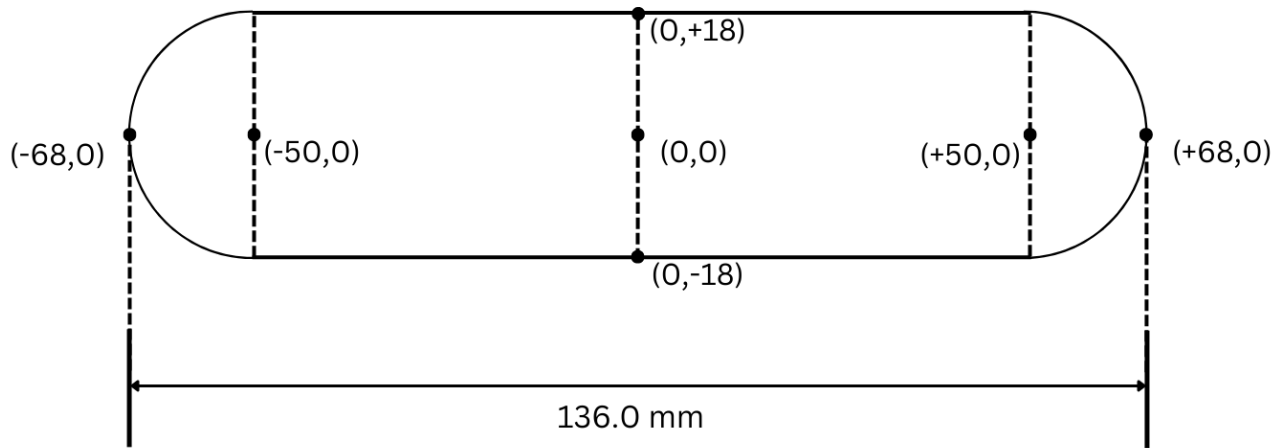


G54: $\varnothing 130\text{mm}$ side – OPEN SLOT (Right side)



- ⇒ Drawing Reference = 14 mm
- ⇒ Centre distance from left collar = 140 mm

G56: Ø145mm side – CLOSED SLOT (Left side)



⇒ Drawing Reference = 19 mm

⇒ Centre distance from left collar = 49 mm

OFFSETS

NUMBER	TOOL	SIDE	H LOCATION	D LOCATION
14	Ø26.5mm Insert DRILL	G56	H280	Not Required for Drilling
		G54	H281	
15	Ø25mm CUTTER (16mm Insert)	G56	H282	Not Required for Slotting
		G54	H283	
16	Ø25mm CUTTER (9mm Insert)	G56	H284	D284 = 13.0
		G54	H285	D285 = 13.0
17	Ø16mm SC ENDMILL	G56	H286	D286 = 8.4
		G54	H287	D287 = 8.4
		G56	Not Required for Finishing	D288 = 8.2
		G54		D289 = 8.2

PROGRAMMING

O6731	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.	

O6732	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.	

O6733		Finishing	
G56	H286	D288	R = 8.2
G54	H287	D289	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.			

O6734	Depth
Depth slotting for middle bar with 16mm Diameter SC End-Mill.	

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	

CHECKLIST

O6732		Roughing		
Operation	Side	H Offset	D offset	Radius
Collar cut	G56	H284	D284	R = 13.0
Drilling	G56	H280	Not Required	
	G54	H281		
Slotting	G56	H282		
	G54	H283		
Semi roughing	G56	H284	D284	R = 13.0
	G54	H285	D285	R = 13.0
Semi finishing	G56	H286	D286	R = 8.4
	G54	H287	D287	R = 8.4

O6733		Finishing		
Operation	Side	H Offset	D offset	Radius
Wall finish	G56	H286	D288	R = 8.2
	G54	H287	D289	R = 8.2

O6734		Depth		
Operation	Side	H Offset	D offset	Radius
Depth finish	G56	H286	Not Required	
	G54	H287		