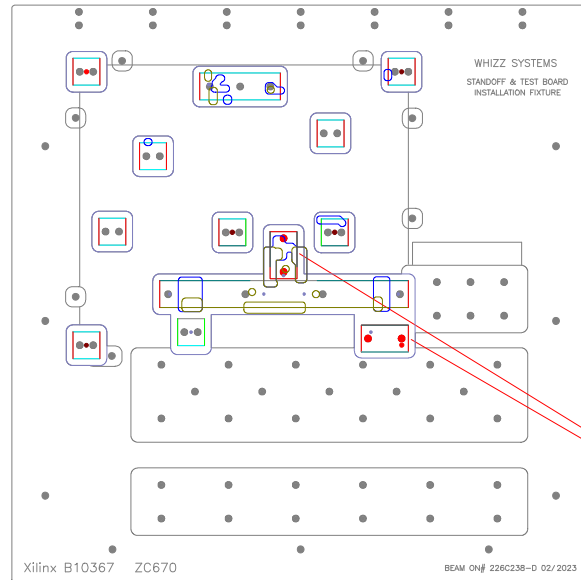


REF# 226C238-D



XOYO

FIXTURE SIZE: 21.5" X 21.5" X 0.250" THK G10 ALREADY SQUARED QTY:1

BLOCK-OPR-1.CNC

FIRST ONLY INSTALL ALL 1.250" TALL BLOCKS- (G59-BLOCK-1.CNC- G59-BLOCK-4.CNC)

!!! MANUALLY SIZED BLOCK- NO SIZING PROGRAM PROVIDED !!!

1/2 ENDMILL X 000 DEEP (ADJUSTABLE)

FINAL BLOCK THICKNESS NEEDS TO BE 1.186" THICK

SINCE THE RECEIVED BLOCK HEIGHTS VARY DUE TO TOLERANCES (1.233" TO 1.249" THICKNESS)
WE HAVE PROVIDED FACING OPERATION DEEP ADJUSTABLE
MAKE SURE ALL THE BLOCKS ARE 1.186" HEIGHT

RESET "0" ON 1.186" HEIGHT BLOCK SURFACE,

1/2 ENDMILL X 1.186" DEEP CONTOUR OUT FOR FACING SIDE

1/2 ENDMILL X 1.186" DEEP CONTOUR OUR FOR FACING SIDE -PLUNGE

1/4 ENDMILL X 1.186" DEEP CONTOUR OUR FOR FACING SIDE -PLUNGE

1/2 ENDMILL X 1.186" DEEP CONTOUR OUT FOR SIZING SIDE

1/2 ENDMILL X 1.186" DEEP CONTOUR OUR FOR SIZING SIDE -PLUNGE

089 DRILL X 250 DEEP FOR 151 DIA PINS

089 DRILL X 250 DEEP FOR DUMMY

7/32 (0.219")DRILL X 350 DEEP 4-40 INSERTS

1/4 ENDMILL X 150 DEEP

1/4 ENDMILL X 200 DEEP

