


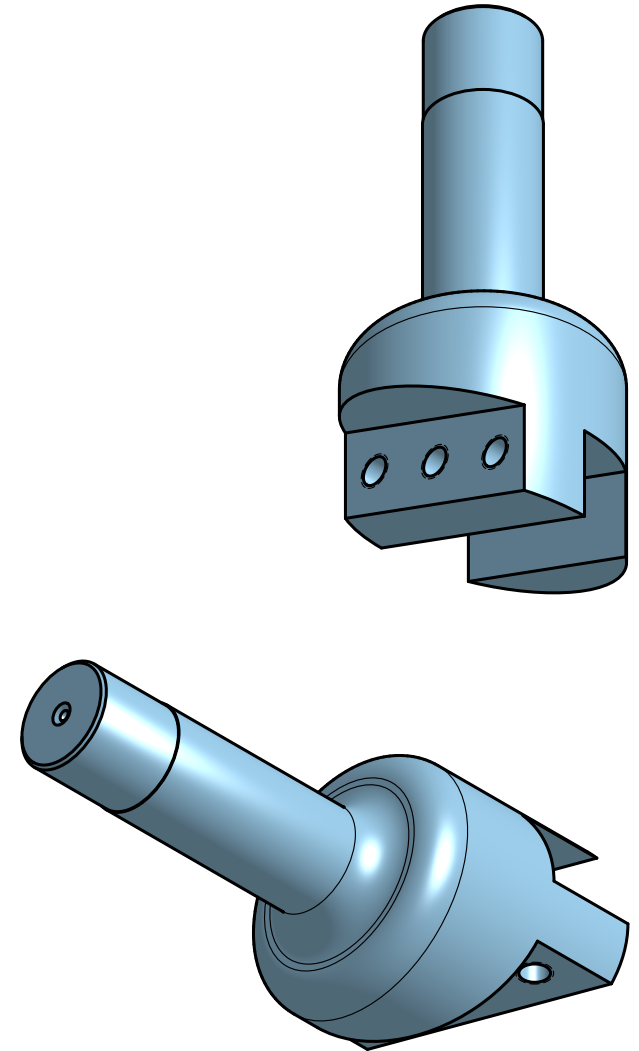
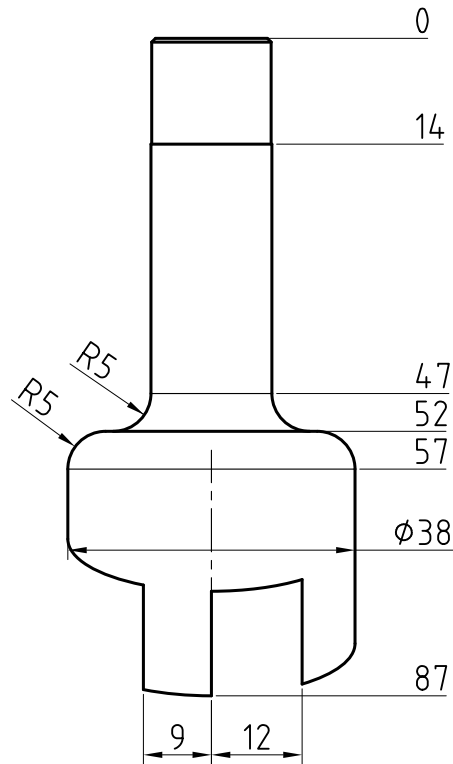
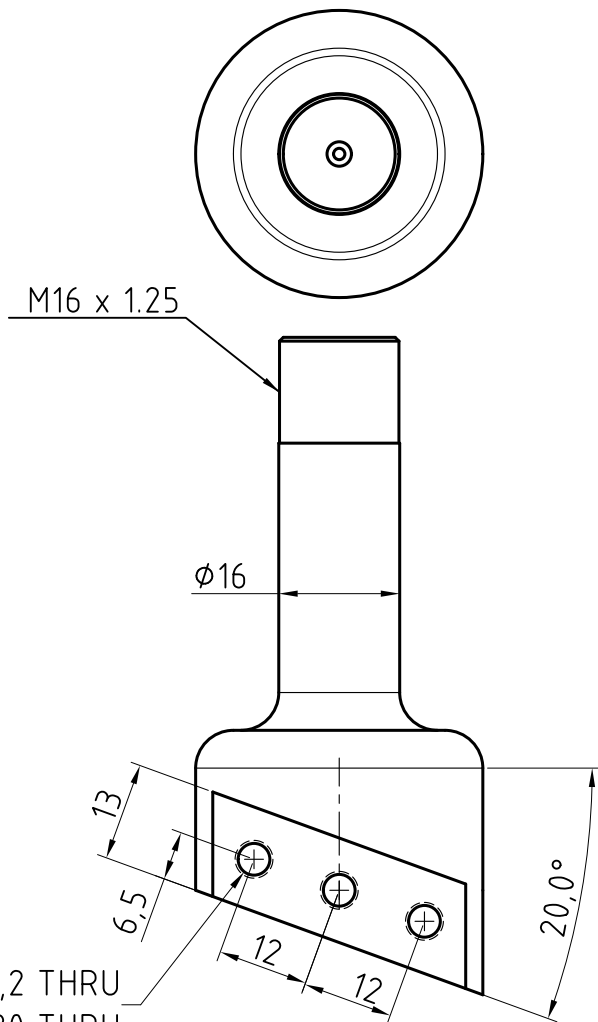


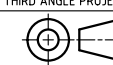
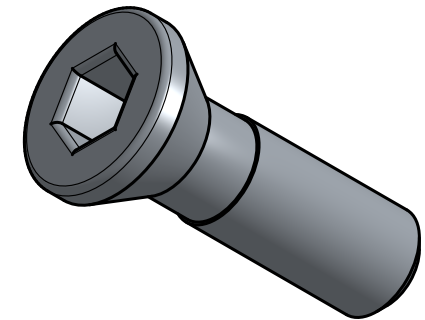
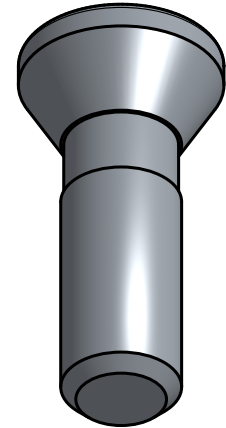
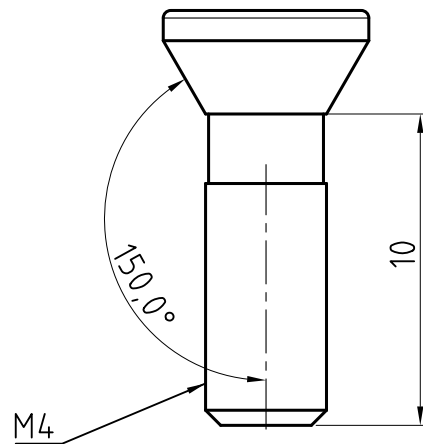
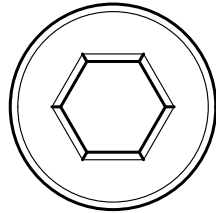




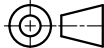
1. Cut 12 x 12mm Square Bar to 80mm long.
2. Set Datum to Top LH Corner of Stock.
3. Use 3D Model for CNC Programming.
4. Spot Drill Clearance Hole "A".
5. Drill Clearance Hole "A".
6. Rough & Finish Nose.
7. 3D Adaptive Rough Insert Pocket.
8. Finish Sloped Walls of Insert Pocket.
9. Spot Drill Insert Tapped Hole.
10. Drill Insert Tapped Hole.
11. Manually Tap Insert Tapped Hole.

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MM  ANGULAR $\angle = \pm 0.1^\circ$ GENERAL = $\pm 0.05$  SURFACE FINISH   DO NOT SCALE DRAWING  BREAK ALL SHARP EDGES AND REMOVE BURRS  THIRD ANGLE PROJECTION 	NAME		DATE		 C.J.HUMPHRIS								
	DRAWN		CJH					26-May-18					
	CHECKED						TITLE  SEKT1204 FLYCUTTER BAR						
	APPROVED												
	DATE DWG LAST CHANGED				15-Jul-19								
MATERIAL		STEEL MILD 1045		FINISH		As Machined		SIZE A4		DWG NO.		REV.	
								SCALE 1:1 UOS		WEIGHT g		SHEET 1 of 4	

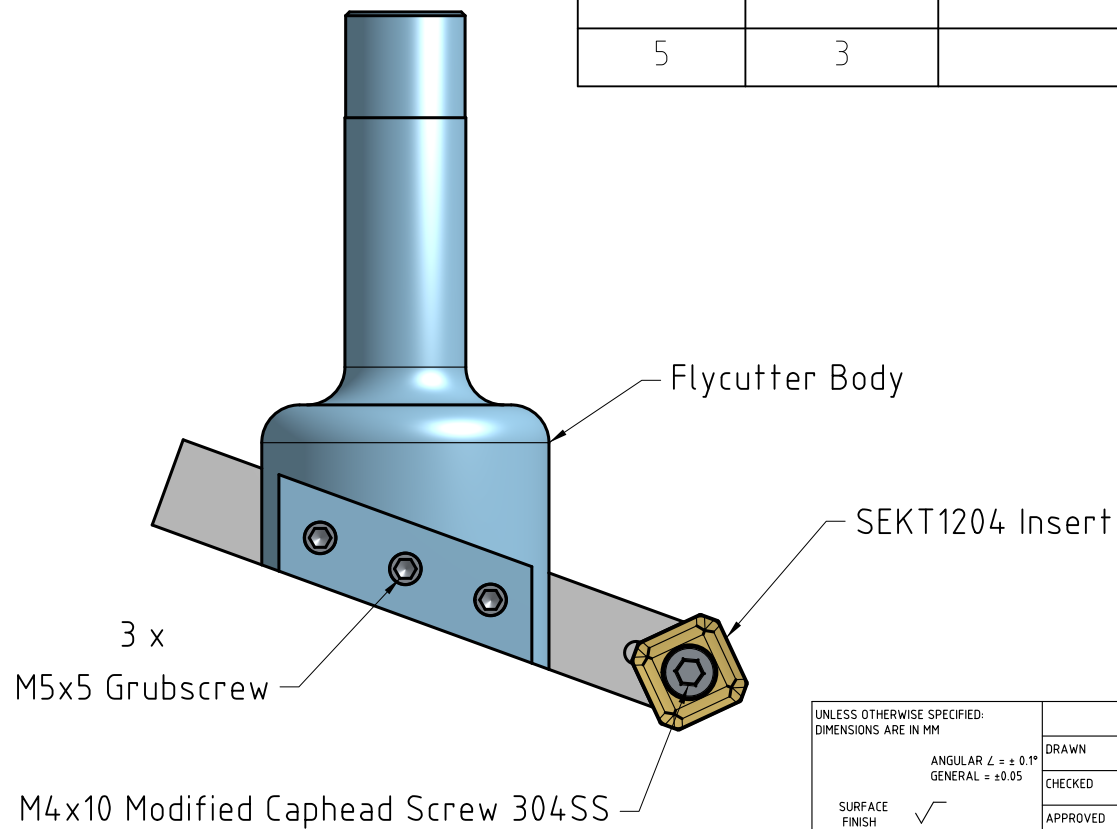


UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MM		NAME	DATE	 <b>C.J.HUMPHRIS</b>	
ANGULAR $\angle = \pm 0.1^\circ$ GENERAL = $\pm 0.05$		DRAWN	26-May-18		
SURFACE FINISH 		CHECKED		TITLE	
DO NOT SCALE DRAWING		APPROVED			
BREAK ALL SHARP EDGES AND REMOVE BURRS		DATE DWG LAST CHANGED	15-Jul-19	<b>FLYCUTTER BODY</b>	
THIRD ANGLE PROJECTION		MATERIAL	STEEL BRIGHT MILD		
		FINISH	As Machined	SIZE	REV.
				A4	
		SCALE	1:1 UOS	WEIGHT	g
				SHEET	2 of 4



UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MM		NAME		DATE		 C.J.HUMPHRIS	
ANGULAR $\angle = \pm 0.1^\circ$ GENERAL = $\pm 0.05$		DRAWN		26-May-18			
SURFACE FINISH 		CHECKED				TITLE	
DO NOT SCALE DRAWING		APPROVED				M4X10 MODIFIED CAPHEAD	
BREAK ALL SHARP EDGES AND REMOVE BURRS		DATE DWG LAST CHANGED		15-Jul-19		SCREW 304SS	
THIRD ANGLE PROJECTION		MATERIAL		FINISH		SIZE	
		304 SS		Alochrome 1200S		A4	
						DWG NO.	
						SCALE	
						4:1 UOS	
						WEIGHT	
						g	
						SHEET	
						3 of 4	

Item No.	Quantity	Part number	Name	Material
1	1		SEKT1204 Flycutter Bar	Steel Mild 1045
2	1	SEKT1204	SEKT1204 Insert	Tungsten Carbide
3	1		M4x10 Modified Caphead Screw 304SS	304 SS
4	1		Flycutter Body	Steel Bright Mild
5	3		M5x5 Grubscrew	304 SS



UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MM		NAME	DATE	C.J.HUMPHRIS	
SURFACE FINISH <input checked="" type="checkbox"/>	DRAWN	CJH	26-May-18	TITLE <b>FLYCUTTER SEKT1204</b>	
	CHECKED				
	APPROVED				
DO NOT SCALE DRAWING	DATE DWG LAST CHANGED		15-Jul-19		
BREAK ALL SHARP EDGES AND REMOVE BURRS	MATERIAL	FINISH		SIZE	REV.
THIRD ANGLE PROJECTION		As per Part Dwg		A4	
SCALE 1:1 UOS		WEIGHT g		SHEET 4 of 4	