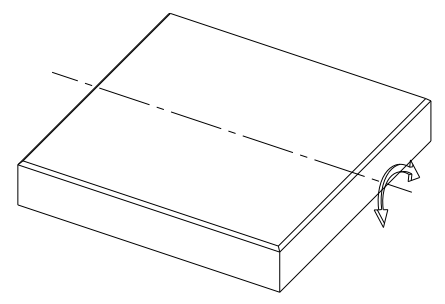
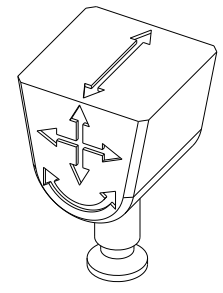


MACHINE : 5-axis M/C



**WORK : FUSELAGE FRAME**

**WORKPIECE MATERIAL - ALMINUM ALLOY**

Unspecified Tolerances	Draw		Customer: TUNGALOY	Japan	
Dim.s: --	Design		Designation:		
Angles: --	Check		LAYOUT-FUSELAGE FRAME-61146	Process	Page 1 Rev. No. 0
	Appr.			Layout.	Of 1
	Scale			Lead Drawing	
				--	
				FL-40030850	Reg.No. 61146/1
					A3L

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MODEL IN SCALE 1:5 TOOLS IN SCALE 1:2

**CUT 101**  
**Face Milling Rough**  
 TPV16R125M40.0E07  
 XVCT160512R-AJ TH10

**Tung-AluMill**  
**TH10**

**CUT 102**  
**Face Milling Finish**  
 TEN09R125M40.0E10  
 PNCU0905GNFR-AJ TH10

**Do Pent**  
**TH10**

**CUT 102**  
**Face Milling Finish**  
 TPYD06M125B40.0R26  
 YDEN0603PDFR-D DX110

**Tung Speed Mill**  
**DX-110**

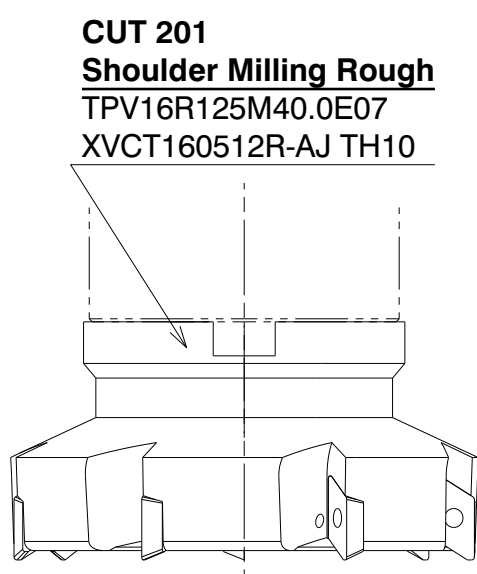
**CUT101**  
**CUT102**

Isometric view  
 Scale: 1:5

**M/C : Face Milling**

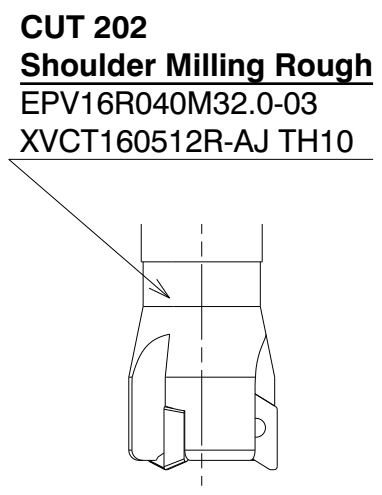
Unspecified Tolerances	Draw		Customer: TUNGALOY	Japan	
Dim.s: --	Design		Designation:	LAYOUT OP100-FUSELAGE FRAME	
Angles: --	Check		Process	Layout.	Page 1
	Appr.			Concept	Of 1
	Scale -				Rev. No. 0
					Reg.No. 61146/1
					A3L
		© 2019 Tungaloy Corporation - Copyrights Notice		FL-40030850	

MODEL IN SCALE 1:5 TOOLS IN SCALE 1:2



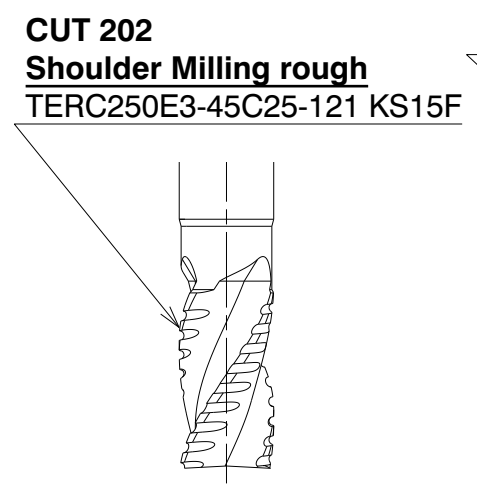
**CUT 201**  
**Shoulder Milling Rough**  
 TPV16R125M40.0E07  
 XVCT160512R-AJ TH10

**Tung-AluMill**  
**TH10**



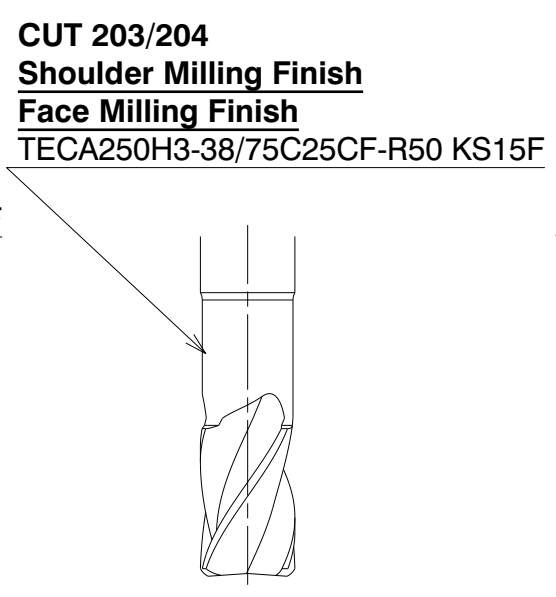
**CUT 202**  
**Shoulder Milling Rough**  
 EPV16R040M32.0-03  
 XVCT160512R-AJ TH10

**Tung-AluMill**  
**TH10**



**CUT 202**  
**Shoulder Milling rough**  
 TERC250E3-45C25-121 KS15F

**Shred Meister**  
**KS15F**



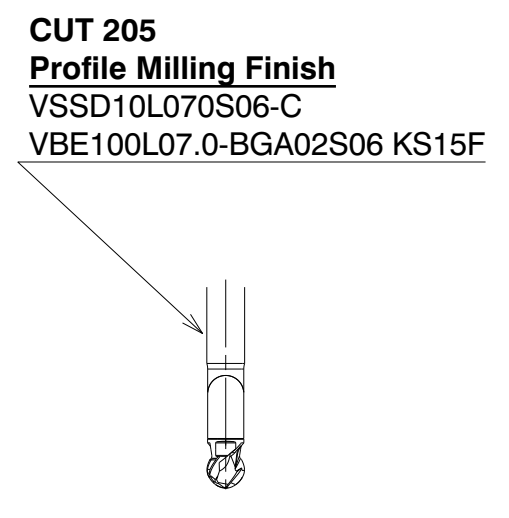
**CUT 203/204**  
**Shoulder Milling Finish**  
**Face Milling Finish**  
 TECA250H3-38/75C25CF-R50 KS15F

**Solid Meister**  
**Variable Meister**  
**KS15F**



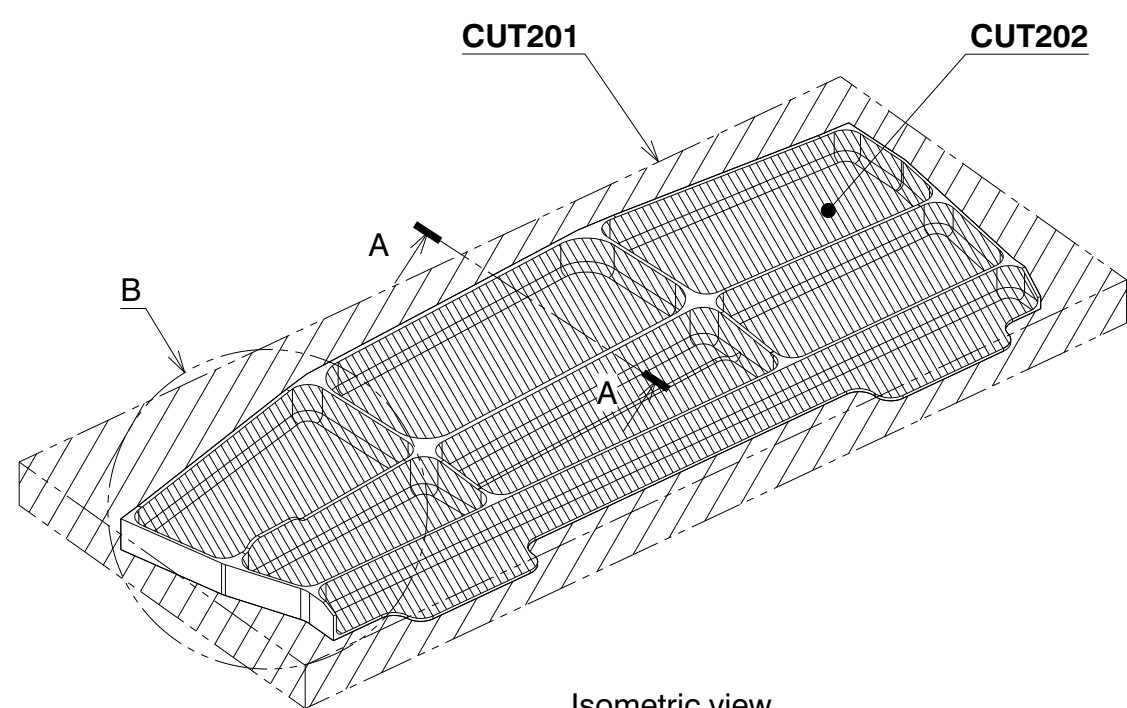
**CUT 203/204**  
**Shoulder Milling Finish**  
**Face Milling Finish**  
 VSSD20L090S12-C  
 VEE200L12.0R20A03S12 KS15F

**Tung Meister**  
**KS15F**

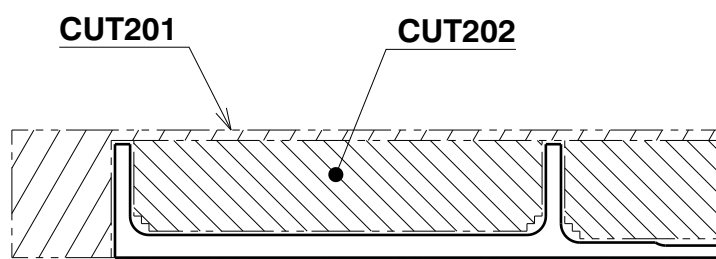


**CUT 205**  
**Profile Milling Finish**  
 VSSD10L070S06-C  
 VBE100L07.0-BGA02S06 KS15F

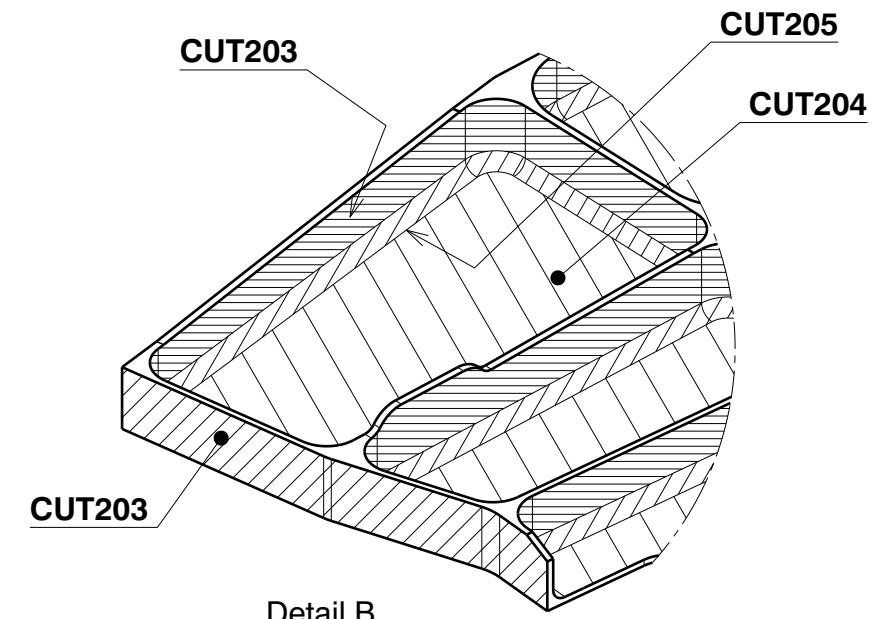
**Tung Meister**  
**KS15F**



Isometric view  
 Scale: 1:5



Section cut A-A  
 Scale: 1:2



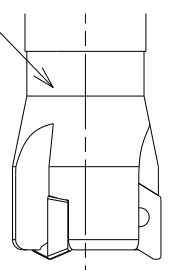
Detail B  
 Scale: 2:5

**M/C : Pocket Milling / Rib Milling**

Unspecified Tolerances Dim.s: -- Angles: --	Draw		Customer: TUNGALOY	Japan	
	Design		Designation: LAYOUT OP200-FUSELAGE FRAME		
	Check		Process	Layout.	Page 1 Of 1
	Appr.		Scale	Concept	Rev. No. 0
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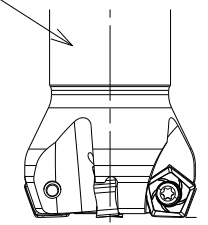
MODEL IN SCALE 1:3 TOOLS IN SCALE 1:2

**CUT 206**  
**Face Milling Finish**  
 EPV16R040M32.0-03  
 XVCT160512R-AJ TH10



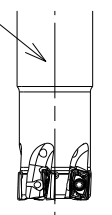
**Tung-AluMill**  
**TH10**

**CUT 206**  
**Face Milling Finish**  
 EEN09R040M32.0-04  
 PNCU0905GNFR-AJ TH10



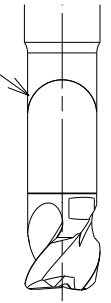
**Do Pent**  
**TH10**

**CUT 207**  
**Shoulder Milling Finish**  
 EPAV06M020C20.0R05  
 AVGT060308PBFR-AJ KS05F



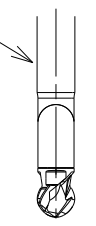
**Tung Force Rec**  
**KS05F**

**CUT 207**  
**Shoulder Milling Finish**  
 VSSD20L090S12-C  
 VEE200L12.0R05A03S12 KS15F

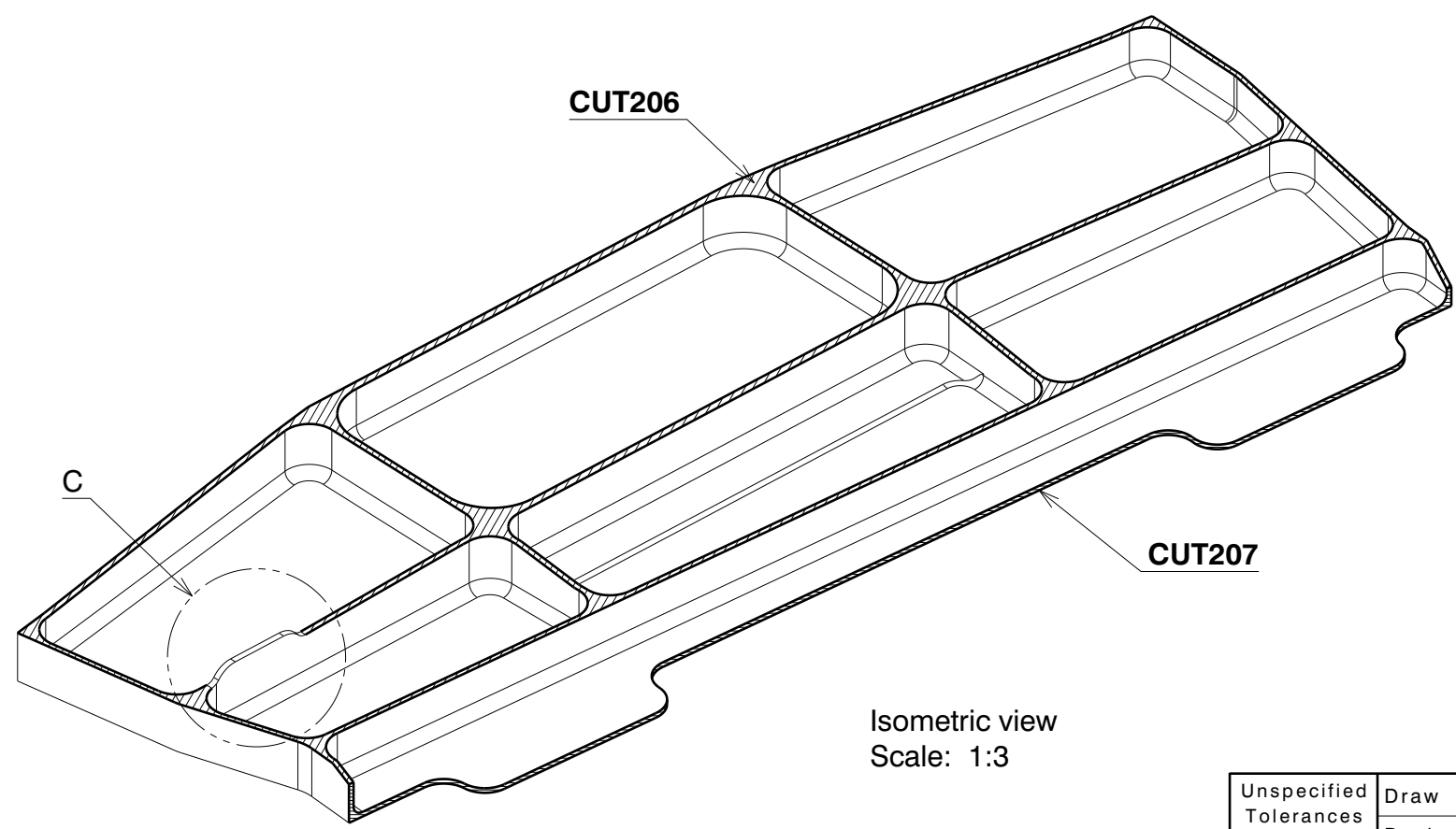


**Tung Meister**  
**KS15F**

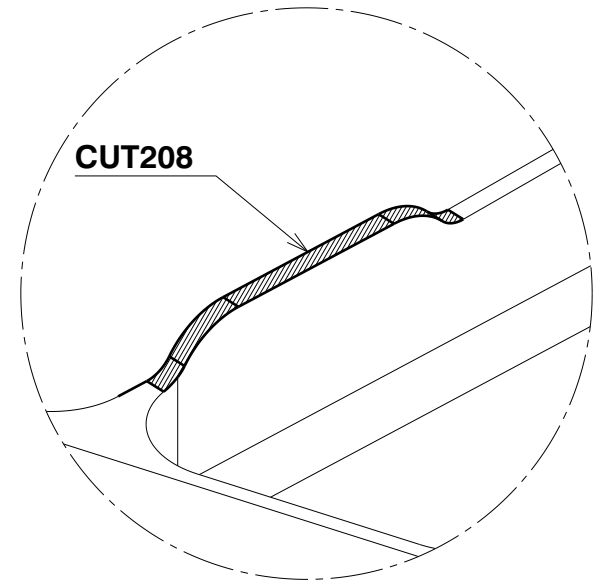
**CUT 208**  
**Profile Milling Finish**  
 VSSD10L070S06-C  
 VBE100L07.0-BGA02S06 KS15F



**Tung Meister**  
**KS15F**



Isometric view  
 Scale: 1:3



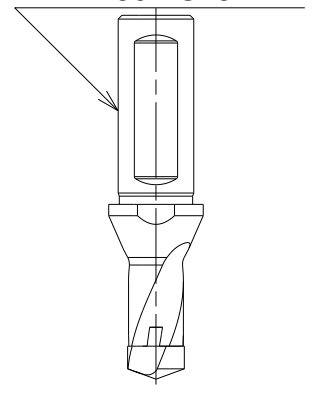
Detail C  
 Scale: 1:1

**M/C : Rib Milling**

Unspecified Tolerances	Draw		Customer: TUNGALOY	Japan	
Dim.s: --	Design		Designation:		
Angles: --	Check		LAYOUT OP200-FUSELAGE FRAME		Page 1
	Appr.		Process	Layout.	Of 1
	Scale -		Concept		Rev. No. 0
					Reg.No. 61146/1
					A3L

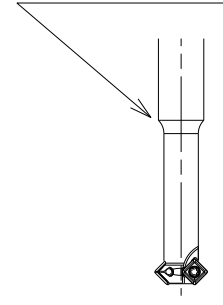
MODEL IN SCALE 1:3 TOOLS IN SCALE 1:2

**CUT 209**  
**Holemaking Finish**  
 TID150F20-1.5  
 DMN150 KS15F



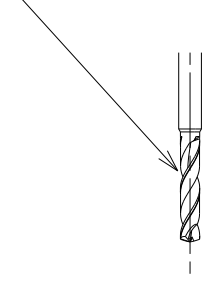
**Drill Meister  
 KS15F**

**CUT 210/211**  
**Chamfering Finish**  
 EASD05M008C12.0R02  
 SDHT050204FN-AJ TH10



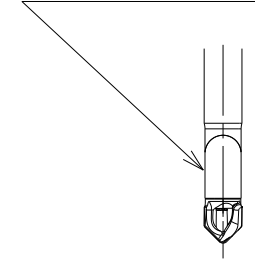
**Tung Quad  
 TH10**

**CUT 212**  
**Holemaking for thread**  
 DSC050FS MD10 (Special)



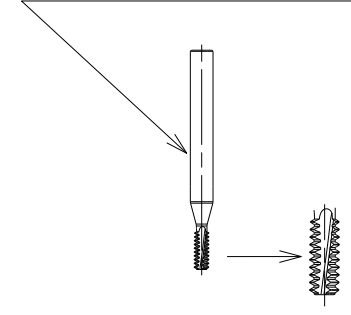
**Solid Drill**

**CUT 213**  
**Chamfering Finish**  
 VSSD10L070S06-C  
 VCP100L09.0A45-02S06 AH725

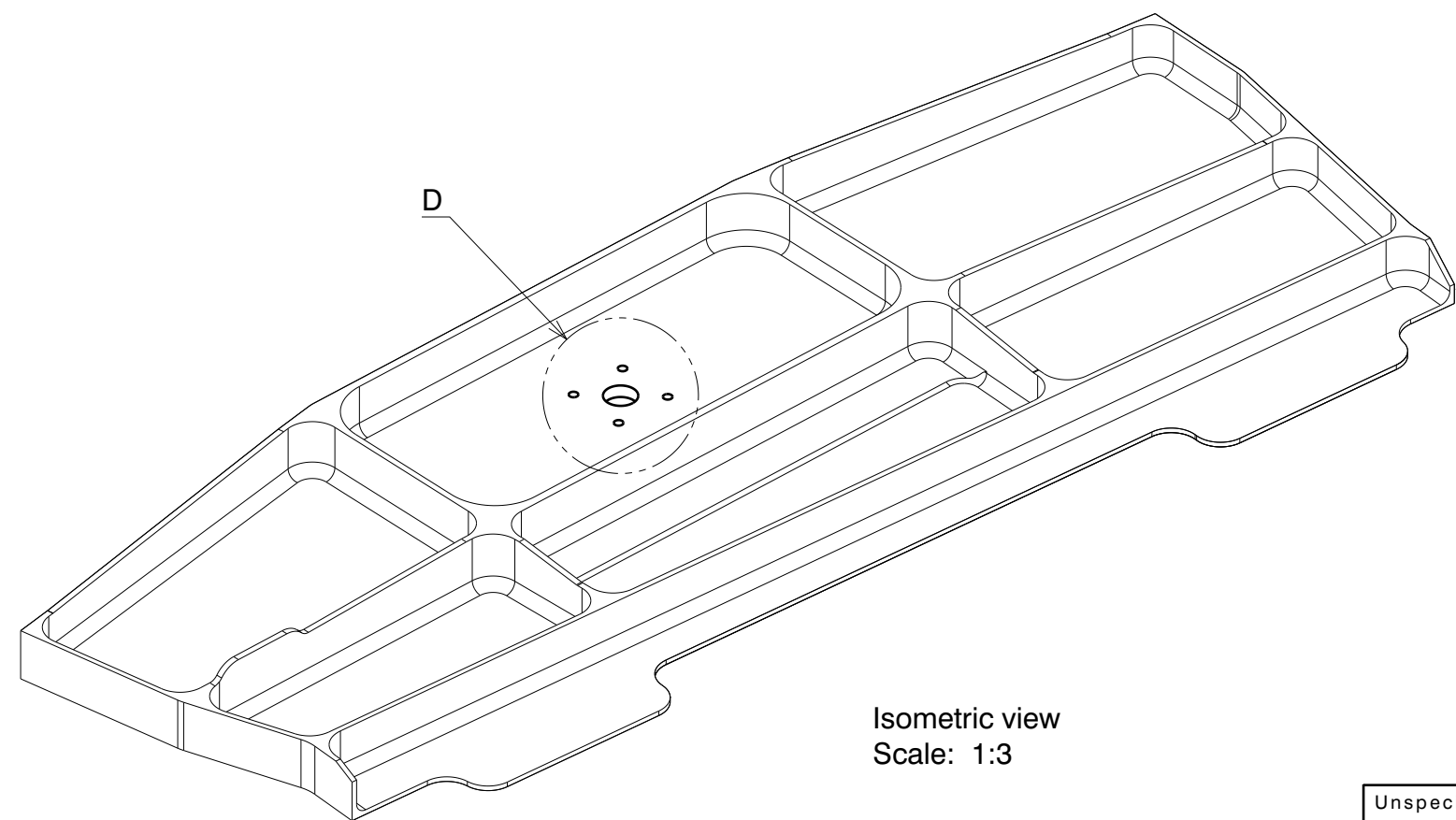


**Tung Meister**

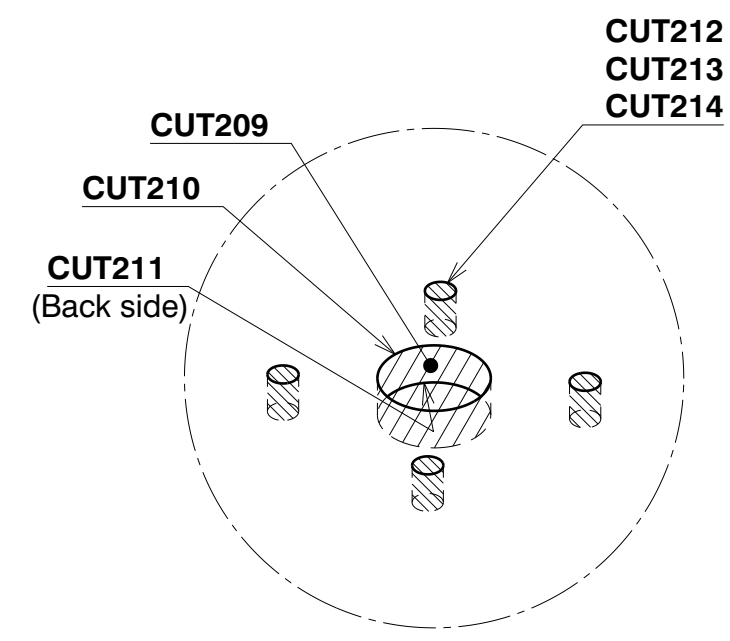
**CUT 214**  
**Int. Thread milling Finish**  
 MTEC0604C101.0ISO AH725



**Solid Thread**



Isometric view  
 Scale: 1:3



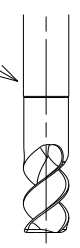
Detail D  
 Scale: 1:1

**M/C : Holemaking / Threading**

Unspecified Tolerances	Draw		Customer: TUNGALOY	Japan	
Dim.s:	Design		Designation:		
Angles:	Check		LAYOUT OP200-FUSELAGE FRAME		Page 1
	Appr.		Process	Layout.	Of 1
	Scale	-			Rev. No. 0
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					A3L

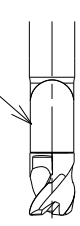
MODEL IN SCALE 1:3 TOOLS IN SCALE 1:2

**CUT 215**  
**Shoulder Milling Finish**  
 TECA120H3-18/36C12CF-R08 KS15F



**Solid Meister**  
**Variable Meister**  
**KS15F**

**CUT 215**  
**Shoulder Milling Finish**  
 VSSD12L070S08-C  
 VEE120L08.0R05A03S08 KS15F



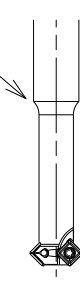
**Tung Meister**  
**KS15F**

**CUT 215**  
**Shoulder Milling Finish**  
 VSSD12L070S08-C  
 HPAV06M012S08R03  
 AVGT060304PBFR-AJ KS05F

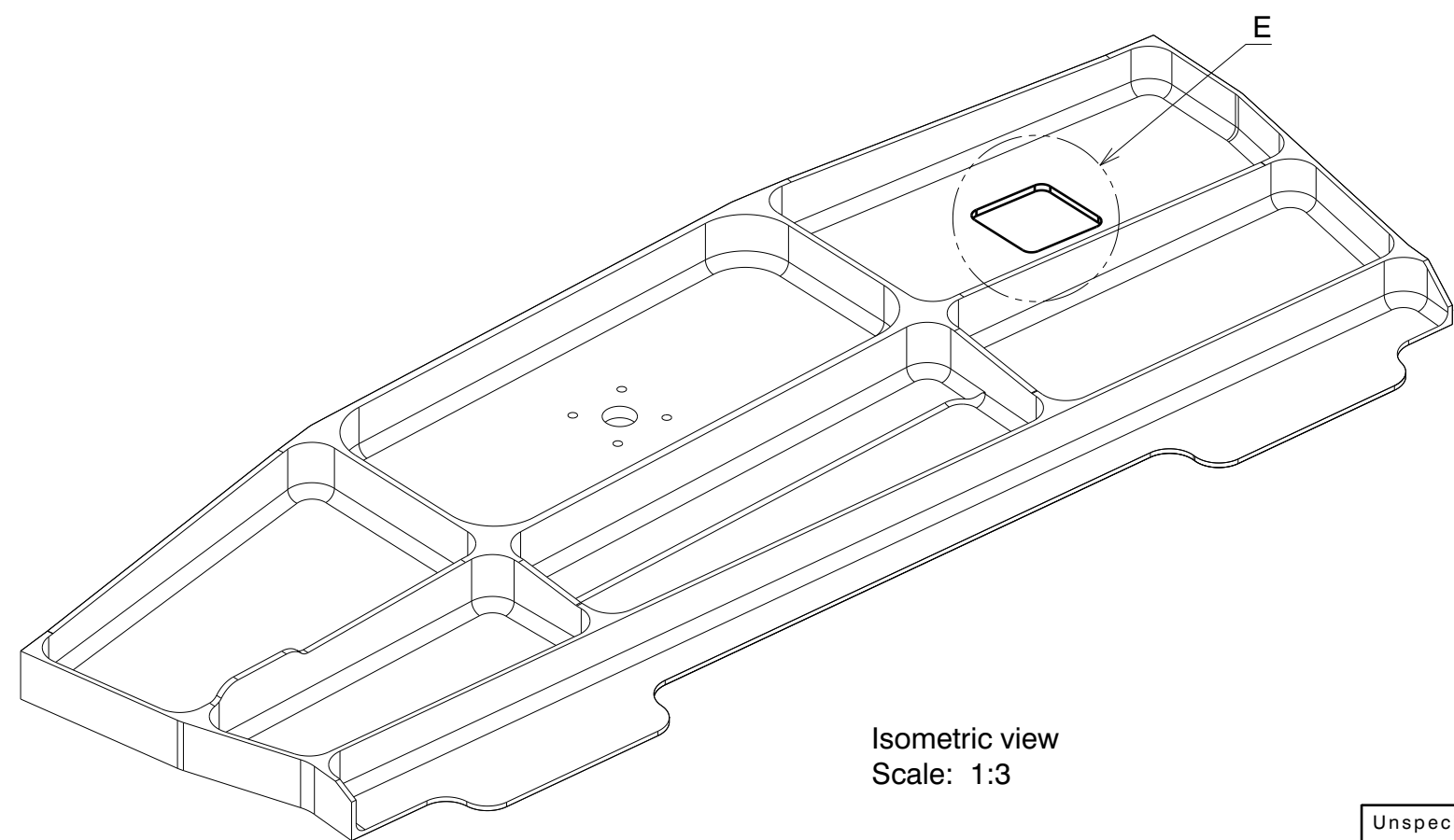


**Tung Force Rec**  
**Tung Meister**  
**KS05F**

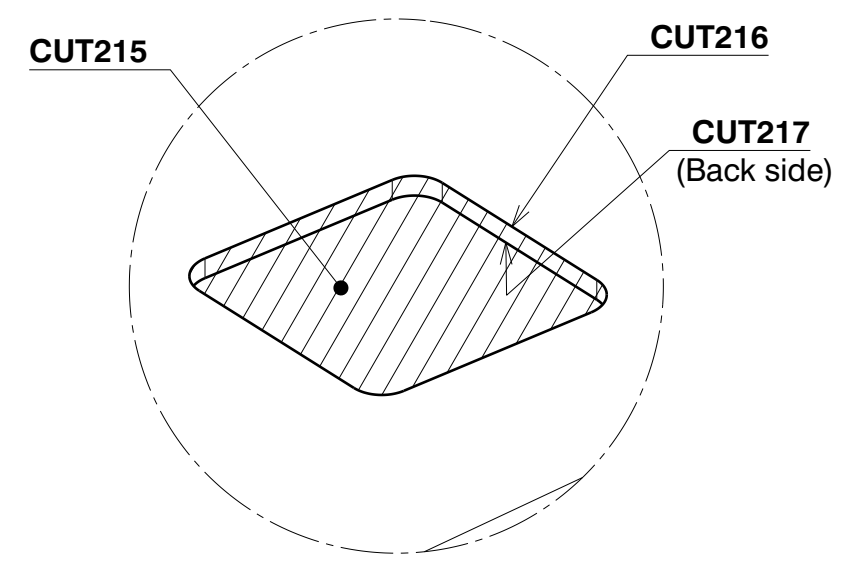
**CUT 216/217**  
**Chamfering Finish**  
 EASD05M008C12.0R02  
 SDHT050204FN-AJ TH10



**Tung Quad**  
**TH10**



Isometric view  
 Scale: 1:3



Detail E  
 Scale: 1:1

**M/C : Pocket Milling**

Unspecified Tolerances	Draw		Customer: TUNGALOY	Japan	
Dim.s: --	Design		Designation:		
Angles: --	Check		LAYOUT OP200-FUSELAGE FRAME		Page 1
	Appr.		Process	Layout.	Of 1
	Scale	-	Concept		Rev. No. 0
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