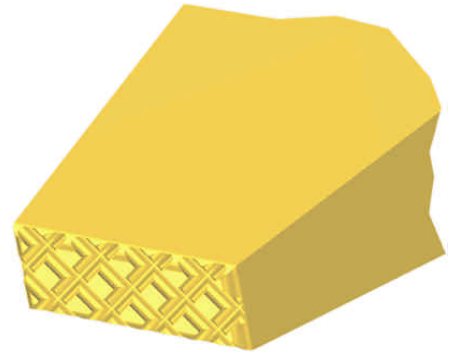
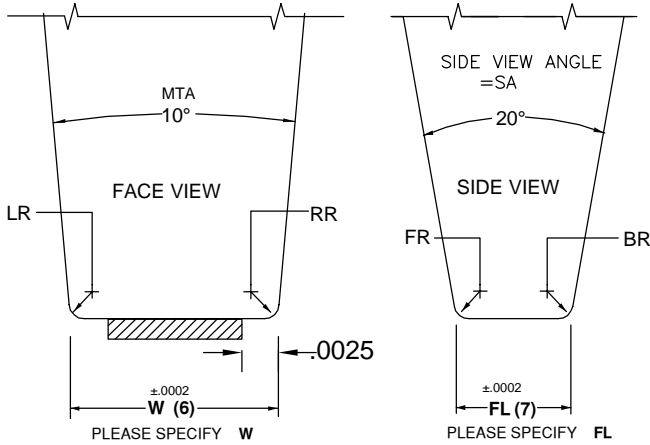


SERIES F 508 (A) (B) or (C)

RIBBON STANDARD : A & TD= $\emptyset \frac{1}{8}$, TDF=.110
 REQUIRED FOR ORDER: RIBBON SIZE & (4),(5),(7),(8),(9)

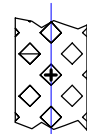


PLEASE SPECIFY W
 PLEASE SPECIFY FL

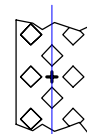
PLEASE SPECIFY EXAMPLE: ONLY FOR REFERENCE
 W= RIBBON WIDTH + 2 x .0025 RIBBON THICKNESS
 MORE THAN .010 (10 MILL) THEN 2x.0050

MTA = MAIN TAPER ANGLE = 10° STANDARD
 SA = SIDE VIEW ANGLE = 20° STANDARD

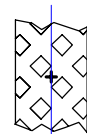
EXAMPLE :
 10: GG GROOVE TO GROOVE=.0060=(6)
 11: DS= DIAMOND SIZE=.0024=(2.4)
 12: GD=GROOVE DEPTH=.0020=(2)
 13: GR=GROOVE RADIUS=.0026=(2.6)



A=DIAMOND POSITION IN CENTER STANDARD



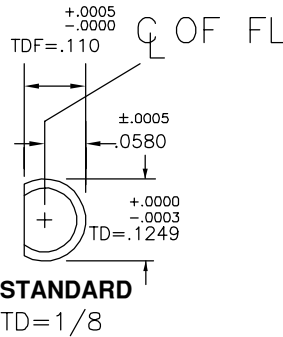
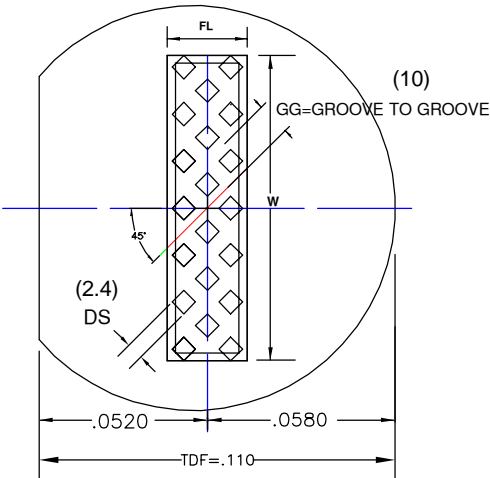
B= DIAMOND POSITION AROUND CENTER



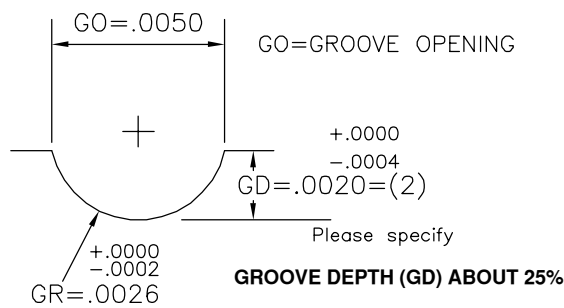
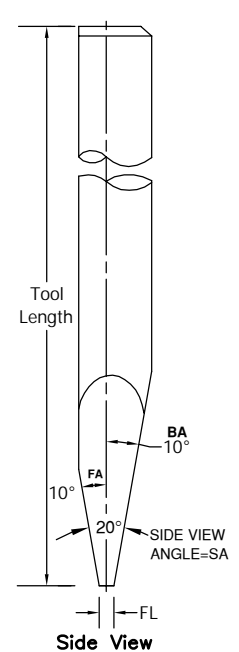
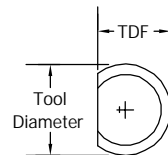
C= DIAMOND POSITION CENTER BETWEEN DIAMOND

	TD		TDF	
	inch	mm	inch	mm
1/16	.0624	1.58	.0460	1.17
	.0784	1.99	.0630	1.60
3/32	.0937	2.38	.0880	2.24
	.1180	3.00	.0985	2.50
1/8	.1249	3.17	.0937	2.38
1/8	.1249	3.17	.1100	2.79
1/8	.1249	3.17	.1180	3.00

Diamond Tip=DT preferably for large Tools
 Minimum of Groove:
 Radius=.00025
 Groove to Groove=.0015



STANDARD
 TD=1/8



DETAIL GROOVE EXAMPLE

SERIES F 508 (A) (B) or (C)

RIBBON A= STANDARD= (EMPTY FIELD)

REQUIRED FOR ORDER: RIBBON SIZE FOR GD CALCULATION & (4),(5),(7),(8),(9)

Special dimensions available upon request.
Dimensions not shown please specify.
Two or Four Sides Radius Tab Tool

Example in mil :
GG=.0060=6
.0060*1000=6

TOOL ANGLE:
(STANDARD=MTA=10°)
MTA=MAIN TAPER ANGLE
(STANDARD=SA=20°)
SIDE-VIEW ANGLE=SA

Special dimensions available upon request.

SAMPLE PART NUMBER: M-F-508A-1/8-2-.004X.002-B5-E-6-2.4-2-2.6-*

SYMBOL EXPLANATION: 1 2 3 4 5 6 7 8 9 10 11 12 13 14

1. MATERIAL: _____
M = Ceramic
C = Tungsten Carbide
T = Titanium Tip Carbide Shank ,
All other:
Material Selection Guide Tool Tips

2. SERIES: F _____
3. STYLE: 508 _____
Please specify
Diamond Position A, B, or C

4. TOOL DIAMETER: Please specify _____

5. TOOL LENGTH: Please specify _____

6. FOOT WIDTH: (W) Please specify _____

7. FOOT LENGTH: (FL) Please specify _____
Diamond Tip=DT
preferably for large Tools
Minimum of Groove:
Radius=.00025
Groove to Groove=.0015

8. FRONT/BACK RADIUS (FL): _____
Empty field=radius 0 or A
See Option Chart below. X=customized

**14. OPTION:
TOOL ANGLE: (TA)
and other OPTION**
Please specify
MTA=MAIN TAPER ANGLE
BA=BACK-ANGLE
FA=FRONT-ANGLE
SA = SIDE-VIEW ANGLE
STANDARD:
MTA=10°, SA=20° =Empty field

13. CROSS GROOVE RADIUS (GR):
Please specify in mil
Empty field=same as GD

12. CROSS GROOVE DEPTH (GD):
Please specify in mil

11. DIAMOND SIZE (DS)
Please specify in mil

10. GROOVE TO GROOVE (GG):
Please specify in mil

9. LEFT/RIGHT RADIUS (W):
Empty field=radius 0 or A
See Option Chart below. X=customized

OPTION CHART (8) RADIUS FOR FOOT LENGTH (FL)	OPTION LETTER		A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	
	FRONT RADIUS		in.	.0000	.0010	.0020	.0030	.0040	.0050	.0060	.0070	.0080	.0090	.0100	.0110	.0120	.0130	.0140
			μ	0	25	51	76	102	127	152	178	203	229	254	279	305	330	356
	BACK RADIUS		in.	.0000	.0010	.0020	.0030	.0040	.0050	.0060	.0070	.0080	.0090	.0100	.0110	.0120	.0130	.0140
		μ	0	25	51	76	102	127	152	178	203	229	254	279	305	330	356	

OPTION CHART (9) RADIUS FOR FOOT WIDTH (W)	OPTION LETTER		A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	
	LEFT RADIUS		in.	.0000	.0010	.0020	.0030	.0040	.0050	.0060	.0070	.0080	.0090	.0100	.0110	.0120	.0130	.0140
			μ	0	25	51	76	102	127	152	178	203	229	254	279	305	330	356
	RIGHT RADIUS		in.	.0000	.0010	.0020	.0030	.0040	.0050	.0060	.0070	.0080	.0090	.0100	.0110	.0120	.0130	.0140
		μ	0	25	51	76	102	127	152	178	203	229	254	279	305	330	356	

**EXAMPLE
ALL OTHER
RADIUS:**

A =.0000 B =.0010 A1 to A9=.0001-.0009
A4=.0004 B1=.0011 B1 to B9=.0011-.0019
A5=.0005 B2=.0012 C1 to C9=.0021-.0029
A6=.0006 B3=.0013 D1 to D9=.0031-.0039
A7=.0007 B4=.0014 for all
A8=.0008 B5=.0015

EXAMPLE:
RADIUS=.0000 = A
RADIUS=.0015 = B5
RADIUS=.0066 = G6