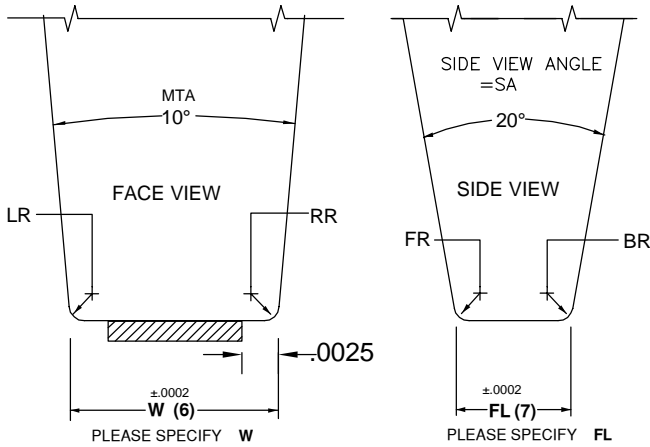
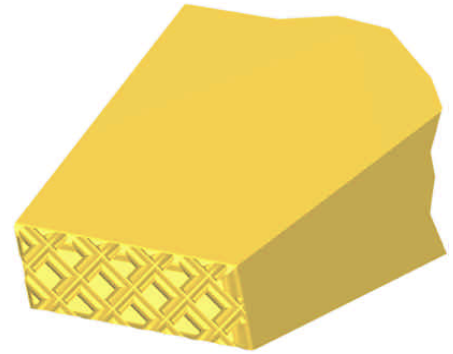


# SERIES F 508 (A) (B) or (C)

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

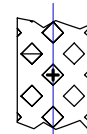
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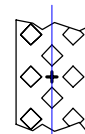
PLEASE SPECIFY W  
 PLEASE SPECIFY FL  
 PLEASE SPECIFY EXAMPLE: **ONLY FOR REFERENCE**  
 W= RIBBON WIDTH + 2 x .0025 RIBBON THICKNESS  
 MORE THAN .010 (10 MILL) THEN 2x.0050

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

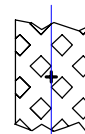
EXAMPLE :  
 10: GG GROOVE TO GROOVE=.0060=(6)  
 11: DS= DIAMOND SIZE=.0024=(2.4)  
 12: GD=GROOVE DEPTH=.0020=(2)  
 13: GR=GROOVE RADIUS=.0026=(2.6)



**A=DIAMOND POSITION IN CENTER STANDARD**



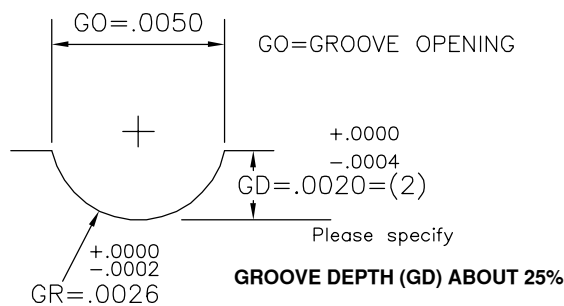
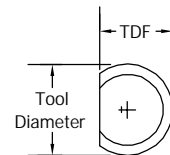
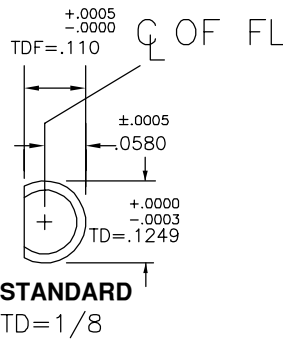
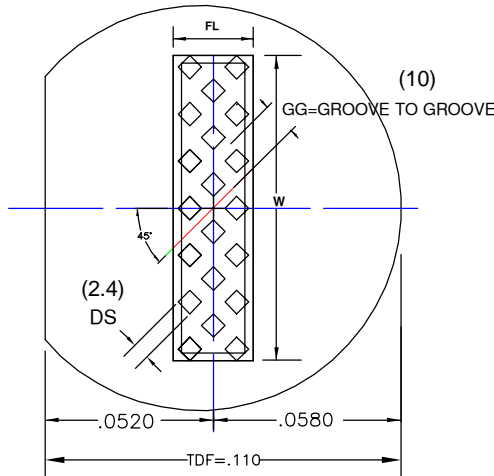
**B= DIAMOND POSITION AROUND CENTER**



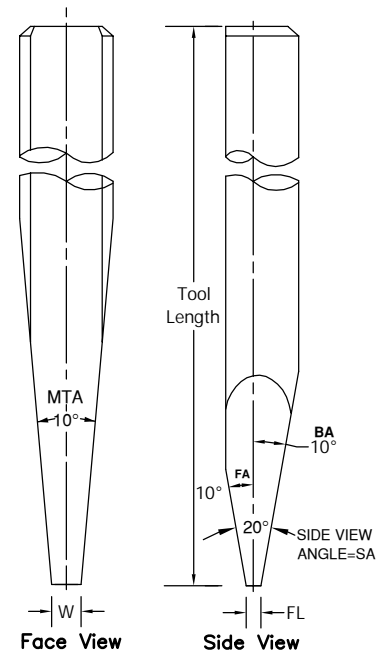
**C= DIAMOND POSITION CENTER BETWEEN DIAMOND**

	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



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

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