

Chart 1 Insert Shape

Symbol	Insert Shape
V	35° Diamond
D	55° Diamond
T	60° Triangle
C	80° Diamond
W	80° Trigon
S	90° Square
R	Round
A, K, M	Parallelogram

Chart 2 Relief Angle









Symbol	Relief Angle	
N	0°	
B	5°	
C	7°	
P	11°	
D	15°	
E	20°	
F	25°	

Chart 3 Tolerance

Symbol	Insert I.C.	Thickness	Nose Position
A	±.001	±.001	±.0002
C	±.001	±.001	±.0005
E	±.001	±.001	±.001
F	±.0005	±.001	±.0002
G	±.001	±.005	±.001
J	±.002	±.001	±.002
M	See Chart 3.1		
U	See Chart 3.1		

Chart 5 Inscribed Circle

Sumitomo Number SHAPE SIZE	I.S.O. Number							
	R	S	T	C	D	V	W	I.C.
(5)			06				03	5/32"
(6)			08					3/16"
			09					7/32"
	06							(.236)
2		06	11	06	07		04	1/4"
2.5		07		08	09			5/16"
	08							(.315)
3	09	09	16	09	11	16	06	3/8"
	10							(.394)
	12							(.472)
4	12	12	22	12	15	22	08	1/2"
5	15	15	27	16				5/8"
	16							(.630)
6	19	19	33	19				3/4"
	20							(.787)
	25							(.984)
8	25	25						1
	31							1-1/4"
	32							(1.260)

Chart 6 Thickness

Sumitomo Number	I.S.O. Number	Thickness
(2)	01	1/16"
1.5	02	3/32"
2	03	1/8"
2.5	T3	5/32"
3	04	3/16"
—	05	7/32"
4	06	1/4"
5	07	5/16"
5	08	5/16"
6	09	3/8"



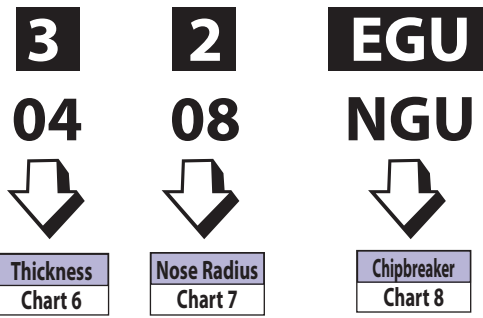


Chart 3.1 "M" and "U" Class Tolerance's

	Inscribed Circle		Nose Position Tolerance				Thickness
	M	U	M		U	M & U	
Shapes	All	All	S, T, C, R, W	D	V	All	All
I.C. Size							±.005
5/32 - 3/8	±.002	±.003	±.003	±.004	±.007	±.005	
7/16 - 9/16	±.003	±.005	±.005	±.006	±.010	±.008	
5/8 - 3/4	±.004	±.007	±.006	±.006	-	±.001	
7/8	±.006	±.010	±.006	±.006	-	±.015	
1	±.006	±.010	±.007	±.007	-	±.015	
1 1/4	±.006	±.010	±.008	±.008	-	±.015	

Chart 4

Symbol	Hole	Chipbreaker	Hole Style
A	Yes	No	Straight
G	Yes	Double	Straight
M	Yes	Single	Straight
N	No	No	None
R	No	Single	None
D	Yes	No	Countersunk
T	Yes	Single	Countersunk
X	Yes	10° Rake Angle	Straight or Countersunk
E	No	No	None

Chart 7 Nose Radius

Sumitomo Number	I.S.O. Number	Radius
v	00	.0012"
001	.0039"	
0.5	02	.0079"
1	04	.0156"
—	05	.0197"
2	08	.0312"
—	10	.0394"
3	12	.0469"
—	15	.0591"
4	16	.0625"
6	24	.0938"
8	32	.1250"
—	40	.1575"

Chart 8 Chipbreaker

See Pages 9-10 for chipbreaker information.

