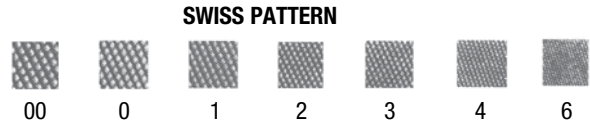


TECH INFORMATION

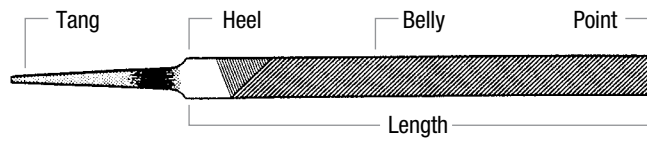
File Terminology

COARSENESS



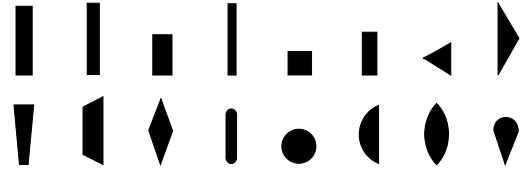
- Work to be accomplished, whether roughing or finishing, will determine type of teeth and coarseness for each application
- Most American pattern files are available with 3 grades of cut: bastard-cut, second-cut and smooth-cut
- Swiss pattern files are available in seven cuts: No. 00, 0, 1, 2, 3, 4, and 6
- The degree of coarseness is greater in longer files, but differences between bastard, second and smooth are proportionate

LENGTH



- Length is measured exclusive of tang, from point to heel, unless specified otherwise
- Desired stroke length, type of material and size will determine length required

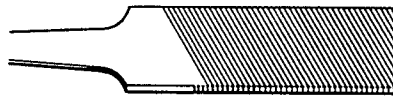
SHAPE



- Area to be filed will determine specific cross-section (round, square, flat, etc.) to be used

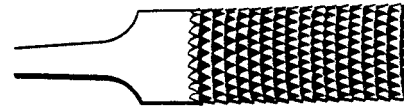
Kinds of Teeth

SINGLE-CUT



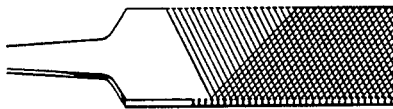
- Single set of parallel, diagonal rows of teeth
- Single-cut files are often used with light pressure to produce a smooth surface finish or to put a keen edge on knives, shears or saws

RASP-CUT



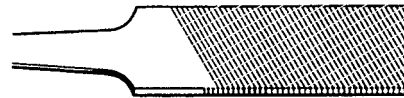
- Series of individual teeth which are formed by a single-pointed tool
- Produces a rough cut that is used primarily on wood, hooves, aluminum and lead

DOUBLE-CUT



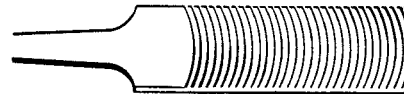
- 2 sets of diagonal rows of teeth
- Second set of teeth cut in opposite diagonal direction and on top of the first set
- First set of teeth is known as the overcut, second is known as upcut
- Upcut is finer than overcut
- Double-cut file is used with heavier pressure than the single-cut and removes material faster from the workpiece

MAGICUT®



- Single cut teeth divided by angular serrations into shorter cutting edges, which free themselves readily from chips and perform roughing and smoothing at the same time

CURVED-CUT



- Teeth arranged in curved contours across the file face
- Curved-cut file is normally used in automotive body shops for smoothing body panels

Safety Information

	⚠ WARNING
	Wear safety goggles to protect your eyes. Never use a file without a tight fitting handle.
	⚠ AVERTISSEMENT
	Porter des lunettes de protection. Ne jamais utiliser une lime sans poignée bien ajustée.
	⚠ ADVERTENCIA
	Use gafas de seguridad para proteger sus ojos. Nunca utilice una lima con el mango suelto.

⚠ WARNING	⚠ AVERTISSEMENT	⚠ ADVERTENCIA
Risk Of Eye Injury Wear ANSI Approved Eye Protection	Risque de dommages d'oeil Protection d'oeil approuvée de l'usage A.N.S.I.	Riesgo de lesión del ojo Protección de ojo aprobada del desgaste ANSI

Barrette Files - Hot Die



- XF® Files, Swiss Pattern Barrette File, Hot Die, Cut No. 00
- Made to More Exacting Measurements Than American Pattern Files
- Used By Tool and Die Makers, Jewelers, Model Makers, Home Craftsman
- Recommended for Those Who Do Superfine Precision Filing
- Double Cut, Wide Flat Sides
- Flat on 1 Side, Backs Are Beveled on Edges As Indicated By Cross Section
- Back and Beveled Edges Are Safe
- Included Angle is 33°
- Approximate Point Thickness is .040"/1.10mm
- Same As Regular Barrette Files Except with Thinner Point

Cat. No.	UPC No.	Packaging	Length	File Cut	Product Weight	Shelf Pack Qty.
35108N	037103241948	Boxed	3 in	00	0.02 lb	12
35114N	037103241955	Boxed	4 in	00	0.03 lb	12

6-1/2" (163mm) Die Sinker's Rifflers



- Made to More Exacting Measurements Than American Pattern Files
- Used By Tool and Die Makers, Jewelers, Model Makers and Home Craftsman
- Made in Approximately 6-1/2"/165mm Length
- Made in Shales As Illustrated
- Each Riffler Identified By Number

Cat. No.	UPC No.	Packaging	Length	File Cut	Style	Product Weight	Shelf Pack Qty.
35976	037103359766	Boxed	6-1/2 in	0	1	0.02 lb	12
35982	037103359827	Boxed	6-1/2 in	2	1	0.02 lb	12
36018N	037103360182	Boxed	6-1/2 in	2	5	0.02 lb	12
36054	037103360540	Boxed	6-1/2 in	2	7	0.02 lb	12

Equaling Files



- Made to More Exacting Measurements Than American Pattern Files
- Used By Tool and Die Makers, Jewelers, Model Makers and Home Craftsman
- Rectangular Shape
- Double-Cut on Sides, Single-Cut on Edges
- Parallel in Both Width and Thickness for Their Entire Length

Cat. No.	UPC No.	Packaging	Length	File Cut	Product Weight	Shelf Pack Qty.
36219N	037103241962	Boxed	4 in	0	0.05 lb	12
36227N	037103241979	Boxed	4 in	2	0.05 lb	12
36253N	037103241986	Boxed	6 in	2	0.10 lb	12
36281N	037103241993	Boxed	8 in	2	0.25 lb	12