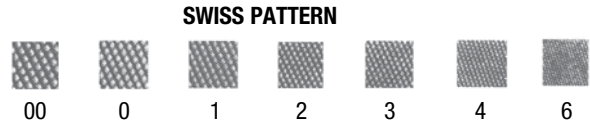


TECH INFORMATION

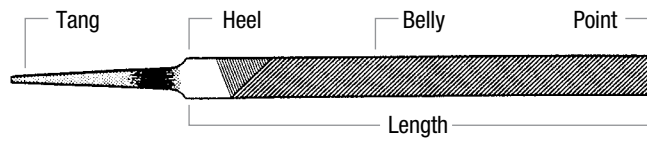
File Terminology

COARSENESS



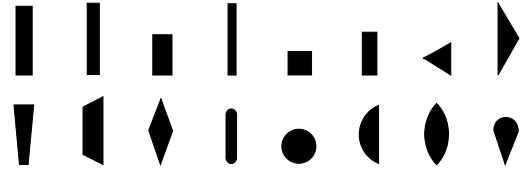
- Work to be accomplished, whether roughing or finishing, will determine type of teeth and coarseness for each application
- Most American pattern files are available with 3 grades of cut: bastard-cut, second-cut and smooth-cut
- Swiss pattern files are available in seven cuts: No. 00, 0, 1, 2, 3, 4,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

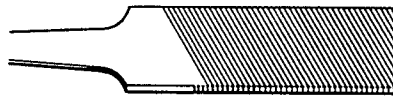
SHAPE



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

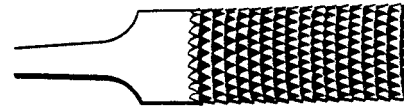
Kinds of Teeth

SINGLE-CUT



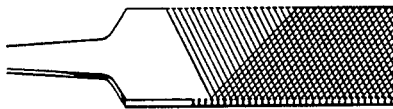
- Single set of parallel, diagonal rows of teeth
- Single-cut files are often used with light pressure to produce a smooth surface finish or to put a keen edge on knives, shears or saws

RASP-CUT



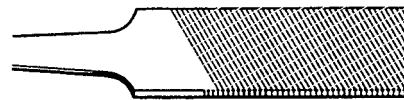
- Series of individual teeth which are formed by a single-pointed tool
- Produces a rough cut that is used primarily on wood, hooves, aluminum and lead

DOUBLE-CUT



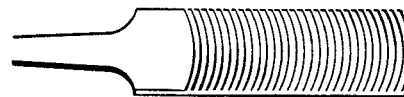
- 2 sets of diagonal rows of teeth
- Second set of teeth cut in opposite diagonal direction and on top of the first set
- First set of teeth is known as the overcut, second is known as upcut
- Upcut is finer than overcut
- Double-cut file is used with heavier pressure than the single-cut and removes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

Mill Files - 1 and 2 Round Edges



- Round Edges Are Used Where Rounding Gullets Are Preferred
- Compared to Sharp Corners or Squared Gullets
- Rectangular Shape
- Single Cut on Sides and Edges
- Bastard Cut
- Same As Regular Mill File Except It Has 1 Round Edge

Cat. No.	UPC No.	Packaging	Length	Handled	File Cut	Edge Type	Product Weight	Shelf Pack Qty.
09099N	037103243232	Boxed	8 in	No	Bastard	One Round	0.25 lb	12
09179N	037103243249	Boxed	10 in	No	Bastard	One Round	0.45 lb	12
09227N	037103243256	Boxed	12 in	No	Bastard	One Round	0.80 lb	6
09389N	037103243263	Boxed	8 in	No	Bastard	Two Round	0.25 lb	12
09469N	037103243270	Boxed	10 in	No	Bastard	Two Round	0.45 lb	12

Round Files



- American Pattern Round File, Bastard Cut
- Primarily Used to File Circular Openings or Concave Surfaces
- Single Cut
- Tapered Slightly Towards Point
- Round Shape
- Safe Point on Round Files

Cat. No.	UPC No.	Packaging	Length	Handled	Diameter	File Cut	Product Weight	Shelf Pack Qty.
11526N	037103231901	Boxed	4 in	No	1/8 in	Bastard	0.02 lb	12
11559NN	037103231895	Boxed	4 in	No	1/8 in	Second	0.02 lb	12
11592NN	037103231918	Boxed	4 in	No	1/8 in	Smooth	0.02 lb	12
11637N	037103231925	Boxed	5 in	No	3/16 in	Bastard	0.03 lb	12
11716N	037103231826	Boxed	6 in	No	1/4 in	Bastard	0.02 lb	12
11748N	037103231987	Boxed	6 in	No	1/4 in	Second	0.05 lb	12
11781N	037103231994	Boxed	6 in	No	1/4 in	Smooth	0.05 lb	12
11904	037103119049	Boxed	8 in	No	5/16 in	Bastard	0.14 lb	12
11936	037103119360	Boxed	8 in	No	5/16 in	Second	0.10 lb	12
11969	037103119698	Boxed	8 in	No	5/16 in	Smooth	0.20 lb	12
12019	037103120199	Boxed	10 in	No	3/8 in	Bastard	0.25 lb	12
12051	037103120519	Boxed	10 in	No	3/8 in	Second	0.25 lb	12
12084	037103120847	Boxed	10 in	No	3/8 in	Smooth	0.30 lb	12
12131	037103121318	Carded	12 in	No	1/2 in	Bastard	0.60 lb	6
12134	037103121349	Boxed	12 in	No	1/2 in	Bastard	0.55 lb	6
12166	037103121660	Boxed	12 in	No	1/2 in	Second	0.55 lb	6
12199	037103121998	Boxed	12 in	No	1/2 in	Smooth	0.55 lb	6
12248	037103122483	Boxed	14 in	No	5/8 in	Bastard	1.00 lb	6
21708N	037103232007	Carded	6 in	Yes	1/4 in	Bastard	0.21 lb	6
21715	037103217158	Carded	8 in	Yes	5/16 in	Bastard	0.26 lb	6
21846N	037103232014	Carded	6 in	No	1/4 in	Bastard	0.12 lb	3
21853	037103218537	Carded	8 in	No	5/16 in	Bastard	0.16 lb	6
21854	037103218544	Carded	10 in	No	3/8 in	Bastard	0.30 lb	6