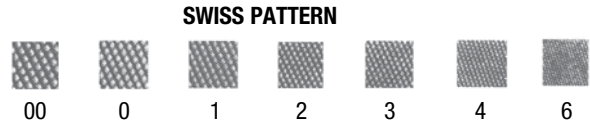


TECH INFORMATION

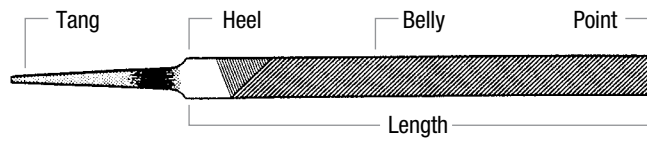
File Terminology

COARSENESS



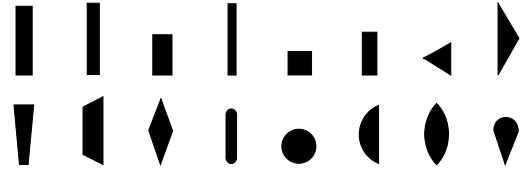
- Work to be accomplished, whether roughing or finishing, will determine type of teeth and coarseness for each application
- Most American pattern files are available with 3 grades of cut: bastard-cut, second-cut and smooth-cut
- Swiss pattern files are available in seven cuts: No. 00, 0, 1, 2, 3, 4,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

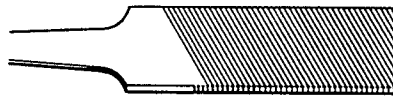
SHAPE



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

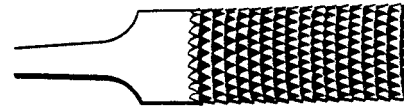
Kinds of Teeth

SINGLE-CUT



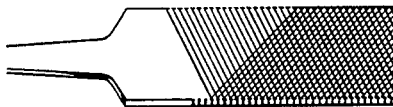
- Single set of parallel, diagonal rows of teeth
- Single-cut files are often used with light pressure to produce a smooth surface finish or to put a keen edge on knives, shears or saws

RASP-CUT



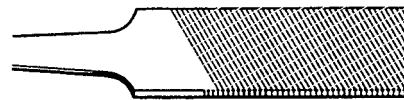
- Series of individual teeth which are formed by a single-pointed tool
- Produces a rough cut that is used primarily on wood, hooves, aluminum and lead

DOUBLE-CUT



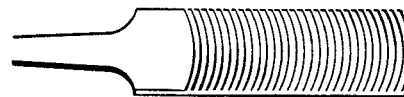
- 2 sets of diagonal rows of teeth
- Second set of teeth cut in opposite diagonal direction and on top of the first set
- First set of teeth is known as the overcut, second is known as upcut
- Upcut is finer than overcut
- Double-cut file is used with heavier pressure than the single-cut and removes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



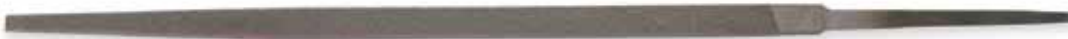
- Teeth arranged in curved contours across the file face
- Curved-cut file is normally used in automotive body shops for smoothing body panels

Safety Information

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

<b>⚠ WARNING</b>	<b>⚠ AVERTISSEMENT</b>	<b>⚠ ADVERTENCIA</b>
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

## Square Files



- American Pattern Square File, Bastard Cut
- Used on Slots, Keyways and General Surface Filing
- Square Shape
- Double Cut
- Tapered Slightly Towards Point
- Larger Sizes Frequently Preferred to Corresponding Flat Files
- This is Due to a Heavier Section and 4 Filing Surfaces

Cat. No.	UPC No.	Packaging	Length	Diameter	File Cut	Product Weight	Shelf Pack Qty.
12790	037103127907	Boxed	4 in	5/32 in	Bastard	0.03 lb	12
12857	037103128577	Boxed	4 in	5/32 in	Smooth	0.03 lb	12
12967	037103129673	Boxed	6 in	1/4 in	Bastard	0.10 lb	12
13000N	037103130006	Boxed	6 in	1/4 in	Second	0.08 lb	12
13033	037103130334	Boxed	6 in	1/4 in	Smooth	0.08 lb	12
13081	037103130815	Boxed	8 in	5/16 in	Bastard	0.10 lb	12
13114	037103131140	Boxed	8 in	5/16 in	Second	0.10 lb	12
13147	037103131478	Boxed	8 in	5/16 in	Smooth	0.55 lb	12
13196	037103131966	Boxed	10 in	3/8 in	Bastard	0.30 lb	12
13229	037103132291	Boxed	10 in	3/8 in	Second	0.30 lb	12
13262	037103132628	Boxed	10 in	3/8 in	Smooth	0.30 lb	12
13310	037103133106	Boxed	12 in	1/2 in	Bastard	0.65 lb	6
13343	037103133434	Boxed	12 in	1/2 in	Second	0.68 lb	6
13376	037103133762	Boxed	12 in	1/2 in	Smooth	0.65 lb	6
13425	037103134257	Boxed	14 in	5/8 in	Bastard	1.20 lb	6

## Taper (Triangular) Saw Files

Number of Saw Points	Files Recommended
4	7" Heavy or 8" Regular Taper
5	7" Regular Taper or 10" Slim
5 1/2	7" Regular Taper or 10" Slim
6	5" or 6" Regular Taper 7" or 8" Slim
7	6" or 7" Slim
8	4" Regular Taper 6" Slim, 7" X Slim, 8" XX Slim
9	5" Slim, 6" X Slim, 7" XX Slim
10	3 1/2" Regular Taper or 5" Slim, 5" or 6" X Slim
11	3" Regular Taper or 4" Slim, 5" X Slim, 6" XX Slim
12	3" Regular Taper or 5" X Slim
13,14	4" X Slim or 5" XX Slim
15,16	4" XX Slim

- Made for Filing Saws with 60° Angle Teeth
- Triangular Shape
- Single-Cut
- Edges Set and Cut for Filing Gullets Between Saw Teeth
- When Filing Handsaws, it is Important to Select the Right File
- In general, the table lists suggested size and type of file that will give best result