

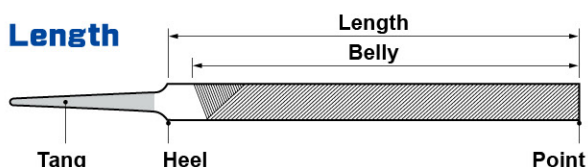
File Terminology

American Pattern



- Work to be accomplished, 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.
- The degree of coarseness is greater in longer files, but differences between bastard, second and smooth are proportionate.

Length

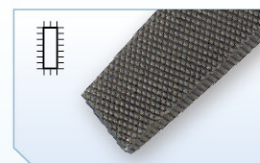


- Length is measured exclusive of tang, from point to heel, unless specified otherwise.
- Desired stroke length, type of material and size will determine length required.

Shape



Mill File



Flat File



Half Round File

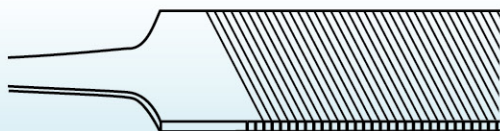


Round File



Three Square File

Kinds of Teeth



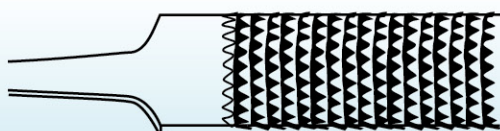
Single-cut

- 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.



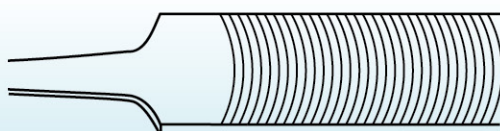
Double-cut

- 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.



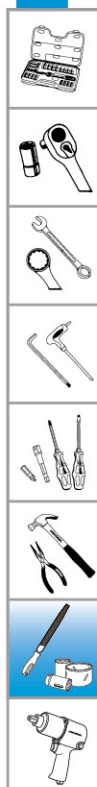
Rasp-cut

- 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.





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.



Three Square Files

Three Square File

Item No.	Size		 kgs
Rough (Bastard Cut)			
84-501	4"	10/240	0.2/7.5
84-502	6"	10/180	0.6/13.0
84-503	8"	10/120	1.2/13.0
84-504	10"	12/72	2.3/15.0
84-505	12"	6/36	2.5/11.0
84-506	14"	6/24	3.7/16.0
Middle (Second Cut)			
84-511	4"	10/240	0.2/7.5
84-512	6"	10/180	0.6/13.0
84-513	8"	10/120	1.2/13.0
84-514	10"	12/72	2.3/15.0
84-515	12"	6/36	2.5/11.0
84-516	14"	6/24	3.7/16.0
Fine (Smooth Cut)			
84-521	4"	10/240	0.2/7.5
84-522	6"	10/180	0.6/13.0
84-523	8"	10/120	1.2/13.0
84-524	10"	12/72	2.3/15.0
84-525	12"	6/36	2.5/11.0
84-526	14"	6/24	3.7/16.0

- Single-cut.
- Made for filing saws with 60° angle teeth, axes and machetes.



← If plastic handle were needed, please add additional "PH" to the item number.

For Example

