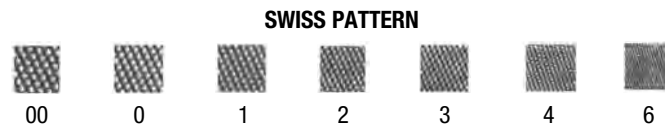


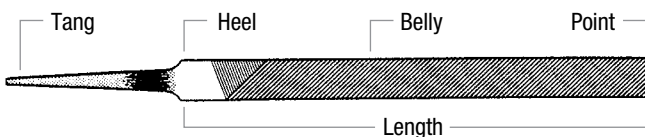
# File Terminology

## COURSENESS



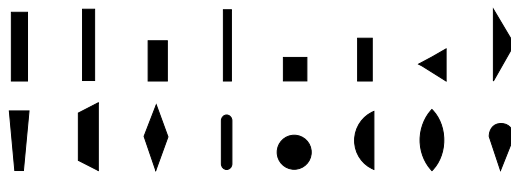
- Work to be accomplished, whether roughing or finishing, will determine type of teeth and coarseness for each application
- Most American pattern files are available with 3 grades of cut: bastard-cut, second-cut and smooth-cut
- Swiss pattern files are available in seven cuts: No. 00, 0, 1, 2, 3, 4,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

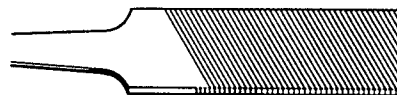
## SHAPE



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

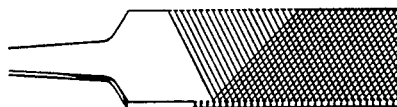
# Kinds of Teeth

## 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

## DOUBLE-CUT



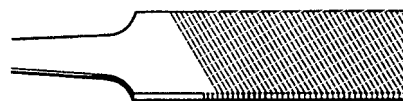
- 2 sets of diagonal rows of teeth
- Second set of teeth cut in opposite diagonal direction and on top of the first set
- First set of teeth is known as the overcut, second is known as upcut
- Upcut is finer than overcut
- Double-cut file is used with heavier pressure than the single-cut and removes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

## RASP-CUT



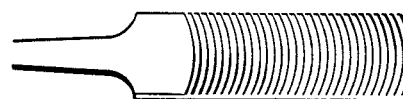
- Series of individual teeth which are formed by a single-pointed tool
- Produces a rough cut that is used primarily on wood, hooves, aluminum and lead

## 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	Risque de dommages d'oeil	Riesgo de lesión del ojo
	Wear ANSI Approved Eye Protection	Protection d'oeil approuvée de l'usage A.N.S.I.	Protección de ojo aprobada del desgaste ANSI