

File Selection Guide

COARSENESS

- Work to be accomplished, roughing, or finishing will determine type of teeth and coarseness for each application
- Degree of coarseness is greater in longer files, but the difference between bastard, second, and smooth are proportionate

American Pattern

- Most American pattern files are available with 3 grades of cut: Bastard Cut, Second Cut, Smooth Cut



Bastard Cut



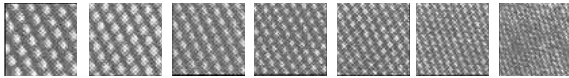
Second Cut



Smooth Cut

Swiss Pattern

- Swiss pattern files are available in 7 cuts: Nos. 00, 0, 1, 2, 3, 4, and 6



00

0

1

2

3

4

6

FILE SHAPES



Pillar



Half Round



Round & Chain Saw



Square



Aluminum, Rasp



Lathe, Handy File, Flat, Mill, Warding, Magicut



Taper, Three Square, Machinist's Scraper

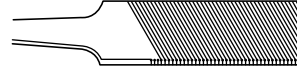


Knife

KINDS OF TEETH

Single-Cut

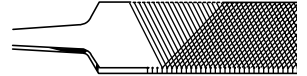
- Single set of parallel, diagonal rows of teeth



- 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 direction and on top of the first set



- First set of teeth is known as **OVERCUT**, the second set 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

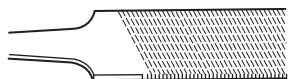
Rasp-Cut

- 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

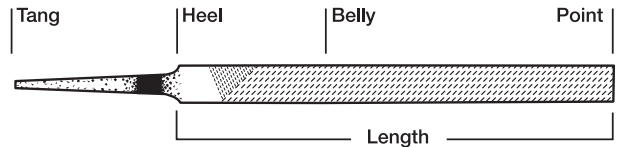


Magicut®

- 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



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