File Terminology

Coarseness

American Pattern

Bastard cut Second cut Smooth cut

Swiss pattern files

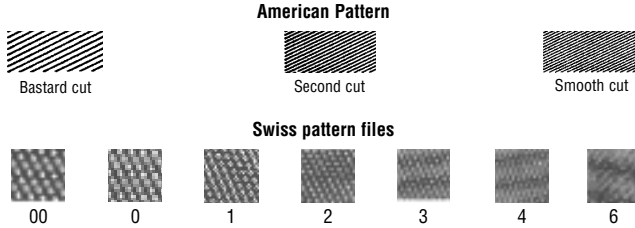00   0   1   2   3   4   6

- 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
- 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

Tang   Heel   Belly   Point
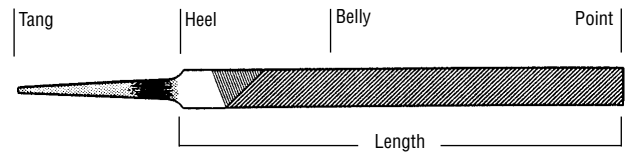
Length

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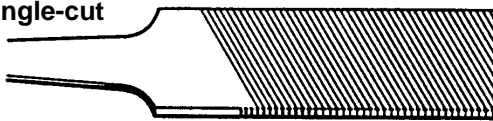
Shape
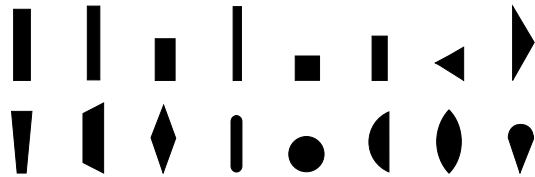
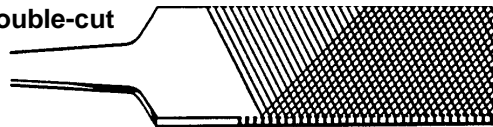- Area to be filed will determine specific cross-section (round, square, flat, etc.) to be used

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
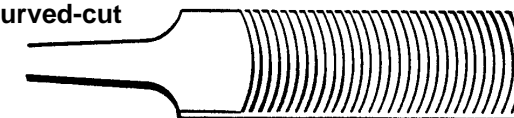
Rasp-cut

- 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

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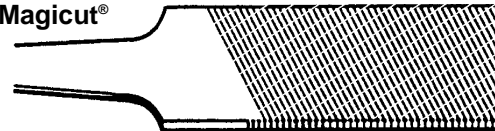
- Single cut teeth divided by angular serrations into shorter cutting edges, which free themselves readily from chips and perform roughing and smoothing at the same time

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