

Files, Half-Round, Double Cut



1. Scope

This standard covers the requirements for half-round general purpose files and half-round pipeline files.

This standard applies to the following Seattle City Light (SCL) stock numbers:

Stock No.	Type	Length (in)	Double Cut
762050	General purpose	4	Bastard
762051	General purpose	6	Bastard
762052	General purpose	8	Bastard
762053	General purpose	10	Bastard
762054	General purpose	12	Bastard
762064	General purpose	12	Second cut
762073	General purpose	10	Smooth
762055	Pipeline files	14	Bastard

For additional file material standards see SCL 7637.41 through 7637.71.

2. Application

Files are hand tools used for sharpening, smoothing, cutting, and reducing, and for enlarging slots on a workpiece.

Half-round general purpose files can be used for filing out concave surfaces and crevices, and for rounding out holes. The spiral cut enables them to remove metal rapidly and leaves a smooth finish.

Half-round pipeline files (Stock No. 762055) can be used for filing pipeline welds and root passes, and for scale removal from pipeline.

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3. Definitions

Cut: The number of teeth per inch.

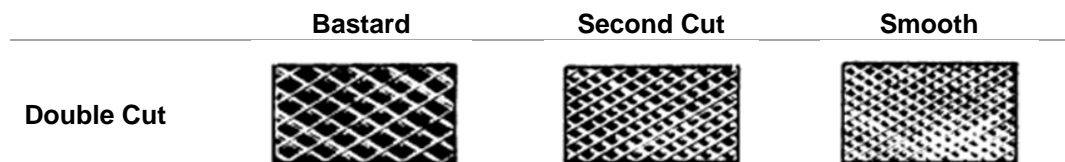
Cut Coarseness: Refers to the coarseness of the file as defined below and as shown in Figure 3:

- **Bastard:** Having fewer teeth per unit length than second cut.
- **Second Cut:** Having more teeth than bastard and less teeth than smooth per unit length.
- **Smooth:** Having more teeth per unit length than second cut.

Cut Pattern: Refers to the type of cut as defined below and shown in Figure 3.

- **Double Cut:** Has two parallel sets of cuts crossing each other.

Figure 3. Double Cut File Pattern and Coarseness



4. Industry Standards

Half-round files shall meet the applicable requirements of the latest revision of the following industry standards:

ANSI/DOD A-A-2312A; File, Hand (American Pattern), Half Round

5. Requirements

Product requirements shall be as described below and as defined in Section 7.

- Made of high carbon steel
- Case hardened, except for tang
- Tanged at one end to accommodate fitted handle
- Half-round shape with a flat side
- American pattern
- Spiral cut teeth on round side

6. Packaging

Product shall be packaged to prevent damage during shipping, handling, and storage.

Individual packages shall be legibly marked with:

- Manufacturer name
- Manufacturer catalog number
- Product description
- Seattle City Light stock number

Shipping containers shall be legibly marked with:

- Seattle City Light purchase order number

7. Issuance

Stock Unit: EA

8. Approved Manufacturers

Stock No.	Type	Length (in)	Cut	PFERD	Simonds	Nicholson
762050	General purpose	4	Bastard	11150	73315000	04695N
762051	General purpose	6	Bastard	11020	73317000	04795N
762052	General purpose	8	Bastard	11023	73319000	04896N
762053	General purpose	10	Bastard	11026	73321000	04995N
762054	General purpose	12	Bastard	11029	73323000	05094N
762064	General purpose	12	Second cut	11030	73323500	05125N
762073	General purpose	10	Smooth	11028	73322000	05059N
762055	Pipeline files	14	Bastard	11155	73756060	05190N

9. References

SCL Material Standard 7637.41; “File Handles and File Card with Brush”

SCL Material Standard 7637.46; “Files, Round, Regular and Chain Saw”

SCL Material Standard 7637.56; “Files, Taper”

SCL Material Standard 7637.61; “Files, Flat, Double-Cut”

SCL Material Standard 7637.66; “Files, Mill, Single Cut”

SCL Material Standard 7637.71; “Files, Assorted”

10. Sources

Lu, Curtis; SCL Standards Engineer and subject matter expert for 7637.51
(curtis.lu@seattle.gov)

Neuansourinh, Ponet; SCL Standards Engineer and originator of 7637.51
(ponet.neuansourinh@seattle.gov)

SCL Stock Catalog page 76-34; April 8, 2004

www.ansi.org

www.apextoolgroup.com

www.pferdusa.com

www.simondssaw.com