

Files, Taper, Single Cut



1. Scope

This standard covers the requirements for taper files.

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

Stock No.	Length (in)	Taper
762212	4	Slim
762213	5	Slim
762214	6	Slim
762216	8	Slim
762217	10	Slim
762222	4	Extra Slim
762224	6	Extra Slim
762225	7	Extra Slim

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.

Taper files can be used for shaping or sharpening saws with 60 degree angle teeth.

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 3a:

- **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.

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

- **Single Cut:** Has a set of parallel cuts extending across the length of the file.
- **Double Cut:** Has two parallel sets of cuts crossing each other.

Taper: Taper saw files are triangular in shape, have cut edges, and taper toward the point in width and thickness. See Figure 3b.

Figure 3a. Single Cut File Pattern and Coarseness

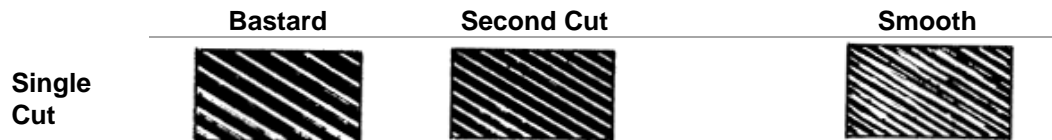


Figure 3b. Taper Files



4. Industry Standard

Files shall meet the applicable requirements of the latest revision of the following industry standard:

ANSI/DOD A-A-2321A; File, Hand (American Pattern), Taper

5. Requirements

File 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
- Triangular shape and tapered toward the point
- American pattern
- Single cut
- Second cut
- 60-degree angle teeth

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.	File Length (in)	Taper	Manufacturer		
			Simonds	PFERD	Nicholson
762212	4	Slim	73535500	17022	14106M
762213	5	Slim	73536500	17023	14162M
762214	6	Slim	73537000	17024	14224M
762216	8	Slim	73538000	17026	14290M
762217	10	Slim	73538500	–	14341N
762222	4	Extra Slim	73547500	17027	14547M
762224	6	Extra Slim	73549500	17029	14665M
762225	7	Extra Slim	73550000	–	14698N

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 7637.51; “Files, Half-Round”

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

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Neuansourinh, Ponet; SCL Standards Engineer and originator of 7637.56
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www.ansi.org

www.apextoolgroup.com

www.pferdusa.com

www.simondssaw.com