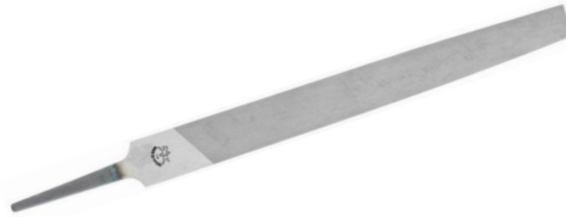


Files, Mill, Single Cut



1. Scope

This standard covers the requirements for single cut mill files.

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

Stock No.	Length (in)	Cut
762103	4	Bastard
762104	6	Bastard
762106	8	Bastard
762107	10	Bastard
762108	12	Bastard
762109	14	Bastard
762116	8	Second cut
761955	8	Smooth

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.

Mill files can be used for sharpening mill saws and cutting tools.

3. Definitions

Cut: The number of teeth per inch.

Cut Coarseness: Refers to the coarseness of the file. See 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 shown in Figure 3.

Single Cut: Has a set of parallel cuts extending across the length of the file.

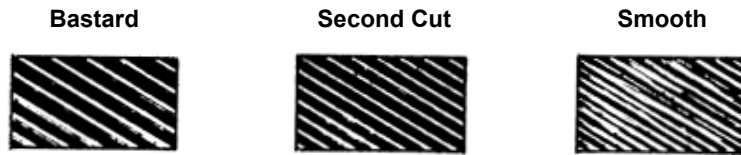
Standards Coordinator
Curtis Lu

Standards Supervisor
John Shippek

Unit Director
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Figure 3. Single Cut File Pattern and Coarseness



4. Industry Standards

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

ANSI/DOD A-A-2316; File, Hand (American Pattern), Mill

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
 - Rectangular shape
 - Tapered toward the point in width
 - American pattern
 - Single cut on both sides
 - Single cut on the edges
-

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.	Length (in)	Cut	Pferd	Simonds	Nicholson
762103	4	Bastard	–	73140500	08243N
762104	6	Bastard	19001	73143000	08354N
762106	8	Bastard	19004	73145500	08497N
762107	10	Bastard	19007	73147500	08642N
762108	12	Bastard	19010	73149500	08737N
762109	14	Bastard	–	73151500	08832N
762116	8	Second cut	19005	73146000	08529N
761955	8	Smooth	–	73146500	08560N

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 7637.56; “Files, Taper”

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

SCL Material Standard 7637.71; “Files, Assorted”

10. Sources

Lu, Curtis; SCL Standards Engineer and subject matter expert for 7637.66
(curtis.lu@seattle.gov)

Neuansourinh, Ponet; SCL Standards Engineer and originator of 7637.66
(ponet.neuansourinh@seattle.gov)

SCL Stock Catalog page 76-35; October 19, 2005

www.ansi.org

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