

Hand Files are Great for Many Application

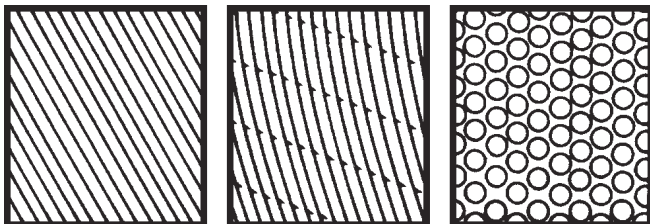
*Filing • Deburring • Shaping • Forming • Chamfering • Sharpening
Smoothing • Beveling • De-Flashing • Trimming and De-Scaling*

Severance Offers Four Types of Hand Files To Solve Virtually Every Application

Carbide – Severance Tool originated the Carbide Hand files which are ideal for use on hard materials, which quickly dull ordinary steel files. They are available in several sizes, styles, cuts and tooth patterns to meet almost any application requirement. Carbide files are stocked in coarse, medium and fine cuts, and in standard tooth pattern. Other cuts and patterns can be supplied promptly to order. **Severance Tool can regrind dull carbide files many times for a fraction of the new file cost.**

Cubic Boron Nitride – The CBN file segment has thousands of cubic boron nitride particles on its surface. Low heat generation makes it ideal for high speed rotary applications (such as working on a lathe or turning machinery) versus conventional files. Removes material quickly and easily without clogging or loading up. Ideal for use on High Speed Tool Steels, High Nickel Alloys, Hardened Structural Steels.

Standard Tooth Patterns



Standard Tooth

Curved Tooth

Diamond Grid
CBN Grid

Tooth Patterns Available

Standard Tooth– Used in deburring and smoothing many different types of materials; M-2, M-42, Cold and Hot Roll Steels. Used with light pressure for smooth finishes or to sharpen cutting surfaces on Steel, Aluminum, Cast Iron, Bronze.

Curved Tooth– Used in removing and smoothing different types of surfaces: Flat, Curved, and Round. Used for fast material removal with less material loading up on file. Used in the Auto Industries for shaping Sheet Metals, also used in Aluminum, Cast Iron, Bronze, Lead Zinc, and Plastics.

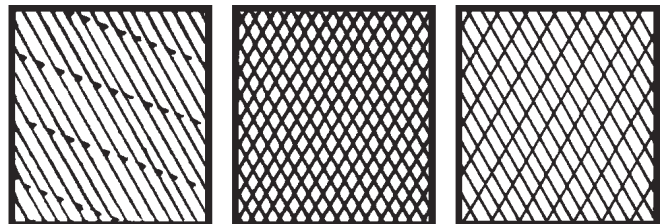
Diamond Grid– High stock removal rate makes jobs easier and faster. Deep recesses remove material quickly without clogging or loading up. Available in coarse or fine grits. Works on Carbide, Hardened Steel, Ceramics, Glass, Fiberglass, Composites, and more.

CBN Grid (Cubic Boron Nitride) – Used in high speed rotary applications because it will not generate heat. Removes material

Diamond – The diamond file segment has thousands of diamonds on its surface. Deep recesses remove material quickly and easily without clogging or loading up. High stock removal rate makes jobs faster and easier than conventional files. Very little pressure is used, thereby reducing worker fatigue and increasing output. Works on: Carbide, Glass, Fiberglass, Laminates, Graphite, Plexiglas, Hard Alloys, Hardened Dies, and more.

Steel – Tough, fatigue-resistant select grade of Molybdenum steel. Heat treated before final grinding to provide the optimum combination of properties for high performance. Steel Files will produce the same cutting action as our Carbide Files and are the ideal “medium” material where inexpensive files do not hold up and where chipping might occur using Carbide Files on an interrupted cut. Steel files may also

Special Tooth Patterns



Chip Breaker

Rasp Tooth

Double Cut

NOTE: Standard tooth patterns will be supplied, unless specified.

easily without clogging or loading up. Available in coarse or fine grits. Works on High Speed Tool Steels, High Nickel Alloys and more.

Chip Breaker – Adding chip breakers will not reduce the finish but will make them cut a little better since no large shavings are produced.

Rasp Tooth – Ideal for fast material removal on relatively soft materials. Used with heavy pressure for rough finishes, shaping or sharpening cutting surfaces on Steel, Aluminum, Cast Iron, Bronze, Wood and other soft material. Rasp tooth pattern will produce a rougher finish than other tooth patterns.

Double Cut – Used with medium pressure for medium finishes, shaping or sharpening cutting surface on Steel, Aluminum, Cast Iron, and Bronze.