



Unit 14 Cutting operations with machines and by hand

Task 05

Announcer: Listen to Lilly's and David's supervisor Mr Kaup talking about filing.

Mr Kaup: Ok, today we are going to speak about filing. You know, work pieces are often finished by filing. All files have wedge-shaped teeth. The chips gather in the tooth spaces and are discharged over the edges of the work piece as the file moves over the surface. Do you know how files are made?

David: Yes, the basic shape of any file is forged. Next, wedges are cut or milled into the file. And the file handle is fixed at the forged tang of the file.

Mr Kaup: That's right. So, David has already mentioned the two groups of files ... There are milled files and cut files. Lilly, can you tell me the difference?

Lilly: Yes ... uhm ... Milled files have a positive chip angle and large chip holes. Cut files have a negative chip angle and small chip holes.

Mr Kaup: That's right! Could you also tell me what are they used for?

Lilly: Milled files are used for soft materials, such as aluminium or synthetic materials. Cut files are for harder materials, such as steel or grey cast iron.

Mr Kaup: Excellent, I see, you're filing experts ...