



Unit 14 Cutting operations with machines and by hand

Task 05. Fill in the missing words from the box.

wedge-shaped – filing – forged – cut – chips – tooth spaces – chip holes – file
handle – tang – milled – chip angle – cut – soft materials – harder materials

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

Mr Kaup: Ok, today we are going to speak about _____. You know, work pieces are often finished by filing. All files have _____ teeth. The _____ gather in the _____ 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 _____. Next, wedges are cut or milled into the file. And the _____ is fixed at the forged _____ of the file.

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

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

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

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

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