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September 27, 1985

COMMERCIAL ITEM DESCRIPTION

FILE, HAND (AMERICAN PATTERN), TAPER

The General Services Administration has authorized the use of this commercial item description in preference to Type XVIII, Classes 1, 2, 3, and 4 of Federal Specification GGG-F-325.

This commercial item description covers hand files used for sharpening standard hand saws and other saws having 60 degree angle teeth.

Salient characteristics:

Material: Carbon alloy steel.

Design: Tapered on all sides at least one-third of the length to the point. Single-cut on each surface (one set of parallel cuts on the surface). Sides at any point on the file shall be of equal width. Edges set (blunted), then single-cut. No portion shall extend outside of the area of the largest cross-section of the file. Furnished in regular, slim, extra-slim, or double-extra-slim as shown in table.

Tang: Of a conventional shape and size suitable for attachment to a wood handle. Tempered to a maximum hardness of 45 on the Rockwell C scale at a point approximately midway of its length and width.

Teeth: Uniformly cut or etched and of uniform height throughout the fully cut portion. Cutting surfaces hardened to a uniform hardness. The distance between the heel and point of the file, excluding the tang, shall be hardened to not greater than 68 nor less than 64 on the Rockwell C scale. Free from decarburization and brittleness.

Marking: Marked with the country of origin and the name of the manufacturer or with a trademark of such known character that the source of manufacture may be readily determined.

Workmanship: The teeth of the file shall be well-defined, sharp, and uniform in height and form. There shall be no evidence of rust or other defect which may impair serviceability, durability, or appearance.



FIGURE 1
 Regular

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FIGURE 2
Slim



FIGURE 3
Extra-slim



FIGURE 4
Double-extra-slim

National Stock Number	Length Inches	Dimension at largest section A Inch	Number of teeth per inch Surface		Number of teeth per inch Edges	
			Min.	Max.	Min.	Max.
Regular						
5110-00-234-6522	6	1/2	40	45	51	56
5110-00-516-3822	8	5/8	36	40	45	51
5110-00-234-6524	10	3/4	32	36	42	46
Slim						
5110-00-234-6526	4	1/4	58	63	67	72
5110-00-423-0720	5	5/16	54	59	61	66
5110-00-234-6528	6	3/8	50	55	60	66
5110-00-242-8187	7	13/32	45	50	51	56
5110-00-234-6529	8	1/2	41	45	46	55
5110-00-245-3539	10	19/32	37	42	44	50

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Extra-slim

5110-00-529-3206	4	3/16	61	68	72	79
5110-00-156-0092	6	9/32	55	60	62	70
5110-00-242-8185	7	11/32	51	56	57	65
5110-00-293-3428	8	13/32	48	52	54	60

Double-extra-slim

5110-00-540-6804	4	5/32	62	70	73	81
5110-01-023-0332	5	3/16	60	66	70	77
5110-00-009-5039	6	7/32	58	63	66	71
5110-00-239-7528	7	1/4	55	60	62	70

Length dimension: Measured from the point (free or front end) to the heel (junction of the tang with the body of the file) and have a tolerance of plus or minus 1/8 inch.

Tolerance: Width (A) - plus or minus 1/32 inch.

Regulatory requirements. In accordance with the section 23.403 of the Federal Acquisition Regulations, the Government's policy is to acquire items composed of the highest percentage of recovered materials practicable, consistent with maintaining a satisfactory level of competition without adversely affecting performance requirements or exposing suppliers' employees to undue hazards from the recovered materials.

Preservation, packaging, packing, labeling, and marking. The preservation, packaging, packing, labeling, and marking shall be as specified in the contract or order.

PREPARING ACTIVITY:

GSA-FSS