

A-A-2453
June 2, 1986

COMMERCIAL ITEM DESCRIPTION

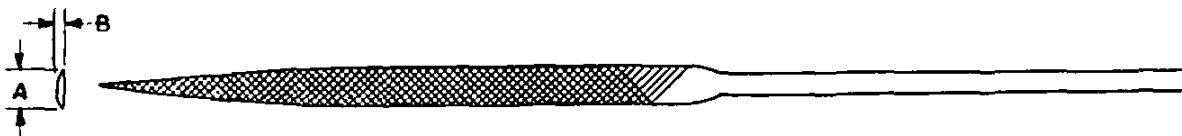
FILE, HAND (SWISS PATTERN),
NEEDLE, MARKING, HALF-ROUND

The General Services Administration has authorized the use of this commercial item description in preference to Type XVIII, Class 12 of Federal Specification GGG-F-331.

This commercial item description covers hand files used for filing, smoothing, and finishing intricate and small surfaces.

Salient characteristics:

- Material:** Carbon alloy steel.
- Design:** Tapered in width and thickness to produce a pointed end. Double-cut (two sets of parallel cuts on the surface, one set crossing the other) on the half-round side and uncut (safe) on the flat side.
- Tang:** Round in cross-sectional area. Uniform in diameter. Knurled (either diamond or straight) the full length, or intermittently knurled approximately one-half of the full length, for firm gripping. 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 63 on the Rockwell C scale. Free from decarburization and brittleness.
- Marking:** Marked with the cut number, 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.



National Stock Number	Cut Number	Overall Length Inches	Dimensions of largest section		Number of teeth per inch	Length of cut Inch
			A Inch	B Inch		
5110-00-233-9688	0	4	9/64	3/64	90	2-1/8
5110-00-293-1488	0	5-1/2	3/16	1/16	74	2-3/4
5110-00-245-4165	2	6-1/4	7/32	1/16	80	3-1/4
5110-00-245-4166	4	6-1/4	7/32	1/16	120	3-1/4

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Tolerance: Overall length - plus or minus 1/4 inch.
Length of cut - plus or minus 1/4 inch.
Width (A) - plus or minus 1/32 inch.
Thickness (B) - plus or minus 1/64 inch.
Number of teeth per inch - plus or minus 5 percent.

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