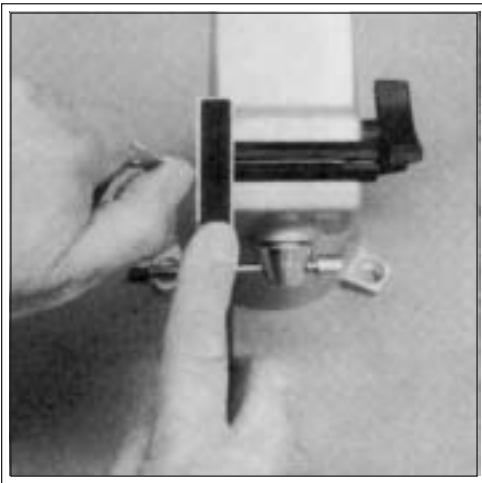# Diamond Corrugating File Instructions

1. Sharpen the blade that is to be corrugated and make sure that the old corrugation is completely removed. The usual angle is 25°.

2. Clamp the blade in a nylon jaw vise, (Wolff part #23400).

3. Hold the file at approximately the same angle as the newly sharpened edge.

4. Begin close to the pivot, holding your thumb against the side of the file to help guide it straight.

5. Push the file forward and back in a sawing motion 5 to 6 times. Lift the file to see if the teeth created are even.

Use <u>VERY LIGHT PRESSURE</u> to prevent damage to the file!
Diamonds cut freely and only a few ounces of hand pressure are needed.
Heavy pressure will destroy the file.

6. Move the file about 1/4" down the blade so that 1/2 of the file is aligned with the teeth just created and file new teeth.

7. Continue this process to the tip of the blade.
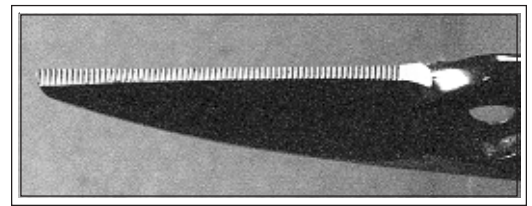
8. Hone the inside of the blade with a ceramic hone (pink Diamonite #20600, or fine white ceramic #20601) held **flat** against the blade until the burrs are removed.

NOTE: For best results use the OOKAMI GOLD® Honing Block (part #20650) with the deburr paper instead of the hone.

9. Close the scissors <u>without</u> spreading the blades apart and cut off the burr.

10. Sharpen the other blade as normal.

11. Test the scissors for hair slide and ease of cut.
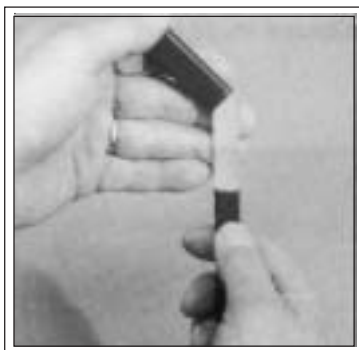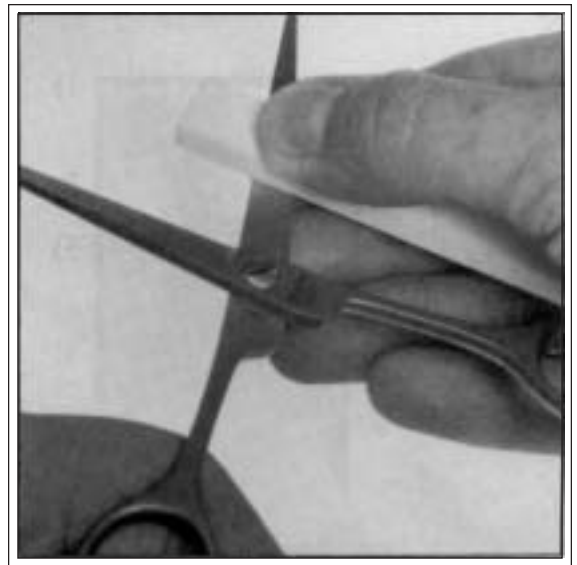
To keep your file in top condition and prevent damage always keep the cap on when it is not in use. If the file fails to cut, wash it with detergent and water.

Wolff Industries, Inc.
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