BI-METAL JIG SAW BLADES

Rev. 00

1. PRODUCT:

Bi-metal jig saw blades.

2. DESCRIPTION:

Bi-metal jig saw blades with unified or Makita shank.

Picture 1. Product illustrative image

3. APPLICABILITY:

Product suitable for cutting operations of steel, non-ferrous metals, wood and plastic.

4. STANDARDS:

NBR 5903
NBR 6215
NBR 6662
ASTM A600

5. DIMENSIONS AND TOLERANCE:

Unified shank

Application	N° Cat.	Length x Width x Thickness	TPI (*)	Type of cut	Teeth
WOOD CUTTING	BU36T	3” x 5/16” x .050”	6	Straight/Curved	Rectified and tapered body
	BU36		6	Straight/Curved	Milled and alternate set
	BU46	4” x 3/8” x .040”	6	Straight/Curved	
	BU56	5” x 3/8” x .050”	6	Straight/Curved	
	BU38	3” x 5/16” x .050”	8	Straight/Curved	

	BU310T		10	Straight/Curved	Rectified and tapered body
	BU310DT		10	Straight/Curved (**)	Rectified, tapered body and downstroke cut
	BU2DCS (****)	2” x 3/16” x .050”	9-19	Straight/Curved	Milled and tapered body
	BU3DC (****)	3” x 5/16” x .060”	9-19	Straight	
MULTI-PURPOSE	BU41014	4” x 3/8” x .040”	10-14	Straight/Curved	Milled and wavy set
	BU214	2” x 5/16” x .040”	14	Straight/Curved	
	BU214S	2” x 3/16” x .040	14	Contour/Curved	
	BU218	2” x 3/8” x .040”	18	Straight/Curved	
	BU418	4” x 3/8” x .040”	18	Straight/Curved	
METAL CUTTING	BU224	2” x 5/16” x .040”	24	Straight/Curved	
	BU224S	2 x 3/16” x .040”	24	Contour/Curved	
	BU424	4” x 3/8” x .040”	24	Straight/Curved	
	BU232	2” x 5/16” x .040”	32	Straight/Curved	

(*) Teeth per inch.
(**) Inverted cutting direction, provides a burr-free surface finish, ideal for formica cuts.
(***) Products can be used by the following machine models: Black & Decker, Bosch, Craftsman, DeWalt, Makita model 4323, 4324 and 4340, Metabo, Milwaukee, Porter Cable and Skil.
(****) Dual-Cut line, cuts any type of wood and its unique geometry prevents chips on the cutting edge in materials coated on both sides, ensuring a perfect finish on both sides.

SELECTION FOR CUTTING

Section to be cut		**TPI** (teeth per in)
13 – 63 mm	1/2” – 2.1/2”	6
8 – 50 mm	5/16” – 2”	8
6 – 38 mm	7/32” – 1.1/2”	10
4 – 25 mm	5/32” – 1”	14
3 – 22 mm	1/8” – 7/8”	18
2,50 – 16 mm	3/32” – 5/8”	24
1,60 – 11 mm	1/16” – 7/16”	32
4 – 20 mm (*)	5/32” – 13/16”	9-19
6 – 30 mm (**)	7/32” – 1.1/4”	

(*) For BU2DCS (Dual-Cut).
(**) For BU3DC (Dual-Cut).

Makita Shank

Application	N° Cat.	Length x Width x Thickness	TPI (*)	Type of cut	Teeth
WOOD CUTTING	BS36	65 x 7,5 x 1,27	6	Straight	Milled and alternate set
	BS38	65 x 7,5 x 1,27	8	Straight	
	BS310T	65 x 7,5 x 1,40	10	Straight	Rectified and tapered body
MULTI	BS314	65 x 7,5 x 1,00	14	Straight	Milled and wavy set
METAL CUTTING	BS324	65 x 7,5 x 1,00	24	Straight	
	BS324S	65 x 4,5 x 1,00	24	Contour	

Suitable for Makita machines, models 4320, 4321, 4300BA and 4300BV.

6. PACKAGE:

Product available in blister pack with 2 or 5 blades or in plastic tube with 20 and 100 blades (check availability by product).

7. TECHNICAL CONSTRUCTION:

Starrett Bi-metal Jig Saws are manufactured with alloy steel body and high-speed steel teeth, are punched, milled, setting and hardened/tempered and painted with Starrett standard yellow color and red printing, meeting strict Starrett Quality standards (ISO 9000).
Bi-metal jig saws are flexible and shatter resistant during use.

8. RAW MATERIAL:

Body hardness: From 40 to 50 HRC (whole line)

Teeth hardness: From 63 to 65 HRC (whole line)

9. SAFETY:

- Follow all safety recommendations shown in the operation catalog and labels of the machine;
- Recognize and read safety and caution signs such as Danger, Caution and Warning;
- Beware of danger points and keep your hands and clothes away from the moving machine;
- Necessary safety equipment: gloves, safety glasses, safety shoes and hearing protection;
- Follow the manual jig saw blade installation instructions;
- Select the blade according to the material to be cut;
- Decrease blade tension and then remove blade;
- Observe the cutting direction when installing the blade;
- Apply the appropriate tension to the blade.