

Effective 1st November 2018

# JIGSAW BLADE CATALOGUE



***sutton*tools**  
world class cutting tools

# Saw Blades Jigsaw – Selection Chart



T – Shank	Page Number	U – Shank	Page Number	Wooden Materials					Metals					Masonry			Specialty Materials					Cut Type				
				Soft Wood	Hard Wood	Chipboard	Plywood	MDF	Steel	Stainless Steel	Aluminium	Copper & Brass	Sheet Metal	Compressed Fibre Cement	Cement Sheet	Hebel	PVC Plastics	Acrylic	Fibreglass	Carbon Fibre	Laminate	Clean Cut	Rough Cut	Curved Cut	Plunge Cut	Fast Cut
		H459	9	●		●	●	○								○		○	○	○	●		●			
H431	5			●	●	●	●	○								●		○	○	○	●			●		
H432	5			●	●	●	●	○								●		○	○	○	●					
H435	6	H462	9	●	●	●	●	○								●		○	○	○	●			●		
H437	6	H463	9	●	●	●	●	○												○		●			●	
H447	7								●	○		●	●								●				●	
H448	7								●	○		●	●								●				●	
H451	7	H467	10						●	○	●	○									●					
H453	8								○		●	○		○	○											
H455	8			●		●	●	○								●			○			●			●	
		H466	10						●	●		●	●								●					
		H468	10								●	○				●	●									

● Optimal ○ Effective

## Brand Equivalent

### Power Tool Suitability

AEG, Black & Decker\*, Bosch, De Walt, Festool, Hitachi, Makita\*, Metabo, Milwaukee, Ryobi\*.

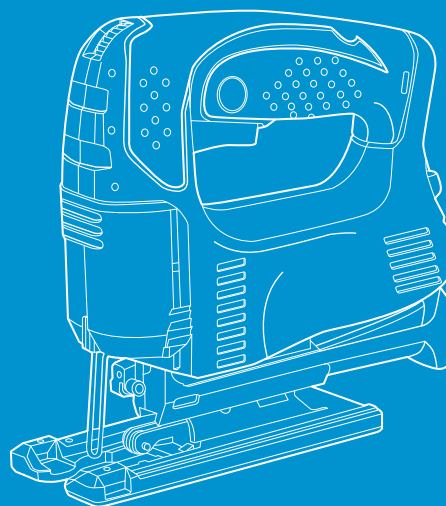
\*New models only

BRAND EQUIVALENT LIST							
SUTTON TOOLS	AEG	BOSCH	FESTOOL	LENOX	MAKITA	METABO	MILWAUKEE
H431 1002	254061	T101B	S75/2,5	450S	B11/A85634	23634	48425240
H432 1002	346079	T101BR	-	450SR	B19/A85715	23650	48425540
H435 1002	274351	T101D	-	456S	B12/A85640	23635	48425500
H437 1002	213116	T144D	S75/4	406S	B16/A856842	3633	48425421
H437 1302	311633	T344D	S105/4	-	L2/P06454	23678	-
H447 0752	274652	T118G	-	-	B24/A85759	23636	-
H448 0752	254063	T118A	-	-	B22/A85737	23637	-
H451 0752	254064	T118B	-	-	B23/A85743	23638	48425101
H455 1002	254071	T111C	-	410S	B13/A85656	23632	48425220

## Helpful Hints

Jigsaws are one of the most widely used power tools along with the power drill and cordless screwdriver, this is due in part to their versatility.

A jigsaw is a tool used for cutting arbitrary curves, such as stenciled designs or other custom shapes. It can be used in a more artistic fashion than other saws, which typically cut in straight lines only. In this way, it is similar to the rasp and the chisel.



### How to use:

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i. **Select a jigsaw suitable for your project.**

Hint: Make sure you are comfortable with your machine before you start cutting. Read the user's manual carefully and know all control features of your tool.

ii. **Select the correct blade for the material you are going to cut and attach it to the saw.**

iii. **Measure and mark the cut line you need for your project.**

For shapes like sink cut-outs in countertops you can use a template which is usually supplied with the sink or use the actual sink to scribe a cut line is your best option. For other shapes or special projects, creating a template for your cut out of paper or cardboard may make the process easier and more accurate. Draw the cutting design on your work piece. The mark has to be thick enough to be visible when sawdust accumulates.

iv. **Clamp your workpiece firmly.**

Hold smaller pieces such as pipe or conduit in a vice or attach it to the workbench with clamps.

v. **Position the blade close to the edge of the material where you will begin your cut.**

Start the cut on an edge of the work piece and not on a corner as you run the risk of chipping the corner.

Hint: Drill pilot hole for interior cuts. Make a 1/2" hole to allow the saw to commence cutting. Some saws have plunge cutting capability. In this instance, pilot hole is not required.

vi. **Commence cutting the material.**

Begin your cut by slowly squeezing the trigger of the saw, and when it is running at the desired speed, push it forward into the material you are cutting. Use a steady cutting speed and make slow movements to cut along the mark. To eliminate vibration, always cut close to the clamping point.

Hint: The adjustable shoe of a reciprocating saw is on a pivot, which allows it to turn when you work on bevelled or slanted wood so that the cut will go completely through without splintering the wood.

vii. **Stop occasionally and clear the sawdust.**

For example, with a brush or attach a dust extraction system if suitable to the tool.

### Cutting Tips:

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- Let the blade do the work. Never apply excessive forward pressure to the tool.
- Let the blade cool down naturally. Never use water or other liquids to cool the blade rapidly since it might break.
- Operate the saw with two hands. Let the blade run freely for a few seconds before commencing to cut.
- When cutting thin sheets of metal, place a piece of plywood on either side to control vibration and prevent tearing.
- Always wear safety equipment.

### Operating Conditions:

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It is important to work with the right speed and feeds to preserve the life of your jigsaw blades and increase efficiency. Although the best speed for specific application is largely determined by experience, as a general rule, slower speeds should be used when cutting hard materials like metals. Faster speeds should be used when cutting soft materials like wood.

Always make sure that the blade is sharp to ensure less load on the tool and better cutting results.

In order to increase the life of a saw blade, a cooling liquid is recommended during cutting:

- Sutton Tools Venom Cutting Fluid (steel, metal)
- petroleum (aluminium)
- water (plastics, glass-fiber)

### Safety Considerations:

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- Use hearing and eye protection before commencing cutting.
- Jigsaws use big motors that take awhile to spin down after you let go of the trigger. Carefully hold onto the tool when you're finished with the cut till it stops completely.
- When restarting in the middle of a cut, back the saw off just a hair so the teeth aren't touching the material before you pull the trigger. The blade will bite in more predictably this way.
- Be careful to avoid kickback, which arises when the material you're cutting through tries to make the blade hold still, which then causes the body of the saw to reciprocate instead of the blade. If you experience more than mild kickback, immediately let go of the trigger and continue to hold the jigsaw firmly until the saw motor winds down

## suttontools

### Making blade selection easy

To aid easy blade selection, we have colour coded their blades and packs into the following four material groups:



#### Wood Application

- Soft Wood
- Hard Wood
- Wood & Nails
- Chipboard
- Plywood
- MDF
- Green Wood
- Sandwich Construction
- Window Frame

#### Metal Application

- Steel
- Hard Steel
- Stainless Steel
- Aluminium
- Copper & Brass
- Cast Iron
- Sheet Metal
- Metal Pipes

#### Masonry Application

- Masonry
- Plaster Board
- Compressed Fibre Cement
- Cement Sheet
- Ceramic Tile
- Hebel

#### Specialty Application

- PVC Plastics
- Acrylic
- Leather
- Rubber
- Fibreglass
- Carbon Fibre
- Glass
- Laminate



## suttontools

### U-Shank



Description		Pieces	Item #	Barcode	List Price							
<b>Multi-Purpose Jigsaw Blades Set</b>		5	H496 0005	9311963611051								
Contents	O/A Length	Cut Length	Tooth Pitch	Blade Thickness	Cut Thickness	Cut Type						Item #
						Clean	Fast	Straight	Rough	Plunge	Curved	
H460 Wood	100	75	10 TPI	1.27	3.0 – 30mm	•						H460 1002
H463 Wood	100	75	6 TPI	1.27	5.0 – 50mm		•		•			H463 1002
H464 Plastic	100	75	8.5 TPI	1.27	4.0 – 50mm		•		•			H464 1002
H465 Sheet Metal	75	55	21 TPI	1.00	1.2 – 2.0mm	•						H465 0752
H467 Metal	75	55	13 TPI	1.00	2.5 – 6.0mm	•						H467 0752

**Ideal for:**



### T-Shank

### Jigsaw Blades



#### H431 Wood Jigsaw Blade, Clean Cut

Clean cutting jigsaw blade for wood. Suitable for cutting soft wood, hard wood, plywood, chipboard, MDF and PVC plastic (3.0-30mm).

- Conically ground blade, teeth diagonally sharpened for very clean and precise cuts
- Made from alloyed tool steel. A flexible blade for cutting soft materials

Clean Cut	CUT TYPE				Material Compatibility			
	Thickness	Clean	Fast	Straight	Soft Wood	Hard Wood	Plywood	PVC Plastic
	3.0 – 30mm	•						
		Rough	Plunge	Curved				
			•					

O/A Length	Cut Length	Tooth Pitch	Blade Thickness	Blade Height	Blade Material	Qty	Item #	Barcode	List Price
100	75	10 TPI	1.45	7.8	HCS	2 Pack	H431 1002	9311963610740	



#### H432 Wood Jigsaw Blade, Splinter Free

Special jigsaw blades with reverse teeth and conically ground for SPLINTER-FREE surface cuts in wood. Suitable for cutting soft wood, hard wood, plywood, chipboard, MDF, laminate and plastics.

- Reverse teeth for very clean and splinter-free surface cut
- Conically ground blade, teeth diagonally sharpened for very clean and precise cuts
- Made from alloyed tool steel. A flexible blade for cutting soft materials





Reverse Teeth Splinter Free	CUT TYPE				Material Compatibility				
	Thickness	Clean	Fast	Straight	Soft Wood	Hard Wood	Laminate	PVC Plastic	Plywood
	3.0 – 30mm	•							
		Rough	Plunge	Curved					
			•						

O/A Length	Cut Length	Tooth Pitch	Blade Thickness	Blade Height	Blade Material	Qty	Item #	Barcode	List Price
100	75	10 TPI	1.45	7.8	HCS	2 Pack	H432 1002	9311963610863	

**suttontools****H435 Wood Jigsaw Blade, Clean Cut**

Clean cutting jigsaw blade for wood. Suitable for cutting soft wood, hard wood, plywood, chipboard, MDF and PVC plastic (10-45mm).





- Conically ground blade, teeth diagonally sharpened for very clean and precise cuts
- Made from alloyed tool steel. A flexible blade for cutting soft materials

Clean Cut			CUT TYPE				   			
			Thickness	Clean	Fast	Straight				
10 - 45mm			●							
			Rough	Plunge	Curved					
O/A Length	Cut Length	Tooth Pitch	Blade Thickness	Blade Height	Blade Material	Qty	Item #	Barcode	List Price	
100	75	6 TPI	1.45	7.8	HCS	2 Pack	H435 1002	9311963610764		

**H437 Wood Jigsaw Blade, General Purpose**

General purpose jigsaw blade for fast cuts in wood. Suitable for cutting timber, soft wood and hard wood.

- Teeth side set and diagonally sharpened for fast, rough cuts
- Made from alloyed tool steel. A flexible blade for cutting soft materials

Fast Cut			CUT TYPE				   			
			Thickness	Clean	Fast	Straight				
H437 1002 5 - 50mm			●							
H437 1302 5 - 80mm			Rough	Plunge	Curved					
O/A Length	Cut Length	Tooth Pitch	Blade Thickness	Blade Height	Blade Material	Qty	Item #	Barcode	List Price	
100	75	6 TPI	1.27	7.8	HCS	2 Pack	H437 1002	9311963610818		
130	105	6 TPI	1.27	7.8	HCS	2 Pack	H437 1302	9311963610795		

**suttontools****H447 Sheet Metal Jigsaw Blade, General Purpose**

Finely toothed jigsaw blade for clean cuts in thin sheet metal. Suitable for cutting steel, stainless steel and copper (0.5-1.5mm).

- Teeth milled and wavy set for fine, clean cuts
- Made from hardened High Speed Steel for cutting metals

O/A Length	Cut Length	Tooth Pitch	Blade Thickness	Blade Height	Blade Material	Qty	CUT TYPE			
							Thickness	Clean	Fast	Straight
							0.5 – 1.5mm	Rough	Plunge	Curved
75	55	36 TPI	1.0	7.8	HSS	2 Pack	Item #	Barcode	List Price	
							H447 0752	9311963610665		

**H448 Sheet Metal Jigsaw Blade, General Purpose**

General purpose jigsaw blade for clean cuts in sheet metal. Suitable for cutting steel, copper and brass (1.2-2.0mm).

- Teeth milled and wavy set for fine, clean cuts
- Made from hardened High Speed Steel for cutting metals

O/A Length	Cut Length	Tooth Pitch	Blade Thickness	Blade Height	Blade Material	Qty	CUT TYPE			
							Thickness	Clean	Fast	Straight
							1.2 – 2.0mm	Rough	Plunge	Curved
75	55	21 TPI	1.0	7.8	HSS	2 Pack	Item #	Barcode	List Price	
							H448 0752	9311963610672		

**H451 Metal Jigsaw Blade, General Purpose**

General purpose jigsaw blade for cutting metal. Suitable for cutting steel, non-ferrous metal and aluminium (2.5-6.0mm).

- Teeth milled and wavy set for fine, clean cuts
- Made from hardened High Speed Steel for cutting hard materials like metal, aluminium and non-ferrous metal

O/A Length	Cut Length	Tooth Pitch	Blade Thickness	Blade Height	Blade Material	Qty	CUT TYPE			
							Thickness	Clean	Fast	Straight
							2.5 – 6.0mm	Rough	Plunge	Curved
75	55	13 TPI	1.0	7.8	HSS	2 Pack	Item #	Barcode	List Price	
							H451 0752	9311963610689		



**suttontools**

H4551002

HCS

suttontools

PLASTIC

4-50MM


8.5TPI

MADE IN GERMANY

**H455 Specialty Jigsaw Blade, Plastics**

Special jigsaw blade for fast cuts in plastics. Suitable for PVC plastic, soft wood, plywood, MDF and chipboard (4.0-50mm).

- Teeth side set and diagonally sharpened for fast, rough cuts
- Made from alloyed tool steel. A flexible blade for cutting soft materials

Fast Cut		CUT TYPE							
		Thickness	Clean	Fast	Straight				
O/A Length	Cut Length	Tooth Pitch	Blade Thickness	Blade Height	Blade Material	Qty	Item #	Barcode	List Price
100	75	8.5 TPI	1.27	9.8	HCS	2 Pack	H455 1002	9311963610757	



**suttontools**

H4590752

HCS

suttontools

WOOD

1.5-15MM

19TPI

MADE IN GERMANY

**H459 Wood Jigsaw Blade, Curved Clean Cut**

Special jigsaw blades with 4.5mm tall body and thin kerf for controlled, curved clean cuts in wood. Suitable for cutting soft wood, plywood, chipboard, MDF and laminate (1.5-15mm).

- 4.5mm tall body and thin kerf increases agility for controlled, curved cuts
- Conically ground blade, teeth diagonally sharpened and tapered for very clean and precise cuts
- Made from alloyed tool steel. A flexible blade for cutting soft materials

Curved Cut		Clean Cut		CUT TYPE			Soft Wood Plywood Chipboard Laminate		
		Thickness	Clean	Fast	Straight				
		1.5 - 15mm	●						
			Rough	Plunge	Curved				
O/A Length	Cut Length	Tooth Pitch	Blade Thickness	Blade Height	Blade Material	Qty	Item #	Barcode	List Price
75	50	19 TPI	1.25	4.5	HCS	2 Pack	H459 0752	9311963611167	

H4621002

HCS

suttontools

WOOD

10-45MM

6TPI

MADE IN GERMANY

**H462 Wood Jigsaw Blade, Clean Cut**

Clean cutting jigsaw blade for wood. Suitable for cutting soft wood, hard wood, plywood, chipboard, MDF and PVC plastic (10-45mm).

- Conically ground blade, teeth diagonally sharpened for very clean and precise cuts
- Made from alloyed tool steel. A flexible blade for cutting soft materials

Clean Cut		Fast Cut		CUT TYPE			Soft Wood Hard Wood Plywood PVC Plastic		
		Thickness	Clean	Fast	Straight				
		10 - 45mm	●						
			Rough	Plunge	Curved				
O/A Length	Cut Length	Tooth Pitch	Blade Thickness	Blade Height	Blade Material	Qty	Item #	Barcode	List Price
100	75	6 TPI	1.45	7.8	HCS	2 Pack	H462 1002	9311963611006	

H4631002

HCS

suttontools

WOOD

5-50MM

6TPI

MADE IN GERMANY

**H463 Wood Jigsaw Blade, General Purpose**

General purpose jigsaw blade for fast cuts in wood. Suitable for cutting timber, soft wood and hard wood (5.0-50mm).





- Teeth side set and diagonally sharpened for fast, rough cuts
- Made from alloyed tool steel. A flexible blade for cutting soft materials

Fast Cut		CUT TYPE			Soft Wood Hard Wood Plywood Chipboard				
		Thickness	Clean	Fast	Straight				
		5 - 50mm	●						
			Rough	Plunge	Curved				
O/A Length	Cut Length	Tooth Pitch	Blade Thickness	Blade Height	Blade Material	Qty	Item #	Barcode	List Price
100	75	6 TPI	1.27	7.8	HCS	2 Pack	H463 1002	9311963610993	

**suttontools**H4660752 **BiM** **suttontools** SHEET METAL 1.2-2MM 21TPI  
MADE IN GERMANY**H466 Sheet Metal Jigsaw Blade, Long Life**

Flexible, long life, general purpose jigsaw blade for clean cuts in sheet metal. Suitable for cutting steel, stainless steel and copper (1.2–2.0mm).




- Teeth milled and wavy set for fine, clean cuts
- Made from Cobalt Bi-Metal HSS for flexibility, heat and break-resistance, lasting up to 10X longer than high carbon steel blades

COBALT BI-METAL			CUT TYPE				   			
			Thickness	Clean	Fast	Straight				
1.2 – 2.0mm			●							
			Rough	Plunge	Curved					
O/A Length	Cut Length	Tooth Pitch	Blade Thickness	Blade Height	Blade Material	Qty	Item #	Barcode	List Price	
75	55	21 TPI	1.0	7.8	Cobalt Bi-Metal	2 Pack	H466 0752	9311963610962		

H4670752 **HSS** **suttontools** METAL 2.5-6MM 13TPI  
MADE IN GERMANY**H467 Metal Jigsaw Blade, General Purpose**

General purpose jigsaw blade for cutting metal. Suitable for cutting steel, non-ferrous metal and aluminium (2.5–6.0mm).





- Teeth milled and wavy set for fine, clean cuts
- Made from hardened High Speed Steel for cutting hard materials like metal, aluminium and non-ferrous metal

COBALT BI-METAL			CUT TYPE				  			
			Thickness	Clean	Fast	Straight				
2.5 – 6.0mm			●							
			Rough	Plunge	Curved					
O/A Length	Cut Length	Tooth Pitch	Blade Thickness	Blade Height	Blade Material	Qty	Item #	Barcode	List Price	
75	55	13 TPI	1.0	7.8	HSS	2 Pack	H467 0752	9311963610948		

H4681002 **BiM** **suttontools** ALUMINIUM <30MM 8.5TPI  
MADE IN GERMANY**H468 Metal Jigsaw Blade, Aluminium**

Special flexible jigsaw blade for cutting non-ferrous metals. Suitable for cutting non-ferrous metal, aluminium, steel and plastics (&lt;30mm).

- Teeth milled and side set for aluminium cutting
- Made from Cobalt Bi-Metal HSS for flexibility, heat and break-resistance, lasting up to 10X longer than high carbon steel blades

COBALT BI-METAL			CUT TYPE				   			
			Thickness	Clean	Fast	Straight				
<30mm			●							
			Rough	Plunge	Curved					
O/A Length	Cut Length	Tooth Pitch	Blade Thickness	Blade Height	Blade Material	Qty	Item #	Barcode	List Price	
100	75	8.5 TPI	1.0	7.8	Cobalt Bi-Metal	2 Pack	H468 1002	9311963610955		

# Saw Blades Technical Information

The performance of a saw blade depends on **1 Tool Material** **2 TPI** **3 Tooth Geometry** **4 Blade Length**. These factors guarantee in conjunction with the correct use of the machine and blade selection the optimum result in cutting all materials.

## 1 Tool Material



### High Carbon Steel:

- Most economical blade material
- Resistant to abrasion and deformation
- Ability to hold a cutting edge at elevated temperatures
- High flexibility

### Recommended material to cut:



Hard Wood    Soft Wood    PVC Plastic    Plasterboard



### Cobalt Bi-Metal:

Flexible electron beam welded joint of high temperature alloyed sprung steel and cobalt high speed steel on the cutting edge to meet the highest demands given to a blade during use.

- optimum cutting efficiency
- prolonged service life
- flexible making it virtually unbreakable

### Recommended material to cut:



Pallet    Wood & Nails    Carbon Fibre    Steel    Aluminium    Copper & Brass    Sheet Metal    Metal Pipe

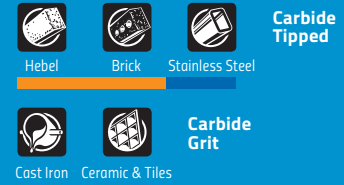


### Carbide Tipped / Carbide Grit:

Alloyed tool steel with tungsten carbide teeth or tungsten carbide gritted cutting edge:

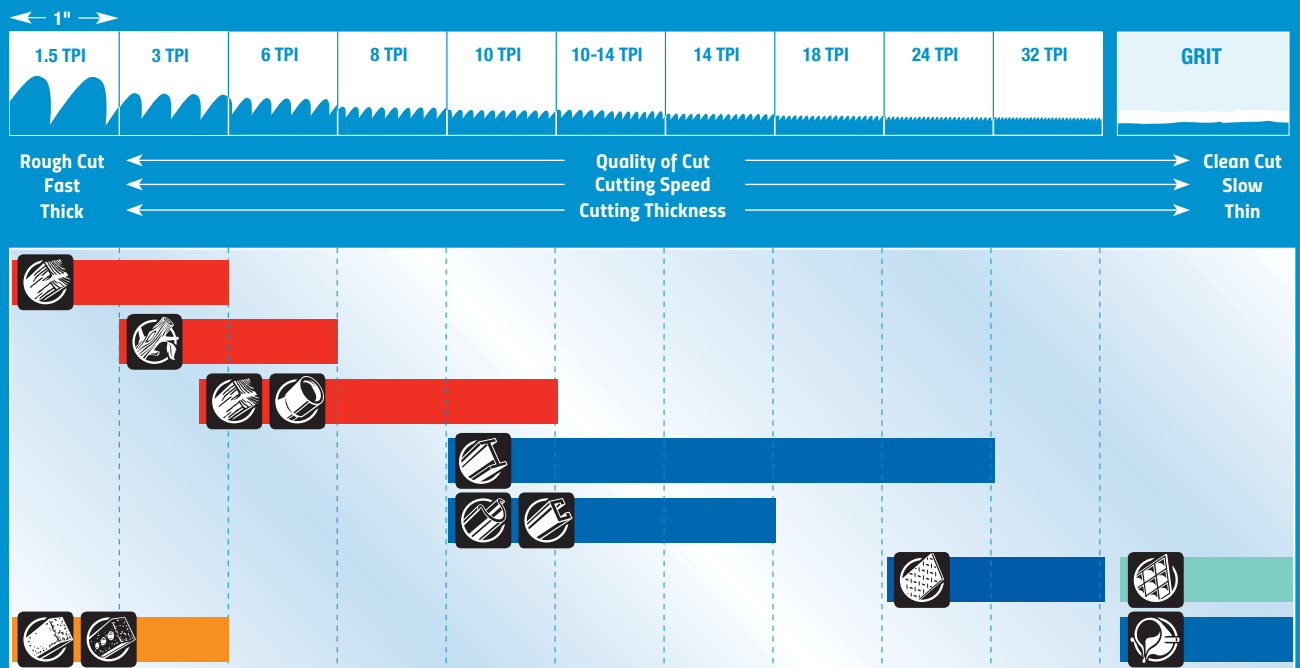
- Very abrasion resistant = longest life.
- Can withstand higher temperatures than standard high speed steel tools
- Maintain a sharper cutting edge, produce a better finish and allows faster cutting

### Recommended material to cut:



Hebel    Brick    Stainless Steel    Cast Iron    Ceramic & Tiles

## 2 TPI (Teeth Per Inch) Selection Guide



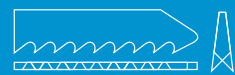
## 3 Tooth Geometry Selection Guide



**Side set** toothing for rough cuts



**Side set, diagonally sharpened** toothing for rough quick cuts



**Conically ground blade**, teeth diagonally sharpened toothing for precise clean cuts



**Wavy set** toothing for fine and clean cuts

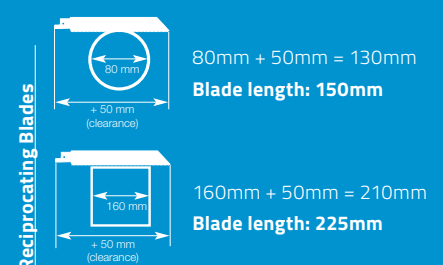
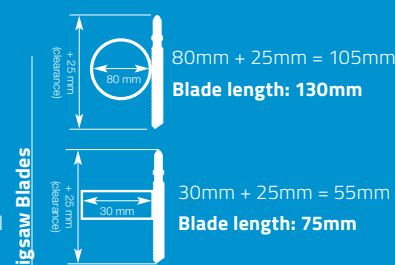


**Reverse Teeth** very clean and splinter free surface cuts

**Tooth Shape:** ▽ D = Roof Tooth    ▲ P = Positive Tooth    ▽ N = Normal Tooth

## 4 Blade Length Selection Guide

- As a general rule, the jigsaw blade should be 25mm longer than the workpiece thickness and the reciprocating blade should be 50mm longer than the workpiece thickness.
- 2-3 teeth need to work constantly in the material, the used tooth pitch also follows this rule of thumb.
- It is recommended to use saw blades with a small tooth pitch for thin material and a rough tooth pitch for thick material.



Material Codes: Wood Metal Specialty Masonry

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