

**STARTRITE**

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**User Manual  
SC Range  
Single and  
Dual Speed  
Metal Cutting  
Circular Saws**

BO10710

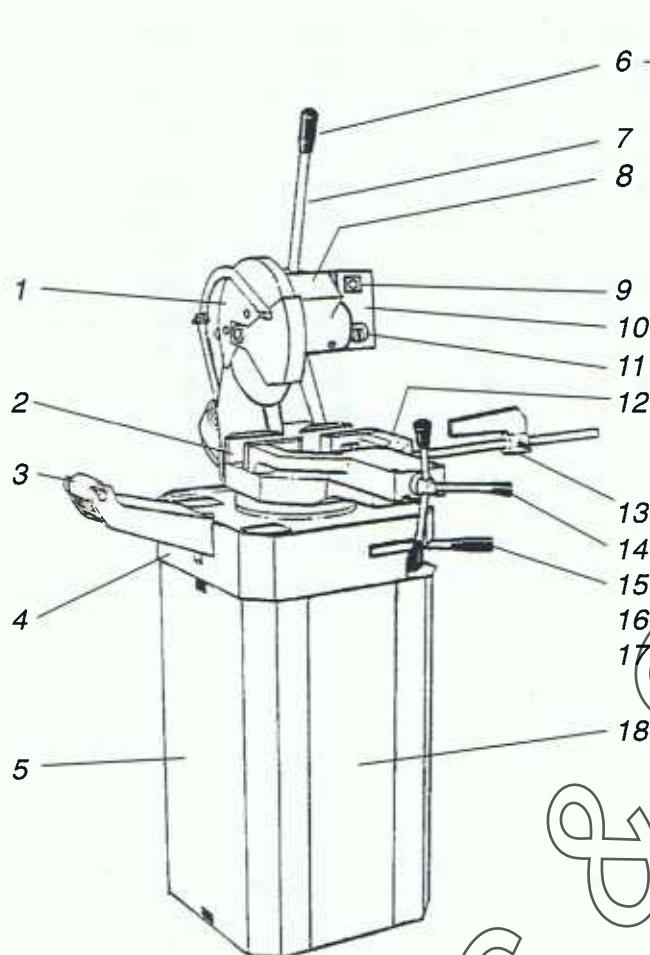
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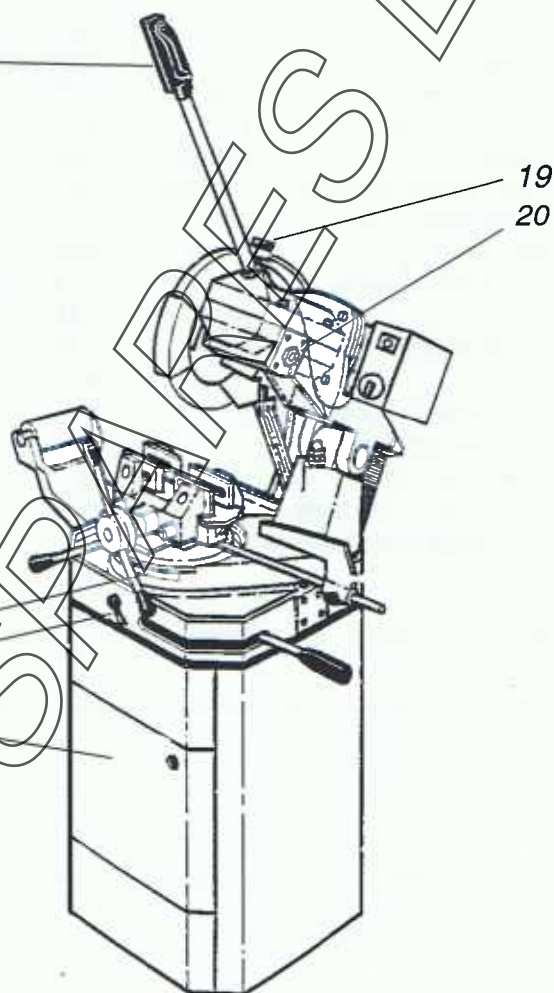
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## GENERAL ARRANGEMENT



**Fig 1a**  
SC250, SC275, SC275D  
and SC315D (SC315D shown  
with optional stand)



**Fig 1b**  
SC350D and SC350DP  
(SC350D shown)

### Key

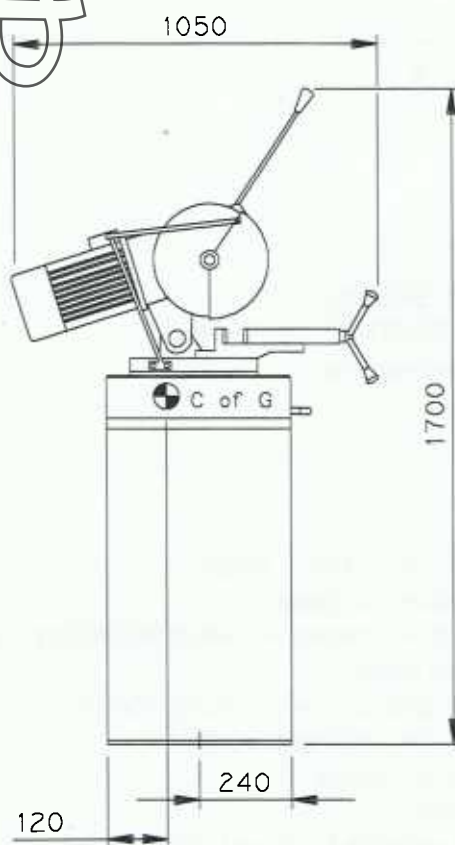
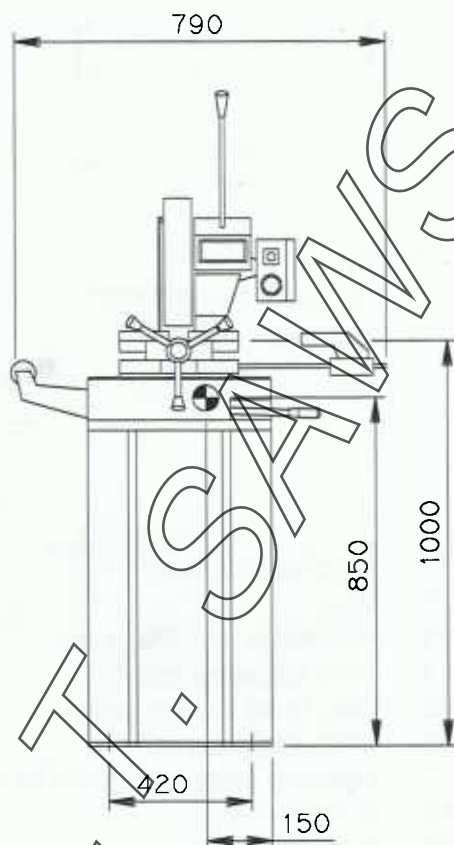
- |    |   |    |                                 |
|----|---|----|---------------------------------|
| 1  | Self actuating blade guard                | 11 | Electrical Isolator             |
| 2  | Adjustable vice jaws                      | 12 | Vice                            |
| 3  | Infeed roller (optional except SC350D/DP) | 13 | Adjustable material stop        |
| 4  | Machine base                              | 14 | Vice actuating lever            |
| 5  | Stand (optional except SC350D/DP)         | 15 | Saw head locking lever          |
| 6  | Hold to run start/stop control            | 16 | Mitre angle scale               |
| 7  | Operating handle                          | 17 | Indexing lever (SC350D/DP only) |
| 8  | Saw head                                  | 18 | Access cover                    |
| 9  | Speed selector (2 speed variants only)    | 19 | Coolant control valve           |
| 10 | Control housing                           | 20 | Gear box oil level indicator    |

## SPECIFICATION AND STANDARD/OPTIONAL EQUIPMENT

Model		SC250	SC275	SC275D	SC315D	SC350D/DP
Electrical Supply	(V)					
3 phase 50 Hz		380/415	380/415	380/415	380/415	380/415
1 phase 50 Hz		220/240	n/a	n/a	n/a	n/a
Motor Power	(kW)	0.75	1.1	1.1/1.5	1.5/1.9	1.7/2.2
Control voltage	(V)	24	24	24	24	24
Stopping time	(secs)	<10	<10	<10	<10	<10
Blade speed (normal)	(m/min)	40	44	44/88	50/100	47/94
Blade speed (low)	(m/min)	n/a	n/a	22/44	25/50	24/48
Max blade dia	(mm)	250	275	275	315	350
Vice rotation angle	(°)	+/-45	+/-45	+/-45	+/-45	+/-45
Weight	(kg)	135	140	150	150	300
Noise level*	(dbA)	< 95	<95	<95	<95	<99
Tools		●	●	●	●	●
Adjustable material stop		●	●	●	●	●
Material support roller		○	○	○	○	●
Heavy duty stand		○	○	○	○	●
Infeed roller conveyer		○	○	○	○	○
Discharge roller conveyer		○	○	○	○	○

● Standard ○ Optional

\* Actual sound levels may vary depending on conditions of use



# SPECIFICATION AND STANDARD/OPTIONAL EQUIPMENT (continued)

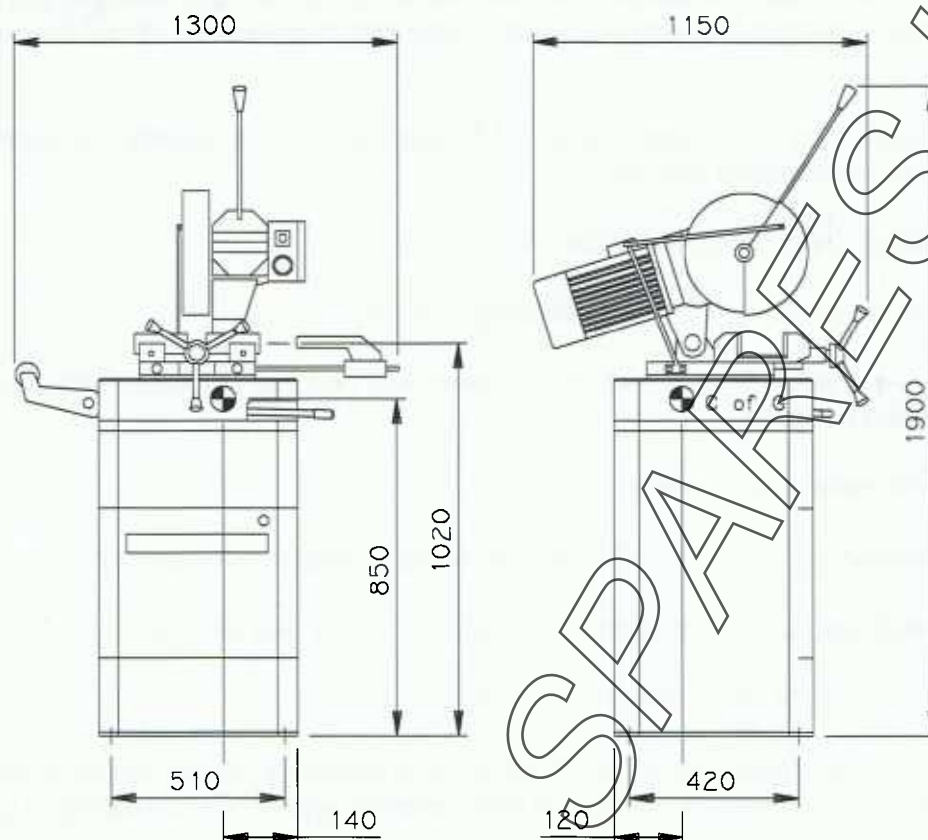


Illustration shows SC350D

## CAPACITY

	Model	SC250	SC275	SC275D	SC315D	SC350D/DP
○	90°	75	90	90	110	120
	45°	75	85	85	95	115
□	90°	70	80	80	90	110
	45°	65	70	70	80	105
▭	90°	80x70	100x70	100x70	105x85	140x100
	45°	80x55	80x65	80x65	85x75	110x100
●	90°	40	50	50	55	60
	45°	35	45	45	50	55
◊	90°	35	45	45	55	65
	45°	30	40	40	50	55

All dimensions are in mm and are approximate.

Due to the policy of continuous product improvement specification may change without notice.



## HEALTH AND SAFETY ADVICE

Ensure that you have read the contents of this operating manual, and that you have received sufficient training to enable the safe adjustment, use and maintenance of this machine before using it.

Inexperienced users and those under the age of 18 years should not operate this machine unless supervised by an experienced operator.

For safe operation of this machine ensure that:

- All guards are securely fitted and operating correctly
- The blade is suitable for the work to be undertaken and that it is sharp and moving in the correct direction.
- The correct blade speed is selected.
- Loose items of clothing or jewellery are fastened or preferably removed.
- The material stop and depth stop are adjusted correctly and secured.
- The working area is clean and unobstructed.
- That the coolant system is working effectively and that all necessary safety precautions are taken when mixing coolant, filling and using coolant system and disposing of coolant.
- Suitable protective clothing such as goggles and ear defenders are available and worn if necessary.
- The machine is kept clean and maintained in accordance with the maintenance instructions.

When adjusting, cleaning or maintaining this machine ensure that all moving parts are stationary and that the electrical supply is disconnected.

Report immediately to your supervisor any machine malfunction or operator hazard. Do not attempt to repair the machine unless competent to do so.

The electrical supply must be connected in accordance with the installation instructions. It is recommended that regular electrical safety tests are undertaken by a competent person.

Whilst measures have been taken to minimise the noise emitted by this machine the actual level of noise emissions is dependent on operating conditions and may be higher than specified.

If in doubt about the safe use of this machine contact STARTRITE CUSTOMER SUPPORT for advice and the availability of training.

## HANDLING, TRANSPORTATION AND FIXING

Damage caused by incorrect handling, transportation or installation may invalidate the guarantee. Consequently if in doubt about the safe handling or installation of the machine obtain the services of a competent technician or contact STARTRITE CUSTOMER SUPPORT.

When transporting this machine do not strap across the top of the machine. Always locate retaining straps over the cast iron base avoiding handles and other controls.

To minimise the risk of damage it is recommended that the machine be transported with the stand (if supplied) detached.

When moving and positioning this machine do not hold the vice adjusting handle, locking lever, motor or guard, always hold the machine base or vice. If moving long distances position the machine on a trolley before moving.

The machine should not be located in a confined space. Ensure that the working area is adequately lit. A cabinet located nearby is useful for the safe and secure storage of tools, blades and accessories.

If the machine is supplied separate from the stand it is essential that it is securely fixed to the stand. To fix position the machine on the stand with the access cover to the front and secure by placing and securing the M10 bolts supplied in the mounting holes located on both sides of the machine base. The pneumatic control tubes (SC350DP only) are coupled to the vice housing on the front of the machine and to the air control valve at the rear of the machine. If the vice opens when the control valve is actuated by lowering the saw head then reverse the pneumatic control tubes on the vice housing.

The machine should be located on a firm level surface and fixed using four bolts (not supplied) if mounted on a stand, or two bolts (not supplied) if bench mounted. Mounting holes are provided in the base of the stand (remove access cover to fit) and both sides of the machine base when bench mounting. If the machine is bench mounted ensure that the bench is flat to prevent damage to the coolant pump.

Ensure that the anti corrosive coating is removed from the vice and other working parts before use.

## CONNECTION TO THE AIR SUPPLY (SC350DP ONLY)

The SC350DP must be connected to suitable air supply to enable operation of the pneumatic vice. The air supply should be coupled to the inlet of the pressure regulator located on the rear of the machine. The line pressure should be 2.7 bar (40 lb/in<sup>2</sup>) minimum to 5.4 bar (80 lb/in<sup>2</sup>) maximum.

## CONNECTION OF THE ELECTRICAL SUPPLY

Before connecting the electrical supply ensure that it is the correct voltage, phase and frequency, and that it has sufficient capacity for the machine. The relevant information can be found on the rating plate located on the rear of the machine.

### THREE PHASE SUPPLY

Remove the screw retaining the electrical control housing cover. Pass the supply lead through the cable gland located on the lower end of the housing. Connect the supply leads to terminals L1, L2 and L3 on the isolator. Connect the protective earth lead (yellow/green) to the earth

## CONNECTION OF THE ELECTRICAL SUPPLY (continued)

terminal (E). Connect the neutral wire to terminal N if required (see fig 2).

Before proceeding check the direction of motion of the machine. This should be done without the blade fitted to prevent damage in the event of the direction of motion being incorrect.

The lower bandwheel should rotate in the direction of the arrow located on the guard. If it does not interchange two of the supply leads.

The use of 1.5mm<sup>2</sup> cable and fuses rated at 10 A is recommended.

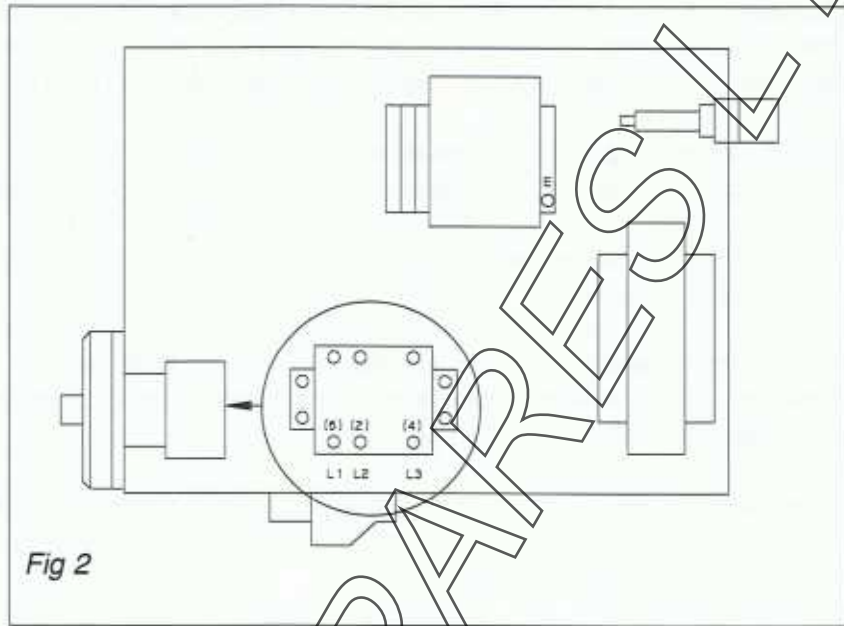


Fig 2

### SINGLE PHASE SUPPLY (SC250 and SC275 only)

Remove the screw retaining the electrical control housing cover. Pass the supply lead through the cable gland located on the lower end of the housing. Connect the live (brown) lead to terminal L3 on the isolator. Connect the neutral (blue) wire to terminal L1. Connect the protective earth lead (yellow/green) to the earth terminal (E) (see fig 2). The use of 1.5mm<sup>2</sup> cable and fuses rated at 15 A is recommended.

IT IS IMPORTANT THAT THE MACHINE IS EFFECTIVELY EARTHED.

If in doubt about the connection of the electrical supply consult a qualified electrician.

## COOLANT SYSTEM

To optimise cutting performance the machine is fitted with an electrically actuated coolant/lubricating system. The coolant flow rate is controlled by the valve located on the guard.

The coolant pump is actuated by the start/stop control positioned on the control handle.

The use of STARCOOL209 is recommended for optimum cutting performance. This should be diluted with water in the ratio of 15 parts water to 1 part STARCOOL209. If other coolants are used follow the manufacturer's recommendations.

Never use undiluted coolant, damage to the coolant pump may occur and the coolant flow will be adversely affected. Always add water to the coolant to prevent accidental spillage of coolant and mix well before using.

Observe the handling and safety precautions provided with the coolant particularly when mixing, filling the coolant system, clearing spillages or disposing of coolant. Always wear gloves and goggles when handling or mixing coolant. To avoid spillage always ensure that the machine and drainage outlet is clear from swarf.



## SETTING AND OPERATING INSTRUCTIONS

### BLADE SPEED SELECTION (TWO SPEED MACHINES ONLY)

The speed selector switch is located on the front of the control box (see fig 1). Low speed can be selected by switching the speed selector switch to 1, and the high speed selected by switching the speed selector switch to 2.

It is advised that the blade be allowed to stop before changing the blade speed.

### ADJUSTING CUTTING ANGLE

The saw head or vice can be swivelled to the left or right by 45°. To change cutting the angle release the saw head clamp by rotating the locking handle to the left. Swivel either the vice assembly or saw head until the correct angle is indicated on the mitre angle scale located beneath the vice assembly. Ensure the saw head clamp is securely tightened by rotating the locking handle to the right before using the machine.

The SC350D and SC350DP variants incorporate an indexing saw head. The indexing lever is located on the front of the base. The saw head or vice cannot be rotated until the lever is pulled outward. When released the lever locks the saw head or vice at 15° intervals.

### ADJUSTING MATERIAL STOP

Adjust the material stop releasing the locking screw and positioning the stop on the support bar to give the required material length. Ensure that the material stop is positioned to make contact with the material by rotating it around the support bar.

Ensure the material stop locking screw is tightened before using the machine.

### ADJUSTING VICE

#### *Manual Vice*

Material is clamped in the vice by rotating the vice locking handle clockwise, and released by rotating the handle anti-clockwise.

It is important to ensure that the vice jaws are correctly positioned to avoid damage when cutting and to provide support of the work piece on both sides of the cut. To adjust release the retaining screws and slide the jaws until correctly positioned.

Ensure the retaining screws are securely fastened and that the material is securely clamped before cutting. When cutting short pieces it is important that the right hand vice jaws are supported by means of packing made from off cuts of the material being cut.

It is important that long lengths of material are adequately supported.

#### *Pneumatic Vice*

The pneumatic vice should be adjusted manually and the work piece secured as described above.

Having clamped the material the vice is closed automatically by pulling the saw head downwards. This operates the air valve actuating switch located at the rear of the machine. The vice is opened by raising the saw head. Ensure that clothing and hands are clear of the vice before actuation.

## **SETTING AND OPERATING INSTRUCTIONS (continued)**

### **ADJUSTING DEPTH STOP**

The depth stop is located at the rear of the vice beneath the saw head. Before adjusting ensure that the machine is disconnected from the power supply by rotating the electrical isolator to the off position marked 'O'.

Loosen the locknut and adjust the depth stop screw until the correct depth of cut is obtained. Securely tighten the lock nut before use. When cutting off it is recommended that the depth stop be set to enable the blade to just break through the material.

### **FITTING BLADE**

Before removing or fitting the blade ensure that the machine is disconnected from the power supply by rotating the electrical isolator to the off position marked 'O'. Always wear protective gloves when handling the blade.

Remove the screw which retains the end of the guard actuating arm to the guard. Rotate the guard anti-clockwise to gain access to the blade. Slacken and remove the screw retaining the blade clamp. Remove the saw blade and clamp.

To ensure accurate blade alignment it is important that all surfaces are clean and free from damage.

To fit blade place blade over retaining shoulder on drive shaft ensuring that locating pins are correctly positioned in blade. Place the clamp over the saw blade ensuring the locating pins are correctly located in the clamp. Secure by positioning and securely tightening retaining screw. Ensure that the blade and clamp are correctly seated. Finally reposition the guard and refasten the guard actuating arm. After fitting the blade ensure that all fasteners are securely tightened and that the guard operates correctly. Ensure that the depth stop and material stops are correctly set before cutting.

### **STARTING AND SAWING**

The machine is started by holding the control handle and depressing the start/stop button. Releasing the start/stop button stops the machine. Pull the saw head downwards until the blade makes contact with the work piece. When cutting the work piece apply even and light downward pressure. When the cut is complete raise the saw head until it reaches the upper stop. Do not release the saw head until the upper position is reached.

When sawing do not hold the work piece.

### **STOPPING**

The saw blade is stopped at any time by releasing the start/stop button.

### **PREVENTING UNAUTHORISED USE**

To prevent unauthorised use or to provide security whilst undertaking maintenance, a lockable isolator is fitted to the control housing (see fig 1). The electrical supply is disconnected by rotating the control clockwise to the "O" position. Security can be provided by padlocking the control in the off position (padlock not supplied). The electrical supply is reconnected by removing the padlock (if fitted) and rotating the control anticlockwise to the "I" position. The blade will not move until the start control marked "I" is depressed.

## MAINTENANCE

The frequency of maintenance is dependent on the frequency of use and the nature of the work undertaken. It is recommended that the following maintenance schedule is undertaken at least weekly to ensure trouble free operation. Ensure that the electrical supply is disconnected from the machine and that it has come to rest before undertaking any maintenance.

- Remove swarf and chips and lubricate the vice lead screw and guide bars.
- Ensure that the level of oil in the saw head is correct by viewing sight glass located on right hand side of head. The oil should be changed after the first 10 hours of operation and every 250 hours or 6 months (which ever is the shorter) thereafter.
- Check condition of saw head counterbalance spring to ensure that it is not cracked or broken. The spring is located at the rear of the machine.
- Grease the saw head pivot shaft at least every month. Grease nipples are located at the rear of the machine.
- Use only sharp blades and blades that are suitable for the material being cut.

## CHANGING OIL

To change the oil in the saw head remove the plug located in the bottom and drain the oil into a suitable container. Refit the plug after thoroughly flushing the old oil out.

To refill ensure the saw head is raised and remove the filler plug or operating handle. Fill the gear box with one of the recommended oils (see table 1) until it reaches the line in the site glass. Replace the filler plug or operating handle.

Always wear suitable protective equipment such as gloves and goggles when changing the oil. For advice on the safe handling, disposal and action to be taken in the event of a spillage consult the information given on the oil container.

Table 1 Recommended Oils

Manufacturer	Grade
Mobil	Gear 636
Shell	Omale 680
Esso	Sportan 680
Castrol	Alfa 817
BP	Grxp 680

For genuine spare parts and service from fully trained engineers contact **A.L.T. Saws & Spares Ltd** SUPPORT. We can also supply blades for any application.

## BLADE AND SPEED SELECTION

To enable the most effective use of the saw it is important to select the correct speed and blade pitch. These are dependent on the material specification, shape and size.

### SELECTION OF TOOTH PITCH

Table 2 below provides a guide on tooth pitch selection for a variety of solid and structural section thicknesses.

Table 2 Tooth Pitch Selection

Thickness of solid section (mm) (S)				10	20	30	40	50	60
Tube wall thickness (mm) (T)				1	2	3	4	5	6
Tooth pitch	8 tpi	(3mm)		T					
	6 tpi	(4mm)			T				
	5 tpi	(5mm)		S		T			
	4 tpi	(6mm)		S	S	S	T		
	3 tpi	(8mm)				S	S		T
	2.5 tpi	(10mm)					S	S	
	2 tpi	(12mm)						S	S
	1.75 tpi	(14mm)							S

The above table should be used as guide only for most applications when cutting hard materials. As a general guide when cutting tube or structural material the tooth pitch in mm should be approximately 2 times the material thickness. For further information or advice contact **A.L.T. Saws CUSTOMER SERVICE**.

### SELECTION OF BLADE SPEED

Two speed models provide increased versatility for cutting a wider range of materials. Table 3 below provides a guide on which speed to select for a variety of materials.

Table 3 Blade Speed Selection

Switch Position	Speed	Material
1	Low	Stainless, high carbon, alloy, tool steels, and cast iron
2	High	Mild steel, brass, bronze, copper, aluminium

### ORDERING BLADES

When ordering blades always specify:

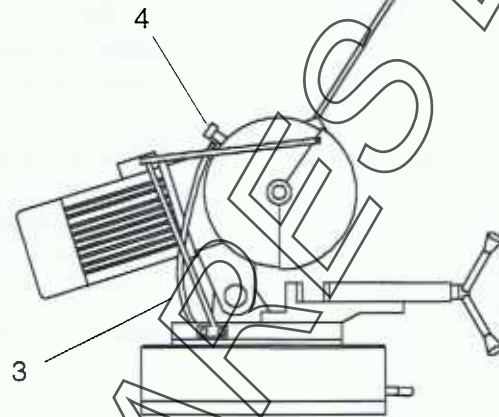
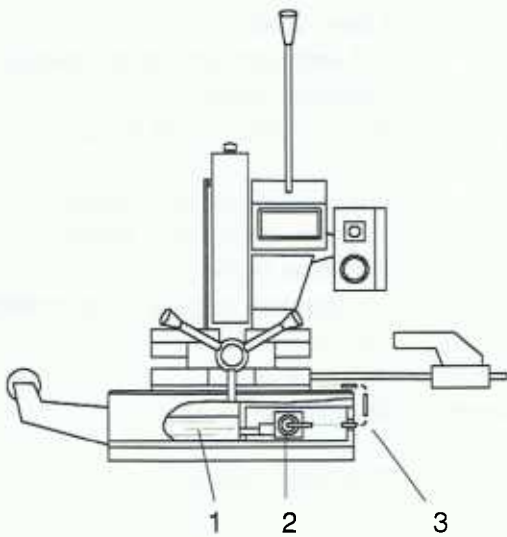
- blade diameter in mm
- centre diameter
- number of locating pins
- diameter of locating pins
- pitch of locating pins



## COMMON PROBLEMS

PROBLEM	POSSIBLE CAUSE	REMEDY
Coolant will not flow	Flow control valve closed Coolant tank empty Defective pump Defective electrical supply	Open valve Fill with correct mix of coolant Replace pump Inspect wiring and repair
Cut not square	Blade wobbles on spindle  Incorrect blade Incorrect sharpening  Vice not set correctly Material not correctly clamped	Remove blade and clean spindle, clamp and blade Replace blade Resharpen to give correct form for material Adjust vice Reposition work piece
Blade will not cut	Blade teeth reversed	Remount blade
Premature dulling or breaking of teeth	Cutting speed too fast  Feed pressure too high Incorrect blade Incorrect sharpening  Insufficient coolant Incorrect coolant Fusion of chips to blade Material loose in vice	Change speed or blade diameter Reduce feed pressure Change blade Resharpen to give correct form for material Increase coolant flow Change coolant Resharpen blade Reposition and clamp material
Saw blade vibrates	Work piece not correctly positioned or clamped Incorrect blade speed Incorrect tooth pitch Dull blade Vice incorrectly clamped or adjusted	Reposition and clamp Change speed Change blade Change or resharpen blade  Reclamp and adjust

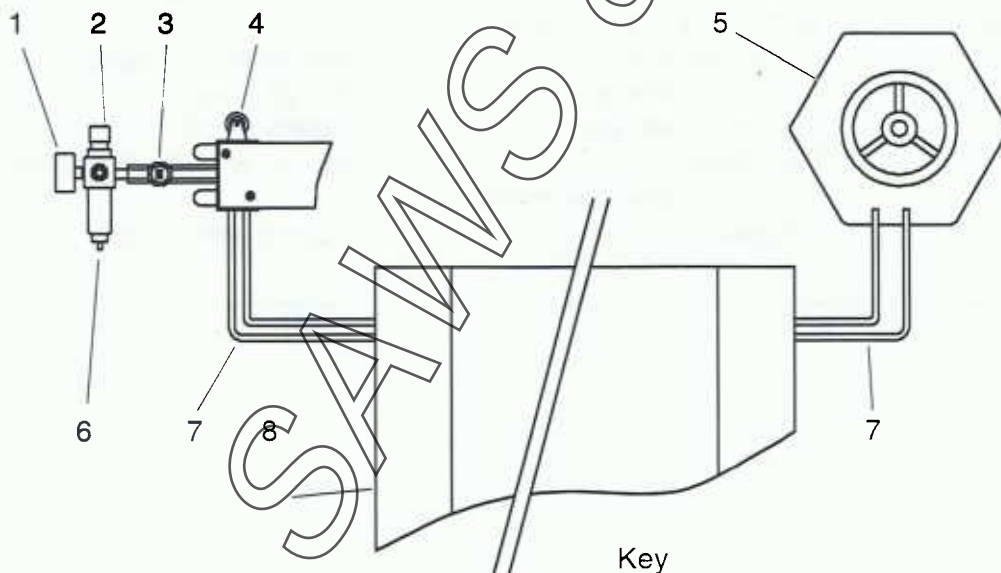
## COOLANT SYSTEM



### Key

- 1 Reservoir
- 2 Pump
- 3 Hose
- 4 Flow regulator

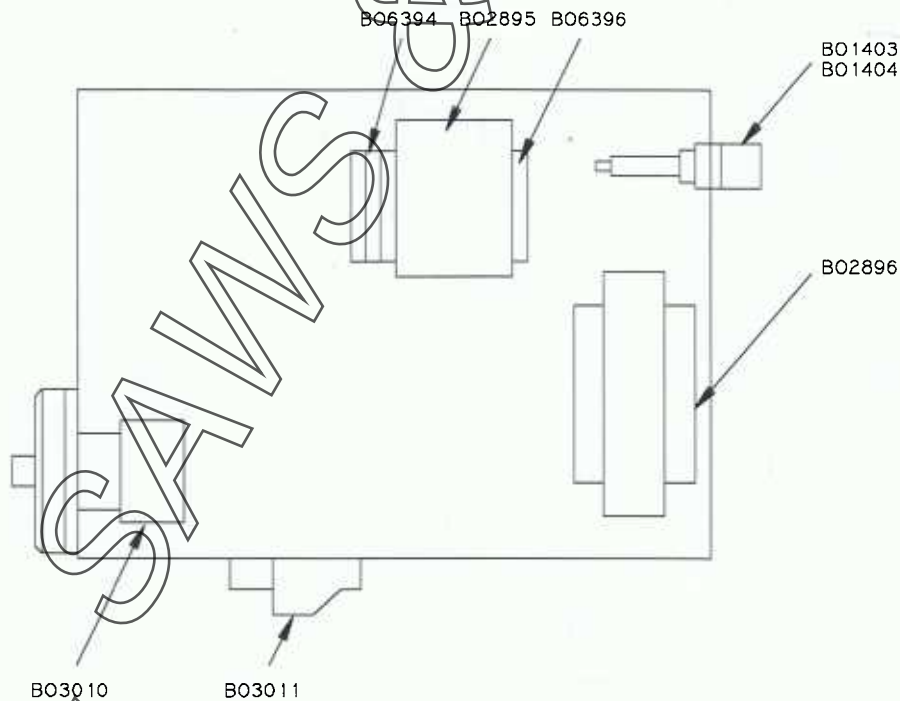
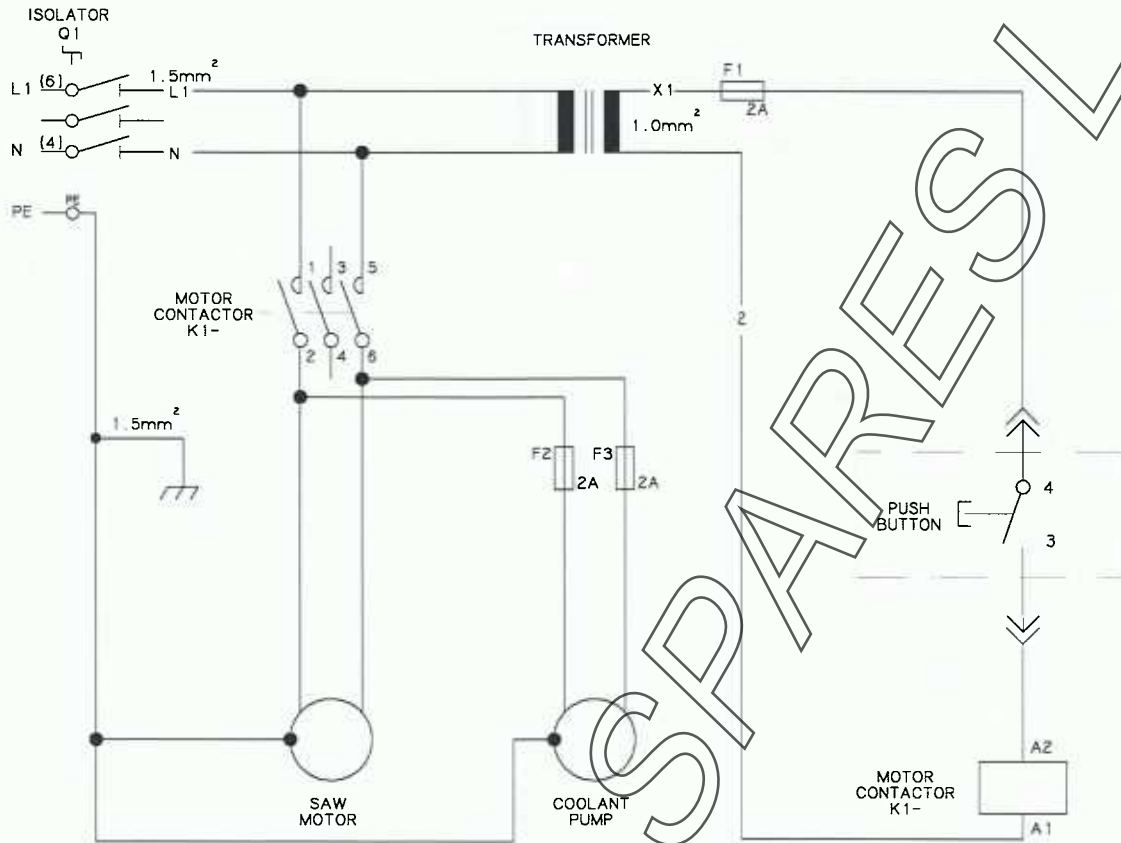
## PNEUMATIC SYSTEM (SC350DP ONLY)



### Key

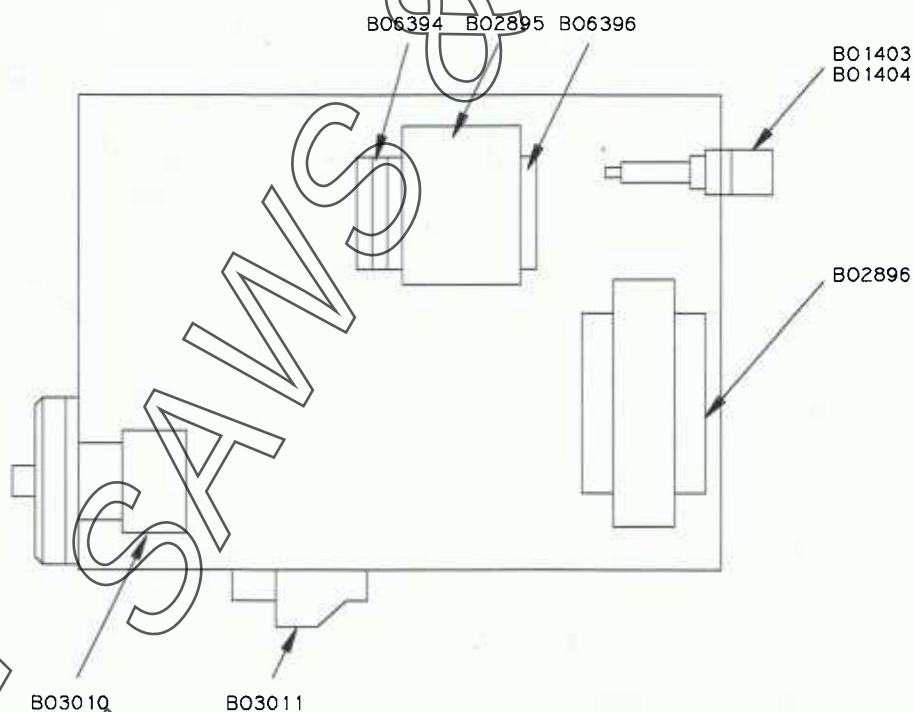
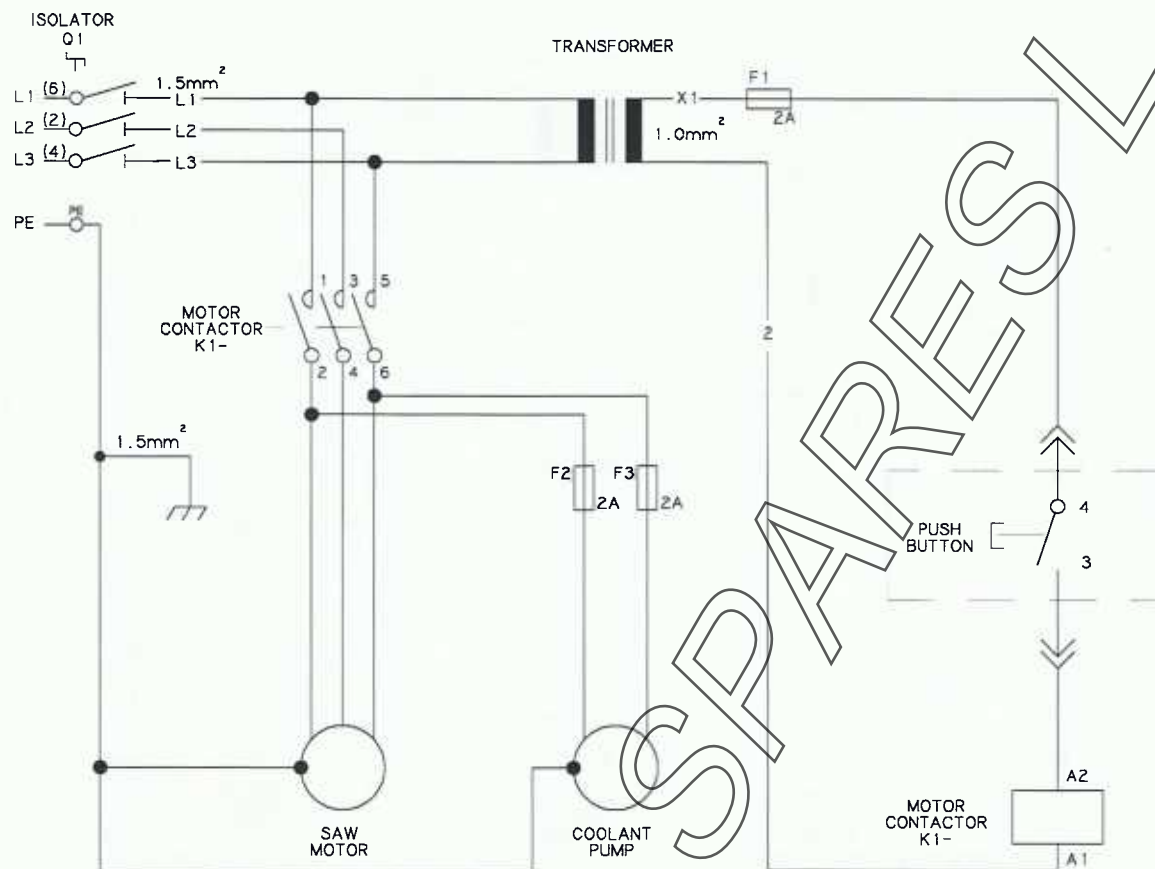
- 1 Pressure gauge
- 2 Pressure regulator
- 3 Electrical interlock switch
- 4 Vice actuation switch
- 5 Vice housing
- 6 Lubricator
- 7 Tube
- 8 Stand

# WIRING AND LOCATION DIAGRAM - SC250 AND SC275 (1 PHASE)



B06394	TERMINAL BLOCK	2
B06396	EARTH TERMINAL BLOCKS	2
B01403	FUSE 2.0 ampres	3
B01404	FUSE HOLDER	3
B02896	24 VOLT OUTPUT TRANSFORMER	1
B02895	CONTACTOR 24v 50-60Hz	1
B03011	PLUG BASE	1
B03010	ISOLATOR	1
PART No	DESCRIPTION	DTY

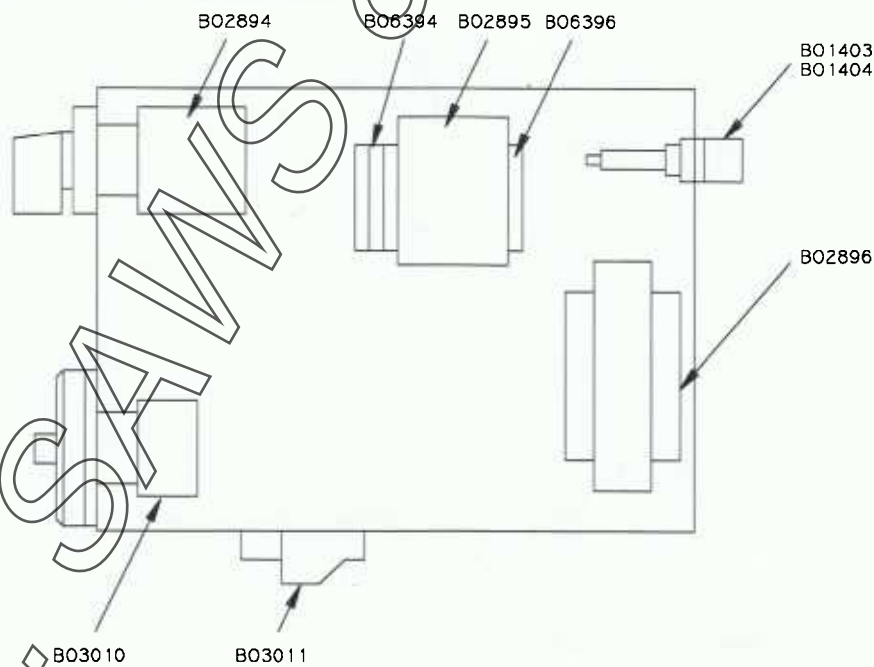
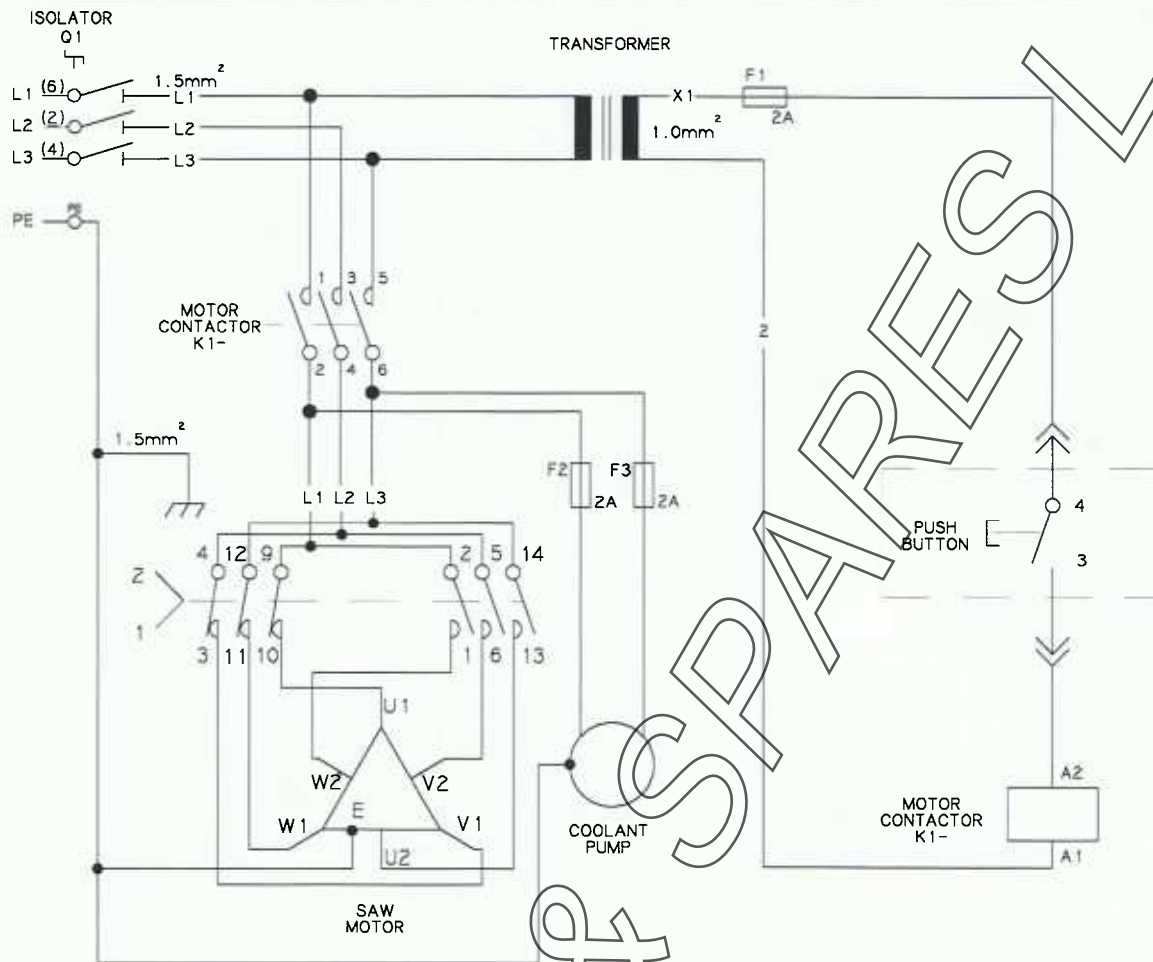
# WIRING AND LOCATION DIAGRAM - SC250 AND SC275 (3 PHASE)



B06394	TERMINAL BLOCK	2
B06396	EARTH TERMINAL BLOCKS	2
B01403	FUSE 2.0 amperes	3
B01404	FUSE HOLDER	3
B02896	24 VOLT OUTPUT TRANSFORMER	1
B02895	CONTACTOR 24v 50-60Hz	1
B03011	PLUG BASE	1
B03010	ISOLATOR	1
PART No	DESCRIPTION	QTY

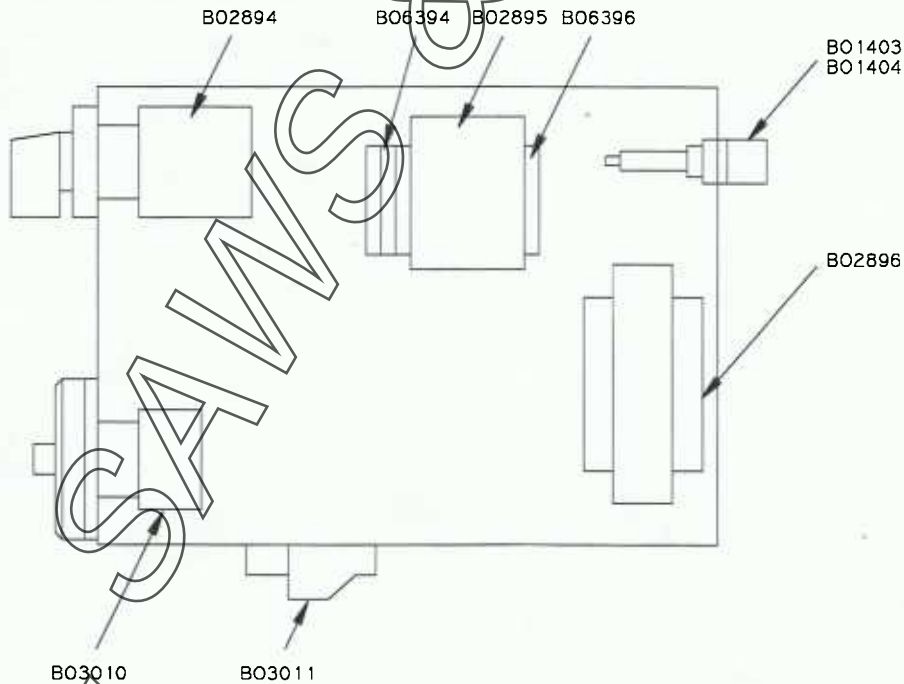
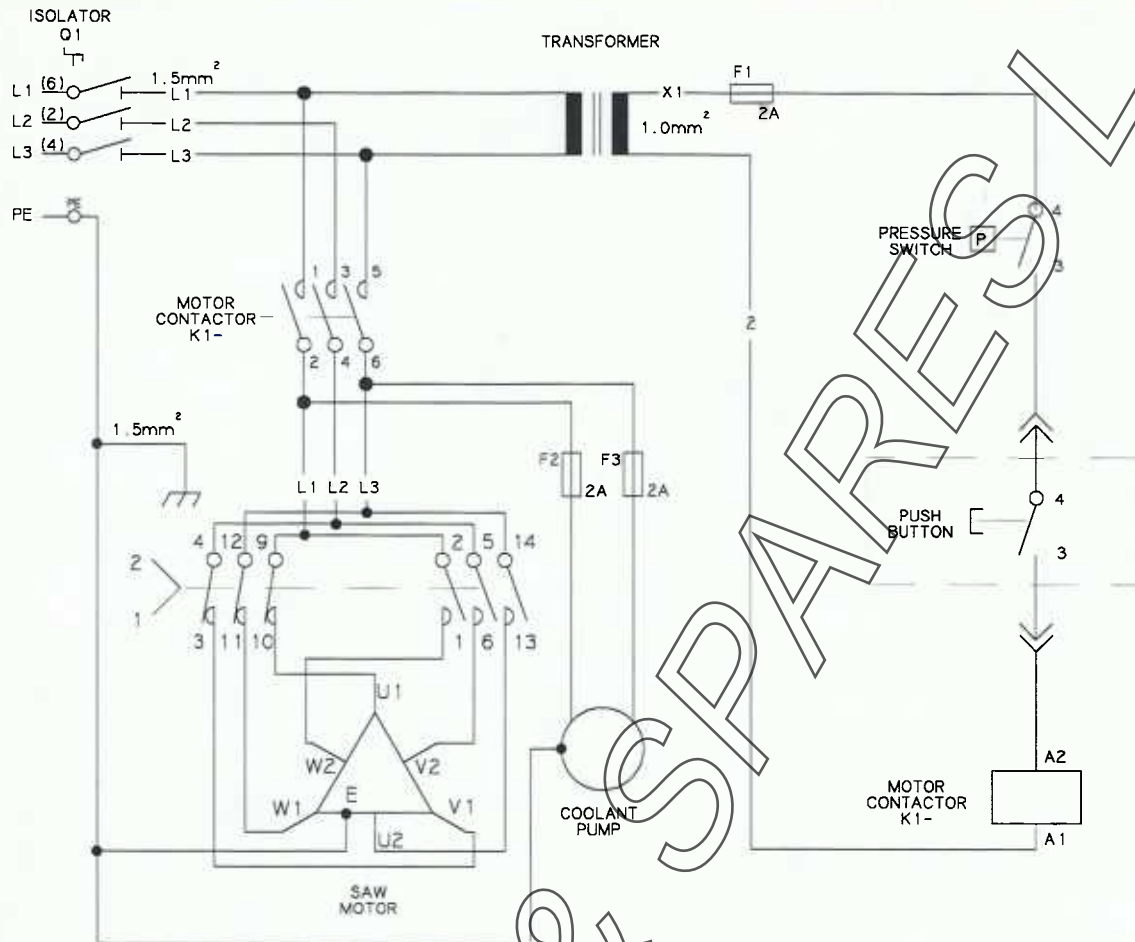


# WIRING AND LOCATION DIAGRAM - SC275D, SC315D AND SC350D (3 PHASE ONLY)



BO2894	SPEED SELECTOR	1
BO6394	TERMINAL BLOCK	2
BO6396	EARTH TERMINAL BLOCKS	2
BO1403	FUSE 2.0 amperes	3
BO1404	FUSE HOLDER	3
BO2896	24 VOLT OUTPUT TRANSFORMER	1
BO2895	CONTACTOR 24v 50-60Hz	1
BO3011	PLUG BASE	1
BO3010	ISOLATOR	1
PART No	DESCRIPTION	QTY

# WIRING AND LOCATION DIAGRAM - SC350DP (3 PHASE ONLY)

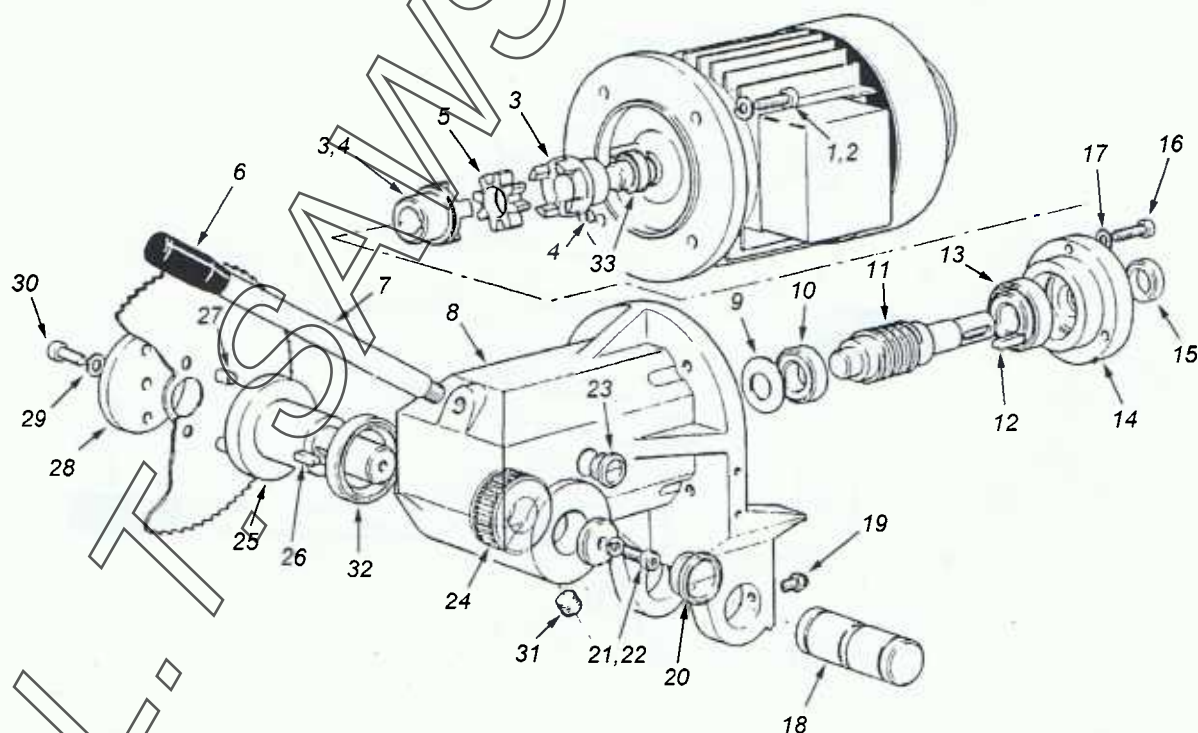


B02894	SPEED SELECTOR	1
B06394	TERMINAL BLOCK	2
B02895	EARTH TERMINAL BLOCKS	2
B01403	FUSE 2.0 amp	3
B01404	FUSE HOLDER	3
B02896	24-VOLT OUTPUT TRANSFORMER	1
B02895	CONTACTOR 24v 50-60Hz	1
B03011	PLUG BASE	1
B03010	ISOLATOR	1
PART No	DESCRIPTION	QTY

# PARTS LIST SC250, SC275, SC275D AND SC315D

## SAW HEAD ASSEMBLY

Item	Part Number	Description	Quantity
1	BO5086	hexagon socket cap head screw	4
2	BO5932	spring washer	4
3	BO2801	Coupling	2
4	BO5195	hexagon socket set screw	2
5	BO2804	Flexible coupling	1
6	BO2809	Hand knob	1
7	9019	Operating handle	1
8	9001	Saw head	1
9	BO2853	Disc spring	1
10	BO2006	Bearing	1
11	9008	Worm shaft	1
12	BO2857	Key	1
13	BO2851	Bearing	1
14	9007	Bearing housing	1
15	BO2850	Oil seal	1
16	BO5077	hexagon socket cap head screw	3
17	BO5935	lock washer	5
18	9064	Pivot	1
19	BO2478	Grease nipple	2
20	BO2863	Oil level plug	1
21	BO5086	hexagon socket cap head screw	1
22	9026	Washer	1
23	BO2832	Oil level plug	1
24	9028	Worm wheel	1
25	9072	Output drive shaft	1
26	BO2833	Key	1
27	BO2985	Pin	2
28	9032/A	Blade clamping flange	1
29	BO5921	washer	1
30	BO5092	hexagon socket cap head screw	1
31	BO2808	Plug	1
32	BO2834	Oil seal	3
33	10306	Spacer	1

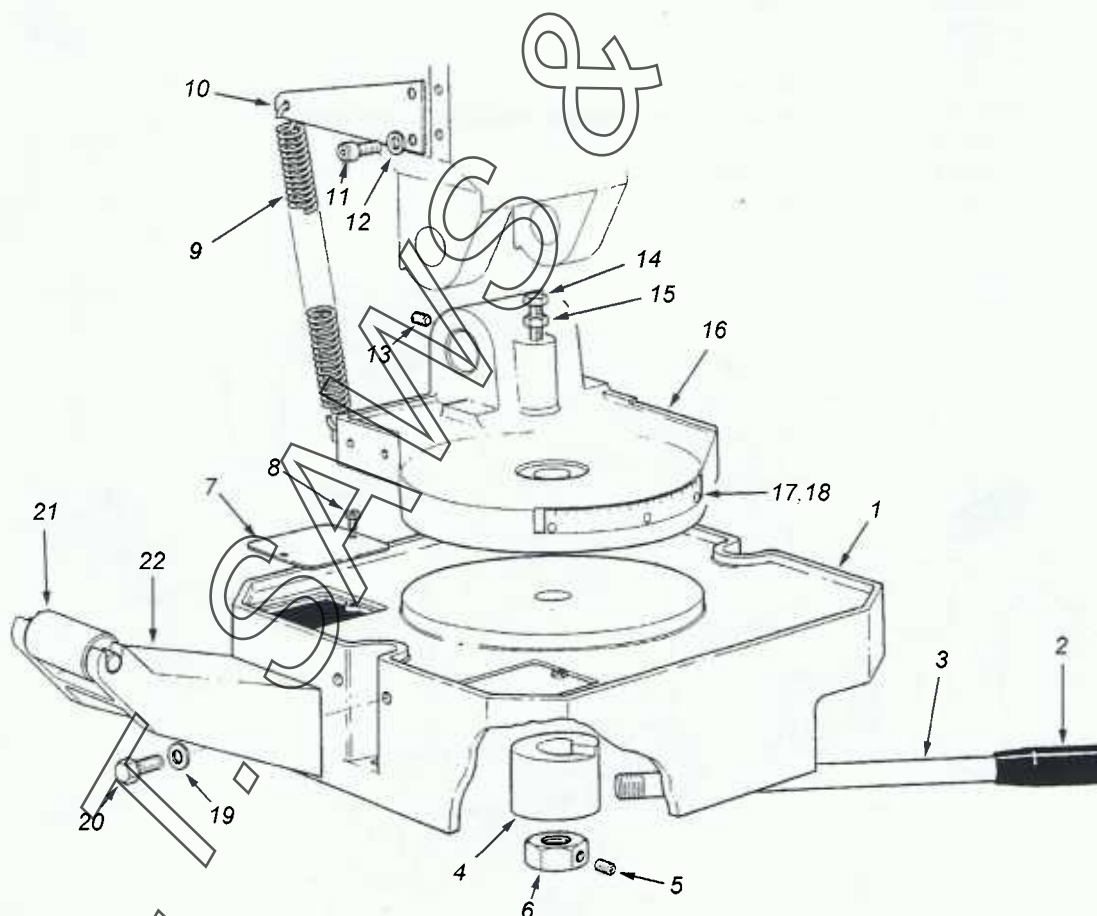


# **PARTS LIST SC250, SC275, SC275D AND SC315D (continued)**

## **MACHINE BASE AND SWIVELLING PEDESTAL**

Item	Part Number	Description	Quantity
1	9000	Machine base	1
2	BO2809	Hand knob	1
3	9012/A	Vice locking lever	1
4	9020	Vice Locking Nut	1
5	BO5199	hexagon socket set screw	1
6	9016	lock nut	1
7	9031	Strainer	2
8	BO5855	Self Tapping Screw	4
9	9275	Tension spring	1
10	9023	Upper spring bracket	1
11	BO5073	hexagon socket cap head screw	2
12	BO5935	wavy washer	2
13	BO5211	hexagon socket set screw	1
14	BO5575	hexagon head screw	1
15	BO5754	nut	1
16	9002	Swivelling pedestal	1
17	9041	Scale	1
18	BO2858	Button head. rivet	3
19*	BO5919	washer	2
20*	BO5087	hexagon socket cap head screw	2
21*	9029	Roller	1
22*	9005	Material support	1

\*optional

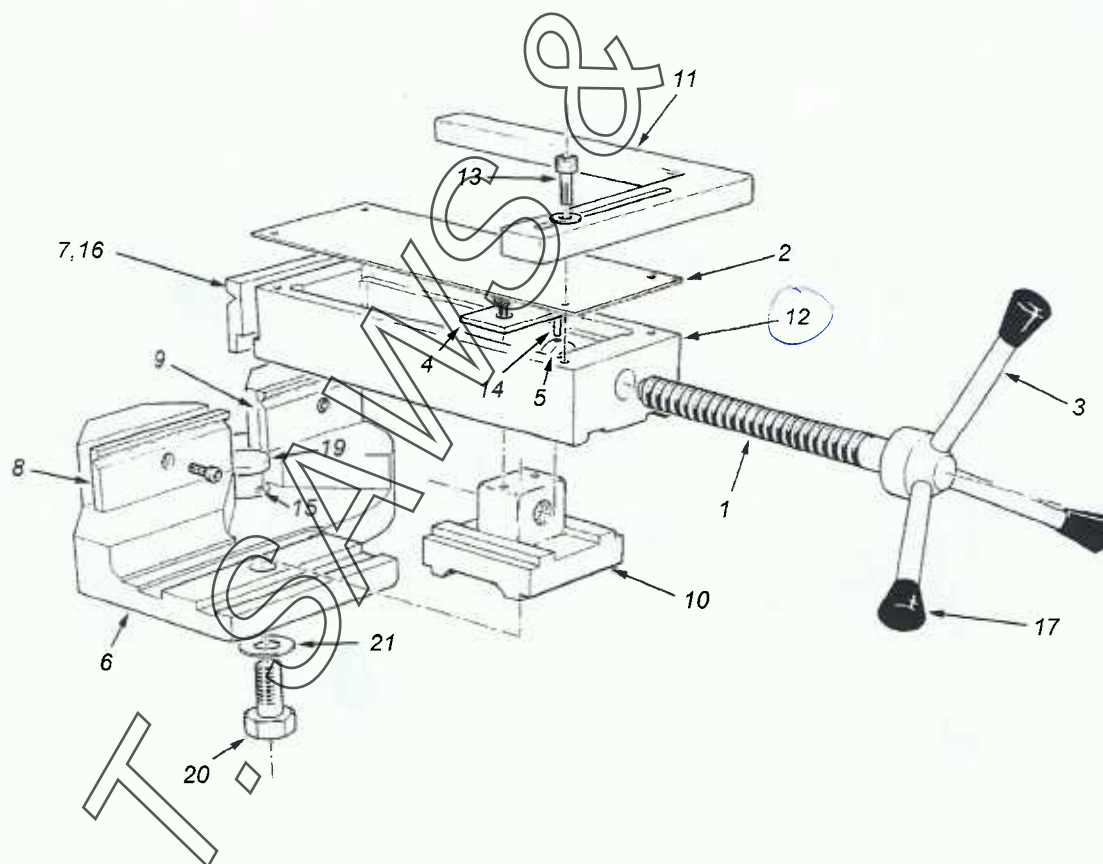




# **PARTS LIST SC250, SC275, SC275D AND SC315D (continued)**

## **VICE ASSEMBLY SC250**

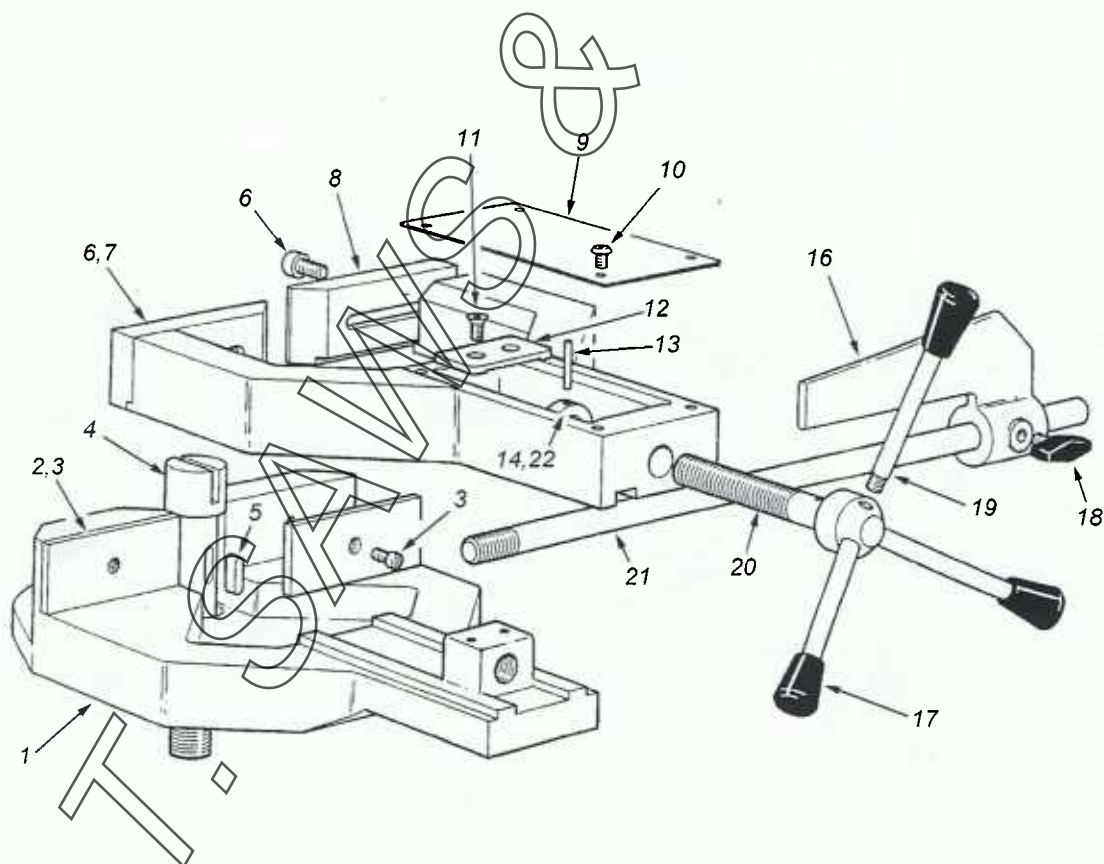
Item	Part Number	Description	Quantity
1	9286	Screw spindle	1
2	9018	Cover plate	1
3	9284	Vice handle	3
4	9027	Clamping plate	1
5	9030	Stop collar	1
6	9287	Vice base	1
7	9288	Front vice jaw	1
8	9289	Rear vice jaw left	1
9	9290	Rear vice jaw right	1
10	9291	Vice adjuster	1
11	9292	Anti-burr device	1
12	9293	Vice adjustment block	1
13	BO5075	hexagon socket cap head screw	2
14	BO5341	pin	1
15	BO2820	Key	1
16	BO2864	hexagon socket cap head screw	2
17	BO2817	Knob	3
18	BO5269	hexagon socket countersunk head screw	2
19	9009	Central shaft	1
20	BO5584	hexagon head screw	1
21	BO5922	washer	1



# **PARTS LIST SC250, SC275, SC275D AND SC315D (continued)**

## **VICE ASSEMBLY SC275, SC275D AND SC315D**

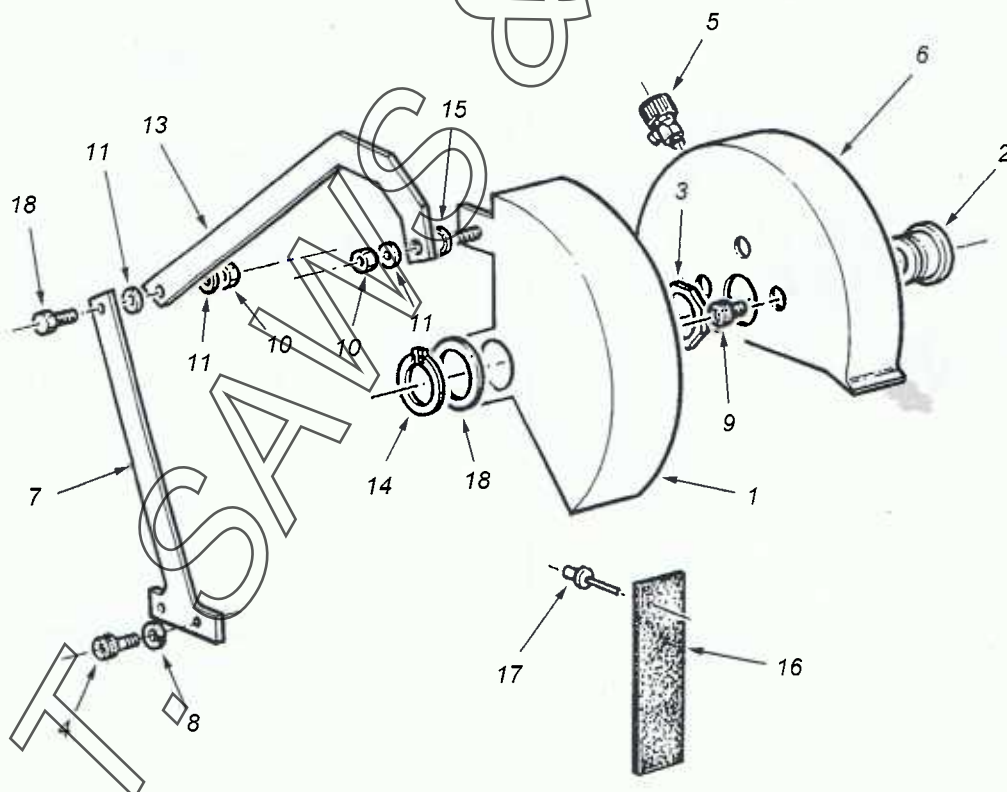
Item	Part Number	Description	Quantity
1	9033	Vice base	1
2	9365	Back jaw	2
3	BO5067	hexagon socket cap head screw	2
4	9009	Central shaft	1
5	BO2820	Key	1
6	9366	Left front jaw	1
7	BO5085	hexagon socket cap head screw	2
8	9367	Right front jaw	1
9	9039	Cover plate	1
10	BO5453	hexagon socket button head screw	4
11	BO5269	hexagon socket countersunk head screw	2
12	9027	Clamping plate	1
13	BO5341	pin	1
14	9030	Stop collar	1
15	9035	Double vice	1
16	9004	Stock stop	1
17	BO2817	Handknob	3
18	BO2953	Locking screw	1
19	9284	Vice handle	3
20	9286	Screw spindle	1
21	9017	Stock stop bar	1
22	BO5185	hexagon socket set screw	1



# **PARTS LIST SC250, SC275, SC275D AND SC315D (continued)**

## **BLADE GUARD ASSEMBLY**

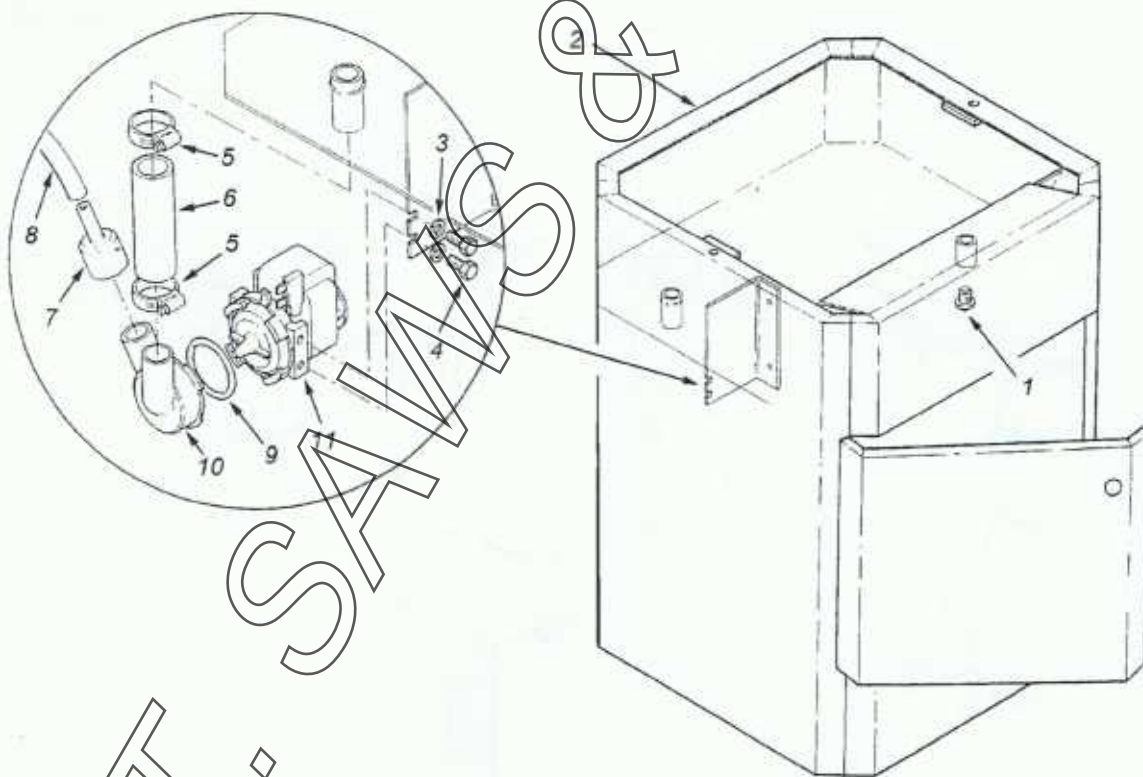
Item	Part No. SC250	Part No. SC275 SC275D	Part No. SC315D	Description	Quantity
1	SM2130	SM2143	SM2154	Outersafety guard	1
2	9312	9312	9312	Bearing	1
3	9313	9313	9313	Spacer plate	1
4	BO5074	BO5074	BO5074	hexsocket cap headscrew	2
5	BO2855	BO2855	BO2855	Coolant valve	1
6	SM2141	SM2144	SM2155	Innersafety guard	1
7	9015	9015	9015	Fixed safety guard lever	1
8	BO5935	BO5935	BO5935	lockwasher	2
9	BO2864	BO2864	BO2864	long hexsocket cap headscrew	3
10	BO5731	BO5731	BO5731	nut	2
11	BO5917	BO5917	BO5917	washer	3
12	BO5563	BO5563	BO5563	hexagon headscrew	1
13	9014	9014	9316	Safety guard lever	1
14	BO6029	BO6029	BO6029	Circlip	1
15	BO3021	BO3021	BO3021	Flanged oilite bush	1
16	9242	9242	9242	Splash guard	1
17	BO2858	BO2858	BO2858	Pop rivet	2
18	9355	9355	9355	Axial disk	1



## PARTS LIST SC350D AND SC350DP

### STAND AND COOLANT PUMP ASSEMBLY

Item	Part Number	Description	Quantity
1	BO2924	Drain plug	1
2	SM1738/A	Machine stand	1
3	BO5936	spring washer	2
4	BO5552	hexagon head screw	2
5	BO2581	Hose clamp	2
6	BO2859	hose	1
7	BO2824	Reducer	1
8	BO6378	hose	1
9	BO2921	Coolant pump seal	1
10	BO2920	Pump housing	1
11	BO2910	110V 50 Hz coolant pump, or	1
	BO2919	220V 50 Hz coolant pump, or	
	BO2925	380V 50 Hz coolant pump, or	
	BO2927	415V 50 Hz coolant pump, or	
	BO2918	440V 50 Hz coolant pump, or	
	BO2928	550V 50 Hz coolant pump	





## UPPER SAW HEAD

Diagram illustrating the exploded view of a Startrite machine, showing various components numbered 1 through 28. The components include a motor (1), mounting bracket (2), shaft (3), pulley (4), coupling (5), drive pulley (6), housing (7), base plate (8), and various fasteners (9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27).

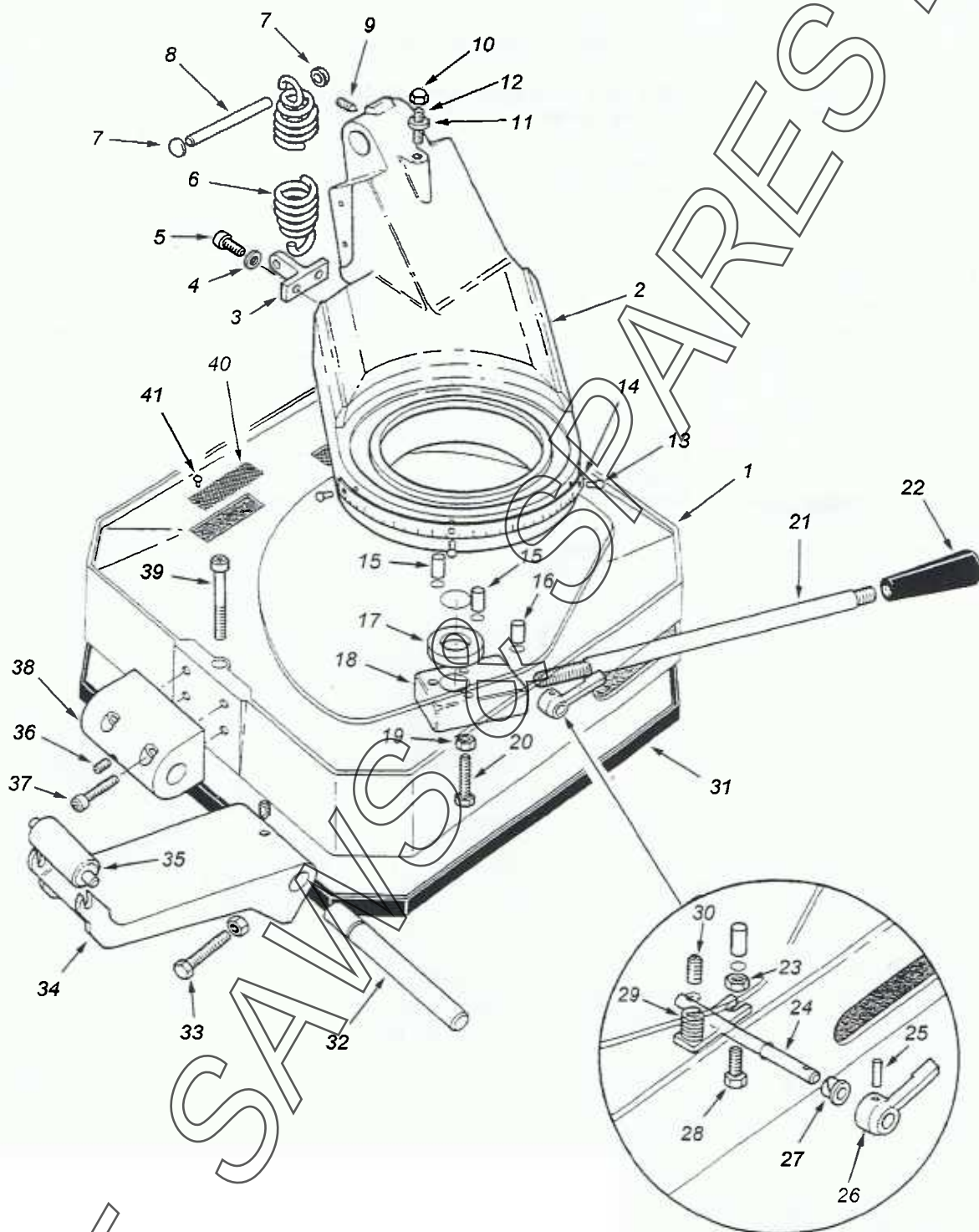
[www.altsawsandspares.com](http://www.altsawsandspares.com)

# **PARTS LIST SC350D AND SC350DP (continued)**

## **MACHINE BASE AND SWIVELLING PEDESTAL**

<b>Item</b>	<b>Part Number</b>	<b>Description</b>	<b>Quantity</b>
1	9094	Machine base	1
2	9090	Swivelling pedestal	1
3	9040	Spring bracket	1
4	BO5395	spring washer	2
5	BO5075	hexagon socket cap head screw	2
6	9102	Spring	1
7	BO2937	Combined end cap and lock washer	2
8	9096	Pin	1
9	BO5212	hexagon socket set screw	1
10	BO2939	domed nut	1
11	9140	Adjuster	1
12	2841	stud	1
13	BO2858	Rivet	7
14	9105	Scale	1
15	BO2949	dowel pin	2
16	BO2997	Pin	1
17	9092	Pressure plate	1
18	9095	Vice locking nut	1
19	BO5715	nut	4
20	BO5569	hexagon head screw	3
21	9012/A	Vice locking lever	1
22	BO2809	Handle	1
23	BO5714	nut	1
24	SM2240	Cam spindle	1
25	BO5349	Pin	1
26	BO3000	Handle	1
27	BO2998	Bearing	1
28	BO5555	hexagon head screw	1
29	BO3001	Spring	1
30	BO3004	hexagon socket set screw	1
31	BO2800	Rubber	1
32	9074	Pivot Shaft	1
33	BO2950	hexagon head screw	1
34	9075	Material support	1
35	9029	Roller	1
36	BO5199	hexagon socket set screw	2
37	BO2958	hexagon socket cap head screw	4
38	9282	Support block	1
39	BO2987	hexagon socket cap haed screw	2
40	9101	Strainer	2
41	BO5855	Self tapping screw	4

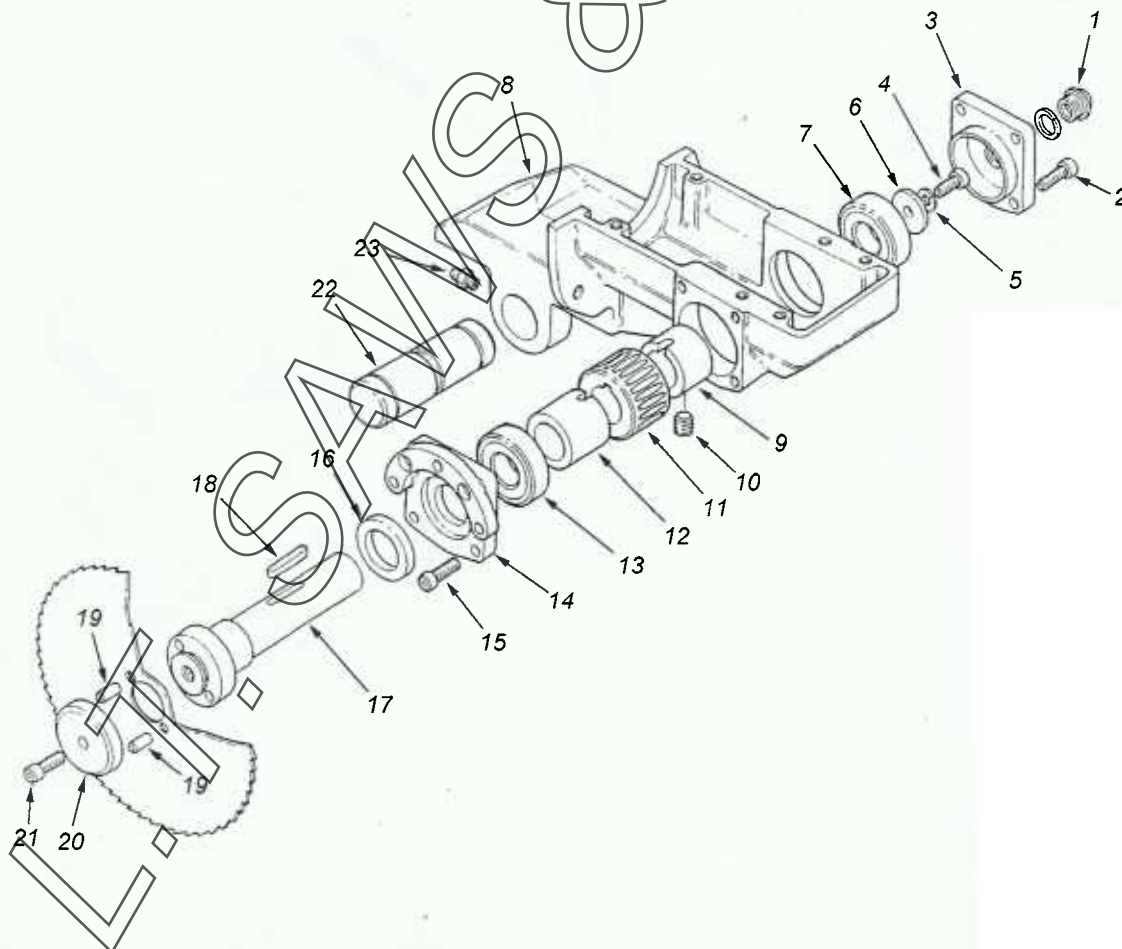
# PARTS LIST SC350D AND SC350DP (continued)



## PARTS LIST SC350D AND SC350DP (continued)

### LOWER SAW HEAD

Item	Part Number	Description	Quantity
1	BO2966	Oil level indicator	1
2	BO5076	hexagon socket cap head screw	4
3	9065	Cover plate	1
4	BO5086	hexagon socket cap head screw	1
5	BO5932	lock washer	1
6	9066	Spacer	1
7	BO2968	Bearing	1
8	9056	Saw head lower	1
9	9100	Spacer	1
10	BO2993	Oil drain plug	1
11	9070	Worm wheel	1
12	9067	Spacer	1
13	BO2935	Bearing	1
14	9071	Cover plate	1
15	BO5074	hexagon socket cap head screw	4
16	BO2974	Oil seal	1
17	9068	Output drive shaft	1
18	BO2969	Key	1
19	BO2985	Pin	2
20	9032/A	Outer flange	1
21	BO5092	hexagon socket cap head screw	1
22	9064	Pivot bar	1
23	BO2478	Grease nipple	2

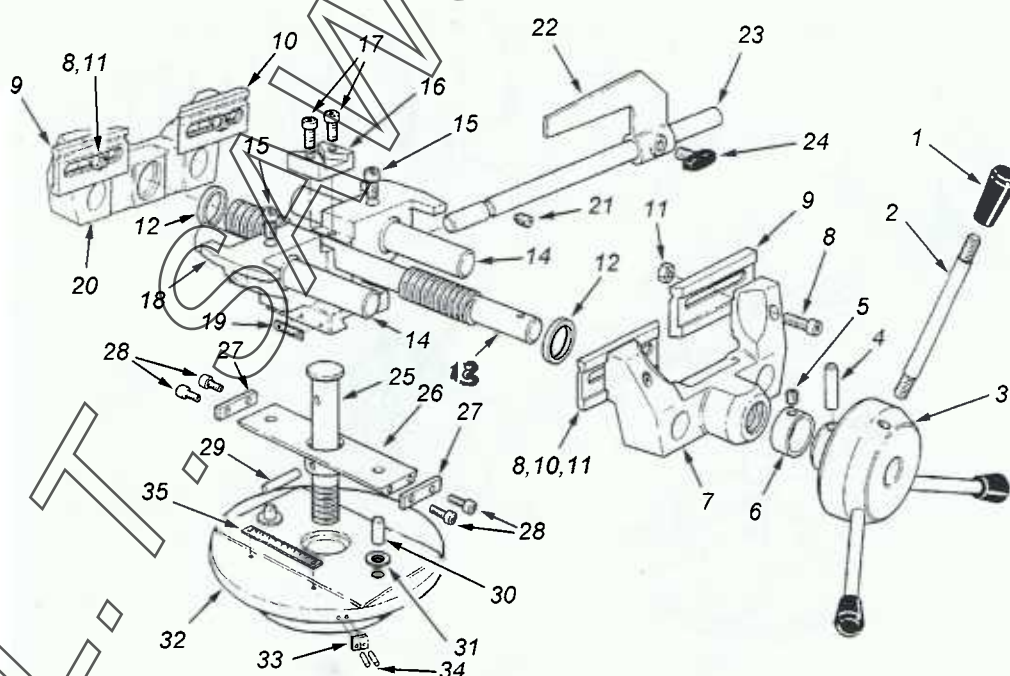




# PARTS LIST SC350D AND SC350DP (continued)

## VICE ASSEMBLY

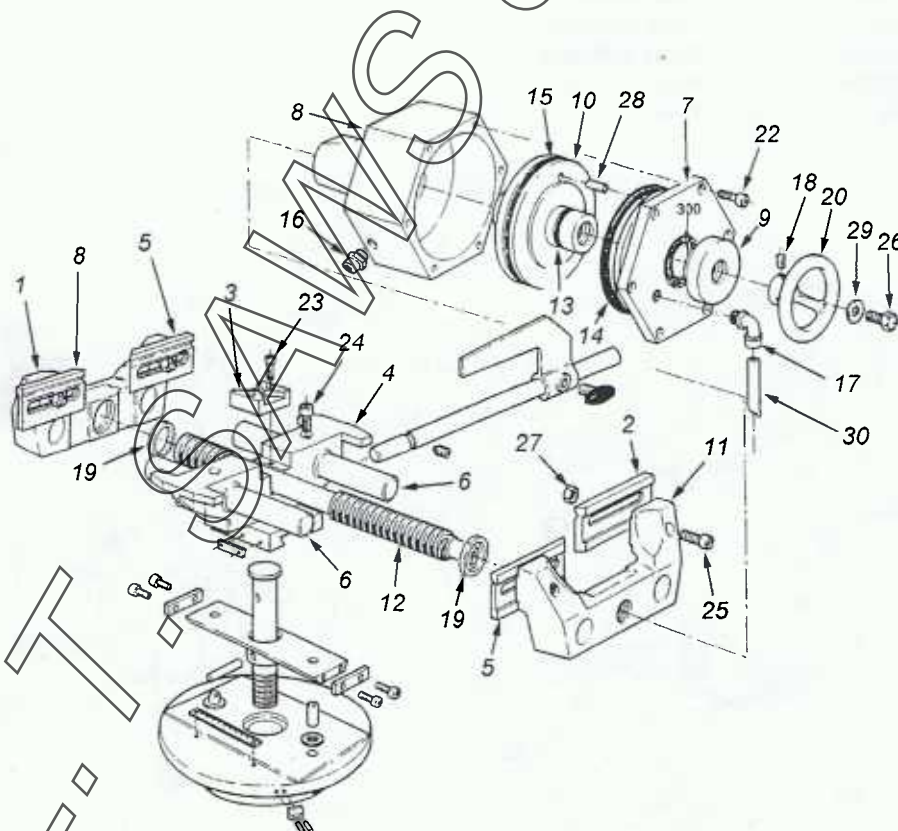
Item	Part Number	Description	Quantity
1	BO2817	Knob	3
2	9284	Vice handle	3
3	9285	Vice hub	1
4	BO5359	Pin	1
5	BO5185	hexagon socket set screw	1
6	9099	Spacer	1
7	9077/B	Inner vice jaw	1
8	BO5088	hexagon socket cap head screw	4
9	9089	Vice jaw insert	2
10	9078	Vise jaw insert	2
11	BO2806	nut	4
12	BO2990	Dust seal	2
13	9083	Vice screw	1
14	9098	Guide spindle	2
15	BO5075	hexagon socket cap head screw	2
16	9080	Support block	1
17	BO5068	hexagon socket cap head screw	2
18	9081	Vice base	1
19	9103	Scale	1
20	9077/A	Inner vice jaw	1
21	BO5201	hexagon socket set screw	1
22	9062	Stock stop	1
23	9017	Stock stop bar	1
24	BO2953	Locking screw	1
25	9093	Screw end	1
26	9088	Dove tail	1
27	9087	End stop	2
28	BO5066	hexagon socket cap head screw	4
29	BO2951	Dowel pin	1
30	BO2985	Dowel pin	2
31	BO2242	Disc spring	2
32	9129	Dove tail table	1
33	BO2996	Scale indicator	1
34	BO2858	Rivet	2
35	9104	Scale	1



# **PARTS LIST SC350D AND SC350DP (continued)**

## **PNEUMATIC VICE ASSEMBLY**

Item	Part Number	Description	Quantity
1	9077/A	Vice jaw casting right hand	1
2	9078	Vice jaw right hand	2
3	9080	Support block	1
4	9081	Vice bed	1
5	9089	Vice jaw left hand	2
6	9098	Guide spindle	2
7	9224	Pneumatic vice cover	1
8	9227	Pneumatic cylinder	1
9	9229	Securing nut	1
10	9234	Piston	1
11	9235	Inner vice jaw	1
12	9250	Screw spindle	1
13	BO2284	O-Ring	2
14	BO2285	O-Ring	1
15	BO2286	O-Ring	1
16	BO2416	Coupling	1
17	BO2423	Female elbow	1
18	BO5186	hexagon socket set screw	1
19	BO2990	Sealing ring	2
20	BO3025	Handle	1
21	BO3026	Sealing ring	1
22	BO5061	hexagon socket cap head screw	6
23	BO5068	hexagon socket cap head screw	2
24	BO5075	hexagon socket cap head screw	2
25	BO5088	hexagon socket cap head screw	4
26	BO5552	hexagon head screw	1
27	BO5716	nut	4
28	BO5892	Dowel	1
29	BO5915	washer	1
30	BO6384	Tube	1



# **PARTS LIST SC350D AND SC350DP (continued)**

## **BLADE GUARD**

Item	Part Number	Description	Quantity
1	SM2159	Safety guard inner	1
2	10382	Bearing	1
3	BO2864	hexagon socket cap head screw	3
4	SM2158	Safety guard outer	1
5	9355	Spacer	1
6	BO6029	Circlip	1
7	BO5935	spring washer	2
8	9326	Guard bracket	1
9	BO5917	washer	3
10	BO5565	hexagon head screw	2
11	9049	Guard bracket	1
12	BO5731	lock nut	2
13	BO5066	hexagon socket cap head screw	3
14	9313	Spacer	1
15	BO5916	washer	3
16	9327	Actuating arm	1
17	BO5563	hexagon head screw	1
18	BO3021	Flanged bush	1
19	BO2855	Valve	1
20	10383	Intermediate guard	1

