

# STARTRITE HORIZONTAL BANDSAWS



**STARTRITE**

THE CHOICE OF  
BRITISH INDUSTRY  
FOR OVER 50 YEARS

## HORIZONTAL METAL CUTTING BANDSAWS

Startrite manufacture the widest and broadest range of top quality Metal Cutting Bandsaws available. With features and benefits simply not found on imported machines, we are able to offer a bandsaw to suit all budgets and applications, from Manually Operated Workshop Saws to Fully Automatic Production Machines and Swivel Head Bandsaws.

### H175W & H200W GENERAL WORKSHOP SAWS

The Startrite H175W & H200W have been designed to be low cost, compact machines, built to withstand the rigours of industry. The machines comprise of strong rigid saw frames fitted to steel beds, all providing a high degree of accuracy and durability

#### Vice



A lead screw operated vice ensures secure clamping of the work piece whilst easily adjustable solid cast iron vice jaws can be angled for mitring.

#### Transmission



A totally enclosed reduction gear box with oil bath lubrication ensures trouble free running and speed change can be done with ease via a stepped pulley.



The H175W Bandsaw can be used either as a horizontal machine or as a vertical bandsaw enabling a very wide range of applications.

#### Optional accessories.



Infeed roller table.  
Useful when cutting long or heavy lengths of material.  
Tables can be fitted together for added versatility.  
Part No. SM1271



Roller stock stand.  
A heavy duty, fully adjustable stand.  
Can be positioned to the front or rear of the machine as a flexible alternative to roller tables.  
Part No. SM559



H200W shown

Machine shown with optional accessories

#### FEATURES AND BENEFITS.

- Fabricated steel bed for rigidity, durability and accuracy.
- Steel wear strips. (H200W only)
- Hydraulically controlled bow descent
- H175W can be easily placed in the vertical position, making it two machines in one.
- Precision blade guide mechanism with carbide inserts.
- Coolant system featuring an electric pump.
- Material stock stop supplied as standard.
- Self propelled blade cleaning brush, helps prevent swarf accumulating in the teeth of the blade.
- 4 speeds using a stepped pulley drive.
- Fully enclosed blade with adjustable guards.
- Blade tension indicator.
- Low voltage control circuit for safety (110V).
- One year warranty cover.

For a comprehensive blade selection and recommended spare parts see page no.7

## H280M5, H330MV & H330SV HEAVY DUTY PRODUCTION SAWS

The Startrite H280 and H330 series, are the perfect solution to the efficient sawing of large sections, tubes and bars, either for production or intermittent use. With their very heavy construction, they offer increased productivity, high reliability and superb accuracy.

### Vice



The vice assembly with its rapid clamp and quick release mechanism provides ease of material handling and can be angled to 45° for mitring.

### Material stop assembly



A heavy duty material stop is supplied as standard equipment.

An automatic swing away end stop assembly allows the billet to clear the sawing area at the end of cut. (H330SV + H280AV only).

### Blade guidance system



Precision blade guide mechanism with carbide inserts coupled with roller bearings provide optimum blade support for accurate cutting.

### Transmission



The Startrite H330MV, H330SV and H280AV are supplied with electronic variable speed drives, delivering increased cutting efficiency and blade life. Heavy duty cast-iron bed assembly and a reinforced cutting box ensures accuracy and durability at all times.



The Startrite H280M5 is equipped with a stepped pulley drive providing 5 preselected speeds.



H330MV shown.



Infeed Roller Table.  
Useful when cutting long or heavy lengths of material. Additional tables can be bolted together for extra length & versatility.  
Part No. SM2679



Roller Stock Stand  
A heavy duty fully adjustable stand can be positioned to the front or rear of the machine as a flexible alternative to roller tables.  
Part No. SM561



Starrite emulsifiable coolant is specially formulated for use with Horizontal Bandsaws to prevent swarf accumulating on the blade and to form a lubricant coating over the blade.  
- 5 litre can coolant  
Part No. BO7021



A fully comprehensive blade selection chart is shown on page 7.

#### FEATURES AND BENEFITS.

- Easy blade speed adjustment through a rugged industrial electronic drive unit. (H330MV, H330SV & H280AV)
- Blade speed adjustment is done through a stepped pulley drive on H280M5.
- Electrical bow release mechanism allows once only setting of saw rate, controlled hydraulically.
- Heavy duty cast iron bed and proven construction.
- Quick release vice.
- Precision blade guide mechanism with carbide inserts.
- Totally enclosed 1.5kw drive motor. 110 volt control with low voltage and overload protection.
- H330SV & H280AV automatic bow lift on end of cut.
- All machines have heavy duty material stop assembly. (H330SV + H280AV - equipped with a swivel away end stop assembly.)
- Conveniently positioned control panel, clearly marked.
- Additional stop/start controls at rear of machine, for ease of use.
- Fully enclosed blade with adjustable guards.
- Blade tension indicator.
- Automatic blade cleaning brush.
- Matrix bi-metal blade.
- Operating manual and tool kit.
- One year warranty cover.

For a comprehensive blade selection and recommended spare parts see page no.7

## H280AV FULLY AUTOMATIC SAW

Where completely automatic sawing is the requirement, the Startrite H280AV provides the solution. It features electronic variable speed drive control delivering increased cutting efficiency and blade life. With its heavy duty vice and fully automatic operation it combines productivity with precise sawing.



H280AV shown with optional infeed roller table (SM267A)

### Swingaway



An adjustable material stop assembly featuring a graduated scale and micro adjust mechanism allowing fine adjustment of 0.1mm means the operator can accurately saw to length. The stop assembly swings away automatically allowing the billet to clear the sawing area at the end of cut.

### Vice



A heavy duty automatic vice grips the work piece and feeds the material to the end stop assembly.

### Control Panel



Ergonomically positioned controls. Clearly marked durable control panel with a facility to stop/start the machine from the front or rear of the machine.

### FEATURES AND BENEFITS.

- Fully Automatic Production Bandsaw.
- Fast material feed by a powerful geared vice.
- User friendly control panel enables all settings to be made easily.
- Automated slide away stop assembly allows billet to fall clear of sawing area.
- Totally enclosed 1.5kw motor with electronic variable speed control.
- Preset cutting - bar stock can be automatically set to predetermined levels from 5mm to 610mm and the number of pieces required can be pre-set and the quantity produced counted.
- Heavy duty cast iron bed and proven construction for rigidity, durability and accuracy.
- Precision blade guide mechanism with carbide inserts and roller bearings providing optimum support for accurate cutting.
- Coolant system and flushing hose.
- 110 volt control with low volt and overload protection.
- Fully covered blade with adjustable guard.
- Blade tension indicator.
- Automatic blade cleaning brush.
- Matrix bi-metal blade.
- Operating manual and tool kit.
- One year warranty guarantee.

For a comprehensive blade selection and recommended spare parts see page 7.

## S330MV LARGE CAPACITY SWIVEL HEAD BANDSAW

Startrite, the leading UK manufacturer of quality metal cutting saws, now provide new levels of sawing versatility with the S330MV swivel head bandsaw.

Ideal for cutting and mitring large tube, structural sections and bar. This machine offers easy mitring, +45° to -60°, with its swivelling bow and its easy to read large graduated scale - telling the operator exactly what angle they are cutting. The machine is equipped with automatic bow lift at the end of cut and the material is securely clamped with long, heavy duty quick release vice jaws. This machine offers exceptional cutting capacity, reliability and accuracy.

### Bed and scale clamp



The head can be easily swivelled, and set to the exact angle by means of a large easy to read scale.



The head swivels to +45° -60° for maximum convenience and enables large capacities from 610 x 305mm at 90° to 275 x 300mm at -60°.

### Vice



Rapid clamp and quick release mechanisms provide ease of material handling. Both fixed and moving vice jaws have been extended to accommodate large work pieces with ease.

### Large cutting capacity



S330MV Capable of cutting standard I beams (610mm x 305mm)

### FEATURES AND BENEFITS.

- Bow swivels in both directions from +45° to -60° for maximum convenience.
- Quick release vice.
- Totally enclosed 1.5kw motor with electronic variable speed control.
- Hydraulically controlled feed rate and bow lift.
- User friendly control panel.
- Precision blade guide with carbide inserts.
- Coolant system with flushing hose
- 110 volt control with low voltage and overload protection
- Fully enclosed blade with adjustable guards.
- Matrix bi-metal blade.
- Blade tension indicator.
- Automatic blade cleaning brush.
- Unique Startrite Anti - blade vibration device.
- Operating manual and tool kit.
- One year warranty cover.

## Sawing Advice

### Startrite Terminology



- 1) Thickness - The thickness of the blade.
- 2) Width - The nominal dimension of the saw blade as measured from the tip of the tooth to the back of the band.
- 3) Set - The bending of teeth to right or left to allow clearance of the back through the cut.
- 4) Tooth - The cutting portion of the saw blade.
- 5) Tooth pitch - The distance from the tip of one tooth to the tip of the next tooth.
- 6) T.P.I. - The number of teeth per inch.
- 7) Gullet - The curved area at the base of the tooth.
- 8) Tooth Tip - The cutting edge of the sawblade.

### What tooth form should I use?

Standard (Regular tooth) - General purpose blades designed for a wide range of applications  
 Vari - pitch (Variable tooth spacing) - Smoother cutting, reduced harmonic vibration, faster cutting rate + enhanced blade life.

### What Blade?



### BLADES AVAILABLE

	H175W/H200W		H280M5/H280AV		H330MV/H330SV		
<b>CARBON STEEL</b>	6TPI = 802492006 10TPI = 802492010 16TPI = 802492018	8TPI = 802492008 14TPI = 802492014	4TPI = 803632504 6TPI = 803632508 10TPI = 803632510 14TPI = 803632514	6TPI = 803632506 10TPI = 803632510	4TPI = 803813204 6TPI = 803813208 10TPI = 803813210 14TPI = 803813214	6TPI = 803813206 10TPI = 803813210	
<b>BI-METAL (MATRIX II)</b>	4TPI = 832492004 8TPI = 832492008 14TPI = 832492014 4/6 Vari-Pitch = 832492004 5/8 Vari-Pitch = 832492005 6/10 Vari-Pitch = 832492006 8/12 Vari-Pitch = 832492008	6TPI = 832492008 10TPI = 832492010 14TPI = 832492014	3TPI = 833632503 6TPI = 833632508 10TPI = 833632510 3/4 Vari-Pitch = 833632504 4/6 Vari-Pitch = 833632504 5/8 Vari-Pitch = 833632504 6/10 Vari-Pitch = 833632504 8/12 Vari-Pitch = 833632504 10/14 Vari-Pitch = 833632504	4TPI = 833632504 6TPI = 833632508 10TPI = 833632510 14TPI = 833632514	3TPI = 833813203 6TPI = 833813206 10TPI = 833813210 14TPI = 833813214 3/4 Vari-Pitch = 833813204 4/6 Vari-Pitch = 833813204 5/8 Vari-Pitch = 833813204 6/10 Vari-Pitch = 833813204 8/12 Vari-Pitch = 833813204 10/14 Vari-Pitch = 833813204	4TPI = 833813204 6TPI = 833813208 10TPI = 833813210 14TPI = 833813214	6TPI = 833813206 10TPI = 833813210
<b>BI-METAL (M42)</b>			3TPI = 843632503 6TPI = 843632508 10TPI = 843632510 2/3 Vari-Pitch = 843632504 3/4 Vari-Pitch = 843632504 4/6 Vari-Pitch = 843632504 5/8 Vari-Pitch = 843632504 6/10 Vari-Pitch = 843632504	4TPI = 843632504 6TPI = 843632508 10TPI = 843632510 14TPI = 843632514	3TPI = 843813203 6TPI = 843813206 10TPI = 843813210 2/3 Vari-Pitch = 843813204 3/4 Vari-Pitch = 843813204 4/6 Vari-Pitch = 843813204 5/8 Vari-Pitch = 843813204 6/10 Vari-Pitch = 843813204	4TPI = 843813204 6TPI = 843813208 10TPI = 843813210 14TPI = 843813214	

### Running in

To obtain the maximum blade life always use the recommended blade speed but lower the feed rate to 1/2 - 1/3 during the first ten minutes of cutting. During the next ten minutes increase the feed rate in stages until you have reached the recommended feed rate.

### Recommended Spares.

Your bandsaw is often the most abused piece of machinery in your workshop. It is the starting point for many operations and is widely used. Its real importance is only noticed when it breaks down or cannot cut with great enough accuracy, delaying the start of important jobs and costing your company money. Below is a list of spares that we recommend you keep to avoid any down time should you experience a breakdown.

SPARES	H175W	H200W	H280M5	H280AV	H300MV	H330SV	S330MV
DRIVE BELT	BO2159	BO2159	BO2152	n/a	n/a	n/a	n/a
BLADE BRUSH	BO2565	BO2565	BO2565	BO2565	BO2565	BO2565	BO2565
GUIDE ROLLERS - 4 REQ	BO2035	BO2035	BO2025	BO2025	BO2025	BO2025	BO2025
GUIDE INSERTS-4 REQ	6393	6393	6383	6393	6393	6393	6393
SUPPORT INSERT - 2 REQ	6409	6409	6068	6068	6068	6068	6068
HYDR. CONTROL VALVE	BO2466	BO2466	BO2466	BO2466	BO2466	BO2466	BO2466
HYDR. SEAL KIT	SM2031	SM2031	SM2031	SM2031	SM2031	SM2031	SM2031

### Demonstration Centre

As part of Startrite's ongoing commitment to providing a fully comprehensive service to its customers, a fully equipped training & demonstration centre has been built at our 33 acre manufacturing site in Sheffield.

Startrite build the finest and broadest range of metalworking saws available, with features, benefits and attention to detail simply not found on imported machines. This is why it is important for Startrite to offer customers and distributors hands on experience of our machines to fully appreciate the advantages of Startrite machines over the competition.

The demonstration centre is located in the centre of the United Kingdom, at Sheffield, just a five minute drive from junction 33 of the M1 motorway.

A comprehensive range of British built Startrite machines can be viewed, including the market leading Vertical Bandsaws, Horizontal Bandsaws, a complete range of Circular Cut Off Saws, Full Down Bandsaws, Heavy Duty Grinding Machines, Industrial Belt Linishers, Magnetic Based Drilling Machines and Industrial Drilling Machines.

So if you are interested in a new machine why not contact Startrite on [redacted] and we will be happy to demonstrate why Startrite has been the choice of the industry for over 50 years.



# SPECIFICATION

	H175W	H200W	H280M5	H330MV	H330SV	H280AV	S330MV
Drive Motor (Kw)	0.55	0.9	1.5	1.5	1.5	1.5	1.5
Coolant Motor (Watt)	7	7	7	7	7	7	7
Hydraulic Motor (Kw)					0.19	0.19	0.19
Master Feed Motor (Kw)					0.9		
Material Feed Rate (m/min)					3.6		
Stock Stop Adjustment (mm)							max - min 810
Blade Speed Range (m/min)	18-30 49-69	18-30 49-69	15-24 36-61-92	15-102	15-102	13-92	15-106
Bow Rotation Controlled							+45° to -60°
Hydraulically Controlled Feed Rate	●	●	●	●	●	●	●
Bow Descent Halt if Power Fails			●	●	●	●	●
Hydraulically Controlled Bow Lift					●	●	●
Electronic Variable Speed				●	●	●	●
Stepped Pulley Drive	4 Speed	4 Speed	5 Speed				
Electronic Workpiece Counter						●	
Adjustable Upper Bow Position			●	●	●	●	●
Blade Stops Auto at End of Cut	●	●	●	●	●	●	●
Low Volt Protection	●	●	●	●	●	●	●
Additional Controls at Rear			●	●	●	●	
Weight (Kg)	120	186	355	360	360	400	500
Total Height (mm)	890	890	1177	1227	1227	1177	1227
Total Width (mm)	500	500	628	628	628	2375	1300
Total Length (mm)	1280	1260	1751	1751	1751	1751	2100
Instruction Manual + Toolkit				●	●	●	●
Flushing Hose	○	○	●	●	●	●	●
Coolant Tank Capacity (Lit)	20	26	25	25	25	25	25
M2 Bi-metal Blade	○	○	●	●	●	●	●
Blade Tension Indicator	●	●	●	●	●	●	●
Automatic Blade Cleaning	●	●	●	●	●	●	●
Infeed Roller Table	○	○	○	○	○	○	○
Adjustable Stock Stand	○	○	○	○	○	○	○
Leadscrew Operated Vice	●	●	○	○	○	●	n/a

● = Standard Features ○ = Optional Features

# CAPACITIES

H175W	Horizontal		
	0°	45°	
	d (mm)	178	120
	d (in)	7	4.75
	b (mm)	279	119
	x (mm)	X	X
	c	152	119
	b (in)	11	4.7
	x (in)	X	X
	c	6	4.7
Height under guides	Vertical 320mm (12 1/2")		
Throat depth	200mm (8")		

H200W	0°		45°	
		d (mm)	200	147
	d (in)	8	5.8	
	a (mm)	165	119	
	a (in)	6.5	4.7	
	b (mm)	275	119	
	x (mm)	X	X	
	c	175	119	
	b (in)	11	4.7	
	x (in)	X	X	
	c	7	4.7	

H280AV	0°	
		d (mm)
	d (in)	11
	a (mm)	225
	a (in)	9
	b (mm)	410
	x (mm)	X
	c	225
	b (in)	16
	x (in)	X
	c	9

H280M5	0°		45°	
		d (mm)	280	215
	d (in)	11	8.5	
	a (mm)	250	200	
	a (in)	9	8	
	b (mm)	410	215	
	x (mm)	X	X	
	c	225	200	
	b (in)	16	8.5	
	x (in)	X	X	
	c	9	8	

H330MV & SV	0°		45°	
		d (mm)	330	215
	d (in)	13	8.5	
	a (mm)	310	250	
	a (in)	12	10	
	b (mm)	425	215	
	x (mm)	X	X	
	c	310	250	
	b (in)	17	8.5	
	x (in)	X	X	
	c	12	10	

S330MV	45°		30°		15°		0°		15°		30°		45°		60°	
		d (mm)	330	340	330	330	330	330	330	330	330	330	330	330	330	330
	d (in)	13	13	13	13	13	13	13	13	13	13	13	13	13	13	13
	w (mm)	350	530	580	610	580	515	410	275							
	x (mm)	X	X	X	X	X	X	X	X							
	h (mm)	310	310	310	310	310	310	310	310							
	w (in)	14	20.9	23.2	24	23.2	20.3	16.1	10.8							
	x (in)	X	X	X	X	X	X	X	X							
	h (in)	12	12	12	12	12	12	12	12							

The capacities given above are typical. Depending on material shape, size and specification, larger or smaller capacities may apply.



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