

STARTRITE

Vertical
metal working
bandsaw machines



VOLANT

Light duty models



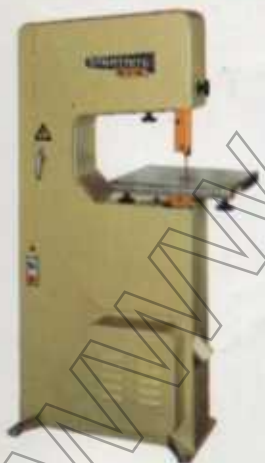
Model 24-V-10

Unitized welded box frame construction, 18in. (455mm) and 24in. (610mm) throat capacity, 1½h.p. (1.1 kw) motor and dual range, totally enclosed transmission are just a few of the reasons why a machine selected from this series would be an excellent choice for any shop.

Ten carefully selected speeds make it possible to cut virtually any material with blades up to ½in. (13mm) wide.

The "V" models differ from the "T" models in that they come with welder, grinder, shear, blade gauge, speed and blade selector dial, pre-focused work light and air chip blower as standard equipment.

Range of models



Model 18-T-10



Model 24-T-10



Model 18-V-10



Model 24-V-10

Specifications

MODEL	18-T-10*	18-V-10	24-T-10	24-V-10
Throat - in. (mm)	18(455)	18(455)	24(610)	24(610)
Work height under top guide - in. (mm)	8(200)	8(200)	8(200)	8(200)
Blade width - in. (mm)	1/8(3), 3/16(5), 1/4(6), 5/16(8), 3/8(10), 1/2(13)			
Blade, File band, Polishing band length - in. (mm)	114(2896)		126(3200)	
Band wheels - No. and size - in. (mm)	3 steel - 12 dia x 1 1/2(305 x 30)			
Wheel tyres	Banded rubber			
Blade guides	Insert type			
Table	19 x 19(483 x 483) split			
Table tilt	45°R, 15°L			
T-slots	Front edge - one			
Table height - in. (mm)	43(1092)			
Drive motor (3 phase)	1 1/2 h.p., 1200 r.p.m.			
Blade speeds f.p.m. (m.p.m.)*	58(17), 70(21), 100(31), 180(55), 320(98), 560(170), 700(210), 1000(310), 1800(550), 3200(980)			
Gear transmission	2 speed - totally enclosed			
Blade welder, grinder and shear	No	Yes	No	Yes
Dimensions - length - in. (mm)	38(965)	44(1118)	47(1194)	53(1346)
width - in. (mm)	21(533)	21(533)	21(533)	21(533)
height - in. (mm)	69(1753)	69(1753)	69(1753)	69(1753)
Net weight - lb(kg)	476(216)	585(265)	556(252)	685(311)
Shipping weight - lb(kg)	656(298)	785(356)	776(352)	925(420)

*Note: These models can be equipped to operate on single phase 50hz supply with speed range 84-4800 ft/min (26-1460 m/min)

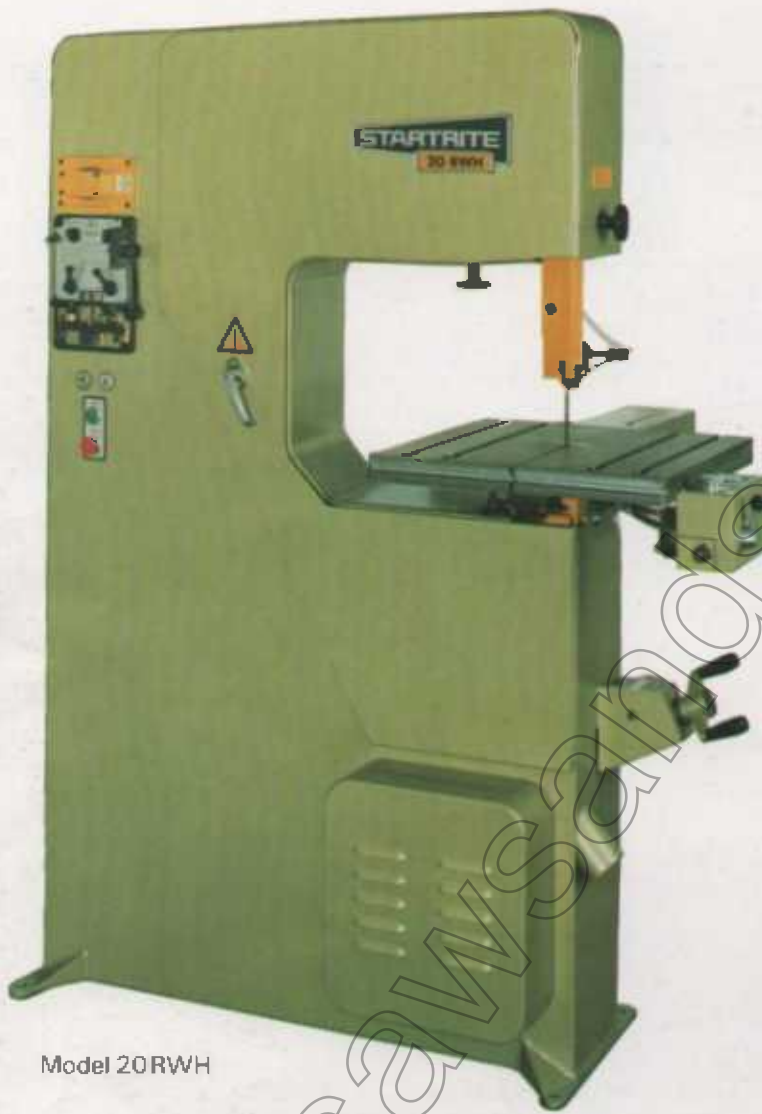
Standard Equipment includes:

- 1 1/2 h.p. (1.1 kw) T.E.F.C. 380/415 volt, 3 phase 50 hz motor.
- Magnetic motor starter push buttons and overload protection and interlocked band wheel doors.
- Two way tilt fixed table.
- Blade Tension indicator.
- Dual range totally enclosed transmission.
- 1/8 in. (16mm). capacity built-in blade welder, shear and flash grinder (V models only).
- Built-in pre-focused low voltage work light (V models only).
- Built-in air chip blower (V models only).
- Speed and blade selector dial (V models only).
- Blade guide inserts for blades 1/8 in., 1/4 in., 3/8 in. & 1/2 in. wide (3, 6, 10, 13mm).
- One hard back blade 1/2 in. (13mm) wide.
- Wrench for table trunnion.
- Wrench for guides.
- Operating and parts manual.

Further details of standard and optional equipment can be found on pages 8-11.

RAPIER

Medium duty models



Model 20RWH

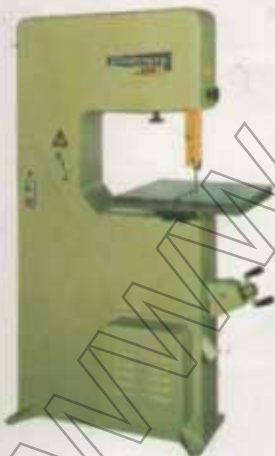
This broad range of machines offers all of the features found on the earlier pages and more.

Heavier blade tensioning and larger bandwheels allow blades up to $\frac{5}{8}$ in. (16mm) to be used.

Featured in this series is a powerful and smooth, infinitely variable blade speed, with dual range, gear transmission.

Also featured are three types of table; fixed two-way tilt, mechanical sliding (sensitive rack and pinion fed) and hydraulic sliding (hydraulic power with fully adjustable control). Both sliding tables have a 4-way tilt for extra flexibility.

Range of models includes:



Model 20RF



Model 14RWF



Model 20RWS



Model 30RWH

Specifications

MODEL	14RF	20RF	30RF	14RWF	20RWF	30RWF	14RWS	20RWS	30RWS	14RWH	20RWH	30RWH
Throat - in. (mm)	13 1/2 (340)	20 (500)	30 (760)	13 1/2 (340)	20 (500)	30 (760)	13 1/2 (340)	20 (500)	30 (760)	13 1/2 (340)	20 (500)	30 (760)
Work height under Top guide - in. (mm)	10 (250)	10 (250)	10 (250)	10 (250)	10 (250)	10 (250)	10 (250)	10 (250)	10 (250)	10 (250)	10 (250)	10 (250)
Blade width - in. (mm)	1/8 (3), 3/16 (5), 1/4 (6), 3/8 (10), 1/2 (13), 5/8 (16)											
Blade, File band, Polishing band length Over 3 wheels - in. (mm)	130 (3302)		147 (3734)		130 (3302)		147 (3734)		130 (3302)		147 (3734)	
Over 2 wheels - in. (mm)	112 (2845)		112 (2845)		112 (2845)		112 (2845)		112 (2845)		112 (2845)	
Band wheels - No. and size - in. (mm)	2 steel 14 x 1 1/2 (355 x 38)	3 steel 14 x 1 1/2 (355 x 38)		2 steel 14 x 1 1/2 (355 x 38)	3 steel 14 x 1 1/2 (355 x 38)		2 steel 14 x 1 1/2 (355 x 38)	3 steel 14 x 1 1/2 (355 x 38)		2 steel 14 x 1 1/2 (355 x 38)	3 steel 14 x 1 1/2 (355 x 38)	
Wheel tyres	Bonded rubber											
Blade guides	Insert type											
Table Type	Fixed						Sliding - Rack and Pinion			Sliding - Hydraulic		
size - in. (mm)	21 x 21/530 x 530						20 1/2 x 20 1/2 (521 x 521)			20 1/2 x 20 1/2 (521 x 521)		
tilt	2 way 45°R, 15°L						4 way 45°R, 15°L, 5°F, 5°B			4 way 45°R, 15°L, 5°F, 5°B		
T-slots	Front edge - one						Front edge - one, table top - four			Front edge - one, table top - four		
stroke - in. (mm)							8 1/2 (216)			8 1/2 (216)		
feed rate										0-36 in./min (0-889 mm/min)		
feed force - lb/kg										0-210 (0-95)		
Auxiliary table - in x in (mm x mm)			10 x 19 (250 x 480)				10 x 19 (250 x 480)				10 x 19 (250 x 480)	
Table height - in. (mm)	43 1/2 (1105)											
Drive motor (3 phase)	1 1/2 h.p. (1.1kw)											
Blade speeds infinitely variable - f.p.m. (m/min)	50-300 (15-90), 500-3000 (152-914)											
Gear transmission	2 speed - totally enclosed											
Blade welder, grinder and shear	No						Yes - built in 5/8" (16mm) capacity					
Dimensions - length - in. (mm)	31 (787)	44 (1118)	55 (1397)	42 (1067)	55 (1397)	66 (1676)	42 (1067)	55 (1397)	66 (1676)	42 (1067)	55 (1397)	66 (1676)
width - in. (mm)	22 (560)	22 (560)	22 (560)	22 (560)	22 (560)	22 (560)	25 (635)	25 (635)	25 (635)	25 (635)	25 (635)	25 (635)
height - in. (mm)	72 (1830)	72 (1830)	72 (1830)	72 (1830)	72 (1830)	72 (1830)	72 (1830)	72 (1830)	72 (1830)	72 (1830)	72 (1830)	72 (1830)
Net weight - lb (kg)	570 (260)	630 (300)	770 (350)	725 (330)	825 (375)	925 (420)	725 (330)	825 (375)	925 (420)	725 (330)	825 (375)	925 (420)
Shipping weight - lb (kg)	760 (350)	890 (400)	1000 (450)	935 (425)	1065 (485)	1175 (535)	935 (425)	1065 (485)	1175 (535)	935 (425)	1065 (485)	1175 (535)

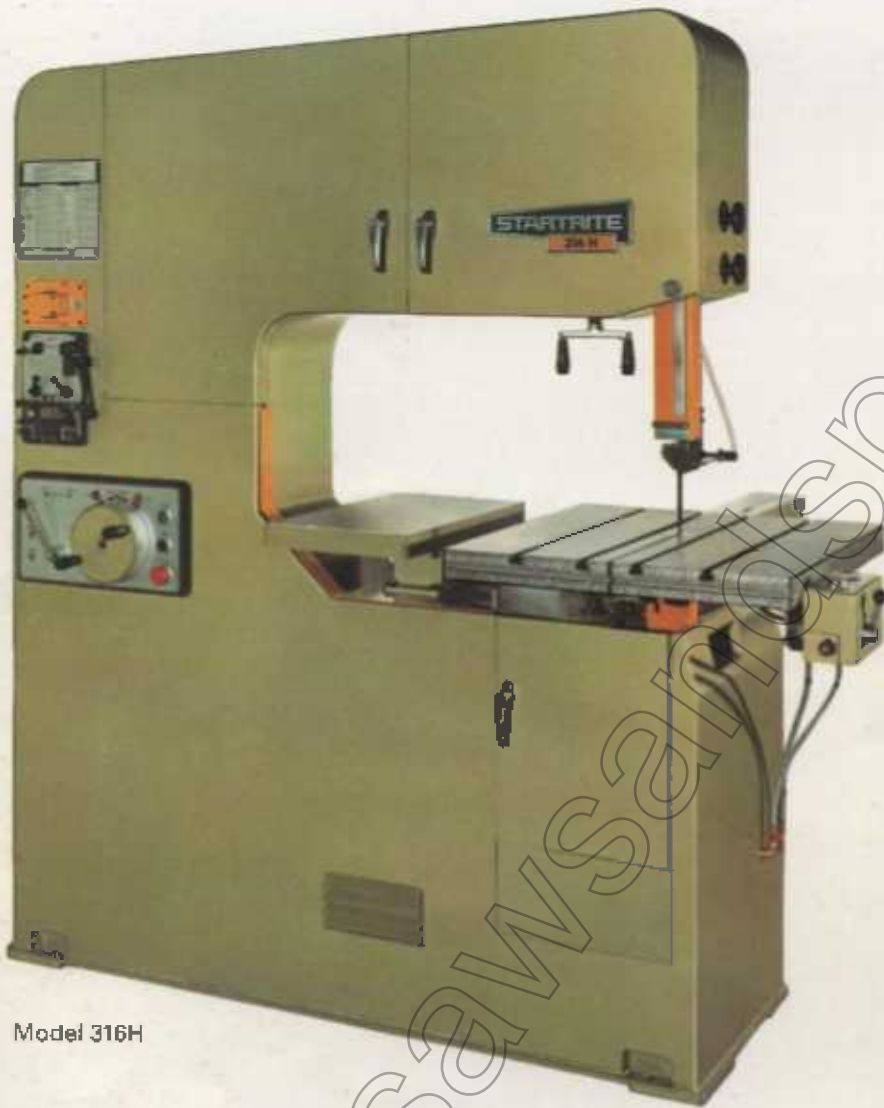
Standard Equipment includes:

- 1 1/2 h.p. (1.1kw) T.E.F.C. 380/415 volt 3 phase 50Hz motor.
- Magnetic motor starter push buttons and overload protection and interlocked bandwheel doors.
- Blade tension indicator.
- Dual range totally enclosed transmission.
- 5/8 in. (16mm) built-in blade welder, shear and flash grinder. (except RF models).
- Built-in pre-focused work light. (except RF models.)
- Built-in air chip blower. (except RF models).
- Speed and blade selector dial (except RF models).
- Blade guide inserts for blades 1/8 in. 1/4 in. 3/16 in. & 1/2 in. wide (3, 6, 10, 13, 16mm).
- One hard back blade 1/2 in. (13mm) wide.
- Wrench for table trunnion.
- Wrench for guides.
- Operating and parts manual.

Further details of standard and optional equipment can be found on pages 8-11.

SABRE

Heavy duty models



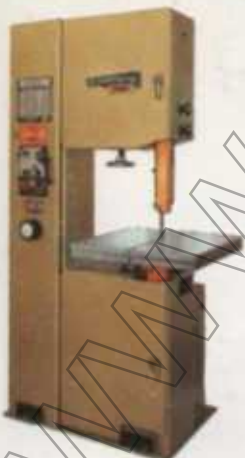
Model 316H

With a 3 h.p. (2.2kW) heavy duty drive and a 1 in. (25mm) blade almost any bandsawing job can be done on a model V500 or 316.

Fixed table models have two-way tilt and optional weight feed device with adjustable feed force up to 80lb (36kg).

Sliding table models have sensitive rack and pinion feed or, when ordered as "H" models, built-in hydraulic power feed with full controls.

Range of models



Model V500F



Model 316



Model 316H

Specifications

MODEL	V500F	316F	316	316H
Throat—in. (mm)	20 (500)	36 (915)	36 (915)	36 (915)
Work height under top guide—in. (mm)	14 (350)	14 (350)	13 (330)	13 (330)
Blade width—in. (mm)	1/8 (3) 3/16 (5) 1/4 (6) 3/8 (10) 1/2 (13) 5/8 (16) 3/4 (20) 1 (25)			
Blade, File band, Polishing band length				
—over 2 wheels—in. (mm)	159 1/2-164 (4050-4165)		135-141 (3429-3581)	
—over 3 wheels—in. (mm)			180-183 (4572-4648)	
Band wheels—size	20 1/2 (520) dia x 1 3/4 (45)		16 (400) dia x 1 1/4 (45)	
Band wheels—number	2	3	3	3
Wheel tyres	Bonded rubber			
Blade guides	Carbide insert with hardened back-up roller			
Table type	Fixed	Fixed	Sliding	Hydraulic
size—in. (mm)	24 x 24 (610 x 610)		26 x 27 3/4 (660 x 700)	
tilt	45°R 15°L		45°R 15°L 6°F 6°B	
T-slot	Front edge only		Front edge only	Front edge—one Table top—four
stroke—in. (mm)	N/A		12 (305)	12 (305)
feed rate—in. (mm)/min.	N/A		N/A	0-35 (0-890)
feed force—lb (kg)	N/A		N/A	0-210 (0-95)
Hydraulic tank capacity—gallons (litres)	N/A		N/A	2 (7.5)
Auxiliary table size—in. (mm)	N/A		13 x 22 (330 x 559)	
Table height—in. (mm)	39 (990)	41 (1041)	42 (1067)	42 (1067)
Drive motor (3 phase)	3 h.p. (2.2kW)			
Blade speed steplessly variable	50-5200 ft/min (16-1585 m/min)			
Gear transmission	2 speed—totally enclosed			
Blade welder, grinder and shear—in. (mm)	Built-in 1 (25) capacity			
Dimensions—width—in. (mm)	47 1/2 (1206)	80 (2030)	80 (2030)	80 (2030)
depth—in. (mm)	36 (915)	35 (890)	43 (1090)	43 (1090)
height—in. (mm)	82 (2080)	82 (2080)	82 (2080)	82 (2080)
Net weight—lb (kg)	1240 (562)	1680 (762)	1680 (762)	1680 (762)
Shipping weight—lb (kg)	1590 (721)	2030 (921)	2030 (921)	2030 (921)

Standard Equipment includes:

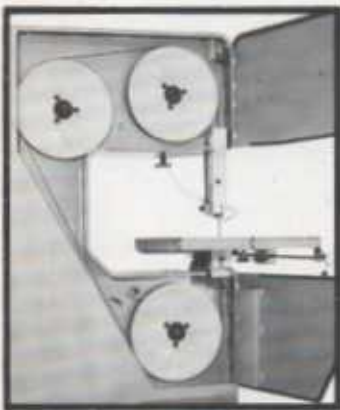
- 3 h.p. (2.2kW) T.E.C. 380/415 volt 3 phase 50Hz motor.
- Magnetic motor starters with 110 volt control circuit, push buttons and overload protection.
- Two-way tilt fixed table or Four-way tilt sliding table with T-slots.
- Blade Tension Indicator
- Dual range totally enclosed transmission.
- 1 in. (25mm) capacity built-in blade welder, shear and flash grinder.
- Built in air chip blower.
- 4 sets carbide insert guides for blades 3/16 in. 1/2 in. 3/8 in. & 1/4 in. wide (10, 13, 16, 20mm).
- One hard-back blade 3/4 in. (20mm) wide
- Wrench for table trunnion.
- Operating and parts manual.

Further details of standard and optional equipment can be found on pages 8-11.

Standard features and optional equipment

Construction

Rigid box frame welded construction of heavy plate ensures maximum stability for all sawing applications. Bandwheels and pulleys are dynamically balanced for exceptionally quiet and smooth operation. Table trunnions are heavy duty and made of durable meehanite cast iron. All moving parts are fully guarded, and a telescopic blade guard allows only the actual cutting area of the blade to be exposed. The baked on enamel finish and clean design make the Startrite vertical bandsaw a pleasant and durable addition to any shop.



Bandwheels

Heavy duty bandwheels are high speed dynamically balanced and ride on sealed for life bearings, ensuring vibration free operation. Bandwheels are interchangeable on each machine and are easily replaced.



Blade tension

Correct blade tension may be quickly applied and accurately checked through the indicator window.



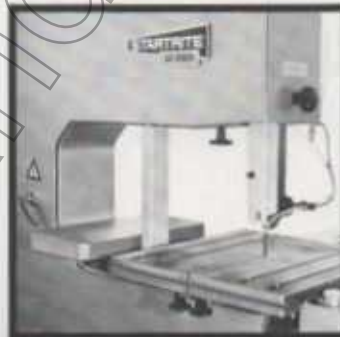
Trunnion

Heavy duty precision trunnions are constructed of rugged meehanite cast iron and are fitted with calibrated scales to indicate the degree of tilt.



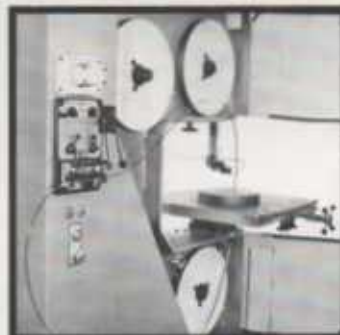
Electrical controls

Easily accessible, all panels include: magnetic motor starters, motor overloads, and circuit breakers. Each panel is neatly wired for easy identification.



Two wheel operation

All 30in and 36in machines are equipped with an auxiliary blade guard, enabling the machines to be used with two bandwheels only. This enables substantial savings when band filing.



Blade welder

On designated models a in blade welder, flash grinder, shear and gauge for checking the finished weld are standard. Free standing units are also available for machines not carrying these as standard equipment.





Chip disposal

Heavy duty models are equipped with the chip drawer as illustrated. All other models discharge chips through a built-in chip chute.



Air chip blower

Built-in air system allows the cutting area to remain free of chips. Standard on most models.



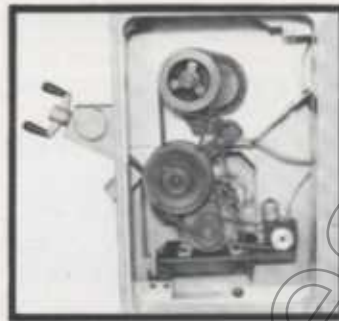
Prefocused work light

Illuminates the exact sawing area. Standard on many models.



Light duty drive

Consists of 1/2 h.p. (1.1kw) motor, cast iron dynamically balanced five step pulleys, and dual range totally enclosed gear transmission providing smooth, efficient power transmission to the blade. (Air chip blower also shown).



Medium duty drive

Features infinitely variable blade speed selection from 1/2 h.p. (1.1kw) motor and dual range totally enclosed gear transmission.



Heavy duty drive

A powerful 3 h.p. drive with dual range gearbox and infinitely variable blade speeds provides smooth and easy sawing of most materials.



Control panel

(Heavy duty model). Locates all controls for convenient operation, exclusive, "DIAL-IN JOB CONTROLLER" automatically selects correct blade speed for the material to be cut. Just "DIAL IT IN."



Blade and speed selector.

Standard on most models, this easy to read reference enables the operator to choose the proper blade and speed.



Blade guides

Replaceable Guide inserts are standard on all models, and the upper guide elevation adjustment is made easy with counterbalance construction. Quick change inserts are available for any size blade. Various other guide types are available for special applications. Guides for heavy duty models differ from those illustrated, having carbide sideguides and a hardened backup thrust roller.

Standard features and optional equipment



Roller guides

Side and backup rollers allow frictionless sawing, especially useful for high-speed applications.



Universal guides

Carbide side guides with roller back-up will adjust to any blade width or thickness.



Angled guides

By introducing a twist in the blade, these guides allow the sawing of long stock lengths.



Mechanical sliding tables

(Models 216, 316 and 'RWS'). Exclusive rack and pinion feed provides easy and sensitive control. Workpieces are clamped to table via 'T' slots and table is then fed through the blade. Work stops are also provided.



Hydraulic sliding table

All models carrying 'H' designation have a built-in hydraulic system which allows the workpiece to be clamped to the table 'T' slots while the entire table is fed through the blade. Adjustable speed feed 0-35 i.p.m. (0-890mm/min) and feed force 0-210lb (0-95kg) allow precise control of cut, and rapid traverse and adjustable stops allow quick, efficient set-up and operation.



Rip fence

Attaches to front table 'T' slot and is equipped with lateral fine adjustment, allowing straight and accurate cuts.



Mitre gauge with pusher

Attaches to front 'T' slot of Fixed table for precision mitre cuts.



Mitre gauge

Attaches to front 'T' slot of Sliding table for precision mitre cuts.



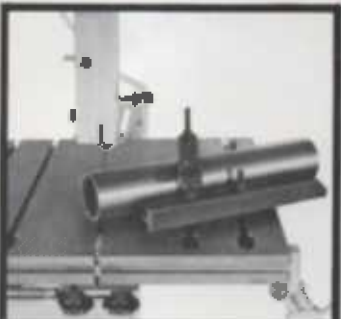
Rack and pinion pusher

Attaches to front 'T' slot of fixed tables for precision mitre or straight cuts with mechanical feed.



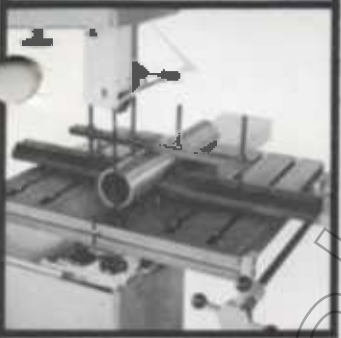
Circle cutting attachment

Assists the accurate sawing of discs.



Universal work holder

Used only with sliding tables, a multitude of sizes and shapes may be held while sawing.



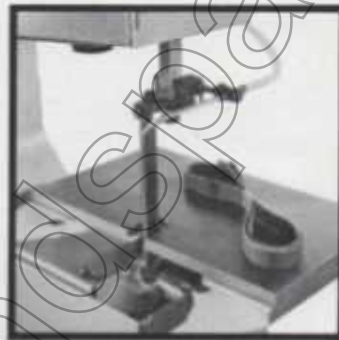
Contouring work holder

For contouring work on any sliding table.



Band filing attachment

Simply replacing the standard guides allows power filing. File bands are available flat or oval, $\frac{1}{8}$ in (6mm), $\frac{3}{16}$ in (10mm) or $\frac{1}{4}$ in (13mm) wide.



Band polishing attachment

Simply replacing the standard guides allows powered polishing with lin. (25mm) wide bands.



Gravity feed spray mist coolant

Adjustable nozzle and metering valve allows the correct amount of coolant to be directed as required. (Requires Air Chip Blower).

STARTRITE®

The twenty metal cutting bandsaws illustrated in this catalogue provide a range of models to cover almost any requirement from jobbing to production, training to toolmaking or maintenance to model making. The extensive range of optional equipment ensures that your Startrite bandsawing machine can be utilised to its full cost saving potential.

Advice on selection of the best machine, equipment and blades for your application is available from your local Startrite sawing specialist or merchant stockist.



Model H250A

The Startrite range also includes manually operated and fully automatic high performance cut-off saws for material up to 660mm (26in.) diameter or square. Please ask for separate literature.

STARTRITE
MACHINE TOOL CO. LTD.

600®
Catalogue V-82