Please ensure that this manual is handed to the operator before using the machine for the first time. The operator must fully understand the contents of this manual before using this machine. (If the machine is resold the Manual must be given to the new owner.)

Important Note

The information contained in this manual is correct at the time of publication. However, in the course of constant development, changes in specification are inevitable. Should you find the information given in this book different to the Machine it relates to please contact the “After Sales Department” for advice.

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We, Spearhead Machinery Ltd, Green View, Salford Priors, Evesham, Worcestershire, WR11 8SW declare under our sole responsibility that the:

Product

Product Code

Serial No

Flail Head Serial No

Type


Signed.................................................................(On behalf of Spearhead Machinery Ltd)

Status          General Manager

Date..........................
Important

Safety

- Never operate the machine with other people present, as it is possible for debris, including stones, to be discharged from the front and rear of the flail hood.
- Always ensure all cab safety guards are in place and all tractor windows closed.
- Never allow an inexperienced person to operate the machine without supervision.
- Never allow children to play on or around the machine at any time.
- Never attempt any maintenance or adjustment without first disengaging the PTO, lowering to the ground, stopping the tractor engine and applying the tractor parking brake.
- Before leaving the tractor cab always ensure that the machine is firmly on the ground, and the rotors have stopped spinning
- Never stop the engine with the PTO engaged.
- Always check that all guards are properly fitted, check there is no damaged or loose parts. Particular attention should be given to the blades to ensure they are not damaged, cracked or missing.
- Never operate with blades missing.
- Always operate PTO at recommended speed 1000 RPM as indicated on the sticker.
- Always inspect work area for wire, steel posts, large stones and other dangerous materials and remove before starting work.
- Never operate with wire around rotors. Stop immediately.
- Never attempt to use the machine for any purpose other than that it was designed for.
- Ensure that all warning labels are always visible and that they are not damaged, defaced or missing.
- Never transport with the PTO engaged.
- When parking up always lower to the ground
Safety

Warning
Stay clear of mower blade as long as engine is running.

Warning
Danger – flying objects keep safe distance from the machine as long as the engine is running.

Warning
Shut off engine and remove key before performing maintenance or repair work.

Warning
Check all nuts are tight every 8 hours.

Warning
Carefully read operator’s manual before handling this machine. Observe instructions and safety rules when operating.
Introduction

The Spearhead Star-Cut 300 is a very robust high capacity Rotary Cutter that is easy to operate and maintain, but to ensure trouble-free operation this manual should be carefully studied.

Safety First

Do not start the machine until you fully understand operation and safety precaution requirements. Always ensure the operators are proficient with the operation of this type of this machine.

Tractor Requirements

- Spearhead strongly recommends 75hp-plus tractor with CATEGORY 2 rear linkage.
- Ensure there is sufficient weight on front wheels of the tractor for safe transport and stability.
- PTO must be independent live drive to enable continuous PTO drive even when tractor clutch is pressed down.
- Before hitching, ensure position control is selected. Do not attempt to hitch in draft control.
- Check chains and stabilizers must be in good working order to hold the machine firmly. Do not operate without checking that chains and stabilizers are tight.
- Spearhead particularly recommend ‘turn buckle’ type check chains
- Set linkage lift rods to an equal length.
### Specification

<table>
<thead>
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<th>Description</th>
<th>Value</th>
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<tbody>
<tr>
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<td>PTO speed</td>
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<td>Input clutch</td>
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<tr>
<td>Tractor minimum power requirement</td>
<td>70hp</td>
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</table>
**Attaching To The Tractor**

Fit the machine to the tractor linkage in the standard way, ensuring the correct match of linkage (CAT 2 pins). Check that the top link is in good order and threads are well lubricated. Use stabilisers to take any free movement out of lower link arms.

Before fitting the machine to the tractor linkage you should ensure there is sufficient front weight to ensure the front wheels are always in contact with the ground. This is most important for safe transport and stability when turning on slopes.

Before fitting the PTO for the first time, it may be necessary to adjust the length. There should be maximum engagement of the sliding tubes without bottoming at the shortest operation position. To check, first connect the mower to the tractor. Pull the PTO shaft apart and connect to the tractor PTO output shaft and the gearbox input shaft. Hold the half shafts next to each other in the shortest working position.

If necessary, shorten the inner and outer guard tubes equally (Fig. 2). Shorten the inner and outer sliding profiles by the same length as the guard tubes. File all sharp edges and remove burrs. Grease sliding profiles.

To fit the PTO to the machine, first remove bolt or tapered pin from the slip clutch yoke and push onto splined shaft of gearbox ensuring it is fully engaged before refitting retaining bolt/pin.

To fit the PTO, first clean and grease press pins on the yoke and simultaneously push the PTO drive shaft onto PTO shaft of the tractor until pins engage.

The PTO shaft is fitted with a non-rotating safety guard. It should be secured to the machine and tractor with the two retaining chains provided.
Setting Up & Adjustment

Height

Cutting height adjustment is achieved by raising or lowering the wheels. Lowering the wheels produces a longer cut, raising the wheels leaves a shorter cut. Always set machine level front to rear and side to side.

The weight of the machine should be equally distributed between the tractor and the wheels. When set properly this should prevent scalping.

Lengthen top link to ensure cables are slack, this will allow machine to float over ground contours.

Raise tractor lower links to set the front of mower level or above.

Adjust rear wheels to set cutting height ensure skids are above the ground.
**Machine Protection**

To prevent gearbox damage the input PTO is fitted with an automatic knocking clutch. When cutting in extreme conditions where solid objects are likely to be found it is recommended the operator reduces the engine revs to allow the blades to pivot more easily when striking solid objects, and proceed with caution.

The wing rotor gearboxes are fitted with friction type torque limiters, the clutch settings should not be altered without reference to the Spearhead Service Department. Never operate without protection, this could result in severe damage to the gearbox and drive lines, as well as infringing the warranty.

The centre rotor gearbox is fitted with an elastic coupling to cushion any shock loads from the rotor and is non adjustable.

**Safety Break Away**

Blade carrier angle ensures blades move up and away from obstacles and also minimises stone throw even when cutting at ground level.
**Operation**

Engage the PTO only when the tractor engine is at low revs to prevent shock damage to the machine, slowly increase the engine revs to achieve the standard 1000 PTO speed. (As indicated on the sticker).

If at any time serious vibration occurs, stop the engine immediately and check that no blades are missing - following all safety precautions. The cause must be found and rectified immediately or other components may be affected.

When in work, lower the machine to the ground carrying its weight on the wheels, allowing the machine to follow the contours of the ground and ensuring there is sufficient slack in the wire rope. Select a sensible forward speed bearing in mind the density of growth, the terrain, and the available horsepower, taking extra care when turning, particularly on slopes. When turning, it is not necessary to lift the machine off the ground but instead allow sufficient room to turn in a large radius. The machine only needs to be raised when turning in a tight corner or reversing over dense undergrowth or when operating on the front linkage. The machine is fitted with, as standard, 4 high lift blades complete with fin, to aid spreading/mulching.

Quality of finish is determined by the forward speed i.e. a slow speed will produce a high quality of cut, whereas faster forward speeds are used when high output is first priority.

When operating, particularly in confined areas, it is possible to cut going backwards but it is advisable to slightly raise the machine, particularly if in dense growth where there is a risk of hitting hidden solid obstacles obscured by dense undergrowth.

Always exercise particular care when operating over uneven ground surfaces. Do not allow the blades and blade holders to frequently hit the ground.

**Transportation**

Please observe Public Highway Regulations concerning the towing of implements, and securely attach a registration and lighting board. Take care to slow when travelling over rough ground and avoid bouncing machine on linkage causing unnecessary strain.

Maximum speed with a mounted implement is 20mph (30 km/h)
Service & Maintenance

Safety First

- Never leave the tractor seat without first disengaging the PTO and stopping the engine.
- Ensure all rotating parts have stopped turning.
- Never attempt any repairs, maintenance, service or any other checks with the machine carried on the tractor hydraulics.
- Always fully lower to the ground, or securely prop the machine on substantial servicing stands.
- Always replace all guards and retaining chains after servicing/maintenance is completed.

Important

On delivery of your machine check that the dealer has completed the P.D.I. form ensure the warranty registration form is completed and returned.

It is imperative that the following checks are carried out in order not to invalidate your warranty; these are carried out before the first operation, after the first hour, then after 4 hours. These checks are:

- Wheel nuts and tyre pressure (50psi)
- Gearbox bolts are fully tightened
- Blade bolts are fully tightened and in particular the castle headed nut on the blade rotor
- Retaining bolts on the drive shaft
- Grease all points
- The gearbox oil level, top up with EP90 Gear oil if required
- It is your responsibility to maintain, to ensure a long reliable working life

Torque Settings

The Torque figures given below are recommended maximum settings only.

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<tr>
<th>Size:</th>
<th>Tensile strength:</th>
<th>Description:</th>
<th>Torque setting: Nm</th>
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<tr>
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<td>8.8</td>
<td>Gearbox bolts</td>
<td>280</td>
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<tr>
<td>M16</td>
<td>8.8</td>
<td>Blade carriers</td>
<td>280</td>
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<td>M20</td>
<td>8.8</td>
<td>Blade bolts</td>
<td>425</td>
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<tr>
<td>M24</td>
<td>8.8</td>
<td>Blade bolts</td>
<td>950</td>
</tr>
</tbody>
</table>
Daily / Every 8 hours

- Grease all grease points, on PTO, including secondary drive line under the center guard.
- Check condition of blades and blade bushes and ensure all retaining bolts are fully tight.
- Check gearbox oil, replenish with ‘EP90’ gear oil as necessary to the correct level line on the dipstick provided with each gearbox.
- Dismantle and clean PTO sliding surfaces and re-grease. Grease universal joints (Fig. 3).

Every 16 hours

- Grease PTO inner tube and push pins (Fig. 3)

Regularly

- Check there is no wrapping of string, plastic, grass or other debris between rotor boss and blades.
- Inspect gearbox seals for leaks.
- Regularly check the rotor boss retaining castle nut for tightness. First remove the split pin, select the correct size socket in 3/4” drive and fully tighten the nut. When replacing the split pin, do not slacken the nut to align the hole, always tighten. Failure to regularly check this nut will result in serious wear to hub, which is expensive to repair.
- It is most important that all gearbox and blade bolts are regularly checked to be very tight. When the machine is new there will be a ‘bedding in’ period where very frequent checking is important.
Blades

Caution! When carrying out maintenance work on or near the blades be careful of free-swinging blades over-centring and falling. It is recommended that protective headgear, gloves and goggles are worn.

The blades can be re-sharpened by grinding the cutting edges and care must be taken that the blades are of the same weight and length after grinding. Do not over heat when grinding, as this will affect the hardness of the blades.

All the blades are free swinging and swivel on hardened steel bushes, which are easily replaced. When replacing blades, it is important that blades are replaced in sets, in order to retain balance of the rotor. Bushes must be replaced when new blades are to be fitted.

If the blades are showing any signs of severe wear, damage or cracking, they must be replaced immediately. Never attempt to weld the blades; this will make them very brittle thus extremely dangerous.

Do not take risks with the cutting blades - if in doubt, replace.
**Skids**

When operating on abrasive soils, particularly in stubbles and similar conditions with thin ground cover, excessive skid wear may be expected. To provide extra protection and to prolong life of the skids, special hard facing rods are available.

If working in wet and muddy conditions, ensure that debris is not allowed to build up on the deck.

**Storage**

Before storing away, thoroughly wash the machine removing all traces of grass and dirt. Great care must be taken when washing with high-pressure hoses, do not hold the water jet close to the paintwork. Use steam cleaners with caution, be sure to remove all detergents to avoid any discolouring or damage to paint.

Grease all grease points until fresh grease shows. Store PTO shaft in a dry place.

**After Storage**

Check condition of the tyre (where applicable) and then follow the maintenance procedure covered in the servicing part of this manual. Pay particular attention to the condition of guards and blades.

Remember the 300 Star-Cut is designed to withstand the most rigorous conditions and, with a little care and attention, will give many years of trouble free service.

So as not to invalidate the warranty and to avoid problems, use only genuine parts and make sure the machine is not driven at a speed in excess of 1000 rpm on the PTO. As indicated on the speed sticker.
Clutch Maintenance & Settings

Check the condition of the friction discs before use and following periods of storage. Release the tension from the spring, turn the clutch while holding the P.T.O to ensure hub is not seized to linings, before placing the machine in work. Your machine may have either a slip clutch with 8 coil springs as (fig 2b) or a diaphragm spring as (fig 2).

<table>
<thead>
<tr>
<th>Fig. No.</th>
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<th>Part No.</th>
<th>Setting (H)</th>
</tr>
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<tbody>
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<td>2b</td>
<td>Wing</td>
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</table>

Warning

The slip clutch is there to protect the gearbox. If the blades strike a large obstacle they may get damaged or break - avoid these conditions.

<table>
<thead>
<tr>
<th>Fig. No.</th>
<th>Position</th>
<th>Part No.</th>
<th>Setting</th>
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<td>2</td>
<td>Wing</td>
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<td>18.5 mm</td>
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</tbody>
</table>
**Trouble Shooting Guide**

**Broken or Damaged Blades**
- Raise cutting height
- Avoid obstacles
- Ensure a steady feed into drive (do not snatch the PTO)

**Damage Blade Holders**
- Raise cutting height
- Avoid obstacles
- Failure to keep retaining nuts and bolts tight

**Gearbox Overheating**
- Incorrect oil level
- Incorrect grade of oil
- Incorrect operating speed
- Machine overloaded
- Rubbish around the gearbox reducing air circulation

**Slip Clutch Failure**
- Machine overloaded
- PTO engaged with too much power/revs
- Blades hitting the ground

**Damage to Rubber Coupling**
- Shock loading from either poor start-up or blades hitting something

**Damage to PTO Shaft & Gearboxes**
- Inoperative torque limiter
- Seized slip clutch
- Telescopic tube bottoming out
- Engaging drive with too much power/revs
- Lifting machine too high
- Not enough overlap
- Lack of grease on sliding tubes of drive shaft
- Shock loading as a result of impact damage due to the blade carrier striking an obstacle.

**Metal Fatigue on Frame**
- Too fast a travelling or operating speed for the conditions
- Machine not floating, i.e. not following the ground controls (check position of top link).
Warranty

Spearhead warrants that the Spearhead machine referred to in the Warranty Registration Form will be free from defects in materials and workmanship for a period of 12 months from the date of sale. This warranty does not affect your statutory rights, but merely adds to them. Should you have a problem within 12 months from the date of sale please contact your original Spearhead dealer, or Spearhead’s Service Department. Any part found to be defective during this period would be replaced or repaired, at Spearhead’s discretion, by the dealer or a Spearhead Service Engineer.

Warranty Conditions

1. The Warranty Registration Form must be completed and returned to Spearhead within 30 days of the date of sale.

2. This warranty does not cover defects arising from fair wear and tear, willful damage, negligence, misuse, abnormal working conditions, use in competition, failure to follow Spearhead’s instructions (oral or written, including all instructions and recommendation made in the Operator’s Manual) or alteration or repair of the machinery without Spearhead’s approval.

3. The machinery must have been serviced in accordance with the Operator’s Manual.

4. This warranty does not cover claims in respect of wearing parts such as blades, flails, paintwork, tyres, belts, hydraulic hoses, bearings, bushes, linkage pins, top links, ball ends unless there is a manufacturing or material defect or the cost of normal servicing items such as oils and lubricants.

5. This warranty does not cover any expenses or losses incurred whilst the machinery is out of use for warranty repairs or parts replacement.

6. This warranty does not extend to parts, materials or equipment not manufactured by Spearhead, for which the Buyer shall only be entitled to the benefit of any such warranty or guarantee given by the manufacturer to Spearhead. Only genuine Spearhead replacement parts will be allowable for warranty claims.

7. All parts replaced by Spearhead under warranty become the property of Spearhead and must be returned to Spearhead if Spearhead so request. Such parts may only be disposed of after a warranty claim has been accepted and processed by Spearhead.

8. Spearhead is not liable under this warranty for any repairs carried out without Spearhead’s written consent or without Spearhead being afforded a reasonable opportunity to inspect the machinery the subject of the warranty claim. Spearhead’s written consent must, therefore, be obtained before any repairs are carried out or parts replaced. Use of non-Spearhead parts automatically invalidates the Spearhead Warranty. Failed components must not be dismantled except as specifically authorised by Spearhead and dismantling of any components without authorisation from Spearhead will invalidate this warranty.

9. All warranty claims must be submitted to Spearhead on Spearhead Warranty Claim Forms within 30 days of completion of warranty work.

Using the machine implies the knowledge and acceptance of these instructions and the limitations contained in this Manual.
**Extended Warranty**

As an extension to the 12-month warranty set out above, Spearhead will provide an additional 12 month warranty cover subject to the Spearhead Warranty Conditions above and the Extended Warranty Conditions below.

**Extended Warranty Conditions**

1. The extended warranty applies to gearboxes only. It does not apply to other parts, to consumables such as lubricants, seals or labour charges.

2. The machinery must have had an annual service carried out by an Authorised Spearhead Dealer or a Spearhead Service Engineer within 1 month of the first anniversary of the date of sale.

3. The extended warranty does not cover costs of transportation of the machinery to or from the dealer or Spearhead or the call out costs or traveling expenses of on-site visits.

**Transfer of Warranty**

The Spearhead warranty may be transferred to a subsequent owner of the machinery (for use within the UK) for the balance of the warranty period subject to all of the warranty conditions and provided that the Change of Owner form is completed and sent to Spearhead within 14 days of change of ownership.

Spearhead reserves the right to make alterations and improvements to any machinery without notification and without obligation to do so.
Spearhead STARCUT 300

Spearhead

Starcut 300

Parts Book

1st Edition – July 2010

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Fax: 01789 778683
www.spearheadmachinery.com
rthompson@spearheadmachinery.com
When ordering parts please refer to your parts list to help your dealer with your order.

- Part number and quantity
- Description
- Machine model number
- Serial number of the machine
- Delivery instructions (e.g. next day).

Delivery is normally via carrier direct to your dealer. Please check with your dealer for stock availability and arrangement of dispatch. Ensure you or your dealer has sufficient cover for parts requirement outside factory hours.

When ordering your gearbox parts please quote both codes stamped on the gearbox housing.

**Important Note**

The information contained in this manual is correct at the time of publication. However, in the course of constant development, changes in specification are inevitable. Should you find the information given in this book different to the machine it relates to, please contact the “After Sales Department” for advise.

**Key:**

- (LH) = Left hand
- (RH) = Right hand
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<thead>
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