

November 12, 2014



F107/9

OPTIONAL EQUIPMENT CATALOG



MANUFACTURED BY:

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NOTE: WHEN ORDERING REPLACEMENT PARTS,
PLEASE GIVE THE MODEL AND SERIAL NUMBER.
SEND DIGITAL PHOTO OF PART TO EXPIDITE ORDER.
ORDER BY PART NUMBER.

THERE IS A MINIMUM ORDER OF \$25.00

F107/9 Options & Accessories Catalog

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Optional Equipment

6761 Factory Supplied Transformer Package

For Voltage Above or Below 208-240 Volts - Customer to Specify Electrical Supply When Placing Order
Contact your Rottler representative or the factory concerning this option.

Conversational Touch Screen Software Packages

For Programmable Automated Engine Rebuilding Machine Work
Contact your Rottler representative or the factory concerning this option.

9040 Boring and Sleeving Software

Including: (1) Circular Interpolation Counterbore Finishing for Corner Radius Undercut and Facing Very Wide Counterbores (2) Lower Offset for Boring Larger Diameters Commonly Found When Resleeving Lower Seal Areas of Wet Liner

Contact your Rottler representative or the factory concerning this option.

9041 Surfacing Software

Including Multiple Pass Programmable Depth of Cuts Including Different Settings for Rough and Finish Milling/Surfacing

Contact your Rottler representative or the factory concerning this option.

9042 Line Boring Software

Including Circular Interpolation for Thrust Facing
Contact your Rottler representative or the factory concerning this option.

9046 Lifter Bore Machining Software

Contact your Rottler representative or the factory concerning this option.

9044 Connecting Rod Boring Software

Contact your Rottler representative or the factory concerning this option.

CAD/CAM (Computer Aided Design and Manufacturing) Software

9043 Rottler Direct Motion CAD/CAM Software Package.

Contact your Rottler representative or the factory concerning this option.

Wireless Probing System for Automatic Centering and Measuring

650-3-59X Renishaw Wireless Radio Probing System

Including a selection of (6) probes/stylus and Software for (1) Automatic Centering in Cylinder Bores (2) Measuring Cylinder Bore Diameters.

Price Includes Factory Installation During Machine Manufacture, Extra Charge Applies for Field Fitment.



Suggested Hold Down Anchor System

9203G Hold Down Anchor Kit

For F100 Machine Installation. Includes injection adhesive system for threaded rod applications in concrete, adhesive dispenser, mixer, anchor rods, and blow out pump.

Note: Hammer Drill Bit and Hammer Drill are not included

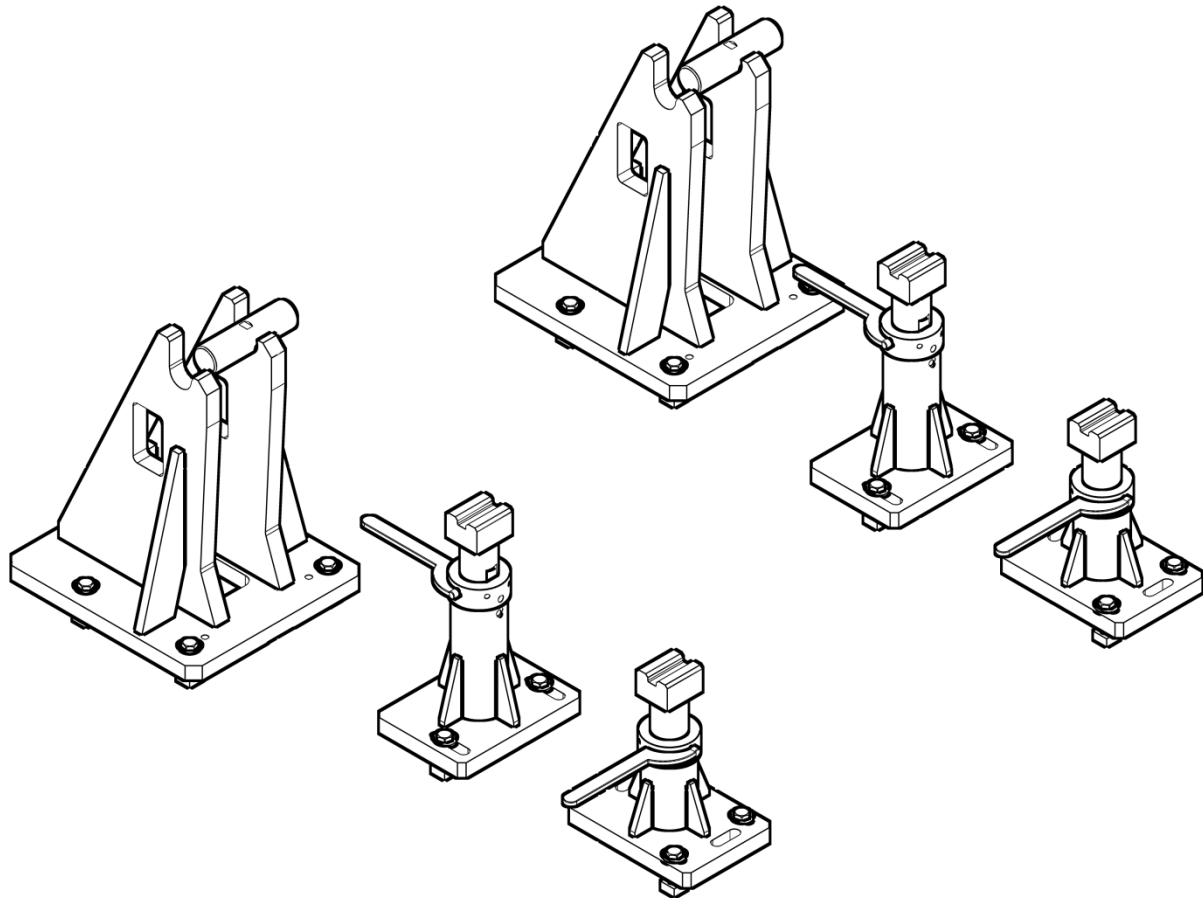


Optional Equipment for Boring and Surfacing

Fixturing for Extra Large In-Line and V Blocks

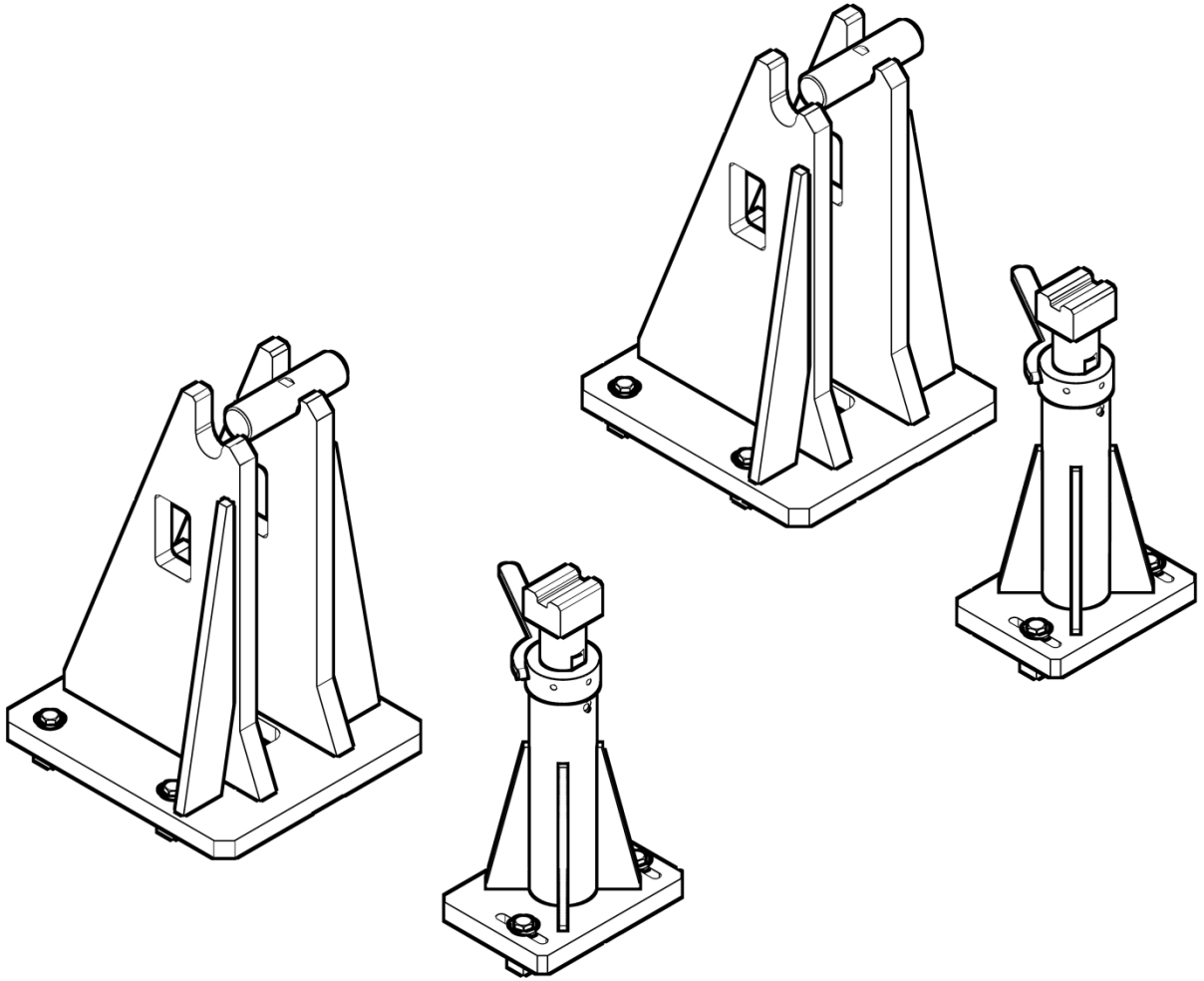
10100 Fixture

For Upper End Machining - Boring and Surfacing of V blocks such as CAT 3600 and Superior 2400. Centerline to deck dimension is 24.65" (626mm) Saddle pin diameter is 2.5" (63.5mm) Main Line Locators must be ordered separately



10100A Fixture

For Upper End Machining - Boring and Surfacing of V blocks such as Waukesha AT. Centerline to deck dimension is 29.28" (743.7mm) Saddle pin diameter is 2.5" (63.5mm) Main Line Locators must be ordered separately

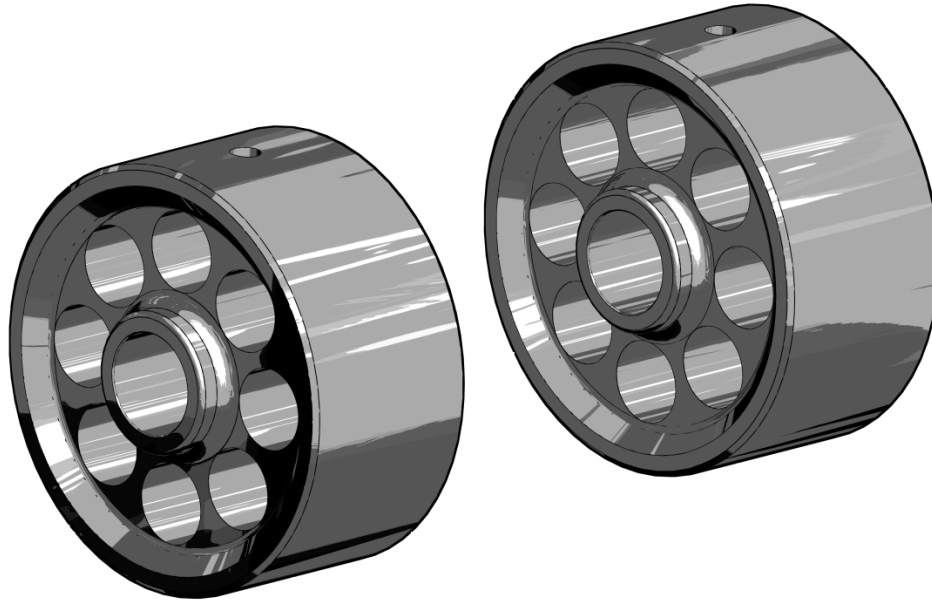


Main Bearing Bore Locator Sets

For 10100 & 10100A Block Fixture. (If Customer Requires Size Other than Available from Stock, Rottler will Manufacture the Required Size.) Customer Must Provide the Size, Including Tolerance of the Main Bearing Bore.

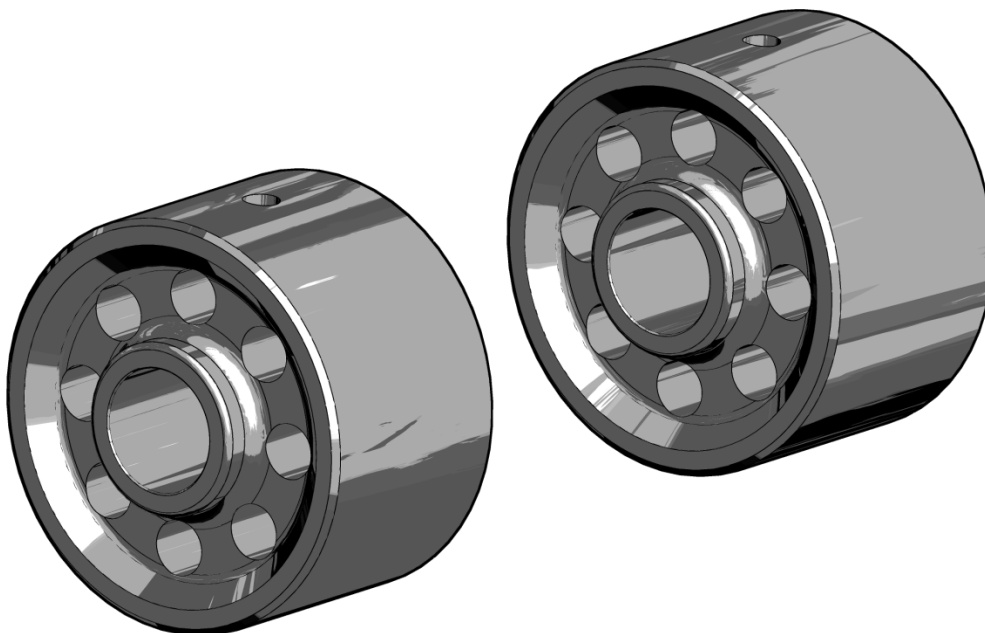
10102A Main Line Locators

For CAT 3600

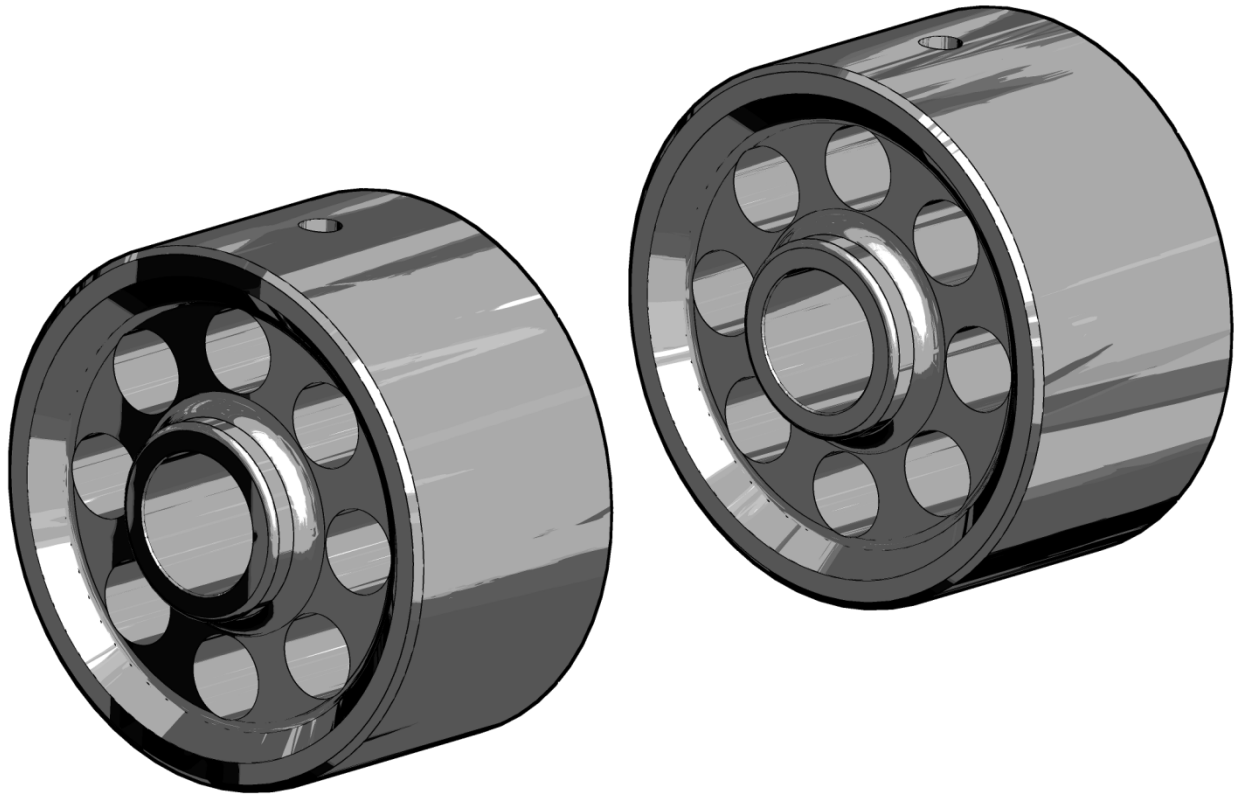


10102C Main Line Locators

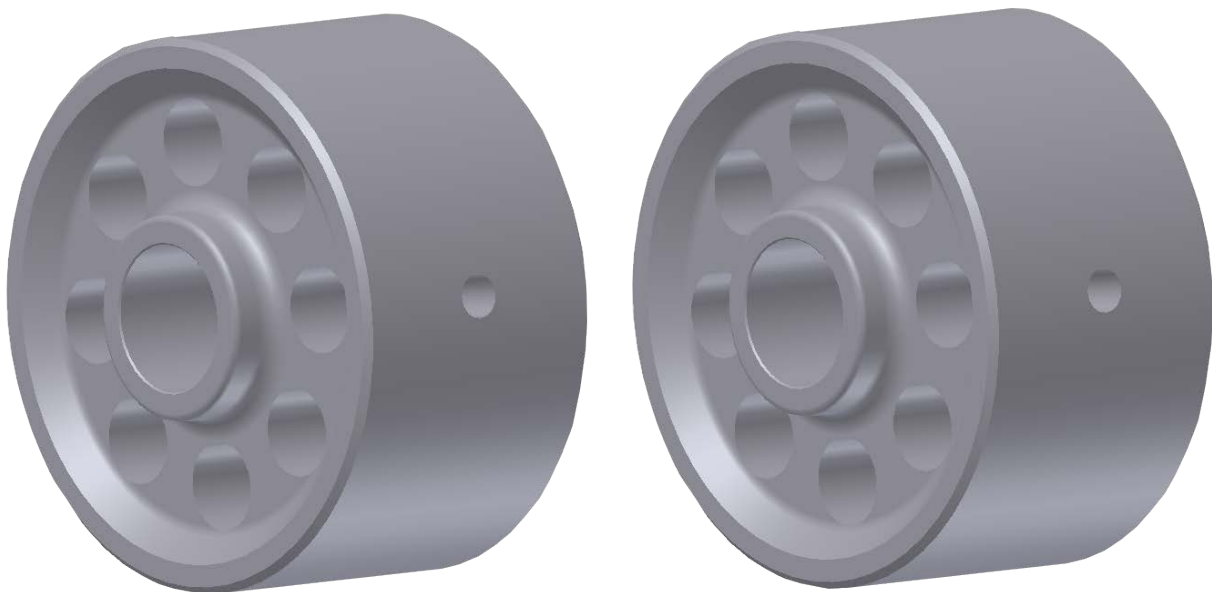
For Superior 2400



10102E Main Line Locators
For Waukesha AT

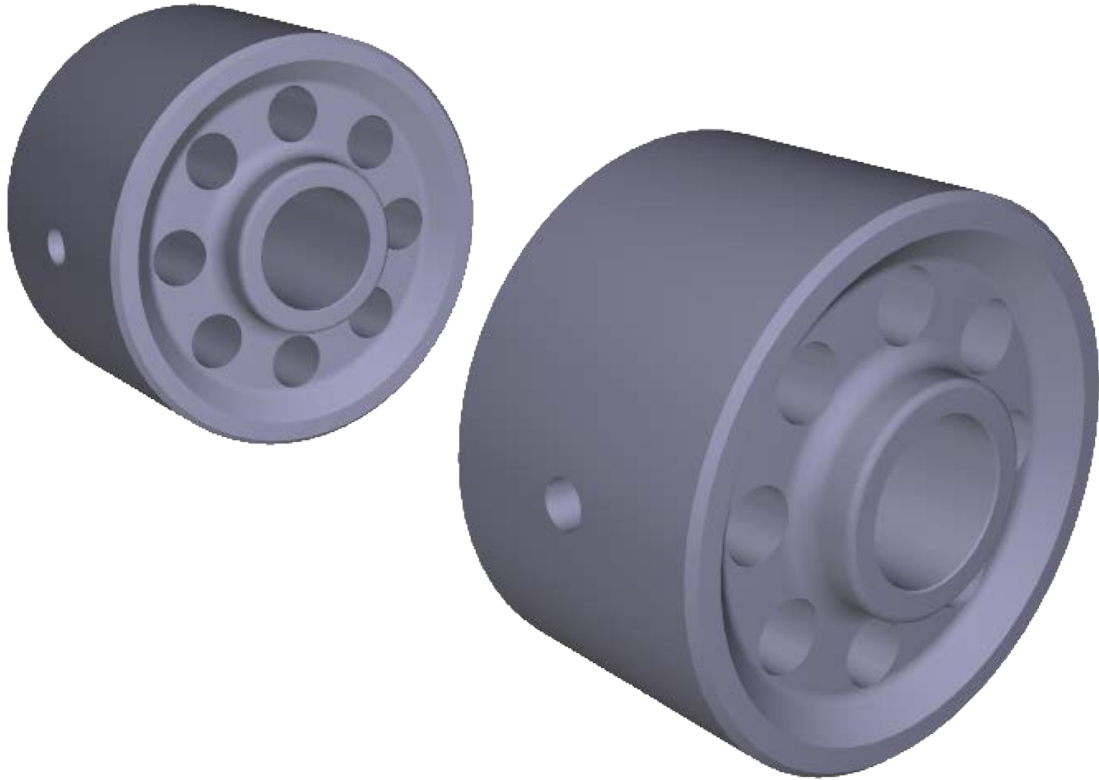


10102G Main Line Locator Assembly
For Locomotive EMD Block

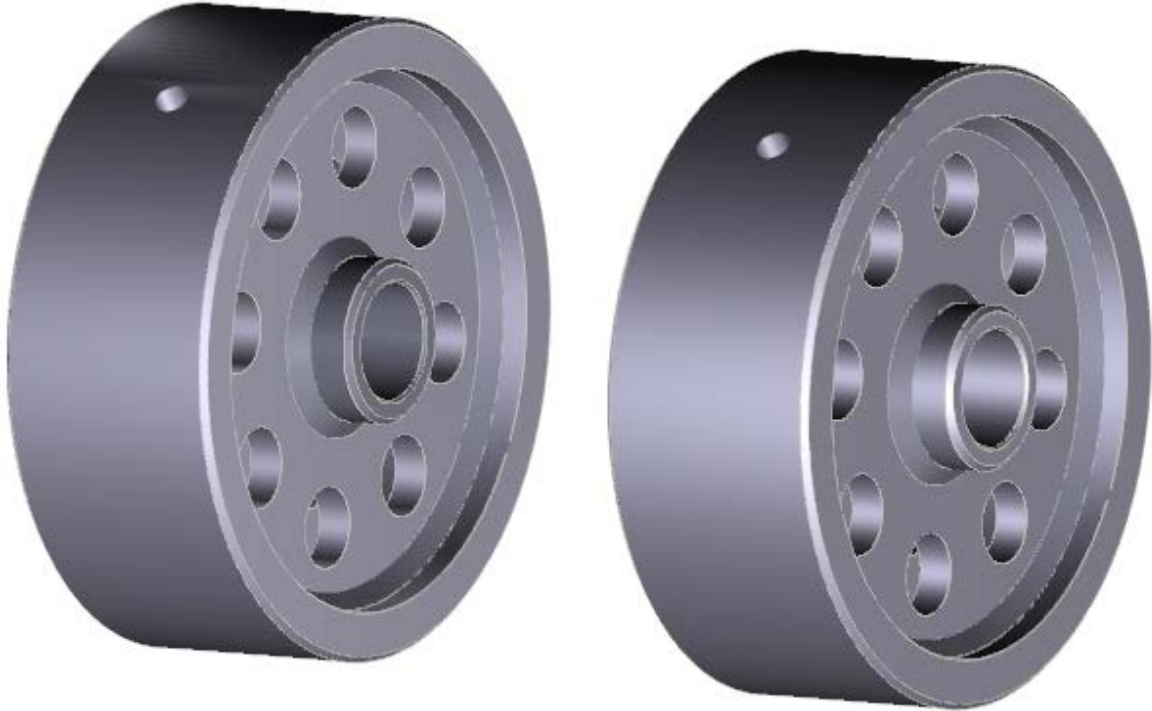




10102L Main Line Locator Assembly
For MTU 1163



10102N **Main Line Locators**
For MTU 8000

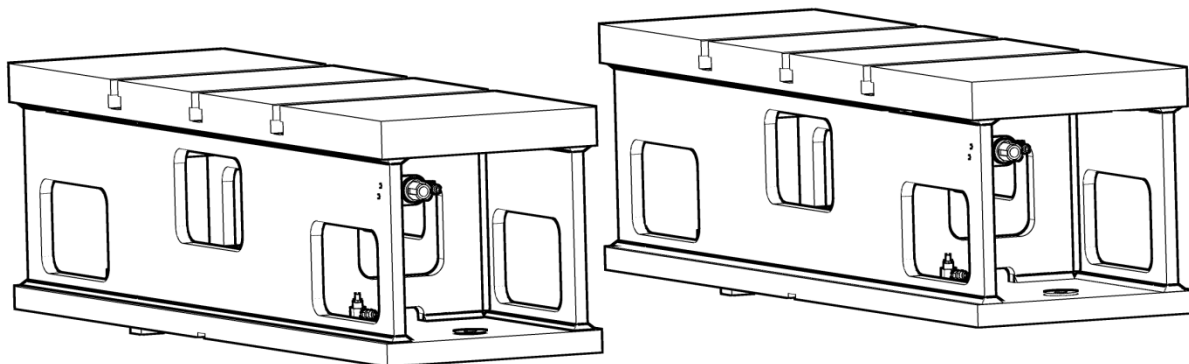


6309P Clamping System
For Fixtures 10100 & 10100A



10355 Set of Parallels with Air Float

15 1/2" (394mm) - 55" (1400mm) long. Required when using Large Block Fixtures 6405F and 6821.

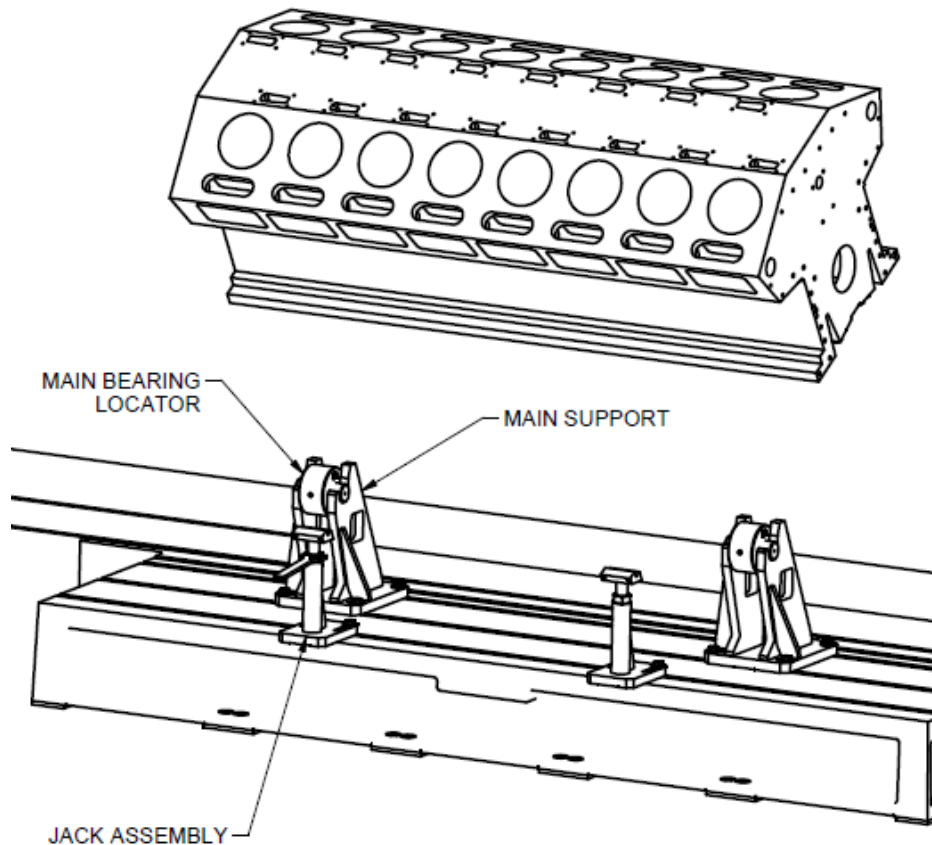
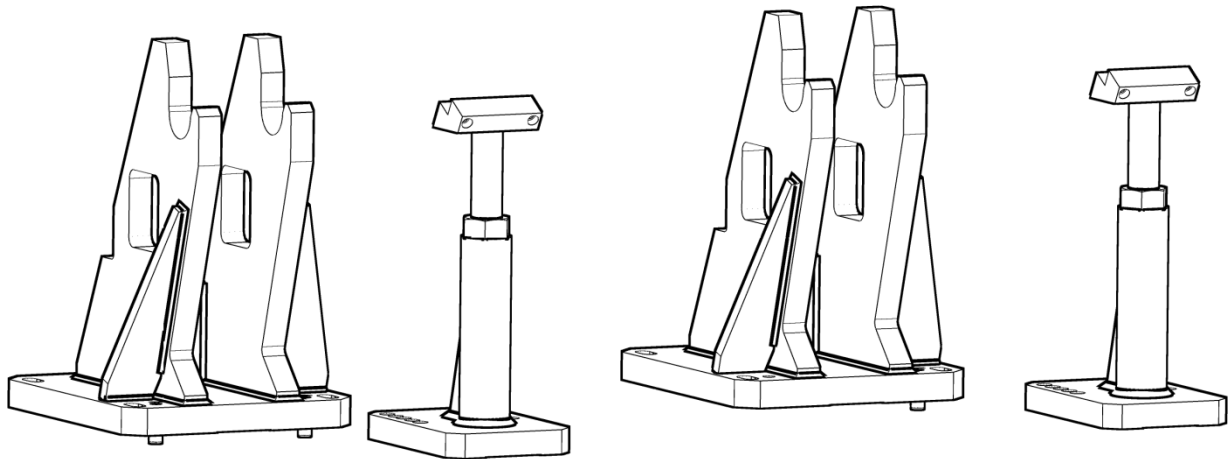


Fixturing for Mid Range to Large In-Line and V Blocks

Requires Parallels 10355

6405F Large V Block Fixture

For Blocks such as CAT 3500/399, Cummins K and QSK, MTU 4000, Waukesha 7042, etc. Centerline to deck dimension is 16.28" (413.5mm) Saddle pin diameter is 2.5" (63.5mm) Requires Locators as listed below.

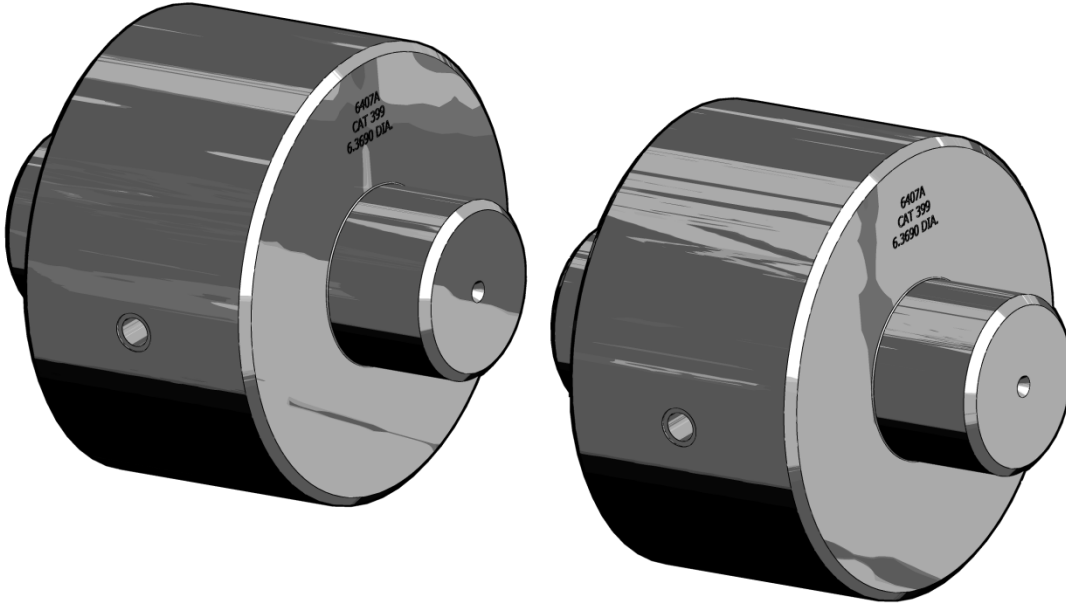


Main Bearing Bore Locator Sets

For 6405F Block Fixture. (If Customer Requires Size Other than Available from Stock, Rottler will Manufacture the Required Size.) Customer Must Provide the Size, Including Tolerance of the Main Bearing Bore.

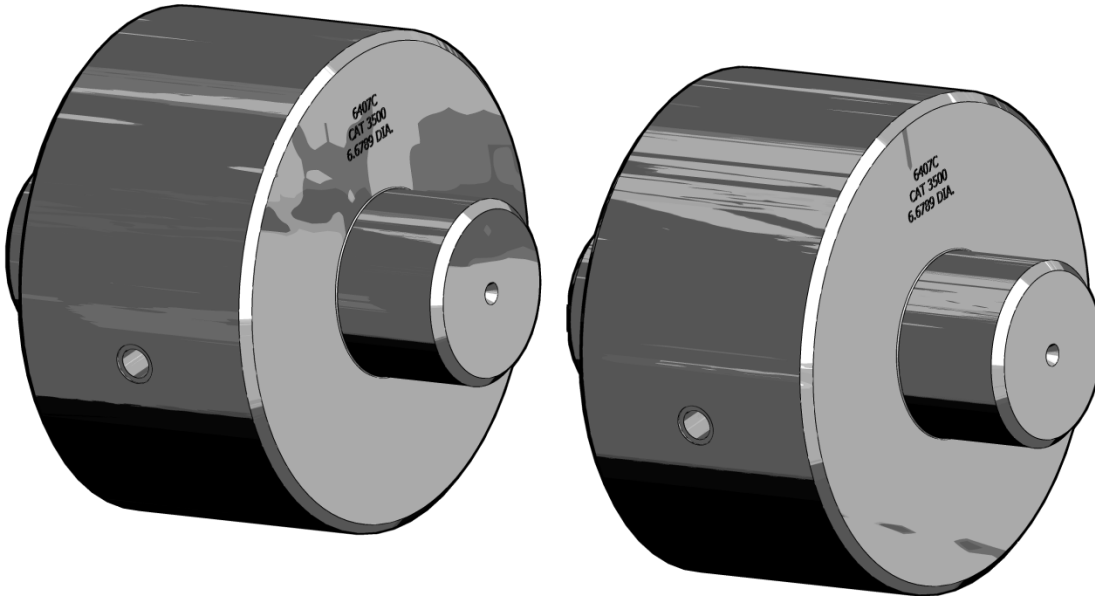
6407A Locator Assembly

Main, CAT 399 / Large V-Block Fixture (Matched Pair)



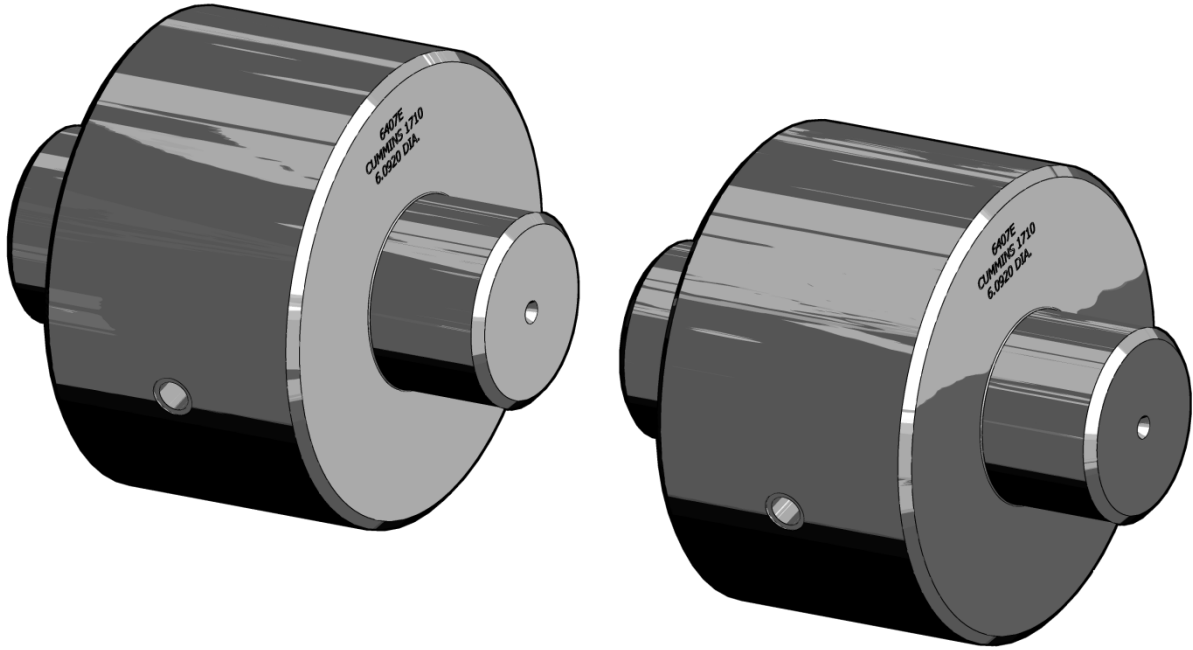
6407C Locator Assembly

Main, CAT 3500 / Large V-Block Fixture (Matched Pair)



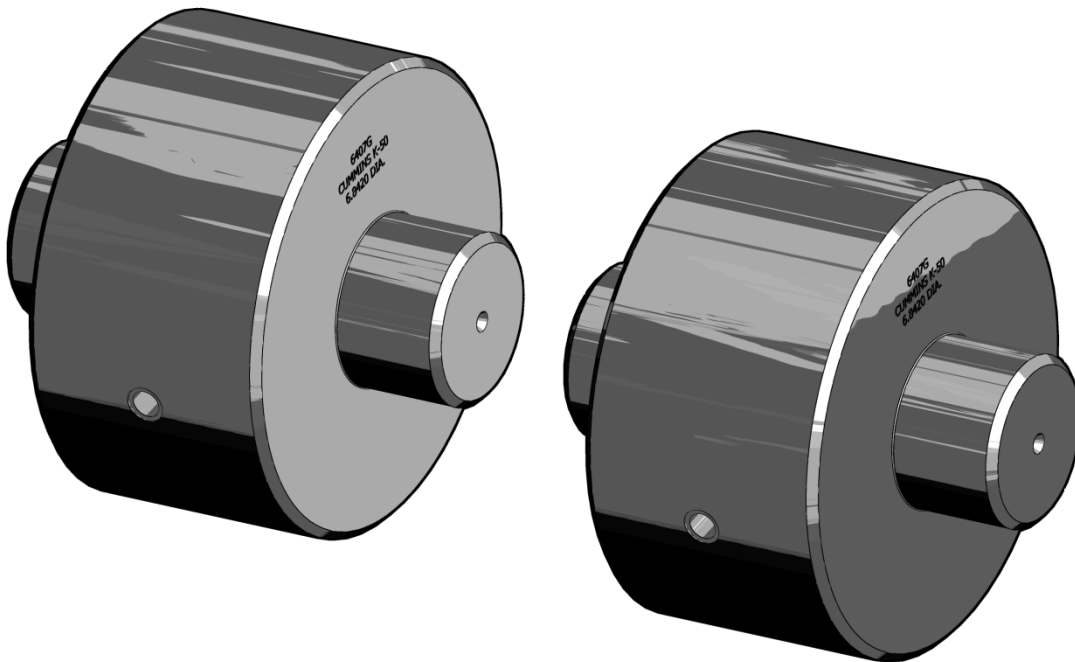
6407E Locator Assembly

Main, Cummins 1710 / Large V-Block Fixture (Matched Pair)



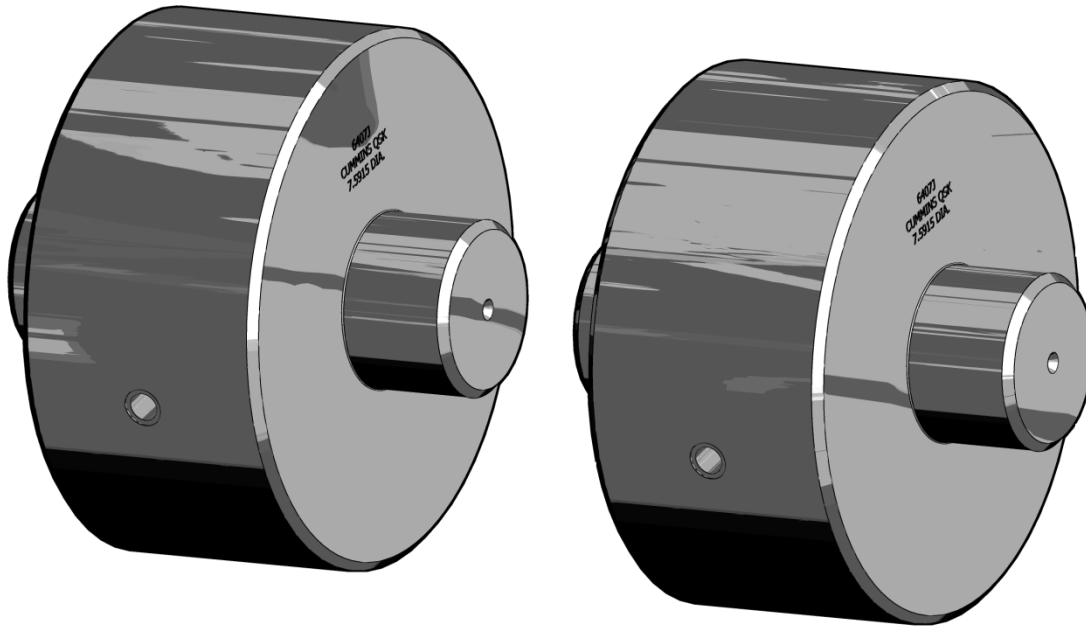
6407G Locator Assembly

Main, Cummins K50 / Large V-Block Fixture (Matched Pair)



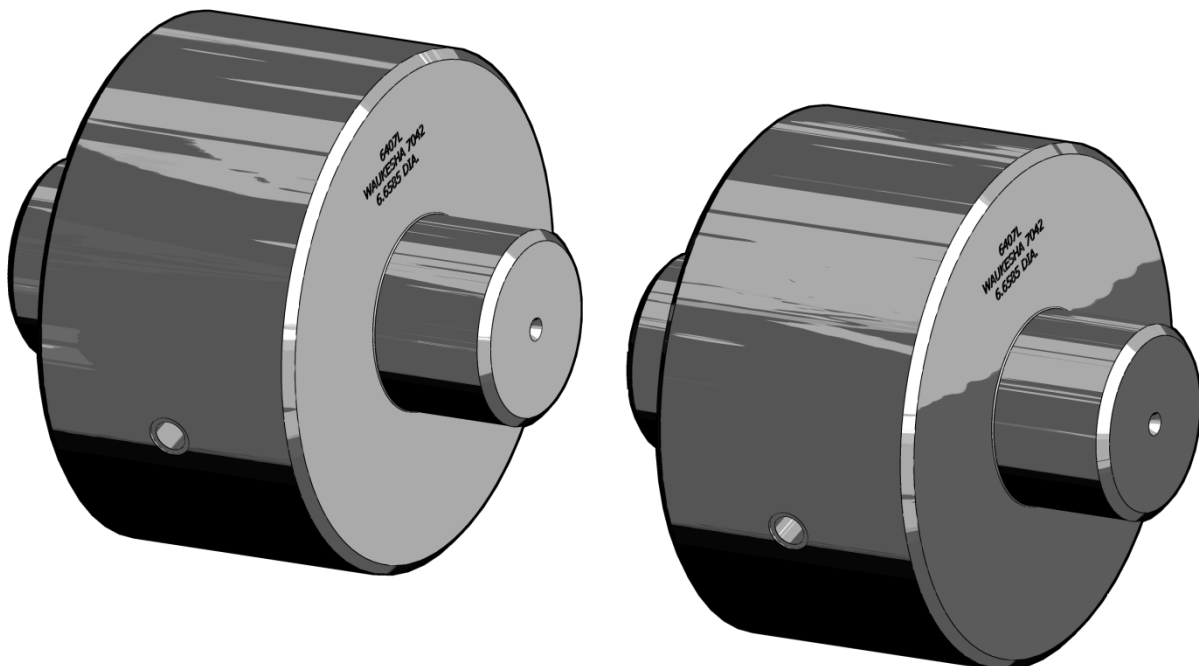
6407J Locator Assembly

Main, Cummins QSK / Large V-Block Fixture (Matched Pair)



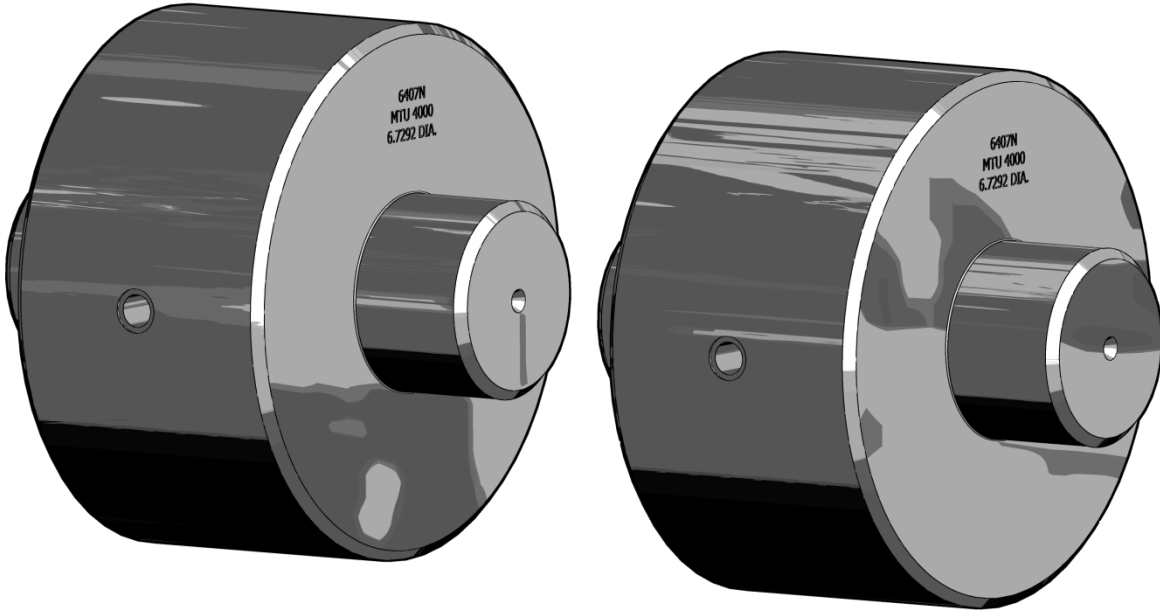
6407L Locator Assembly

Main, Waukesha 7042 / Large V-Block Fixture (Matched Pair)



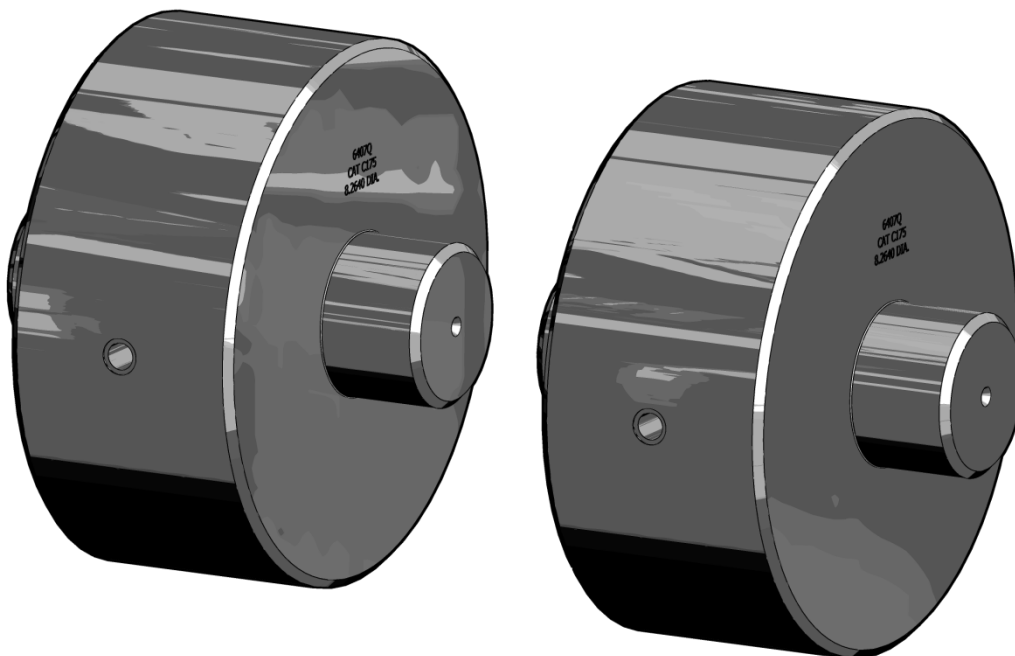
6407N Locator Assembly

Main, MTU 4000 / Large V-Block Fixture (Matched Pair)



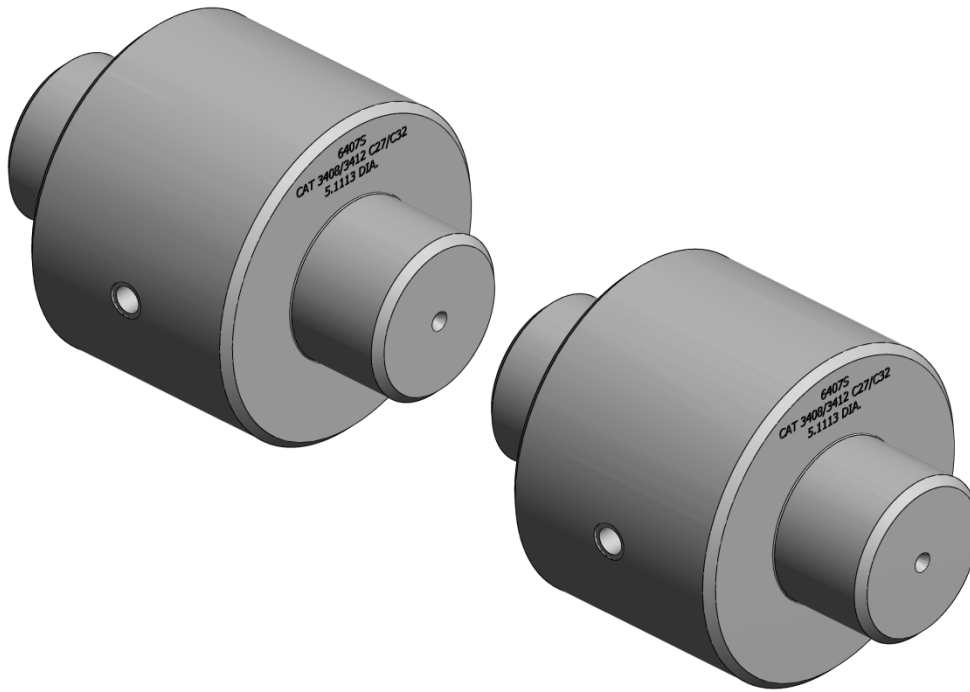
6407Q Locator Assembly

Main, CAT C175 / Large V-Block Fixture (Matched Pair)



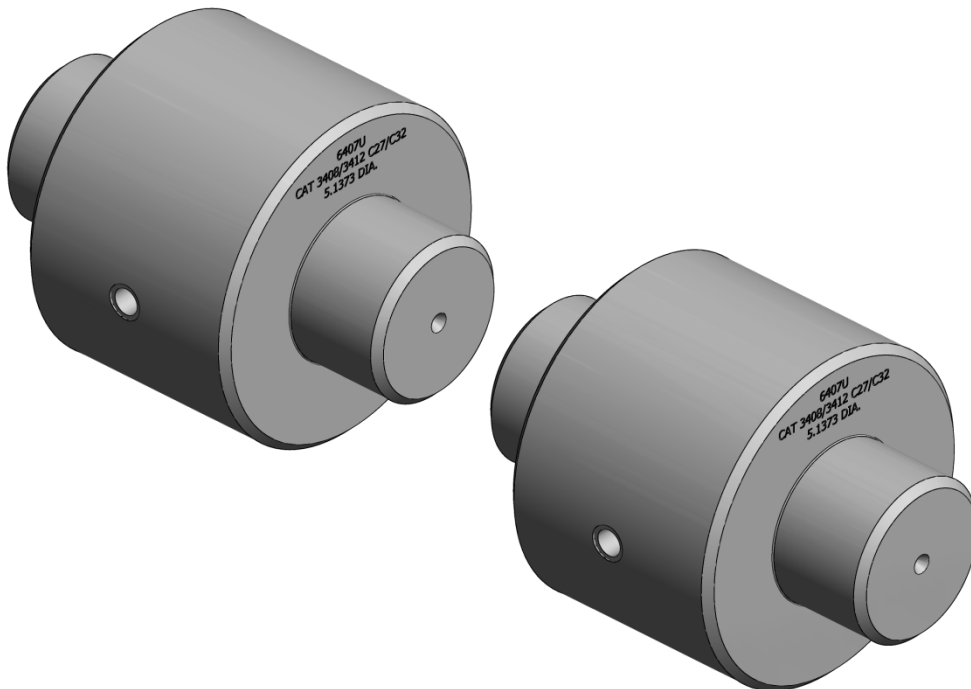
6407S Locator Assembly

Main, 5.1143 diameter bore (Matched Pair)



6407U Locator Assembly

Main, 5.1393 diameter bore (Matched Pair)



6407W Locator Assembly
Main, MTU 396

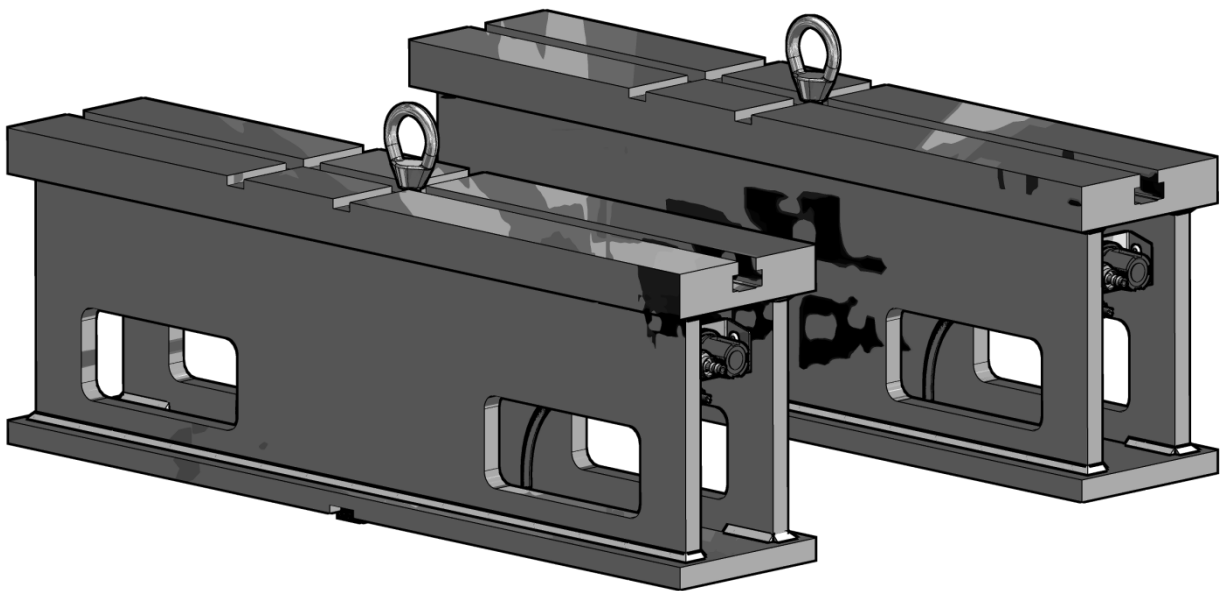


7152A Dual Axis Level Assembly

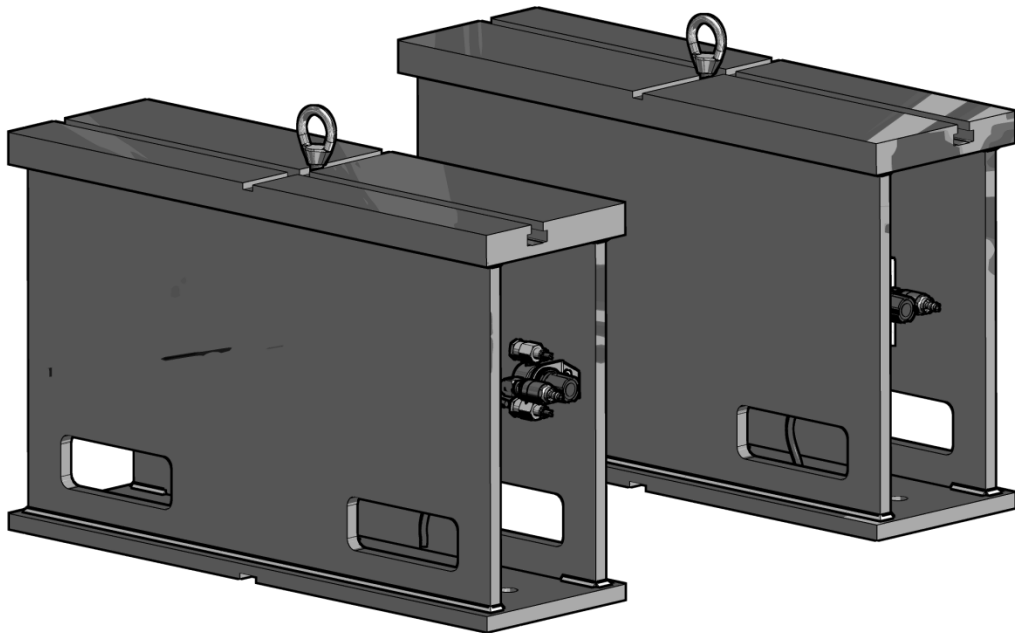


6370Z Set Of Parallels with Air Float

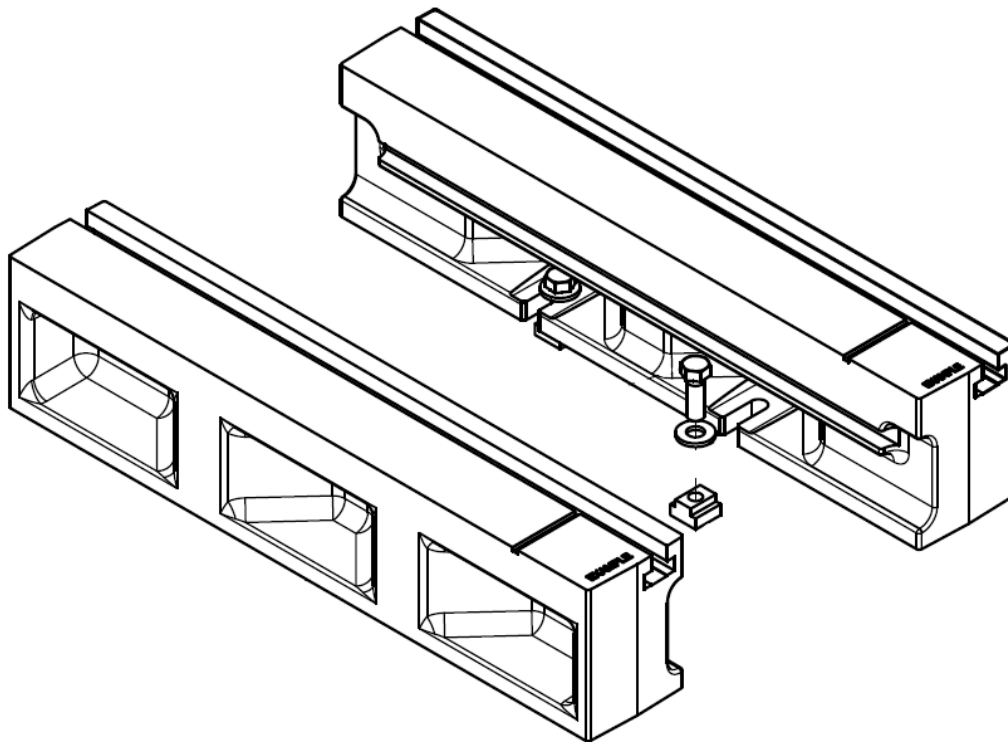
10" (254mm) - 3 T Slots



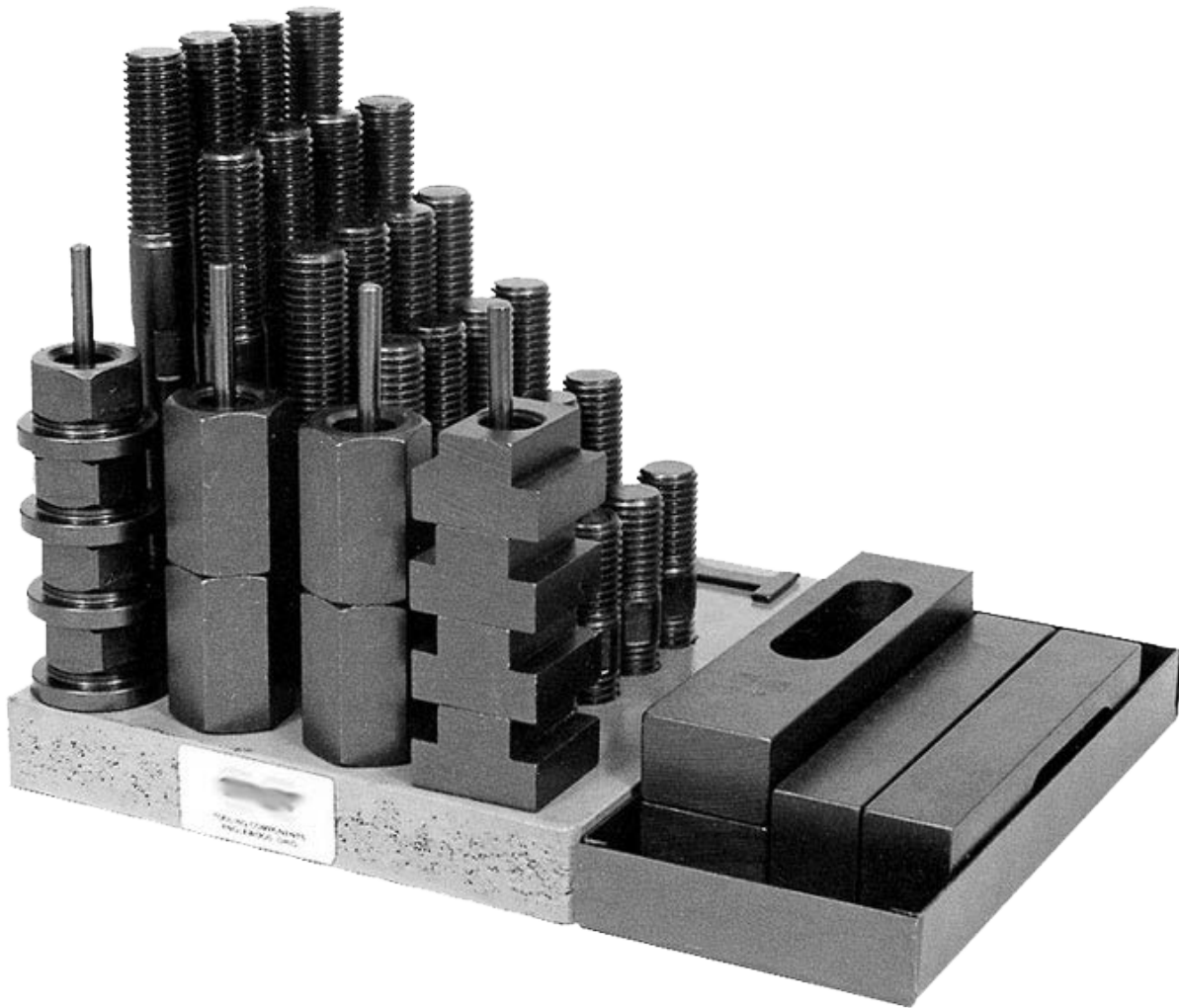
6370C Set Of Parallels with Air Float
18" (457mm) - 3 T Slots



7219W Heavy Duty T-Slot Universal Parallels
5.2" (132mm) Required when Machining Small In-Line Blocks on their Pan Rails.



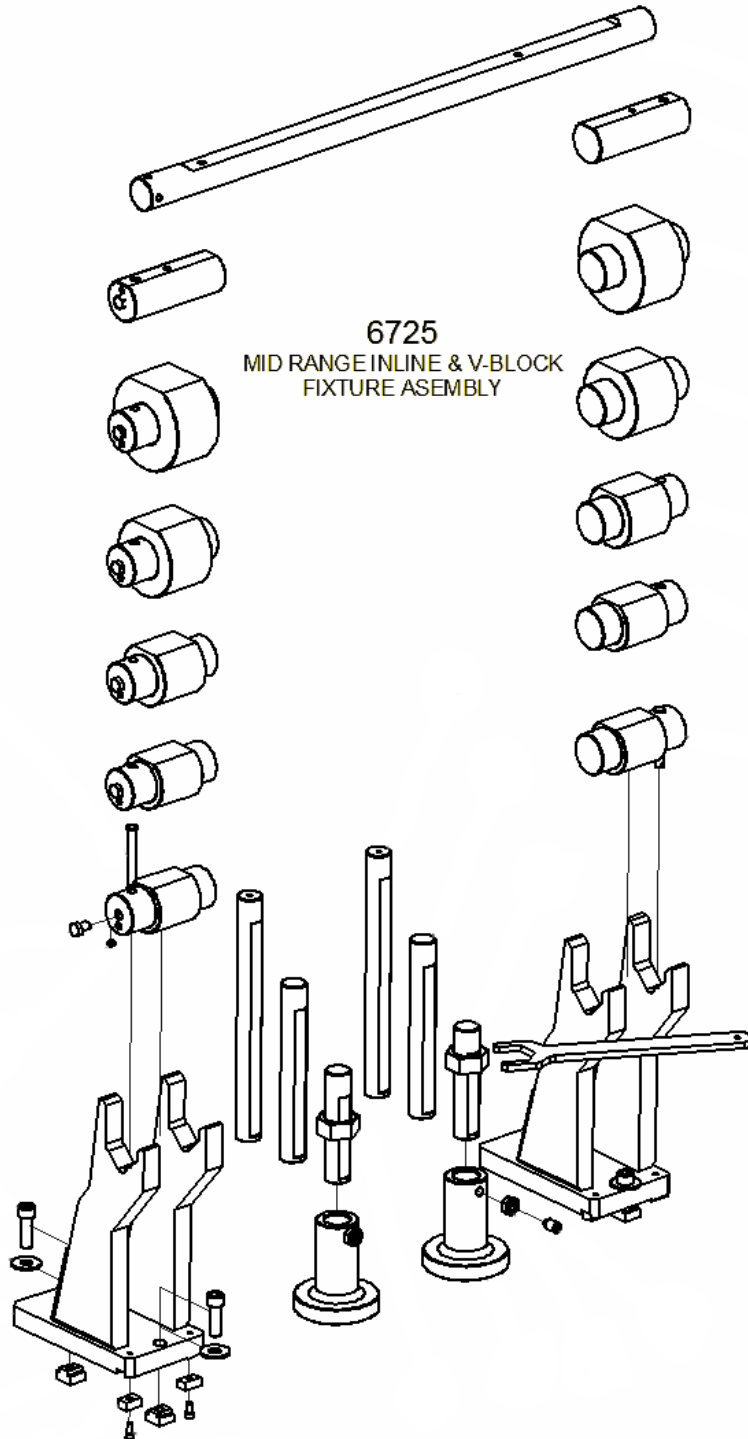
6511 3/4" (19.05mm) Clamp Kit
T-Nuts, Bolts, Strap Clamps, Etc.



6725 Mid-Range In-Line and V Block Fixture

For Blocks Up to V12 Such as CAT C27, Cummins Nv12, Etc. Fixture Includes Five Pair Locators to Cover 2.5 - 6.0" (63.5 - 152mm) Main Line Diameter Range. Package includes 2" (50.8mm) bar to support small in-line and V-blocks, selection of locators available for most common blocks. See F60/F70 Locator price sheet for listing of available locators.

Note: 6725 requires 6370Z 10" (254mm) parallels.



Fixturing for Surfacing Cylinder Heads and Manifolds

Requires Parallels 10355

7209M Leveling Table With Air Float

Complete With Universal Work Holding System for Surfacing Cylinder Heads and Manifolds. Requires One Set of 6370C Parallels

7209N 2-Piece Vise

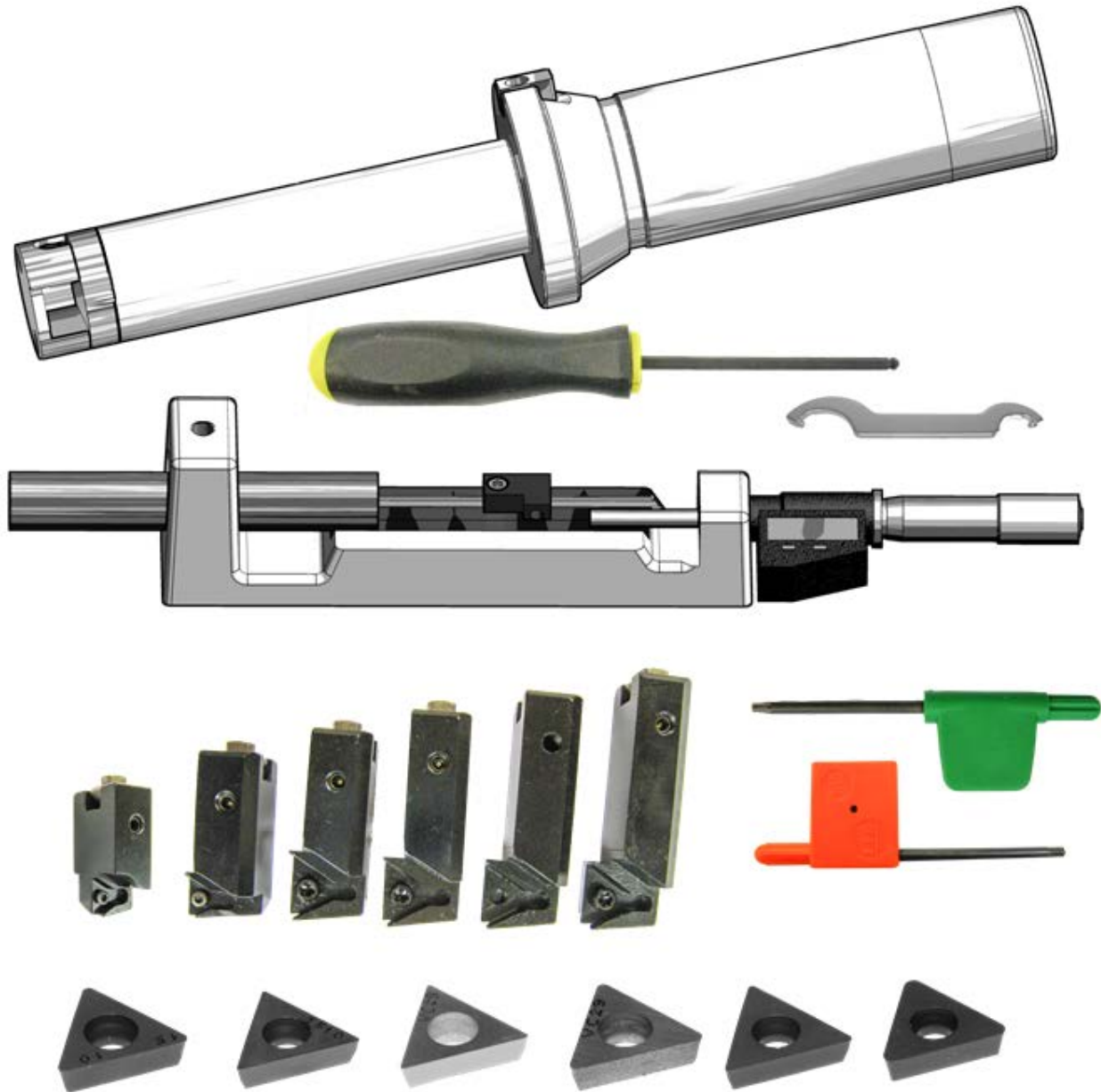
For Holding Exhaust Manifolds for Surfacing. Also Used for Surfacing Main Bearing Housing Caps In Preparation for Main Line Boring. Requires 7209M Leveling Table.



Boring and Sleeving Tooling

6516H Blind Hole Stub Cutterhead

1.5 - 4.2" (38 - 107mm) diameter x 6.5" (165mm) length complete with tooling and Digital Micrometer



6519Z Blind Hole Stub Cutterhead

2.9 - 5.0" (74 - 152mm) diameter X 9.7" (246mm) length Complete With Tooling and Digital Micrometer



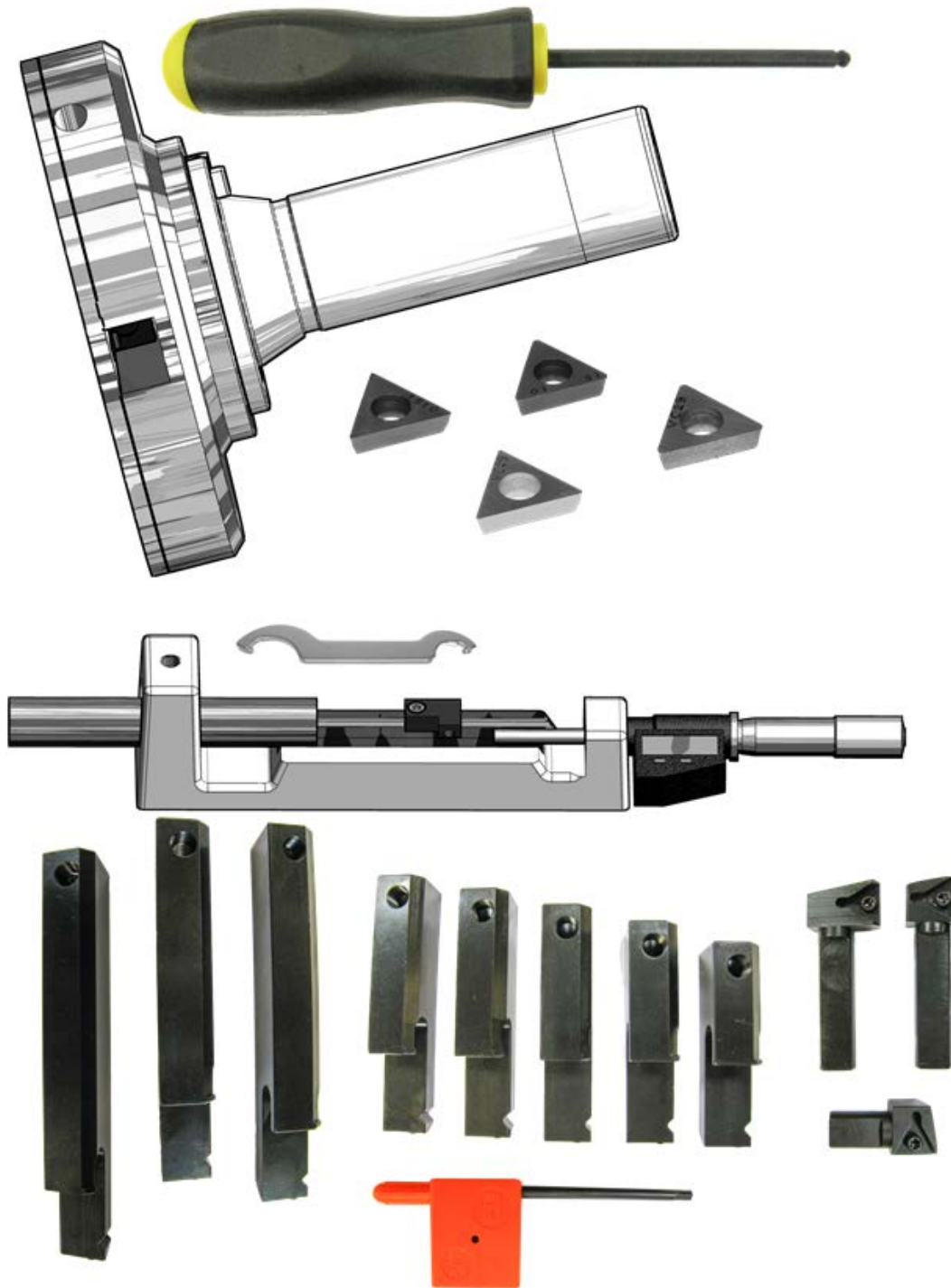
6256A Blind Hole Spindle/Cutterhead

4.5 - 9.0" (114 - 228mm) Diameter X 12" (254mm) Length Complete with Tooling and Digital Micrometer



6464J Blind Hole Cutterhead

8.0 - 14.0" (203 - 360mm) diameter complete with tooling and Digital Micrometer



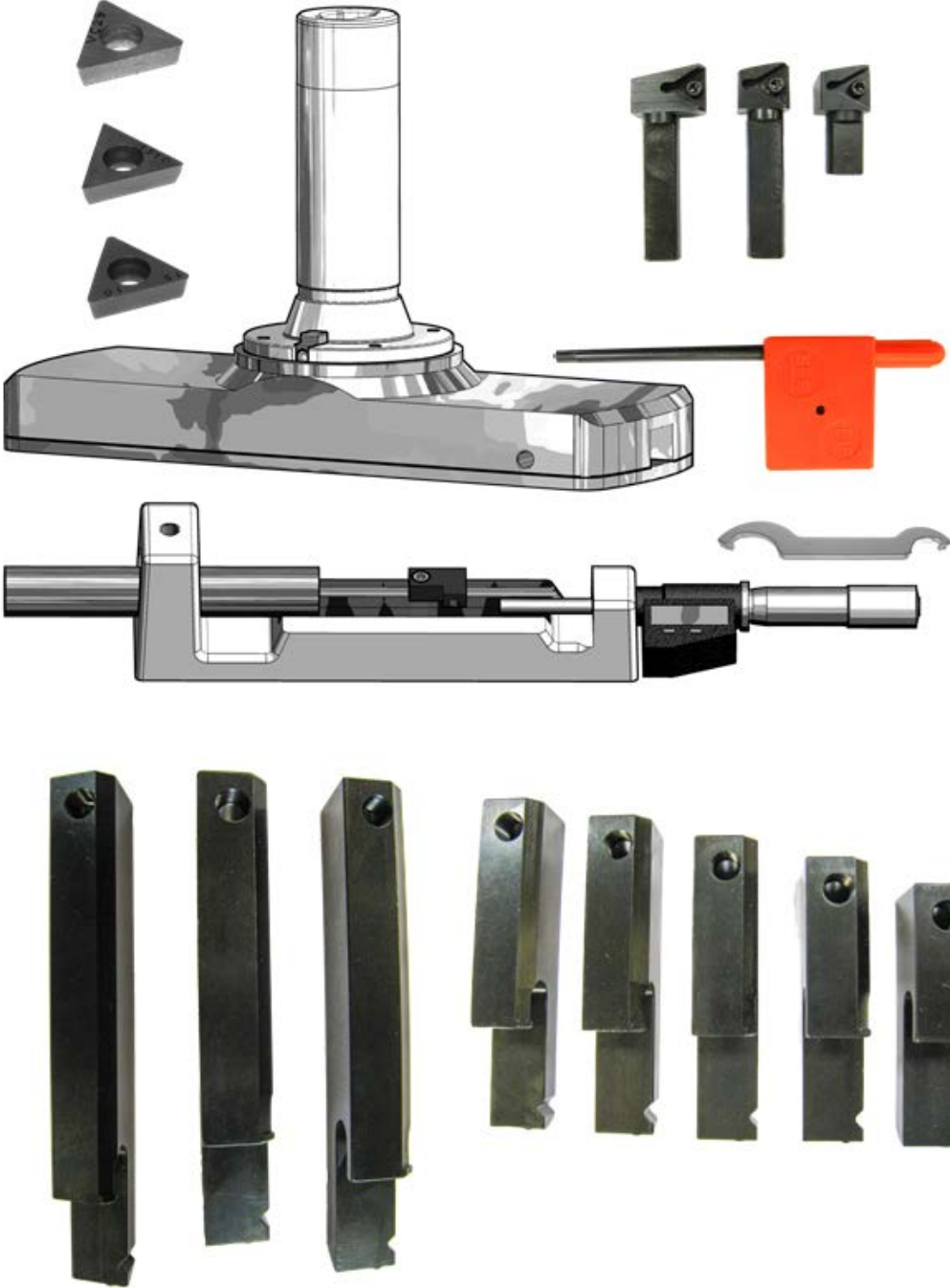
6588 Blind Hole Cutterhead

11.75 - 16" (298 - 406mm) diameter - Complete with tooling and Digital Micrometer



6587 Blind Hole Cutterhead

14.0 - 20.0" (356 - 508mm) diameter complete with tooling and Digital Micrometer

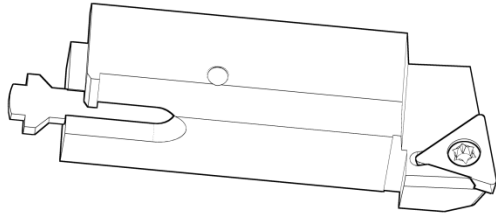


10103 Extended Spindle Blind Hole Cutterhead
4.5" – 9.0" (114mm – 228mm) Diameter /x 12.5" (318mm) Long.
Complete with Tooling and Digital Micrometer





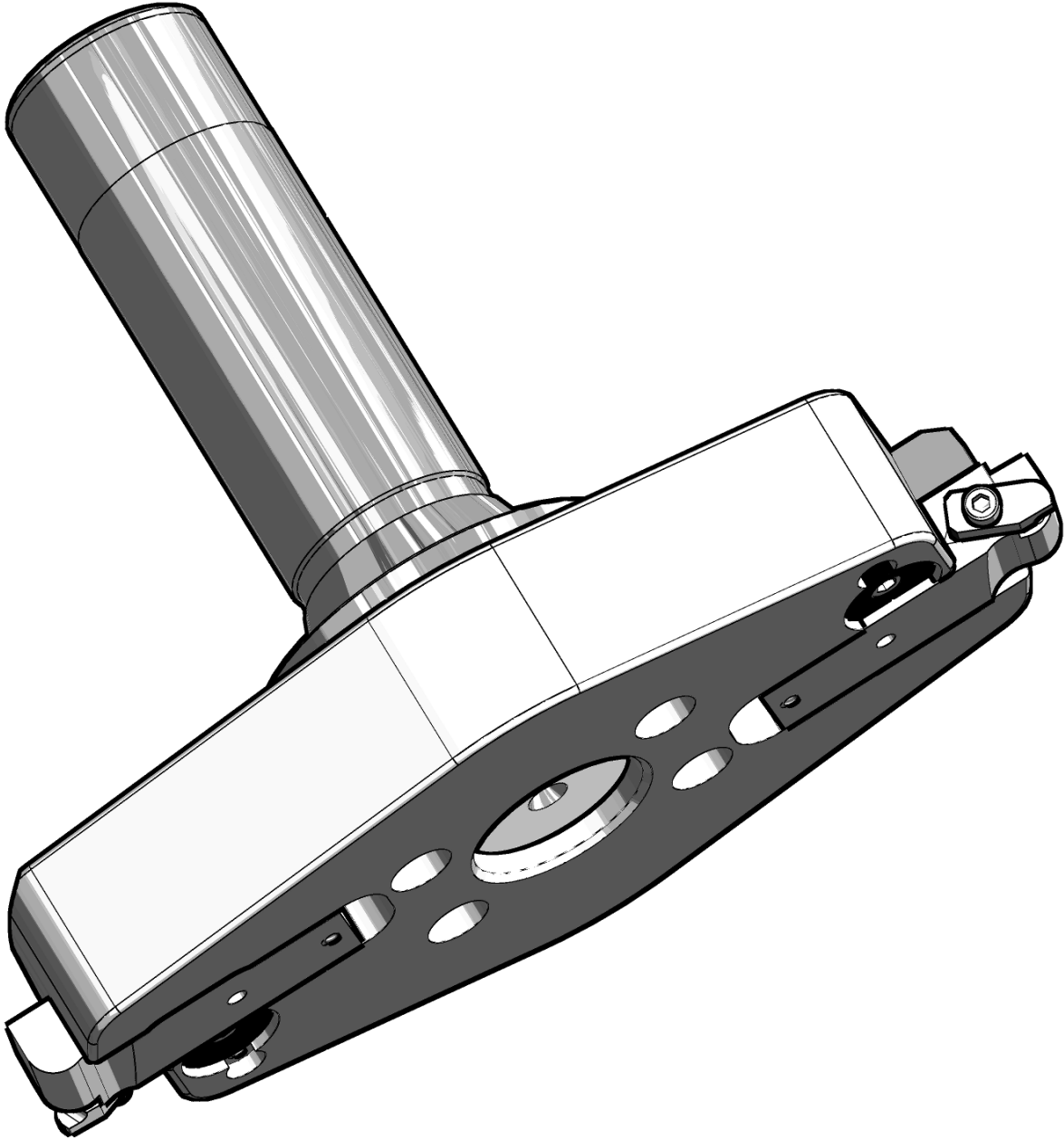
6593S Cartridge Assembly
Circular Interpolation Counterbore Facing



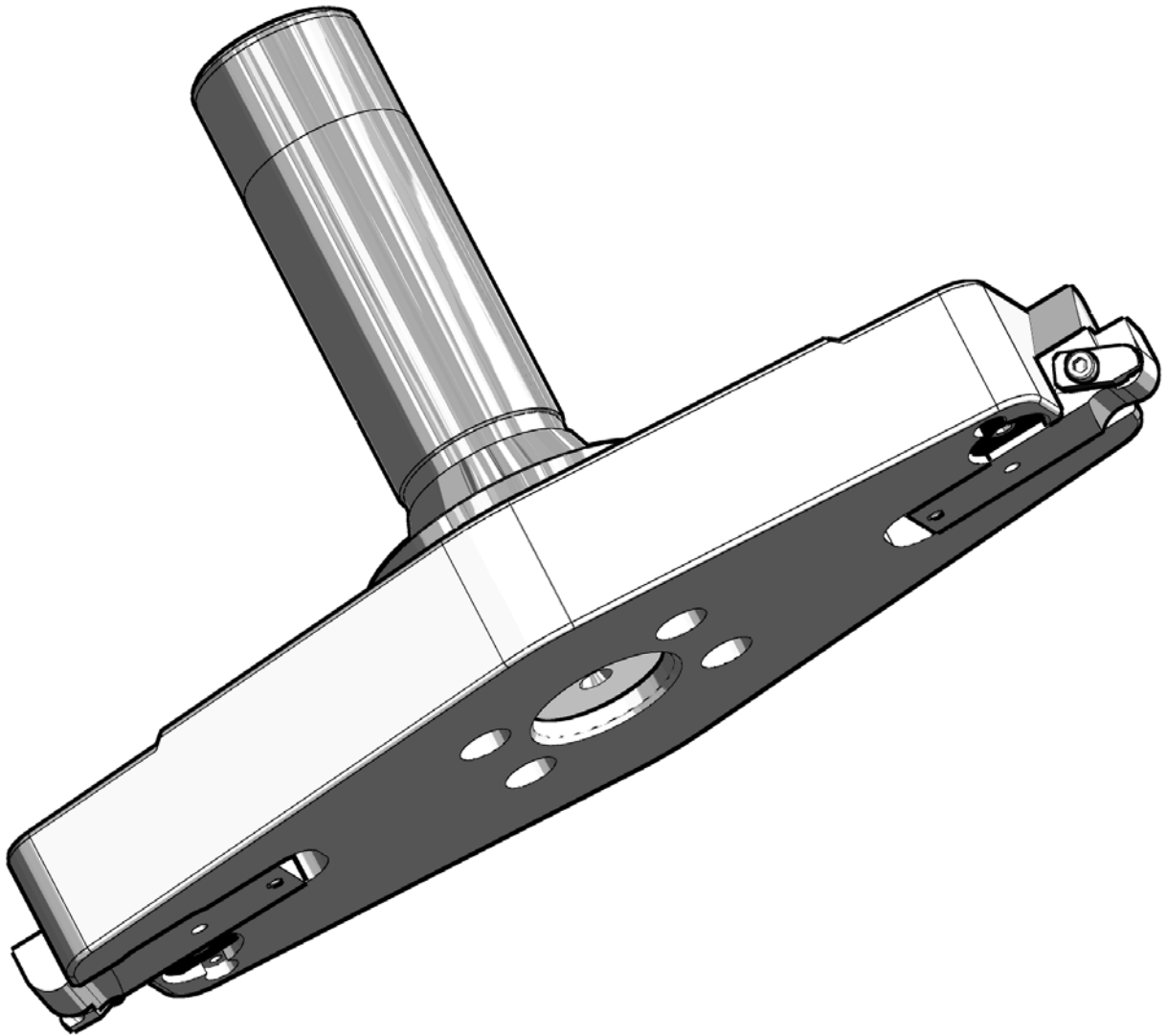
Surfacing Tooling

6294V Surfacing Cutterhead Assembly

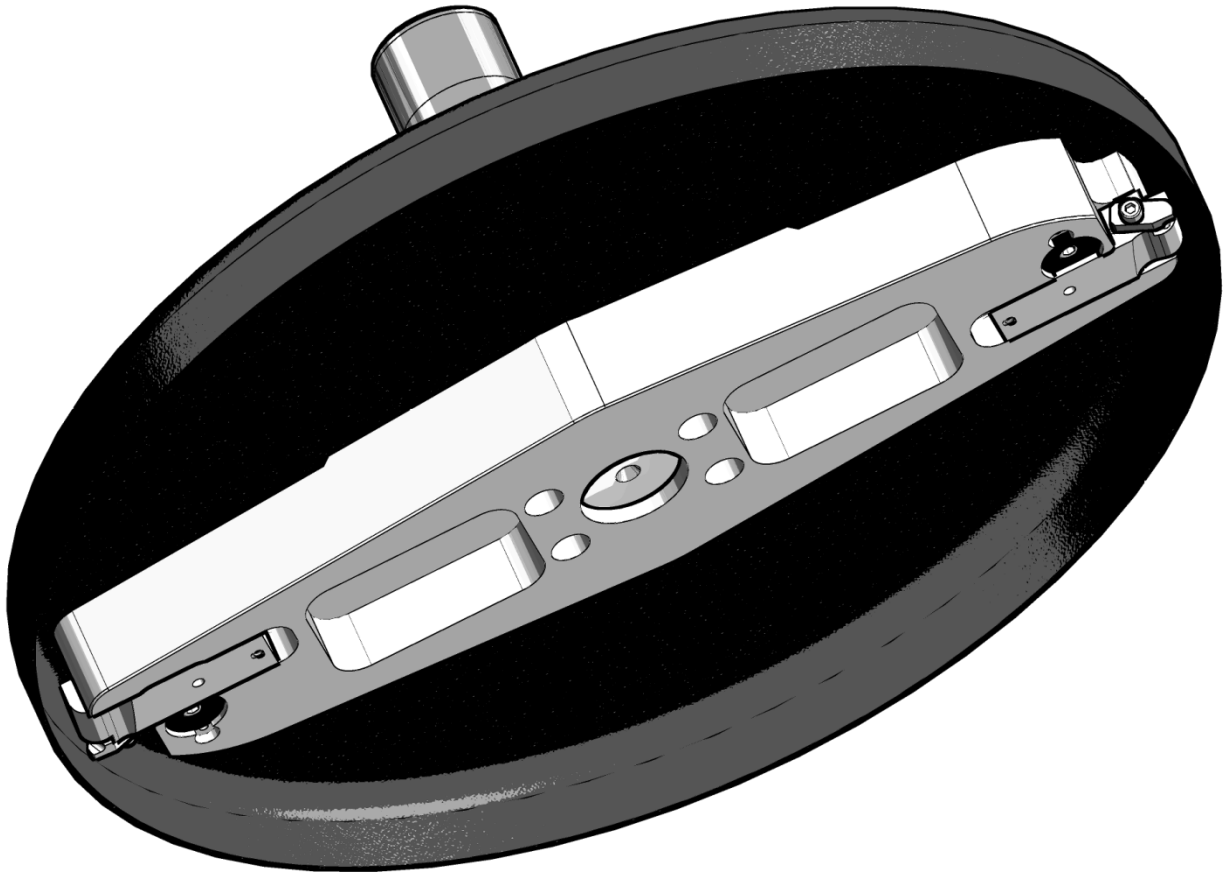
10" (250mm) Diameter Complete With Tooling



6294U Surfacing Cutterhead Assembly
14" (360mm) Diameter Complete With Tooling



6294T Surfacing Cutterhead Assembly
18" (460mm) Diameter Complete With Tooling

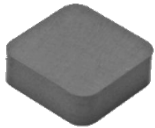


6294W Surfacing Cutterhead Assembly
22" (560mm) Diameter Complete With Tooling



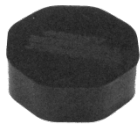
6301J CBN Insert

1/16 Radius, for Surfacing Large Blocks



6303V CBN Insert

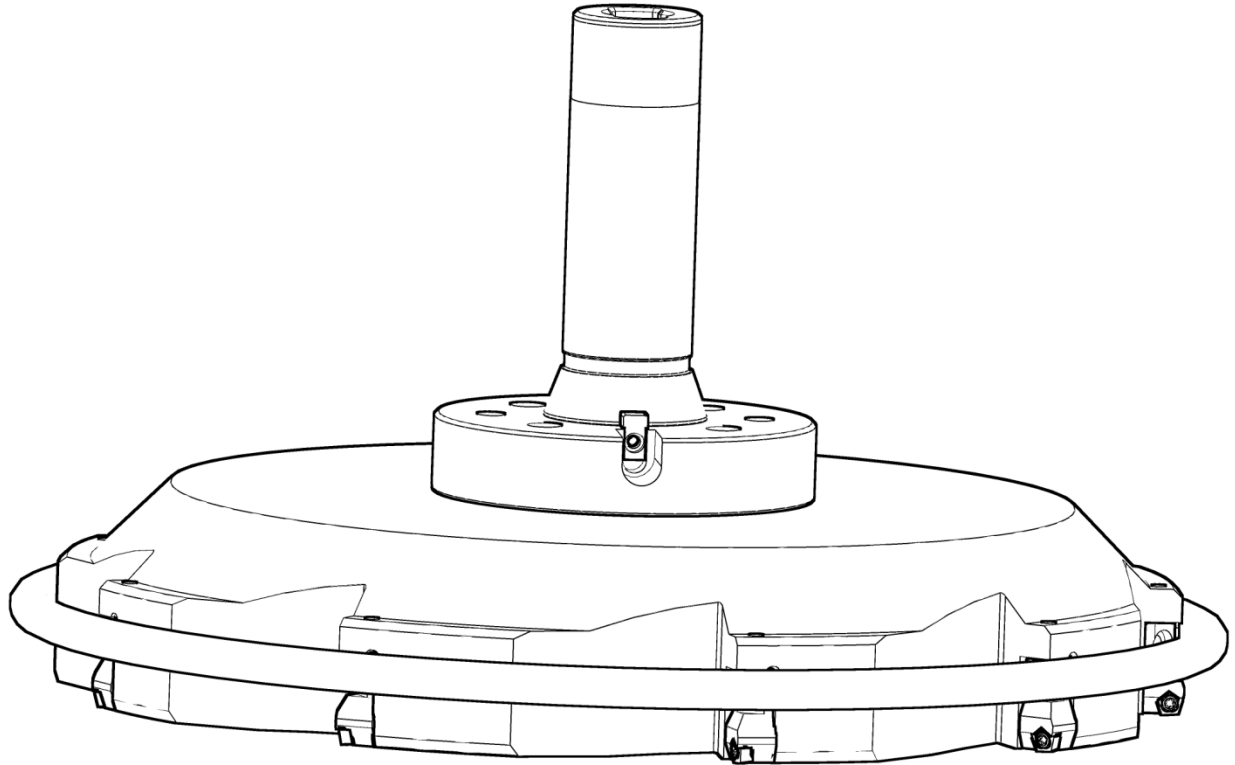
Octagonal (16-Cutting Corners) for surfacing large diesel blocks



Special Surfacing Tooling for Milling Metal Sprayed Head Gasket Decks

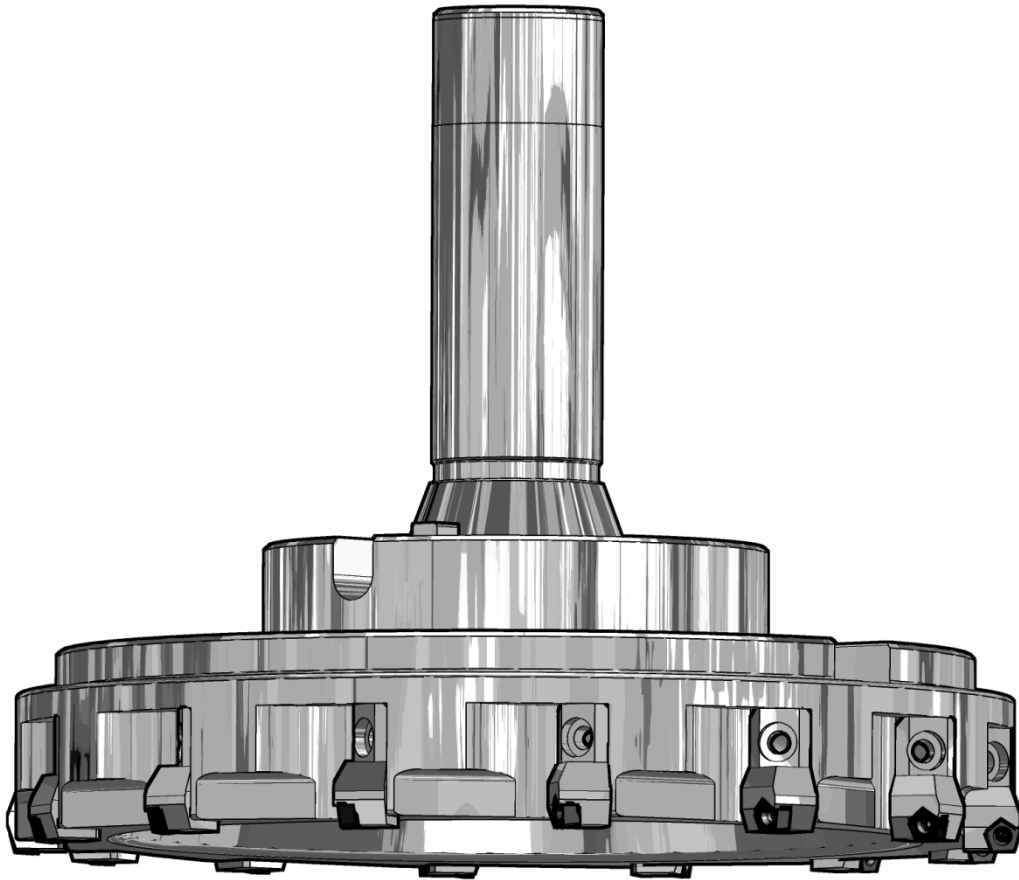
6864 Special Multi Tooth Milling Head

18" (420mm) Diameter Including 9 Cartridges with 10 cutting edges per insert



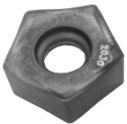
6865 Special Multi Tooth Milling Head

12" (300mm) Diameter Including 14 Cartridges with 10 cutting edges per insert



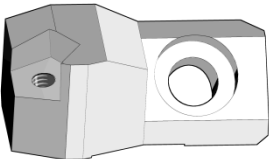
6864E Replacement Insert

(10 cutting edges per insert) for 6864 and 6865 Milling Head



6864D Replacement Cartridge

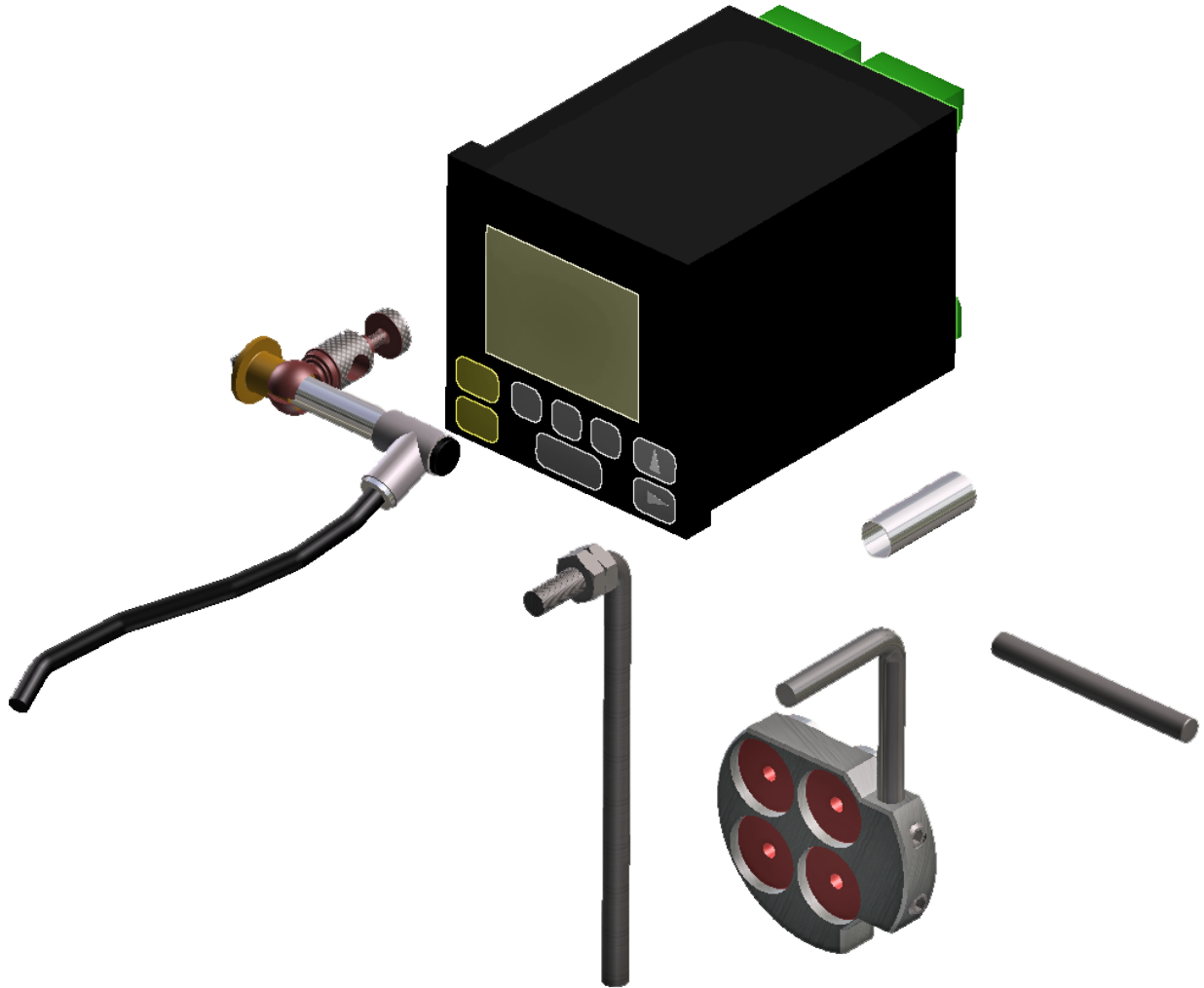
For 6864 Milling Head



General Purpose Accessories

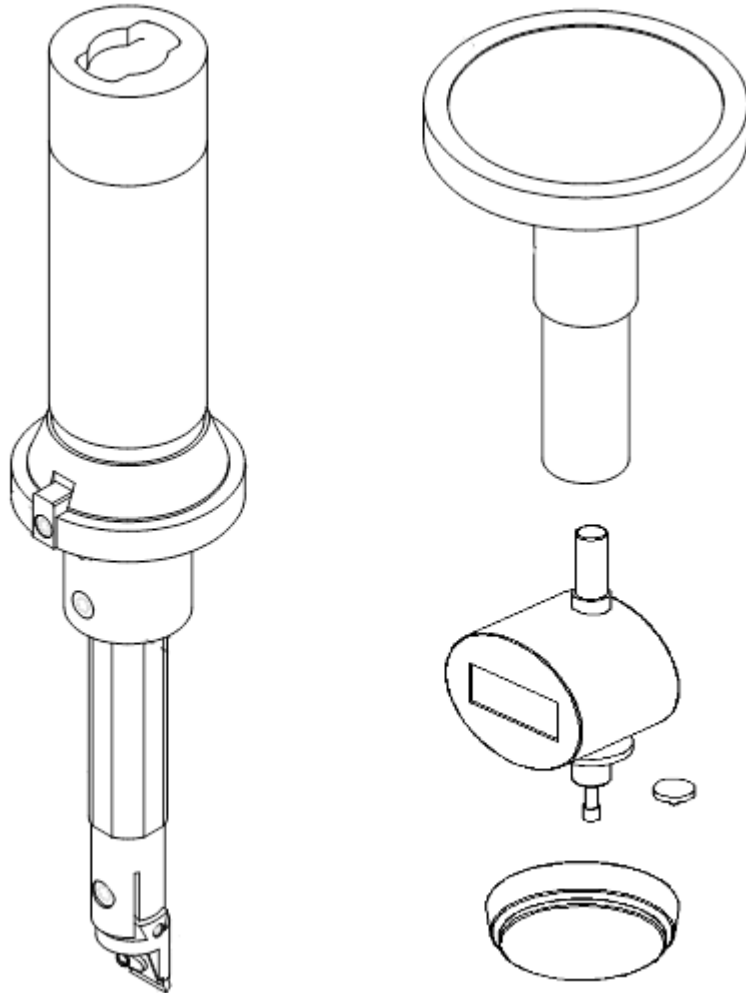
502-12-7B Digital Runout Probe and Readout

Including Magnetic Holder for Block Set Up and Manual Centering of Cylinder Bores and Main Line Bores



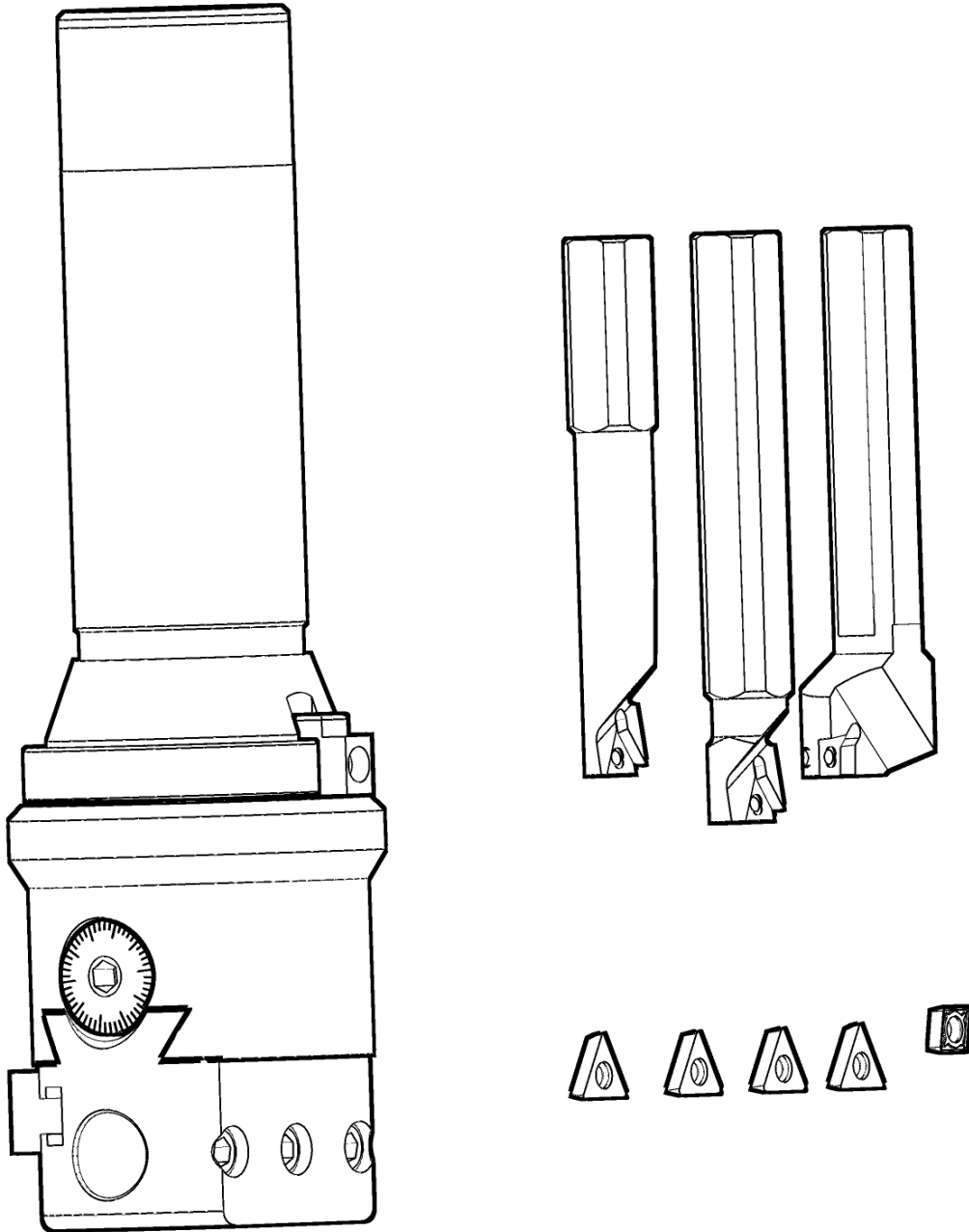
General Purpose Tooling

6648 Caterpillar 3400 Series Tappet Bore Repair Tooling Package Including Digital Indicator



6835 Small Precision Adjustable Boring Head

Including Spindle Adapter and Digital Indicator for General Purpose Boring and Facing Work, Boring Range 3/4 - 3" (20 - 75mm) and Facing Range 4.9 - 7" (125 - 180mm)



6757Z Large Heavy Duty Adjustable Boring/Facing Head

Including Spindle Adapter for General Purpose Boring and Facing Work, and Cutting Wide Chamfers



6648K Collet Kit

1/8 - 1" (3 - 26mm) 23 Collets Including Storage Box and Wrench. Requires 6170J #40 Spindle Adapter



650-2-45G Solid Carbide End Mill

1" (25.4mm) Diameter x 4.00" (101.4mm) overall length. Used for machining head gasket fire deck surface for water hole corrosion repairs.



650-2-43F Four Fluted End Mill

3/4" (19.05mm) X 4" (101.4mm) Overall length (.020" corner radius, flat bottom, no dish) Used for Machining Head Gasket Fire Deck Surface for Water Hold Corrosion Repairs



Spindle Adapters for Mounting Universal Tooling

6648M Spindle Adapter

1" (25.4mm) for Driving 1" (25.4mm) Diameter Shank Tooling

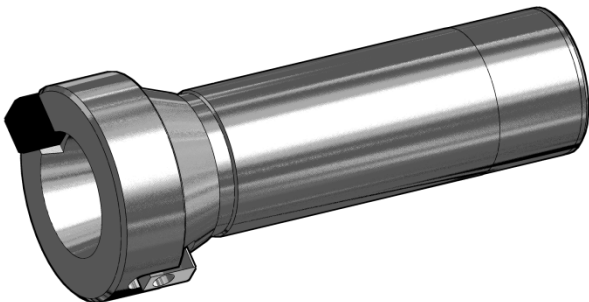


6170C Adapter

Blank, Can be Machined by Customer to Suit Special Requirements



6170J #40 Taper Adapter



6170K R8 Taper Adaptor



6514Q #5 Morse Taper Adaptor

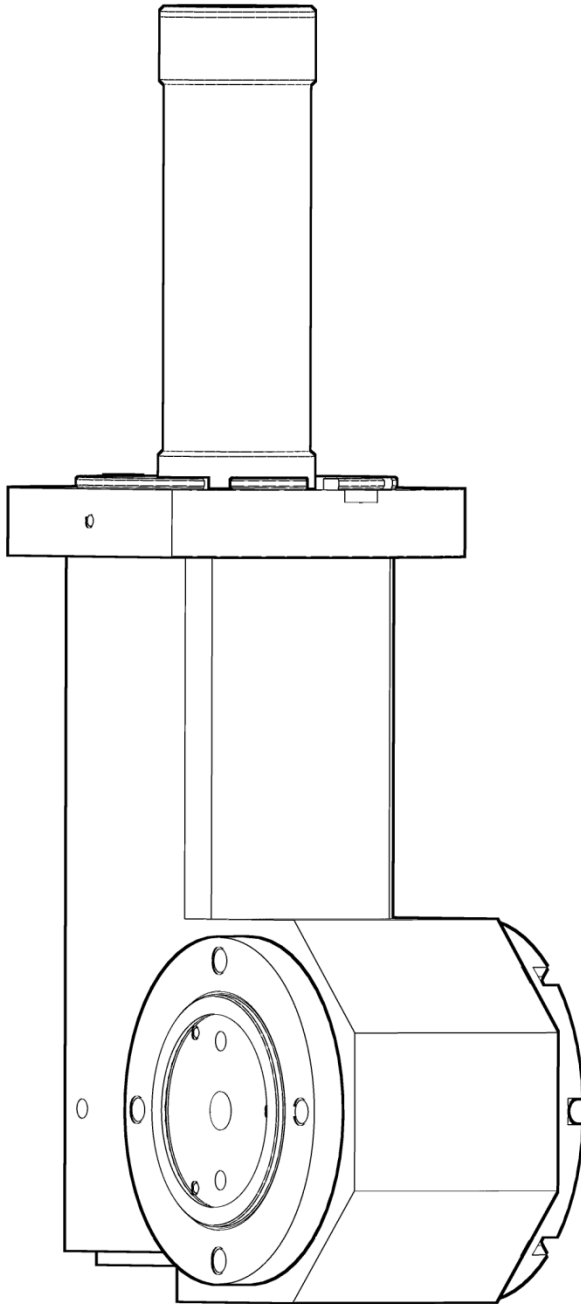


Main Line Bore Equipment

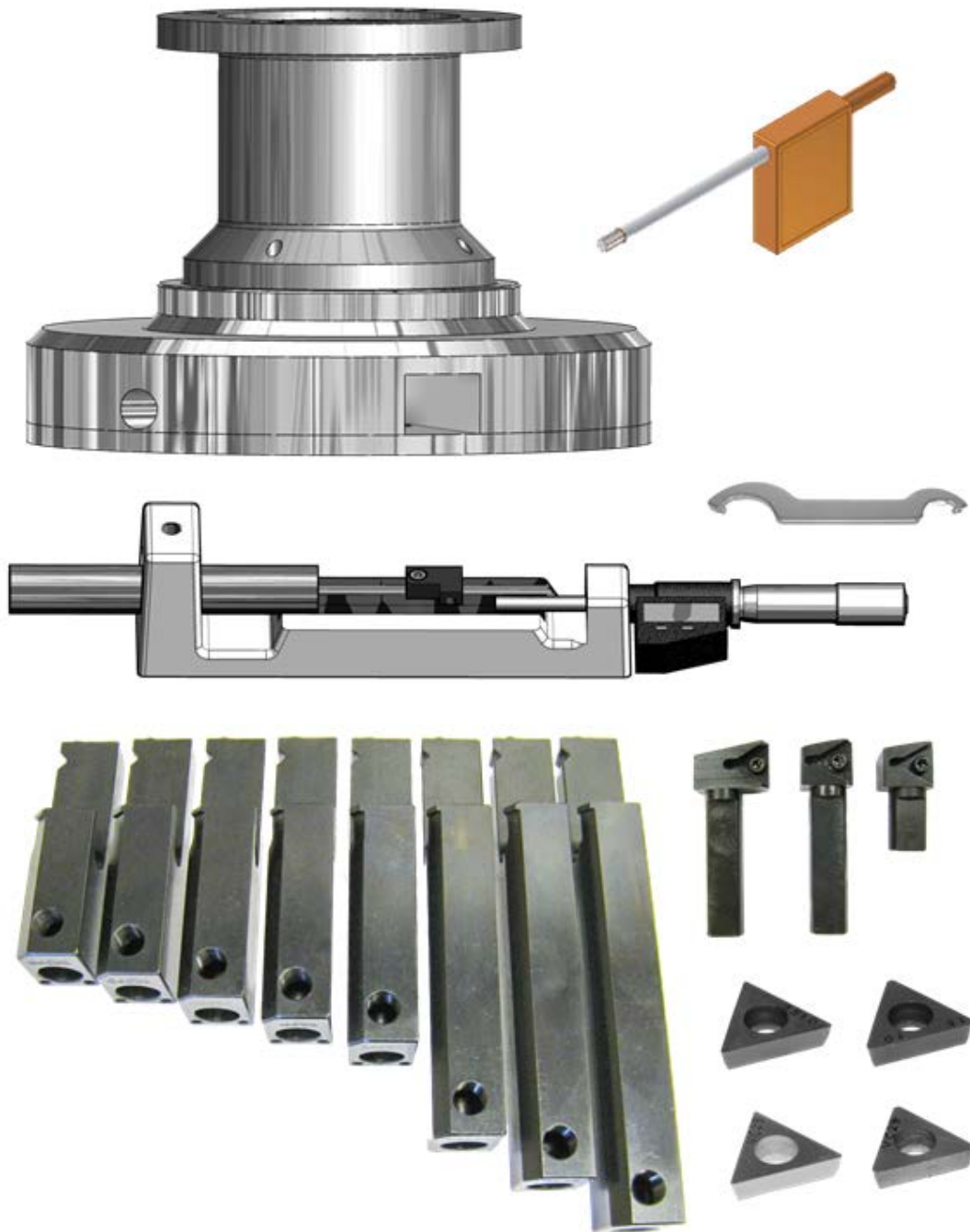
Line Bore Tooling for Extra Large Blocks Such as CAT 3600, 3500 & 399, Waukesha AT, 7042 and 9390, White Superior 2400 and 825

6779K Heavy Duty Offset 90 Degree Right Angle Drive

Note: Cutterheads are Not Included With Right Angle Drive and Must be Ordered Separately



6779A Heavy Duty Line Bore Cutterhead Assembly
8 - 14" (203 - 356mm) Diameter Complete with Tooling and Digital Micrometer



6519V Heavy Duty Line Bore Cutterhead Assembly

6.0 - 8.50" (152.40 - 215.90mm) Diameter X 3" (76mm) Length Complete with Tooling and Digital Micrometer. Minimum Distance Between Bearing Housings 7.94" (102mm)



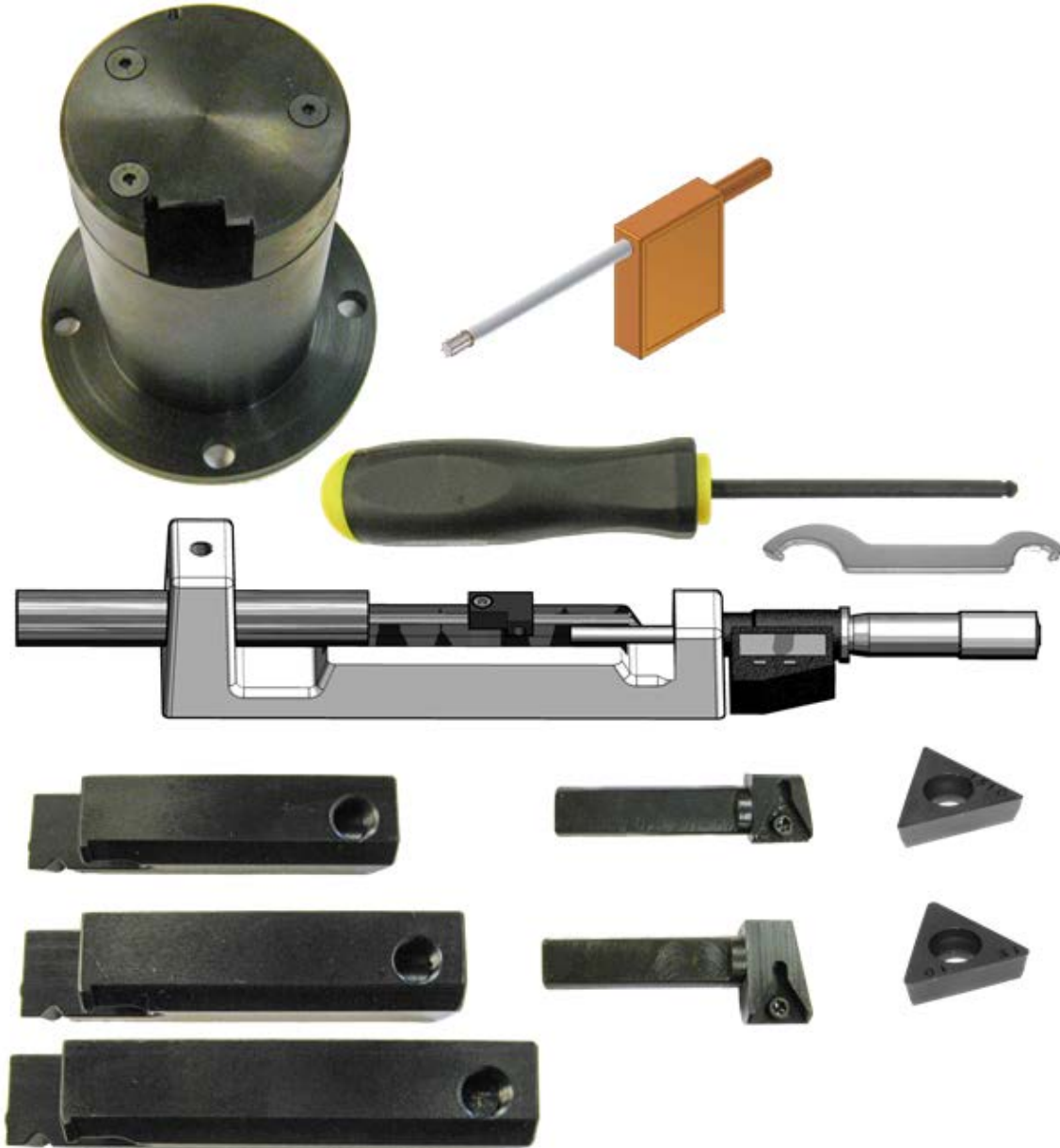
6519P Heavy Duty Line Bore Cutterhead Assembly

6.0 - 8.50" (152.40-215.90mm) Diameter X 4.25" (108mm) Length Complete with Tooling and Digital Micrometer. Minimum Distance Between Bearing Housings 8.94" (227mm)



6519M Heavy Duty Line Bore Cutterhead Assembly

6.0 - 8.50" (152.40 - 215.90mm) Diameter X 5.10" (130mm) Length Complete with Tooling and Digital Micrometer. Minimum Distance Between Bearing Housings 10.04" (255mm)



6519N Heavy Duty Line Bore Cutterhead Assembly

6.0 - 8.50" (152.40 - 215.90mm) Diameter X 6.0" (152mm) Length Complete with Tooling and Digital Micrometer. Minimum Distance Between Bearing Housings 10.94" (278mm)

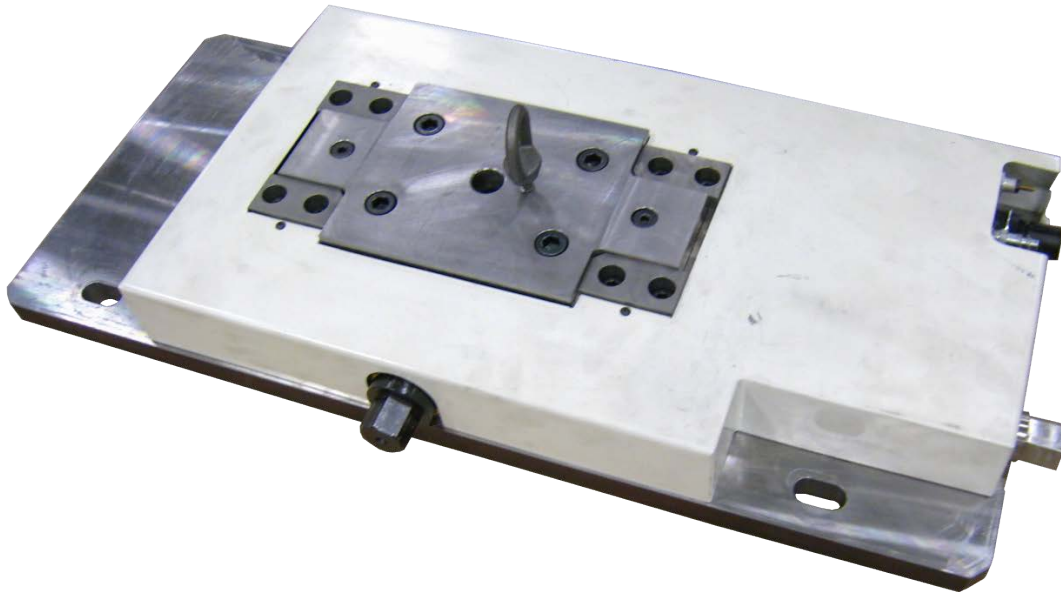


Line Bore Fixturing for Extra Large Blocks

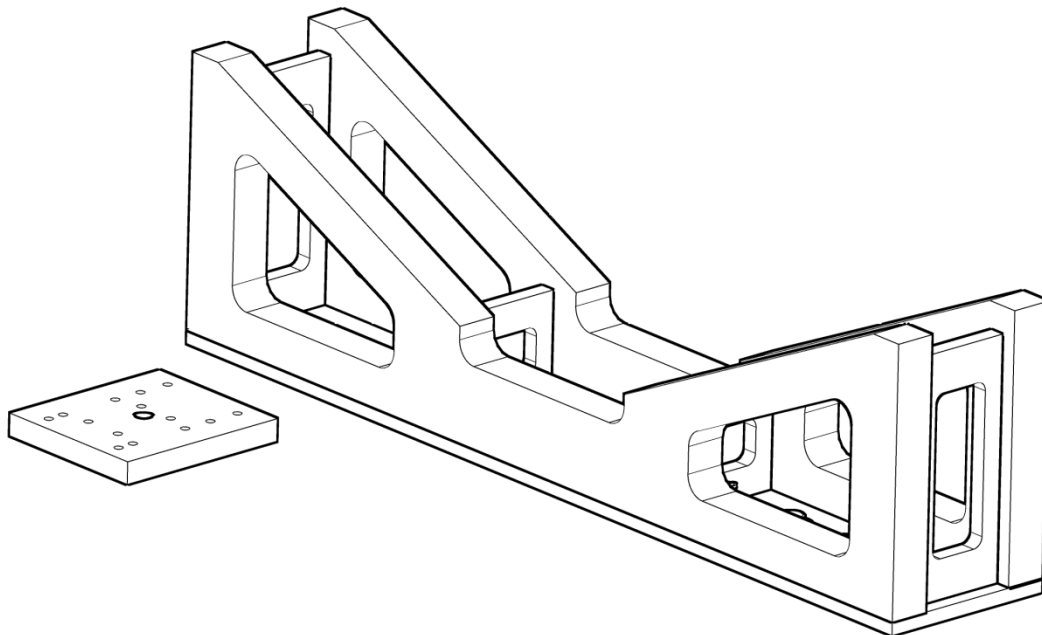
Such as CAT 3600, Waukesha AT, Locomotive EMD and Superior 2400

10200 Adjustable Universal Line Boring Parallel Assembly

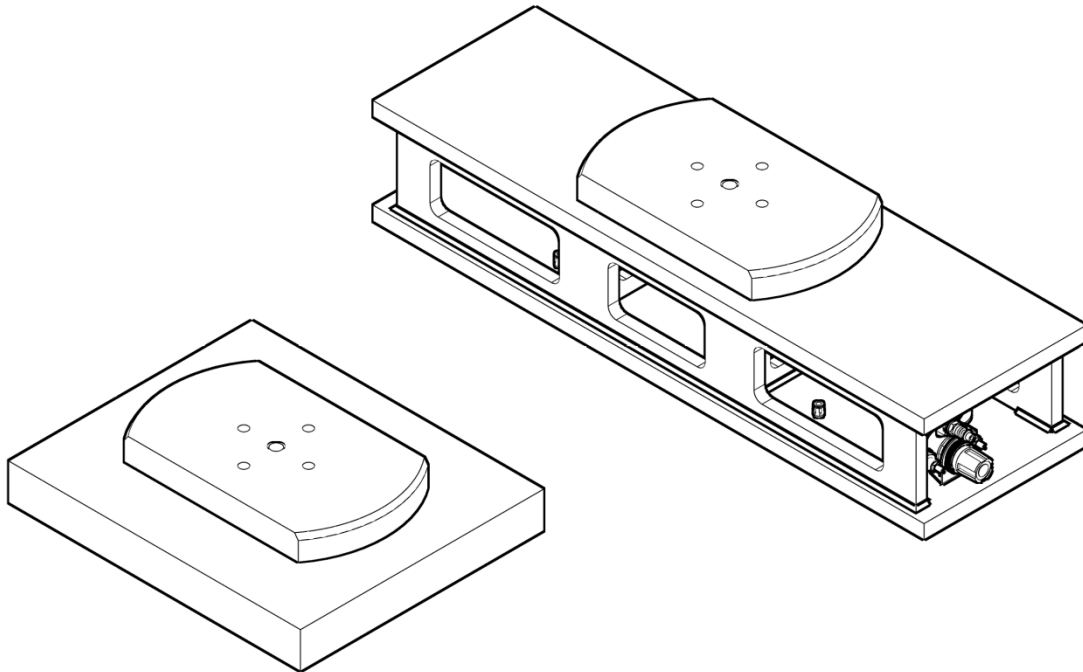
Supports for V Blocks must be Ordered Separately, Listed Below.



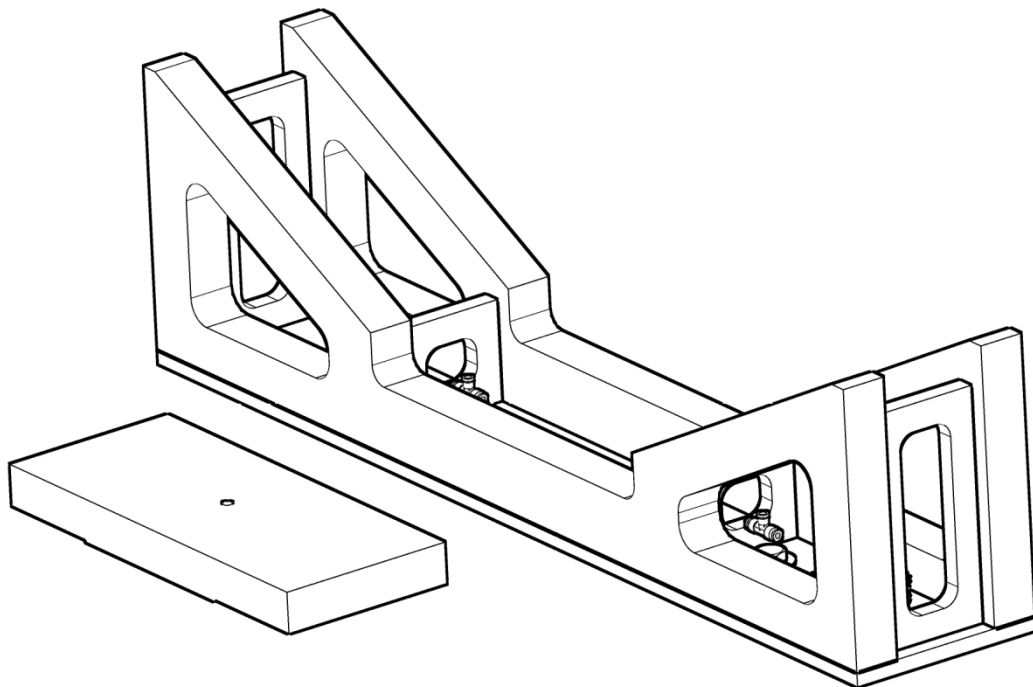
10201 Support Cradle for CAT 3600 V blocks



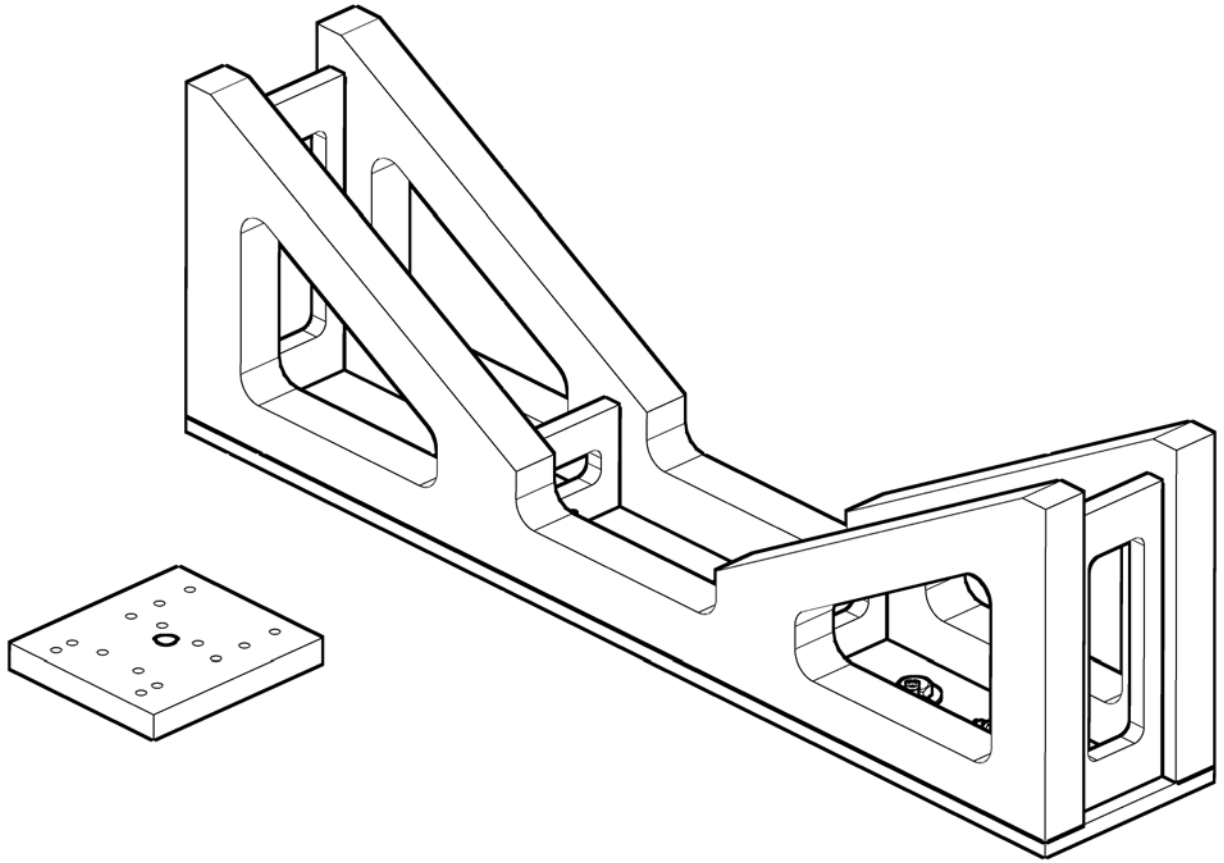
10204 Support Cradle for CAT 3600 In-Line Blocks



10202 Support Cradle for Waukesha AT

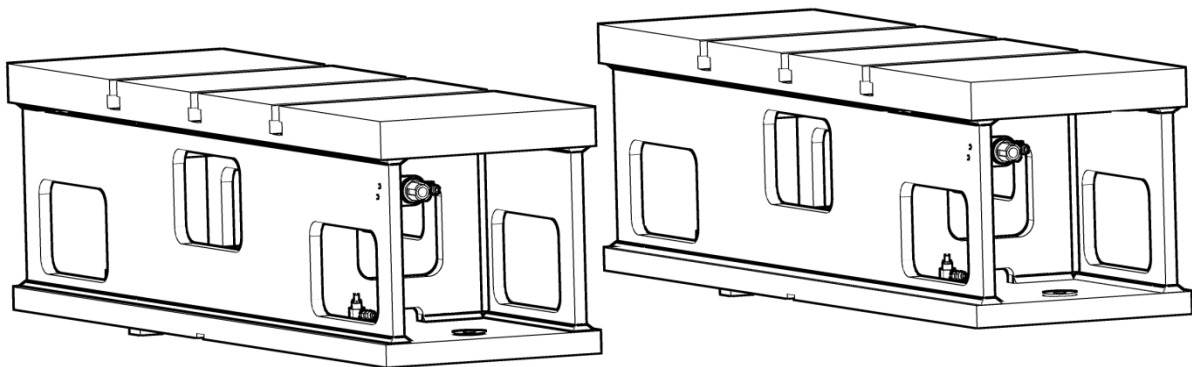


10203 Support Cradle for Superior 2400 V Blocks



10355 PARALLELS

15 1/2" (394 MM) HEIGHT X 55" (1397MM) LONG WITH AIRFLOAT

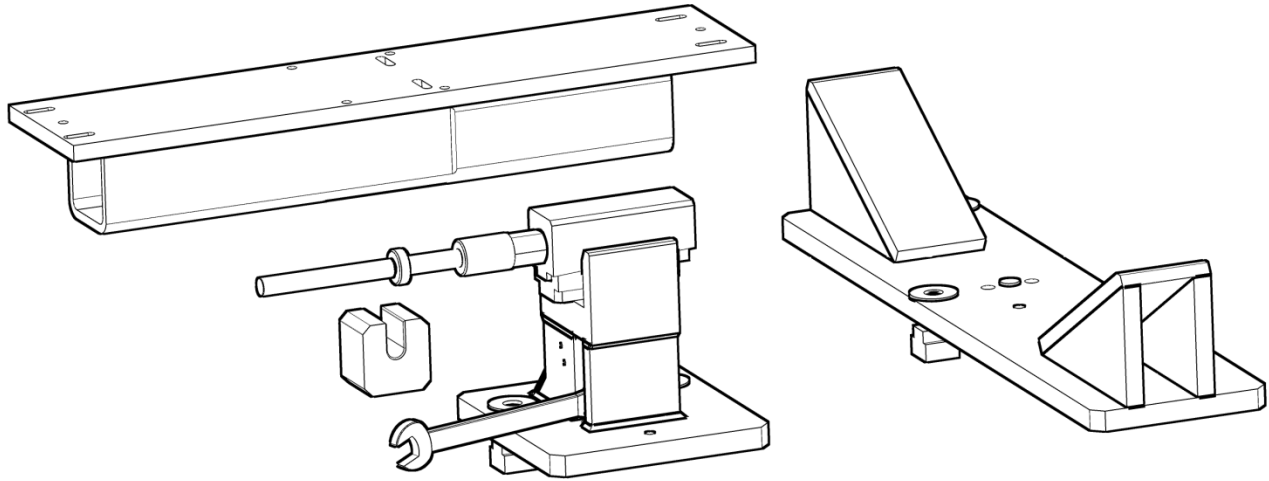


Line Bore Fixturing for Large Blocks

Such as Waukesha 7042, 9390 and White Superior 825 - Requires Parallels 10355

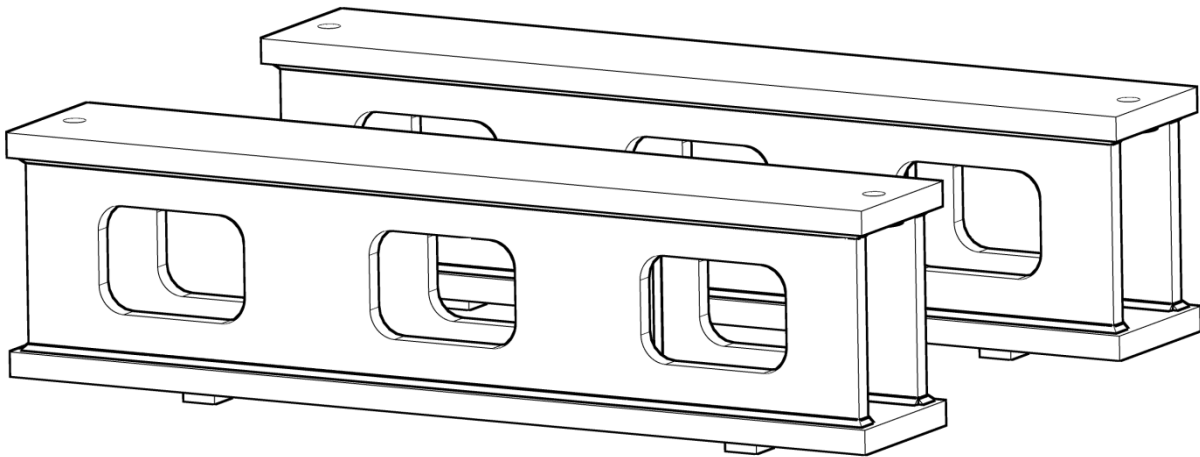
6810 Line Boring Fixture

Waukesha 7042, 9360 and CAT 379, 398, 399



6815 White Superior 8G825 Line Boring Fixture

Requires Fixture 6821



6846 White Superior 12 & 16 G825 Line Boring Fixture
Requires Fixture 6821

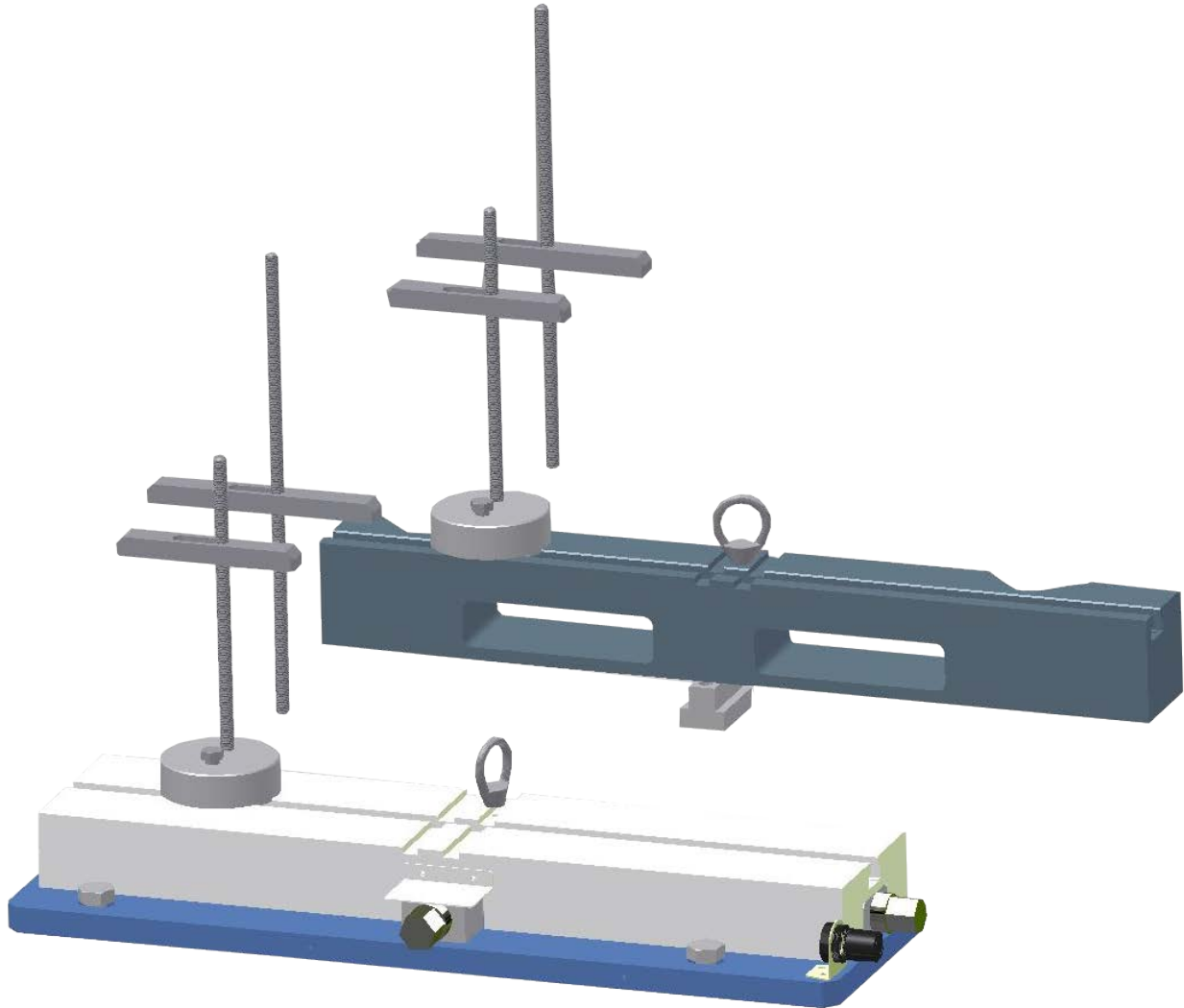
Replace this box with correct
illustration when available

Line Bore Fixturing for Large Blocks

Such as CAT 3500, MTU 4000, Cummins QSK

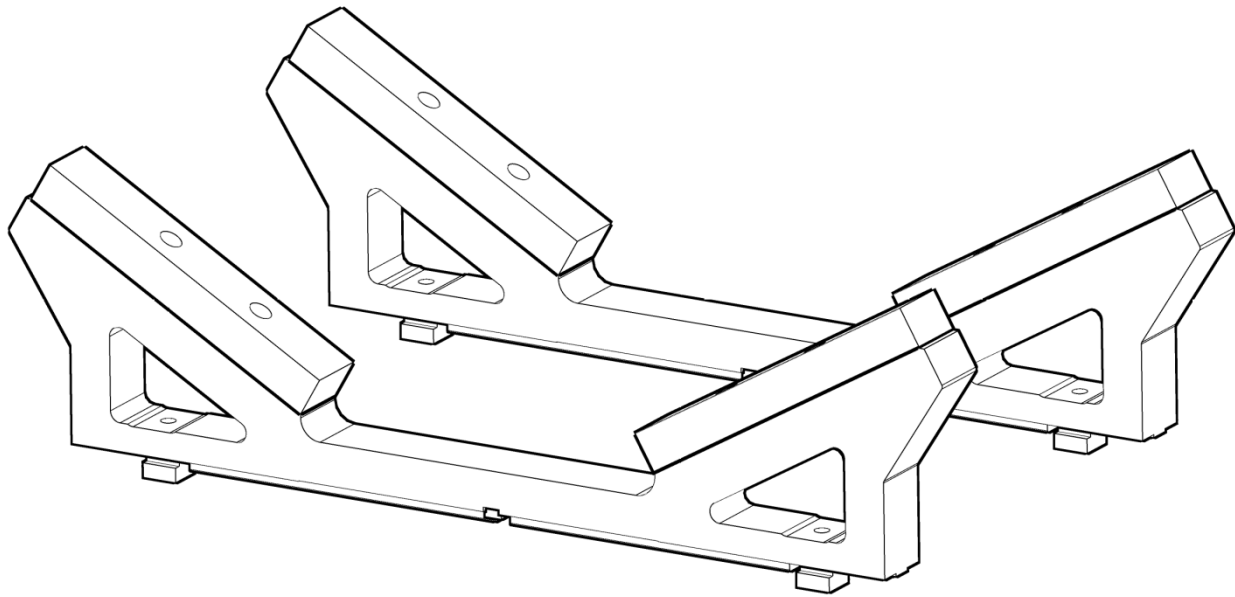
6821 Adjustable Universal Line Boring Parallel Assembly

Includes Locators for Mir Range In-Line Blocks, Supports for V Blocks Must Be Ordered Separately, Listed Below.



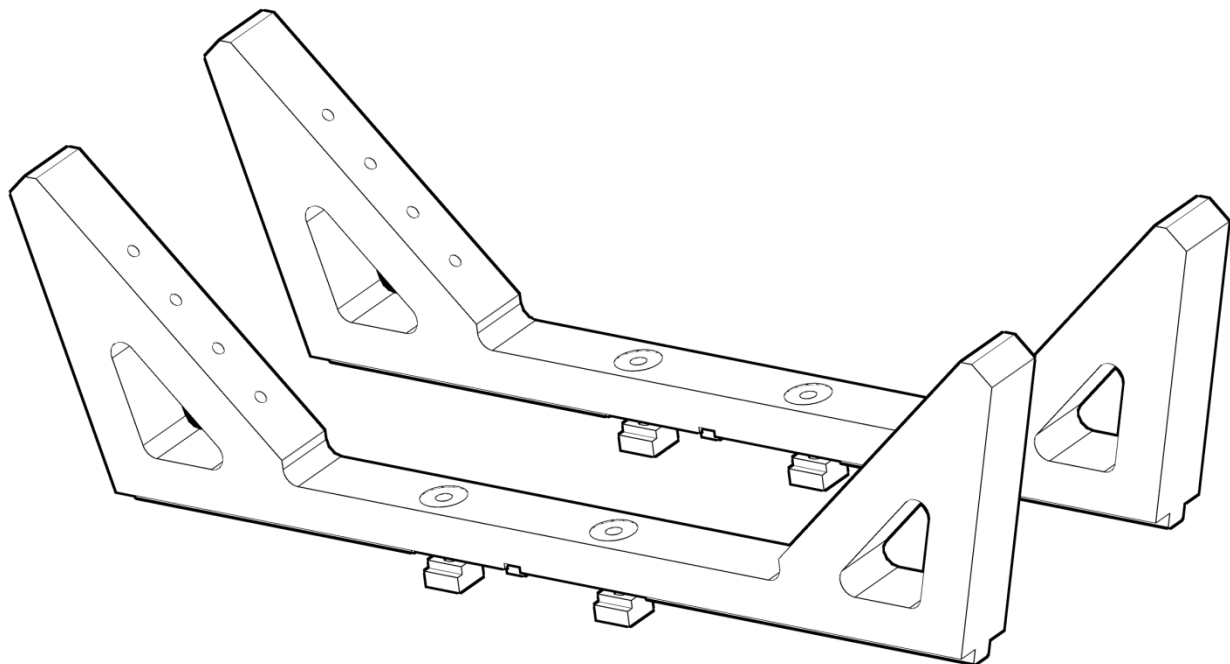
6823B 120 Degree V Block Supports

For Large 120 Degree V Blocks Such as CAT 3500, Komatsu 170 for use on Adjustable Parallels 6821



6823E 90 Degree V Block Supports

For Large 90 Degree V Blocks Such as MTU4000 for use on Adjustable Parallels 6821

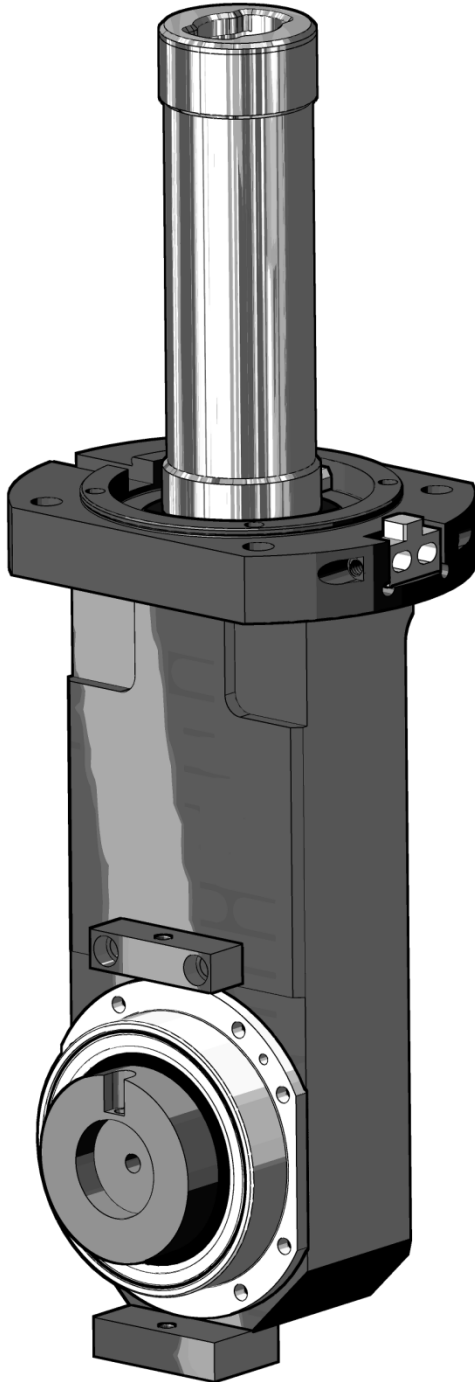


Line Bore Tooling for Small to Large Blocks and Heads

6780 Straight 90 Degree Right Angle Drive Assembly

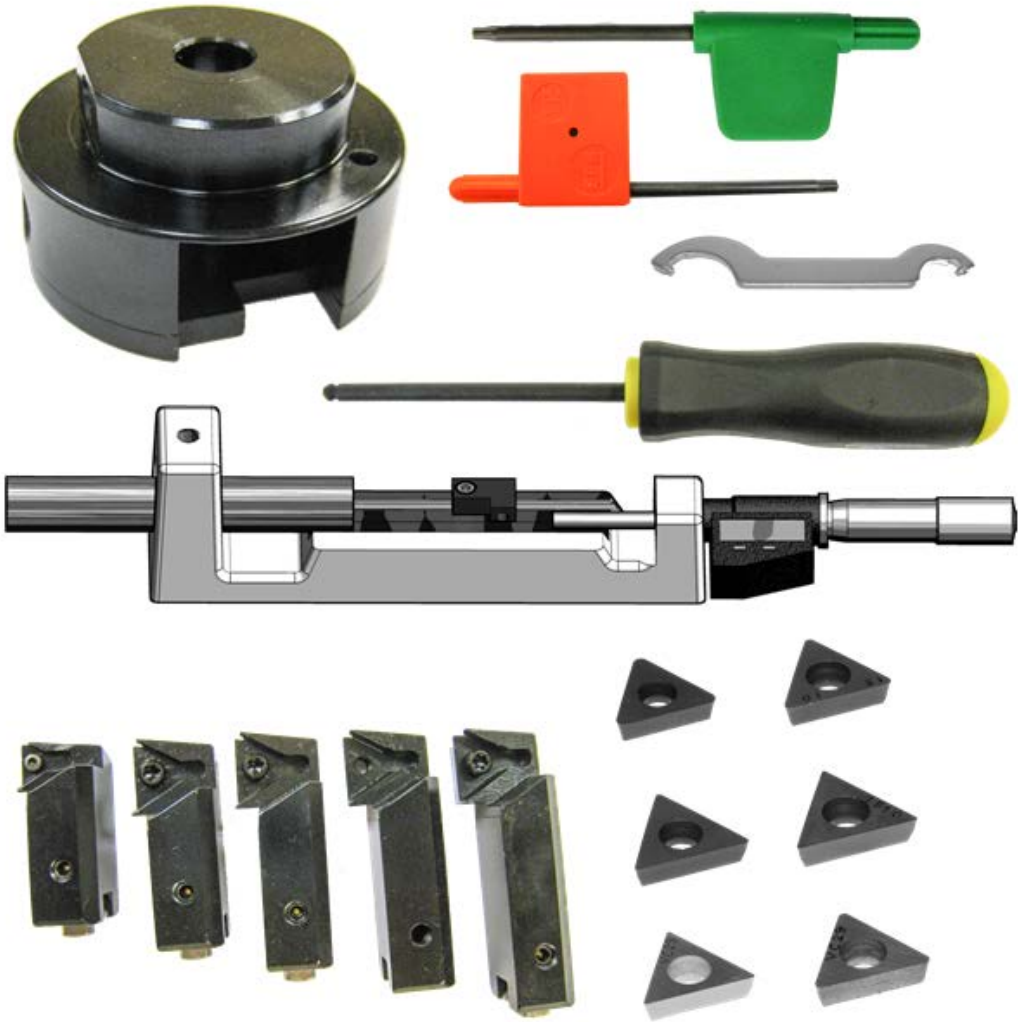
For Medium to Large Blocks. Includes a .41" (10.41mm), .700" (17.78mm), 1.05" (25.725mm), 1.215" (30.86mm) and 1.50" (38.10mm) spacer

Note: Cutterheads are Not Included with Right Angle Drive and Must be Ordered Separately



650-2-39B Line Boring Cutterhead Assembly

1.9 - 4.0" (48.26 - 101.60mm) diameter complete with tooling and Digital Micrometer (When used with 6753J Drive, minimum distance between bearing housings 3.29") (83.6mm)



650-2-39C Line Boring Cutterhead Assembly

2.9 - 5.6" (73.66 - 142.24mm) diameter complete with tooling and Digital Micrometer. When used with 6753J Drive, minimum distance between bearing housings 4.18" (106.2mm)

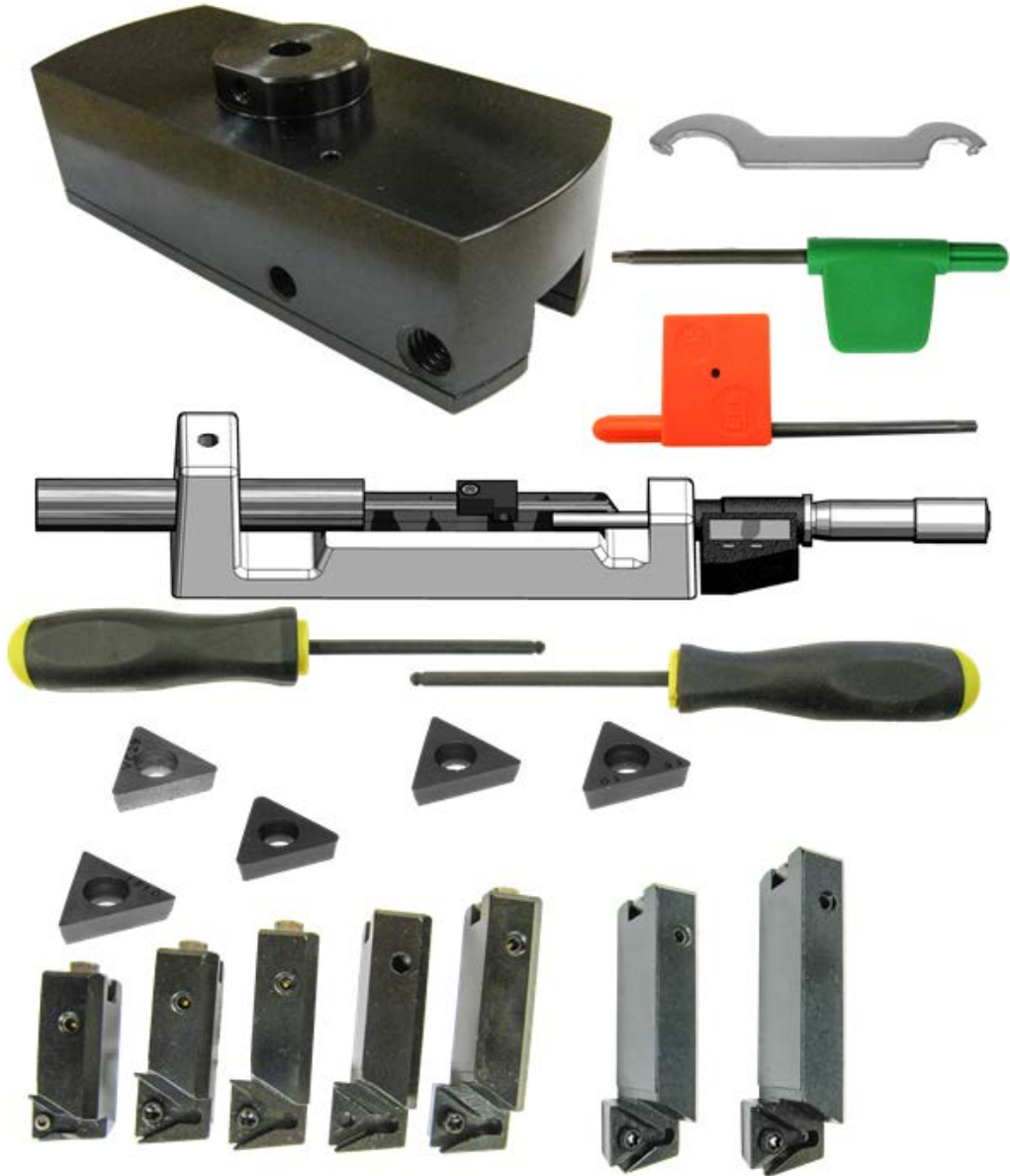
Note: Cutterheads are not included with Right Angle Drive and must be ordered separately



650-2-39A Line Boring Cutterhead Assembly

5.4 - 8.1" (137 - 206mm) diameter complete with tooling and Digital Micrometer. When used with 6753J Drive, minimum distance between bearing housings 4.19" (106.4mm)

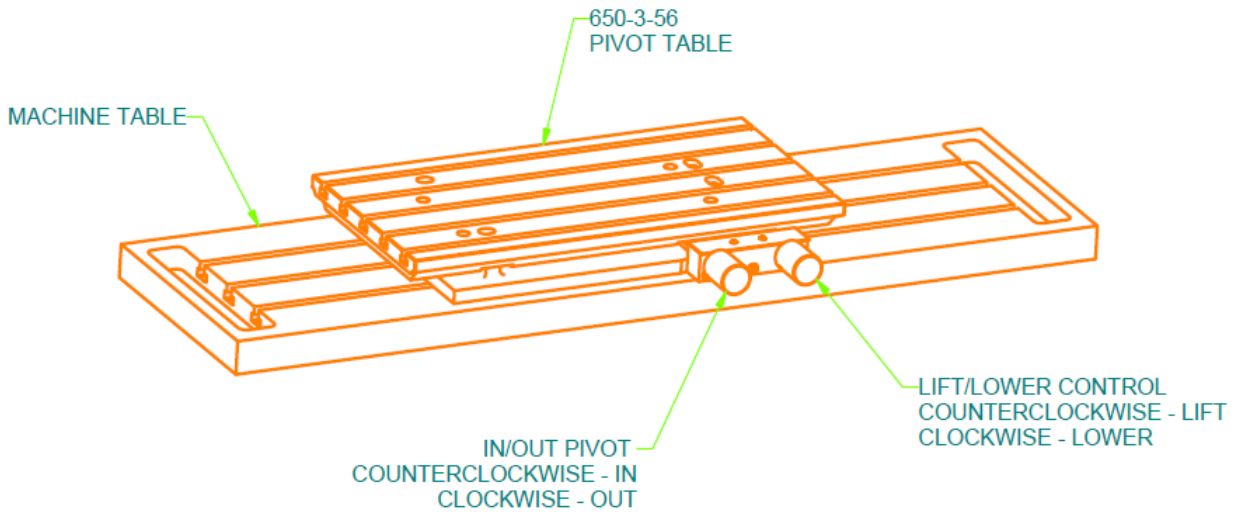
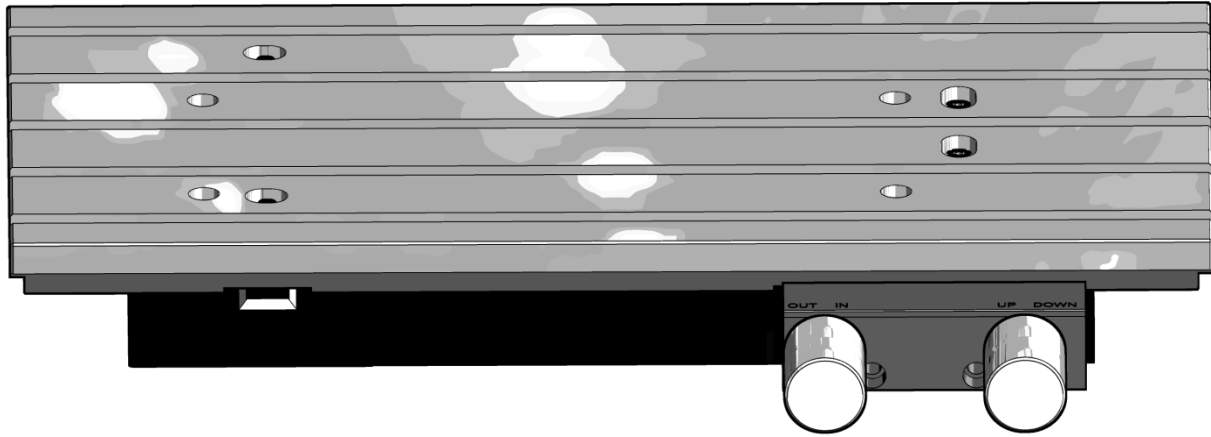
Note: Length of Bores can be Increased with Extension Spacers. The Addition of Extension Spacers will Increase the Minimum Distance Between Bearing Housings by the Length of the Spacer. Allow for Some Clearance Either Side of the Assembly for Safety



Line Bore Fixturing for Small to Large Blocks and Heads

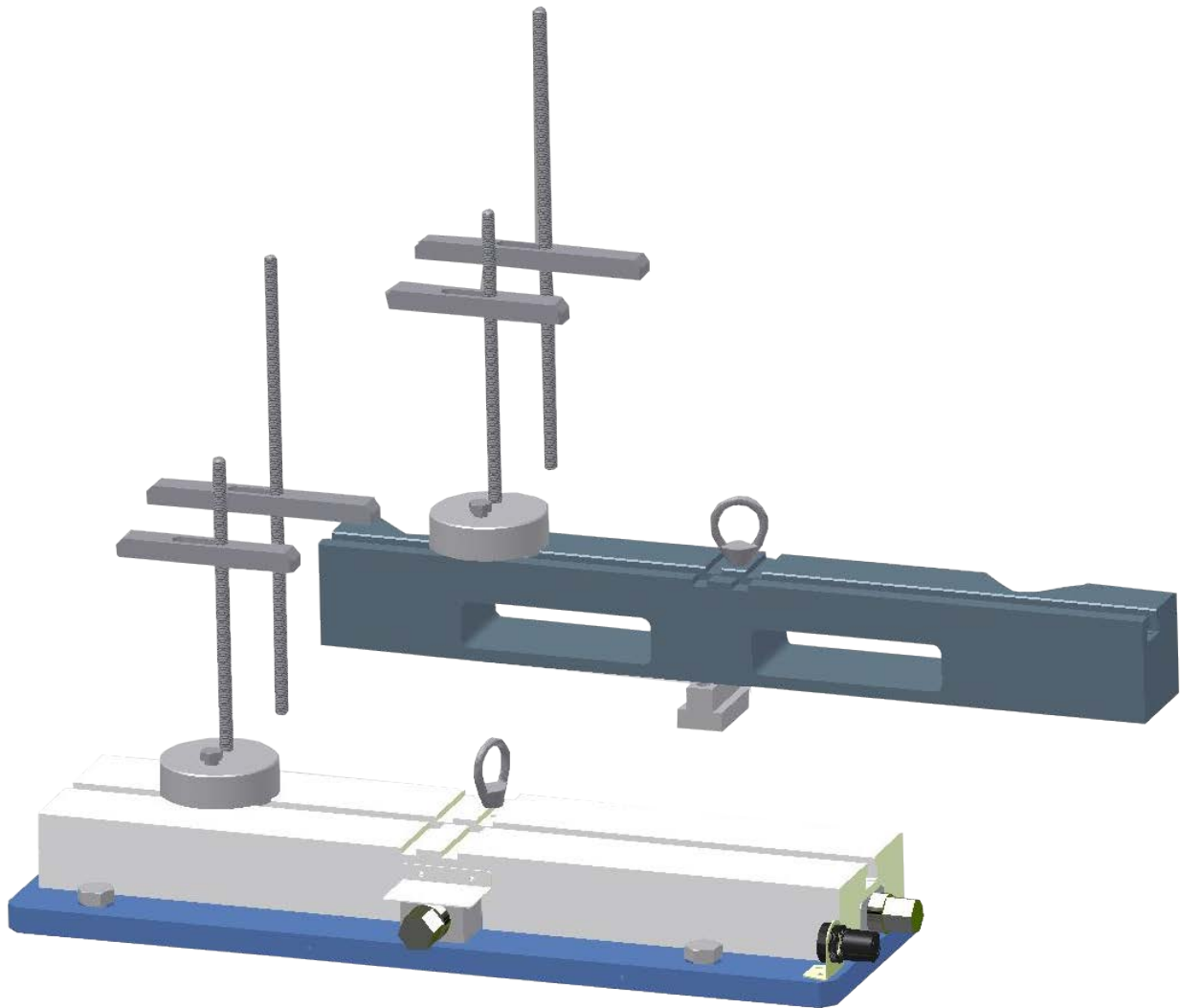
650-3-56 Line Bore Pivot Table Fixture

Complete with Universal Work Holding System for Small In Line and 90 Degree V Blocks, Includes 6843 90 Degree V Block Supports. Also Used for Setting Up Cylinder Heads Such as CAT3406E and Detroit 50/60 Series for Camshaft Line Boring.



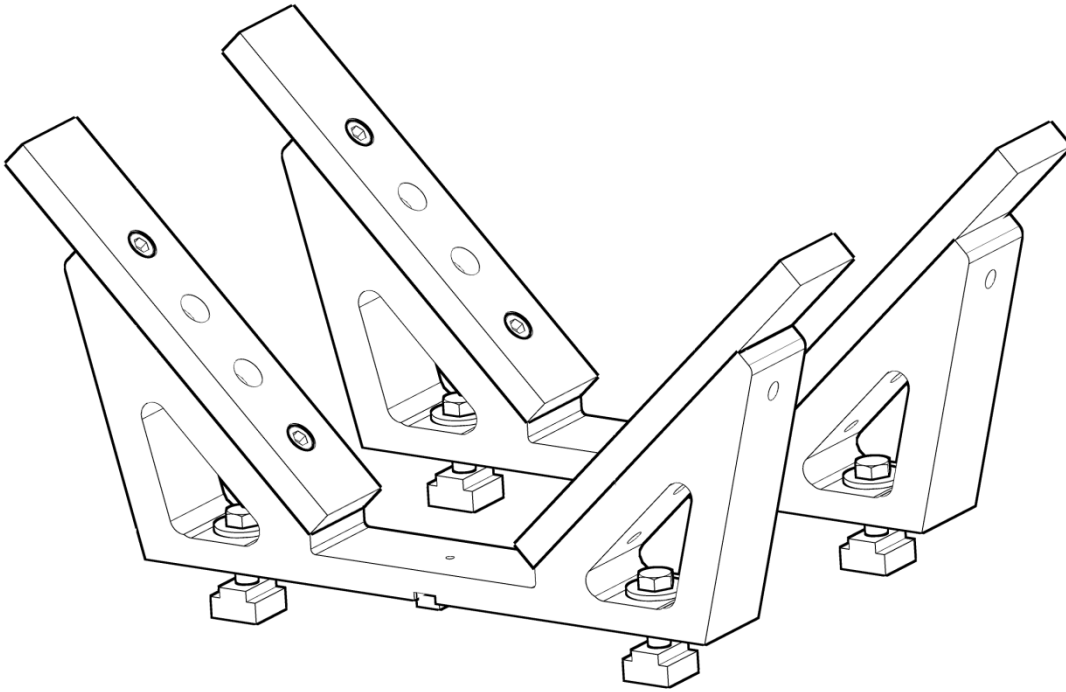
6821 Adjustable Universal Line Boring Fixture Assembly

Includes Locators for In-Line Blocks, Supports for V Blocks Must Be Ordered Separately, Listed Below.



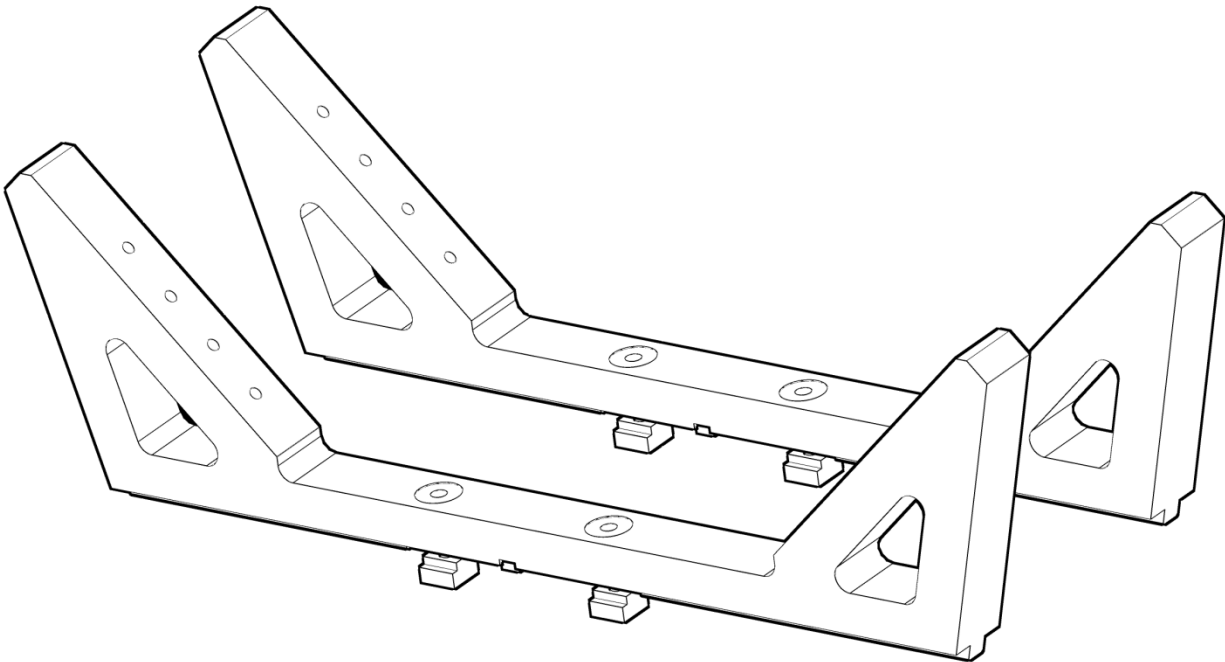
6843 90 Degree V Block Supports

For Small To Mid Size 90 Degree V Blocks for use on Line Bore Fixtures 6821 and 11113



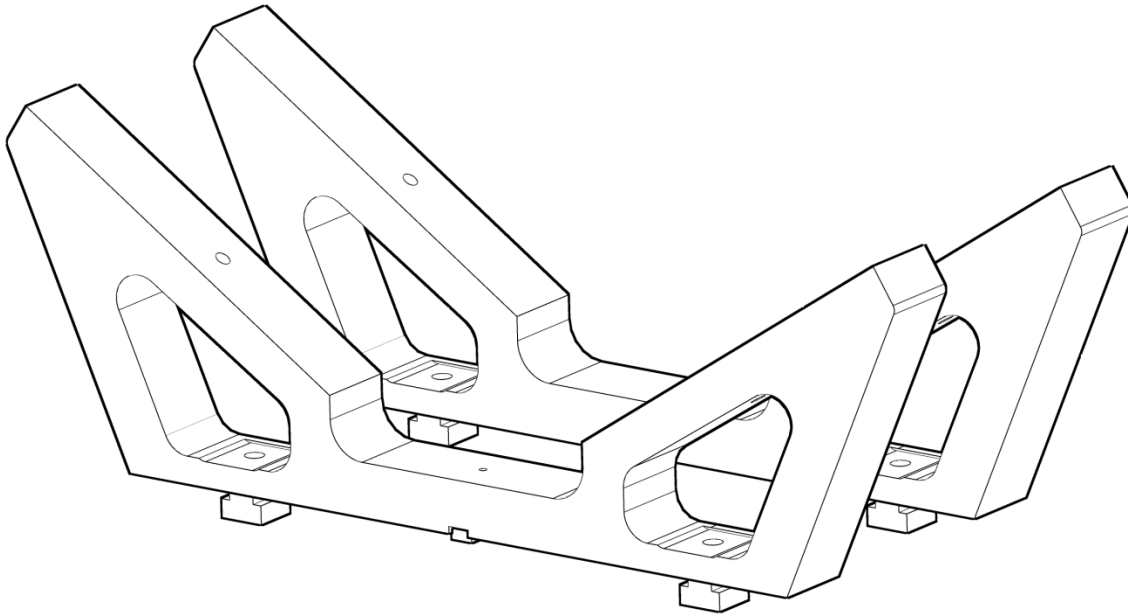
6823E 90 Degree V Block Supports

For Large 90 Degree V Blocks Such as MTU4000 for use on Line Bore Fixture 6821



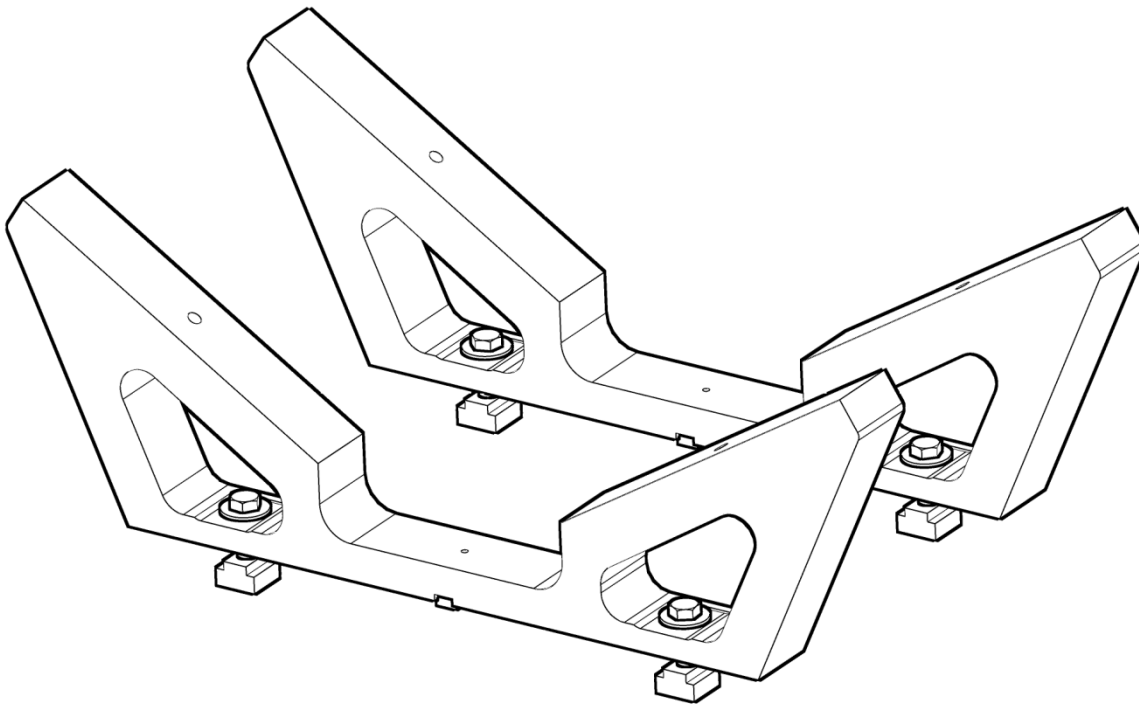
6789L 113 Degree V Block Supports

For Detroit Diesel V53 for use on Line Bore Fixture 6821 and 11113



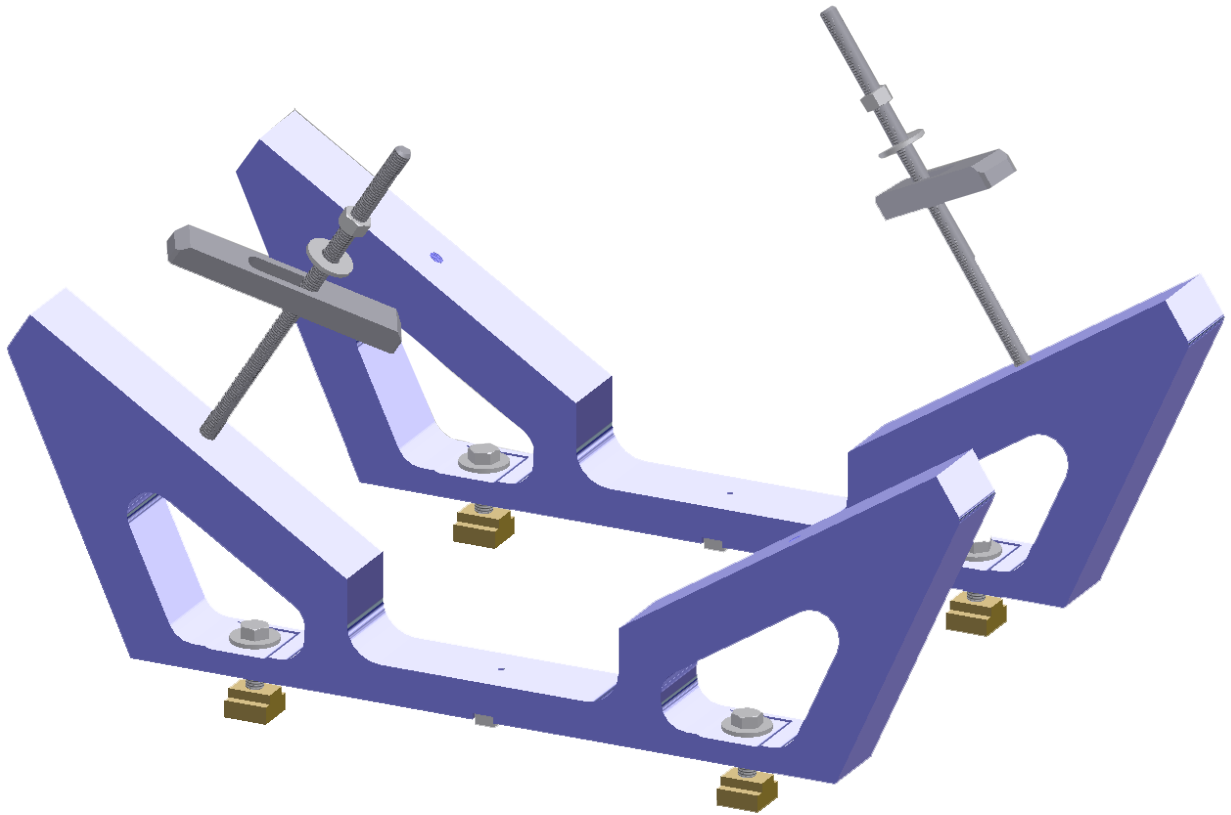
6789N 116 Degree V Block Supports

For Detroit Diesel V71 & V92 for use on Line Bore Fixture 6821 and 11113



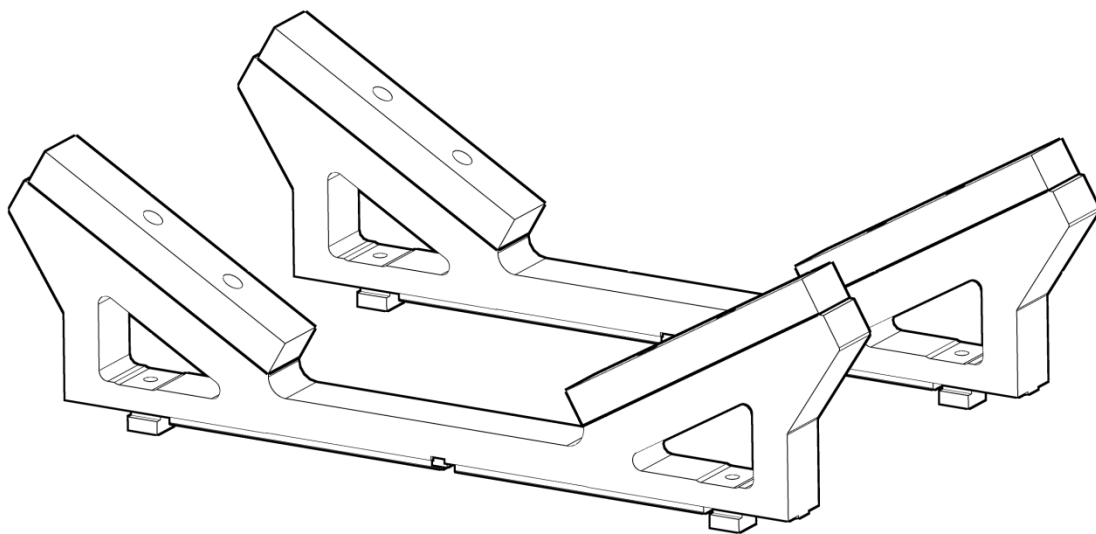
6789E 115 Degree V Block Supports

For CAT 3400 for use on Line Bore Fixture 6821 and 11113



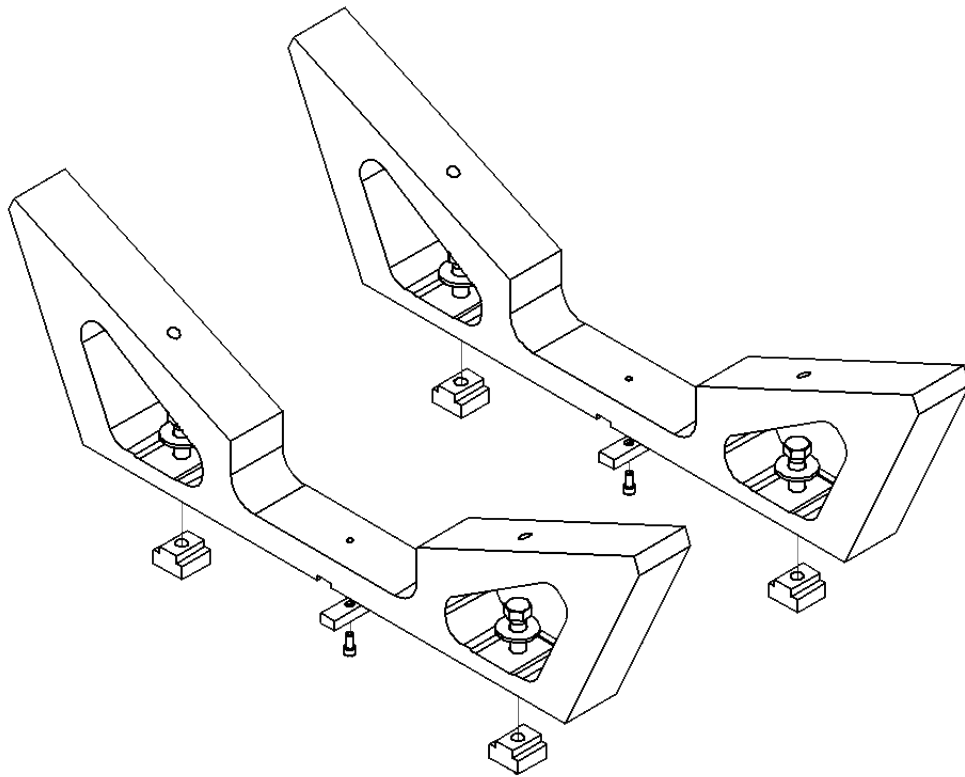
6823B 120 Degree V Block Supports

For Large 120 Degree V Blocks such as CAT 3500, Cummins K & QSK, Komatsu 170 for use on Line Bore Fixture 6821



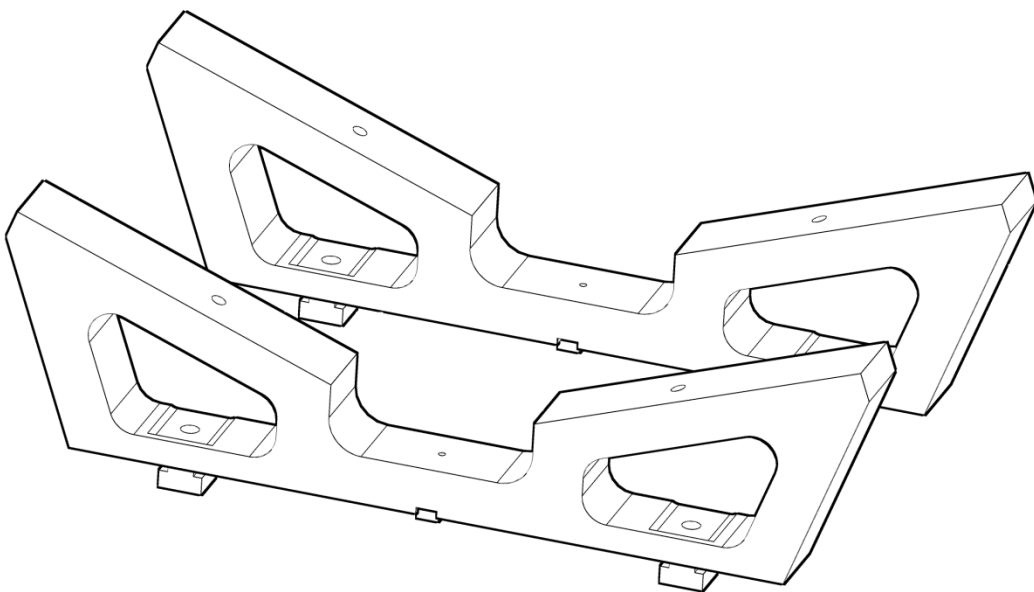
6789K 130 Degree V Block Supports

For Komatsu 140 for use on Line Bore Fixture 6821



6789Q 140 Degree V Block Supports

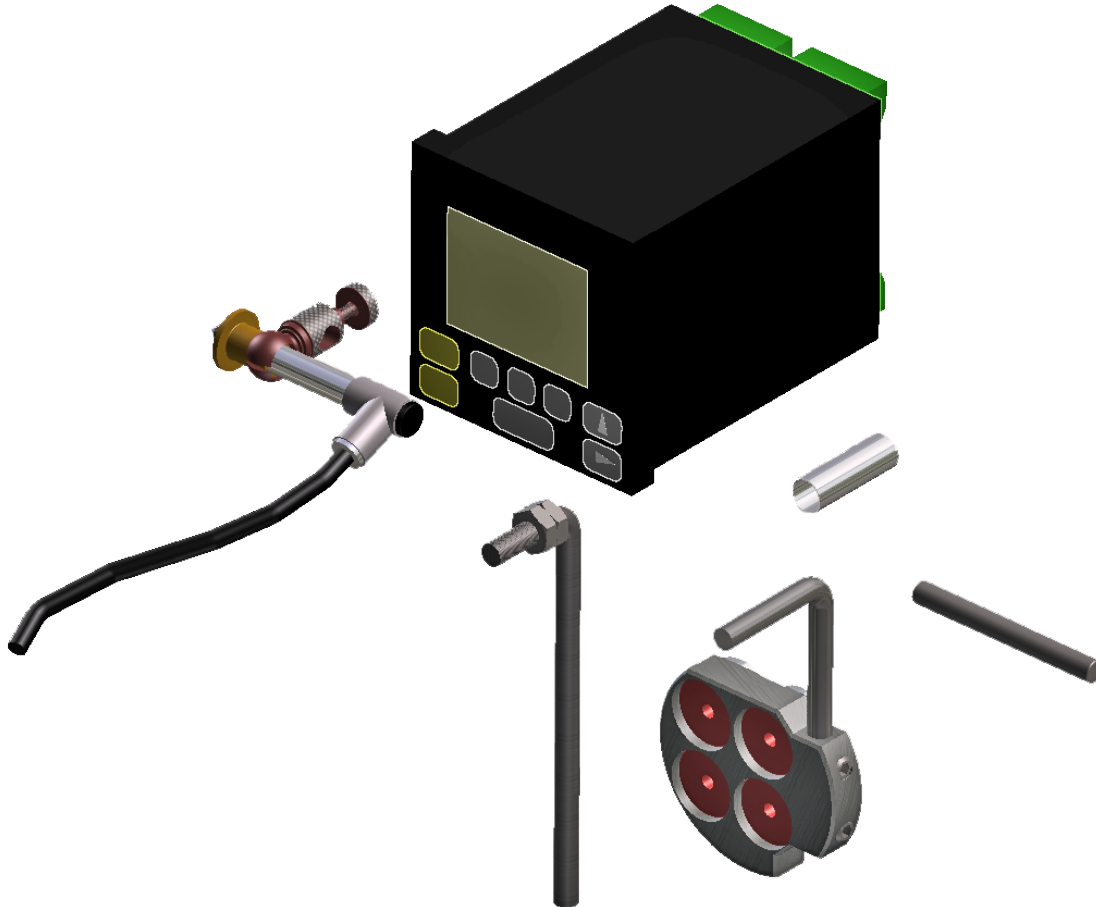
For Cummins 1710 for use on Line Bore Fixture 6821



Line Bore Set Up and Alignment Equipment

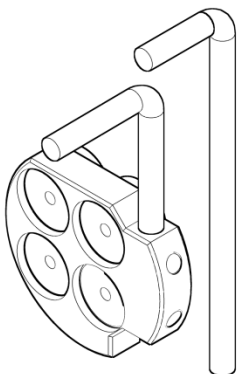
502-12-7B Digital Runout Probe and Readout

Including Magnetic Holder for Block Set Up and Manual Centering of Cylinder Bores and Main Line Bores



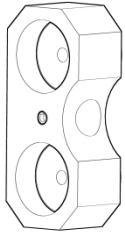
502-12-4 General Purpose Magnetic Indicator Holder

(Requires #502-9-9A or J Indicator)



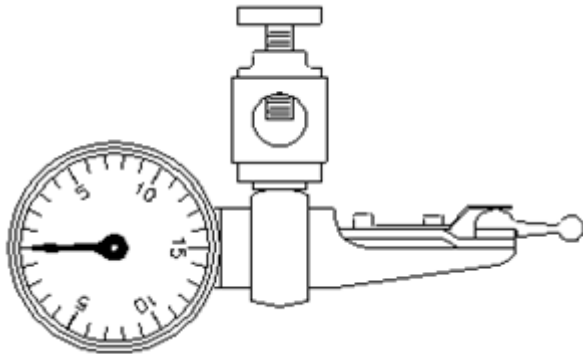
502-12-4A Magnetic Indicator Holder

For 2 - 3" (50 - 75mm) Diameter (Requires 502-9-9A Or J Indicator)



502-9-9A Mechanical Run Out Indicator

General Purpose (.001" Inch Resolution)



502-9-9J Mechanical Run Out Indicator

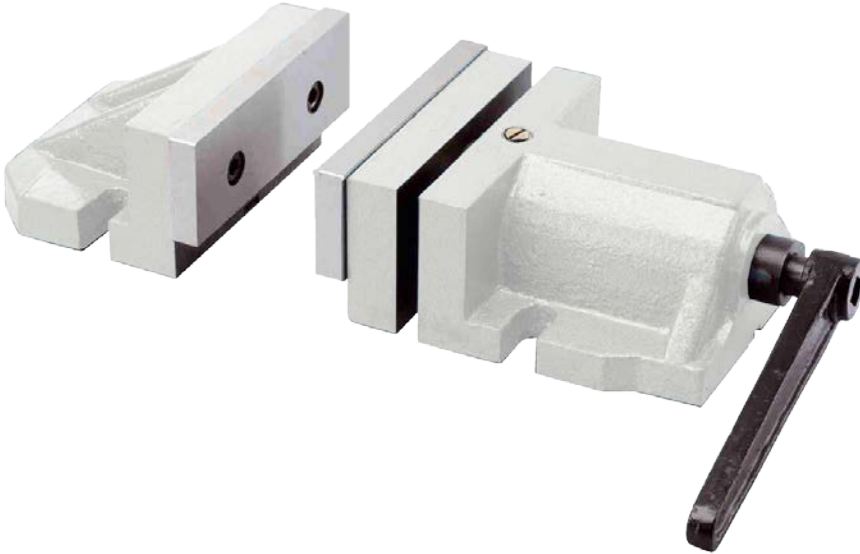
General Purpose (.01mm Metric Resolution)



Equipment for Preparing Blocks for Line Boring

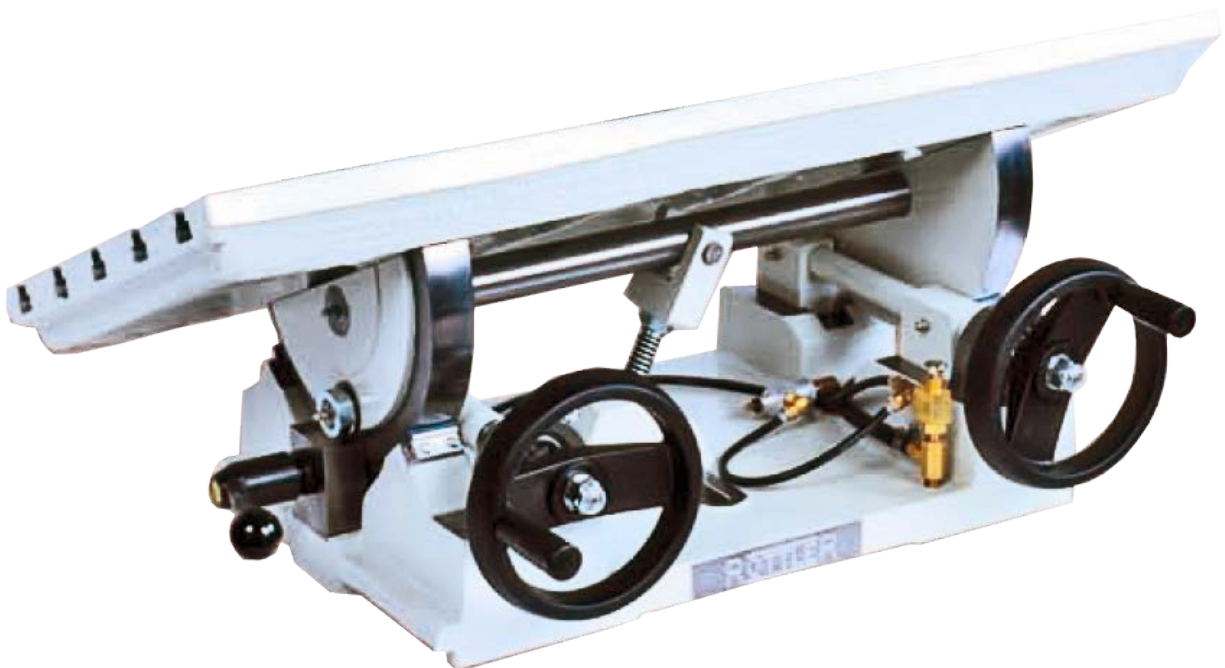
7209N 2-Piece Vise

For Surfacing Main Bearing Housing Caps in Preparation for Main Line Boring. also used for Holding Exhaust Manifolds for Surfacing. Requires 7209M Leveling Table.



7209M Leveling Table With Air Float

Complete with Universal Work Holding System for Surfacing Cylinder Heads and Manifolds. Requires One Set of 6370C Parallels



6514L Shell Mill

5" (127mm) Diameter for Surfacing Main Bearing Cap Register Face in Blocks in Preparation for Main Line Boring



6514V Shell Mill

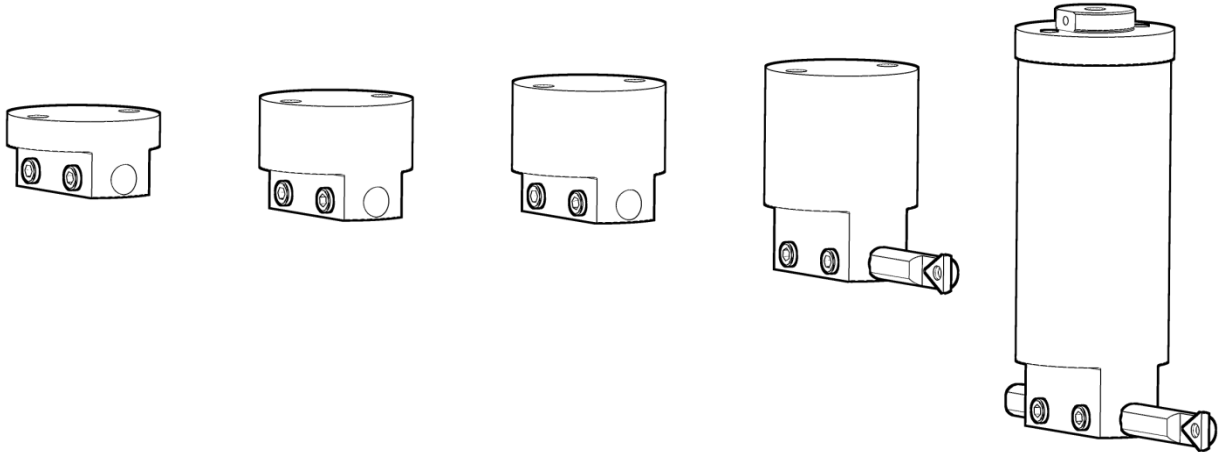
6" (152mm) diameter for surfacing main bearing cap register face in blocks in preparation for main line boring



Equipment for Facing Thrust Bearing Surfaces for Main Line

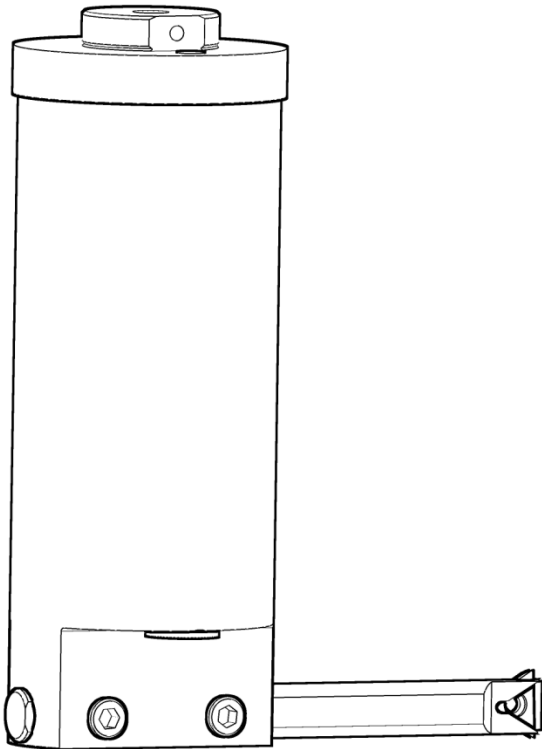
6855C Thrust facing tooling package

For main line bore for small to large blocks



6855G Thrust facing tooling package

For main line bore for extra large blocks

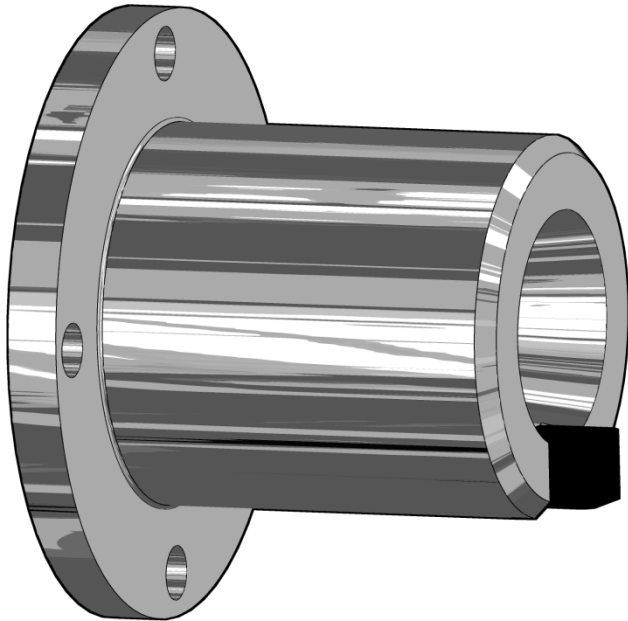


Special Tooling for Block End Machining

Requires Heavy Duty Right Angle Drive 6773F or 6779K

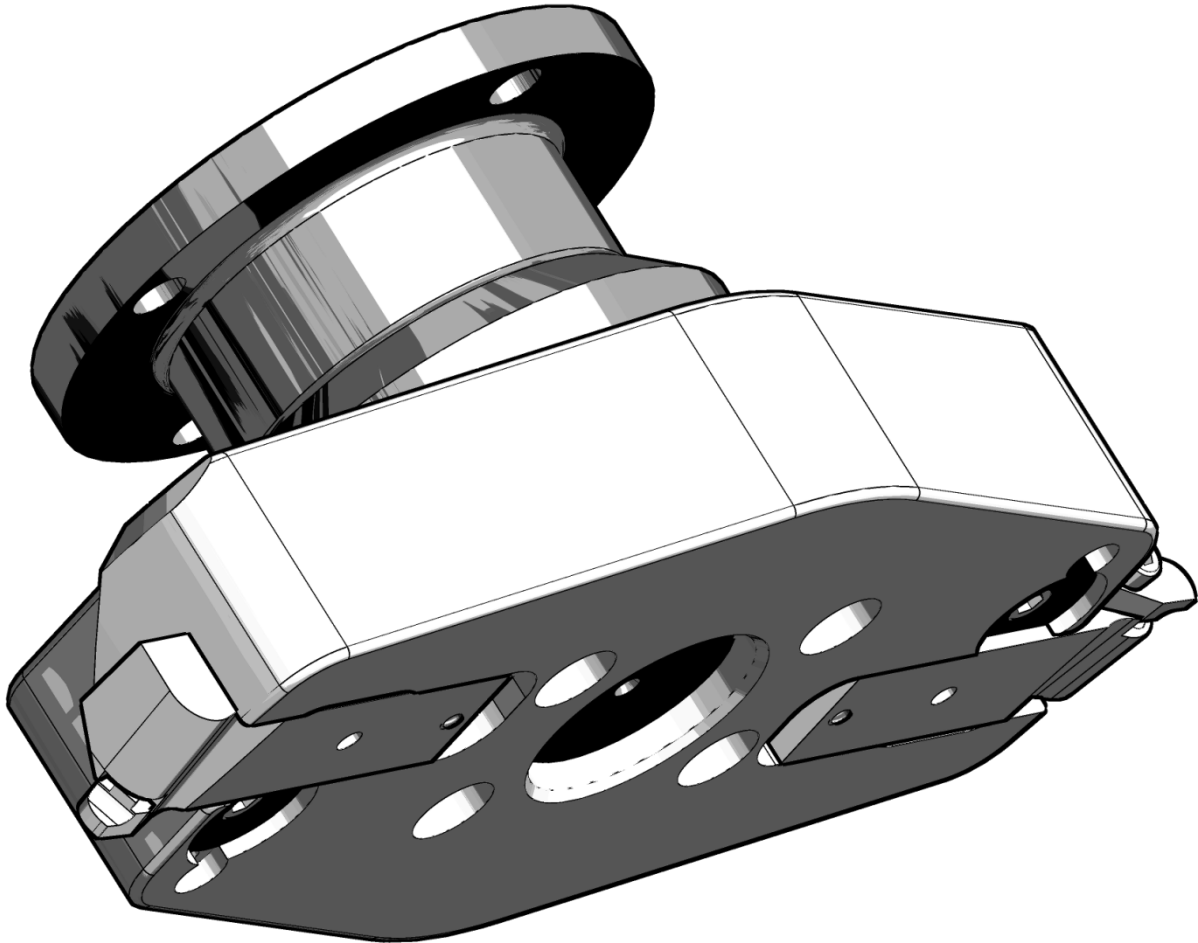
6779H Adaptor

For 40 Taper Tooling such as 6648K Collet Kit



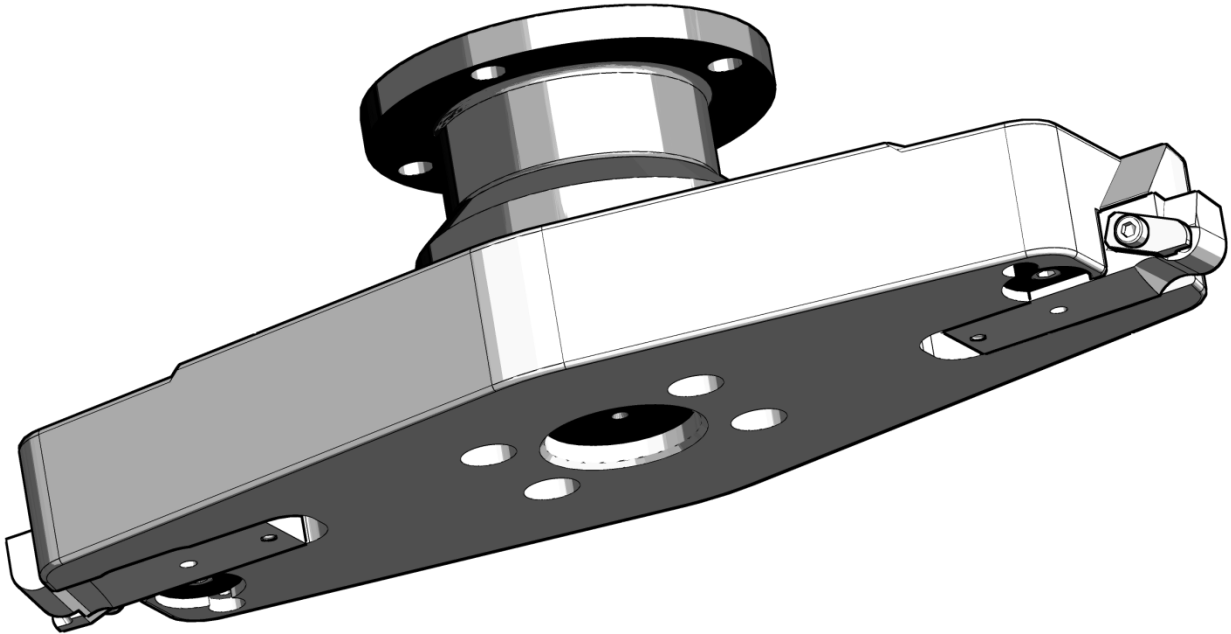
6779L Surfacing Cutterhead Assembly

10" (250mm) Diameter Complete with Toolholders for .375" (9.52mm) round or square inserts for Block End Surfacing



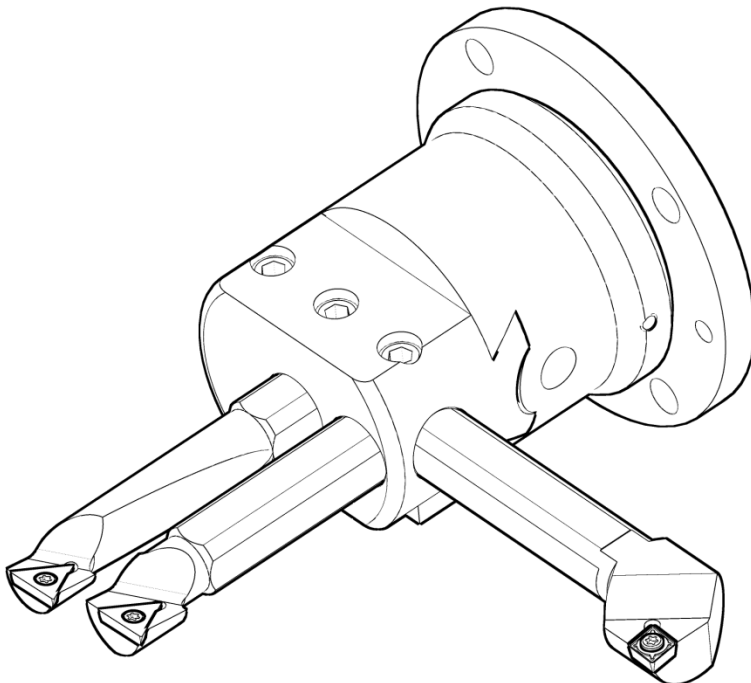
6779M Surfacing Cutterhead Assembly

14" (360mm) Diameter Complete with Toolholders for .375" (9.52mm) round or square inserts for Block End Surfacing



6779N Crossfeed Head Assembly

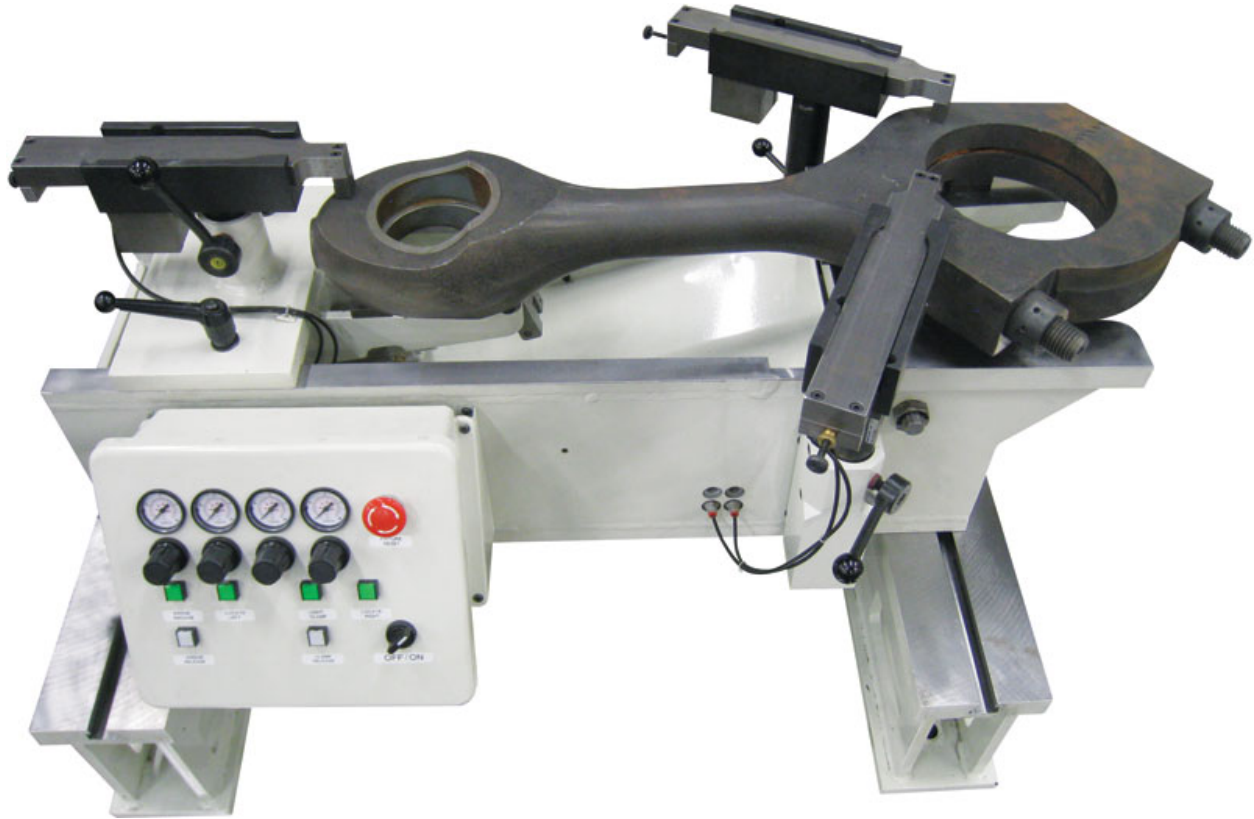
Heavy Duty Offset 90 degree right angle drive



Connecting Rod Boring and Surfacing Equipment

650-3-44R Rottler Precision Connecting Rod Fixturing System

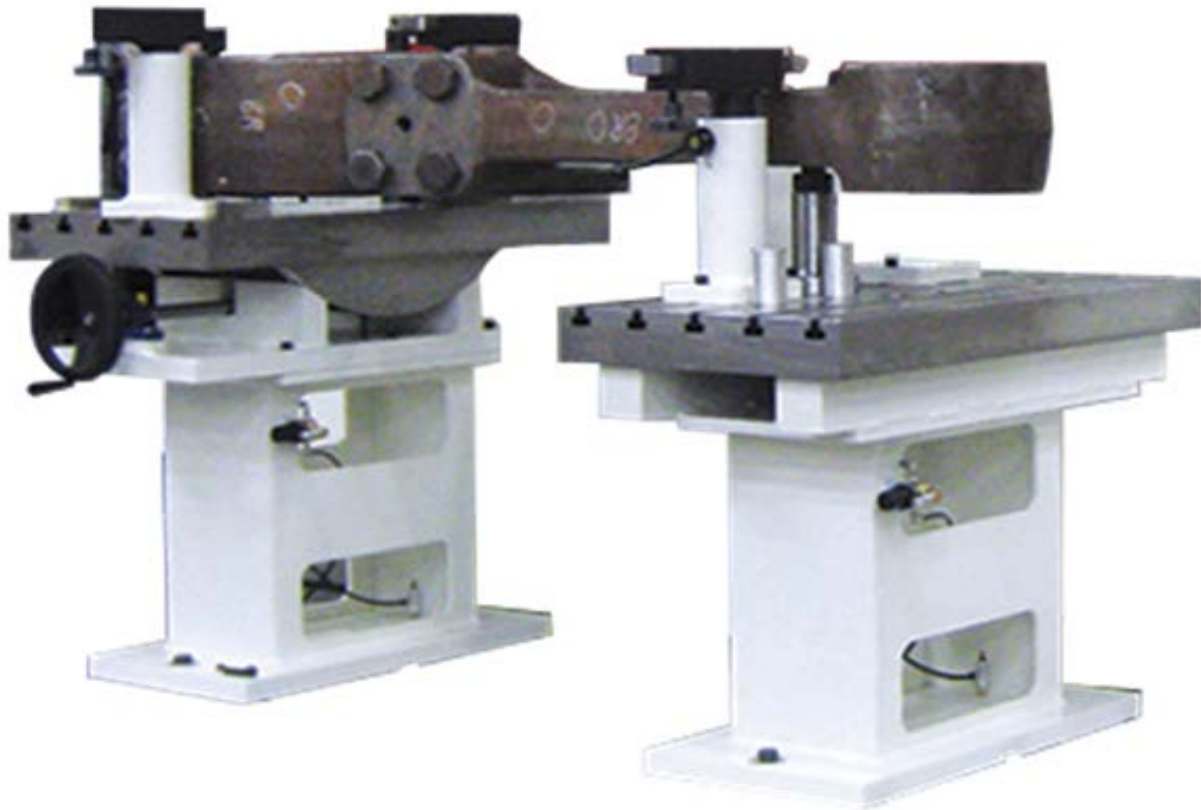
For Connecting Rods Approx. 8 - 24" (200 - 600mm) Center to Center Distance - Requires (1) Set of 6370C Parallels



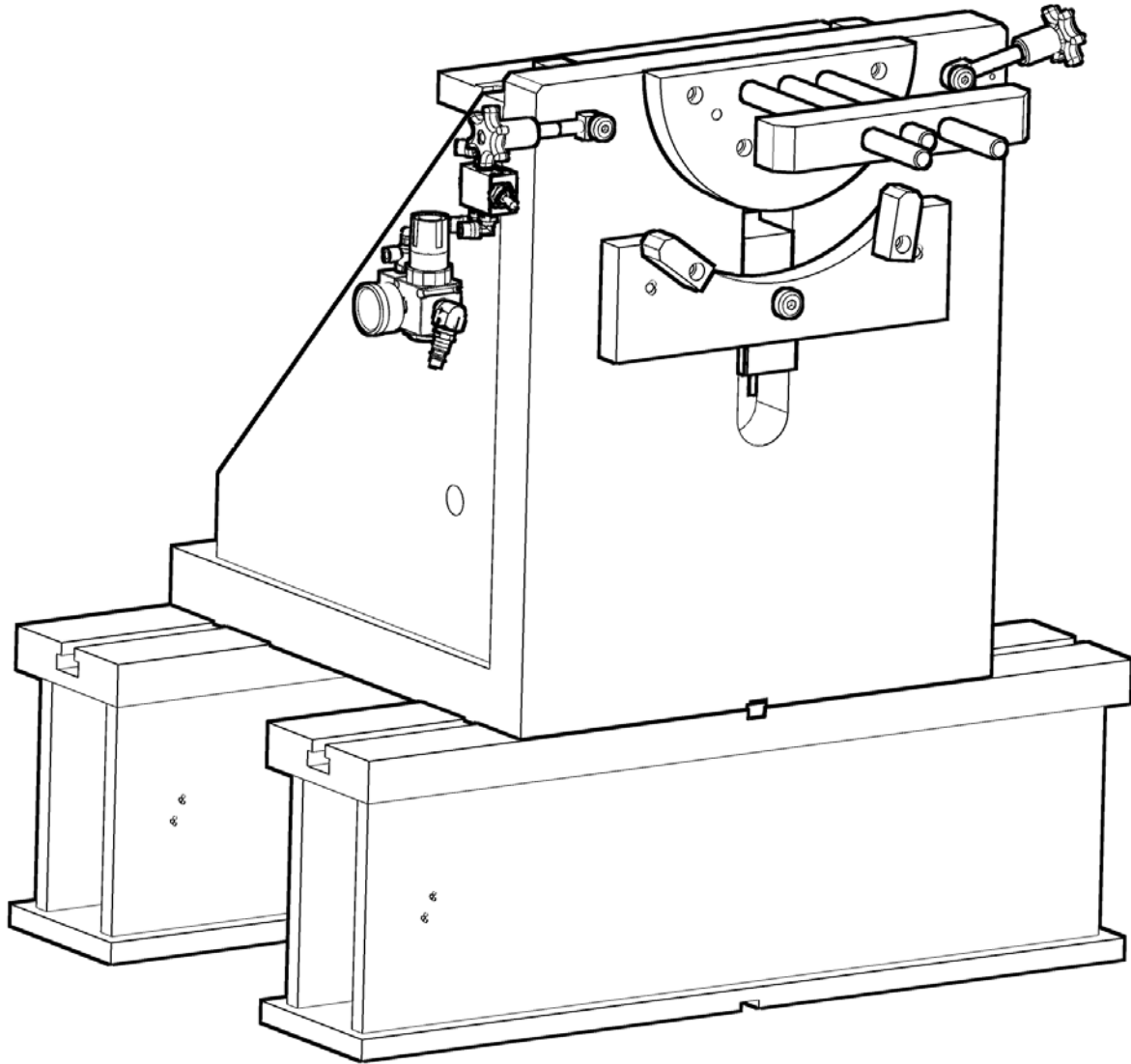
Fixturing & Tooling for Machining Large Engine & Compressor Connecting Rods

650-3-64 Rottler Precision Connecting Rod Fixturing System

Special Version to Handle Natural Gas Compressor Connecting Rods and Large Engine Connecting Rods Such as Waukesha 7042 and White Superior 825 - Requires (1) Set of 6370C Parallels



650-3-66 Rottler Precision Compressor Con Rod Cap Surfacing Fixture
Requires (1) Set 6370Z Parallels



Tooling for Connecting Rod Boring

6516H Blind Hole Cutterhead Assembly

1.5 - 4.2" (38 - 107mm) Diameter X 6.5" (165mm) Length Complete With Tooling and Digital Micrometer



6519Z Blind Hole Cutterhead Assembly

2.9 - 8.0" (74 - 203mm) Diameter X 9.3" (236mm) Length Complete With Tooling and Digital Micrometer



Tool Changing and Storage System for Heavy Tooling

6875A Tool Changing and Storage System

For heavy tooling such as Milling Heads, Flycutters and Right Angle Drives

Replace this box with correct
illustration when available