Legacy Edition

F107/9 SERIES

MULTI-PURPOSE CNC MACHINING CENTER

MACHINE SERIAL NUMBER

_____

OPERATIONS AND MAINTENANCE
MANUAL

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

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⚠WARNING

MACHINE HAZARDS
Do not operate this equipment without prior training and instruction.
Failure to comply will cause serious injury.

READ THE SAFETY CHAPTER BEFORE INSTALLING MACHINE. THOUGHERLY UNDERSTAND ALL SAFETY ISSUES BEFORE OPERATING MACHINE.

ATTENTION OWNER/BUSINESS MANAGER

To validate the warranty on your new Rottler machine, please be sure to sign and complete the "Installation Report" located in the Installation Chapter of this manual.

We suggest that the new user of the F107/9 read the CONTROL DEFINITIONS to get an idea how the machine operates.

The Operating Instructions chapter should be read in order to familiarize the user with the actual button pushing sequences required to carry out a job. These chapters in the manual should be considered an introduction. As the operators of the F107/9 series machines gain experience with using the different functions of the machine, complicated setups and programs will make more sense.

The rest of the manual contains information and part number reference on fixtures, cutting tools, and machine maintenance. The operator should read and become familiar with these areas as well.

Description

The model F107/9 machine is a precision, single point boring, and high-speed surfacing unit. The machine can be equipped with tooling and accessories for surfacing and re-boring most American passenger car and truck engines, In-lines, as well as 90 and 60 degree V-types.

F107/9 machines can be easily tooled, to machine a wide range of engines, including European and Asian engines, also, the machine can be easily adapted to perform other boring and surfacing operations.

The machine is designed, to maintain alignment of cylinder bores, and cylinder head, deck surfaces to the pan rails and main bearing bore locations, as was done in the original factory machining. This overcomes the many inaccuracies and out-of-alignment problems associated with clamping portable boring bars to the cylinder head surface of blocks.

Convenient controls, fast block clamping, precise 3 axis CNC positioning and clamping, means considerable savings in floor to floor time, and operator involvement.

Change over or resetting time required to set up V-type or in-line engines is a minimum, making this machine highly suited to the jobber shop where engines cannot be run through in model lots.

All feeds and rapid travels are power operated and controlled form the control panel.

Disclaimer

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Limited Warranty

Rottler Manufacturing Company Model F107/9 parts and equipment is warranted as to materials and workmanship. This limited warranty remains in effect for one year from the date of delivery, provided the machine is owned and operated by the original purchaser and is operated and maintained as per the instructions in the manual.

Tools proven to be defective within the warranty period will be repaired or replaced at the factory's option.

The products are warranted upon delivery to conform to their published specifications and to be free from defects in material and workmanship under normal use for a period of one year from shipment. Should a product not be as warranted, Rottler sole obligation shall be, at its option, to repair, correct or replace the product or to refund the amounts paid for the Product upon its return to a location designated by Rottler. No warranty shall extend to rapid wear Products (including tooling) or to Products which have been subject to misuse (including any use contrary to Rottler instructions), neglect, accident (including during shipment), improper handling or installation, or subject to any modification, repair or service not certified by Rottler. Rottler shall not be liable for any consequential, direct or indirect damages or for any other

injury or loss. Buyer waives any right, beyond the foregoing warranty, to make a claim against Rottler. No warranty is provided for any Products not paid in full.

Merchandise cannot be returned to Rottler without prior approval. Customer must contact the Order Department or representative to get approval and to be issued a Return Goods Authorization number **(RGR#).** Merchandise authorized for return must be returned prepaid. If merchandise is returned with shipping charges collect, the actual amount of these charges may be deducted from any credit which may be due the customer. The **RGR #** assigned by the Order Department should be written on the shipping label and must appear on a copy of the invoice(s) covering the original shipment. This invoice copy must be included in the box with the parts. Shipment must contain ONLY those items on the **RGR** as approved for return. Merchandise must be received within 10 days of the date of **RGR** or the **RGR** will be canceled. All returned merchandise may be subject to a 20% restocking fee on under $1,000.00 amount or 10% on any items over $1,000.00. Parts or tooling over 30 days old are considered as customer property and can only be returned with prior written approval from Rottler Corporation Management and/or Shipping Department.

The issuance of a **RGR DOES NOT** guarantee credit - it is only authorization for the return of the goods. Credit for return merchandise is at the sole discretion of Rottler. Credit will be issued only after inspection of returned goods.

Tools proven to be defective within the warranty period will be repaired or replaced at the factory's option. We accept no responsibility for defects caused by external damage, wear, abuse, or misuse, nor do we accept any obligation to provide compensation for direct or indirect costs in connection with cases covered by the warranty.

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ATTENTION OWNER/BUSINESS MANAGER

To validate the warranty on your new Rottler machine, please be sure to sign the installation report after the installation technician has installed the machine and verified the machine is operating correctly and given the operators operation and maintenance training.

Thank you for your cooperation and the opportunity to be of service to you.

ROTTLER MANUFACTURING

Route to: Andy ⟶ Machine Packet File
F100 Installation Report Rev 11082013

ROTTLER F100 SERIES INSTALLATION REPORT

ROTTLER MANUFACTURING MUST HAVE THIS REPORT RETURNED TO PROPERLY QUALIFY WARRANTY ON EQUIPMENT

Customer:_____ Address:_____
City:_____ State:_____ Zip:_____ Phone:_____
Machine Model:_____ Serial Number:_____ Representative:_____

MACHINE INSTALLATION: Electrical information MUST be complete to validate this report.

The following is the customer's responsibility prior to the arrival of Rottler technician. Please initial each item when it is completed.

Customer must provide foundation and hold down bolt system, see following attached drawing and document "F70 and F100 Series Foundation and Hold Down Requirements"

⚠ CAUTION

VERY IMPORTANT: Modern design machines contain electronic low voltage circuitry that provides great advantages and a better machine life. **BUT**, you must have an excellent, stable, isolated power supply along with an isolated ground. If not, electrical noise problems are likely to interfere with machine operation unexpectedly.

Customer is responsible for providing electricity to machine in a manner that meets the local electrical code requirements.

_____Remove machine from truck. Weight: F103 14,000 lbs (6,350 kg) F104 16,000 lbs (7257 kg) F105 18,000 lbs (8165 kg) F107 45,000 lbs (20,412 kg) F109 50,000 lbs (22680 kg).
_____Remove fixturing and misc. parts from machine and clean.
_____Install machine on foundation with supplied jack pads under jacking bolts.
_____Install hold down nuts and bolts, see attached document. – This must e done first.
_____Rough Level the machine using a precision level so there is equal tension on all bolts.
_____This machine requires between 208 and 240 Volts AC, Three Phase, 50/60 Hz, isolated power supply. For voltages above 240 or below 208 VAC, a 17kva transformer will be required and is available at Rottler. Please specify voltage when ordering. Measure the incoming voltage between L1 and L2, L2 and L3, and L1 and L3. Current requirements for this machine is 60 amps. Measure the incoming AC voltage at least twice during installation.
1. L1to L2 _____VAC, L2 to L3 _____ VAC, L1 to L3 _____
2. L1to L2 _____VAC, L2 to L3 _____ VAC, L1 to L3 _____

_____Measure each leg of the incoming supply to ground.
L1 to ground _____VAC L2 to ground _____VAC L3 to ground _____VAC

⚠ CAUTION

Neutral and machine ground are not the same thing. You should measure an open circuit between Neutral and ground.

⚠ CAUTION **IF VOLTAGE IS OUTSIDE THE CORRECT RANGE AT ANY TIME THE MACHINE WILL NOT OPERATE PROPERLY AND MAY BE DAMAGED.**

_____Air of the proper pressure and capacity connected to the machine. Air supply must be free from oil and water. Oil or water will damage electrical and air components.
_____Customer should attempt to have junk work piece available.
_____Have the operator read through the operation manual before training begins. This will help him be familiar with the button pushing sequences. Have the operator read through the manual again after training and some of the sequences will make more sense.
_____Have Internet connection available for the machine. Either via Ethernet cable or Wireless. The machine comes equipped with a wireless USB adapter.

The following is the Rottler technician's responsibility

_____Check column top and spindle base bottom for rust and nicks if spindle must be installed. Clean and stone as required.
_____When lifting spindle unit, keep in mind the front to back center of gravity is located approximately 12 inches form the front end and has a tendency to lean forward.
_____Recheck/Inspect all wire connections with a screwdriver for security. Stranded wire used in these machines can spread and loosen a connection when shipping.
_____Each main system is protected internally by circuit breakers. Green indicates the breaker is "tripped" and red indicates the breaker is "Hot" (conducting electricity).
_____Clean any rust inhibitor from the machine surfaces. Move the column from side to side continually cleaning the machine base until all inhibitor is removed.
_____Install spindle unit on column, if required, using one of the approved methods described in the operation manual. (Spindle unit weighs 6,000 lbs, 2,800 Kgs.)

Using fork lift angle iron brackets

_____Bolt brackets to each side of the spindle base.
_____Use large C-clamps to clamp the fork lift forks to the angle iron brackets. This will prevent any accidental slips. Loosen ½ 13 x 3 ½ Inch bolts on pendent arm to allow it to be moved out of the way.
_____Use a forklift to lift the spindle unit onto the column. Be careful to watch clearance of all items.
_____Install the Right (Fixed Side Rail) and removable dowel pins. Torque Side Rail bolts to 80 Ft/lbs.
_____Lift spindle unit into place. Push spindle base up against Right Side Rail.
_____Install the Left Side Rail and removable dowel pins. Torque Side Rail bolts to 80 Ft/lbs.
_____Measure the protrusion of the Sides Rails above the spindle base and record. These should be between .035" and .040"
Right: Front _____ Rear _____
Left Front _____ Rear _____
_____Install the Right and Left Top Rails.
_____Remove angle iron brackets form spindle base.
_____Connect air and oil lines per air logic diagram.
_____Remind customer of the proper air pressure and capacity connected to the machine. Air supply must be free from oil and water. Oil or water will damage electrical and air components.
_____Connect electrical wires in main rear enclosure if required using machine wiring diagram.

MACHINE START-UP

When starting the machine for the first time, it may move out of control. Make sure all hands are clear of machine parts. Be ready to press the Emergency Stop button if needed.

_____**BEFORE** turning power on to the machine. Check all wires for security by using the correct screw driver and turning CW until movement stops. Stranded wire can "spread" slightly from vibration during transport.
_____Turn main power on at the main disconnect switch located on the rear enclosure.
_____If machine moves out of control, turn power off and contact factory for help in trouble shooting.
_____If any of the circuit breakers "trip", reset and call factory for possible trouble shooting.
_____Install and test the internet connection to the machine. DO NOT download any updates unless instructed to do so by Rottler.

MACHINE MOVEMENTS

_____Make sure there is nothing obstructing the full vertical, horizontal or In/Out travel of the machine taking special notice of the rear enclosure, way travel and top of the spindle unit.
_____Perform the Inner and Outer spindle adjustments per the instructions in the manual. NOTE: These adjustments must be performed at machine start-up or the travel and accuracy of the machine will be off.
_____Put the machine in hand wheel mode and verify Vertical operation. Put an indicator on the cutter head and verify .001" (.02 mm) movement per detent in course mode and .0001" (.003 mm) in fine mode. If the indicator is jumpy the outer spindle adjustment may be too tight. Refer to manual and re-adjust.
_____Put the machine in hand wheel mode and verify Horizontal operation. Put an indicator on the cutter head and verify .001" (.02 mm) movement per detent in course mode and .0001" (.003 mm) in fine mode.
_____Put the machine in hand wheel mode and verify In/Out operation. Put an indicator on the cutter head and verify .001" (.02 mm) movement per detent in course mode and .0001" (.003 mm) in fine mode.
_____Use the rapid buttons and verify proper vertical, horizontal and In/out travel. Check limit switch operation with handwheel before using the power feed.
_____Move the machine to its vertical limits and verify Home, Up and down limit switch operation.
_____Move the machine to its horizontal limits and verify operation of the Home, left and right limit switches.
_____Move the machine to its In/Out limits and verify Home, In and Out limit switch operation.
_____Start the spindle and verify operation at all speeds.
_____Use the spindle creep buttons and verify proper operation.
_____Verify ALL axis backlash comp is operating properly, adjust if needed. Record actual readings after verification.

	Auto	Handwheel
X-Axis	_____	_____
Y-Axis	_____	_____
Z-Axis	_____	_____

_____Create a “Trace” file manually. This will create a file with all machine software parameters that will be stored at Rottler. Insert the Rottler supplied USB Flash memory stick into the computer. Or send via Skype to Rottler. With the Rottler program open. Select Setup Electronics>Control then press Rin 0 Trace. A message box will appear with Manually Created. Press OK Open the Windows Explorer. Navigate to C:\RottlerWPF\2011\8\4 and copy the file with the latest time and date.

NOTE: The date designation will change to correspond with the current date and time.

_____E-mail the file to the Lead of the department for the machine being installed.

_____Use a precision level and level the machine:

Record machine level readings below (must be within .0005). Back Way:

Back Way:

P1 _____ P2 _____ P3 _____ P4 _____ P5 _____ P6 _____ P7 _____ P8 _____

Back to Front Way:

P1 _____ P2 _____ P3 _____ P4 _____ P5 _____ P6 _____ P7 _____ P8 _____

Record Dial Indicator readings:

Spindle to Back Table:

P1 _____ P2 _____ P3 _____ P4 _____ P5 _____ P6 _____ P7 _____ P8 _____

Spindle to Front Table:

P1 _____ P2 _____ P3 _____ P4 _____ P5 _____ P6 _____ P7 _____ P8 _____

_____Install way cover brackets and way covers. Way Cover support brackets should be flush with way surface.

INSTRUCTING THE OPERATOR

_____ 

Explain to the customer and operator that at NO time is there to be any software or hardware other than Windows Auto Update and Rottler installed on this machine. This includes screen savers, anti-virus software, and any hardware device that installs software on the machine. Installation of screen savers and anti-virus software can cause dangerous control problems. Any installation of software or hardware will void the warranty on the machine.

_____Explain to the customer and operator that the machine should be hooked up to the internet anytime it is on. The software on the machine will automatically connect to our server to send back useful information on machine status.

_____Explain to the customer and operator that the Auto Update for the Windows Firewall (Security) and Windows Defender (Anti-Virus) is turned on. The computer will automatically download the updates and then install them when the computer is shut down every Friday night.

_____Explain to the customer and the operator how the to log onto Skype and communicate with Rottler when needed.

_____ 

Computer Viruses will cause the machine control system to become unstable. This may cause the machine to make uncontrolled moves which could create a dangerous environment for the machine operator.

_____Connect customer supplied internet to the machine. Verify that the Internet is accessible from the machine.

IMPORTANT

_____Refer to Chapter 4, Control Definitions of the Machine Manual, Section: Computer and Controller System Safety. Explain and discuss this section carefully with Owner/Manager/Operator and have them sign off. Failure to do so will result in the machine warranty being Null and Void.

_____
Signature / Title

_____Explain to the customer the proper way to turn the machine off when it is not in use. Do not leave the machine on overnight. It is important to close all programs followed by shutting down Windows before turning the main power switch off. Do not turn the main power switch off before shutting down Windows.

_____Using the operating manual as a guide explain the function of all buttons.
_____Cycle all machine movements and supervise the handling of same by operator.
_____Demonstrate the differences of Manual and Auto operation.
_____Fully explain the entire Auto Cycle from Centering to Auto Retract.
_____Explain machine parameters and error messages. It is very important that the customer does not change parameter settings without first checking with Rottler Manufacturing. If certain parameters are changed the machine may make uncontrolled moves or not operate at all.
_____Point out safety features to customer and operator. Do not push any buttons without thinking of safety first.

⚠ CAUTION Do not assume the cutterhead micrometer has been calibrated.

_____Install a work piece in the machine and perform an undersize test bore to qualify the micrometer setting to the customers measuring tools.
Note adjustments: + _____, - _____.
_____Explain precision reset of tool in cutterhead.
_____The following is a checklist to go through every time the machine is started to begin a cut or automatic cycle.

- Work piece secure
- RPM set
- Feed Rate set
- Correct program in use
- Program oriented correctly (vertical zero at correct place) Centering range adequate
- Guards in place
- Cutterhead secure
- Tool holder adjusted to the correct size
- Tool holder locked in place

_____Proceed to have operator bore block to size.
_____Demonstrate and explain boring with the electronic hand wheel.
_____Explain the correct Feed rates and speeds from Cutting Insert Bulletin.
_____Cutter head change and expected stub bar performance.
_____Parts ordering, refer the to the operating manual for part numbers and description.
_____Offset tool bits, calibration of micrometer and anvil setting.
_____Train on ALL Rottler programs even if they need to be run in the air.
_____If Rottler CAM was provided to the customer train on any programs supplied by Rottler.
_____Review Emergency stop procedure with operator per operating manual.

MAINTENANCE SECTION

_____Use the manual as a reference when explaining routine maintenance and lubrication.
_____Overload devices, There are no mechanical overload devices on this machine. The machine is protected from overload by the motor controllers. If the system is overloaded the controllers shut the motors off. The controllers can be reset by turning the main power off for at least 1 minute, then turning it back on.
_____Explain again the proper Inner and Outer spindle adjustment to the operator.
_____Air float adjustment.
_____Dampener cleaning.
_____Micrometer and anvil thread adjustment.
_____Inspection of tool bit hole in tool holders (deformation due to accidental impact).

General remarks on machine performance, adjustments as received and any further organization or parts required to complete the set up:

_____

_____

_____

_____

_____

_____

_____

_____

_____

_____

_____

_____

Instructions given to: _____

Sales/Service Engineer:_____Date_____

Shop Foreman/Superintendent or Owner: _____Date_____

Installation Procedure

Rottler F107/9 Series Foundation and Hold Down Requirements

Rottler machines require a good concrete foundation and hold down system. It is not recommended to install a machine on a cracked floor or over an expansion joint. The layout/position of the hold down holes can be found on the foundation drawings below.

There are two methods commonly used by customers:
1. Drill the concrete floor as per drawing layout before arrival of machine.
2. Place machine, mark floor thru holes in machine base, move machine away then drill the floor.

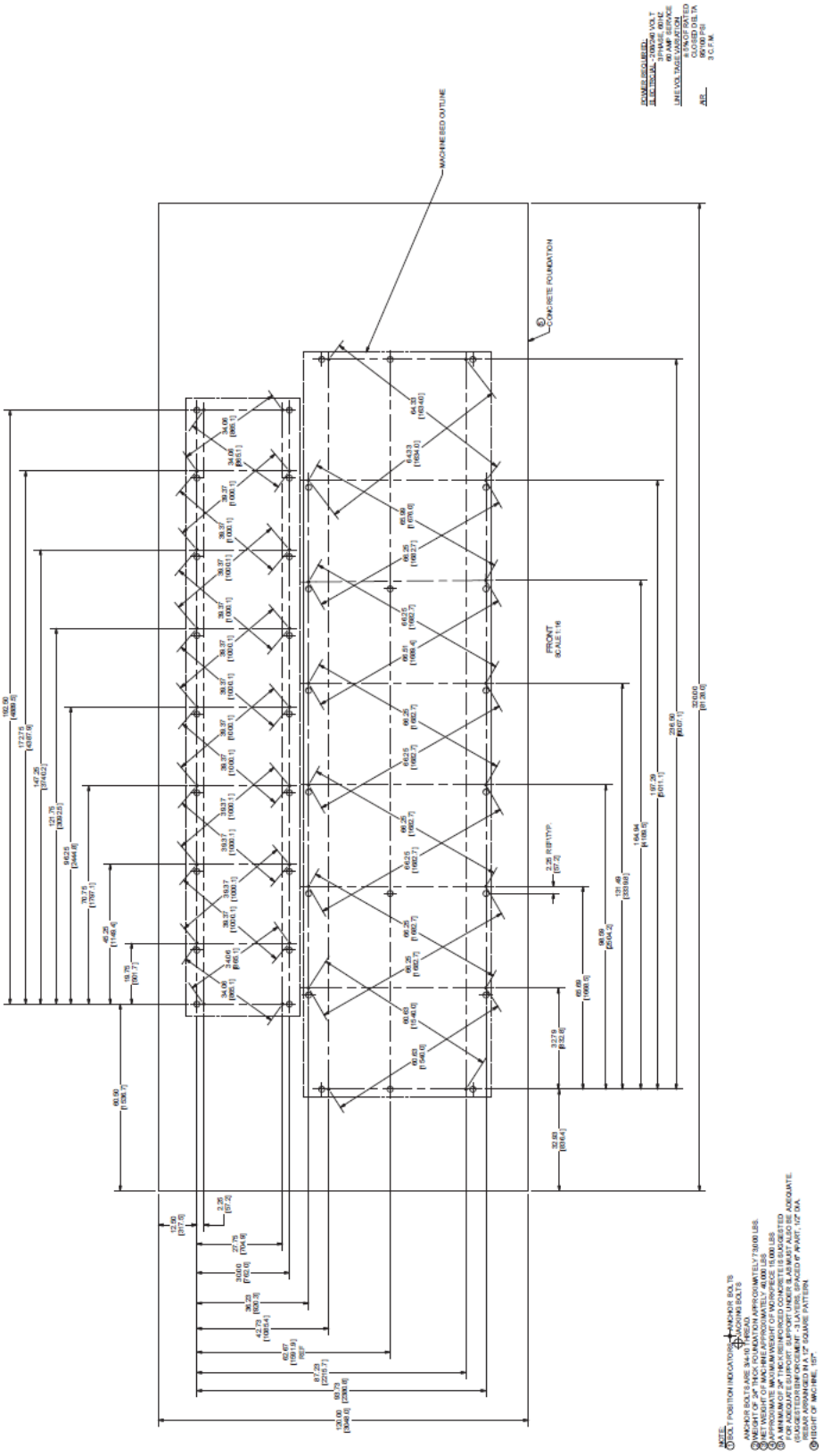
The machine is provided with jacking bolts and steel pads to place between the jacking bolts and floor. For shipping, the steel pads are packed in a separate box and marked with yellow/black tape so the box is clearly visible. This allows the machine to be unpacked and removed from the shipping crate, placed on the floor on these steel pads without opening the accessory crates. When placing the machine on the jacking bolts, ALWAYS rough level to be sure that the weight of the machine is evenly distributed over all the jacking bolts.

Rottler recommend Hilti products as per attached list. ¾" (20mm) diameter X 12" (300mm) long studs are recommended. Drill floor approx 7" (180mm) deep with 1" (25mm) drill. As it is difficult to drill concrete exactly on center, it is recommended to drill a pilot hole. After drilling and before injecting epoxy, it is also recommended to move the machine into place and make sure all studs fit thru the holes in the base and travel all the way down into the holes so that approx 5" (130mm) protrude out of the floor. The machine may have to be moved a small amount to allow all studs to fit. Once this is checked, the studs can be removed then the epoxy injected into the bottom of the holes. Make sure all dust is vacuumed out of the holes before the epoxy is injected. Ensure that the epoxy is injected starting at the bottom of the holes to be sure the stud has maximum contact with the epoxy. The size of the holes will determine how much epoxy to inject into the holes before fitting the studs. On average, ½ to 2/3 of the hole should be filled with epoxy before the stud is installed. Be sure when the stud is installed, that the epoxy fills the hole to the top. Fit the washer and nut and tighten lightly to align the stud then allow the epoxy 24 hours to harden ready for leveling and final anchoring.

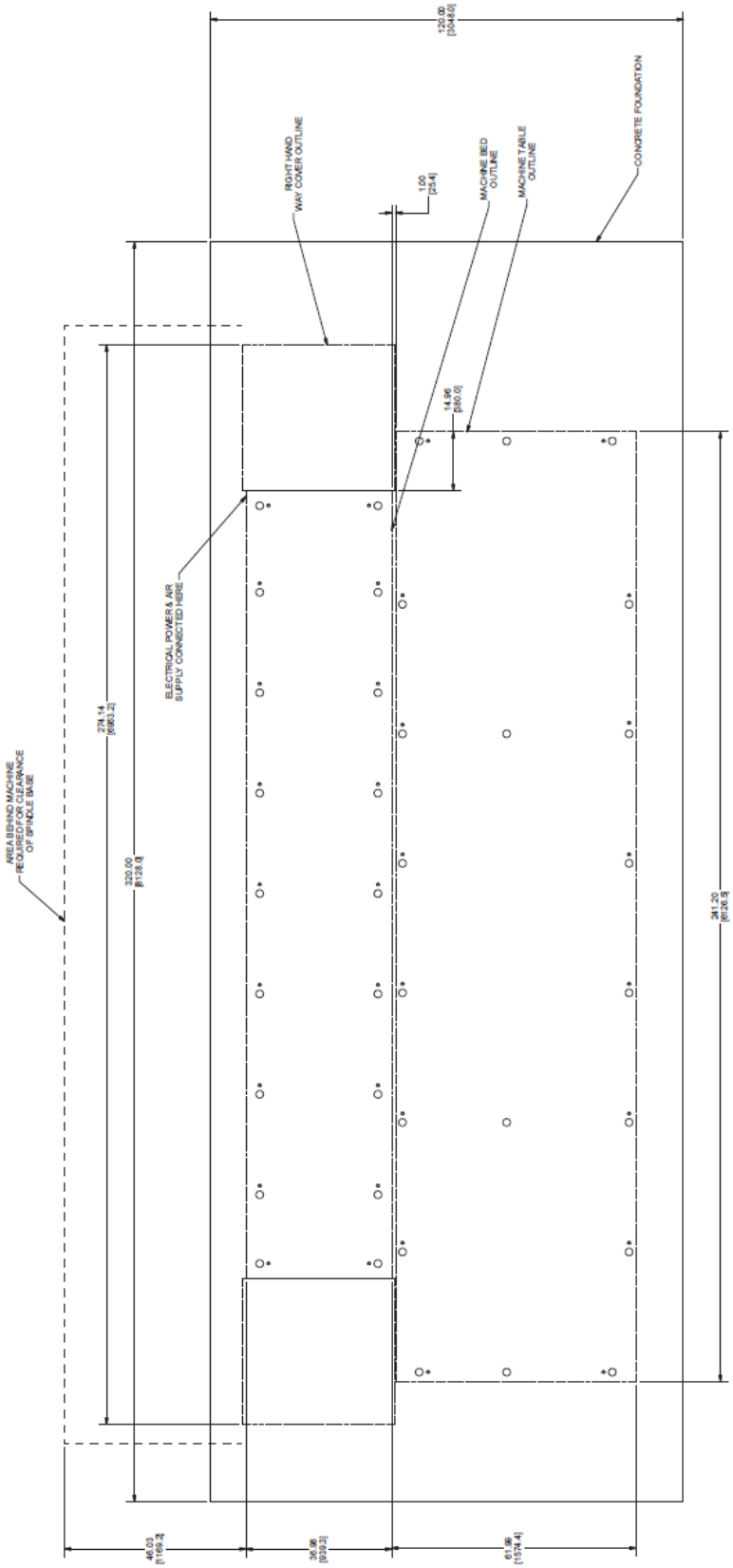
The column is tied down with chains for transport, if it is required to move the column to help with installation of the hold down system, the column tie downs can be removed and manually turn the horizontal ball screw nut by hand to move the column sideways. Be sure that the slideways are clean and lubed under the column before moving.

F107 Hold Down and Jacking Bolt Locations

Full scale drawing located at the end of chapter on the manual CD in PDF format.

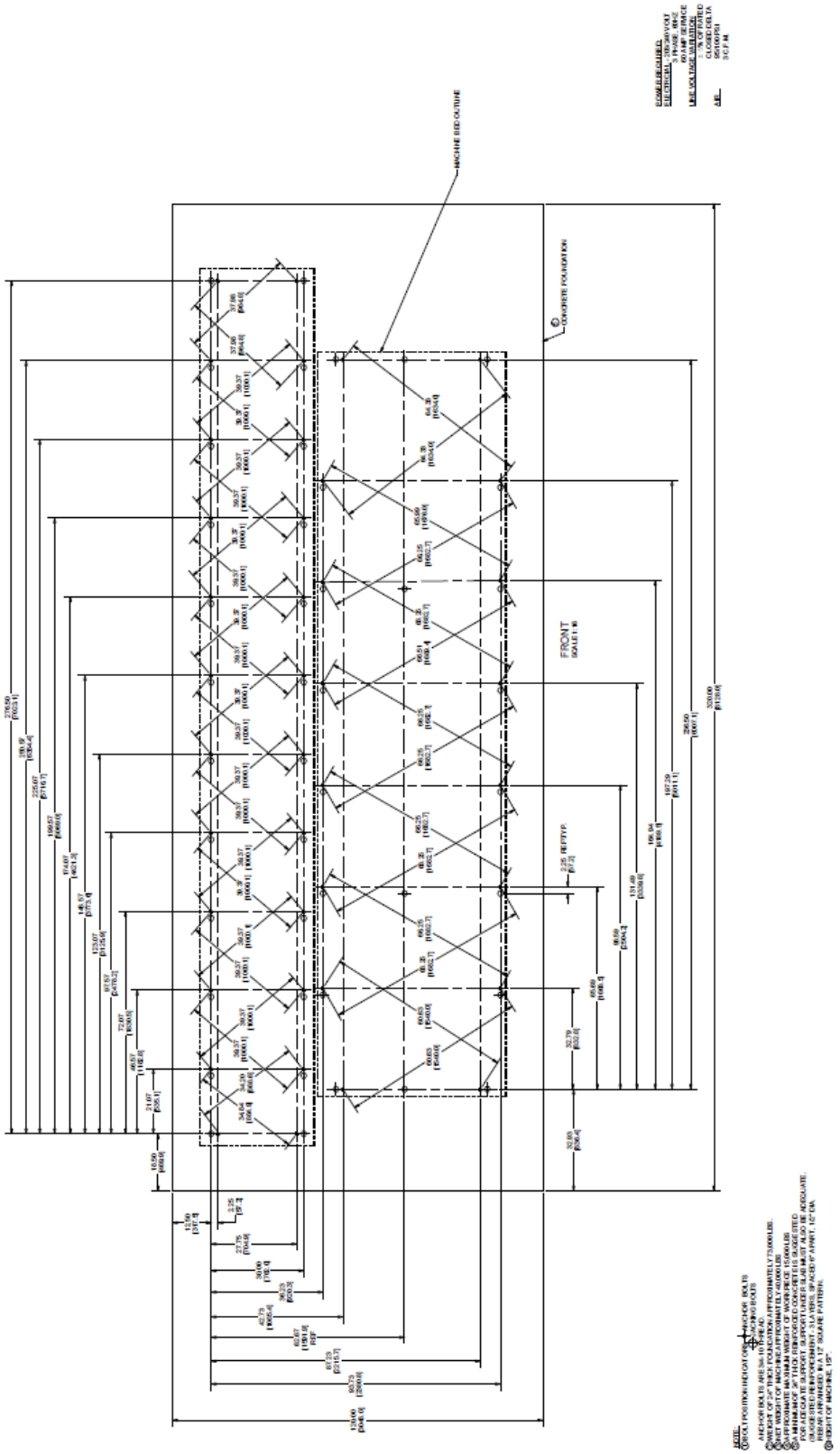


Full scale drawing located at the end of chapter on the manual CD in PDF format.



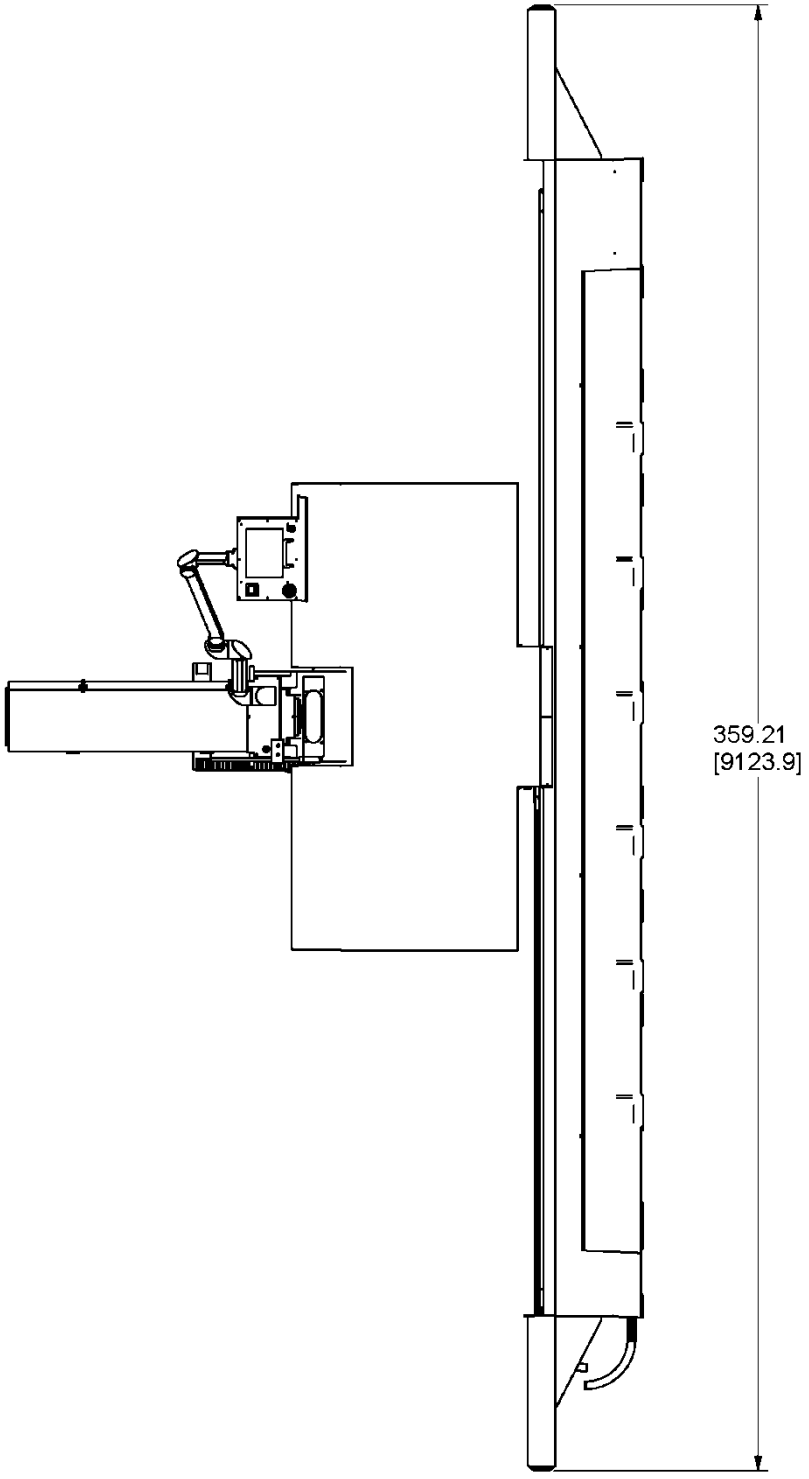
F109 Hold Down and Jacking Bolt Locations

Full scale drawing located at the end of chapter on the manual CD in PDF format.

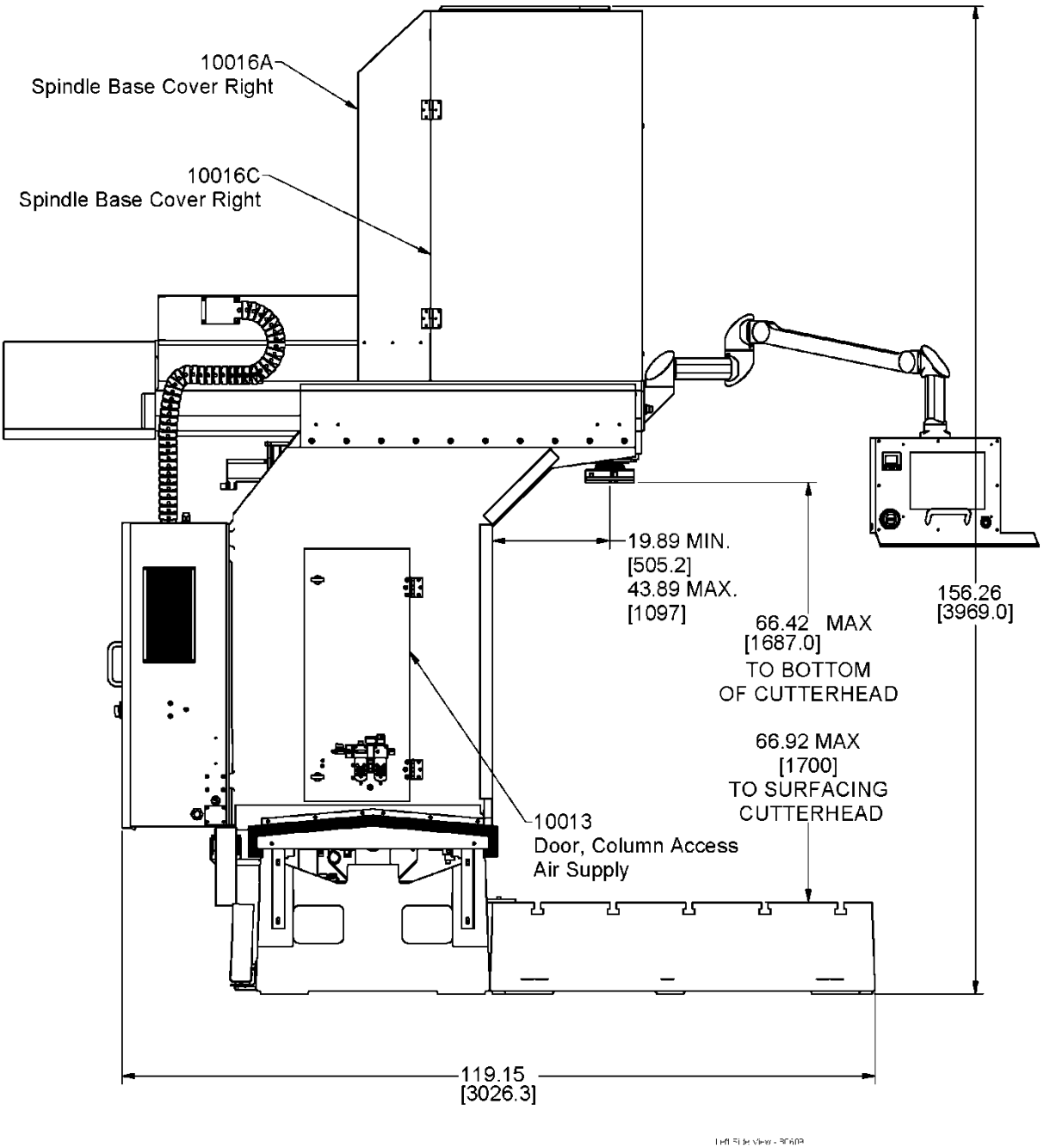


Machine Dimensions

Front View



Left Side View



Location
The productivity of this machine will depend a great deal on its proper initial installation. Pay particular attention to the means by which work pieces are lifted into the machine as well as the material handling to and from other operations in your shop.

The proper loading arrangement and area location for your F109Y machine is extremely important.

A slow travel (6' to 10' per minute) power hoist, operated from either a bridge crane or a jib crane arrangement works very well. Verify the hoist has a rating that exceeds the load being lifted.

For the shop where large production runs are anticipated, the work pieces should be directly loaded and unloaded from a conveyer. If this is not the case we recommend considerable attention be given to the crane so that it covers an adequate area, to allow the operator to back up and remove work pieces without creating a dangerous, cluttered work area.

Unpacking
Use care in removing the crate materials from the machine. Be careful not to use force on any part of the machine.

Remove the toolbox, parallels and optional equipment from the machine. Completely clean these articles as well as the rest of the machine with solvent. Rust inhibitor was applied, at the time of shipment. Any of this left on the machine, will allow cast iron dust to collect in that area, which could cause premature wear.

Column Hold Down
The machine was shipped with the column held in place with chains and turnbuckles to the Main bed. Do not attempt to move the machine under power until these restraints have been removed.

Leveling
Located in the bottom of the main base are the leveling and tie down screws. If care is taken, the main base can be leveled extremely accurately. Start by placing the jacking pads under the jacking screws. Adjust the jacking screws so the lowest point of the main base is at least 1/4" off the jacking pad. Make sure all the jacking screws are touching their jacking pads. Use a precision machinist's level, and check the base at several points to get an idea where the high and low spots are, adjust evenly where necessary. Start with the back way surface. With your precision level, level the back way in the lengthwise direction to .0005" per foot. Take the readings approximately mid way between the jacking points.

Use a precision metal support to span the distance between the front and rear parallels. (Support must be parallel within .0005" in its length). Take readings over every jacking bolt and level within .0005" over the length of the base. Be sure to use the jacking points down the middle of the main base.

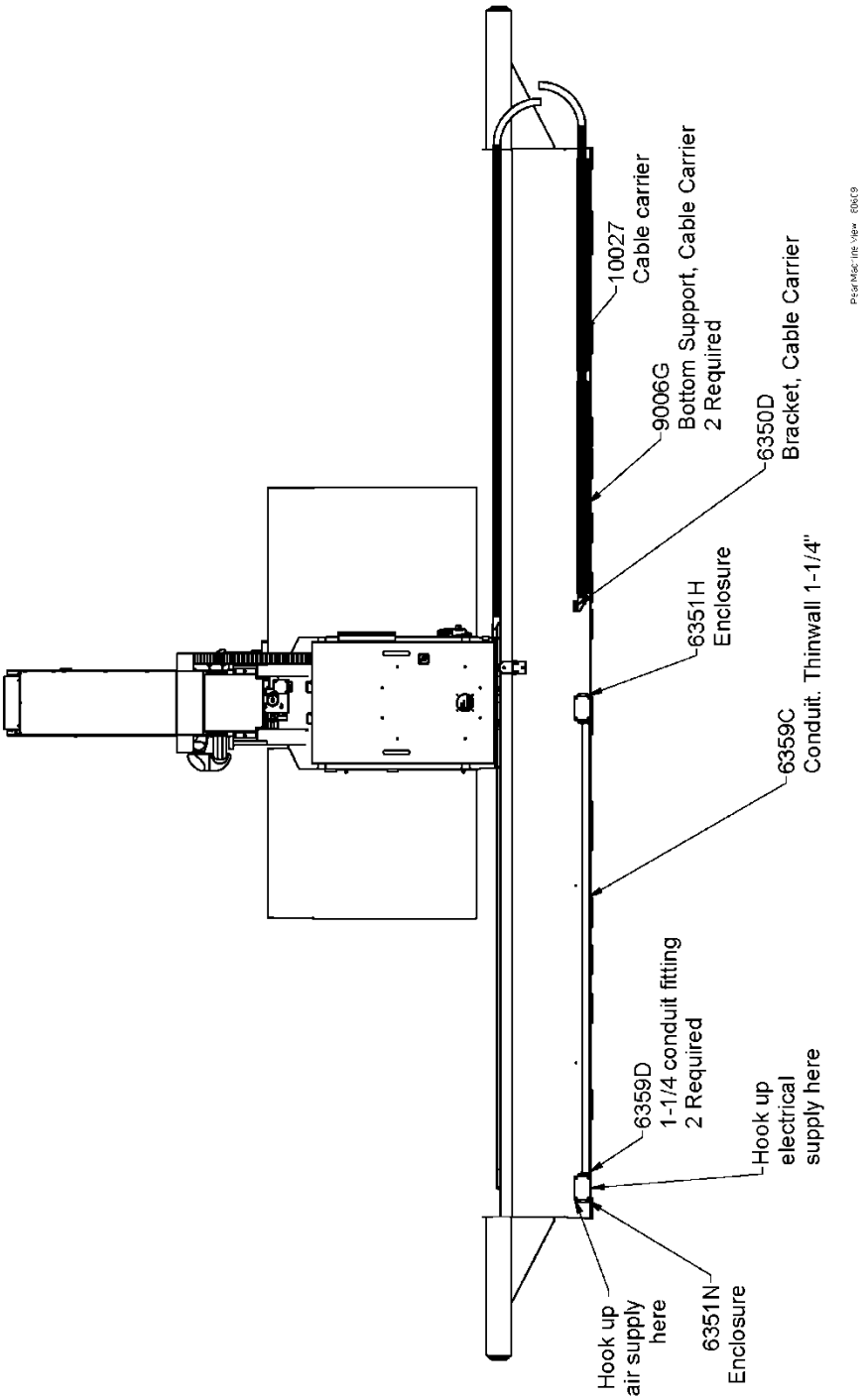
Recheck the way surfaces for level. Now check the machine table. Using the front jacking screws level the table within .0005" in both directions.

Be sure that all jacking bolts have approximately equal weight on them. As you go leveling the base snug the tie down bolts to help hold the main base in place. Recheck all areas of the main base for level.

Air Supply

It is very important the air source for the F109Y machine be moisture free. Water and oil in the line will result in early cylinder and valve failure. The factory recommends installing a water trap at the machine.

Attach a 100 P.S.I. air source to the appropriate intake in the small enclosure located on the left rear of the machine near the bottom.



Power Supply

This machine has the following power requirements:

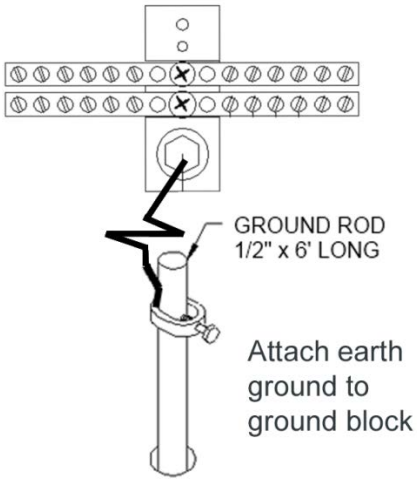
208 to 240 VAC
Three Phase
50 or 60 Hertz
100 amps

See illustration below for correct connection of “measured” incoming power. Connect three phase wiring to the electrical box located on the back of the machine in the lower right hand corner. See previous illustration. If a “high leg” exists, this must be at Line 3 ***Important: Electrically connect in accordance with national and local electrical codes.***

Note: For voltages over 240 VAC (380 – 440 VAC) a factory supplied transformer needs to be purchased with the machine.

Grounding

This machine must be connected to a good earth ground rod. A 6 foot, ½” diameter, 15 OHM, Copper grounding rod driven into the earth next to the machines is preferred. Not providing a grounding rod could void factory warranty.



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Contents

Safety Information

⚠ WARNING

For Your Own Safety Read This Instruction Manual Before Operating This Machine.

⚠ This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.

⚠ DANGER DANGER indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.

⚠ WARNING WARNING indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.

⚠ CAUTION CAUTION indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.

CAUTION CAUTION used without the safety alert symbol indicates a potentially hazardous situation which, if not avoided, may result in property damage.

⚠ WARNING This machine is capable of causing severe bodily injury.

Safety Instructions for Machine Use

ONLY A QUALIFIED, EXPIERENCED OPERATOR SHOULD OPERATE THIS MACHINE. **NEVER ALLOW UNSUPERVISED OR UNTRAINED PERSONNEL TO OPERATE THE MACHINE.** Make sure any instructions you give in regards to machine operation are approved, correct, safe, and clearly understood.

KEEP GUARDS IN PLACE and in proper working order.

KEEP WORK AREA CLEAN. Cluttered areas and benches invite accidents.

KEEP CHILDREN AND VISITORS AWAY. All children and visitors should be kept a safe distance from work area.

WEAR THE PROPER APPAREL. DO NOT wear loose clothing, gloves, rings, bracelets, or other jewelry which may get caught in moving parts. Non-Slip foot wear is recommended. Wear protective hair covering to contain long hair.

ALWAYS USE SAFETY GLASSES. Also use face or dust mask if cutting operation is dusty. Everyday eye glasses only have impact resistant lenses, they are NOT safety glasses.

DO NOT OVER-REACH. Keep proper footing and balance at all times.

USE THE RECOMMENDED ACCESSORIES. Consult the manual for recommended accessories. The use of improper accessories may cause risk of injury.

CHECK DAMAGED PARTS. Before further use of the machine, a guard or other part that is damaged should be checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, breakage of parts, mounting, and other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

NEVER OPERATE A MACHINE WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL. Full mental alertness is required at all times when running a machine.

IF AT ANY TIME YOU ARE EXPERIENCING DIFFICULTIES performing the intended operation, stop using the machine! Then contact our service department or ask a qualified expert how the operation should be performed.

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to follow guidelines could result in serious personal injury, damage to equipment or poor work results.

Electrical Power

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to follow guidelines could result in serious personal injury, damage to equipment or poor work results.

Make sure all electrical equipment has the proper electrical overload protection.

In the event of an electrical short, grounding reduces the risk of electric shock by providing a path of least resistance to disperse electric current.

Electrocution or a fire can result if the machine is not grounded correctly. Make sure the ground is connected in accordance with this manual. DO NOT operate the machine if it is not grounded.

No single list of electrical guidelines can be comprehensive for all shop environments. Operating this machinery may require additional electrical upgrades specific to your shop environment. It is your responsibility to make sure your electrical system comply with all local codes and ordinances.

When boring the machine is capable of throwing metal chips over 10- feet from the cutting area. Always use the guards. Eye protection must be worn at all times by the operator and all other personnel in the area of the machine.

⚠ WARNING The F109Y operates under computerized control and, as is all computerized equipment, and is susceptible to extraneous electrical impulses internally for externally produced. The machine may make moves out of the operator control at any time. The operator should work in and around the machine with caution at all times.

The operator and nearby personnel should be familiar with the location and operation of the Emergency Stop Button.

Make sure all electrical equipment has the proper overload protection. The F109Y should have ***a fully isolated*** power supply to prevent damage and uncontrolled movement of the machine. If the F109Y is on the same power lines that are running to other electrical equipment (grinders, welders, and other AC motors) electrical noise can be induced into the F109Y electrical system. Electrical noise can cause the controller to see false signals to move. Not supplying a fully isolated supply to the machine may void factory warranty. Refer to the Power supply section later in this chapter for voltage and amperage requirements of the F109Y.

Machine Operator

The operator of the F109Y should be a skilled machinist craftsman who is well versed in the caution, care, and knowledge required to safely operate metal cutting tools.

If the operator is not a skilled machinist he/she must pay strict attention to the Operating Instructions outlined in this manual, and get instruction from a qualified machinist in both production and operation of this machine.

The F109Y machines have the following areas of exposed moving parts that you must train yourself to respect and stay away from when they are in motion:

⚠ WARNING

Cutting Tool Area – Any operation involving hands in the cutter head area, such as inspection or alignment of the cutter head or tools, changing Centering Fingers, tool insertion, and removal, cutter head changes, and size checking etc. requires the machine to be in Neutral.

⚠ CAUTION

Machining – Eye protection must be worn during all operations of the machine. Hands must be kept completely away from the cutter head. All chip guards must be in position during machine operations.

⚠ CAUTION

Work Loading and Unloading – Carefully develop handling methods of loading and unloading work pieces so that no injury can result if hoist equipment or lift connection should fail. Periodically check lift components for damage that may cause failure.

⚠ CAUTION

Machine Maintenance – Any machine adjustment, maintenance or parts replacement absolutely requires a complete power disconnection from the machine, ***this is an absolute rule.***

Emergency Procedure

Assuming one of the following has occurred: tool bit set completely off size, work piece or spindle base not clamped, spindle is not properly centered, and these mistakes will become obvious the minute the cut starts

PRESS THE EMERGENCY STOP BUTTON (on the front control panel) **IMMEDIATELY!**

Find out what the problem is; return the spindle to its up position without causing more damage. To restart the machine, turn the Emergency Stop Button CW until the button pops out
Be alert to quickly stop the machine in the event of a serious disruption of the boring process either at the top or bottom of the bores.

"**REMEMBER**" metal cutting tools have the speed and torque to severely injure any part of the human body exposed to them.

Computer and Controller System Safety

The computer and controller are located in the main rear electrical enclosure. This unit is a full computer, running Windows 7 64 Bit operating system. Contact the factory if more information on the computer system is required.

IMPORTANT: The computer in this machine has the ability to connect to the World Wide Web via Ethernet or Wireless using a USB wireless (Wi-Fi) adapter. Updating the Rottler software should ONLY be done when directed to do so by a Rottler service technician. Updating Rottler Software when not directed by Rottler personnel will result in a non-operational machine.

The machine should be hooked up to the internet anytime it is on. The software on the machine will automatically connect to our server to send back useful information on machine status.

The Auto Update for the Windows Firewall (Security) and Windows Defender (Anti-Virus) is turned on. The computer will automatically download the updates and then install them when the computer is shut down every Friday night.

Any "IT" personnel should ALWAYS get approval from Rottler before doing ANYTHING on the computer.

⚠ DANGER This machine is capable of causing severe injury or death. Doing any of the following without Rottler's direct consent may cause severe injury or death.

⚠ WARNING Downloading ANY program from the Internet or by other means when not directed by Rottler is prohibited and will result in the machine warranty being NULL and VOID.

Downloading any program or changing any Rottler or Computer settings may cause the machine and/or software to become unstable. DO NOT install ANY screen saver, Anti-Virus, Spyware or any type of Security software on the computer. This could create a hazardous environment for the operator and personnel around the machine. Performing any of the above will also result in the machine warranty being NULL and VOID.

Contents

Control Definitions:

The purpose of this chapter is to define the function of the buttons throughout the various screens. Certain button functions may not make sense right away in this chapter. As the operator reads through the Operating Instructions chapter of this manual, the function of these buttons will become clear.

Computer and Controller System Safety for DM Controlled Machines:

The computer and controller are located in the main rear electrical enclosure. This unit is a full computer, running Windows 7 64 Bit operating system. Contact the factory if more information on the computer system is required.

IMPORTANT: The computer in this machine has the ability to connect to the World Wide Web via Ethernet or Wireless using a USB wireless (Wi-Fi) adapter. Updating the Rottler software should ONLY be done when directed to do so by a Rottler service technician. Updating Rottler Software when not directed by Rottler personnel could result in a non-operational machine.

It is recommended that the machine be hooked up to the internet anytime it is on. The software on the machine will automatically connect to our server to send back useful information on machine status. It will also record performance parameters that will be used to evaluate any occurrence of a malfunction.

The Auto Update for the Windows Firewall (Security) and Windows Defender (Anti-Virus) is turned on. The computer will automatically download the updates and then install them when the computer is shut down every Friday night.

Any “IT” personnel should ALWAYS get approval from Rottler before doing ANYTHING on the computer.

Downloading ANY program from the Internet or by other means when not directed by Rottler is prohibited and will result in the machine warranty being NULL and VOID.

Downloading any program or changing any Rottler or Computer settings may cause the machine and/or software to become unstable. DO NOT install ANY screen saver, Anti-Virus, Spyware or any type of Security software on the computer. This could create a hazardous environment for the operator and personnel around the machine. Performing any of the above will also result in the machine warranty being NULL and VOID.

Master Power On/Off Switch:

This switch is located on the main electrical control enclosure on the right hand side of the machine. The switch must be in the off position before opening the rear enclosure door.

When first applying power to the machine the computer will need to boot up. Be patient, it will take several minutes to complete booting. The Rottler program will not automatically start. Double tap the Rottler_WPF icon on the screen to start Rottler.

When turning the main power to the machine off there is a specific procedure to follow so as not to damage the computer. The computer must shut down its internal systems before main power is removed from it.

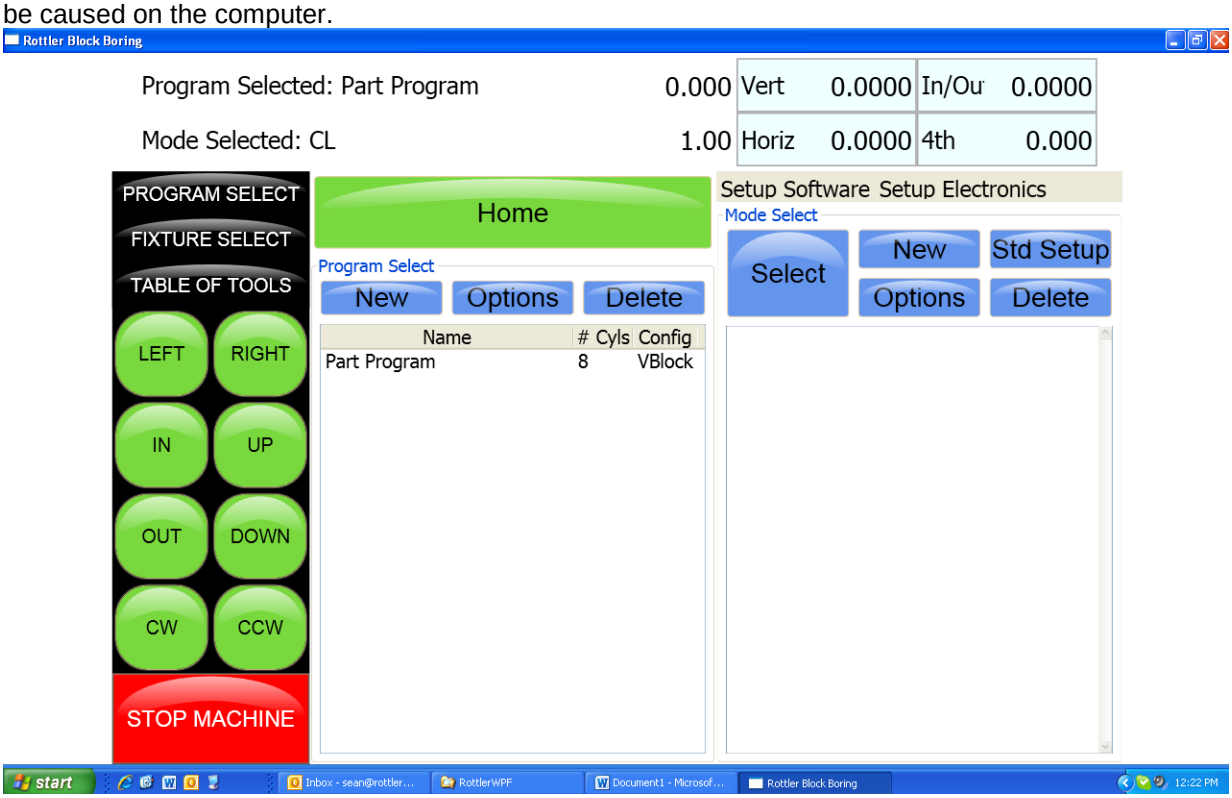
Press the “Start” button in the left-hand side of the Start Bar. This will bring up the “Start Menu”. Press the “Shutdown” line at the bottom of the Start Menu. This will bring up a Pop Up menu, make sure that “shut down computer” is selected and press “OK”.

This will shut down the computer. It is now OK to turn Main Power off to the machine.

Initialization Screen:

When the F109 is powered up the Rottler program will not automatically start. It may take several minutes for the computer to power. Start the Rottler program by double tapping the Rottler_WPF icon on the desktop Once the program is started, the Rottler Program Select will appear.

NOTE: Do not push any buttons or icons on the screen before the Rottler program starts or an error may be caused on the computer.



General Information:

The Rottler software operates on a Block Model format. You select or create the block you are working with. Then select or create an operation to be performed on that block.

Home:

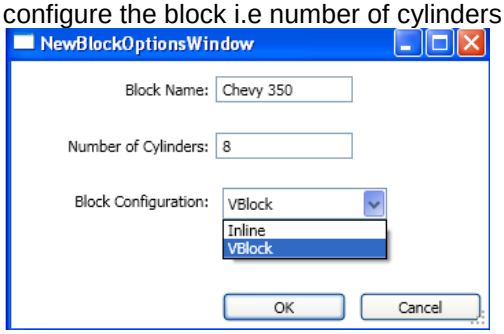
Pressing this button will cause the machine to move all axis to their home (Machine Origin) position. The vertical will home first to be sure it is clear to move the other axis. The machine MUST be homed after it is turned on. This is how the machine gets its reference points to operate.

Program Select:

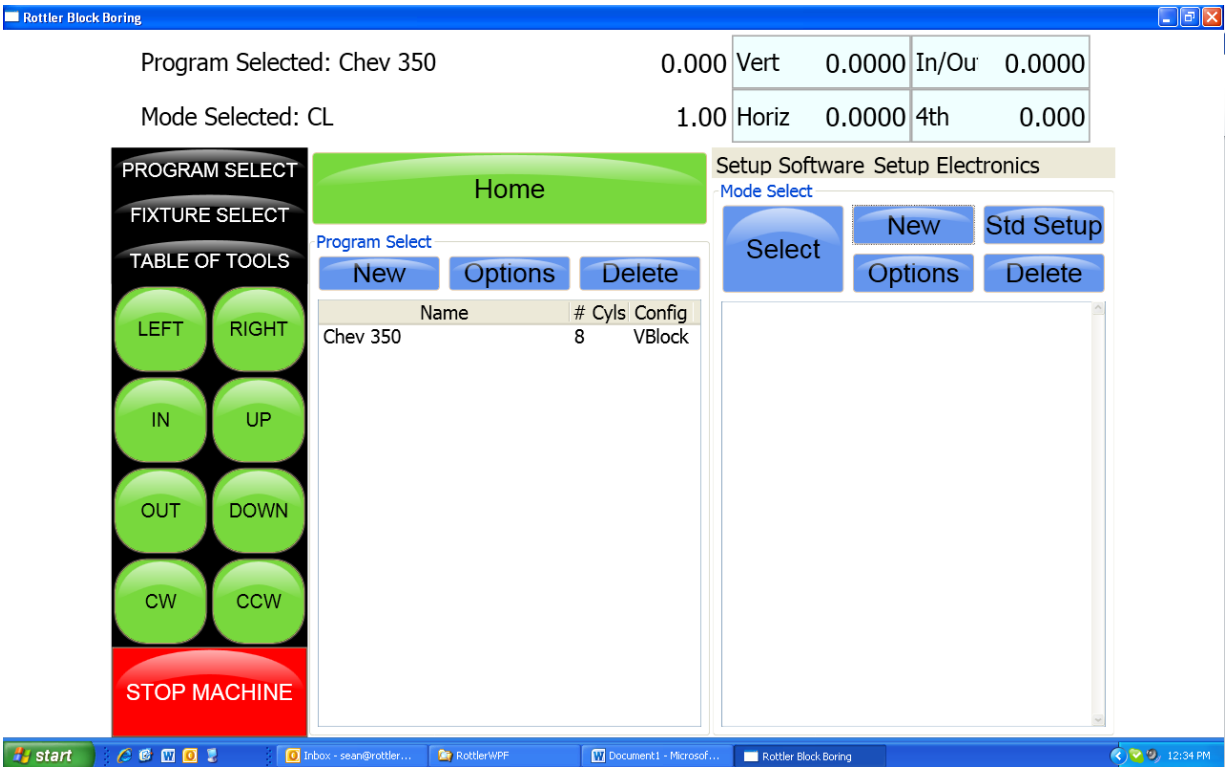
This is the left section of the screen. This is where you create and select blocks you will be working with.

New:

Pressing this in the Upper level will cause a dialog box to appear. Here is where you name and configure the block i.e number of cylinders and Inline or V Block.



Pressing OK will result in the Block Model being inserted into the left hand side of the screen.



Options:

This will bring up the same dialog box as described above if any of the information needs to be changed.

Delete:

This will delete whatever block program is selected. A dialog box will appear to ask you if you want that program deleted.

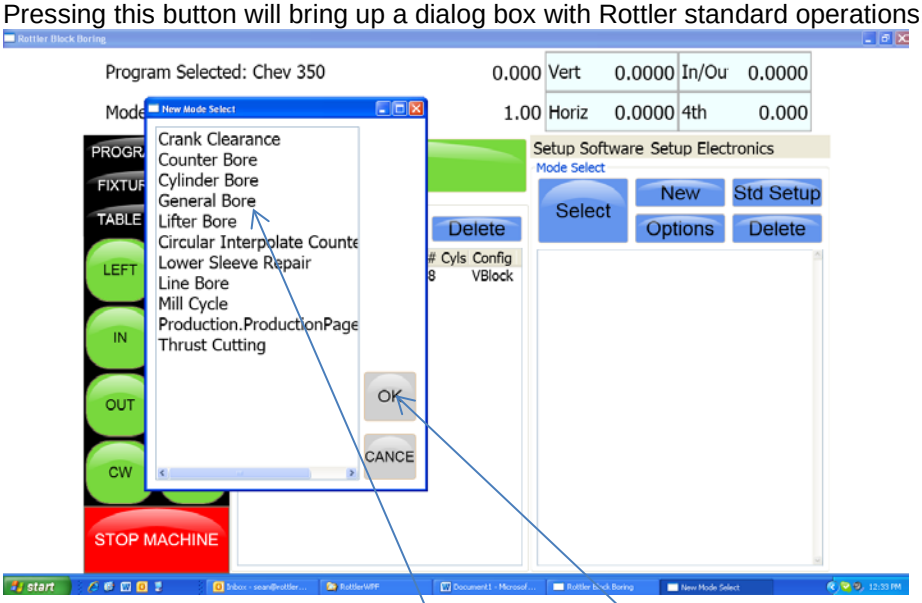
Mode Select:

This is the right section of the screen. This is where you create or select operations to be performed on the selected Block. This area will be blank when you first create a block.

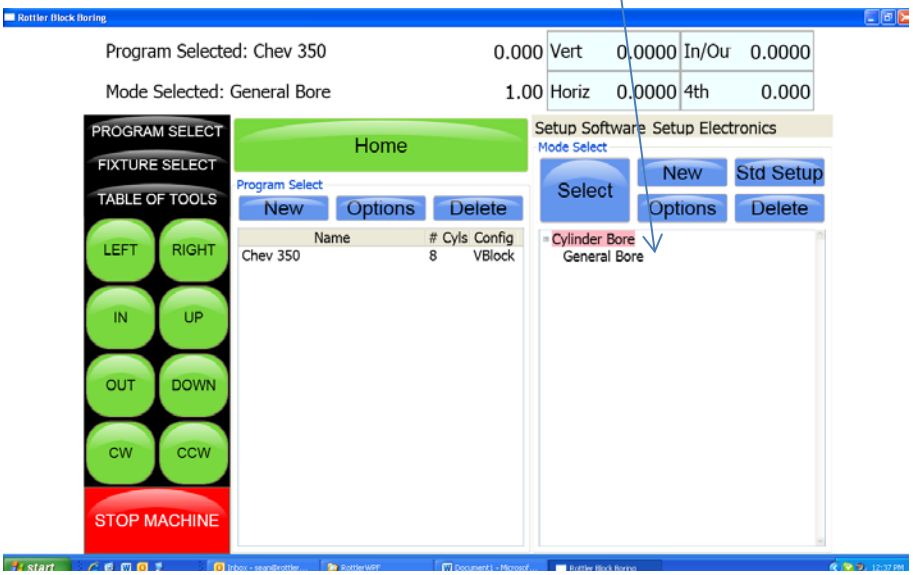
You can create only certain modes you will use on a block or use a standard set up that inserts all modes available. You can also create a new mode and rename if for a specific use.

New:

Pressing this button will bring up a dialog box with Rottler standard operations.



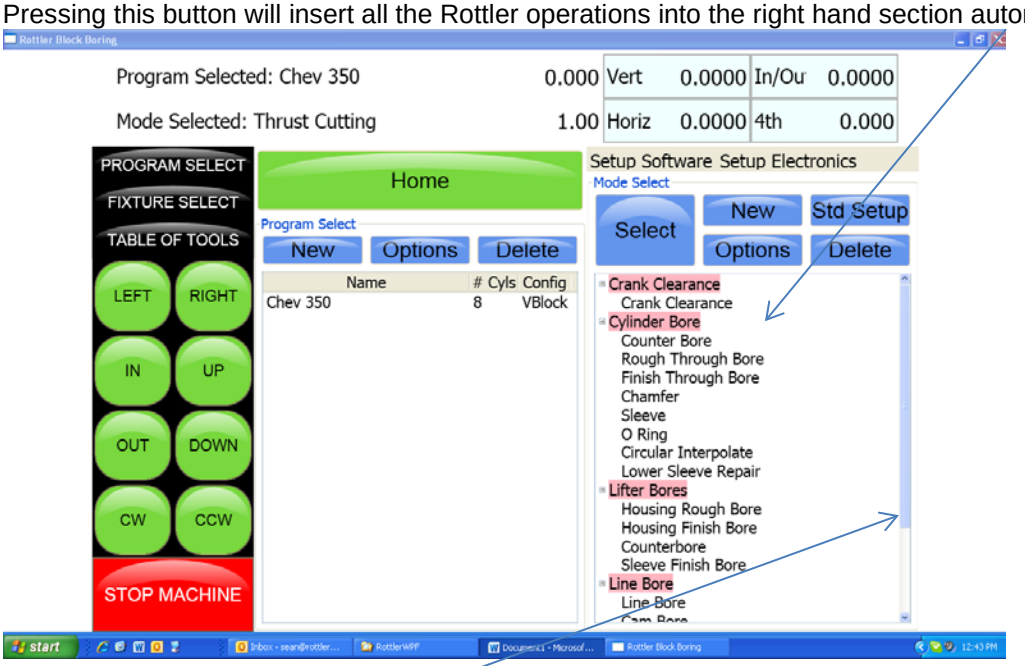
Select the operation you want to create and then press OK. This will place a general Bore operation under the Cylinder bore mode in the right hand section.



To enter General Bore mode highlight it and then press Select. This will take you to the operation screens that will be described later.

Std (Standard) Setup:

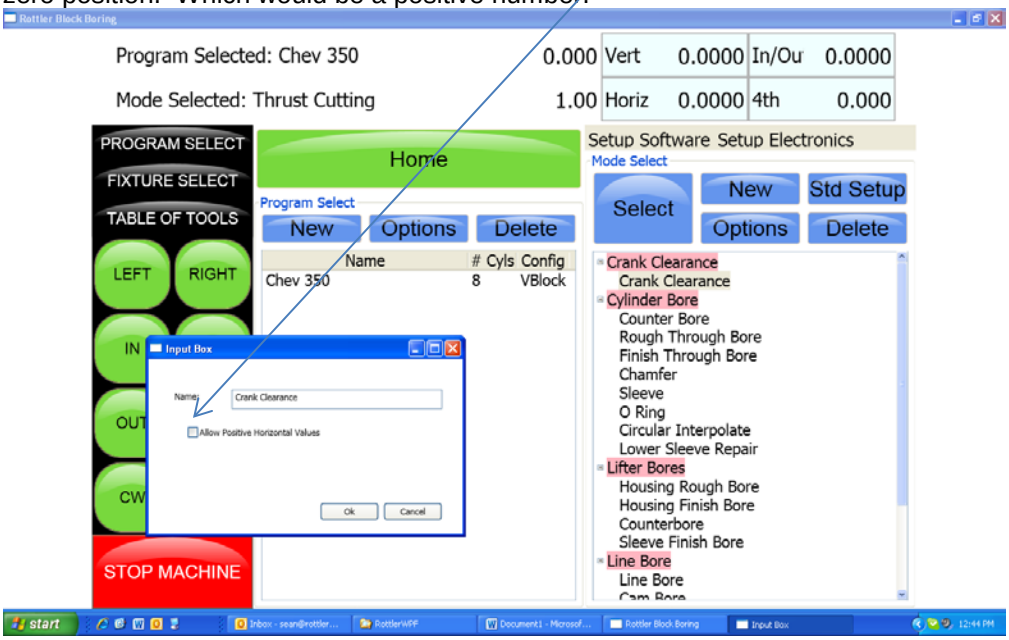
Pressing this button will insert all the Rottler operations into the right hand section automatically.



Use the slide bar on the right hand side to scroll through all the operations.

Options:

Press this button to bring up a dialog box to allow positive numbers to be entered in the horizontal stops. Most all programs are from left to right, the farther right you go the larger the negative number. However if a different zero point is used a positive number may be needed. For example, if you zero on the first cylinder on the left bank of a block and then "roll it over" the first cylinder is farther to the right than the zero position. Which would be a positive number.



Delete:
This will delete the selected Mode. It will ask you if you want this mode deleted before deleting it.
NOTE: Once the control definition for a particular button has been discussed it will not be repeated in the different modes of operation. Only new buttons or buttons with a different function will be discussed in different modes.

For these descriptions the Tool# and Probe # are not being used. They will be described later in this chapter.

Cylinder Bore, General Bore 3 Axis (without Tool Changer):

Each buttons function will be described in this section. In the different MODES, the same buttons will not be descrbed again.

Set Zero Tab:

Actual Position:
These are a numerical display showing the actual distance the axis are away from where they have been zeroed.

Velocity Override:
The Velocity override is displayed in the upper left of the Actual Position display. The default is 100% of the programmed Feed Rate. When operating… turning the handwheel Counter Clockwise will override the axis rapid travel and feed rate 100 and 0% when in an automatic cycle.

Zero Buttons:
These buttons will erase the actual position display of their associated axis and reset the displayed value to zero.

Handwheel Buttons:
These buttons will activate their associated axis for use with the handwheel. The left button of each axis will move the machine in .010" per detent, the middle button .010" per detent and the right .0001" per detent of the handwheel. Pressing any of the axis Jog buttons will disengage the handwheel.

Spindle Start:
This button will start the spindle at the RPM that is specified on the Auto Bore Cycle tab. Once the button has been pressed and the spindle is running the button will turn red and read Spindle Stop. Pressing the button again will stop the spindle and cause the button to go back to green.

CW and CCW Creep:
These buttons will cause the spindle to rotate slowly CW or CCW direction. The spindle will continue to rotate as long as the button is pressed. The speed at which the spindle will rotate is set in the Machine Parameters and should not be changed unless instructed to do so by the factory.

Jog Buttons:
These buttons control the rapid travel of the Vertical, Horizontal and In/Out axis. Pressing these buttons will allow you to move the machine through all ranges of its travel unobstructed. If the spindle is turned on these buttons become feed buttons and the machine will feed in whatever direction you have pressed. The rate at which the machine will feed is determined by the value set in the Auto Bore Cycle tab. When in rapid travel, these buttons are momentary contact and you will have to keep them pressed to keep the machine moving. When the spindle is on, they are latching buttons and once they are pressed the travel will continue until they are pressed again.

Move to:
Pressing these buttons will bring up a dialog box for the associated axis. Enter a value that you want the axis to move to and press ENTER. That axis will then move to that position. You can do multiple "Move To" at the same time. One after another.

Move To Zeros:
Pressing this button will cause the vertical to move the zero position first. The in/out and horizontal will move after the vertical has moved to zeros.

CW and CCW Index:
Pressing either of these buttons will cause the spindle to rotate to the index position. Index position is with the tool to the right as you are facing the machine.

Important:

Setting Spindle Index:
Any time the machine has been turned off the spindle index position must be set. Turn the spindle to the index position (tool holder facing to the right at 90 degrees from the operator). Then press the Zero button net to the spindle position read out. This will put a zero value in the display box.

This screen also shows the Spindle Load, programmed Feed Rate and Spindle RPM.

Probe Auto Center:
The Probe is an option on the F109 machine. When this button is pressed a single Probing routine will be run in the position the machine is currently at.

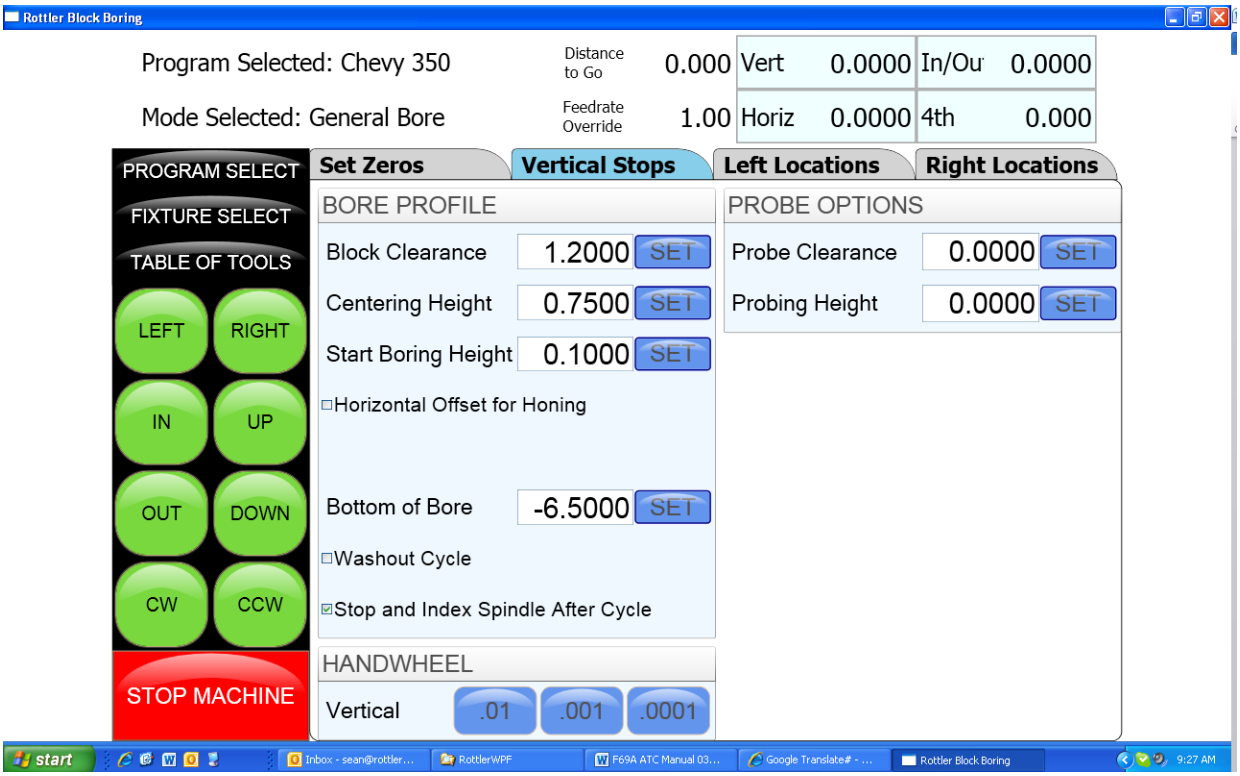
Vertical Stops Tab:

This screen is used to set the Vertical stops the machine will use to bore a cylinder. There are four Vertical stops used on this screen plus two optional Lower Clearance stops.

If the machine is equipped with a probe there are two (2) additional stops, Probe Clearance and Probe Height.

The function of the Vertical stops will be defined in the Operating Instructions chapter in this manual.

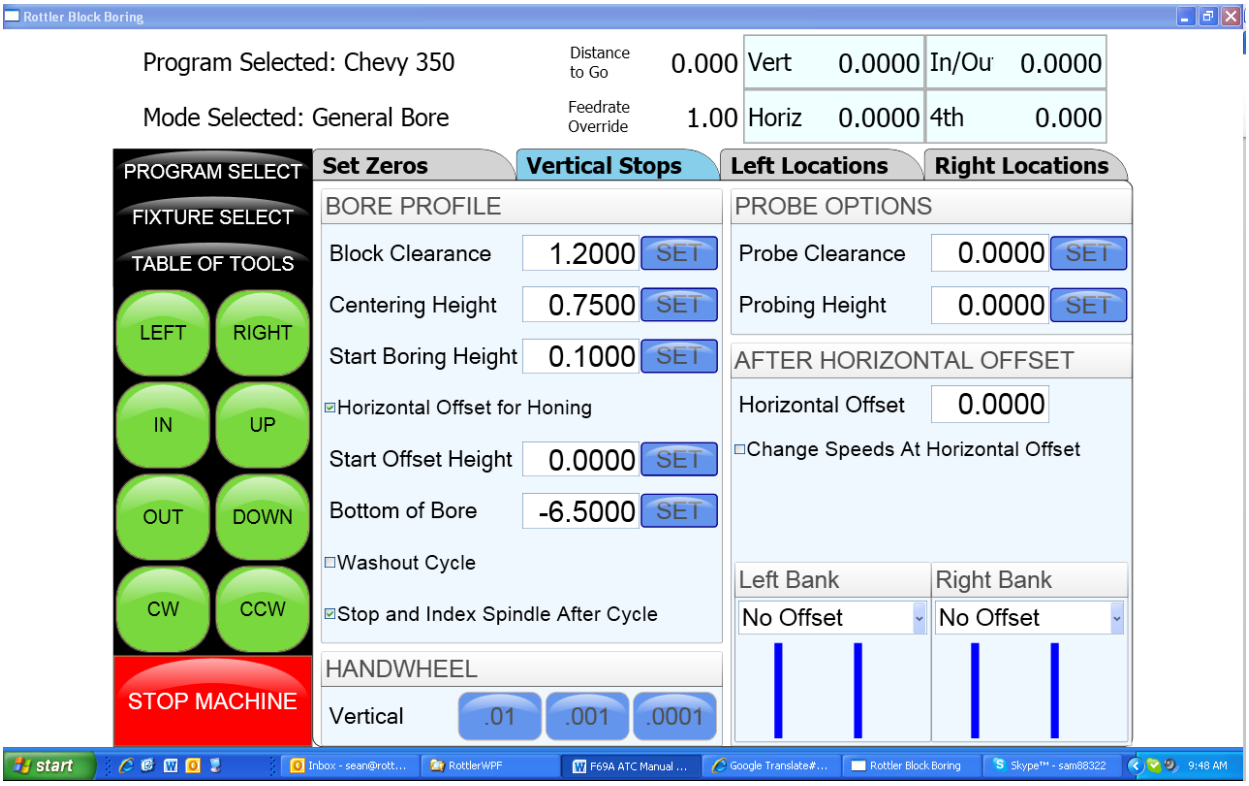
To enter any of the Vertical Stops press the Data box next to the Vertical stop you want to enter. A pop-up menu will appear. Press the desired numerical value and then press ENTER. The numerical data will then appear in the data box. You can also move the Vertical physically to the location you want the stop to be at and press the "SET" button next to the Data Box. This will take the current position from the Digital read out and insert it into the associated Data Box.



Horizontal Offset for Honing:

There is often the need to machine out the “webbing” at the bottom of a cylinder to get the correct honing clearance. Checking the box next to “Horizontal Offset for Honing” will bring up an additional screen section on the lower right.

This is where you will set the amount, direction and speed the offset will cut.



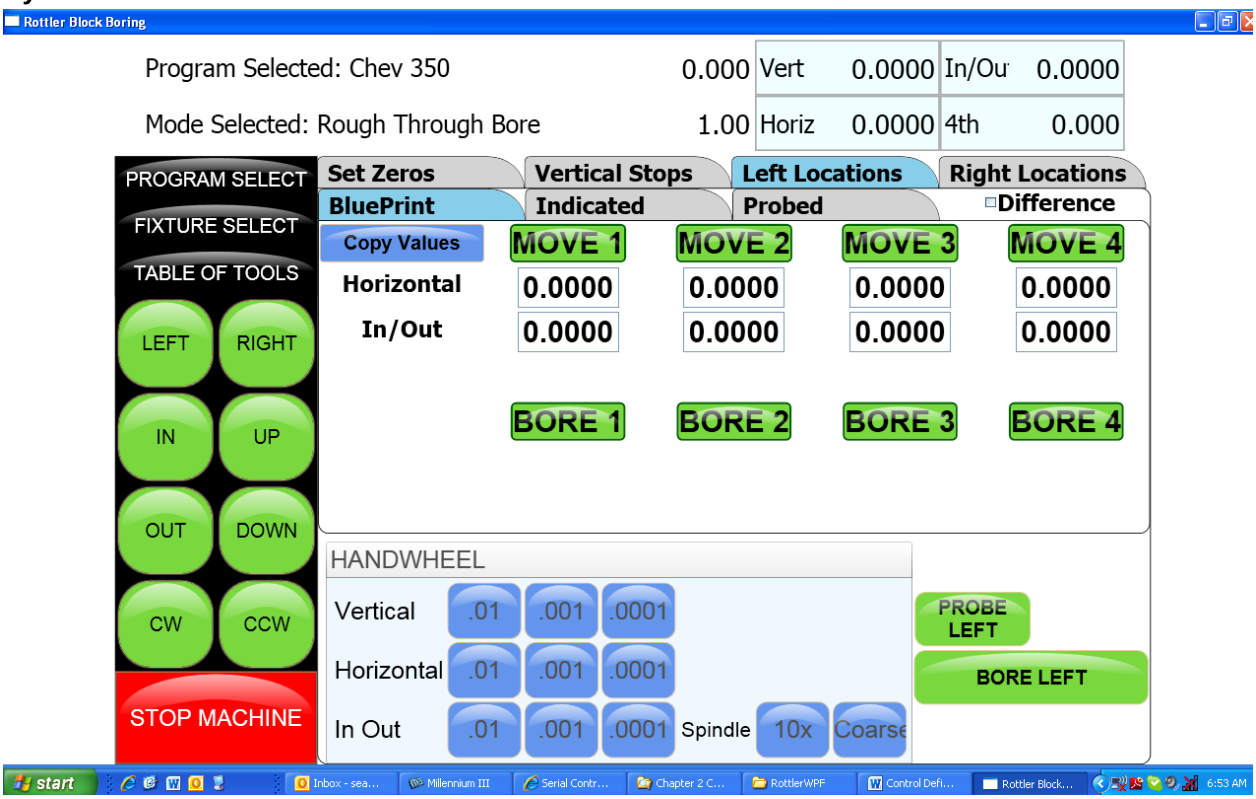
Left and Right Locations Tab:

This screen is used to set the Horizontal and In/Out stops the machine will use to bore a block. The number of In/Out and horizontal stop on this page will change with the block configuration i.e V6, V8 or inline.

The function of the Horizontal and In/Out stops will be defined in the Operating Instructions chapter of this manual.

To enter any of the Horizontal and In/Out stops press the Data box next to the Horizontal or In/Out stop you want to enter. A pop-up menu will appear. Press the desired numerical value and then press OK. The numerical data will then appear in the data box

Cylinder Bore – Bore Locations



There are three (3) different modes you can operate the machine in on these screens, Blueprint, Indicated and Probing.

Blueprint:

This mode of operation allows you to enter specific values for the bore locations from a blueprint type document.

It is helpful to have the blue print numbers entered on this screen even if you are not going to bore to the blueprint locations on a particular block. They help to set the general area of the bore if you are manually centering (indicating) or probing the block.

Move Buttons:

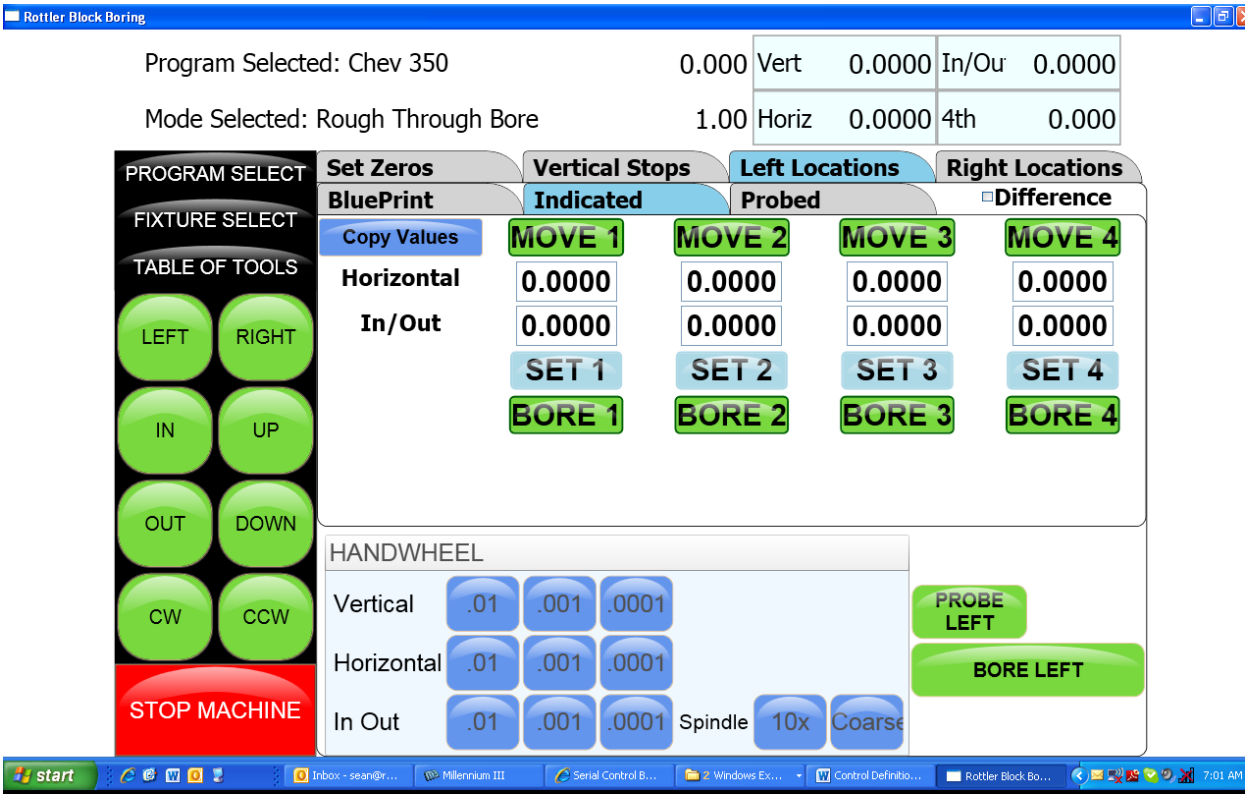
When pressed, these buttons will move the machine, under power, to the Horizontal and In/Out positions shown in the data boxes below the Move button. The Vertical will move to the Clearance height before it makes the Horizontal or In/Out moves. After it has moved to the Horizontal and In/Out positions the Vertical will move to the Centering Height. After this, all motion stops.

Bore Buttons:
Pressing this button once will cause it to turn yellow. This indicates when the "Bore Left" button is pressed this cylinder will not be bored.

Touching this button again (with a pause in between touches) will turn the button back to green. All green bores will be bored if the "Bore Left" button is pressed. The control will ask you if you sure you want to bore the selected bores.

Double Clicking a Bore button will keep it green and turn all other bore buttons yellow.

Indicated:
This screen is designed to manually indicate each cylinder in for it's specific location.



Set Buttons:
Once a cylinder has been indicate, pressing the associated Set Button will take the current machine position and place the values in the Data Box associated with that cylinder.

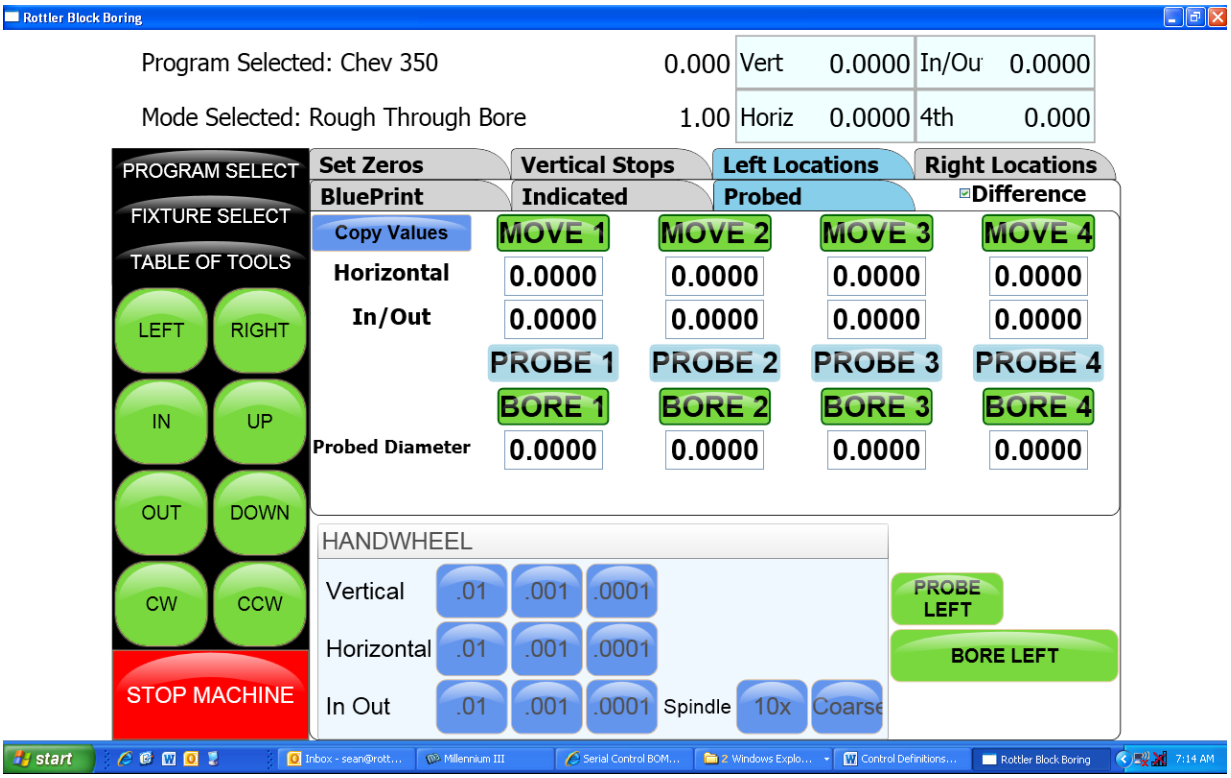
Copy Values:
Pressing this button will bring up another window where you can select to copy the In/Out and Horizontal values from Blueprint, Indicated or Probed screen.

Difference:
Checking this Box will cause a green check mark to be placed in the box. The Data Boxes will then display the difference in values from the blueprint screen to the indicated screen. This is helpful to know how far the cylinders actual location is from blueprint values.

Bore Left and Right:
Pressing this button will cause the entire Left or Right bank to be bored automatically. The Bore buttons that are yellow will not be bored though.

Probing:
The probe is an option on the F109 machine.

This screen is designed to automatically probe one or all of the cylinders.



Probe Buttons:
Pressing this button will cause a probing routine to be run on the associated cylinder.

Probe Left or Right:
Pressing this button will cause the entire Left or Right banks to be probed automatically.

Probed Diameter:
This Data Box will display the diameter of the cylinders as they are probed.

Lifter Bore:

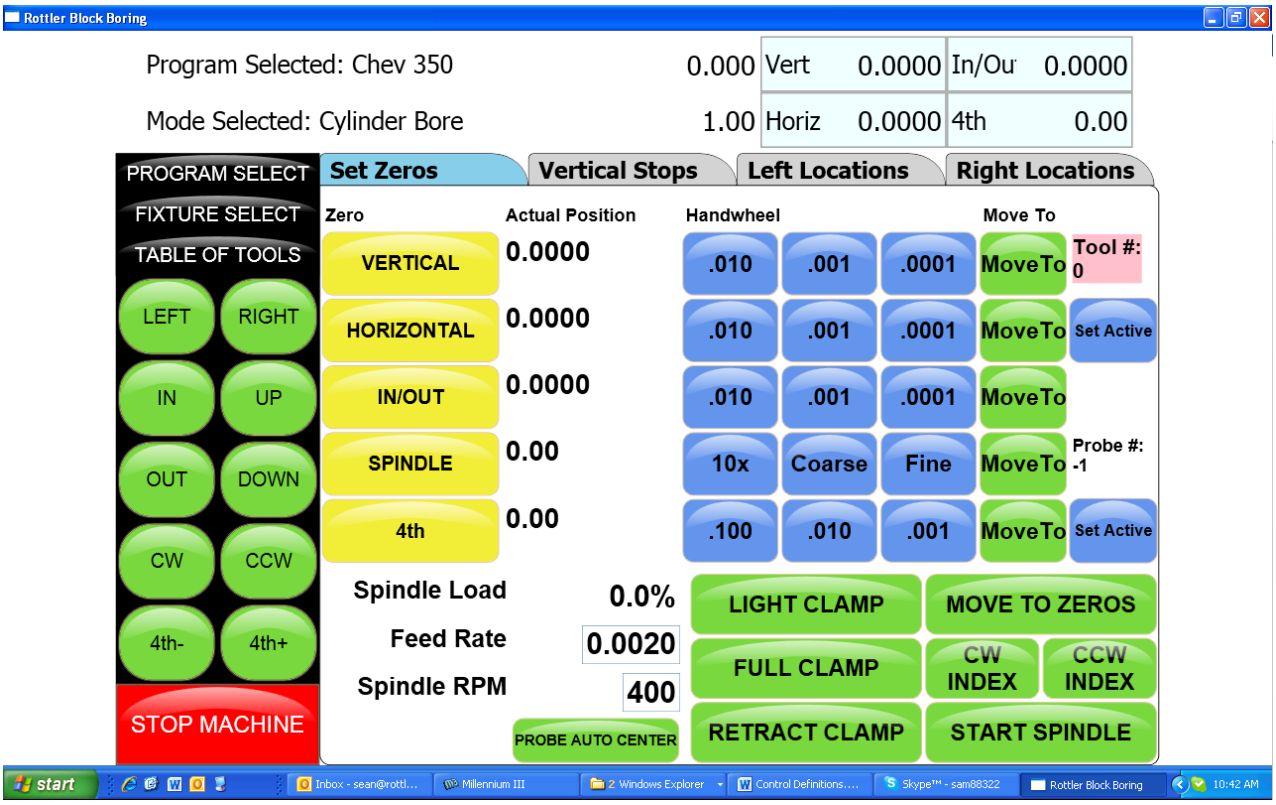
The Lifter Bore Mode and its buttons operate identical to the Bore Mode with a couple of exceptions.

On the Program Vertical Stops screen, lower Clearance Offset is not an option.
After a bore is complete the spindle will not offset .020" for tool clearance unless the "Horizontal Offset after Cycle" box is checked. This is used when a single point boring tool is used for lifter boring.

Cylinder Bore 4 Axis:

Most of the Control Definition in the 4th axis is the same as the 3 axis version of software. Only the differences or new features will be discussed in this section.

Set Zero Tab:



Jog Controls:

4Th-:
Pressing this button will cause the 4th axis to rotate in a negative direction while held.

4Th+:
Pressing this button will cause the 4th axis to rotate in a positive direction while held.

4th Axis Degree and Move:
Touching the 4th Axis Degree Data Box will bring up a Pop-Up Menu so a degree can be entered. Once a value is entered (even zero), pressing the Move button will move the 4th axis to that position.

4th axis Brake:

This shows the status of the 4th axis brake a well as manually turning the brake on and off. When the 4th axis is rotated using the jog controls the fixture will automatically switch the brake On and Off.

Light Clamp:

Pressing this button will cause light pressure to be exerted from the Tail Stock towards the Head stock. When the 4th axis is rotated using the jog controls the fixture will automatically switch from Full to Light clamp and back.

Full Clamp:

Pressing this button will cause full pressure to be exerted from the Tail Stock towards the Head stock.

Retract:

Pressing this button will cause the tail stock to fully retract. A dialog box will appear when this button is pressed to assure you want to retract the tail stock. This is to prevent an accidental retraction when a block is in the fixture.

Table Of Tools:

The Table Of Tools is a very powerful feature in this software. Most of the Rottler programs are designed to be used without interacting with the Table Of Tools.

Only the program specific uses will be described here.

Table Of Tools General Information:

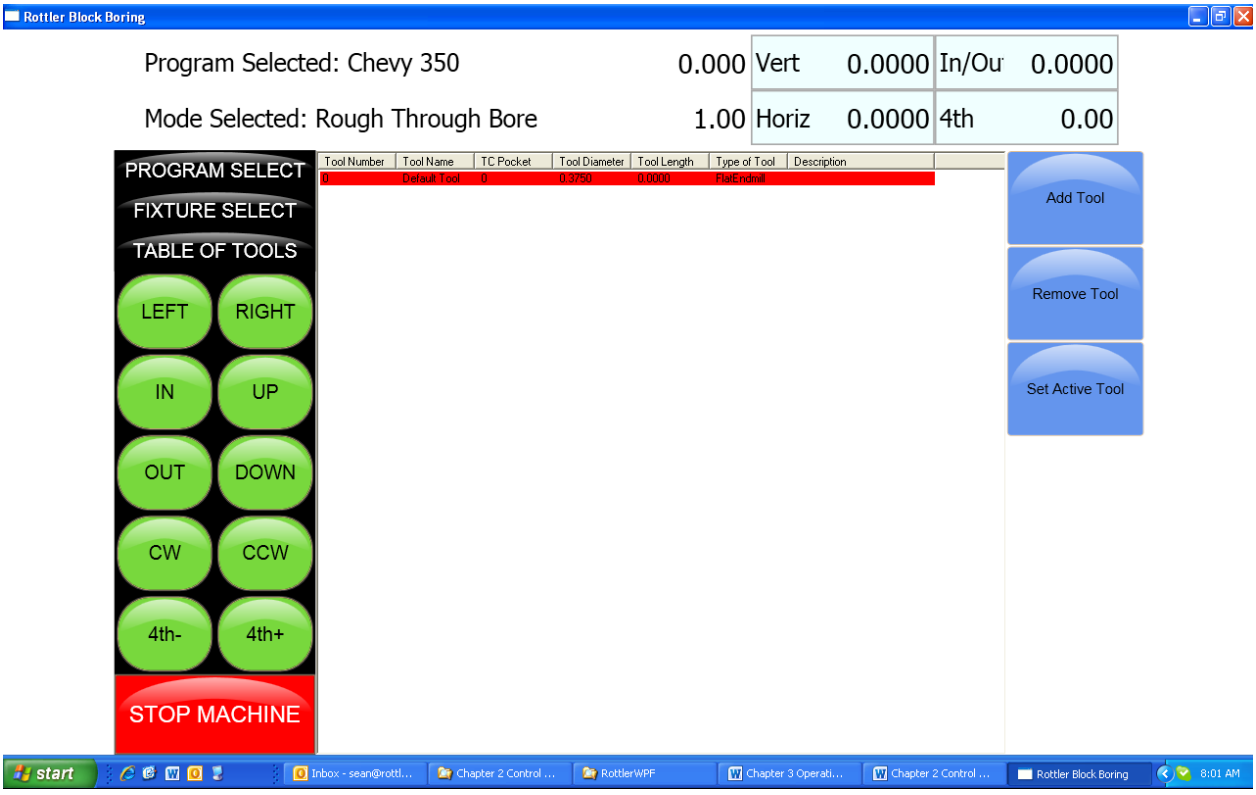
The Table Of Tools is used to set different tool lengths so multiple tools can be used in one program and reference the same vertical zero position.

For Example, if you were to use two boring bars in one program. One boring bar is 8" long and the other is 4" long. There is then a 4" difference in where the cutter of each bar will come into contact with the part to be machined. Using the Table of Tools you can set the 4" difference for one of the boring bars so that both of the cutting tools will come into contact with the material at the same vertical position.

Accessing Table Of Tools:

Select TABLE OF TOOLS from any screen in the upper left hand corner. This will open up the Table Of Tools.

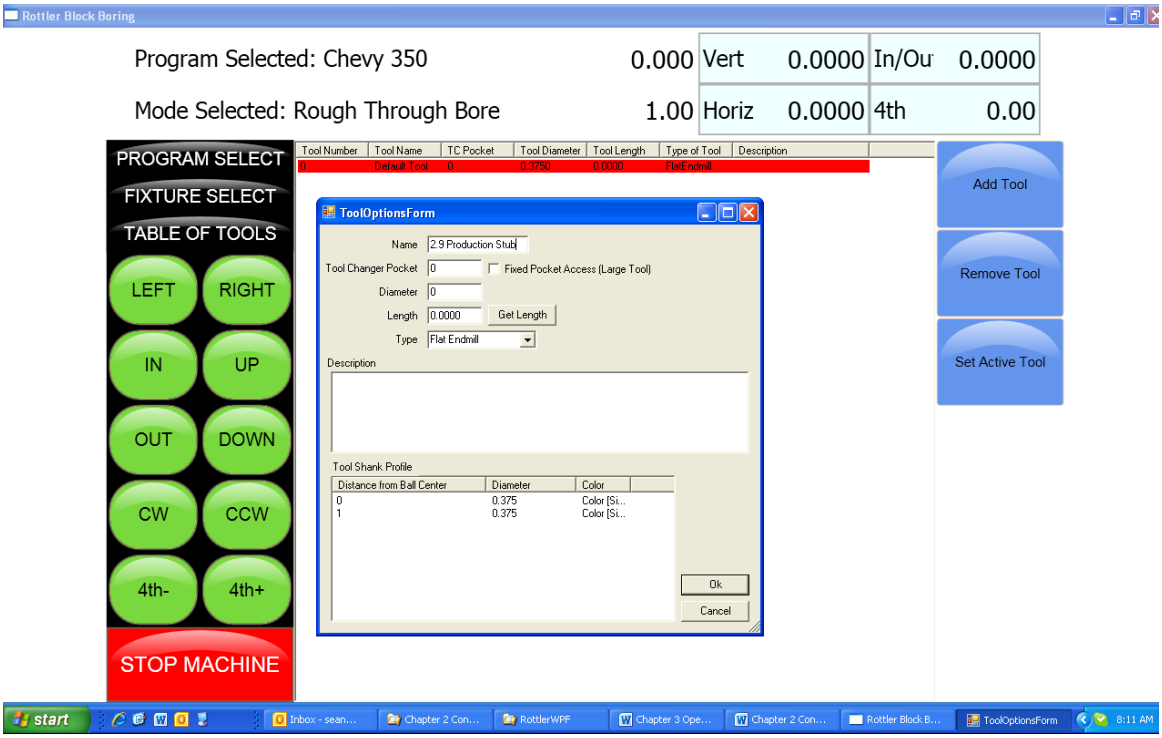
On this screen you will be able to Add, Remove or Set that tool Active (installed in spindle and being used).



The Table of Tools comes with Tool 0 installed with no offset amount. Tool 0 will remain tool 0 with no offset always. Tool 0 will be set active when you are using programs that do not require tool offsets.

Add Tool:

To add a tool to the Table of Tools press Add Tool. This will open another window. Here you will name the Tool you are adding. Such as 2.9 production Stub. It is important to give an accurate name to the tool. You want the tool easily identifiable by its name. The only other data box the Rottler software uses is the Length Data Box. This will be discussed later. Press OK.

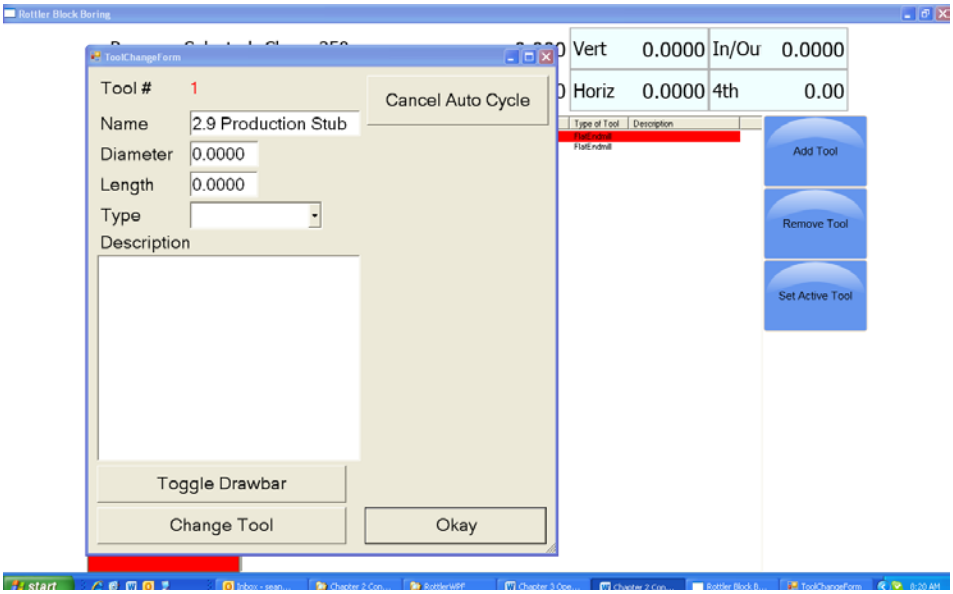


The Added tool will now show in the Table of Tools.

Remove Tool:
Pressing this button will remove the highlighted tool from the Table of Tools.

Set Active Tool:
Pressing this button will set the highlighted tool to an Active Status (tool installed and will be used) Any Vertical offset associated with that tool will be used when a program is run. You can tell which tool is active because it is highlighted in Red. When no offset is required in a program Tool 0, Default Tool should be active.

When setting a tool active another window will open. This is the Tool Change Form. It is basically there to verify the tool information before it is set to an active status. Verify the information and press OK.



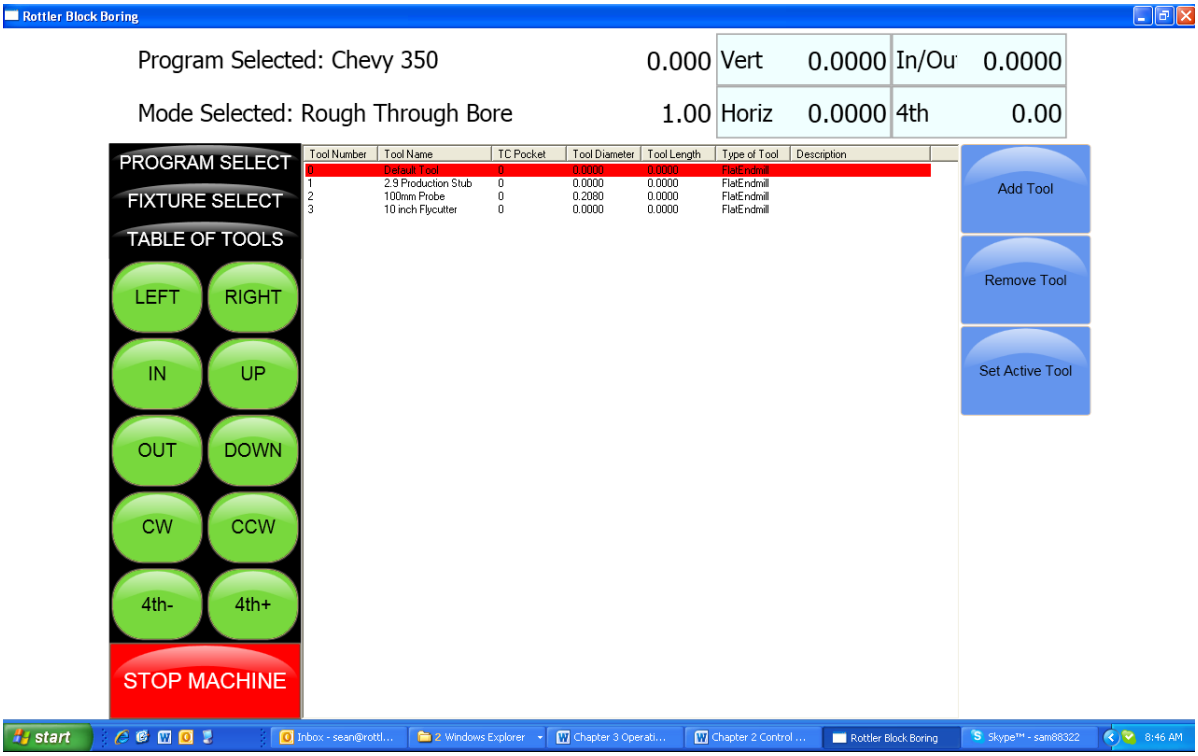
This window will open when the machine does an automatic tool change. This will be discussed in Chapter 3 Operating Instructions. After you press OK another window will open. This is a Warning Dialog box to inform the operator of the possibility of the spindle start if the tool change is done in an automatic program. Press OK.

Setting Tool Offsets:

Add all the tools that will need offsets into the table of tools. Leave the Length value at 00.00 when you first enter them.

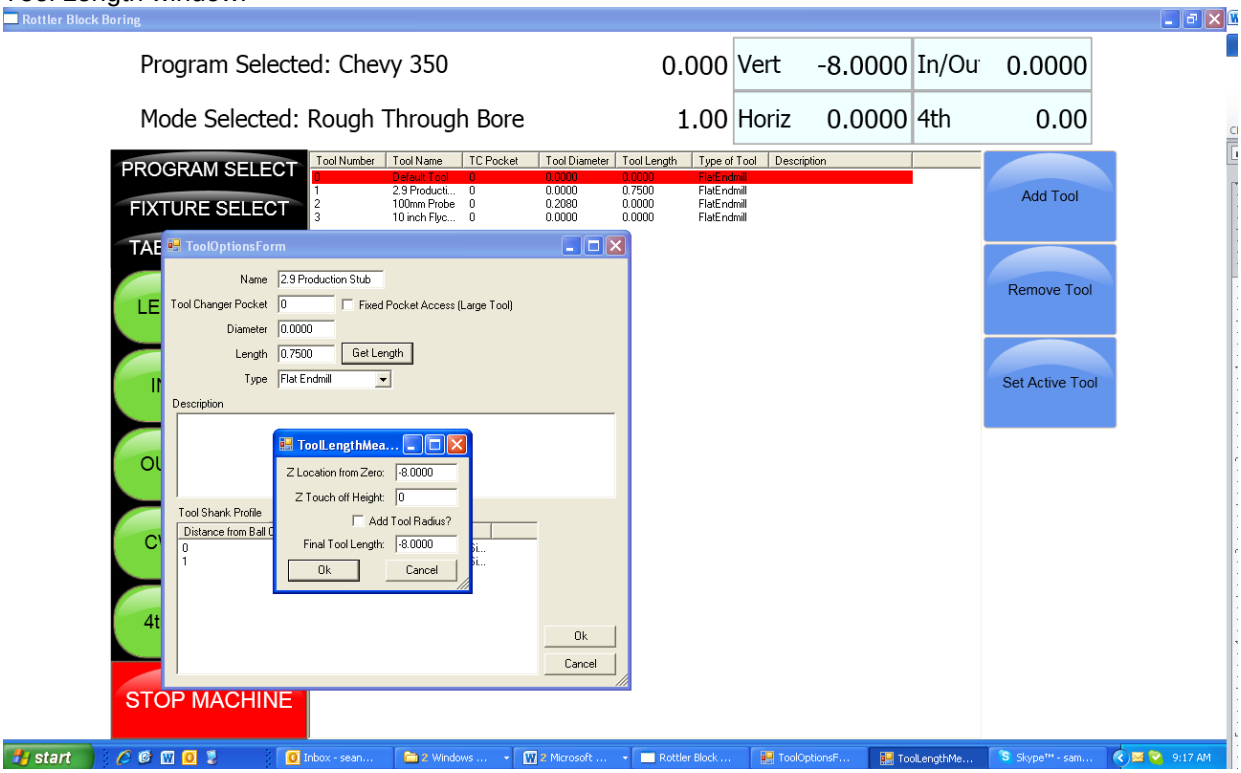
For this example we will be setting offsets for a 2.9 Production Stub, 100mm Probe and a 10 inch Fly cutter. Add these tools to the table of Tools.

NOTE: Only the Probe will use the Tool Diameter. The Probe will use the Tool Diameter when probing a cylinder, it will not use the Tool Diameter when touch off a surface such as a block deck. Changing this setting will be discussed in later in this Chapter.



To set Tool Offsets you will need a fixed vertical reference point on the machine that does not change such as the head stock of the 4th axis or Performance Fixture.

Install the first tool such as the 2.9 Production Stub with Cutting insert installed. Bring the cutting insert down until it just touches the flat on the head stock of the 4th axis fixture. Go to the TABLE OF TOOLS and double click the 2.9 Production Stub tool. Select Get Length from that window. This will bring up the Tool Length window.



Z Location from Zero:

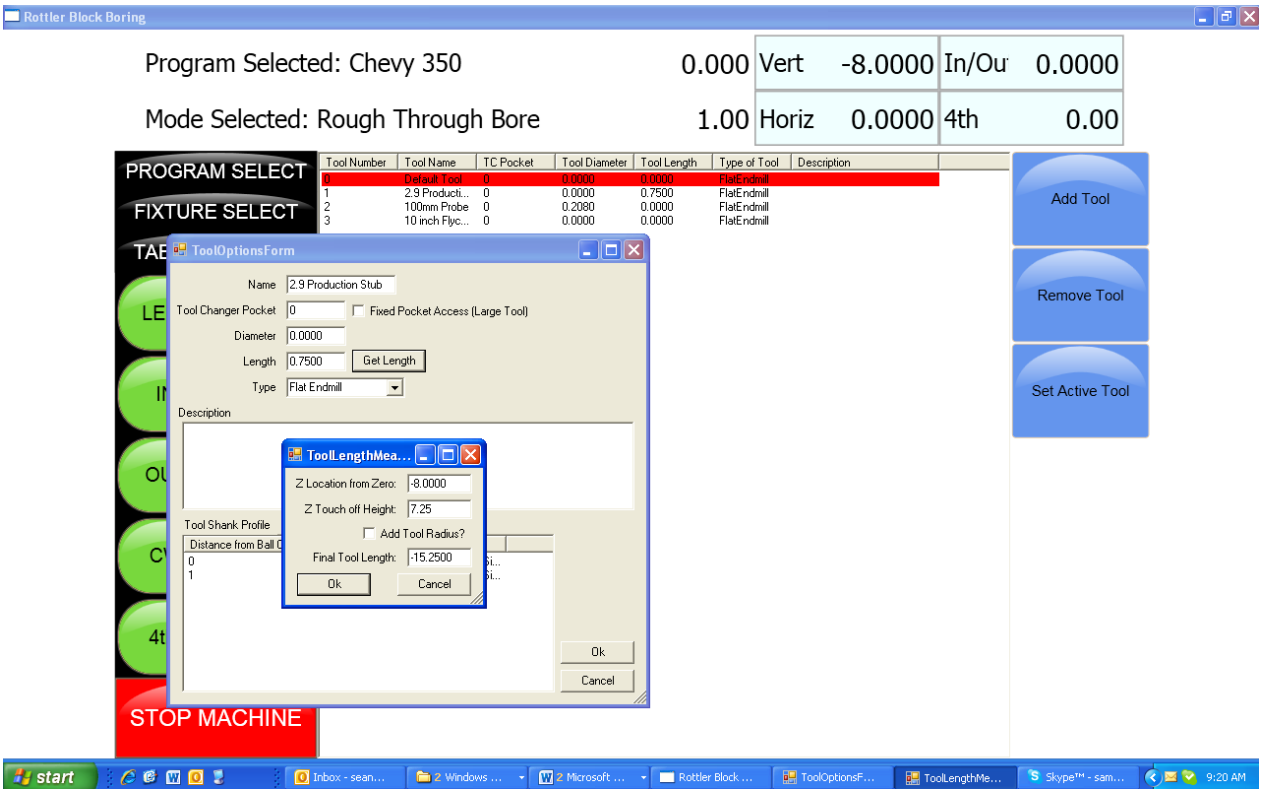
This is the distance the Vertical Axis is from the home position. NOT where the operator has set the Vertical Zero in the program. This value is set by the computer automatically. In this example the tool just touched the flat at 8.0000.

Z Touch Off Height:

This value is an additional value you want added to the Z location from zero. For example, if you wanted to use the center of the Crankshaft as the vertical reference point, but you are touching the tool off of the flat of that head stock, you would enter the distance from where you are touching off to the center of the Crank (this value is stamped into the headstock by Rottler). The values from Z Location from Zero and Z Touch off Height are added together by the computer to get the Final tool Length value. If you are not referencing another vertical position then this value will remain 00.000.

Add Tool Radius?:

Checking this box will add the Tool Radius to the Final Tool Length. This is not used in the Rottler programs and should remain unchecked for all tools.



Repeat this procedure for each tool. Touch ALL of them off from the same point.

When running a Rottler program the cutting insert for each tool will reference the Vertical Zero the operator set in the program and come into contact with the surface to be machined at the same vertical value.

Applying Table of Tools to Rottler Programs:
The use of the Table of Tools to specific Rottler programs such as Bore and Mill will be defined in Chapter 3 Operating Instructions.

Fixture Select:
This is also a very powerful tool. It is not generally used in the Rottler Programs. It's basic function is to offset a program and table of tools a set distance on each axis (if desired) and run the same program without resetting axis zero points.

For example, if you have to fixtures that are identical but are set at a different location on the table you can set the difference values in the table of fixtures and run the program.

It is recommended this is not used unless you are a very experienced operator.

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Contents

Operating Instructions:

The purpose of this chapter is to explain and then guide the operator from loading a block through running an automatic cycle.

All modes of operation will be discussed in this chapter.

Note: We recommend, particularly for operators unfamiliar with the boring machine, to practice on a junk block in order to become familiar with the controls and procedures of the boring machine.

Loading Blocks:
Small Gas and Diesel:

Manual V6/V8 Combination Fixture:

502-1-72H

⚠ WARNING Handle the block and fixture with EXTREME care and guidance. A block hoist is REQUIRED. Mishandling of a heavy engine block and fixture may result in the dropping of parts and personal injury.

The Model 502-1-72H manual V6/V8 combination fixture is a fast, simple and universal system to properly and accurately hold most 60 degree V-type engine blocks for either cylinder boring or deck surfacing.

See illustration on the following page.

Boring Application:

NOTE: The block must have the main bearing caps in place and torqued.

Care must be taken to assure the contact edges of the locator bar are near the cap split line. A pair of 3/8" and ½" spacers are provided for blocks with large main bearing bores, to enable the bar to locate near the main bearing split line. (See figure 2)

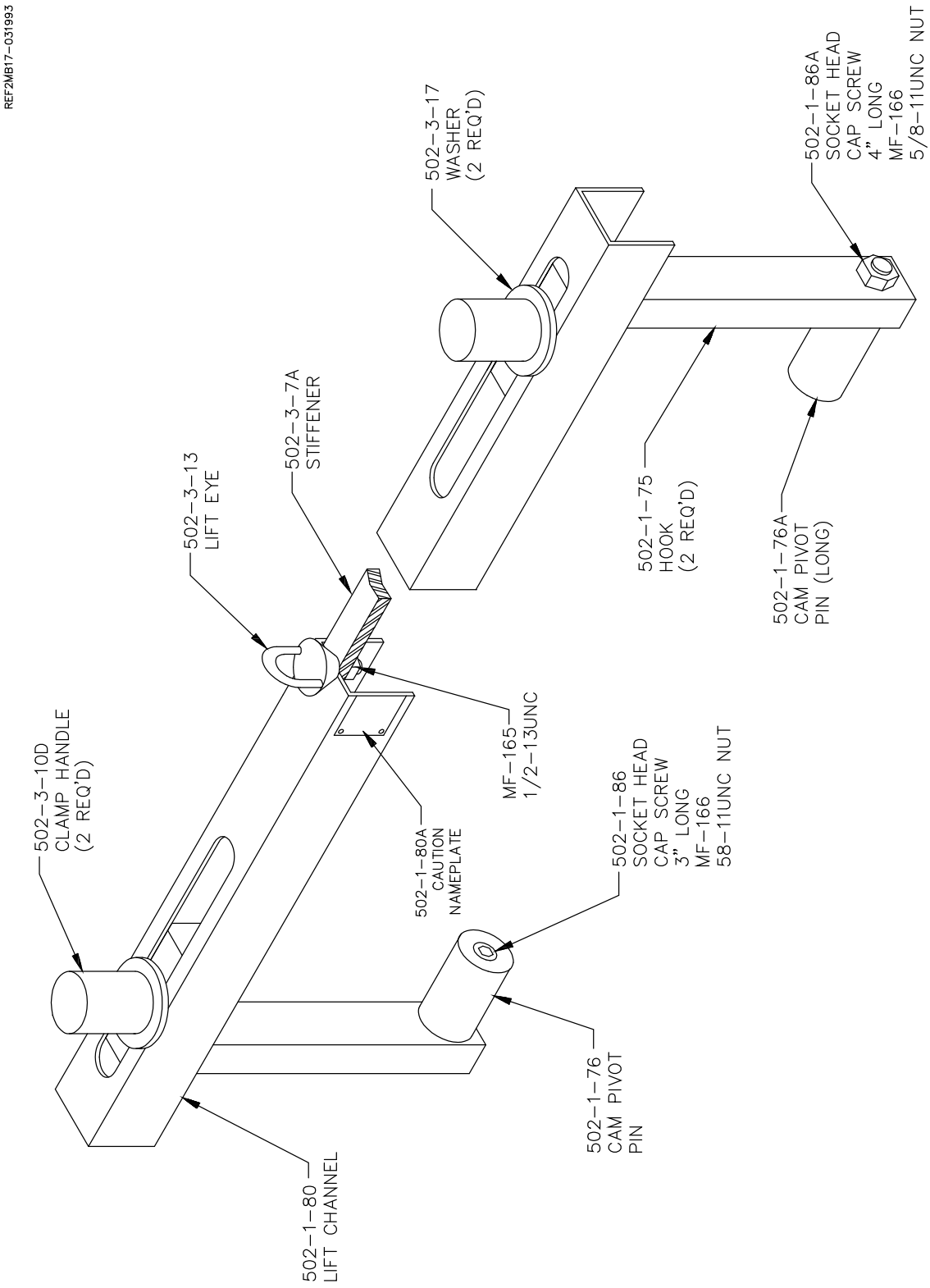
V-blocks:

(blocks with main bearing center lines no more than ½" higher than the pan rail plane) are mounted with the 502-3-8B V-block frame in place. Select the 90-degree option placement of the frame to suit block length, or main bearing caps will interfere with frame. Rotate frame 90 degrees by moving its shoulder screws to alternate set of holes.

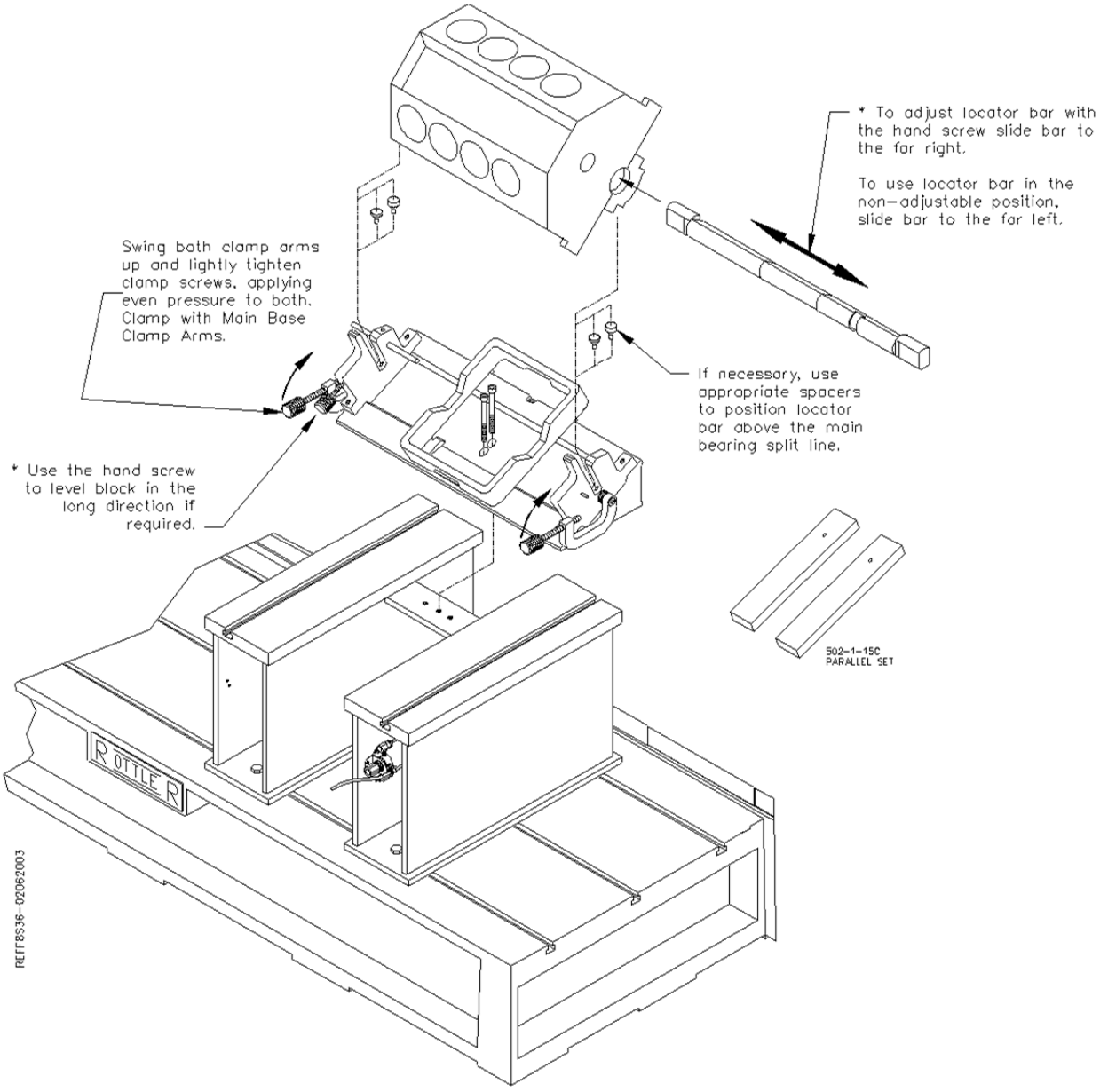
Y-Blocks:

(blocks with main bearing center lines 2-3/8" to 3-1/2" higher than the pan rail plane) are mounted directly on the fixture. Some Y-blocks (GM 60 degree) have too narrow pan rails and some have too low main bearing location which will require the use of the 502-1-15C precision 1-1/4" x 3" parallel set to raise and or support the block. Use the shoulder screw from the V-block frame and hook the parallels over the back of the V-fixture.

This fixture may be easily repositioned on the support parallels (without a block in place) to shift from the 60 degree support surface to the 90 degree support surface or vice versa.


REF2MB17-031993
502-3-17
WASHER
(2 REQ'D)
502-1-86A
SOCKET HEAD
CAP SCREW
4" LONG
MF-166
5/8-11UNC NUT
502-3-7A
STIFFENER
502-3-13
LIFT EYE
502-1-75
HOOK
(2 REQ'D)
502-1-76A
CAM PIVOT
PIN (LONG)
502-3-10D
CLAMP HANDLE
(2 REQ'D)
MF-165
1/2-13UNC
502-1-80A
CAUTION
NAMEPLATE
502-1-86
SOCKET HEAD
CAP SCREW
3" LONG
MF-166
58-11UNC NUT
502-1-76
CAM PIVOT
PIN
502-1-80
LIFT CHANNEL

⚠ WARNING Extreme care must be taken by operator whenever handling large blocks. Large blocks may cause fixture to tip when floated too far outward. We recommend leaving hoist attached when moving these blocks. Large blocks should be lifted from the block bank surface. DO NOT use the 502-1-95 block handler assembly on these blocks.



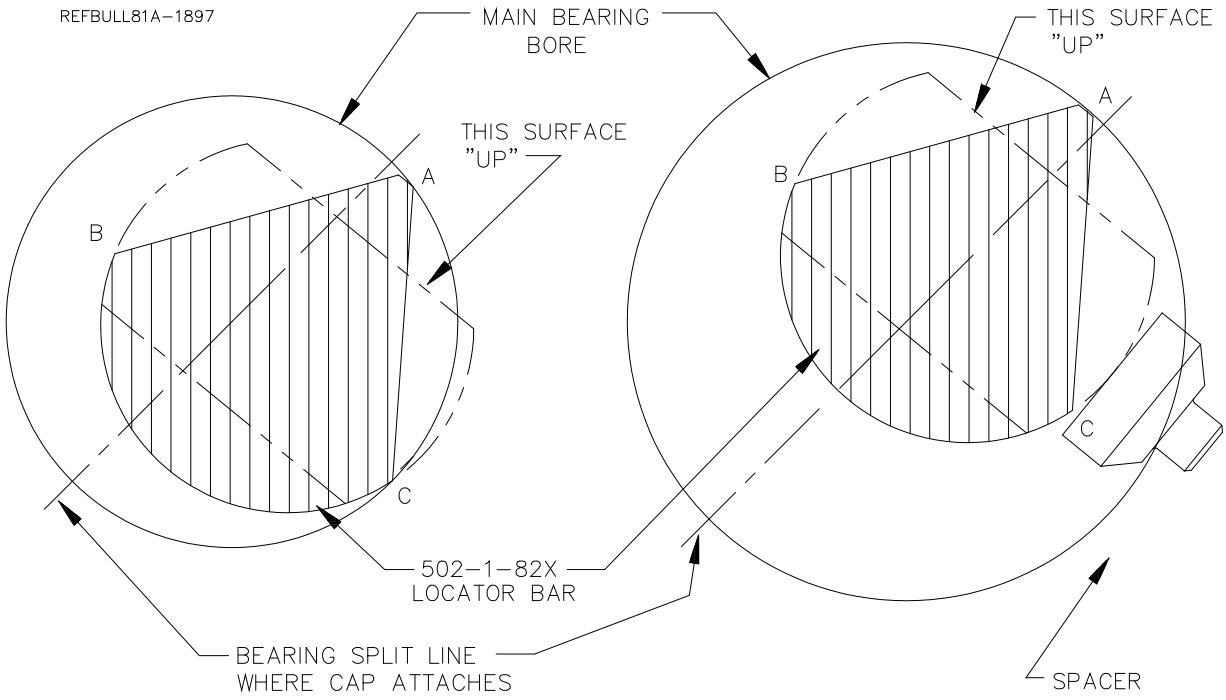


FIGURE 1 FIGURE 2

Normal Operating Procedure:

The normal operation procedure on smaller V-blocks is to first pick up the block. If using the optional 502-1-95 block handler attach it to the block making sure the cam lifters are COMPLETELY engaged, and that the lift hook is approximately centered in the block lengthwise. Place the 502-1-82X locator bar through the main bearings and hoist the block into the fixture. Pulling the block towards you, with the locator against the positioners, will prevent jamming in the slot of the guides during the loading and unloading operations. The locator bar is positioned with the word ‘UP’ that is on the end of the bar facing up and away from the operator. (see figure 1) After the locator bar is engaged in the positioners, pivot block outwards as you lower it. Slide block to the far left (this is the non adjustable position).

Make sure the block is firmly seated in place and not resting on pan-rail burrs or other interference points. Accurate seating can also be a problem with extremely warped, distorted blocks. Another cause of problems is failure to remove main bearing inserts. The locator bar has a relief for blocks with a small main bearing or seal. Rotate locator bar clamps into position & lightly tighten the hand screws, applying even pressure to both. Clamp the block securely with the main base clamp arms.

Warped or distorted blocks may require leveling of the deck surface in the long direction. This is possible with the hand-screw assembly in the left-hand bar positioner. Loosen both clamp hand-screws and slide the locator bar to the far right position. Retighten both clamp hand-screws. Raise or lower the adjusting hand-screw as required. For the non-adjustable position slide locator bar to the far left.

Push fixture back into bore position. There is a guide block (502-1-105) attached to the bottom of the fixture to aid in guiding the fixture along the support ways.

Operate the block clamp arms, bore, and pull fixture back to the load position.

Loosen locator bar hand screws and rotate clamps out of the way. Lift the block, either from the deck surface or with the optional 502-1-95 block handler. Turn the block 180 degrees & reload to duplicate the operation on the other bank.

After turning the engine block 180 degrees the locator bar must be twisted 180 degrees also. Again the word 'UP' must enter into the positioners facing up and away from the operator. (See figure 1).

Figure 1

502-1-82X main bearing locator bar indexes at point A. When bank is reversed and the bar is twisted 180 degrees, point A still indexes the main bearing.

Point C holds the block down. When bank is reversed and the bar is twisted 180 degrees, point B holds the block down.

Figure 2

502-1-82X main bearing locator bar indexes near bearing split line. Point C does not contact the bearing cap but rests on matched spacers that are provided to fit in the bar positioners slot. If there is a means of holding the block down such as block clamp towers, this method may be used in large bores in order to properly index near the bearing split line. If extreme care is used this method may be used to index blocks without bearing caps attached. (Optional clamp down must be provided).

Surfacing Application:

NOTE: The block must have the main bearing caps in place and torqued.

Care must be taken to assure the contact edges of the locator bar are near the cap split line. A pair of 3/8" and ½" spacers are provided for blocks with large main bearing bores, to enable the bar to locate near the main bearing split line. (See figure 2)

V-blocks:

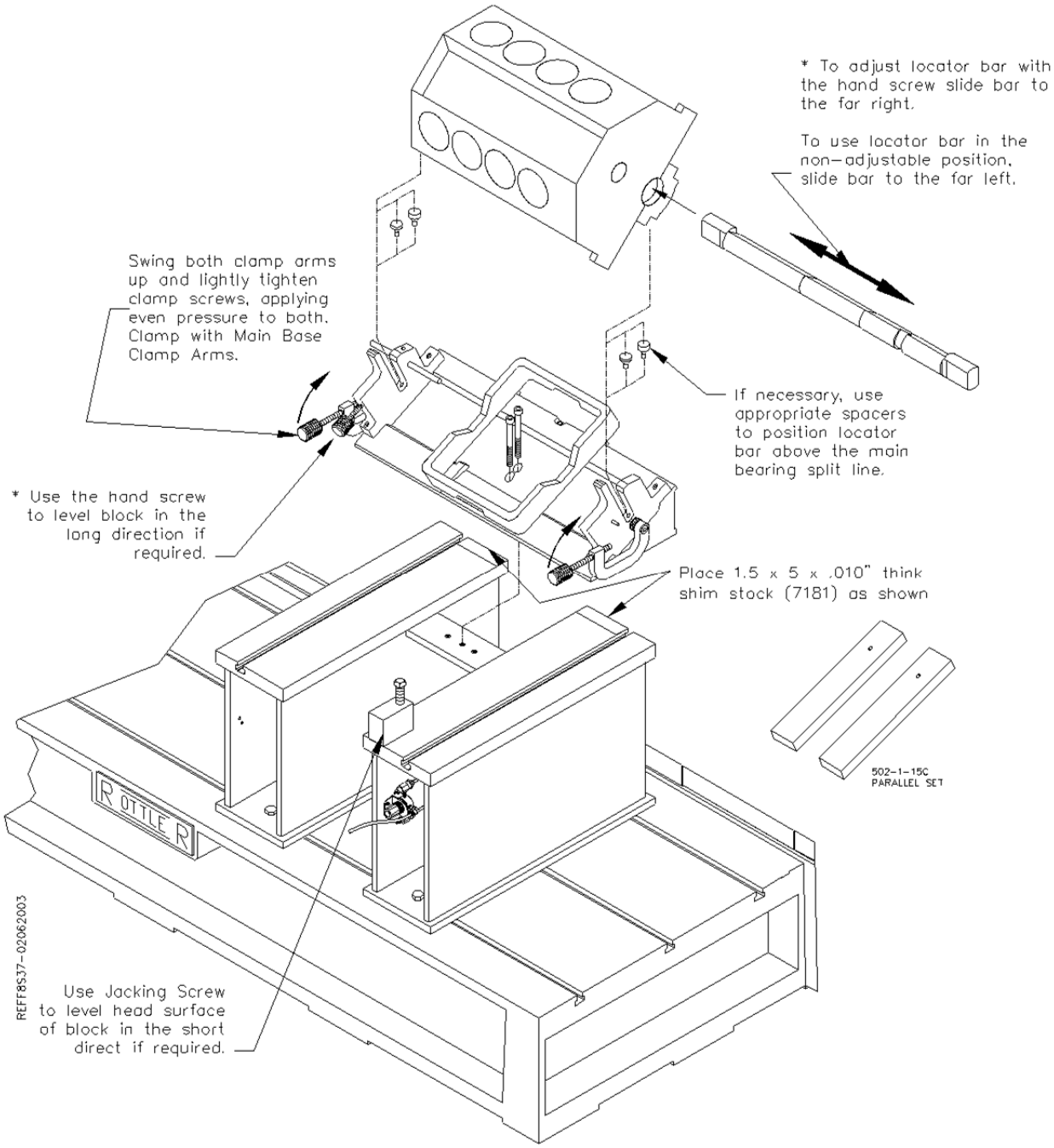
(blocks with main bearing center lines no more than ½" higher than the pan rail plane) are mounted with the 502-3-8B V-block frame in place. Select the 90-degree option placement of the frame to suit block length, or main bearing caps will interfere with frame. Rotate frame 90 degrees by moving its shoulder screws to alternate set of holes.

Y-Blocks:

(blocks with main bearing center lines 2-3/8" to 3-1/2" higher than the pan rail plane) are mounted directly on the fixture. Some Y-blocks (GM 60 degree) have too narrow pan rails and some have too low main bearing location which will require the use of the 502-1-15C precision 1-1/4" x 3" parallel set to raise and or support the block. Use the shoulder screw from the V-block frame and hook the parallels over the back of the V-fixture.

This fixture may be easily repositioned on the support parallels (without a block in place) to shift from the 60 degree support surface to the 90 degree support surface or vice versa.

⚠ WARNING Extreme care must be taken by operator whenever handling large blocks. Large blocks may cause fixture to tip when floated too far outward. We recommend leaving hoist attached when moving these blocks. Large blocks should be lifted from the block bank surface. DO NOT use the 502-1-95 block handler assembly on these blocks.



Normal Operating Procedure:

The normal operation procedure on smaller V-blocks is to first pick up the block. If using the optional 502-1-95 block handler (see page 9.20), attach it to the block making sure the cam lifters are COMPLETELY engaged, and that the lift hook is approximately centered in the block lengthwise. Place the 502-1-82X locator bar through the main bearings and hoist the block into the fixture. Pulling the block towards you, with the locator against the positioners, will prevent jamming in the slot of the guides during the loading and unloading operations. The locator bar is positioned with the word 'UP' that is on the end of the bar facing up and away from the operator. (see figure 1) After the locator bar is engaged in the positioners, pivot block outwards as you lower it. Slide block to the far left (this is the non adjustable position).

Make sure the block is firmly seated in place and not resting on pan-rail burrs or other interference points. Accurate seating can also be a problem with extremely warped, distorted blocks. Another cause of problems is failure to remove main bearing inserts. The locator bar has a relief for blocks with a small main bearing or seal. Rotate locator bar clamps into position & lightly tighten the hand screws, applying even pressure to both. Clamp the block securely with the main base clamp arms.

Warped or distorted blocks may require leveling of the deck surface in the long direction. This is possible with the hand-screw assembly in the left-hand bar positioner. Loosen both clamp hand-screws and slide the locator bar to the far right position. Retighten both clamp hand-screws. Raise or lower the adjusting hand-screw as required. For the non-adjustable position slide locator bar to the far left.

Push fixture back into surfacing position with the back of the fixture on the Shim Stock. The shim stock is put in place to raise the back side of the block, you can then use the Jacking Screw to raise and lower the front of the block. There is a guide block (502-1-105) attached to the bottom of the fixture to aid in guiding the fixture along the support ways.

Operate the block clamp arms, surface, and pull fixture back to the load position.

Loosen locator bar hand screws and rotate clamps out of the way. Lift the block, either from the deck surface or with the optional 502-1-95 block. Turn the block 180 degrees & reload to duplicate the operation on the other bank.

After turning the engine block 180 degrees the locator bar must be twisted 180 degrees also. Again the word 'UP' must enter into the positioners facing up and away from the operator. (See figure 1).

Figure 1

502-1-82X main bearing locator bar indexes at point A. When bank is reversed and the bar is twisted 180 degrees, point A still indexes the main bearing.

Point C holds the block down. When bank is reversed and the bar is twisted 180 degrees, point B holds the block down.

Figure 2

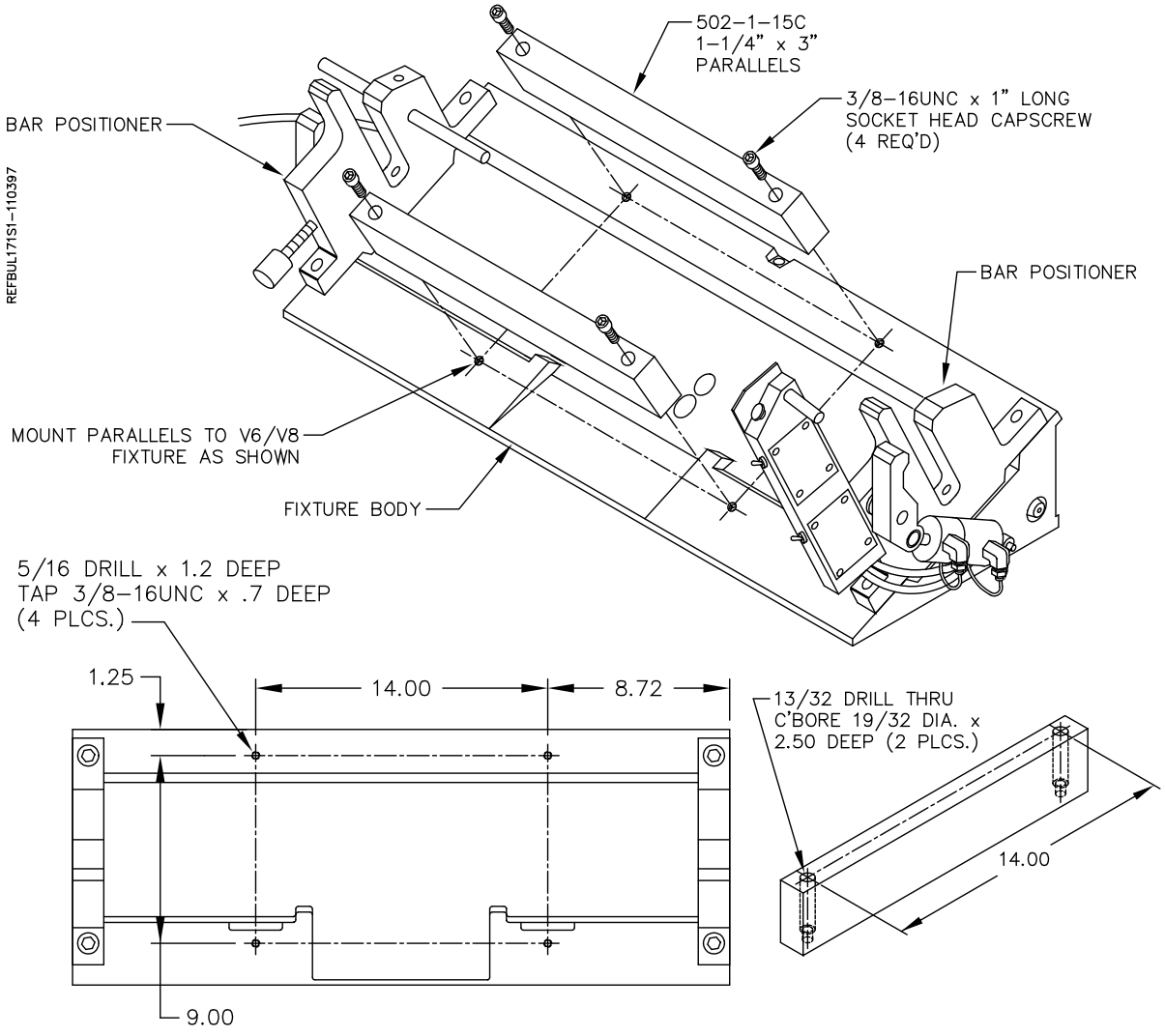
502-1-82X main bearing locator bar indexes near bearing split line. Point C does not contact the bearing cap but rests on matched spacers that are provided to fit in the bar positioners slot. If there is a means of holding the block down such as block clamp towers, this method may be used in large bores in order to properly index near the bearing split line. If extreme care is used this method may be used to index blocks without bearing caps attached. (Optional clamp down must be provided).

Retrofitting 502-1-15C Parallels to V6/V8 Combination Fixture

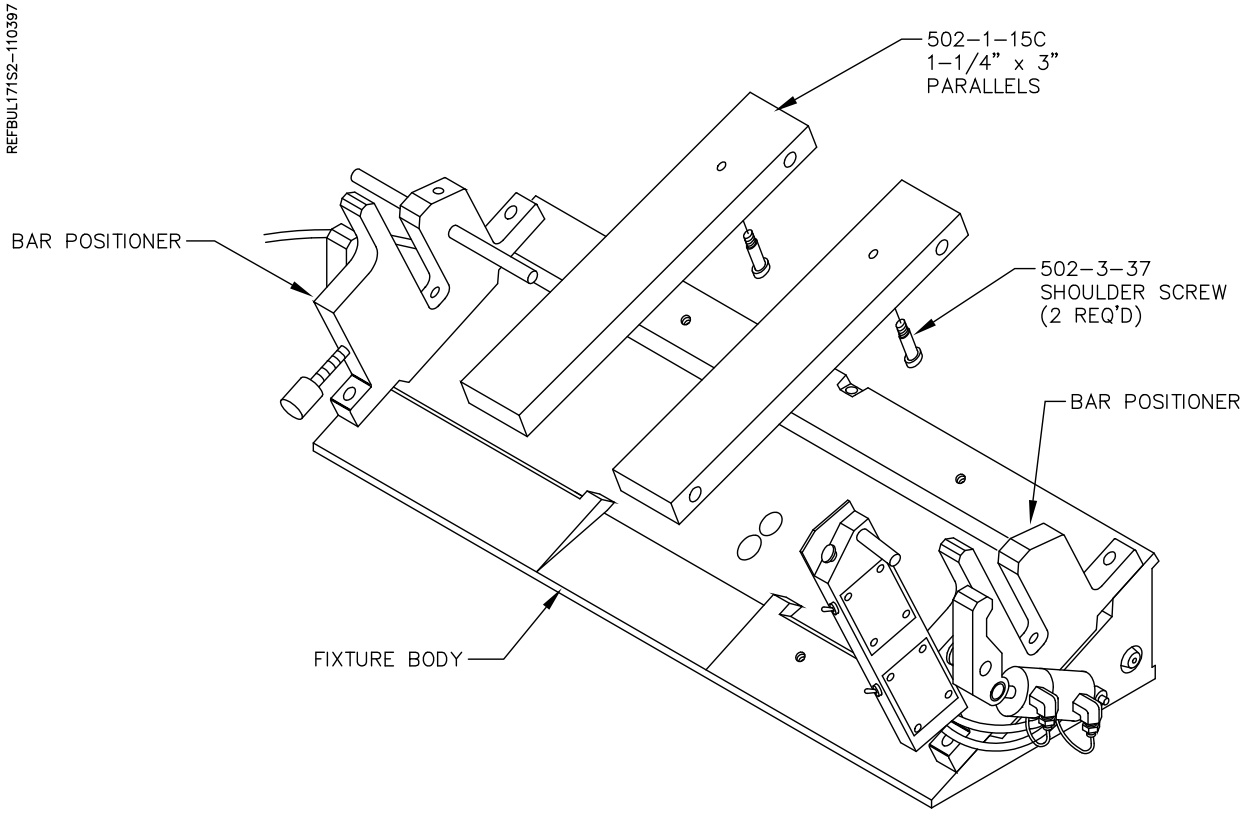
(Special Applications)

Some engine blocks with large main bores (3-1/8” and larger) cause a problem of the locator bar bottoming out in the bar positioners and/or the V-shaped relief’s of the 502-3-8B V-block frame before clamping the block properly. Mounting the 502-1-15C parallel set as shown below in place of the V-block frame will provide proper clearance for clamping. Older style fixtures and parallels can be modified to this configuration using illustrations below.

V-6 blocks with one-piece ‘caged’ main bearing caps (all caps are connected) can interfere with 502-3-8B V-block frame. The parallel arrangement shown below will allow proper support and clamping of these blocks.



Some V-6 engine blocks (for example Buick V-6) have main bearing bores that are too low in respect to the pan rails. This presents a problem of the locator bar bottoming out in the bar positioners before the block is properly clamped. Positioning the 502-1-15C parallel set as shown below will raise the block enough to provide proper clamping.



Diesel Blocks:
6725 Diesel Fixture:

Small Diesel V Blocks:

On these blocks it will be necessary to install the 6370Z, 10” parallels or 6794E, 8” parallels onto the bed of the machine. These parallels are keyed, place them onto the deck surface and then push them toward the rear of the machine. This will located them evenly on the middle keyway of the machine bed. Place the two 6553F main bearing supports onto the parallels, these are also keyed and fit into the machined slots on the parallels. This will put the two main bearing supports in line with each other. Tighten all bolts to lock the parallels and main bearing support into place. Select the correct size main bearing locators and install them into the mains of the block..

Note: Make sure there are no burrs or debris in the main bearing bores where they will contact the main bearing locators. This can cause the block not to clamp properly and may cause tipping or rocking of the block.

⚠ WARNING Handle these large blocks with Extreme care and guidance. A block hoist is required when handling these blocks. These blocks should be lifted from the block bank surface. DO NOT use 502-1-95 Block Handler assembly on these blocks.

Install the main bearing locators into the mains of the engine block. Lower the block so that the locators go into the main bearing support.

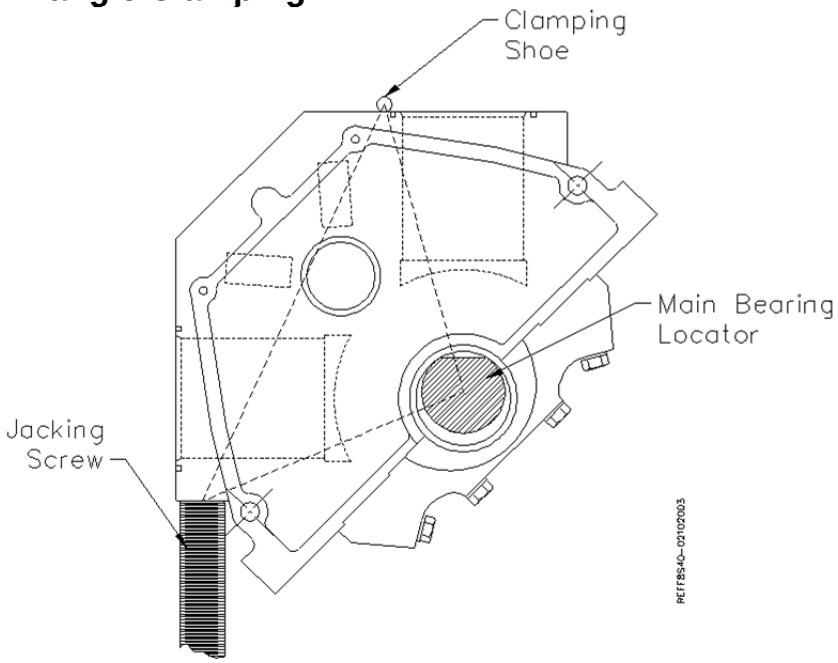
⚠ DANGER The hoist must remain attached to the block until it is firmly clamped into position. The blocks will have a tendency to tip forward until they are properly supported and clamp. When not properly supported and attached to a hoist these blocks will roll forward and out of the fixture. This will cause severe injury or death to operator.

Select the correct jacking screw to reach the block. Place the jacking screws into the jack bodies and place on the parallels in a location they will support the block from rolling forward.

Position the block clamps so the front of the shoe will clamp the block in the middle on both ends. The following illustration shows the correct triangle clamping system that should be used.

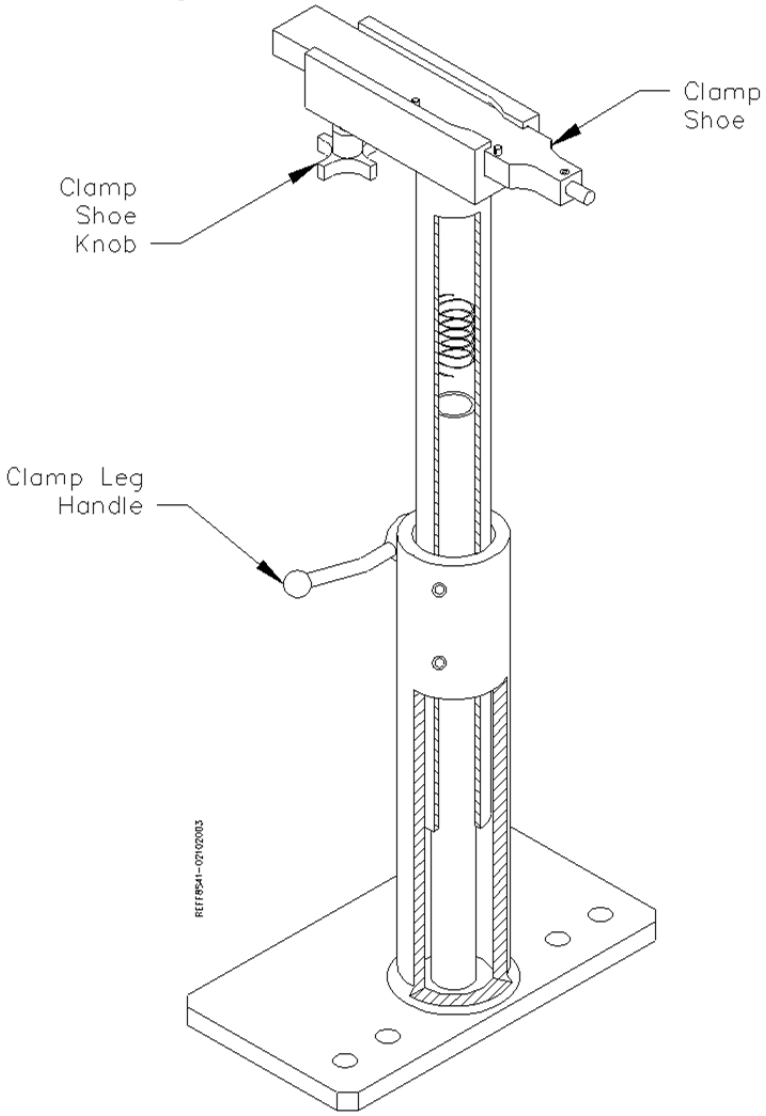
You can raise and lower the ends of the block by rotating the Hex nut located on the ends of the main bearing locators.

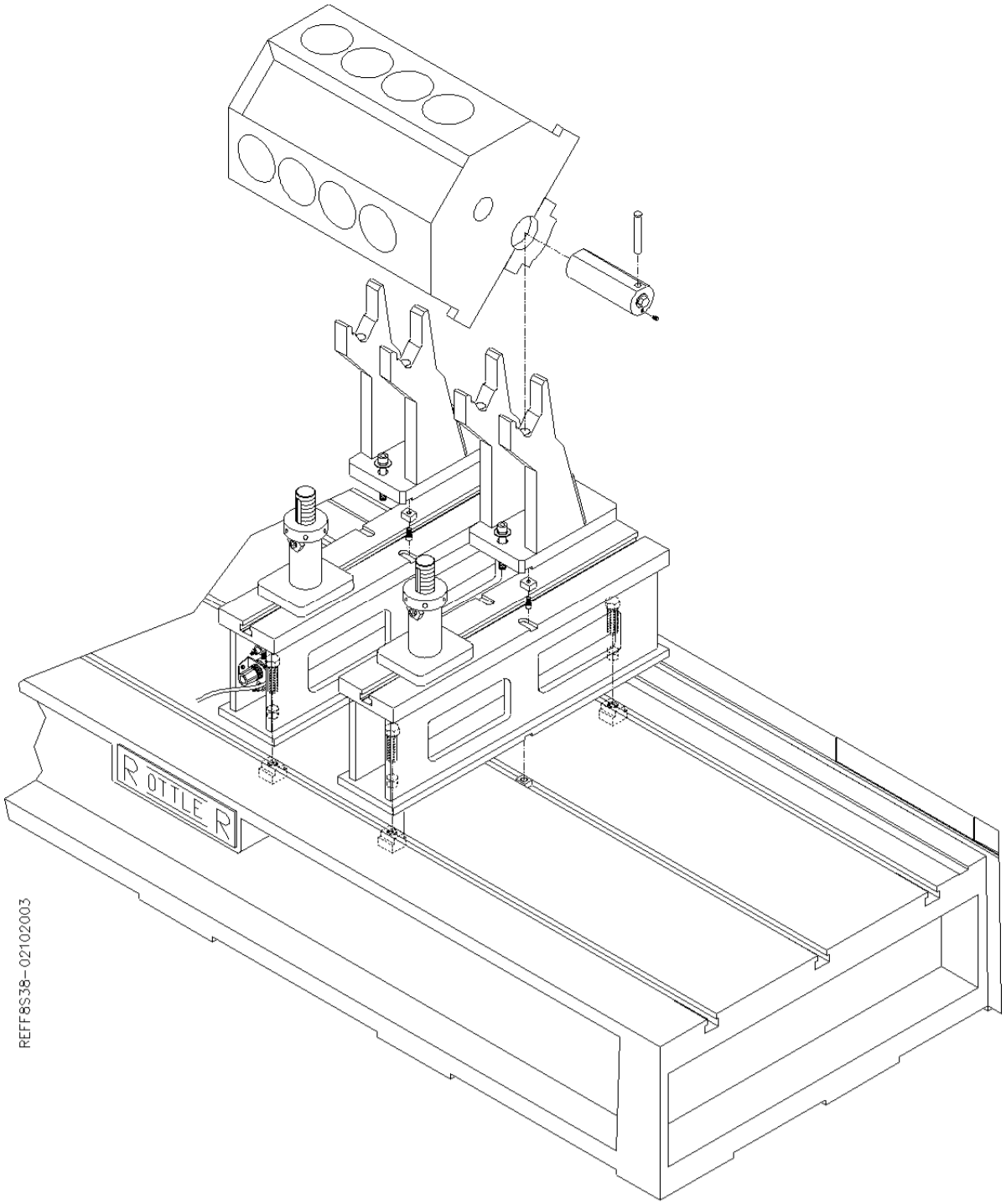
Triangle Clamping:



Adjust the height so the shoes rest on the clamp points. Tighten the clamp leg handles. Actuate the clamp shoes by turning their knobs. Apply pressure to the two clamps as evenly as possible to avoid tipping the block up on one side.

Block Clamp Arm:




ROTTLER
REFF8S38-02102003

Small Diesel In Line Blocks:

On these blocks it will be necessary to install the 6370Z, 10" parallels onto the bed of the machine. These parallels are keyed, place them onto the deck surface and then push them toward the rear of the machine. This will located them evenly on the middle keyway of the machine bed. Place the two 6553F main bearing supports onto the parallels, these are also keyed and fit into the machined slots on the parallels. Use the forward machined slots. This will put the two main bearing supports in line with each other, and on centerline of the machine bed.
Position the fixtures at a distance apart equal to the outboard main journals. Tighten all bolts to lock the parallels and main bearing support into place. Select the correct size main bearing locators, and install them into the mains of the block. Notice the locators have a flat area. Installing with the flat side up will allow end to end height adjustment of the block by rotating the locator. Installing with the round side up will position the block so all machining operations are parallel and perpendicular to the main bore centerline. This simply requires leveling the block in the front to rear direction.

Note: Make sure there are no burrs or debris in the main bearing bores where they will contact the main bearing locators. This can cause the block not to clamp properly and may cause tipping or rocking of the block.

⚠ WARNING Handle these large blocks with Extreme care and guidance. A block hoist is required when handling these blocks. These blocks should be lifted from the block bank surface. DO NOT use 502-1-95 Block Handler assembly on these blocks.

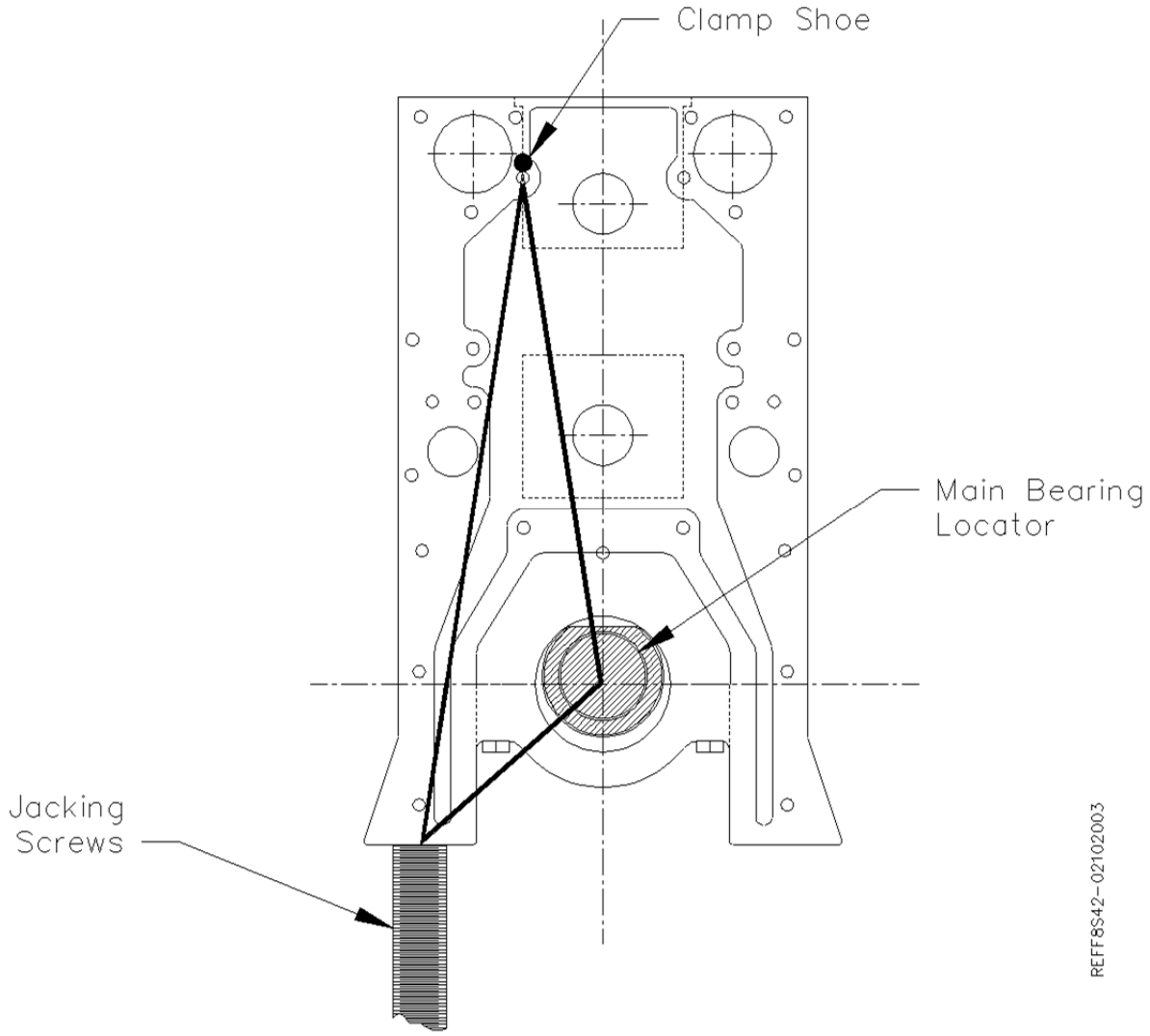
Lower the block so that the locators go into the main bearing support. A clevis pin is provided to keep the locator in position on the main bearing support.
For in-line blocks, load the block with the heavier side towards the front.

⚠ DANGER The hoist must remain attached to the block until it is firmly clamped into position. The blocks will have a tendency to tip until they are properly supported and clamp. When not properly supported and attached to a hoist these blocks will roll forward or backwards and out of the fixture. This will cause severe injury or death to operator.

Select the correct jacking screws to reach the block. Place the jacking screws into the jack bodies and place on the machine bed in a location they will support the block from rolling forwards. Rough level the block using a spirit level.

The following illustration shows the correct triangle clamping system that should be used.

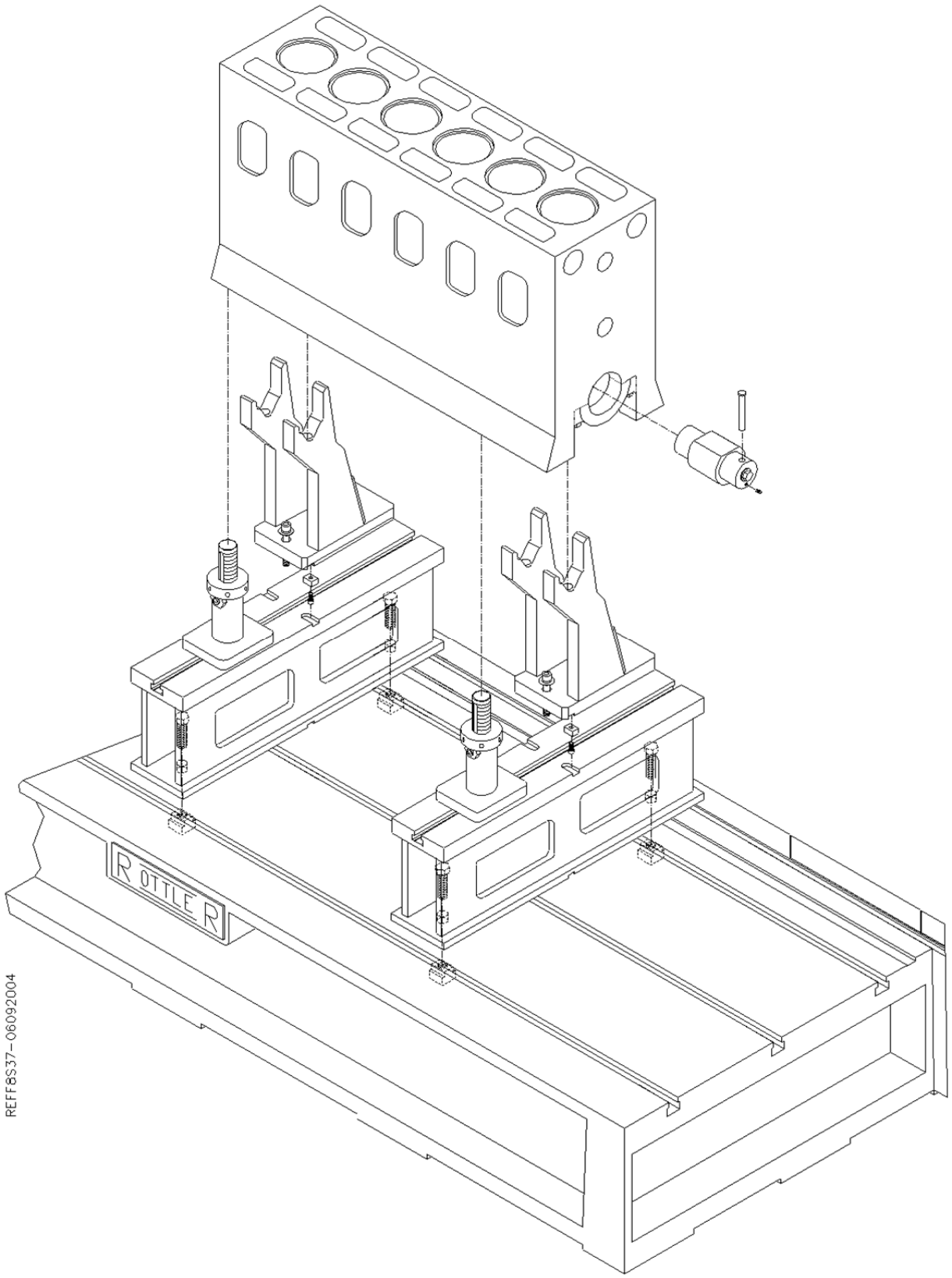
Triangle Clamping:



Adjust the height so the shoes rest on the clamp points. Tighten the clamp leg handles. Actuate the clamp shoes by turning their knobs. Apply pressure to the two clamps as evenly as possible to avoid tipping the block up on one side.

Be sure the clamp is below the deck surface if you to resurface the block.

⚠ WARNING Do not release the hoist or lifting device from the block until the clamping is secure.


ROTTLER
REFF8S37-06092004

6405F Large V-Block Fixture:

Place the 6405 supports on the machine bed. Make sure there is no debris or burrs on the mating surfaced. The supports should be placed on the machine bed with the two dowels on the bottom of the supports into the middle keyway. Place the supports the same distance apart as the mains you will be using. On long blocks, it is recommended to use main bearing locations inward from the ends, to more equally balance the block and avoid sag. Push the supports back toward the rear of the machine against the dowel pins. This will line the supports up with each other. Tighten the four (4) mounting bolts on each support.

Install the correct size locators into the main bores that will be used.

⚠ WARNING Handle these large blocks with Extreme care and guidance. A block hoist is required when handling these blocks. These blocks should be lifted from the block bank surface.

⚠ DANGER The hoist must remain attached to the block until it is firmly clamped into position. The blocks will have a tendency to tip until they are properly supported and clamp. When not properly supported and attached to a hoist these blocks will roll forward or backwards and out of the fixture. This will cause severe injury or death to operator.

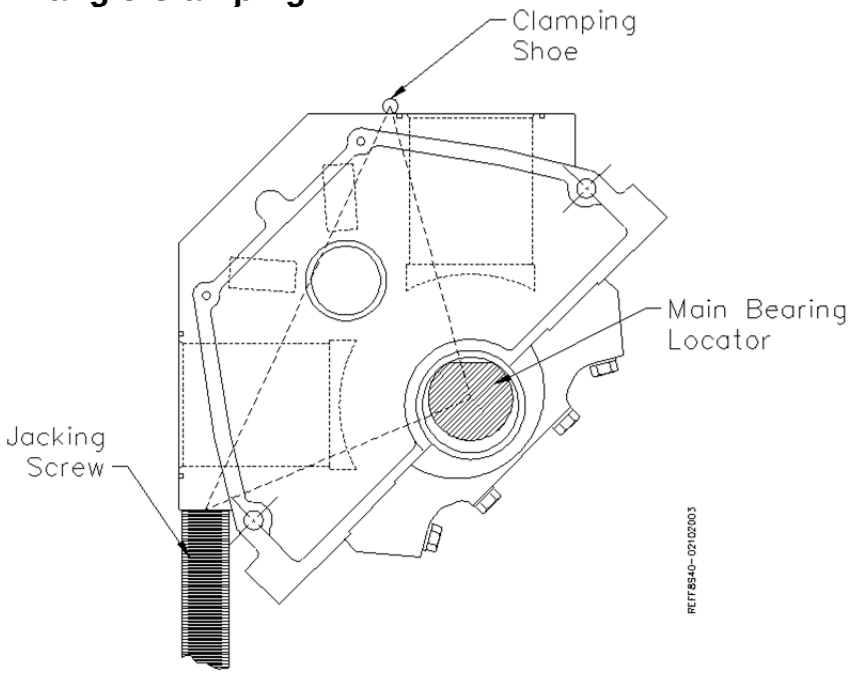
The main bearing bores being used, should be on centerline of each support. Set the jacking bodies, with the proper length jack screw installed onto the machine base. These should be located in the general area of the supports. Temporarily secure to the deck with at least one bolt.

Lower the block down onto the supports. Place a level on the deck of the engine block and check the level front to back. Position the jack stands in a location to properly support the block and secure. To level, use the jacking screws to raise or lower the front of the engine block.

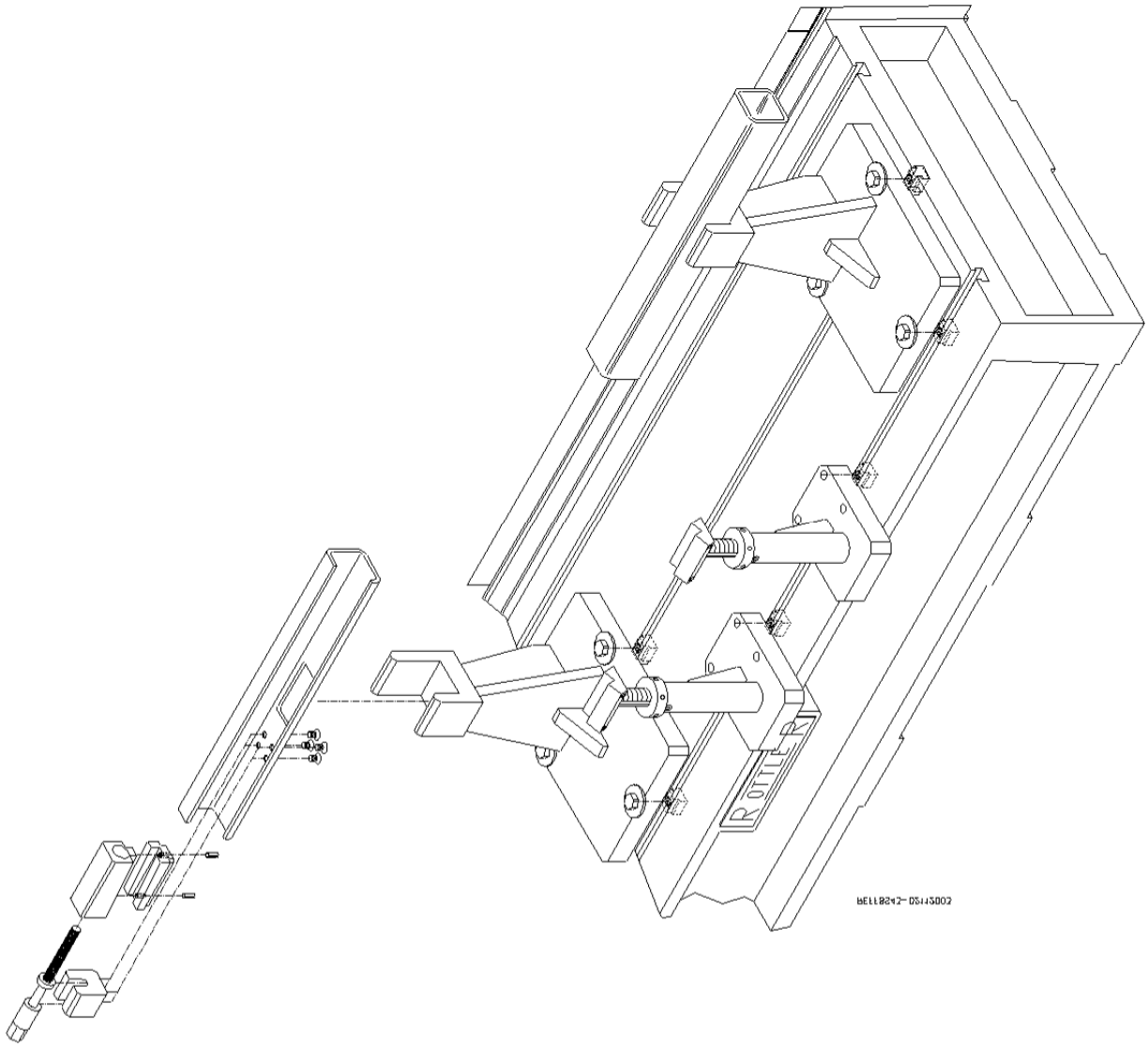
Position the block clamps on the machine bed and secure in a location to allow proper clamping.

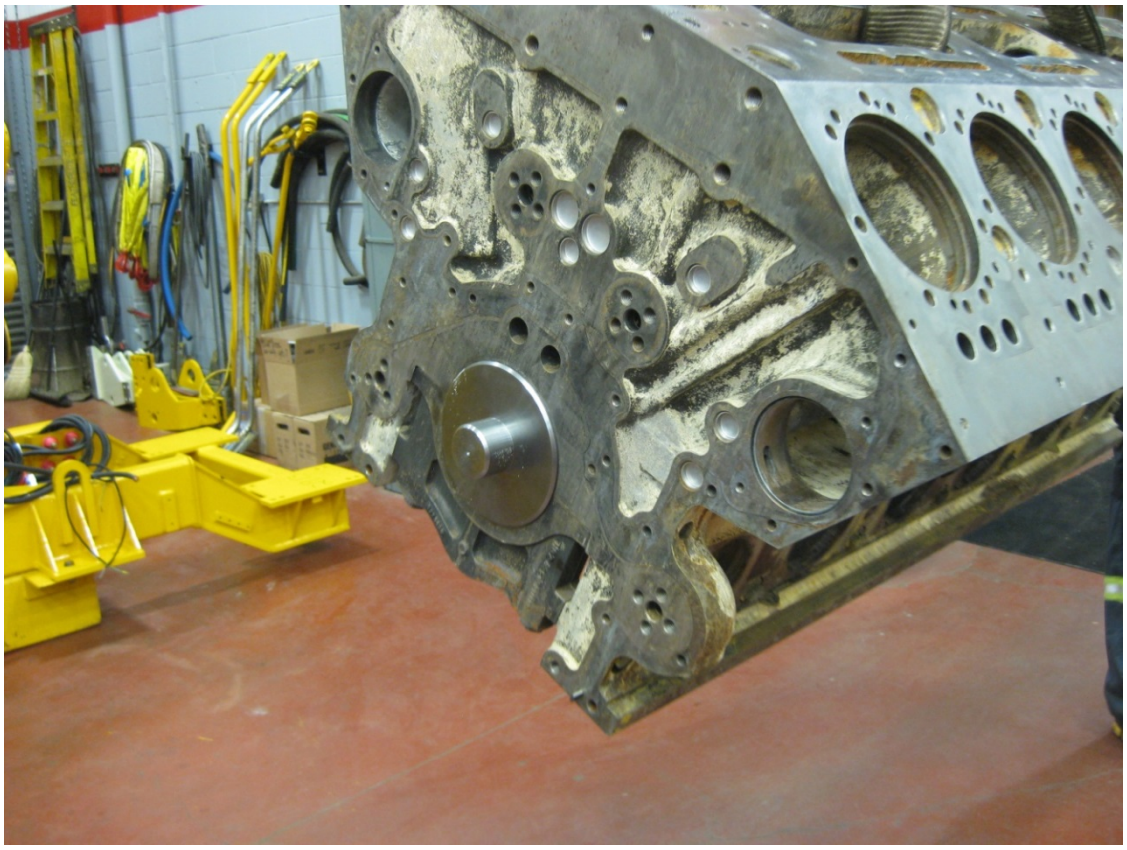
The following illustration shows the correct triangle clamping system that should be used.

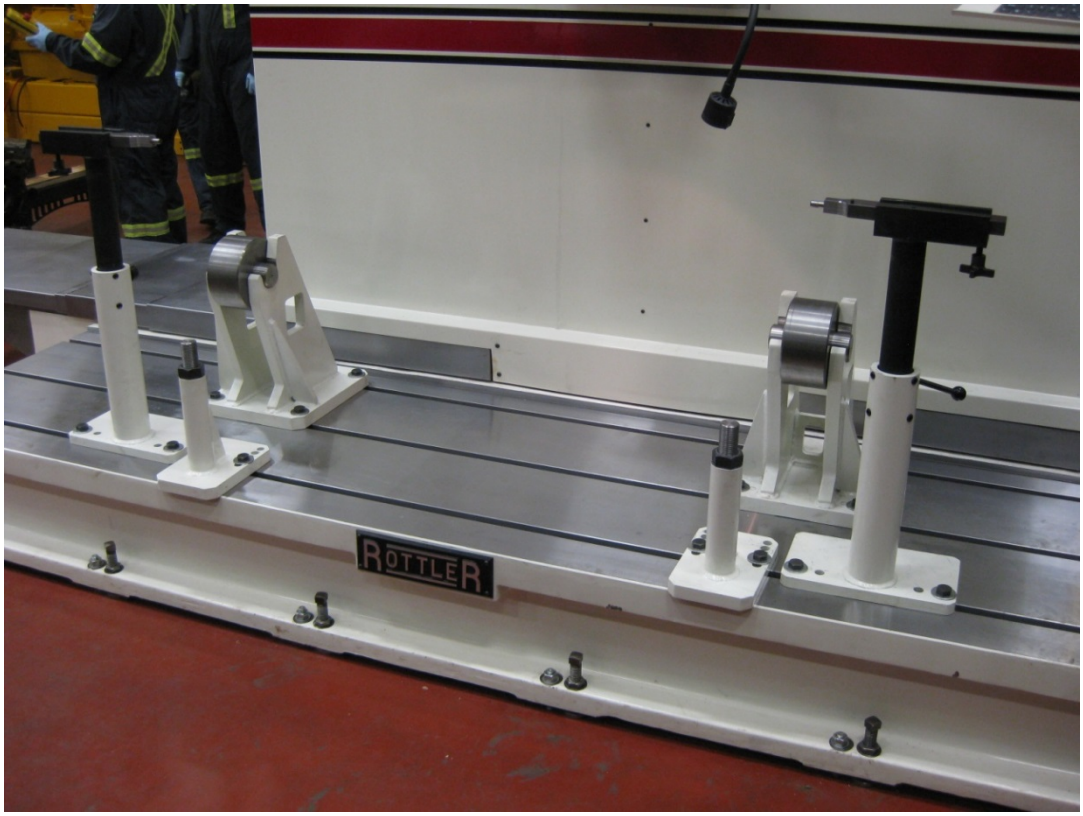
Triangle Clamping:

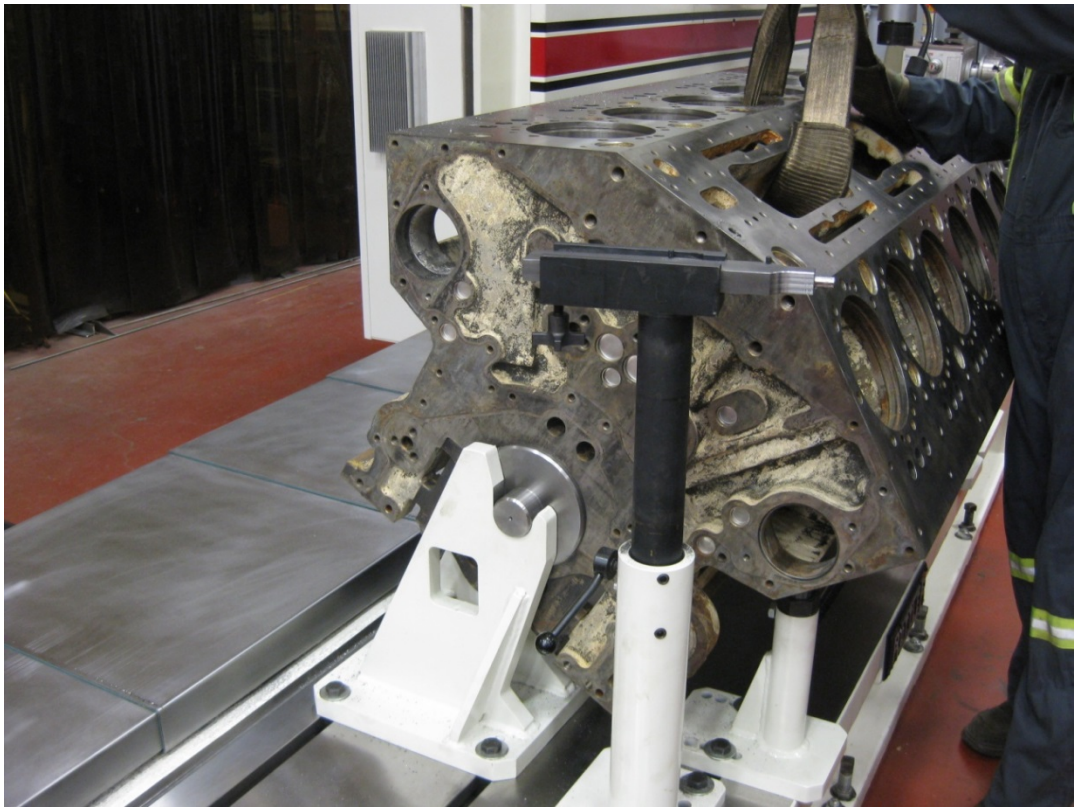


Adjust the height so the shoes rest on the clamp points. Tighten the clamp leg handles. Actuate the clamp shoes by turning their knobs. Apply pressure to the two clamps as evenly as possible to avoid tipping the block up on one side.






ROTTLER

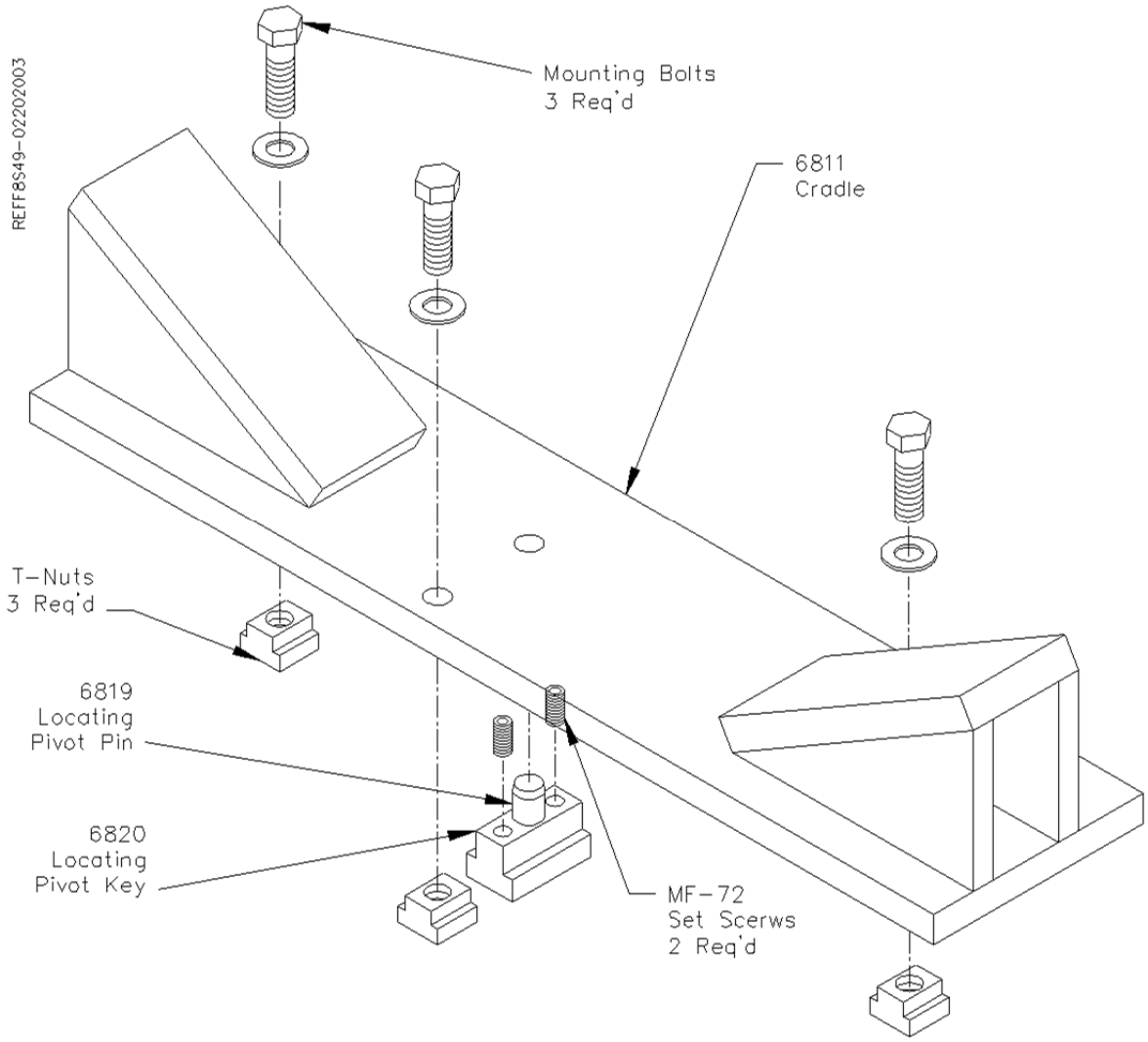


6810 Waukesha 7042, 9390 and CAT 379, 398, 399 Block Line Bore Fixture:

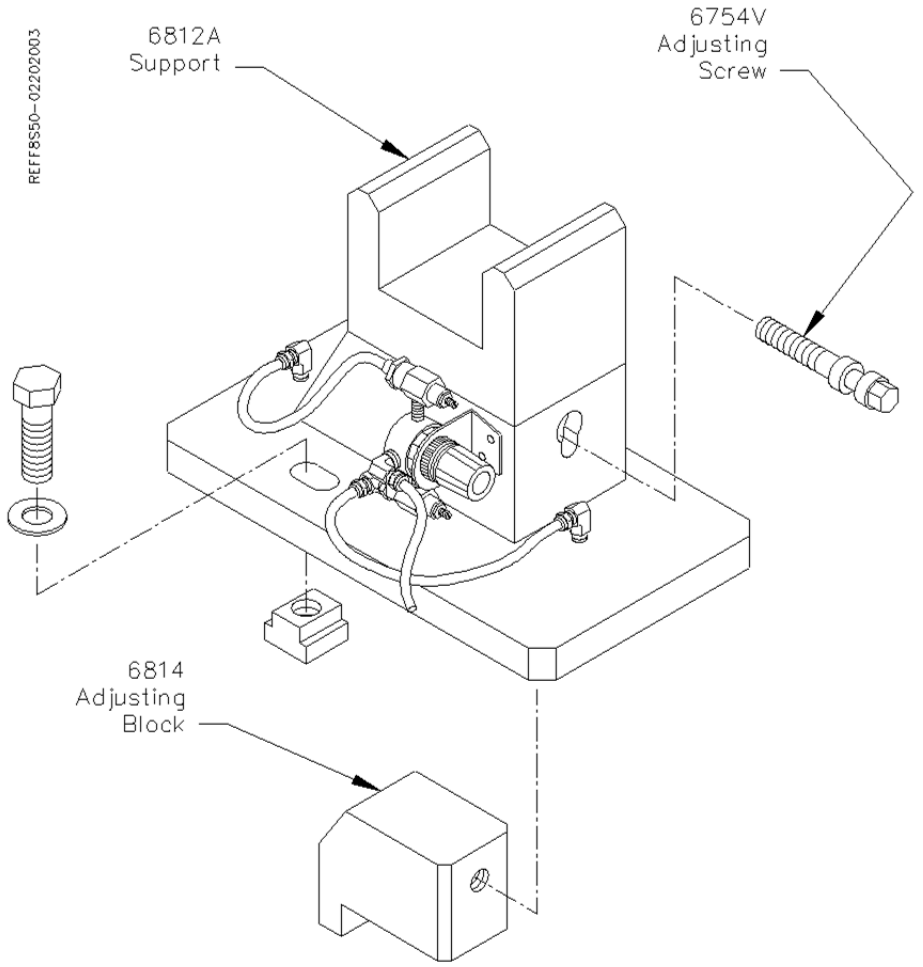
This fixture is designed to be mounted directly on the bed of an F90 machine. Due to the large size of the Waukesha 7042 block, care must be taken when loading and unloading to avoid bumping the block into the block into the column or spindle unit.

⚠ WARNING Handle these large blocks with Extreme care and guidance. A block hoist is required when handling these blocks.

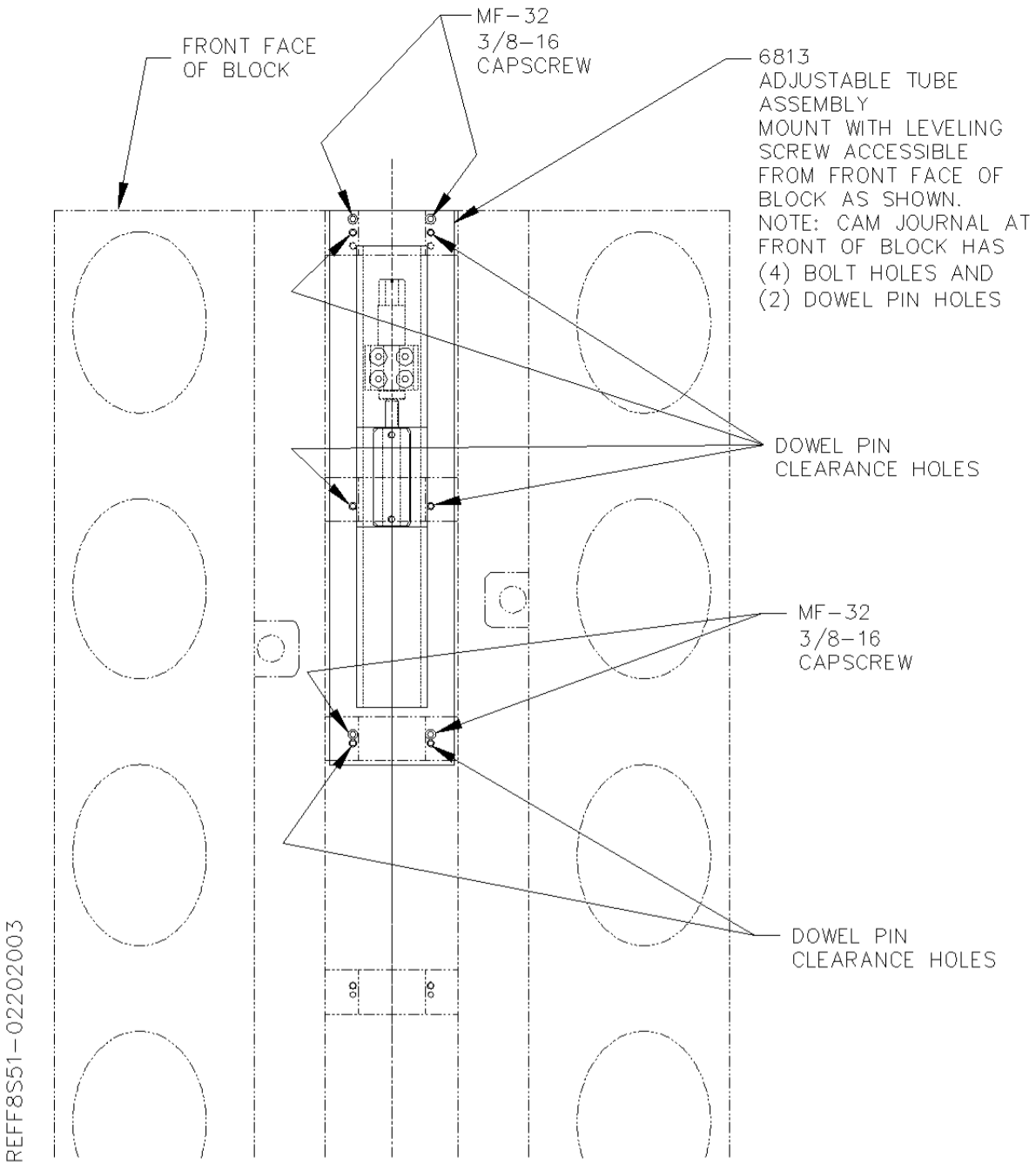
Use the diagram on the following pages when referring to part numbers listed below. This Line Bore fixture consists of a stationary cradle and a adjustable support. The Cradle (6811A) is mounted to the machine bed over the locating pivot key and pin assembly. The locating pivot pin (6819) is pressed into the locating pivot key (6820). This assembly is positioned in the center keyway of the machine bed and the (2) set screws (MF-72) are tightened to lock the key in place. The Cradle is positioned over the pin and mounted to the machine bed. With the mounting bolts installed but not tight this provides a standard pivot point for the Cradle.



The support (6812A) is assembled with the adjusting screw (6754V) and the adjusting block (6814). This assembly is mounted to the machine bed with the lower tab of the adjusting block in the center keyway. **Be sure to install the special ratchet adjusting wrench prior to setting this assembly on the machine bed**

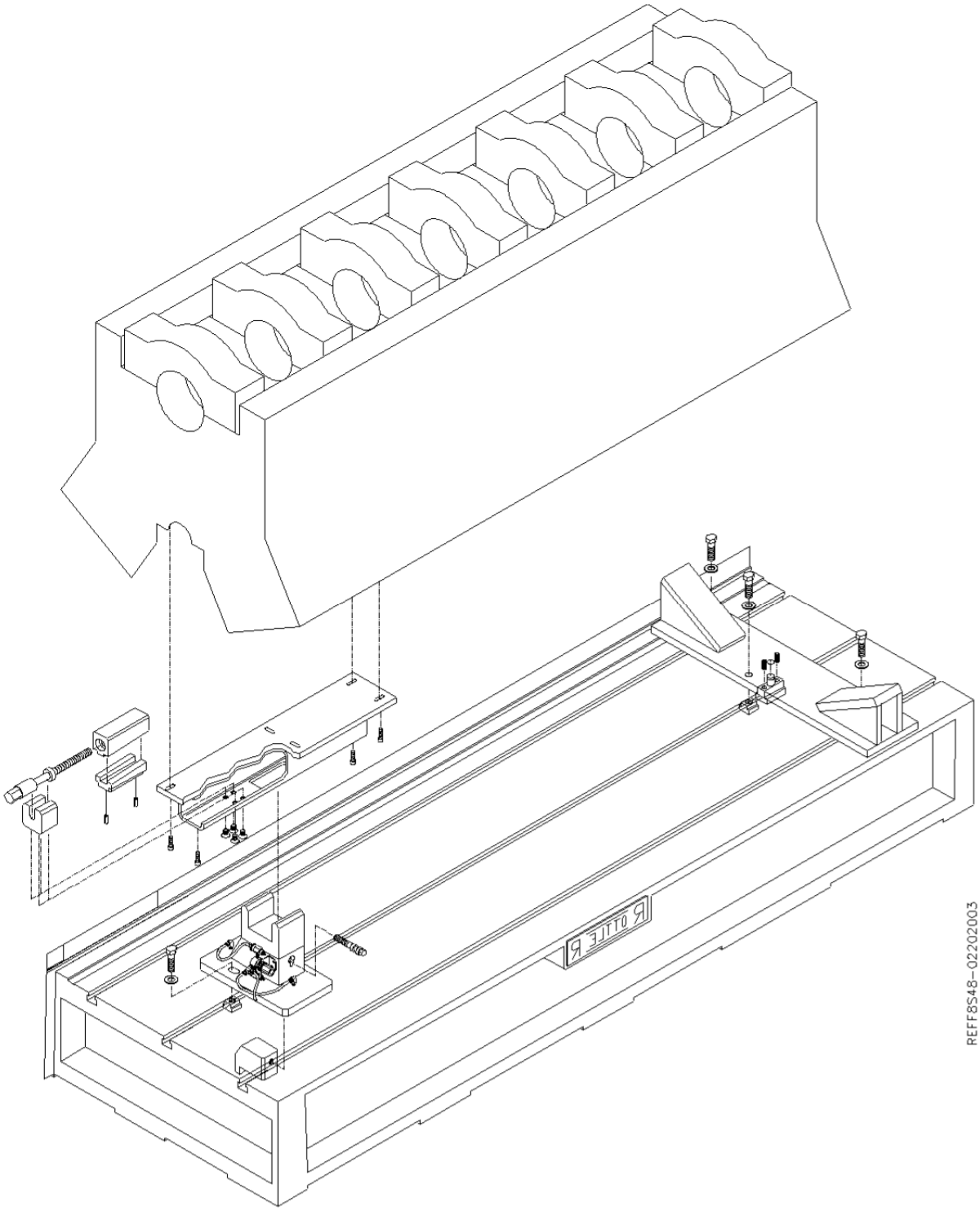


The adjustable tube (6813) is bolted to the Waukesha Block using the Cam Bearing Cap mounting holes. The adjustable tube has ten (10) holes drilled in it. Four (4) of the holes are used to bolt the adjustable tube to the engine block, the remaining six (6) holes are clearance for the cap alignment dowel pins in the engine block. Since the Cam Bearing Caps are not evenly spaced along the block, the adjustable tube must be mounted on the front end of the block as shown in the following illustration.



The upper and lower leveling pads, bracket and screw are already installed in the adjustable tube.

With the adjustable tube installed, the block is ready to be lowered into the Cradle and Support. Use caution to locate the adjustable tube correctly on the support. The two roll pins (MF-229B) installed in the lower leveling pad (6411) are designed to locate the leveling pads properly.



All mounting bolts should be loose to start with. Due to the design of this fixture the Cradle end of the block is stationary both in relationship to the machine bed key way and in height. This end is not adjustable. The adjustable end of the fixture is located on the same machine bed keyway as the cradle. Once the block is loaded into the fixture it is ready to be aligned for the line boring operation. Up and down adjustment is accomplished using the leveling screw (6408) inside the adjustable tube. The block is adjusted in and out by activating the air float on the support, and turning the adjustment screw using the previously installed ratchet wrench. Once the block is located in and out deactivate the air float and tighten the support end mounting bolt to lock into

place. Tighten the three (3) mounting bolts on the Cradle end of the fixture now. The alignment of the block should be checked again at this time. Repeat alignment adjustments as needed.

6821 Adjustable, Universal Line Bore Parallel Assembly:

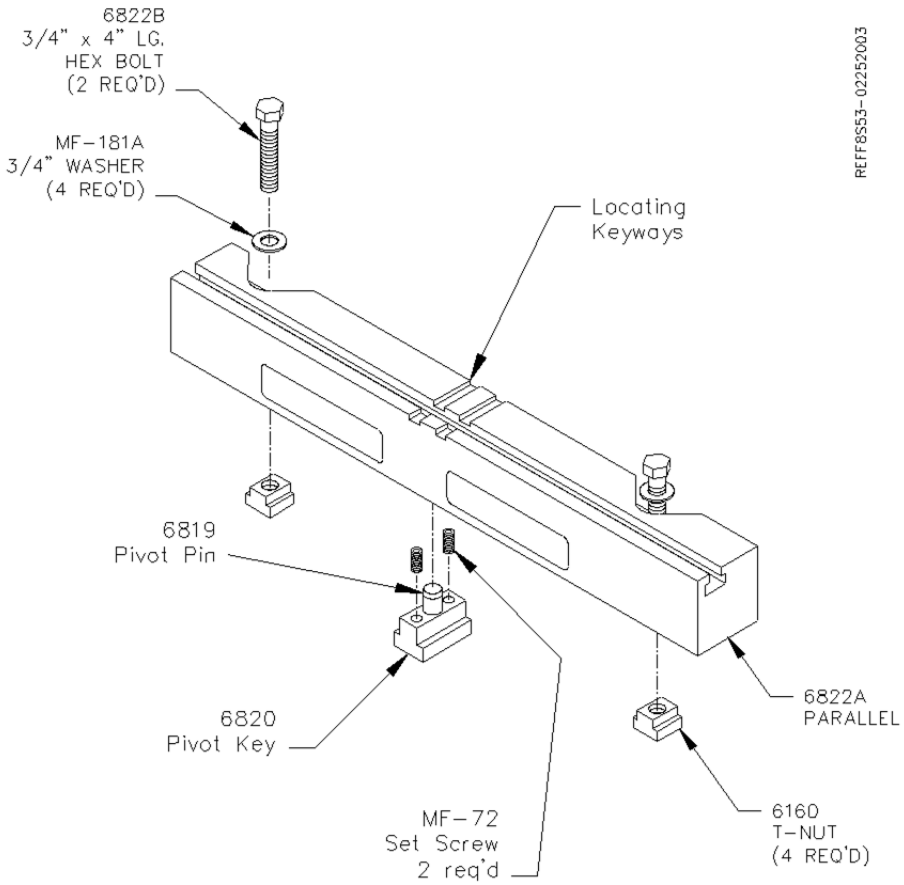
This fixture is designed to be mounted directly on the bed of the F90 series machine.

Due to the large size of the these blocks, care must be taken when loading and unloading to avoid bumping the block into the column or spindle unit.

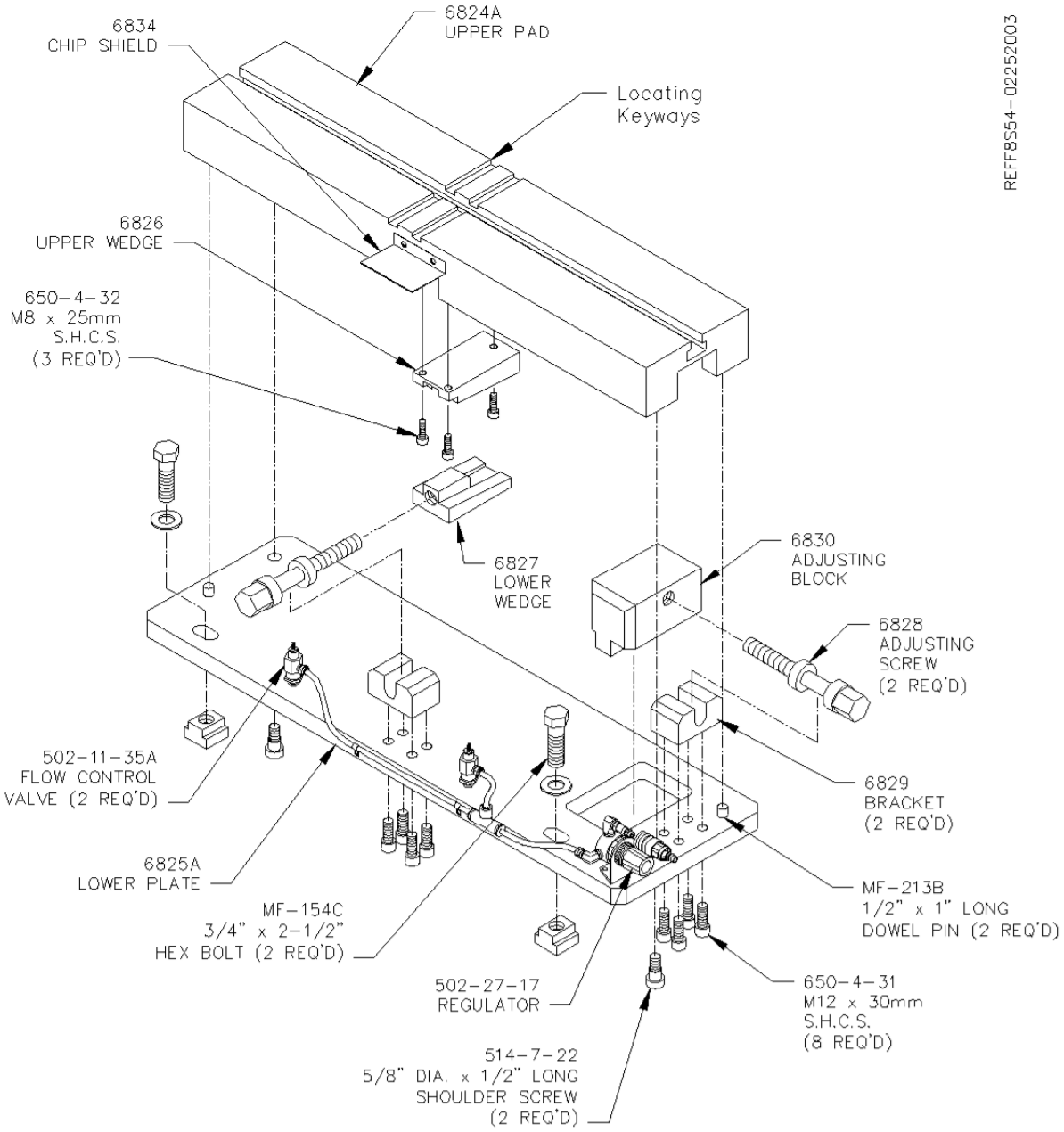
⚠ WARNING Handle these large blocks with Extreme care and guidance. A block hoist is required when handling these blocks.

Use diagrams on the following pages when referring to part numbers listed below. This Line Bore fixture consists of a stationary parallel and an adjustable parallel used in conjunction with a cradle that fits the block to be machined.

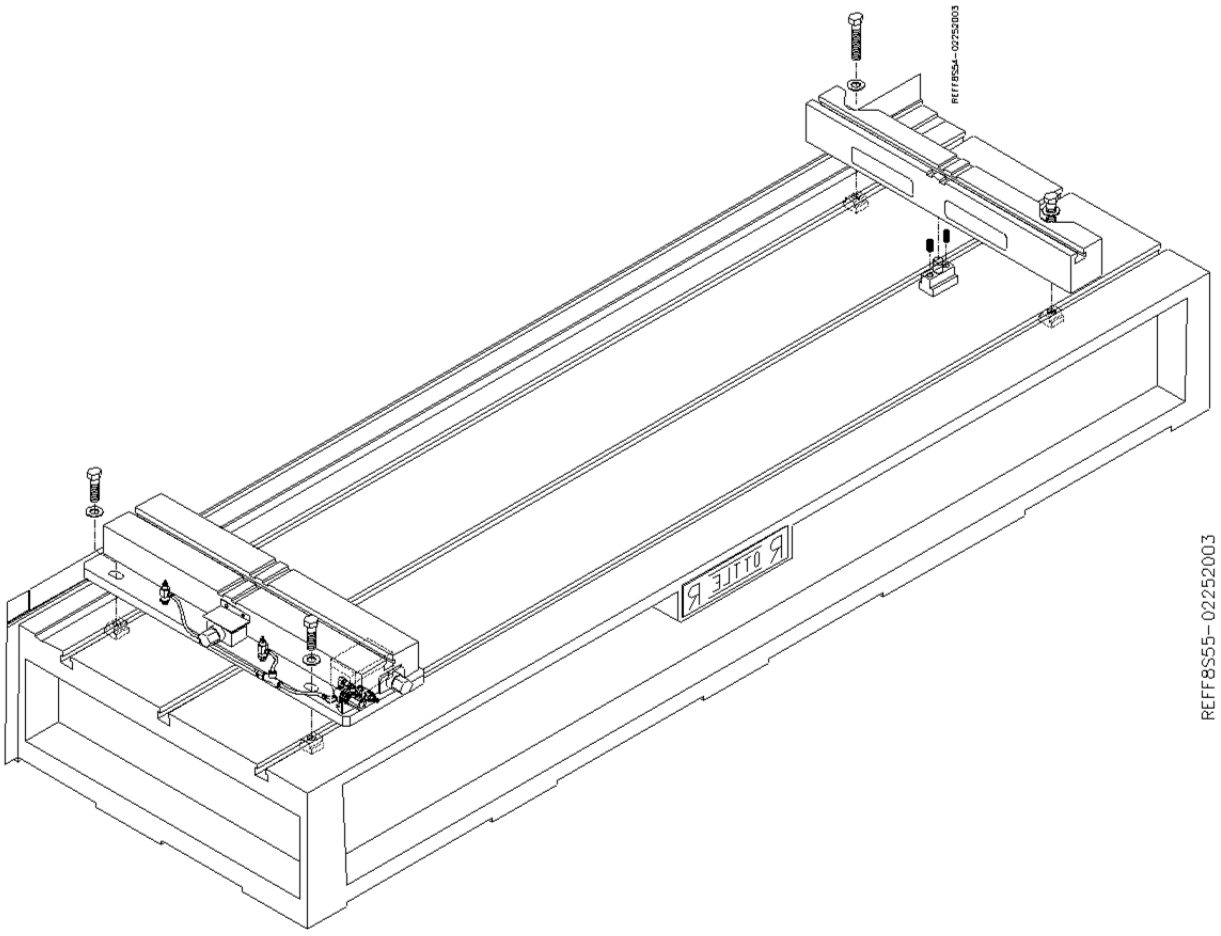
Install the 6820 Pivot Key (with Pivot Pin already pressed in) into the center keyway on the right hand side of the F90 bed. Tighten the two MF-72 set screws down. This will hold the Pivot key in place while the parallel pivots on the Pivot Pin (6819).Place the parallel onto the pivot pin, install the mounting bolts and washers but do not tighten down.



Install the adjustable parallel onto the left hand side of the F90 machine bed with the In/Out adjusting block (6830) located in the front keyway. Install the mounting bolts and washers but do not tighten down.



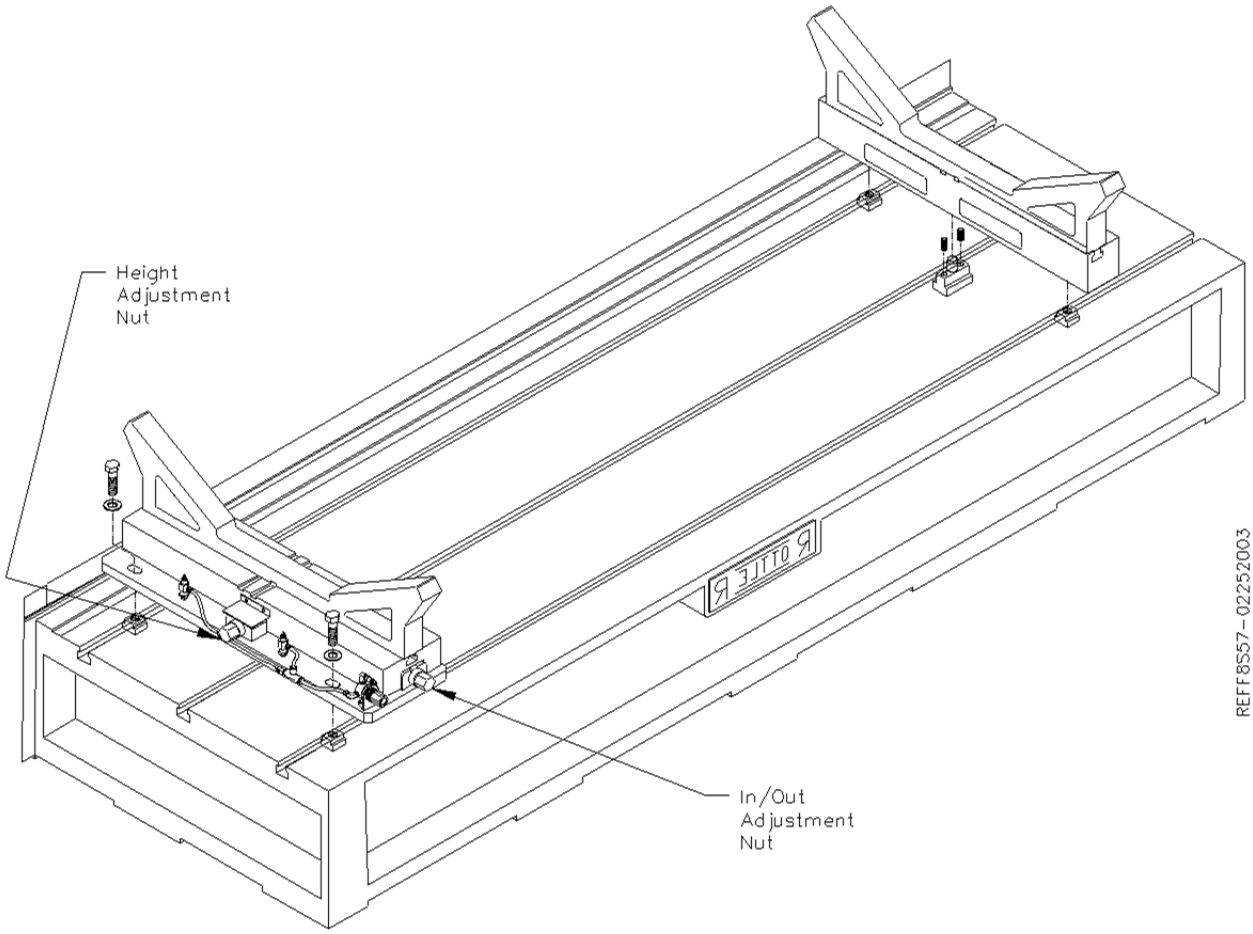
Once both parallels are installed on the machine bed, place a magnetic indicator on the spindle towards the main bed. Indicate the adjustable parallel into the stationary parallel to within .002" on the In/Out and height. This lines the fixture up close so the block can be loaded and then use minor adjustments on the fixture to line the block up.



Select the set of V cradles for the block you are going to be machining. There are various types of cradles that can be used on this fixture. There are risers available also that can be mounted to the cradles to accommodate certain blocks. For cradle and riser selection refer to the Options section of this manual. The CAT 3500 series cradle is shown in this example.

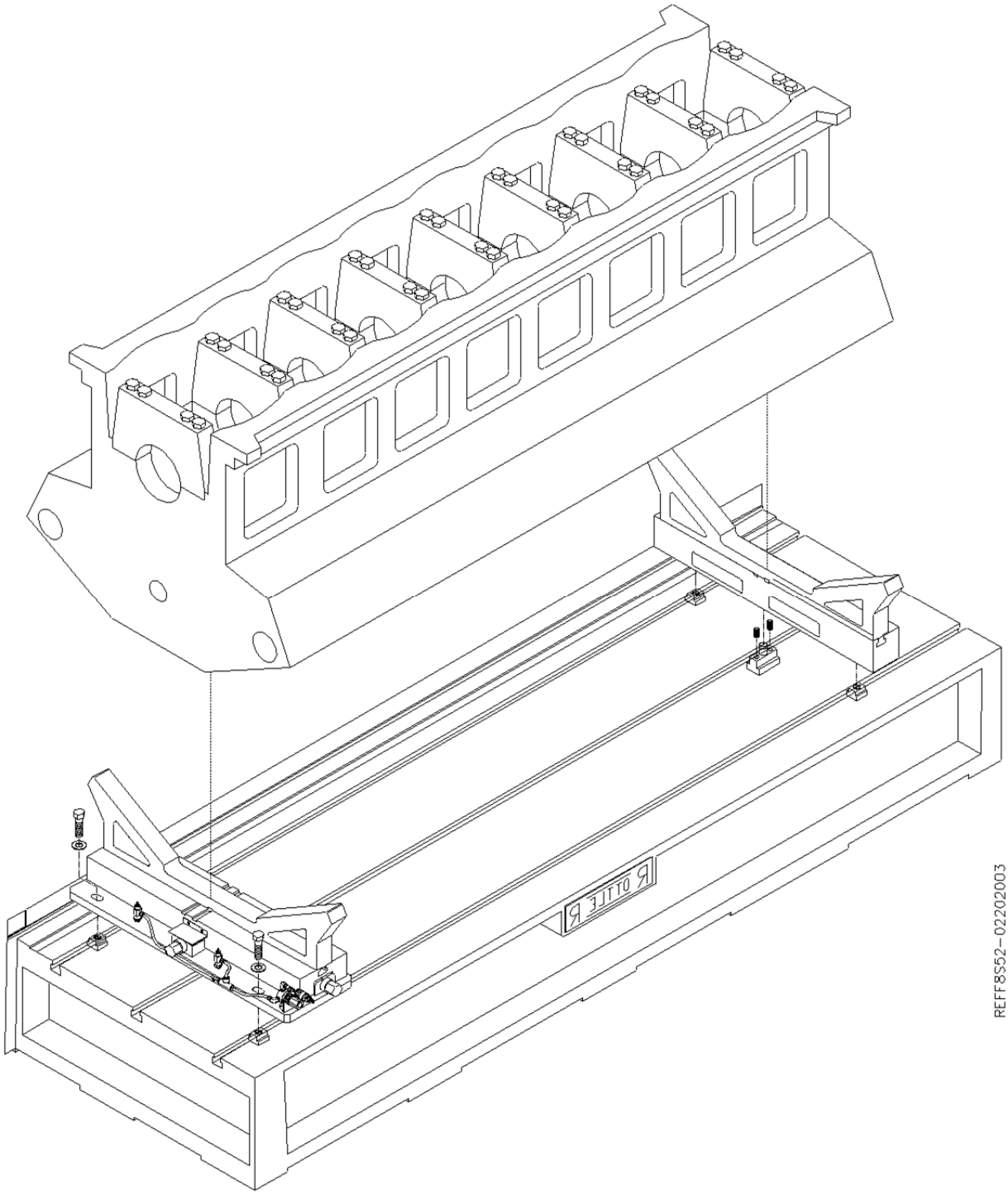
Place the cradles on the parallel. Line up the horizontal key on the cradles with the key slot on the parallels. Generally, the rearward key slot is used, but on large blocks such as the CAT 3500, it is necessary to use the front key slot to allow clearance between the machine column, and engine block. Install mounting bolts and lock the cradles down. Due to the extreme weight of these blocks, clamping is usually not required. Threaded rods and clamp bars bridged across the cylinder bore, and threaded into the cradles is a way to secure the block if desired.

For in-line blocks, cradles are not used. In this case, round locators are bolted directly to the parallels. Lower the block with the end cylinders over the locators and push the block towards the front or rear. This will position the block in a straight line with the machine travel. Secure with threaded rods and clamp bars bridged across the cylinder bore, and threaded into the locators.



Lower the block slowly down into the cradles. Using a heavy soft mallet, tap the sides of the cradles to allow the block to settle into position. The block is now ready for alignment.

Up and down adjustment is accomplished by turning the screw on the side of the adjustable parallel. The in/out direction is adjusted by turning screw at the front of the adjustable parallel. Apply air pressure to the fixture while adjusting the in/out direction. Once the block is aligned, tighten down the fixture bolts and recheck alignment. Readjust as necessary.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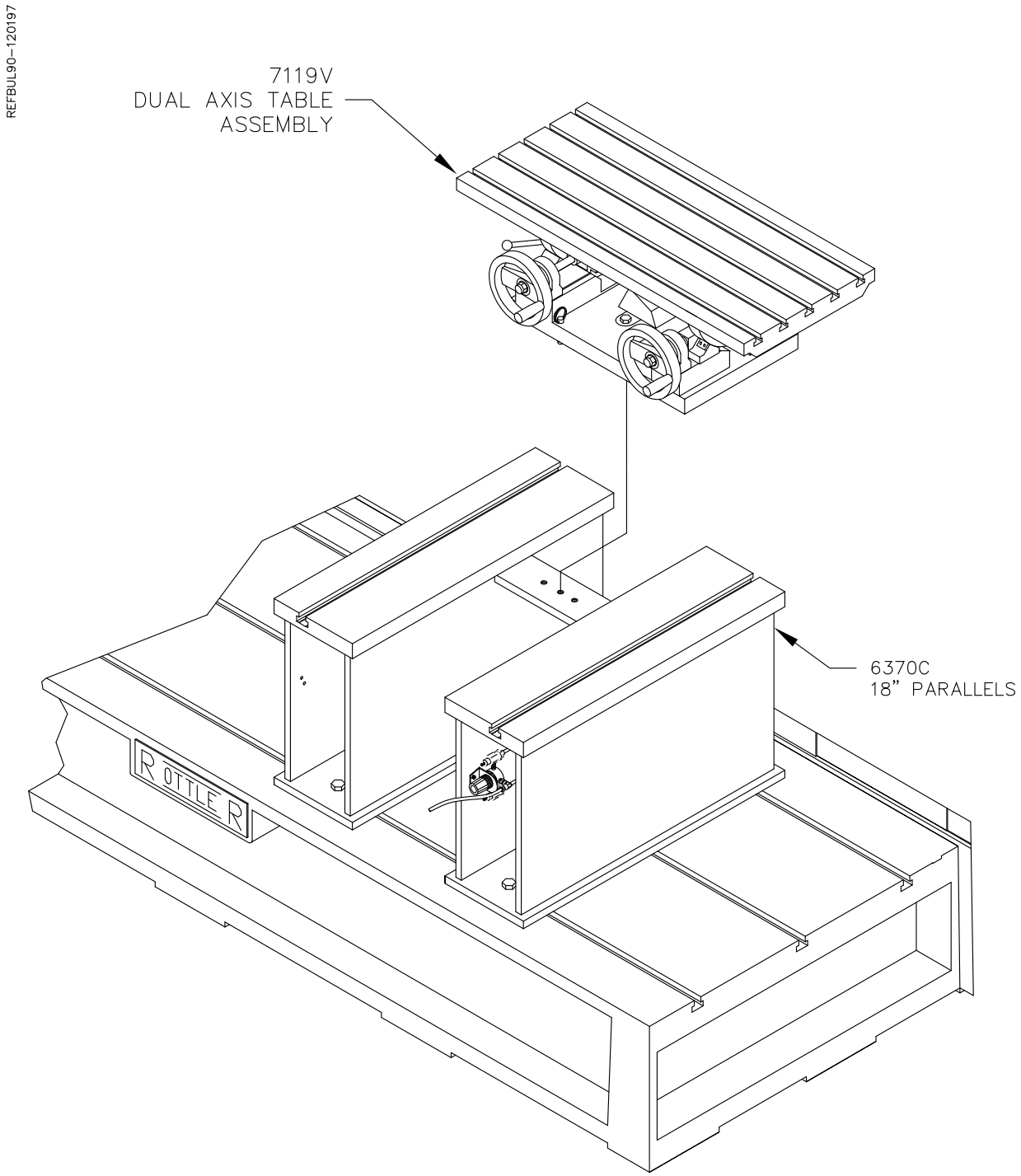
7119V Dual Axis Table Assembly:



Instructions for Small In-Line Blocks:

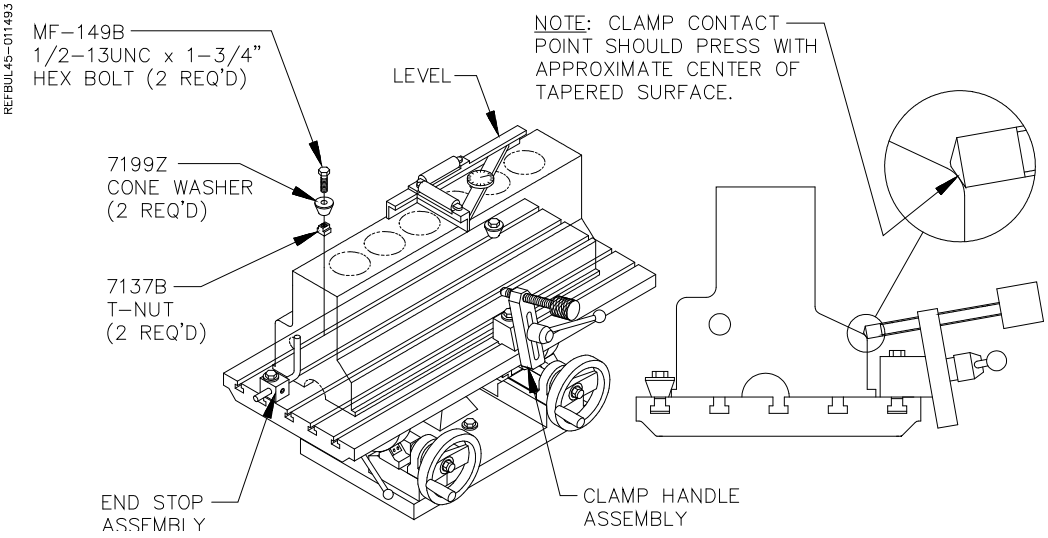
The Dual Axis Table has the capability of holding small (less than 13 ½" from pan rail to head surface) in-line cylinder blocks for resurfacing. This will require the use of parts from the 7119P Universal Head Fixturing package.

Mounting Block to Table:

There are two (2) methods for mounting blocks to the Table. Blocks with the main caps removed or with the raised main bearings can be mounted directly to the table surface. Block with the main bearing caps installed which are lower than the pan rail surface must be mounted using support blocks from the Universal Fixturing package.

Blocks with Main Caps Removed or Raised Main Bearings:

Remove any burrs from pan rails of block.
Locate cone washers on table to approximately center block in path of cutter-head and 'hook' the edge of the pan rail in the rear. Clamp the block using clamp handle assembly. We suggest you install the stop rod assembly on the left hand end of the block. This is an added safety precaution.



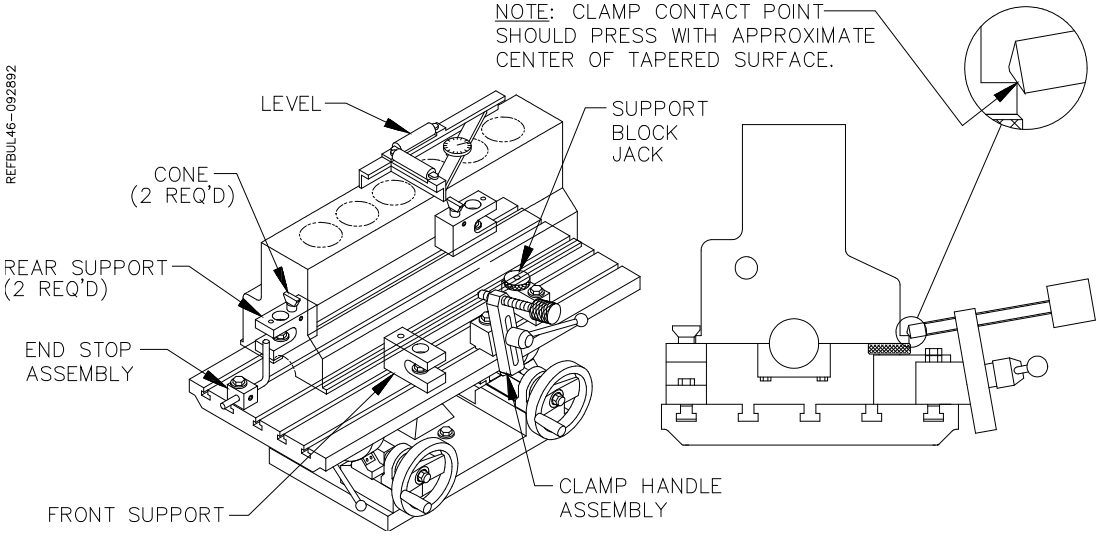
Check that all bolts and holdowns are tight. Loosen table clamp and level head surface of block in both directions. Lock table clamp and recheck block for level.

Blocks with Main Caps Installed:

Remove any burrs from pan rails of block.

Position rear supports and front supports to hold block approximately centered in path of cutter-head. Generally, place the front supports closer together than the rear supports.

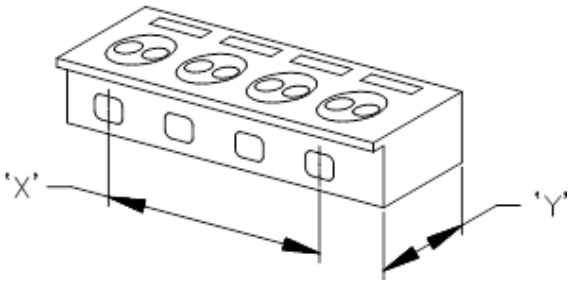
Place the block on the supports. Reposition the supports if necessary to clear main caps. Etc. Elevate the cones to hook the pan rail in the rear. Tighten set screws to lock cones in place. Tighten the hex bolts on the supports. Adjust the support block jack to eliminate any rocking. Lightly apply the clamp handle assembly.



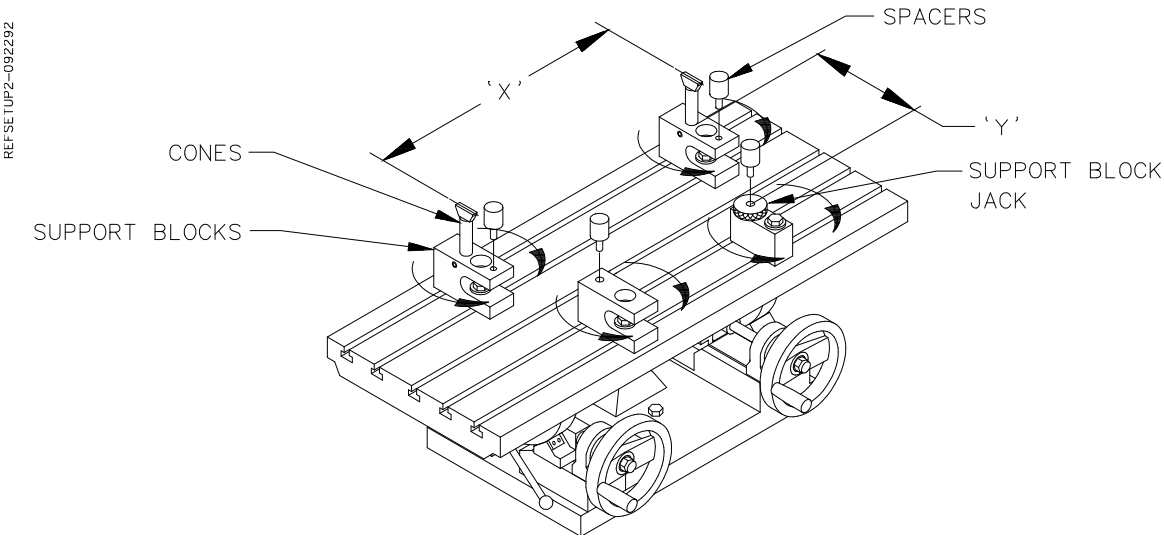
Loosen table clamp and level head surface of block in both directions. Lock table clamp. With the level still on the block tighten clamp handle assembly with appropriate clamp nose on the lower portion of a port or indent near the middle of the block. Tighten the clamp 1/8 to1/4 turn after contacting the block. Do not over-tighten. Watch the level as you tighten to check for movement or warping. If the block moves or warps, repositioning the front supports inward will generally solve the problem. Check to see that the block cannot be moved in the fixture. We suggest that you install the stop rod assembly on the left hand end of the block. This is an added safety precaution.

Typical Head Set Up Procedure:

Find the desired ports or bosses, in the head, to position cones (long or short) on rear support blocks. Measure the distance between the centerlines of these ports (bosses) within 1/16” (1mm – 5mm). Measure the distance from rear support points to front support points on the head.



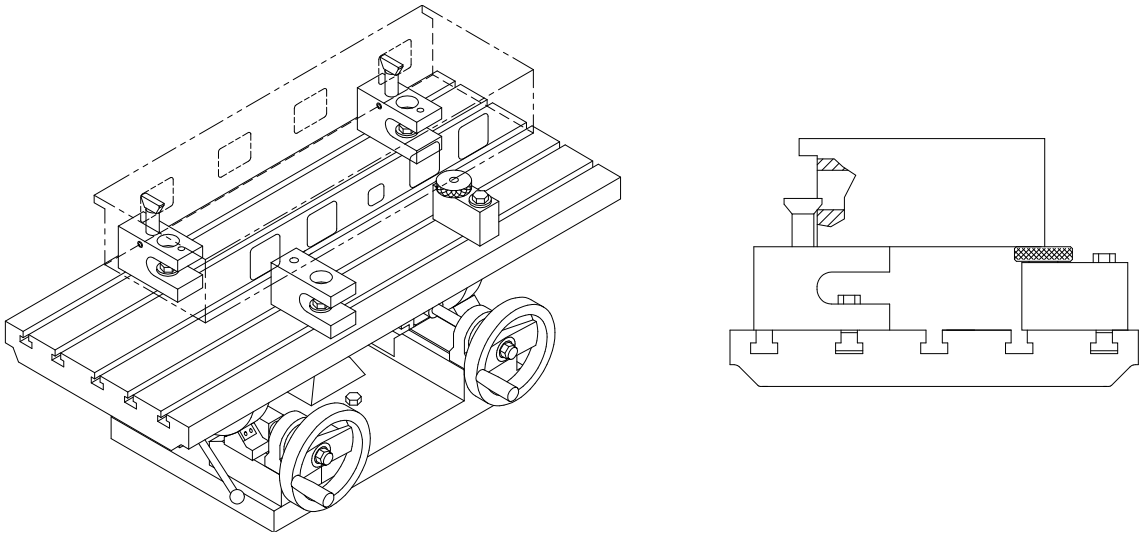
Position rear support blocks and front support blocks to hold the head approximately centered on the table top and spaced apart per dimensions measured in step ‘1’ above. Generally, place the front blocks closer together than the rear blocks. If necessary, use either 2 or 4 spacers to raise the head for clearing studs or to angle the head so the cutterhead clears the head clamp handle assembly.



Place the head on the support blocks. Elevate the cones to ‘hook’ the two ports (bosses) on the head and tighten their set-screws. Adjust the position of the front support blocks if necessary. Tighten the hex bolts on the support blocks. Push the head back firmly into the cones. Adjust the support block jack to eliminate any rocking of the head. Do not tighten the head clamp handle assembly yet.

Unlock the table. Using the two hand-wheels, level the head surface to be cut. Lock the table in this position.

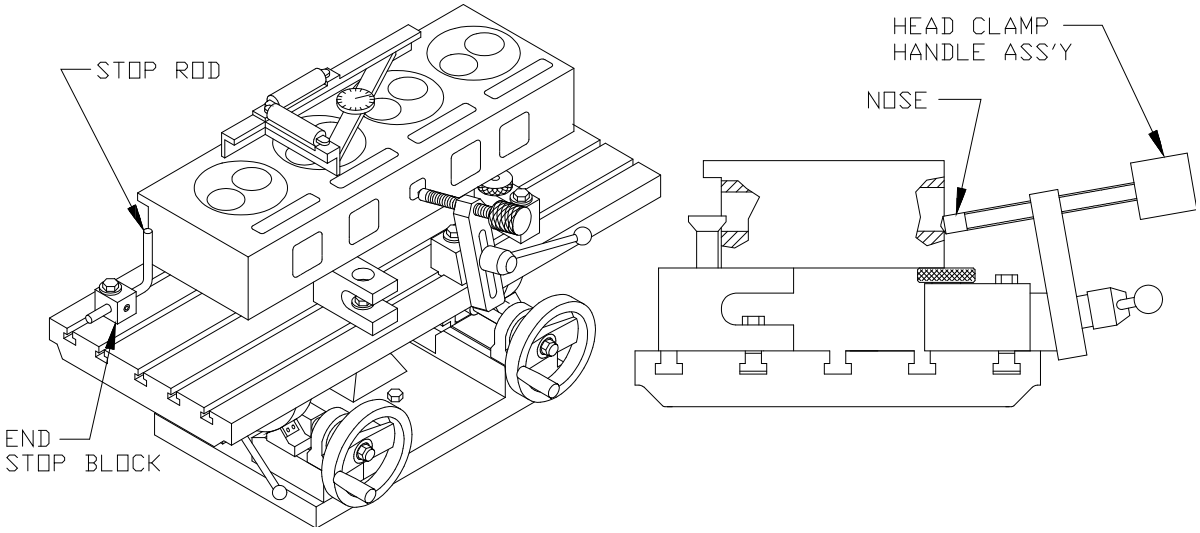
REFSETUP3-092292



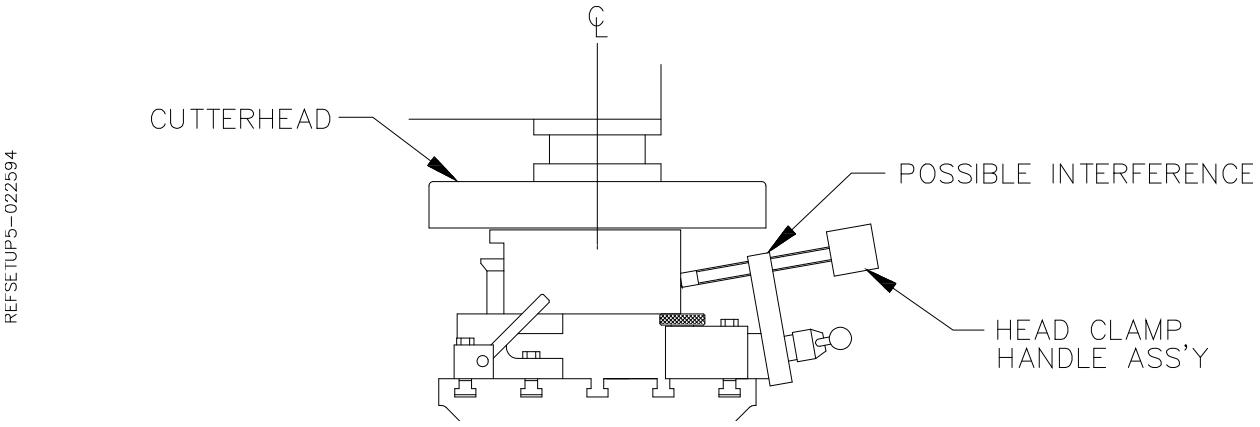
The head clamp handle assembly has a replaceable nose that pushes on the head. With the level still on the head surface, tighten the head clamp handle assembly on the lower edge of a port or indent near the middle of the head. Tighten the clamp 1/8 to 1/4 turn after contacting the head. Do not over tighten. Watch the level as you tighten to check for movement or warping. Some heads are very sensitive to support block placement, and the front support blocks may have to be moved slightly inward to prevent this warping. Check to see that the head cannot be moved in the fixture.

Slide the end stop block up against the left end of the head towards the rear. If possible, rotate the stop rod to contact a machined area on the end of the head. This will aid in loading a run of similar heads.

REFSETUP4-123192



Visually check for clearance between the cutterhead and head fixture tooling pieces, especially the head clamp handle, assembly. The head should be approximately centered in the path of the cutterhead.



12” Multi Tooth Milling Head - 6865

This milling head holds 14 insert cartridges. Each insert has 10 cutting edges, 5 on each side. The inserts need to be adjusted to be at equal height of each other to within .0004” (.01mm). To set the height of the inserts, install the milling head into the machine spindle. Install the inserts. Back off the small set screw above each tool cartridge. Loosen each tool cartridge, push up, and re-tighten.
Using an indicator with a large diameter convex tip, find the insert that is at the lowest setting. Now, adjust the remaining inserts to equal height by turning the small set screw above each tool cartridge.
There are a couple spindle motor parameters that need to be changed to gain more torque that this milling head requires.
Go to “Set up”, then “General Options”.
Find the line labeled “Spindle”.
Find the column labeled “Position Gain”, and change it to 10. (Record the original setting before changing)
Find the column labeled “Velocity Gain”, and change it to 600. (Record the original setting before changing)
100 to 120 RPM and a feed rate of .020”(.05mm) to .040”(1mm) is recommended. Maximum depth of cut .020”(.05mm)
When finish with the machining operation, re-enter the original spindle motor settings as recorded earlier.

18” Multi Tooth Milling Head 6864

This milling head holds 9 insert cartridges. Each insert has 10 cutting edges, 5 on each side. The inserts need to be adjusted to be at equal height of each other to within .0004” (.01mm). To set the height of the inserts, install the milling head into the machine spindle. Install the inserts. Back off the small set screw above each tool cartridge. Loosen each tool cartridge, push up, and re-tighten.
Using an indicator with a large diameter convex tip, find the insert that is at the lowest setting. Now, adjust the remaining inserts to equal height by turning the small set screw above each tool cartridge. Install the dampener band around the perimeter of the milling head.
There are a couple spindle motor parameters that need to be changed to gain more torque that this milling head requires.
Go to “Set up”, then “General Options”.
Find the line labeled “Spindle”.
Find the column labeled “Position Gain”, and change it to 10. (Record the original setting before changing)
Find the column labeled “Velocity Gain”, and change it to 600. (Record the original setting before changing)
Find the column labeled “Accel Rate”, and change it to 2. (Record the original setting before changing)
70 to 90 RPM and a feed rate of .020”(.05mm) to .040”(1mm) is recommended. Limit the depth of cut to .001” (.025mm) to .002” (.05mm)
When finish with the machining operation, re-enter the original spindle motor settings as recorded earlier.

General Machine Information:

Before starting to build or use any of the Rottler operating programs it is important to understand how the machine operates internally.

The Rottler F109 model uses Computerized Numeric Control (CNC). The CNC is always operating when the machine is turned on. However, you will not see the CNC controls unless you switch over to the CNC operating screen.

Homing:

The F109 ***MUST*** be homed anytime it is turned off. If the machine has not been homed the reference positions for all programs will be off.

The purpose of Homing the machine is to set reference points in each axis for the machine to operate from. If the machine is not homed the reference points may be off position. The reference point is set in exactly the same position each time the machine is homed. The machine keeps track of these reference positions internally and the operator will not see them.

Building Programs:

NOTE: The instructions in this section are done WITHOUT using tool or Fixture offset values.

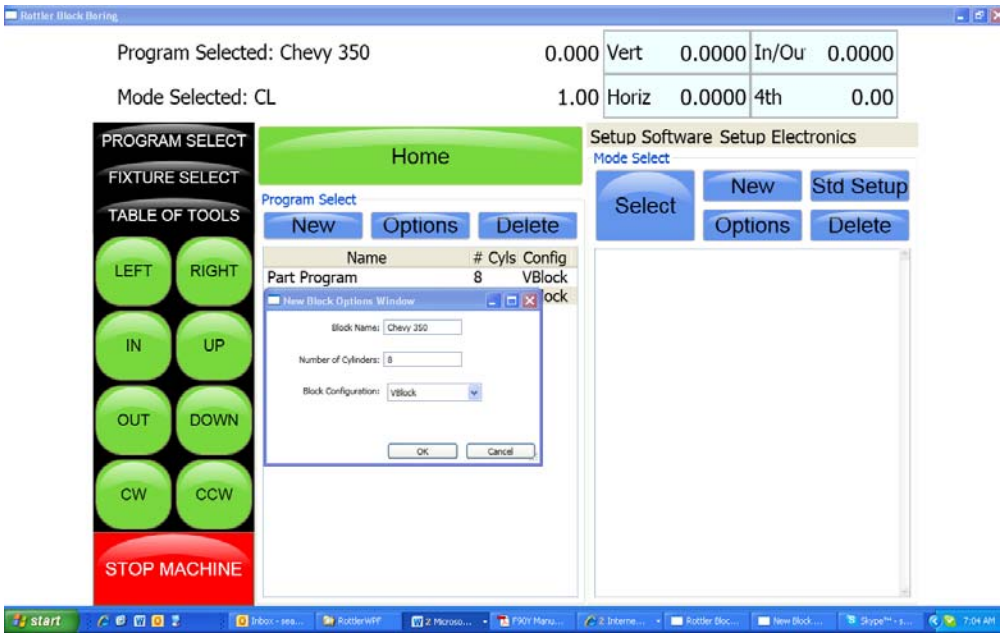
Create a Block Program:

Block Programs are listed on the left hand side of the screen. Mode programs that are for a specific Block Model are listed on the right side of the screen.

New:

From the Program Select screen select New from the Left hand menu. This will open a window where will enter the Block name and configuration i.e. V6, V8 or Inline and number of cylinders.

NOTE: There is an existing program on start-up of new software called Part Program. This can be deleted after the first Block Program is entered.



Options:

If you need to change the block configuration or name of a block that has already been created, use the Options button. This will bring up the same window as when the block was created.

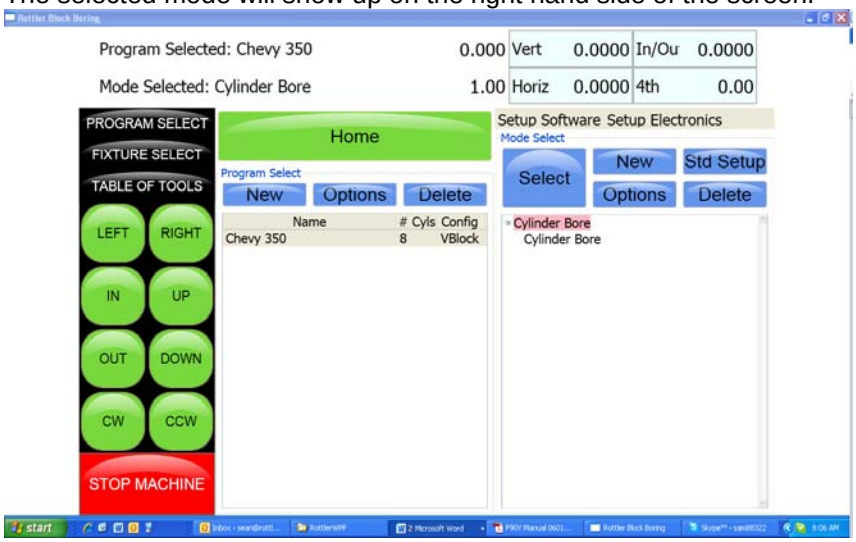
Creating Operating Modes for a Block Model:

Select the Block model on the left hand side of the screen.

New:

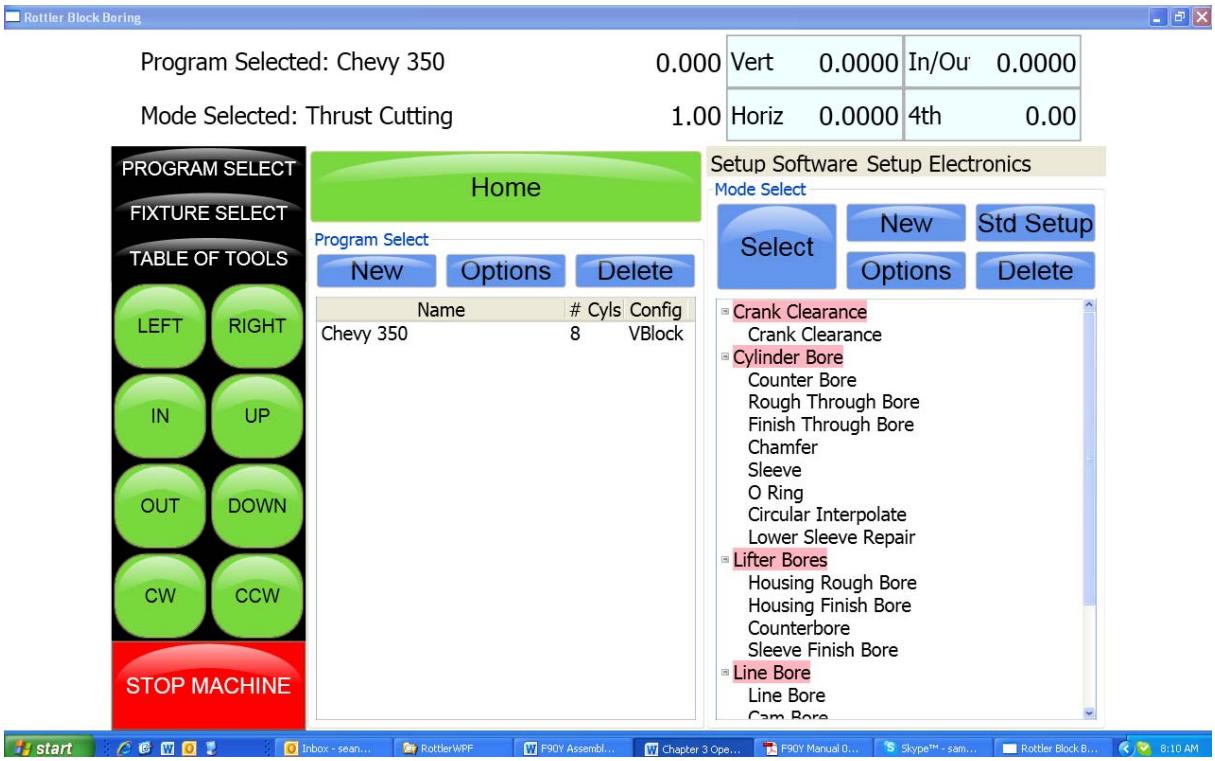
Selecting New will bring up a window that lists all the Modes that can be performed on the selected block model. Highlight the Mode you want to create and press OK.

The selected mode will show up on the right hand side of the screen.



Std (Standard) Setup:

Pressing Std Setup will cause all of the available Modes to be inserted into the Modes area on the right hand side.



Select:

Pressing Select with a Mode highlighted will open the operations screens for using the program.

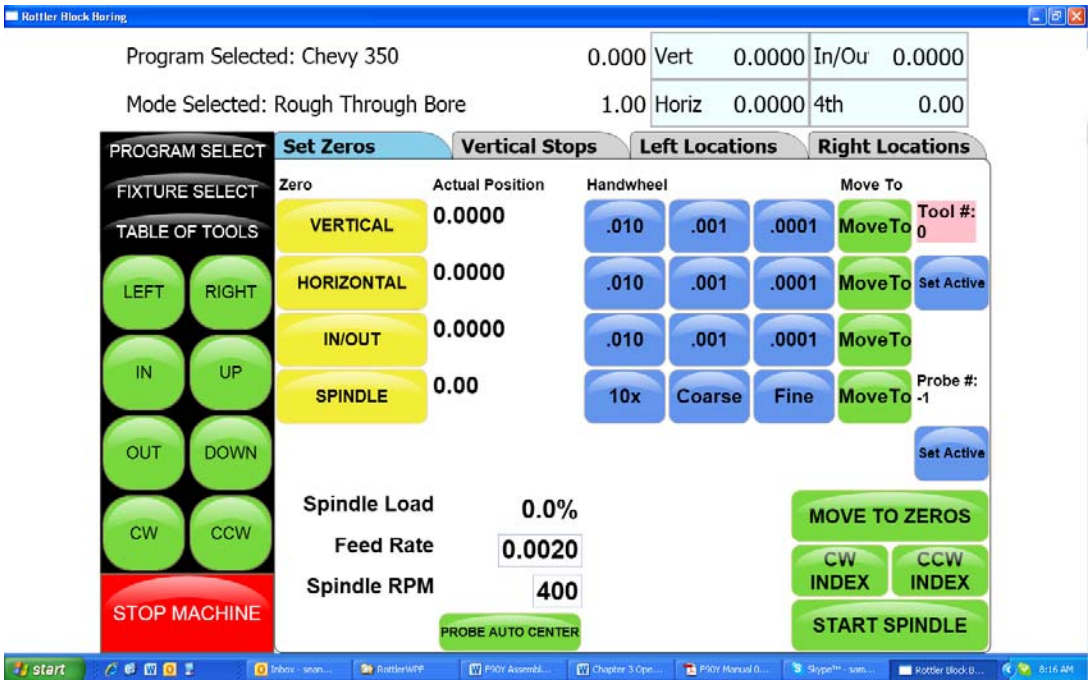
Options:

Pressing the Options button with a Mode highlighted will open a window where you can change the mode name. There is also a check box to allow positive number to be entered into the program where they are normally forced to a negative value.

Cylinder Bore Mode 3 Axis:

Select Cylinder Bore and then Rough Through Bore on the screen. This will bring up the boring program with the Set Zeros tab shown.

NOTE: Once a certain feature is discussed in a particular mode it will not be discussed again in the following modes.

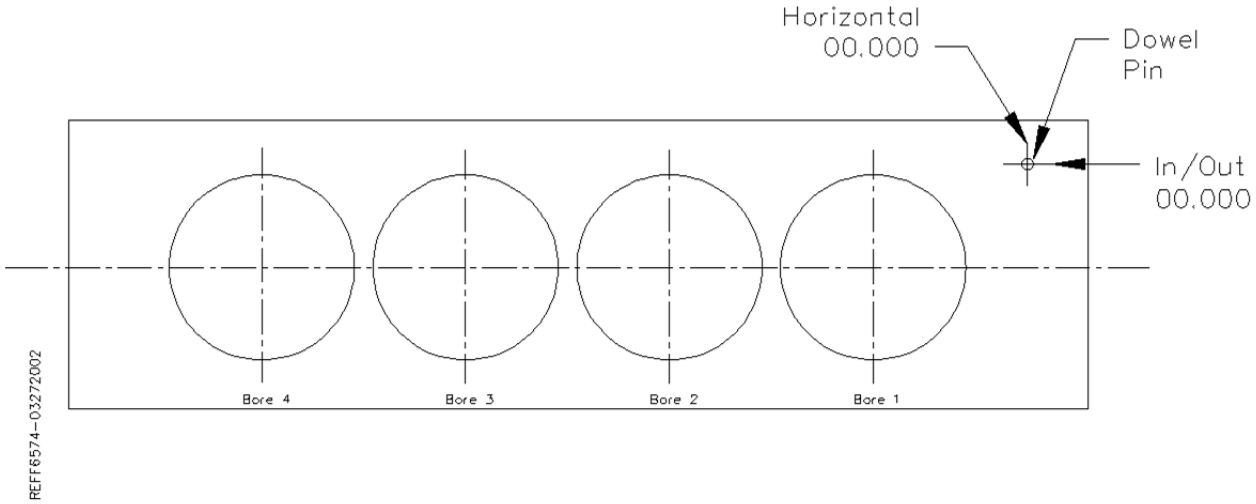


Setting Zeros:

The purpose of setting zero points is to give the operator a specific point to build programs from. The machine also uses these zero points to run the program from. The zero points can be set at

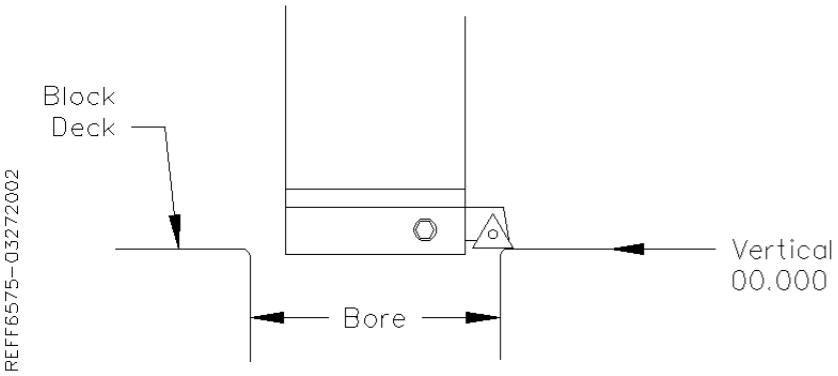
any point in the machines' travel. Each axis (except the Spindle rotation) will need to have a zero point set for the machine to operate from. Every program will save it's individual zero positions. The next time that program is selected the zero position will be the exact same distance from the Home position for each axis.

Horizontal and In/Out Zero:
For this example, the Dowel Pin will be our zero point for the Horizontal and In/Out axis. Using an indicator or electronic probe center the spindle on the Dowel Pin then press the Horizontal and In/Out Zero buttons. The display next to these buttons will go to zeroes. The Horizontal and In/Out zero positions have now been set.



Vertical Zero:
There are three different ways to use the boring software, Blueprinting, Indicating and Probing. It is not unusual for all three modes to be used on the same size block. The vertical stops for these different operating programs will vary. Be sure the vertical stops are set correctly for the mode you are using.

For this example the deck will be our zero for the Vertical axis. Insert a tool holder into the cutterhead you will be using to bore the block. Center the cutterhead over a cylinder. Using the Vertical Handwheel, bring the cutterhead down until the tool just touches the deck and press the Vertical Zero button. The display next to this button will go to zero. The Vertical zero has now been set.



The zeros points for all axis have now been set. All the numbers entered from this point on will reference these zero positions. You are finished with the Set Zeros screen, select the next Tab to the Right, Vertical Stops.

Blueprinting:

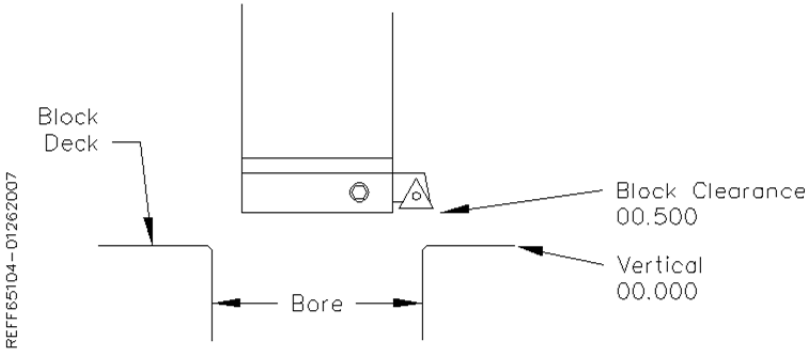
Even if you are not going to be boring a block to the blue print specifications it is recommended to have the Blueprint values entered. It will speed up the process of indicating and probing a block by giving the operator a close estimate of bore location.

Programming Vertical Stops:

To build a program you must set the Vertical Stops for the program.

Block Clearance:

This is the distance above the zero position or block deck allowing the cutterhead to move to the next bore unobstructed. If you are Blueprinting a block the number will be just enough to allow the cutterhead to clear the block deck.

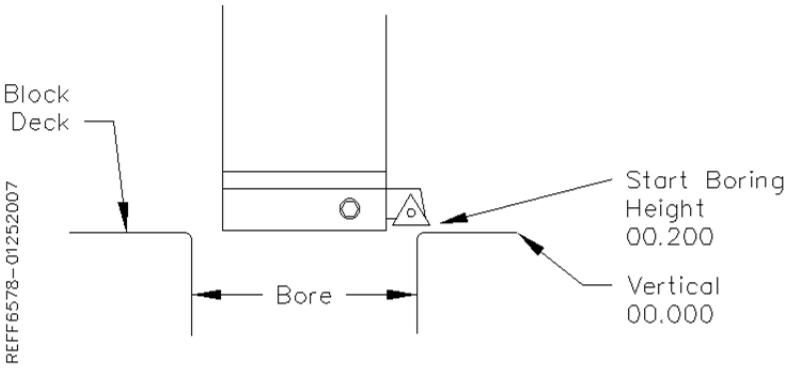


Centering Height:

When Blueprinting this stop is not needed. It should be the same as the block Clearance Height.

Start Boring Height:

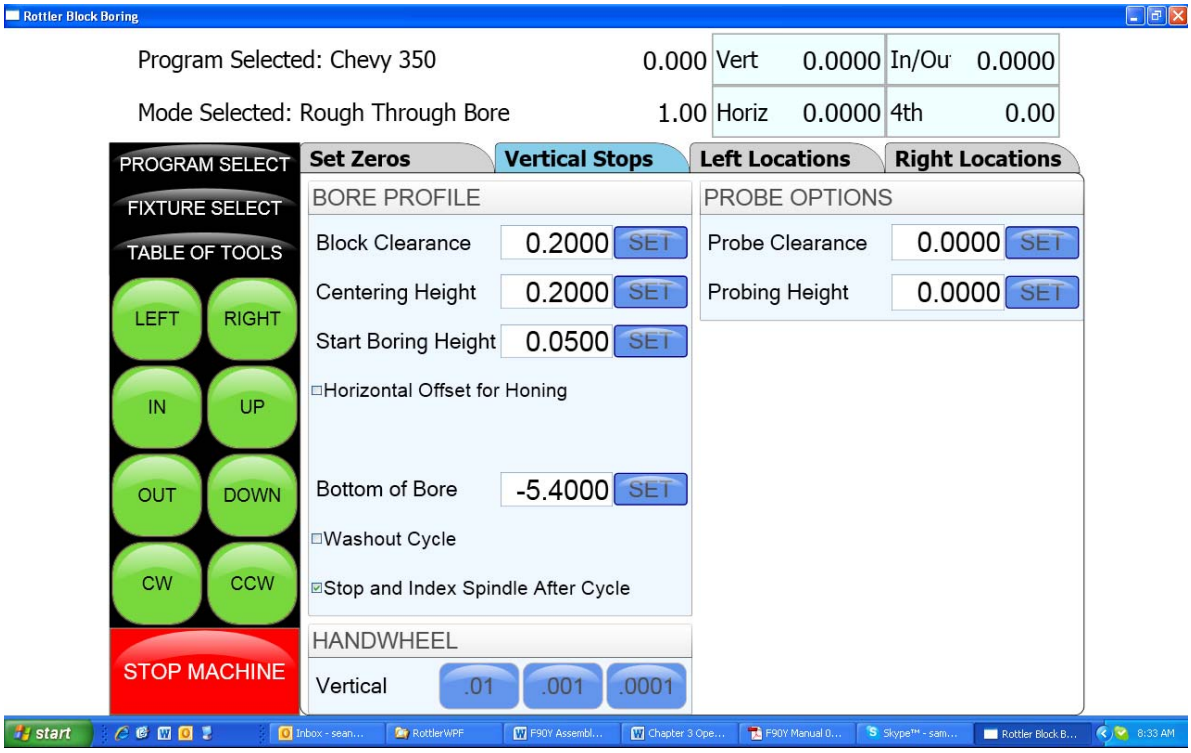
This is the distance above zero or the block deck where you want the cutterhead to start rotating and the downward feed to start. Generally this is just a short distance above the block deck to minimize the amount of time the machine bores through air.



Bottom of the Bore:

This is the distance below zero or the Block deck where you want the machine to stop boring and retract out of the cylinder. When the spindle retracts it will then go to the Block Clearance position.

This is an example of what the above program would look like on the vertical stops.

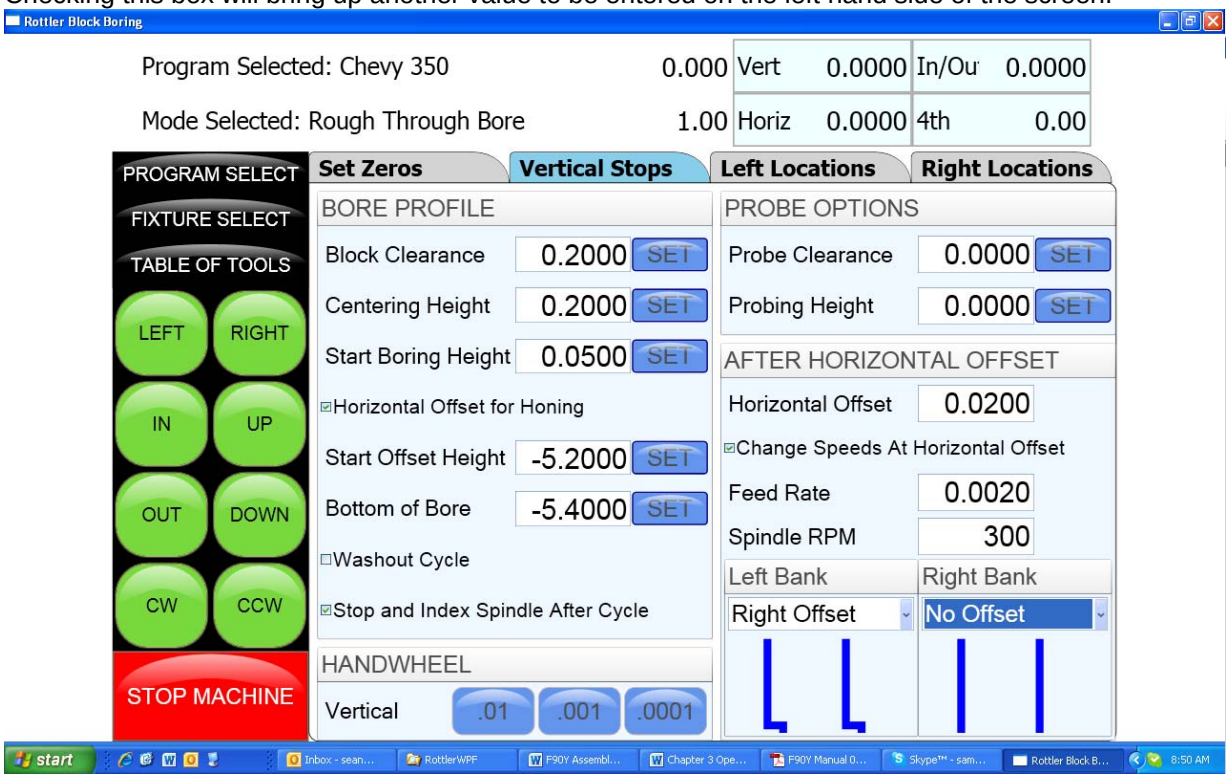


When Blueprinting the Probe is not used. It will be discussed later in this Chapter.

Horizontal Offset for Honing:

This feature is designed to offset the cutter at a certain height in the lower bore to cut out block web intrusions to make room for the honing process.

Checking this box will bring up another value to be entered on the left hand side of the screen.



Start Offset Height:

This is the vertical depth at which the cutter will shift to the side to start cutting.

Horizontal Offset:

This is the distance the cutter will offset from the bore center.

Change Speeds at Horizontal Offset:

Often the clearance cut is much larger that the cut for the rest of the bore. For this you can check this box and enter a different RPM and Feed Rate. If a different speed and feed are not need do not check this box and the same feed and speed will be used that was used to bore the cylinder.

For each bank (of a V Block) you can select the direction the offset should go.

Washout Cycle:

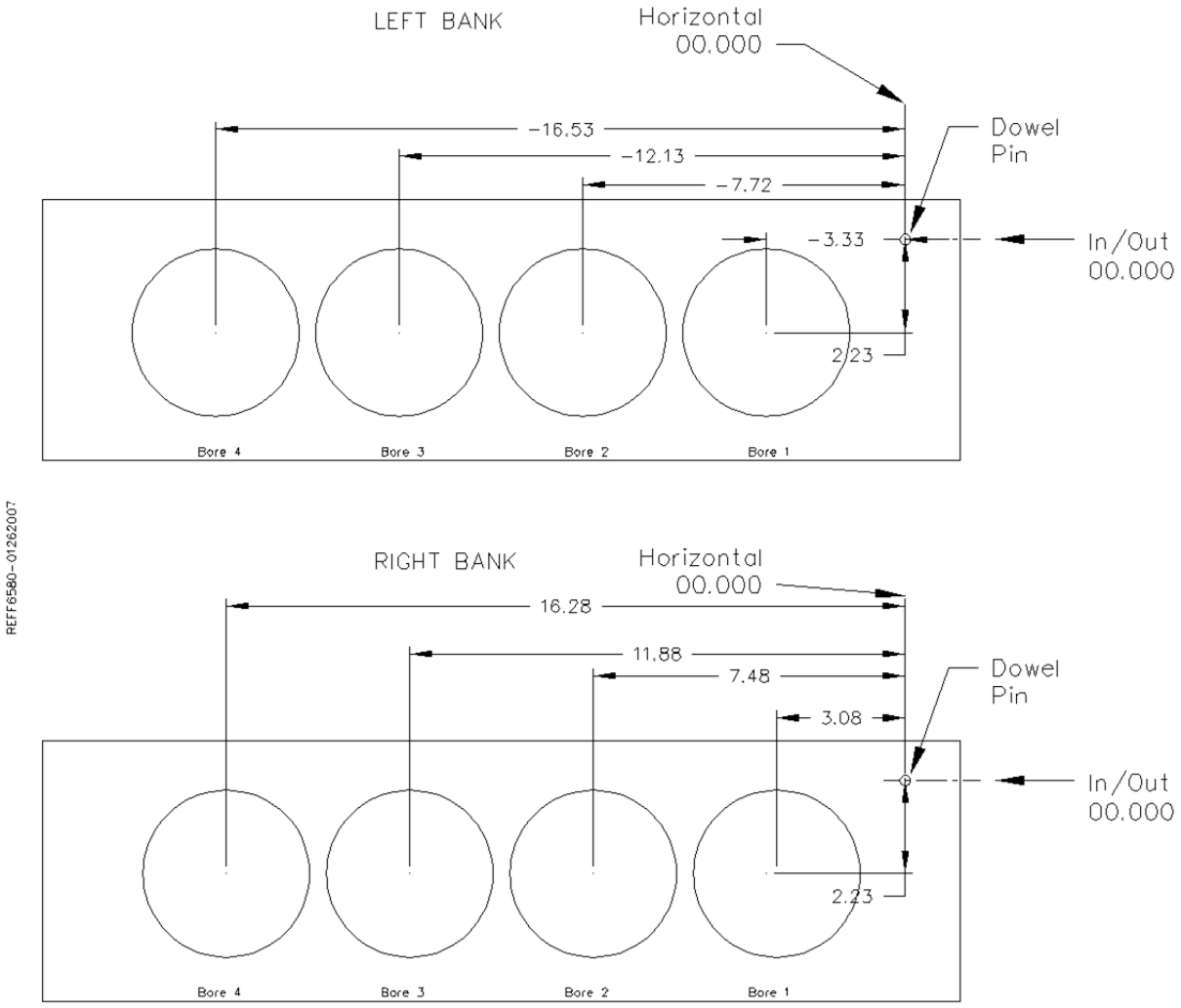
Checking this box will open another window on the right hand side of the screen. Here you can enter the RPM and number of revolutions that will be performed when the cutter reaches the Bottom of Bore position. In Through Boring this is not generally used. This is used when a certain type of finish is required on a counter bore or the bottom of a sleeve cut.

Stop and Index Spindle after Cycle:

Checking this box will cause the spindle to be indexed to the three O'clock position after the cylinder has been bored but before it retracts. It will also offset to the left before the tool is retracted. This is the default setting. You would not want this check in an operation such as Lifter Boring.

Bore Locations:

To build a program you must set the Horizontal and In/Out Stops for the program. All Horizontal and In/Out stop are based from where their zero positions were set. The following illustration shows how the stop positions were derived. These stops would be used when blueprinting a block.



The following is an example of what the screens would look like for the above block.

Left Locations:

Right Locations:

The Horizontal and In/Out stops have now been set.

Boring a Block:

Once the Vertical, Horizontal and In/Out stops have all been entered the Spindle RPM and Feed Rate need to be entered. This is done on the Set Zeros screen. Once this is done you can go to the Left and/or Right Bore location screens and bore the cylinders.

Pressing the Bore Left for Bore Right buttons Will Bore all the cylinders that have Green bore button below them.

Pressing a Bore button once will turn that button Yellow. Any Yellow button will not be bored when the Bore Left or Right button is pressed.

Double clicking any Bore button will turn all the Bore button yellow EXCEPT the one that was double click.

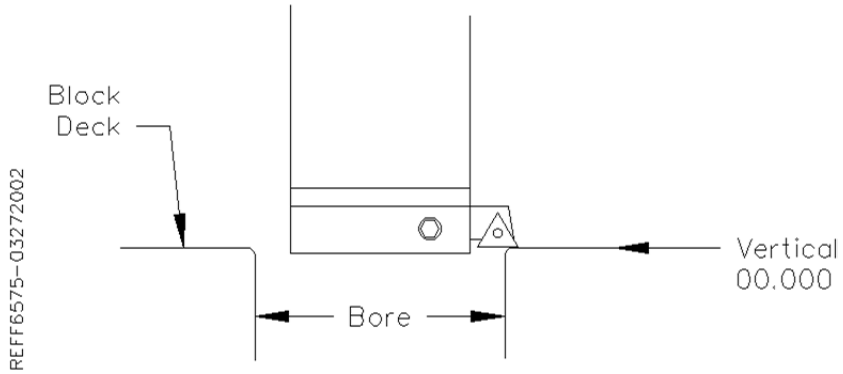
Indicating:

Even if you are not going to be boring a block to the blue print specifications it is recommended to have these values entered. It will speed up the process of indicating and probing a block by giving the operator a close estimate of bore location.

Vertical Zero:

There are three different ways to use the boring software, Blueprinting, Indicating and Probing. It is not unusual for all three modes to be used on the same size block. The vertical stops for these different operating programs will vary. Be sure the vertical stops are set correctly for the mode you are using.

For this example the deck will be our zero for the Vertical axis. Insert a tool holder into the cutterhead you will be using to bore the block. Center the cutterhead over a cylinder. Using the Vertical Handwheel, bring the cutterhead down until the tool just touches the deck and press the Vertical Zero button. The display above this button will go to zero. The Vertical zero has now been set.



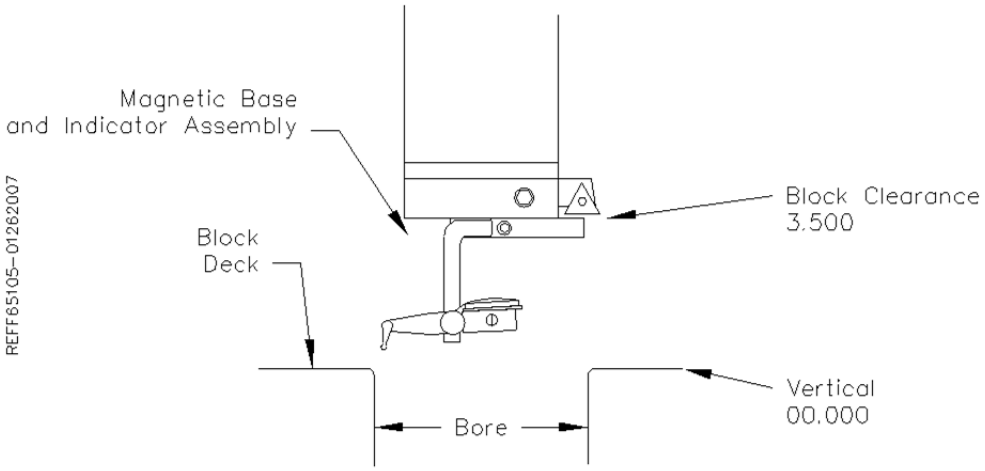
The zeros points for all axis have now been set. All the numbers entered from this point on will reference these zero positions. You are finished with the Set Zeros screen, select the next Tab to the Right.

Programming Vertical Stops:

To build a program you must set the Vertical Stops for the program.

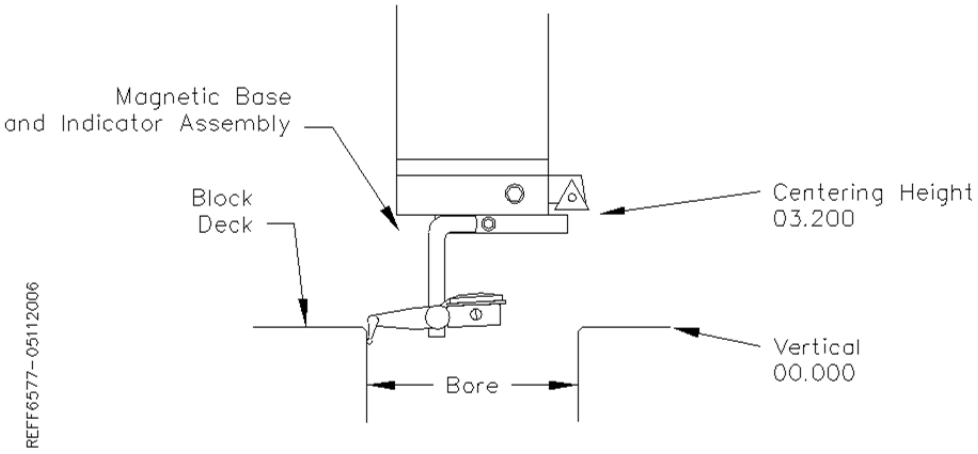
Block Clearance:

This is the distance above the zero position or block deck allowing the cutterhead to move to the next bore unobstructed. When you are indicating the cylinders in you must have this stop set so the indicator will clear the block surface when traveling to the next cylinder.



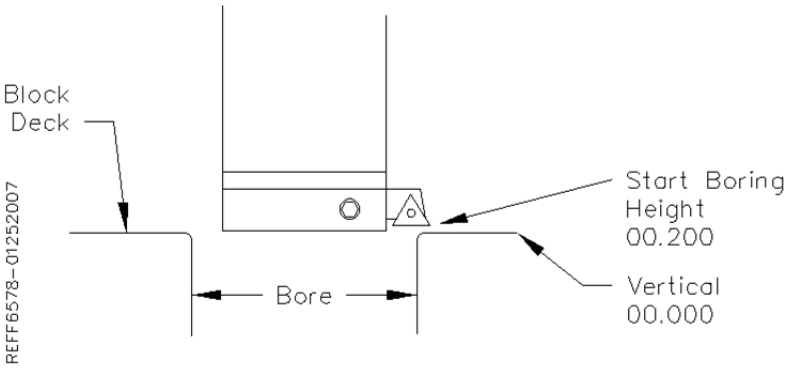
Centering Height:

This is a distance above the vertical zero where you will be manually centering the block. The drawing below is a typical set up for manual centering or indicting a cylinder.



Start Boring Height:

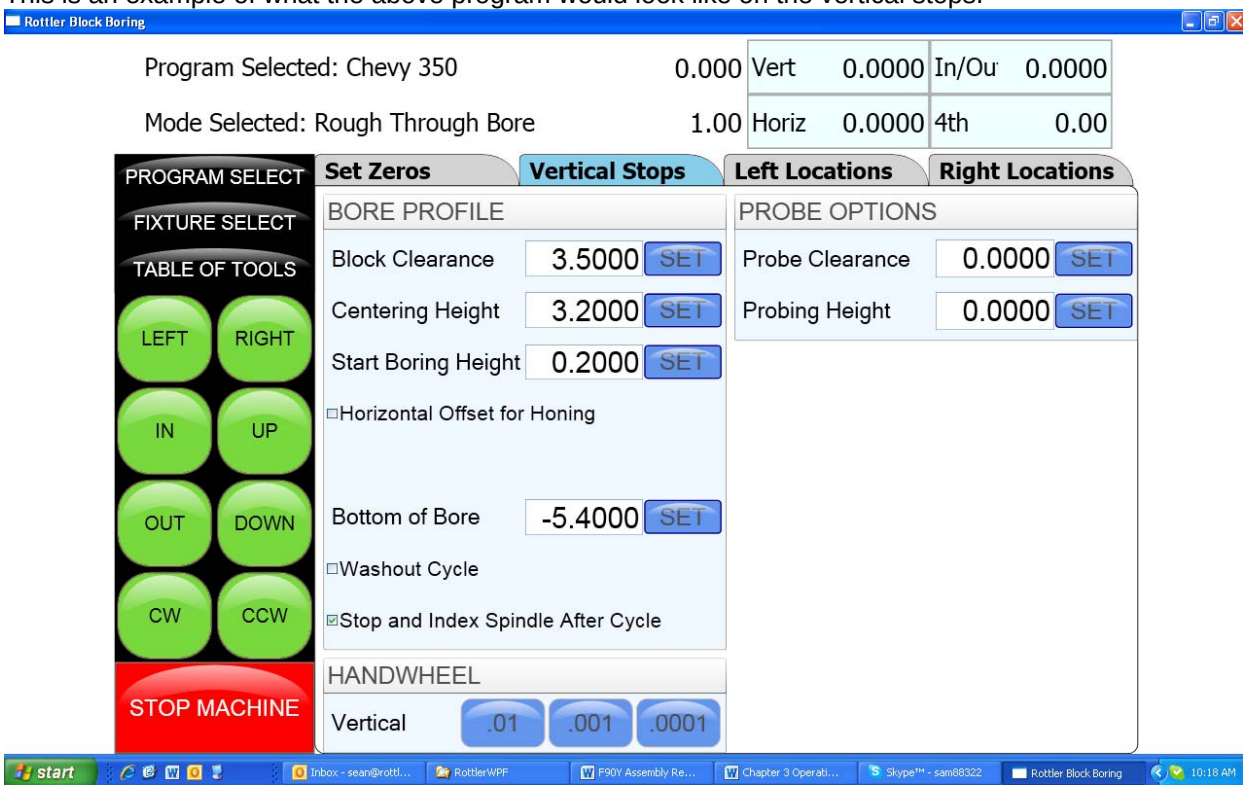
This is the distance above zero or the block deck where you want the cutterhead to start rotating and the downward feed to start. Generally this is just a short distance above the block deck to minimize the amount of time the machine bores through air. This will be a negative number.



Bottom of the Bore:

This is the distance below zero or the Block deck where you want the machine to stop boring and retract out of the cylinder. When the spindle retracts it will then go to the block Clearance position.

This is an example of what the above program would look like on the vertical stops.

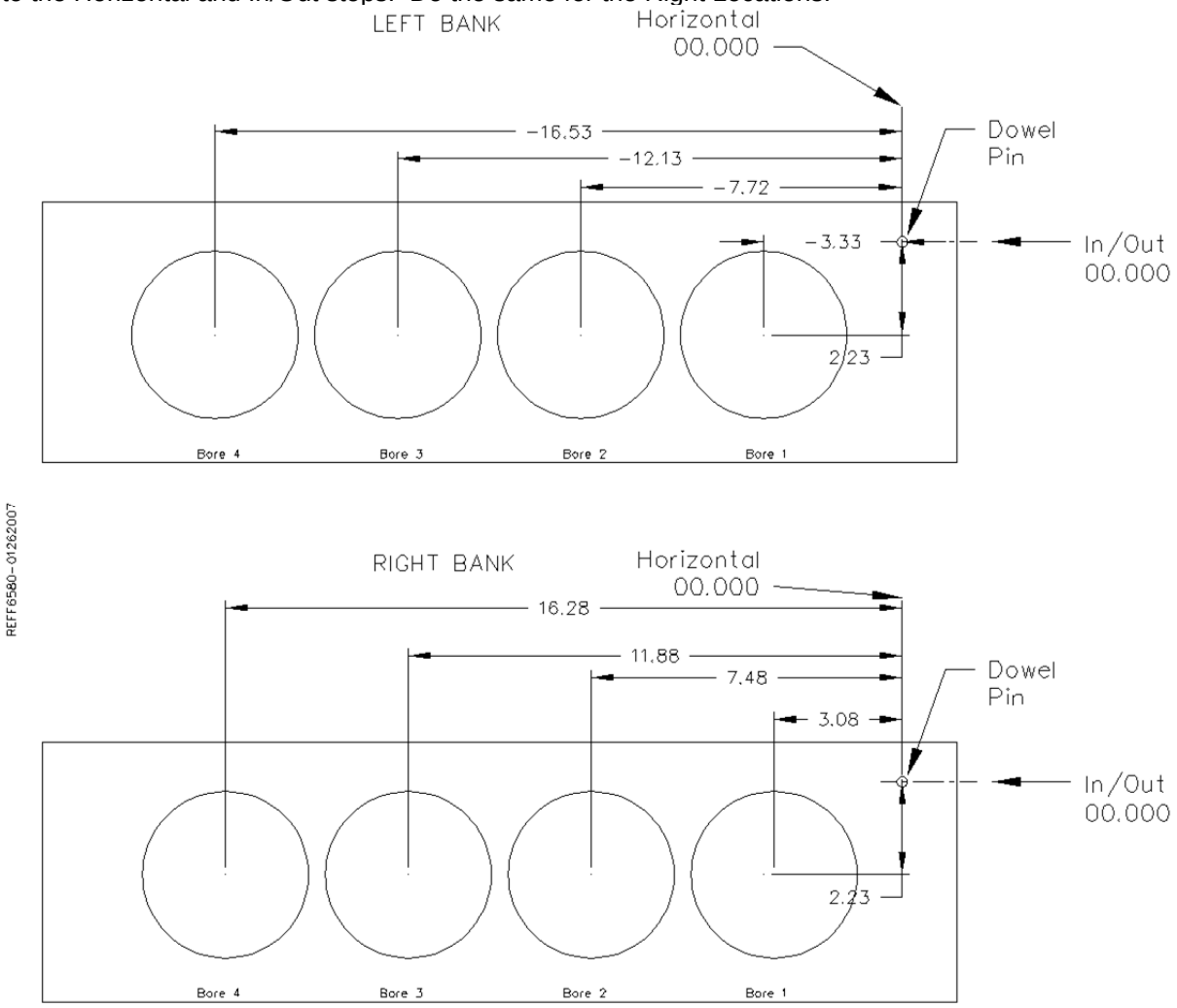


The Vertical stops have now been set. You are finished with the Vertical Stops screen, select Left and/or Right Locations.

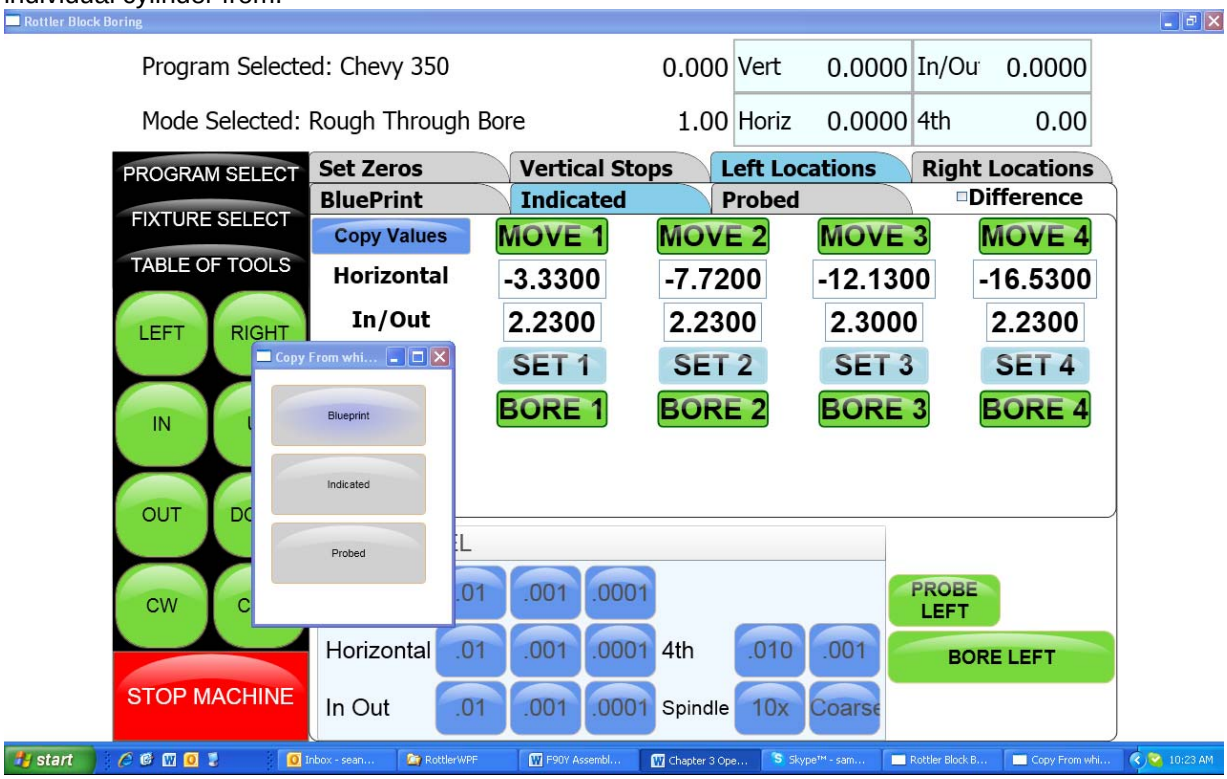
Bore Locations:

To build a program you must set the Horizontal and In/Out Stops for the program. There are eight (8) Horizontal and In/Out stops used in the boring program. All Horizontal and In/Out stop are based from where their zero positions were set.

Select Left Locations and the Blueprint. Program the blueprint values (or close approximation) into the Horizontal and In/Out stops. Do the same for the Right Locations.



Select Left Locations and then Indicated. If you have programmed the blueprint locations into this program then press Copy Values and then Blueprint. This will cause the values from the Blueprint page to be copied into the Indicated page. This give you a starting point to indicate the individual cylinder from.



Press the Move 1 button. The machine will move to the first cylinder and stop at the centering position. Manually indicate the cylinder in using the Horizontal and In/Out handwheel. Once the cylinder is centered press the Set 1 button. This will transfer the current position of the machine into the first set of Data Boxes. Repeat this process for all the cylinders that need to be indicated.

Press the Right Locations tab and repeat the above procedure for the cylinders to be indicated on the right bank.

Boring a Block:

Once the Vertical, Horizontal and In/Out stops have all been entered the Spindle RPM and Feed Rate need to be entered. This is done on the Set Zeros screen. Once this is done you can go to the Left and/or Right Bore location screens and bore the cylinders.

Pressing the Bore Left for Bore Right buttons Will Bore all the cylinders that have Green bore button below them.

Pressing a Bore button once will turn that button Yellow. Any Yellow button will not be bored when the Bore Left or Right button is pressed.

Double clicking any Bore button will turn all the Bore button yellow EXCEPT the one that was double click.

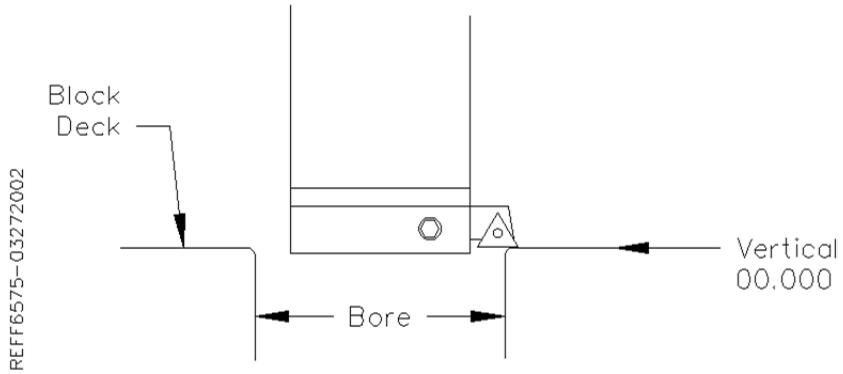
Probing:

Even if you are not going to be boring a block to the blue print specifications it is still recommended to have these values entered. It will speed up the process of indicating and probing a block by giving the operator a close estimate of bore location.

Vertical Zero:

There are three different ways to use the boring software, Blueprinting, Indicating and Probing. It is not unusual for all three modes to be used on the same size block. The vertical stops for these different operating programs will vary. Be sure the vertical stops are set correctly for the mode you are using.

For this example the deck will be our zero for the Vertical axis. Insert a tool holder into the cutterhead you will be using to bore the block. Center the cutterhead over a cylinder. Using the Vertical Handwheel, bring the cutterhead down until the tool just touches the deck and press the Vertical Zero button. The display above this button will go to zero. The Vertical zero has now been set.



The zeros points for all axis have now been set. All the numbers entered from this point on will reference these zero positions. You are finished with the Set Zeros screen, select the next Tab to the Right.

Programming Vertical Stops:

To build a program you must set the Vertical Stops for the program.

Block Clearance:

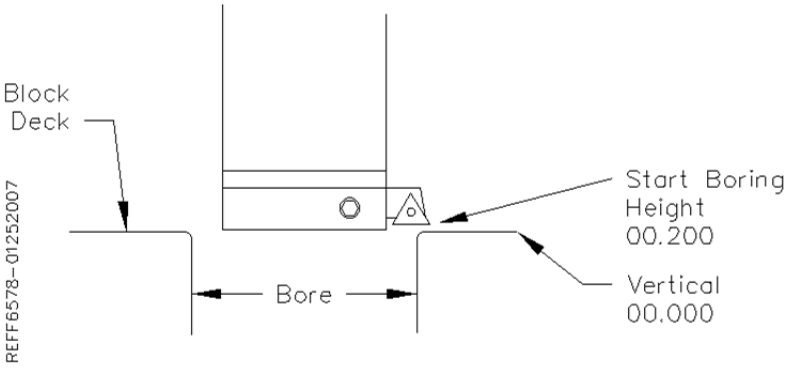
This is the distance above the zero position or block deck allowing the probe to move to the next bore unobstructed.

Centering Height:

This stop is not used when you are using the probing feature. It is recommended that it be set to the same value as the Block Clearance.

Start Boring Height:

This is the distance above zero or the block deck where you want the cutterhead to start rotating and the downward feed to start. Generally this is just a short distance above the block deck to minimize the amount of time the machine bores through air.



Bottom of the Bore:

This is the distance below zero or the Block deck where you want the machine to stop boring and retract out of the cylinder. When the spindle retracts it will then go to the block Clearance position.

This is an example of what the above program would look like on the vertical stops.

Probe Height:

When using the optional Probe… install the probe into the spindle after your vertical positions have been set using the cutterhead.

Using the handwheel and bring the Probe down to the location in the cylinder you will be probing. Press the SET button next to Probe height. This will set the probing height position.

Using the handwheel move the probe up until it can safely move horizontal to the next cylinder. Press the SET button next to Probe Clearance. This will set the clearance height.

The Vertical stops have now been set. You are finished with the Vertical Stops screen, select Left and/or Right Locations.

Bore Locations:

To build a program you must set the Horizontal and In/Out Stops for the program All Horizontal and In/Out stop are based from where their zero positions were set.

Select Left Locations and the Blueprint. Program the blueprint values (or close approximation) into the Horizontal and In/Out stops. Do the same for the Right Locations.

Select Left Locations and then Probing. You can probe each cylinder individual by pressing the associated Probe button or you can probe the entire bank by pressing the Probe Left Button. This is the same procedure for the Right Bank.

Probe Auto Center:

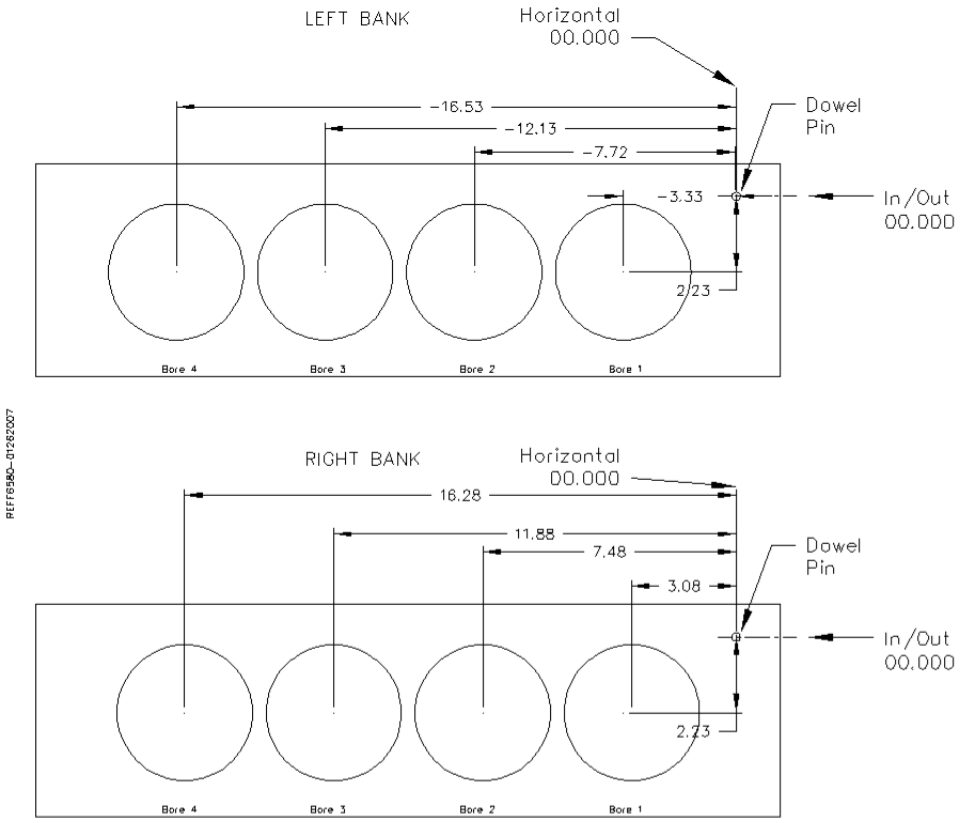
This feature is located on the Set Zero page. This allows easily find the center of a hole or cylinder. Roughly place the probe in the center of a cylinder. Press Probe Auto Center. The cylinder will be probed in 4 places, when finished the probe will move to the center of the probed cylinder. Pressing Horizontal and In/Out zero will then establish the center of that hole.

Automatic Probing Procedure:

The probe will move to the center of the cylinder to be probed. It will then move to the right at a slow rate until the side of the cylinder is touched, it will then back off slightly and touch the same spot again to confirm position. The probe will then touch off the cylinder in three more spots and retract from cylinder.

As each cylinder is probed the Probed Diameter, Horizontal and In/Out positions will be placed into the Data Boxes for the corresponding cylinder.

Press the Right Locations tab and repeat the above procedure for the cylinders to be probed on the right bank.



The Horizontal and In/Out stops have now been set.

Boring a Block:

Once the Vertical, Horizontal and In/Out stops have all been entered the Spindle RPM and Feed Rate need to be entered. This is done on the Set Zeros screen. Once this is done you can go to the Left and/or Right Bore location screens and bore the cylinders.

Pressing the Bore Left for Bore Right buttons Will Bore all the cylinders that have Green bore button below them.

Pressing a Bore button once will turn that button Yellow. Any Yellow button will not be bored when the Bore Left or Right button is pressed.

Double clicking any Bore button will turn all the Bore button yellow EXCEPT the one that was double click.

Cylinder Bore Mode 4th Axis:

NOTE: The program with the 4th axis installed works basically the same as the 3 axis mode. ONLY the differences in operation and screens will be discussed here. Carefully read through the 3 Axis mode and then the 4th axis mode for operation and building programs.

Select Cylinder Bore and then Through Bore on the control panel. This will bring up the boring program with the Set Zeros tab shown.

Setting Zeros:

The purpose of setting zero points is to give the operator a specific point to build programs from. The machine also uses these zero points to run the program from. The zero points can be set at any point in the machines' travel. Each axis (except the Spindle rotation) will need to have a zero point set for the machine to operate from.

4th Axis (Rotational) Zero:

The Zero position for the 4th (Rotational) Axis should be preset from the factory. If the zero needs to be reset use the following procedure.

There are three (3) flats cut onto the Head Stock Plate. Use the middle flat to set the rotational zero. Using an indicator off of the spindle indicate the middle flat to Zero all the way along it. Use the 4th Axis hand wheel to do this. When the middle flat is indicated in press the 4th Axis Zero button. You 4th (Rotational) Zero is set.

Finding the In/Out (Y) Axis Zero with 4th Axis:

The Head Stock Plate has a hole in it next to the Middle Flat. This hole is centered on the center of the Main and Cam locator shafts.

Building Programs with the 4th Axis:

Program are built the same as in the 3 Axis mode with the exception of setting the Angle for each Bank. The Left and the Right Locations page each have an Angle Data Box. Here you enter the angle of each bank from the 4th Axis (Rotational) zero position. The zero position is with the Cam and Crank Locators lined up vertically.

Example: On a Chevy 350 the Left bank would be positive 45 Degrees and the Right Bank would be a negative -45 Degrees.

Setting Vertical Clearance with 4th Axis:

It is very important when setting your Vertical and Probe Clearance height that you be sure to account for the Roll Over of the block from bank to bank. When in an automatic program the block will roll from the Left Bank to the Right bank at the Left Bank Bore1 position. It will also rotate from the Bore1 position when going from Right Bank to Left.

Table of Tools for 3 and 4th Axis Bore Mode:

NOTE: The Table of Tools is not needed to run the Rottler automatic programs. It is recommended that it not be used except by the advanced operator.

Building a Program with Table of Tools:

Build the program as described above for 3 and 4 Axis programs using the same vertical zero locations.

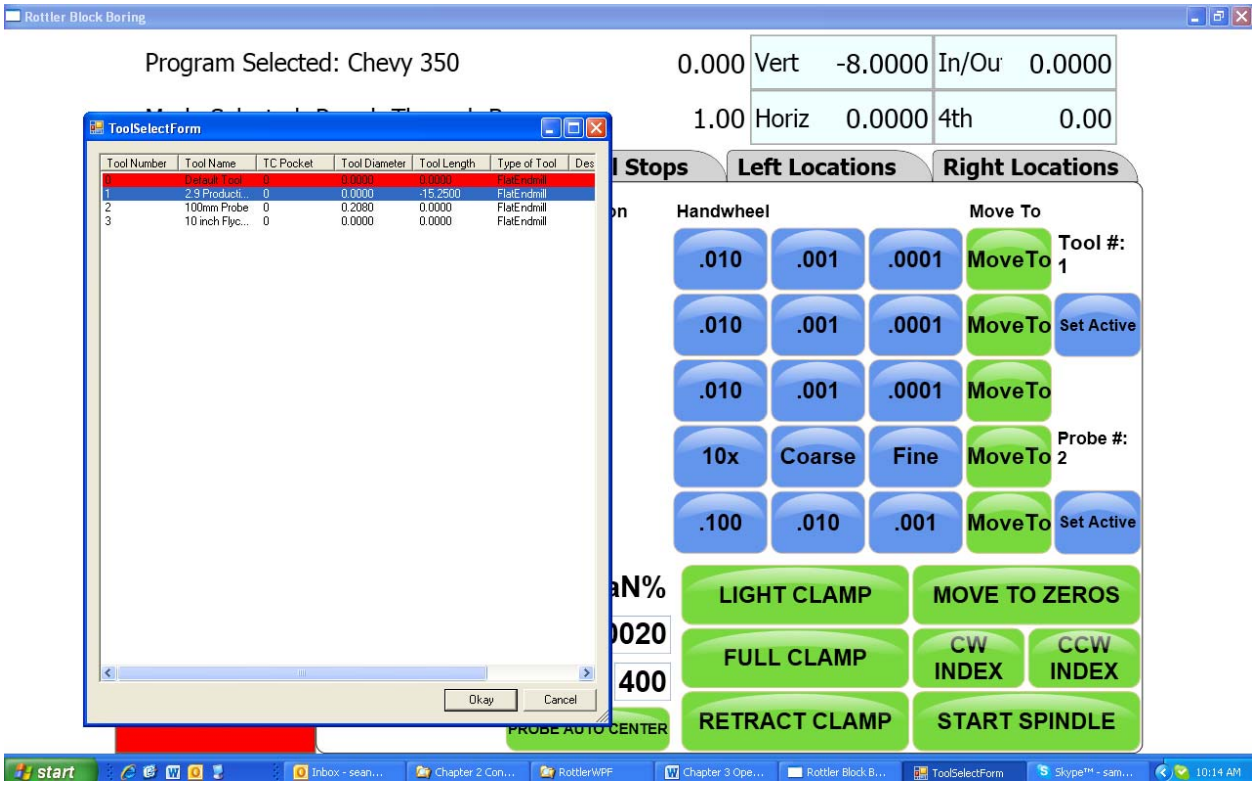
Put the tools to be used into the Table of Tools as described in Chapter 2. In Bore mode you are not referencing another vertical location such as the Crank centerline so the Z Touch off Location will remain at zero.

Assigning Tools:

Tools to be used in the boring operations are set on the Set Zeros page. To select a Tool, double click on Tool # on the right side of the screen. This will bring up the Table of Tools window. Highlight the tool you will be using, such as 2.9 Production Stub and select OK.

Do the Same to select the Probe you will be using, such as 100mm Probe.

NOTE: The Tool highlighted in red is the currently Active tool.

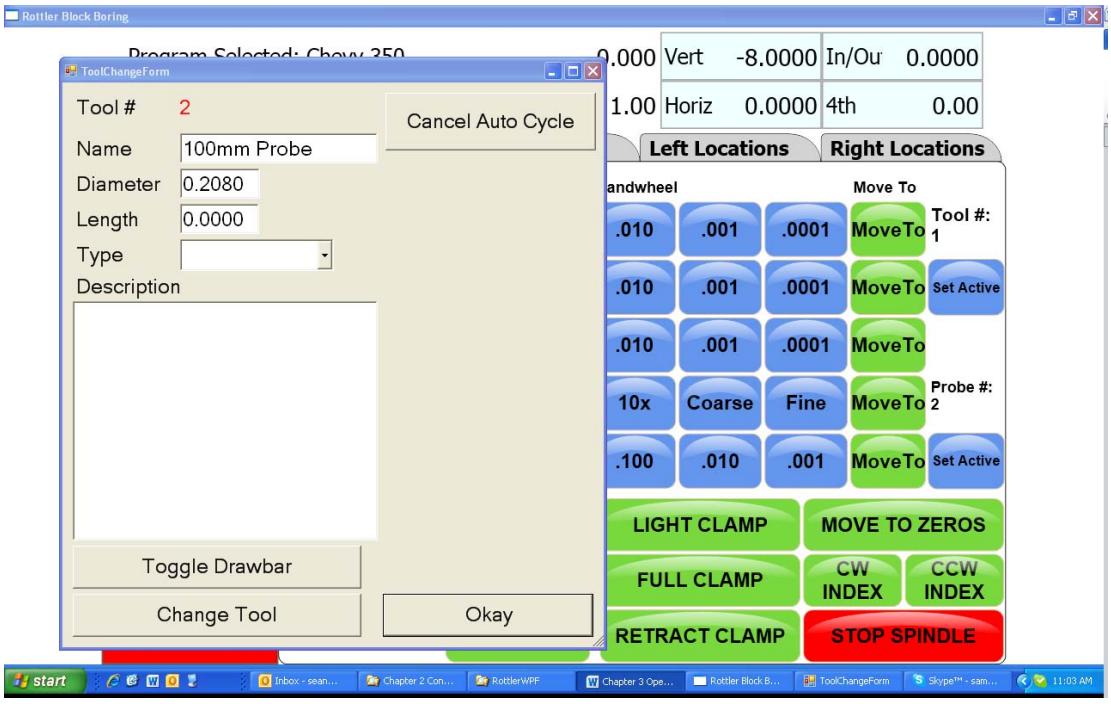


The following shows what the screen will look like with to tools assigned but none of them active. Default Tool 0 is set active and only shows on the Table of Tools screen.

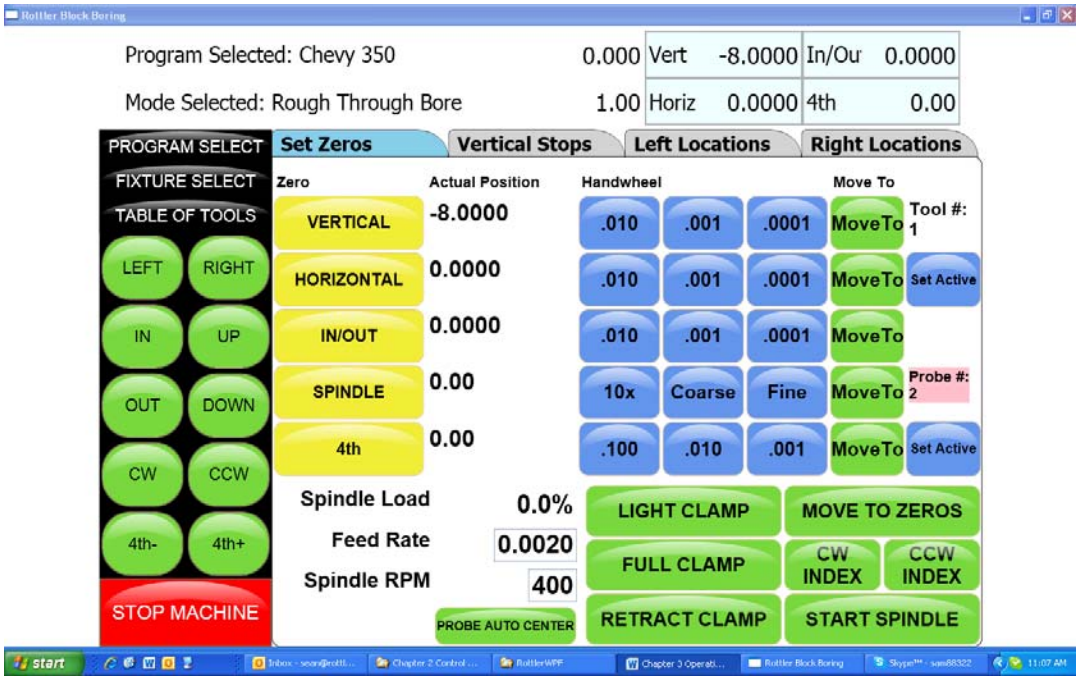
Setting Tools Active:

Physically install the first tool you will be using in the program. For this example physically install the 100mm Probe into the spindle. Press the Set Active button below the Probe #. The Tool Change Form will Open. This is to very your Vertical Tool Length and Probe Diameter. Select OK and then OK again on the spindle warning page.

IMPORTANT: The Tool Diameter on this page is used for the Probe. This must be set to the actual Diameter of the probe when probing cylinders. The Tool Diameter is NOT used for Boring Bars, End Mills etc… in the Rottler Bore program.



The Currently Active tool in a program will be highlighted in Pink on the Set Zero page.

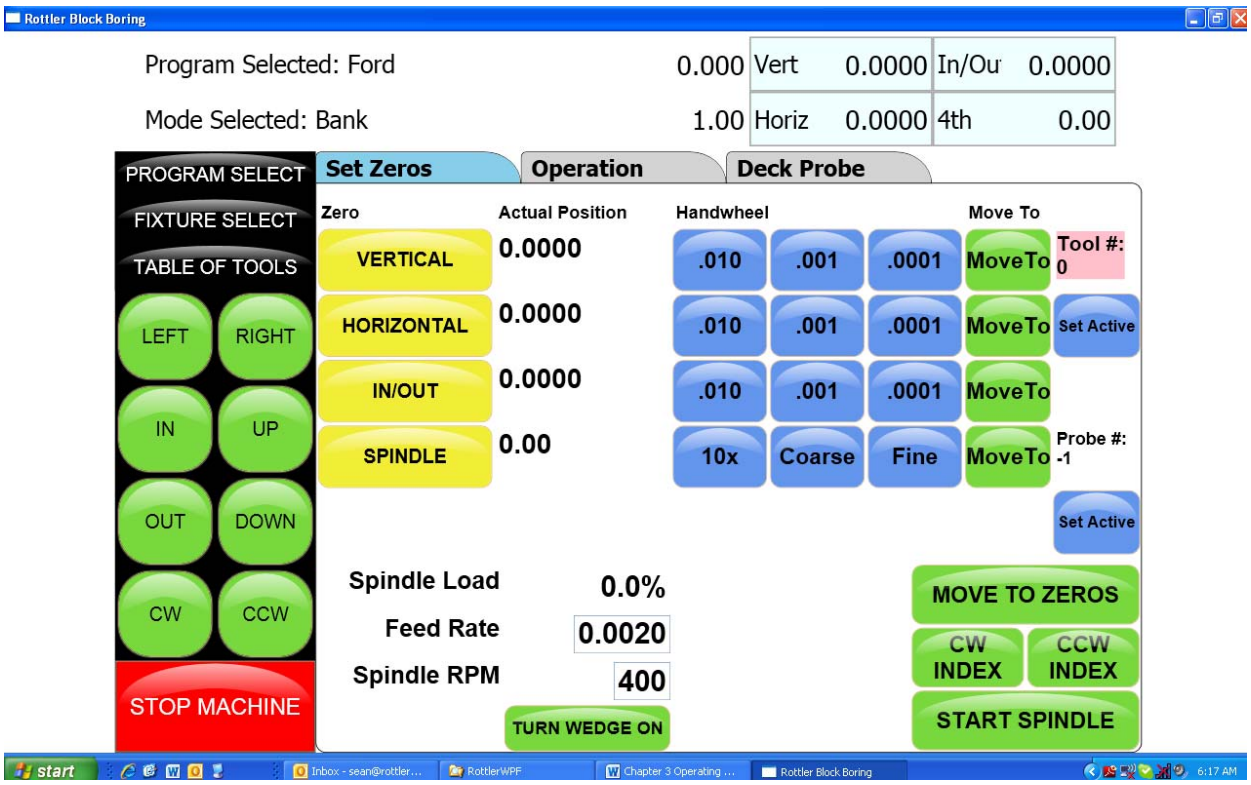


If you attempt to run the Probing Cycle with the Tool # active the machine will automatically move to the Tool Change clearance position and open the Tool Change Window so you can change the tool and vise versa.

Mill Mode 3 Axis:

Setting Zeros:

The purpose of setting zero points is to give the operator a specific point to build programs from. The machine also uses these zero points to run the program from. The zero points can be set at any point in the machines' travel. Each axis will need to have a zero point set for the machine to operate from.

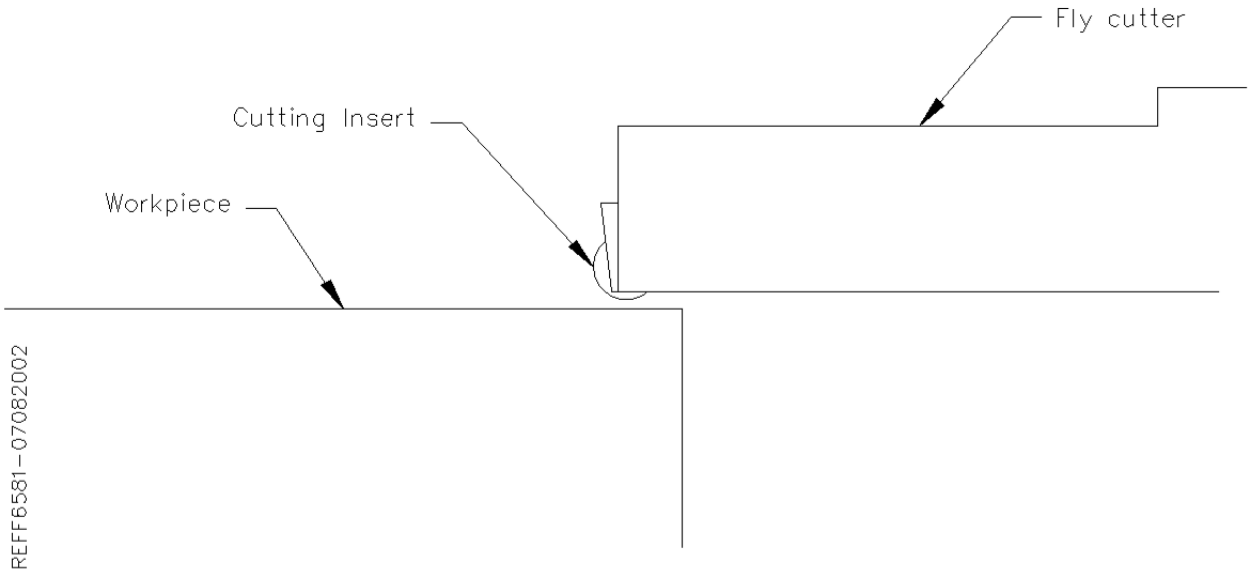


Horizontal Zero:
For this example we are going to set the Horizontal Zero approximately ¼" from the right hand side of the work piece.

In/Out Zero:
For this example we are going to set the In/Out Zero at the center line of the work piece.

Vertical Zero:
For this example the Vertical Zero will be at the deck height of the work piece.

Example:
Install the Milling cutterhead you will be using into the machine. Move the In/Out axis and center the work piece under the spindle. Press the In/Out Zero button here. Move the Horizontal Axis to that the cutter is overhanging the work piece about ¼". Bring the Vertical Axis down until the cutter is just above the work piece. At this time it should look similar to the drawing below.



Set the Spindle RPM and Feed rate on this screen.

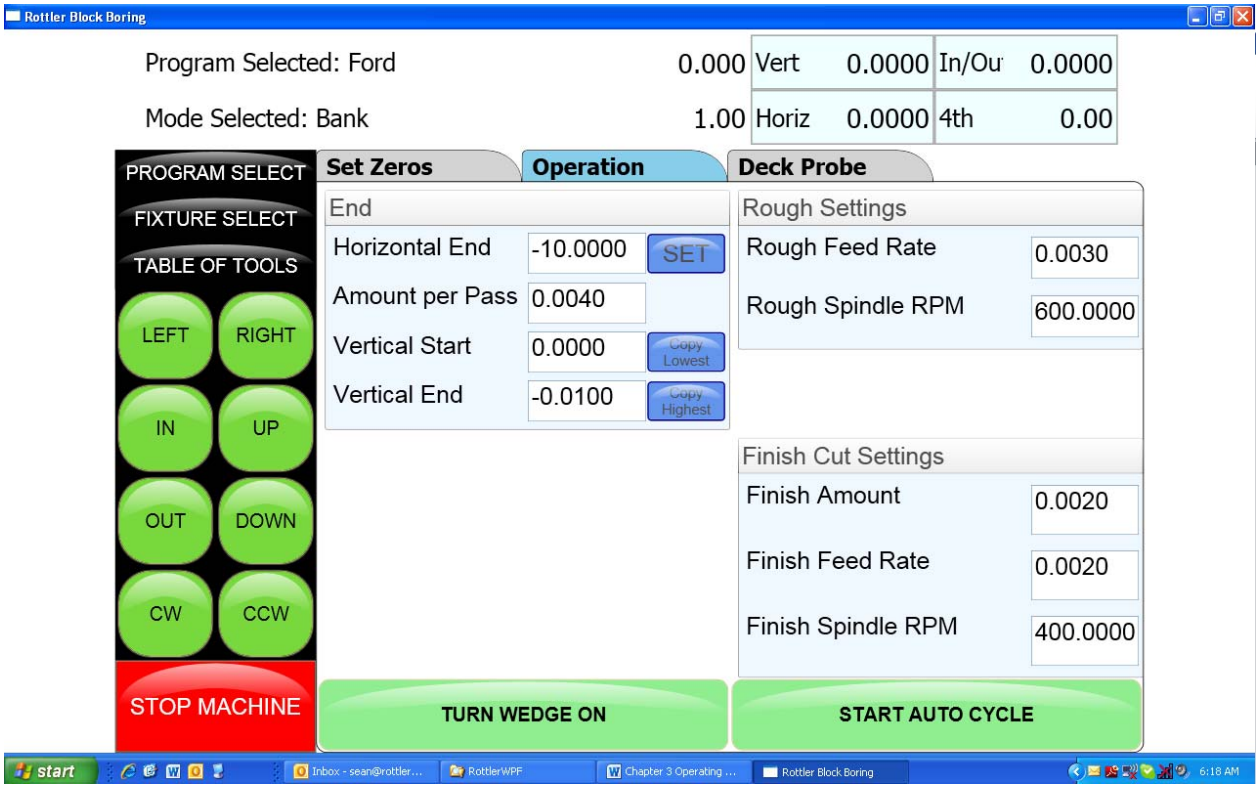
Start the spindle. Press the Vert .001 button to put the handwheel in .001 per detent. Slowly move the spindle downward until you can hear or see the cutter just touch the block. Press your Vertical Zero button here. Press the Right travel button to feed the spindle off of the work piece. When the cutter has cleared the work piece press the Right travel button again to stop the feeding. Press the Horizontal Zero here.

Your zero position for all axis have now been set.

Mill Operation:

IMPORTANT: Do not move the machine In/Out with the Wedge on. The Wedge comes on automatically when the Mill program is entered. If you need to move the machine In/Out to center on the work Piece use the turn Wedge On/Off button at the bottom of the page to do so. Make sure the Wedge is back on when you start the cycle.

This screen is used to set certain parameters the F109 will use to run the automatic cycle.



End:

Horizontal End
This displays the current end stop value. To enter a new value press the display and a pop-up numerical key pad will appear. Press the desired end stop value and then ENTER. This is the distance from where the Horizontal Zero was set. You can move the fly cutter manually to the end of the cut and press the SET button. This will automatically put the Horizontal End value in for you.

Amount Per Pass:
This is the amount of material removed from the work piece on each pass of the cutterhead.

Vertical Start:
This is the Vertical Position the machine will start cutting at. This value is usually Zero which is usually the starting Deck Height.

Vertical End:
This is the Vertical Position the machine will stop cutting at. It is the Total amount of amterial you want to remove in the Milling process.

Copy Lowest Copy Highest:
These buttons will be discussed in the Mill Probing section of this Chapter.

Rough Settings:

These values are used when taking multiple passes on a work piece. These values can be wet high to remove material quickly. The finish on the work piece does not matter in these settings. There will be a Final pass that will apply the finish to the work piece.

Rough Feed Rate:
Enter the desired Roughing Feed Rate;

Rough Spindle RPM:
Enter the Desired Roughing Spindle RPM.

Finish Cut Settings:

These values will be used for the last pass the machine will make on the work piece. These will determine the finish left on the work piece.

Finish Amount:
Enter the amount to be removed on the last pass.

Finish Feed Rate:
Enter the desired Finish Feed Rate.

Finish RPM:
Enter the desired Finish Spindle RPM.

NOTE: You do not need to have evenly divisible numbers in these sections. The computer will do the math to remove the correct amount each time and for the final pass to be at the amount you set.

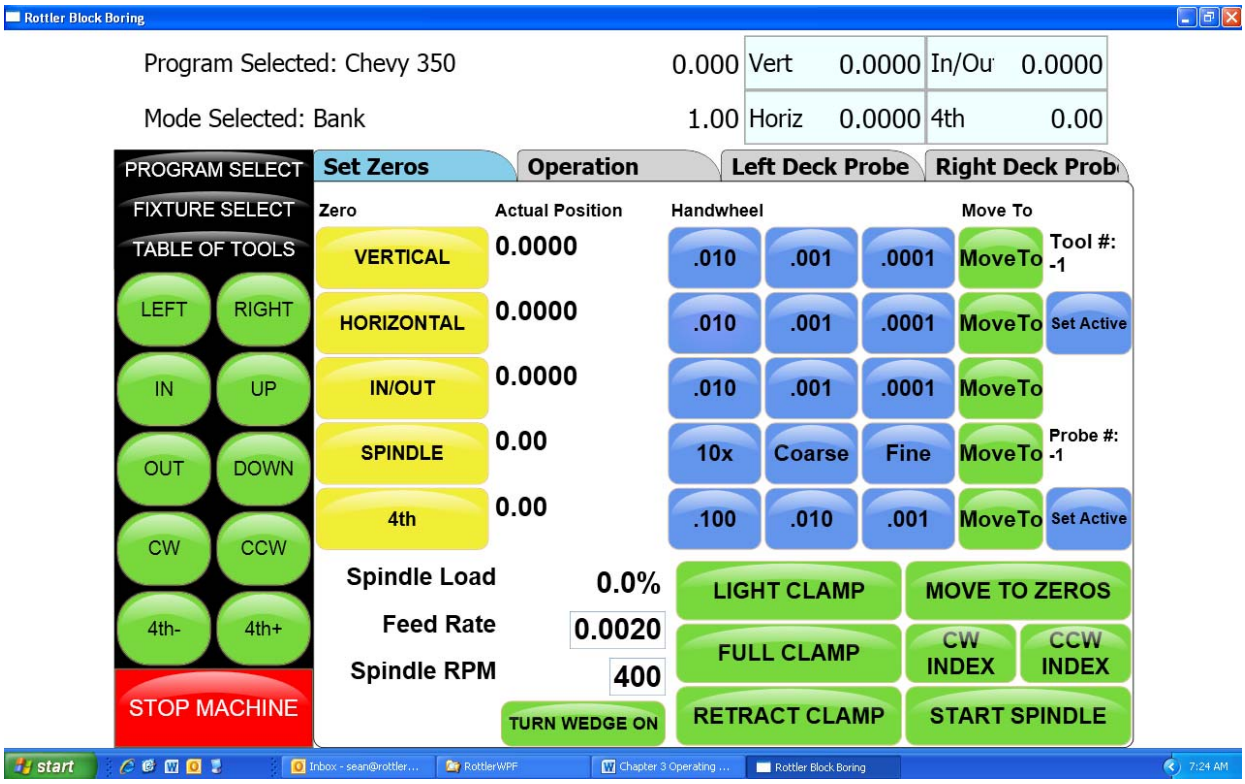
Start Auto Cycle:

Pressing this button will start the machines automatic cycle. The cycle to be run is determined by the setting on this page. If you only require one pass to be made, do not enter any values into the Rough Setting, only the Finish Cut Settings.

Mill Mode 4th Axis:

Setting Zeros:

The purpose of setting zero points is to give the operator a specific point to build programs from. The machine also uses these zero points to run the program from. The zero points can be set at any point in the machines' travel. Each axis will need to have a zero point set for the machine to operate from.



Horizontal Zero:
For this example we are going to set the Horizontal Zero approximately ¼" from the right hand side of the work piece.

In/Out Zero:
For this example we are going to set the In/Out Zero at the center line of the work piece.

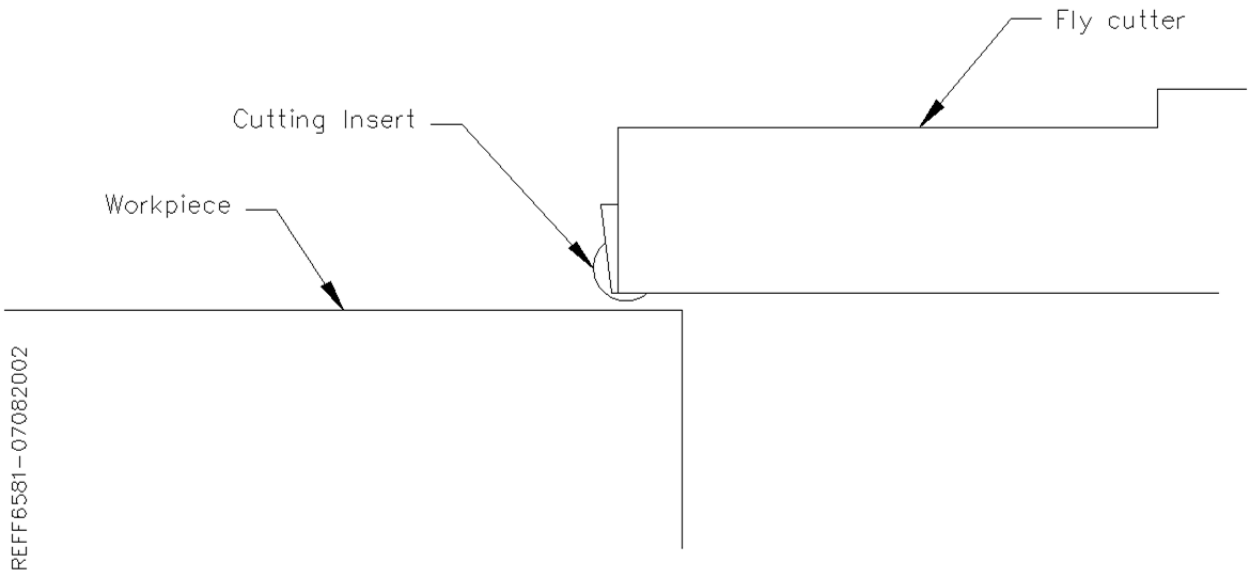
Vertical Zero:
For this example the Vertical Zero will be at the deck height of the work piece.

CAUTION

When setting the vertical zero it is important to check the deck height on both banks of the block before starting a cycle. It is possible that the right bank my be higher than the left bank where the vertical zero was set. This would cause a crash when the block rotated and the cycle was started on the right side.

Example:
Install the Milling cutterhead you will be using into the machine. Move the In/Out axis and center the work piece under the spindle. Press the In/Out Zero button here. Move the Horizontal Axis to

that the cutter is overhanging the work piece about ¼". Bring the Vertical Axis down until the cutter is just above the work piece. At this time it should look similar to the drawing below.



Set the Spindle RPM and Feed rate on this screen.

Start the spindle. Press the Vert .001 button to put the handwheel in .001 per detent. Slowly move the spindle downward until you can hear or see the cutter just touch the block. Press your Vertical Zero button here. Press the Right travel button to feed the spindle off of the work piece. When the cutter has cleared the work piece press the Right travel button again to stop the feeding. Press the Horizontal Zero here.

Your zero position for all axis have now been set.

Mill Operation:

IMPORTANT: Do not move the machine In/Out with the Wedge on. The Wedge comes on automatically when the Mill program is entered. If you need to move the machine In/Out to center on the work Piece use the turn Wedge On/Off button at the bottom of the page to do so. Make sure the Wedge is back on when you start the cycle.

This screen is used to set certain parameters the F109 will use to run the automatic cycle.

End:

Horizontal End
This displays the current end stop value. To enter a new value press the display and a pop-up numerical key pad will appear. Press the desired end stop value and then ENTER. This is the distance from where the Horizontal Zero was set. You can move the fly cutter manually to the end of the cut and press the SET button. This will automatically put the Horizontal End value in for you.

Amount Per Pass:
This is the amount of material removed from the work piece on each pass of the cutterhead.

Vertical Start:
This is the Vertical Position the machine will start cutting at. This value is usually Zero which is usually the starting Deck Height.

Vertical End:
This is the Vertical Position the machine will stop cutting at. It is the Total amount of amterial you want to remove in the Milling process.

Copy Lowest Copy Highest:
These buttons will be discussed in the Mill Probing section of this Chapter.

4th Axis Angles:

Left Bank Angle:
Enter the angle of the Left Deck. This is the angle of the block in reference to the Cam and Crank bore being lined up Vertically.

Right Bank Angle:
Enter the angle of the Right Deck. This is the angle of the block in reference to the Cam and Crank bore being lined up Vertically.

Rollover Vertical Clearance:
Enter the value the Fly Cutter will have to move up vertically to clear the block when it rolls over from bank to bank.

In/Out Offset:
This is a value that can be entered to center the fly cutter in the middle of the deck. You In/Out center on the Left bank will not be the center of the In/out on the Right bank. Enter the value the In/Out will need to be moved to center on the Right Bank when it rolls over.

Rough Settings:

These values are used when taking multiple passes on a work piece. These values can be wet high to remove material quickly. The finish on the work piece does not matter in these settings. There will be a Final pass that will apply the finish to the work piece.

Rough Feed Rate:
Enter the desired Roughing Feed Rate;

Rough Spindle RPM:
Enter the Desired Roughing Spindle RPM.

Finish Cut Settings:

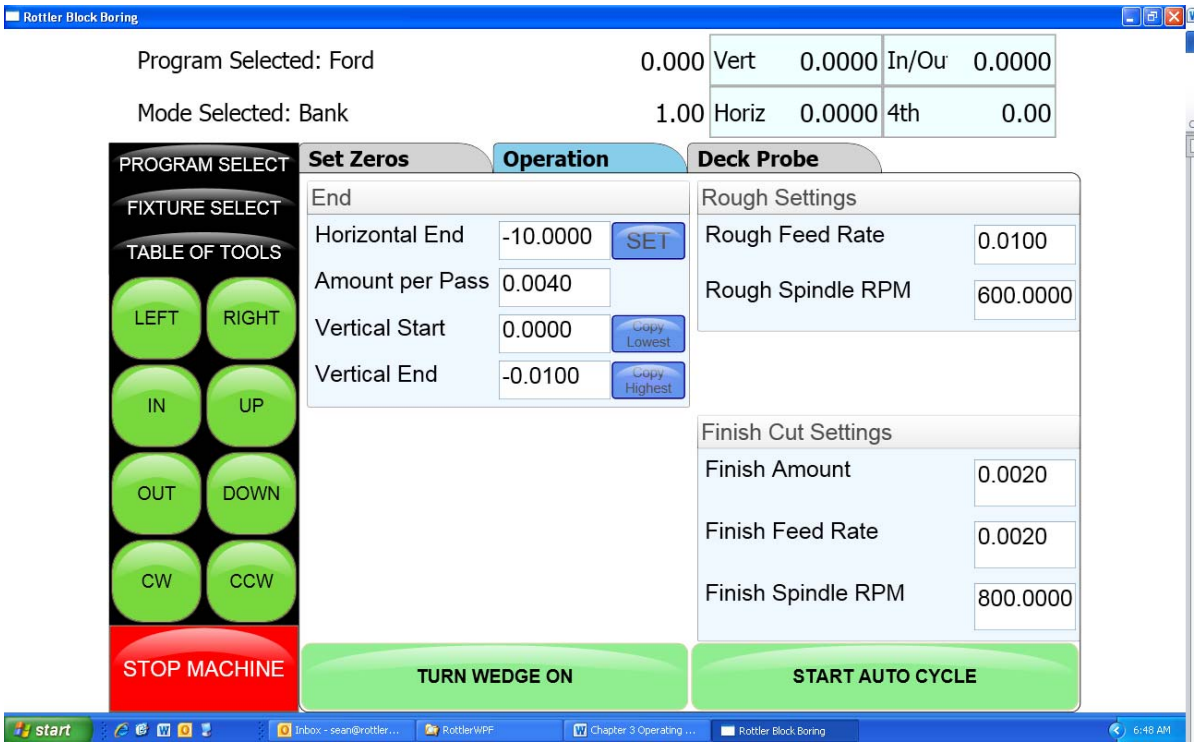
These values will be used for the last pass the machine will make on the work piece. These will determine the finish left on the work piece.

Finish Amount:
Enter the amount to be removed on the last pass.

Finish Feed Rate:
Enter the desired Finish Feed Rate.

Finish RPM:
Enter the desired Finish Spindle RPM.

NOTE: You do not need to have evenly divisible numbers in these sections. The computer will do the math to remove the correct amount each time and for the final pass to be at the amount you set.



Cut Left and Cut Right:

Pressing these buttons will cause the machine to run an automatic cycle (per the parameter defined in the Operations page) on the associated bank.

Start Auto Cycle:

Pressing this button will start the machines automatic cycle. The cycle to be run is determined by the setting on this page. If you only require one pass to be made, do not enter any values into the Rough Setting, only the Finish Cut Settings.

Milling Using Automatic Deck Probing:

The Rottler Milling program is set up to Automatically Probe the Deck height of a block and then Mill it to a set Deck Height. This can be done on a 3 or 4 axis machine.

Table of Tools for Milling:

You MUST use the Table of Tools if you want to Automatically Probe the deck height and cut it to a set height.

Refer to Chapter 2 – Table of Tools to put your Fly Cutter and Probe into the Table of Tools. Once done the Table of Tools Should look similar to the below picture.

The 100mm Probe is Tool 1. The 10” Fly Cutter is Tool 2.

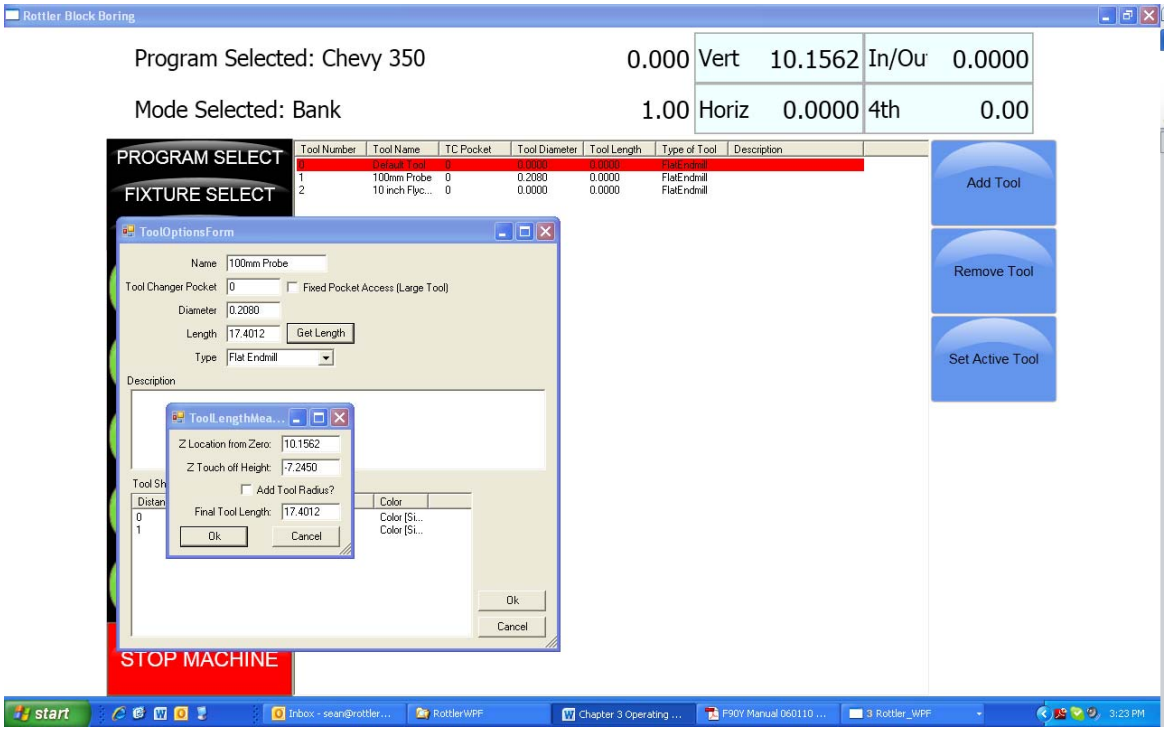
Go to Program Select, then select the block you are working with and then Mill Mode.

Install the Probe physically into the spindle. Rotate the 4th axis to Zero degrees. Indicate the Middle flat on the head stock to be sure it is zero all the way across. There should be a number stamped into the headstock. This is the distance from the Flat to the center of the Crank. Bring the probe down until it just touches the middle flat.

Open the Table of Tools and double click on Tool1 100 mm Probe. Enter the Measured diameter of you r Probe. This is not used in the Milling Program but needs to be entered accurately for Probing in the Bore mode.

On the open window select Get Length. This will open another Window. There will be a value, that you cannot edit, in the “Z Location from Zero” this is the distance the Vertical Axis is from home when the Probe touches the Middle flat.

In the Data box for “Z Touch off Height” enter the number that is stamped on the Head Stock. This is the distance from the flat to the center line of the Crank.



Select OK on both windows. This will put the Total tool length into the Table of Tools.

The Vertical Digital Read Out will now consider the center of the Crank bore to be the Vertical Zero position.

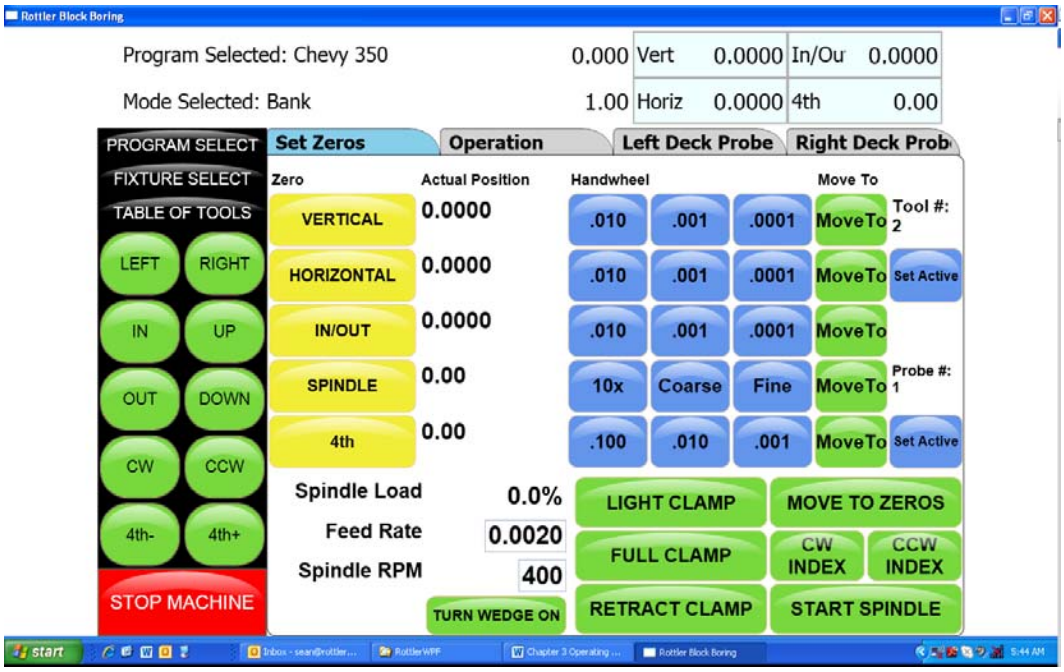
When the Probe tip or Cutting insert touches the Deck the Vertical DRO will be reading out the distance from the center of the Crank bore (Actual Deck Height).

Assigning Tools:

From the Set Zero Tab, select Probe#. This will open the Tools Select Form. Select Tool 1, 100 mm Probe and click OK.

Select the Tool#. This sill open The Tool Select Form. Select Tool 2, 10 inch Fly Cutter and click OK.

The tools to be used have now been assigned to the program.



Setting Tools Active:

To set a Tool Active (tool to be used) Press the Set Active button below that tool. Set the Probe Active. This will bring up the Tool Change Form. Her you can verify the information for the tool. Select OK. Select OK on the Spindle warning form if it appears.

The Probe# will now be highlighted in Pink, this indicates that the tool is active (being used). If you were to open the Table of Tools at this point, Tool 1 will be highlighted in Red. This also indicates that Tool 1 is active.

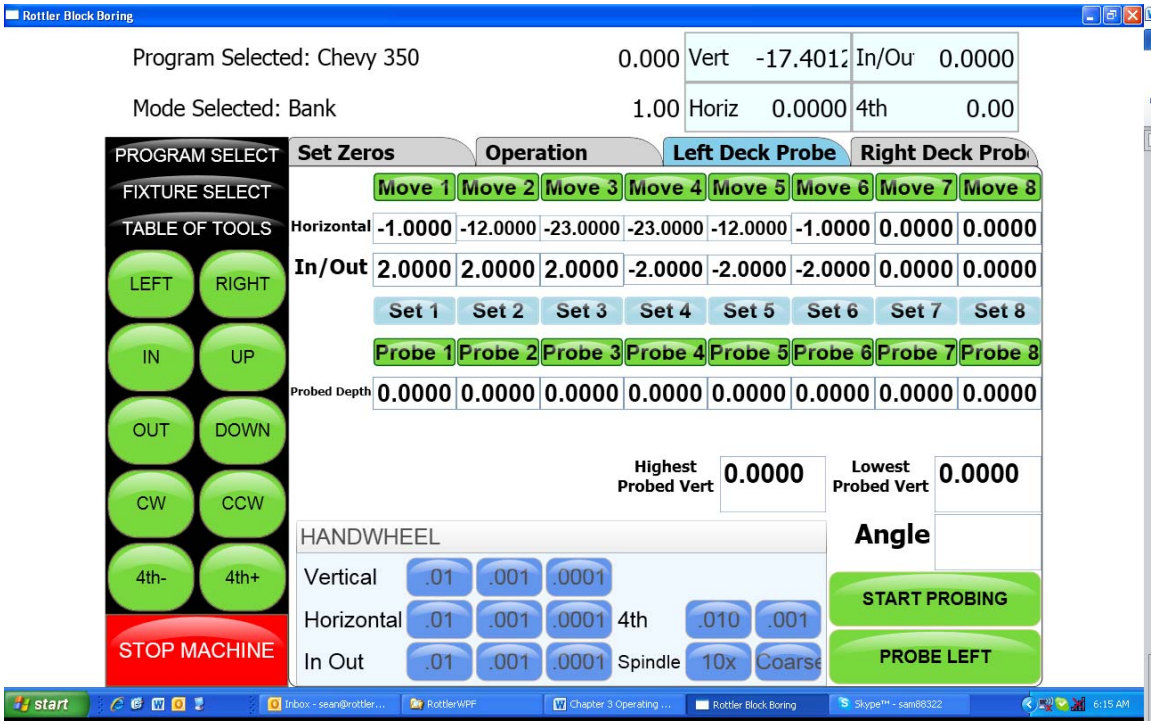
Building a Program Using Table of Tools:

Enter all the values that were described in 3 and 4 Axis Milling earlier in the chapter.

Physically install the probe into the spindle and set active. Bring the probe down until it just touches the Deck. Look at the value in the Vertical DRO. This is the current deck height at position. Enter that numeric value into the Vertical Start. This gives the Probe a value to start probing the deck at.

Left Deck Probe:
Enter the positions you want the Probe to probe here. You can physically move the probe to the locations on the bank you want to probe and hit the set button also.

Right Deck Probe:
Roll the block over to the Right Bank. Enter the positions you want the Probe to probe here. You can physically move the probe to the locations on the bank you want to probe and hit the set button also.



Auto Probing:

Press the Start Probing button. The machine will first probe each programmed location on the left bank and record the height. The spindle will move to Vertical Clearance height and the block will roll over to the right bank and probe the programmed locations and record them. The block will then roll back over to the Left bank and the spindle will move to the first Left location and stop.

Auto Milling:

Go to the Operations Tab.

Vertical Start:
Press Copy Highest next to Vertical Start. This will copy the Highest Probed point of either bank. This is the Height at which the Start Auto Cycle would start the first cutting pass.

Vertical End:
Press Copy Highest next to Vertical Start. This will copy the Highest Probed point of either bank. This is the height at which the Start Auto Cycle would end the Final Pass. You would use this value if you just wanted to clean the deck up to the lowest point. If you want to cut the Deck Height to a certain value you would manually enter that value into the Vertical End Data Box.

Cut Left or Cut Right:
Pressing either of these buttons will Start the Auto Cycle for only the associated bank. That bank will be cut to the set parameters and the machine will stop.

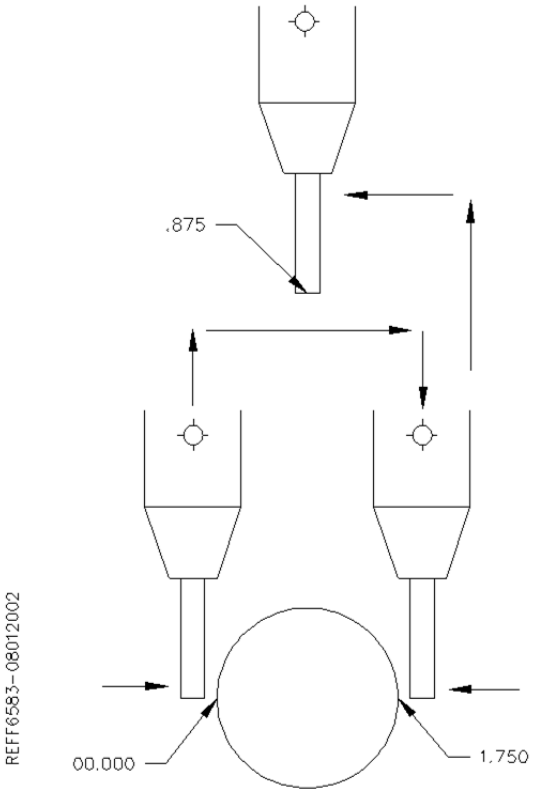
Start Auto Cycle:
Pressing this button will start the Auto Cycle for Both Banks. First the Left bank will be cut to the set parameters. The spindle will go to the Clearance Height and Roll over to the Right bank and cut it to the set parameters. The Spindle will again go to the Clearance Height and roll over to the Left bank. The machine will go idle at this point.

Lifter Bore Mode 3 Axis:

Lifter Bore programs are built the same as described in the Bore Mode 3 Axis. Only the differences will be discussed in this section.

In / Out Zero:

The In/Out zero position for Lifters is the center line of the Cam Bore. An easy way to find the center of the cam line is to use the electronic probe. The following is an example of this procedure. Install the probe into the holder and the holder into the spindle. Bring the probe down until it is in the approximate center of the cam Bar Vertically. Press the Vertical Zero button now (this is only a temporary Vertical Zero position). Using the In/Out handwheel bring the probe up to the Cam Bar until it lights. Press the In/Out zero button here. Move the spindle up enough to clear the Cam Bar, move the probe to the other side of the Cam Bar. Bring the vertical down to the zero position. Hand wheel the probe into the Cam Bar until the light comes on. Note the In/Out position reading. Divide this reading by two. Bring the spindle up until it can clear the Cam Bar. Use the In/Out handwheel and move the In/Out position until it matches the divided number. This is the center line of the Cam Bar. Press the IN/Out Zero button now. The In/Out zero position has been set. The following illustration visual shows the above description.



Start Boring Height:

Pay particular attention when setting this height, there are often protrusions in the casting that will not allow the End Mill to travel unobstructed all the way to the start of the lifter bore. It is safest to set the Start Boring Height above the Deck.

Lifter Bore Angle:

Rottler has specific Lifter Bore spacers that are installed on the Cam bar to set the correct angle for lifter boring when using the Performance Fixture.

Lifter Bore 4th Axis:

Lifter Bore programs are built the same as described in the Bore Mode 4th Axis. Only the differences will be discussed in this section.

Start Boring Height:
Pay particular attention when setting this height, there are often protrusions in the casting that will not allow the End Mill to travel unobstructed all the way to the start of the lifter bore. It is safest to set the Start Boring Height above the Deck.

Lifter Bore Angle:
The angle for each bank is located on the associated Locations page. Press the angle numerical value and a pop-up will open so you can type in the Lifter Bore angle.

Calculate In/Out:
This button is located next to the In/Out Locations for each Bank. You must first have the Correct angle entered into the Angle data box. Then press the Calculate In/Out button. A window will open where you enter the center to center distance of the Cam to Crank bores. The In/Out locations will automatically be filled in.

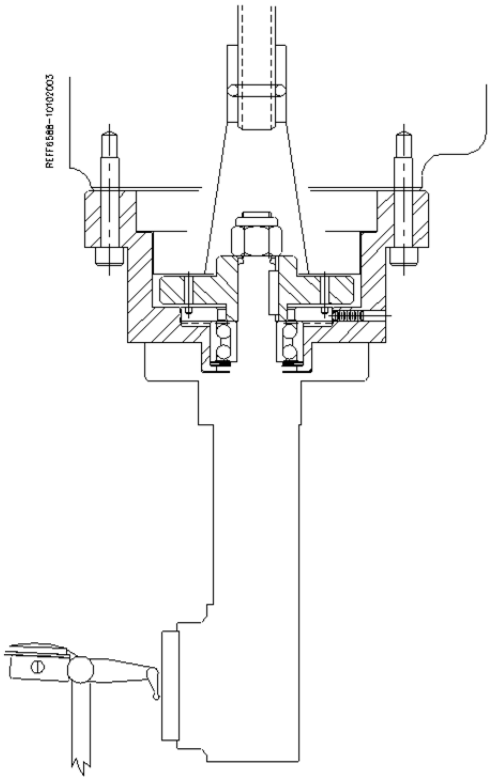
Line Bore Mode:

Select the Line Bore button from the Main Menu. This will bring up the Line Bore Mode with the Set Zeros tab shown.

Mounting and Aligning the 90 Degree Head:

Mount the 90 degree head onto the spindle and just snug the four mounting bolts. Use the following instructions to align the head.

Mount a .001" or .0001" dial indicator to the machine table or block. The 90 degree head has two machined surfaces that can easily be used to align the head. The two surfaces and indicator positions are shown below.



Put some pressure on the indicator. Using the In/Out handwheel move the indicator form one side to the other noting the amount of difference. Keep the indicator on that side of the head and rotate it half of the noted distance. Repeat this procedure until there is less than .0005" variance.

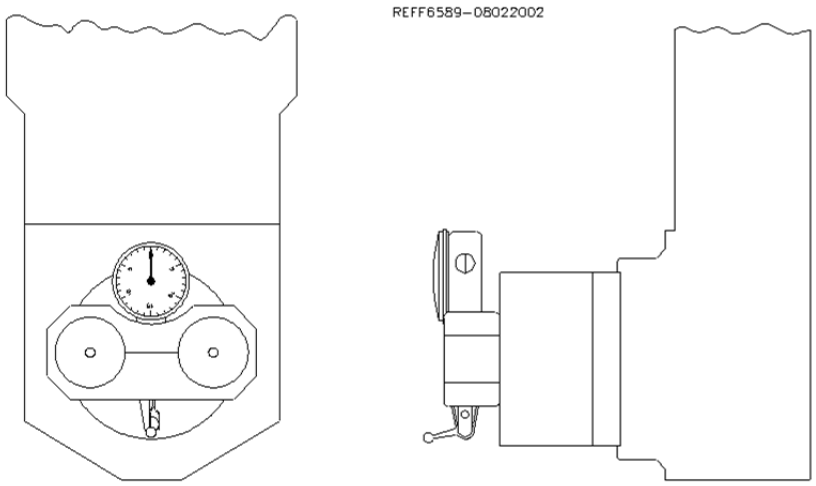
Tighten the four mounting bolts for the head and check the surface again to be sure it did not shift when tightening the head.

Setting Zeros:

The purpose of setting zero points is to give the operator a specific point to build programs from. The machine also uses these zero points to run the program from. The zero points can be set at any point in the machines' travel. Each axis (except the Spindle rotation) will need to have a zero point set for the machine to operate from.

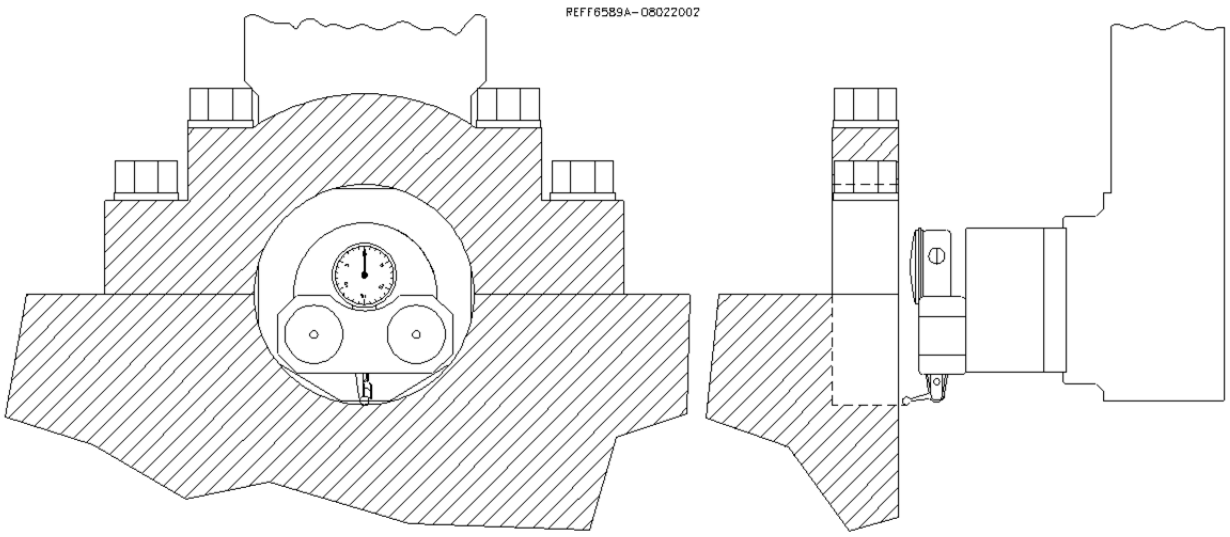
Horizontal Zero:
The Horizontal should be set about .050” from the front of the first main to be bored, making sure that that position will allow the head to travel up without interference. Bring the head down and roughly center it in front of the first main. It does not need to be perfectly centered to set the horizontal zero. Press the Horizontal Zero button at this location.

In/Out and Vertical Zero:
Locate the supplied Last Word indicator and small magnetic base. Mount on cutterhead as shown below.



Using the Horizontal handwheel move the indicator inside the main bore, making sure the indicator is not touching the main bore at this point. You will be indicating both sides and the bottom of the saddle, generally the cap is not used to indicate from.

Physically move the indicator and mag base on the cutterhead until there is about .010” pressure on it. Start rotating the spindle CW and CCW watching he indicator. As there is too much or too little pressure on the indicator, use the In/Out and Vertical handwheel to adjust the spindle in the bore until all three point are equal. Press the In/Out and Vertical zero buttons at this point.



The Vertical stops have now been set. You are finished with the Program Vertical Stops screen, select the next Tab to the Right.

Programming Vertical Stops:

To build a program you must set the Vertical Stops. There are two (2) vertical stops used in the Line bore mode.

Bore Centerline:
The first vertical stop is on the main bore centerline. The vertical zero was set on the bore centerline, Therefore this stop will always be zero.

Block Clearance:
This stop is set at a negative value that will allow the 90 degree head to travel over the cap and bolts to the next main bore unobstructed.

Programming Horizontal Stops:

The Horizontal Zero was set .050" before the first Main Bore, so the first Horizontal stop will be 00.000. Measure the distance between each main and enter it into the corresponding stop number.

Programming Bore Length:

Measure the length of each Main Bore and enter that value into the corresponding length box

Running the Auto Cycle:

You will need to set a Feed Rate and Spindle RPM on this screen to run an auto cycle. After this is done press the "Move to Zeroes" button. The spindle will move up the Vertical Block Clearance distance if it is not already there. It will then move to the Horizontal and In/Out axis to the zero position. The vertical will then move down to the zero position and stop.

CAUTION: If you press the MOVE buttons or the Cycle Start button the machine will not move the In/Out axis to the zero position. You need to move the In/Out axis to the zero position manually before you press Cycle Start.

The machine will go idle at this time. Pressing the "Start Auto Cycle" button will cause the entire cycle to run.

After a program has been completed the machine will move the spindle over to the first Main Bore at the Clearance Distance.

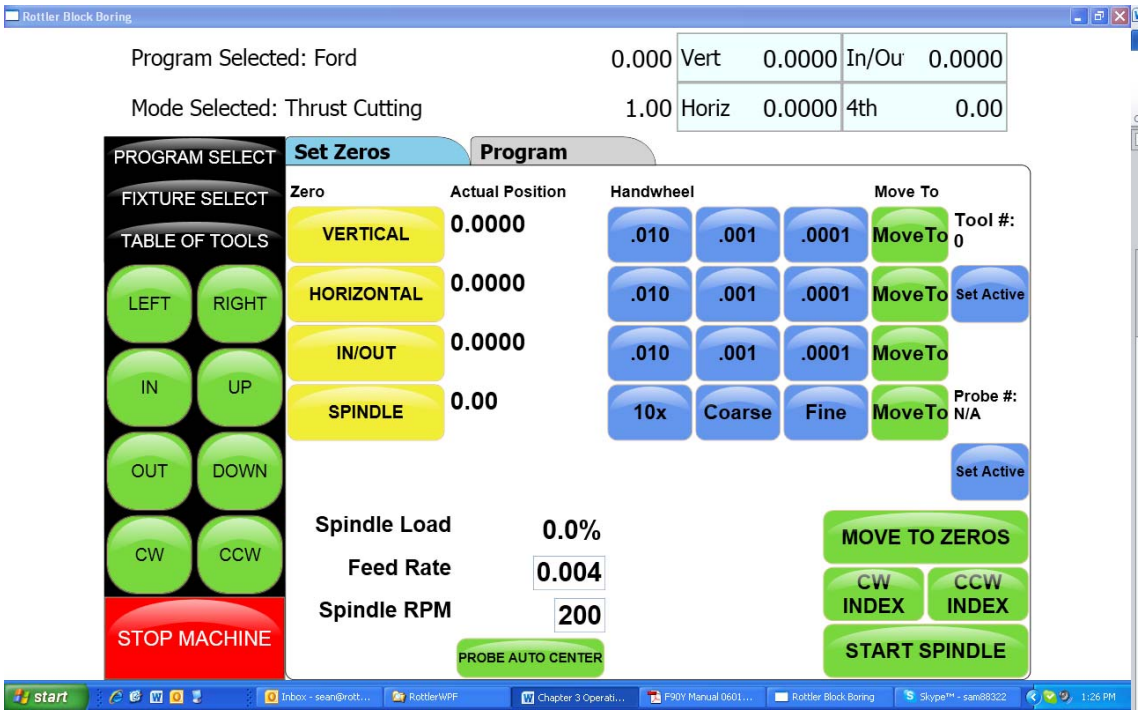
Thrust Cutting:

Refer to Line Bore in this section for mounting the block and aligning the 90 degree head.

Note: It is important to read through the entire Thrust Bearing Cutting section before entering any values or starting the Auto Cycle. You will better understand how the program operates and how the values affect the operation of the Auto Cycle.

The Thrust Cutting program can cut a single or double thrust face using circular interpolation.

Select the Thrust Bearing Cutting button from the Main Menu. This will bring up the Thrust Bearing Cutting Bore Mode with the Set Zeros tab shown.



Setting Zeros:

The purpose of setting zero points is to give the operator a specific point to build programs from. The machine also uses these zero points to run the program from. The zero points can be set at any point in the machines' travel. Each axis (except the Spindle rotation) will need to have a zero point set for the machine to operate from.

Horizontal Zero:

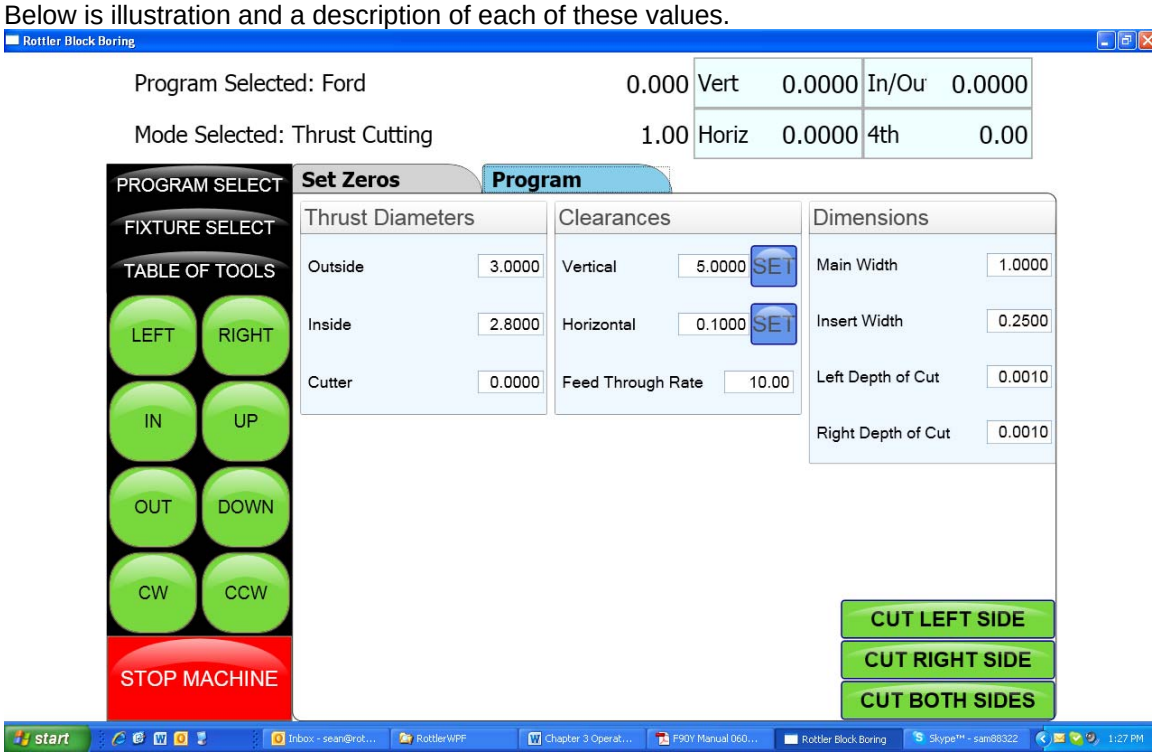
To set the Horizontal Zero, bring the cutter in using the Horizontal Hand Wheel until it just touches off the current thrust face. Press the Horizontal Zero Button here. The computer will use this zero point when cutting the depth of the thrust face.

Follow the procedure for setting zeros in the Line Bore Mode section of this chapter. Set the Horizontal zero on the Main Bearing that is to have the Thrust cut.

After the zeroes have been set select the nest tab to the right, Dimensions.

Dimensions & Auto Cycle:

There are several values that need to be set on this screen for the program to operate properly. Below is illustration and a description of each of these values.



Thrust Dimensions:

Outside:
This is the Outside dimension of the thrust face to be machined.

Inside:
This is the Inside dimension of the thrust face to be machined.

Cutter:
This is the radius, from the center of the 90 degree head to the tip of the insert.

Clearances:

Vertical:
This is the distance, from zero, the 90 degree head will have to travel up to clear the main caps on the block.

Horizontal:
This is the distance, from zero, the 90 degree head will have to travel to clear the main for the next vertical move.

Dimensions:

Main Width:
Width of the Main.

Insert Width:
Width of the Insert.

Left Depth of Cut:
Depth of left cut.

Right Depth of Cut:
Depth of right cut.

Cut Right Side:
If you select Cut Right Side the automatic cycle will cut the thrust face on the right hand side of the Main.

Cut Left Side:
If you select Cut left Side the automatic cycle will cut the thrust face on the left hand side of the Main.

Description and Running of the Auto Cycle:

You will need to enter the Feed Rate and Spindle RPM the program will run at.

There are no Move to buttons in this program. You ***MUST*** be at the zero positions when the Auto Cycle is started.

Start Auto Cycle:
When you are at the zero positions press the Auto Cycle, the spindle will start at the programmed RPM. The vertical feed will start at the programmed rate in an upward direction until the correct Outside diameter is reached. The circular interpolation will start at this point and go 360 degrees. It will then continue the circular interpolation back towards the center of the Main to clear the cutting tool from the thrust face. When the cutterhead is back at the center point (zero positions) of the Main, all motion will stop. The cutterhead will then rapid travel to the left taking the main width and the cutter diameter into account to reach the correct depth on the second thrust face. The same circular interpolation process will then be repeated for the second face. The cutterhead will then retract horizontally to the clearance distance then vertically to the block clearance distance.

When the program is running the “Start Auto Cycle” button will change to “Press to Pause”. If this button is pressed the machine will pause the program right where it is. At this point the screens are locked out from changing anything. The button will the change to “Press to Resume”. If you want to resume press the button and the program will continue from that point on. If you do not wish to continue press the “Stop” button. This will put the machine back in idle mode and changes can be made to the program.

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Contents

Maintenance:

Lubrication:

Refer to illustration following these written instructions:

Below are the directions that explain how and where to add oil to the different systems:

⚠ CAUTION Do not overfill any of the lubrication points, serious electrical damage may result.

Outer Spindle:

The Outer Spindle is hard chromed and is supported in tapered, cast iron spindle bushings. The Outer Spindle supports the Inner Spindle, bearings, seals etc… and maintains the boring rigidity.

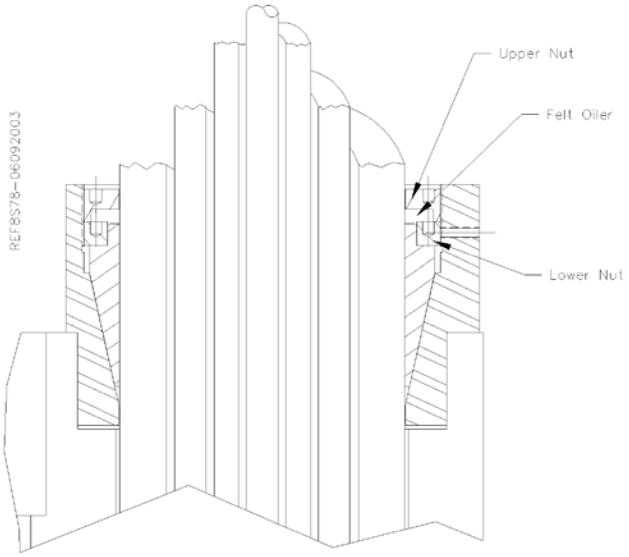
Every 8 hours:

The Outer Spindle needs to be moved down to the lower limit, wiped clean, and then lightly coated with a **light weight #10 oil**. This is very important, if the spindle is allowed to operate dirty the cast iron dust will act as an abrasive on the spindle chrome. This will cause the spindle to wear prematurely. The outer spindle is a very expensive item to replace.

Every 1000 Hours:

Open the sheet metal cover from the front of the spindle unit. There is a large nut where the outer spindle passes through the top of the spindle base. Using a spanner wrench or punch carefully remove the top spindle nut.

Note: Do not adjust the nut below the felt wiper (see the mechanical section for correct adjustment of this nut).



Slide the felt wiper back into place and tighten the Upper Nut back down.

Upper Belt Housing:

No lubrication is necessary in the Upper Belt Housing.

Oil Reservoir System:

IMPORTANT!! – Every 8 hours check the oil supply lines to the upper spindle to be sure they are full of oil.

The oil reservoir system is located inside the lower portion of the column. This system lubricates the following:

Ways
Inner Spindle Bearings (Upper and Lower)
Horizontal Ballscrew
Outer Spindle

Every 175 Hours:

The oil level of the reservoir should be checked, and filled with **a light weight #10 spindle oil**.

When the oil reservoir is low or empty on the F109 machine, the control will "LOW OIL" and will not run until the reservoir has been filled.

The oil system may require priming if the reservoir has been run empty. You can do this manually or automatically. To prime automatically, change the oiler machine parameter #123 to a value of 10. This will turn the oiler solenoid on every ten seconds as long as the spindle is running. Take note when the oil lines are full, reset the oiler parameter and operate the machine normally. To prime manually, open the air door on the lower left hand side of the column, locate the blue solenoid, press the manual override button on the solenoid repeatedly until the oil lines are full. You need to pause for a second between button presses to allow the valve to reset. Pressing the button too fast will not pump oil through the system.

Inner Spindle Bearings:

The Inner Spindle Bearings are lubricated from the oil reservoir system. It is normal for a small amount of this oil to seep through the spindle bearings and onto the cutterhead.

Vertical Ballscrew Bearings:

The Upper Pillow Block bearing is located on the top plate just below the driven sprocket. The lower bearing set is located at the bottom of the ballscrew in the spindle base.

Every 175 Hours:

These bearings should be greased with **Unoba EP 2 Multi Purpose Grease or equivalent NLGI 2 grease.**

Column Feed Gear Housing:

The Column Feed Gear Housing is located inside the main column. Remove the two lower inspection plates from the right hand side of the column. Located the gear housing towards the bottom (the ballscrew goes through it).

Every 1000 Hours:

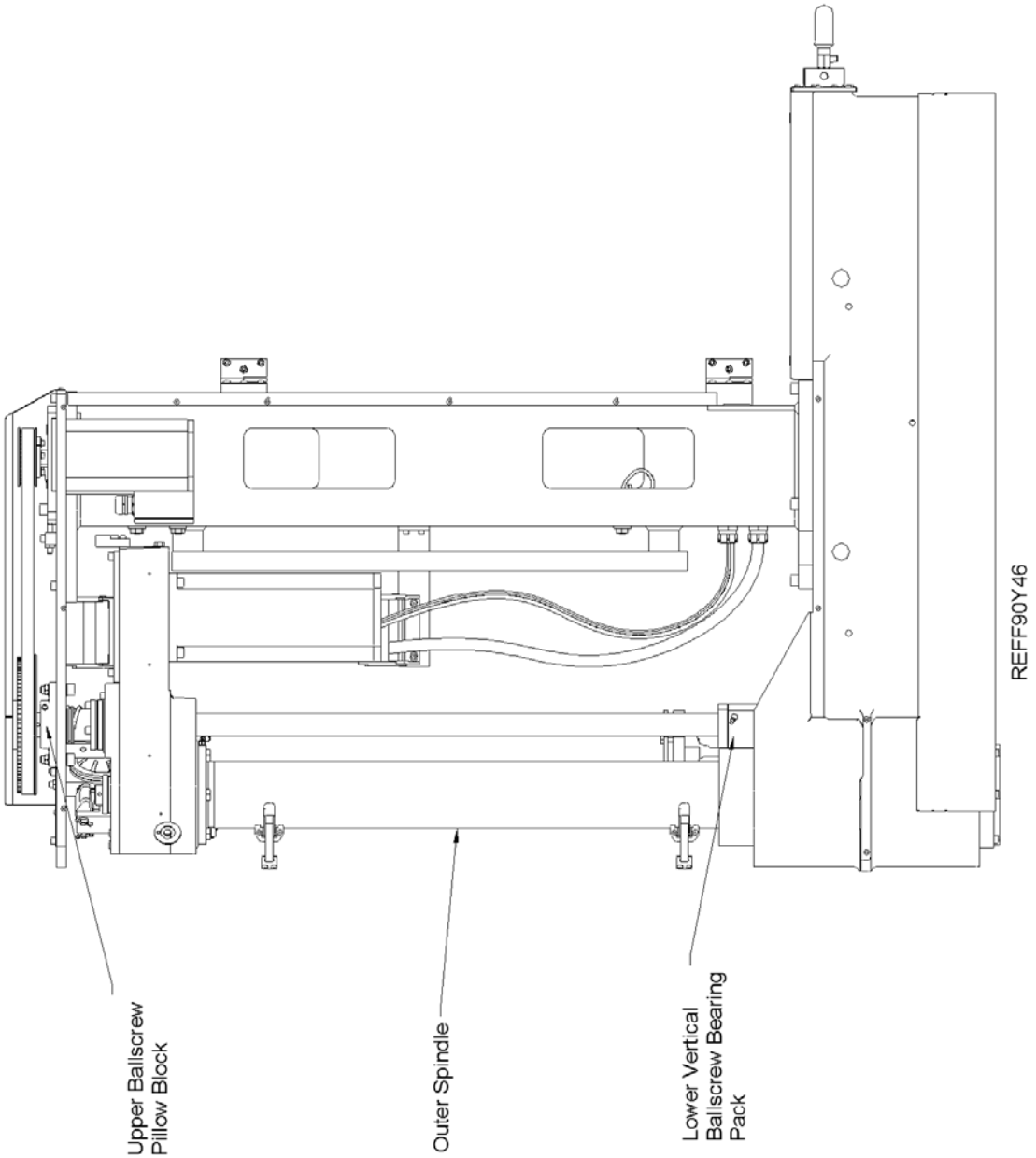
Check and fill the gear housing with **76 MP Gear Lube 80w-90 (ISO VG-100-150)**. Locate the fill hole on top of the gear housing. Locate the level check hole on the side of the gear. Fill only to the level of the Check hole.

Note: If gear housing is over filled serious electrical damage may occur to the Horizontal Servo Motor.

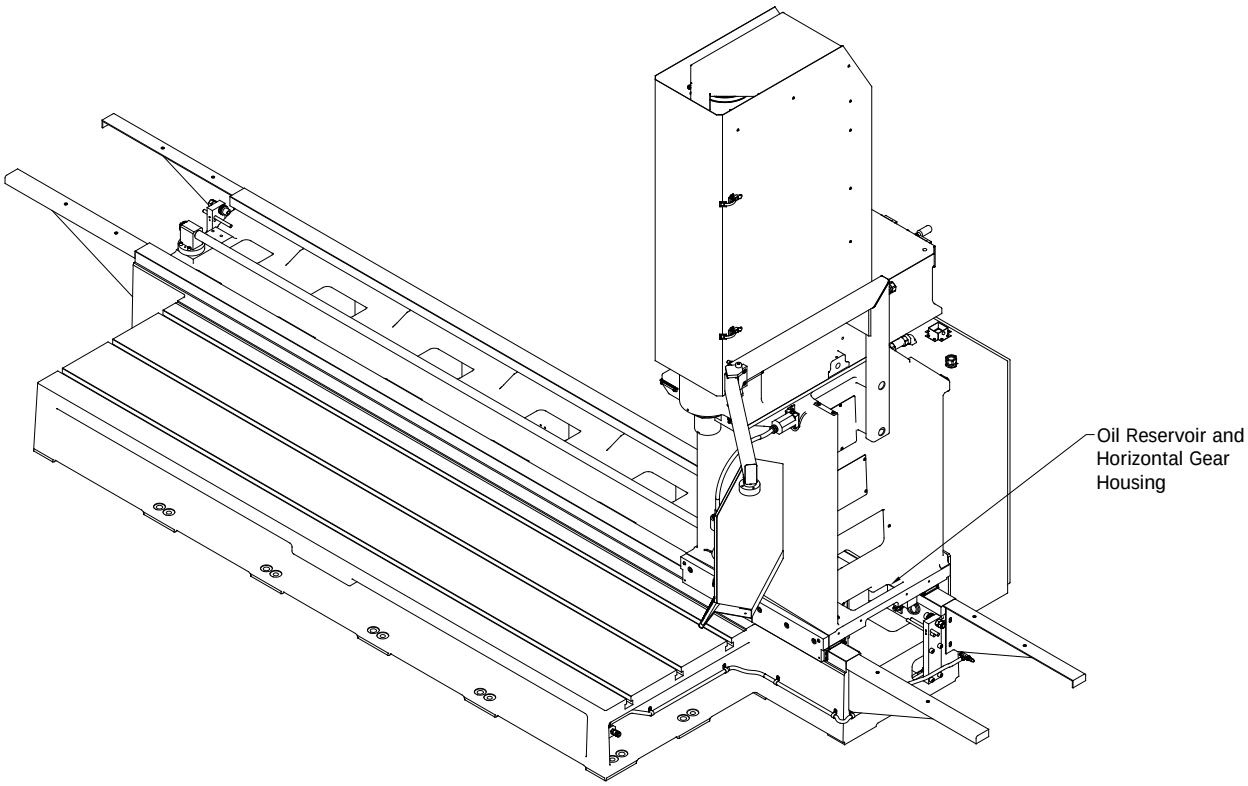
Quick Reference Lubrication Chart:

Assembly	Frequency	Lube Operation
Outer Spindle	8 Hours	Wipe with oil
	1000 Hours	Soak felt wiper with oil
Oil Reservoir System	8 Hours	Check upper oil lines are full
	175 Hours	Fill reservoir with oil if needed
Pillow Block Bearings	175 Hours	Grease
Vertical Ballscrew Bearings	175 Hours	Grease
Swing Arm Hinge	1000 Hours	Grease
Column Feed Gear Housing	1000 Hours	Fill with oil

Lubrication1:



Lubrication2:



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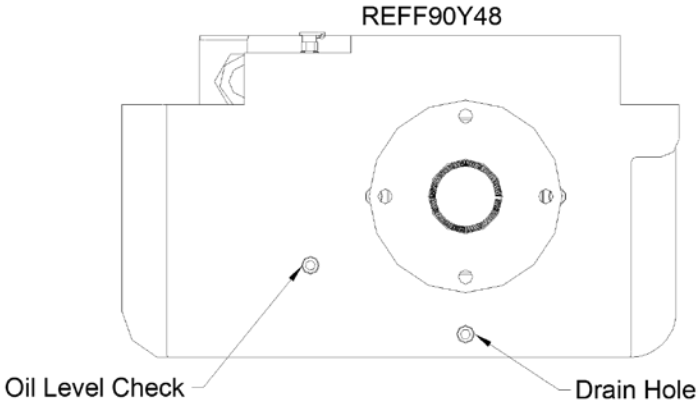
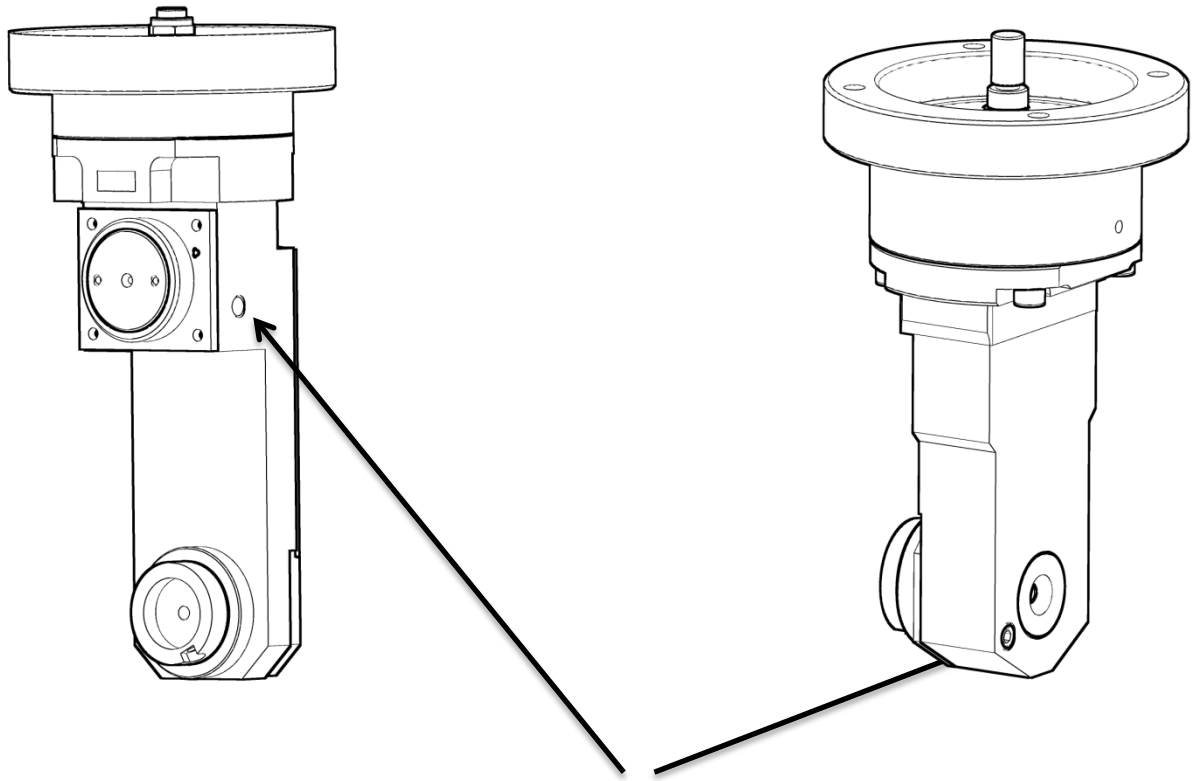


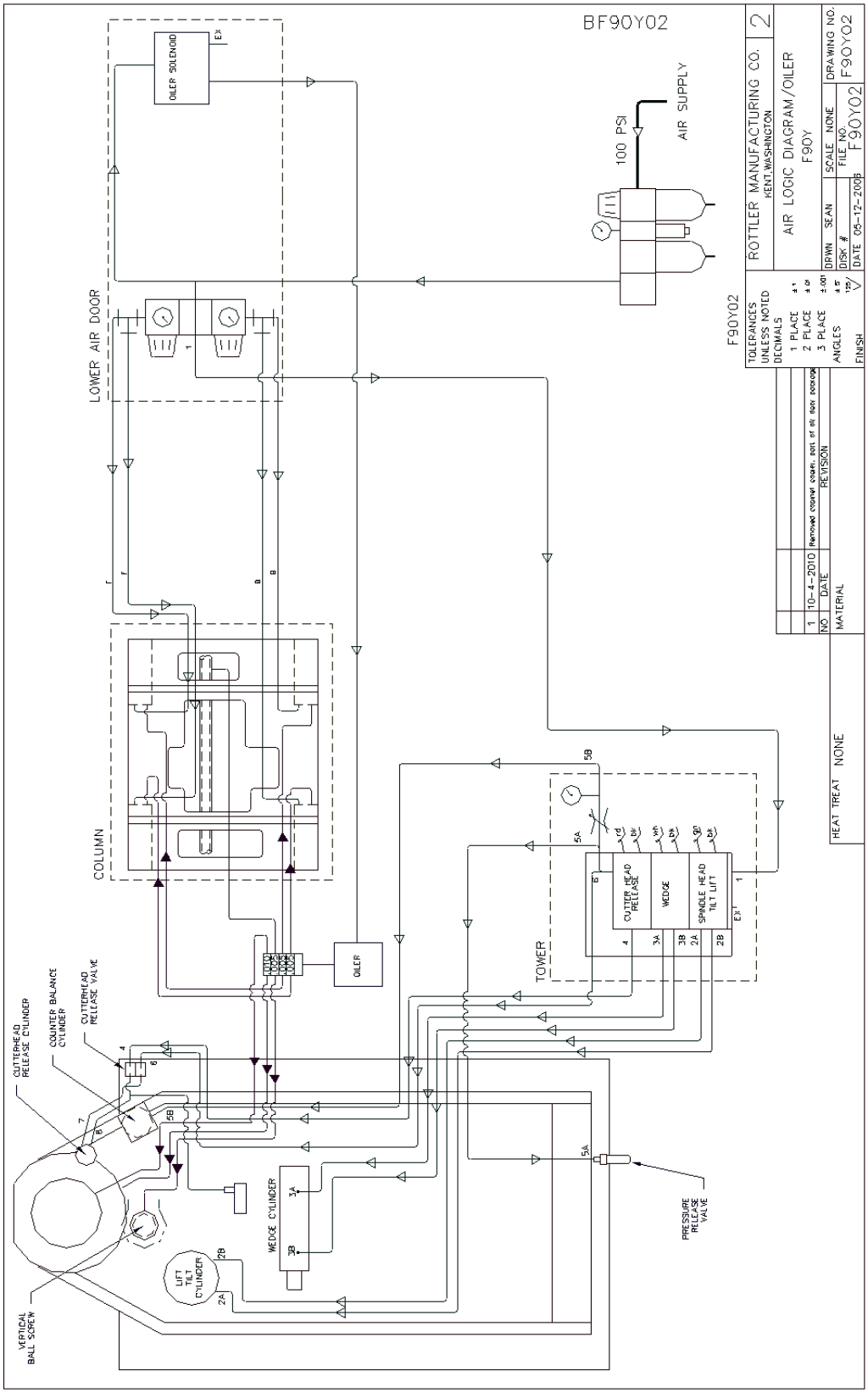
Right Angle Drive Lubrication Information.

All right angle drives require lubrication at the point where the pinion drive intersects with the drive gear. This is generally in the area where the cutterhead is attached, except for the units that have belt drive. There will be a small pipe plug that is removed to check oil level and add oil if needed. See illustration below for general locations.
With the drive mounted on the machine spindle the oil level should be even with the bottom of the pipe plug threads.
All Rottler Right Angle Drives are filled with Union 76 Turbine Oil 68 prior to shipment. Use this or an equivalent ISO VG68 oil if the need to add or change oil arises.
When adding oil, fill until oil starts to run out of fill hole. Allow excess oil to drain, then coat pipe plug threads with anti-seize compound and replace it.

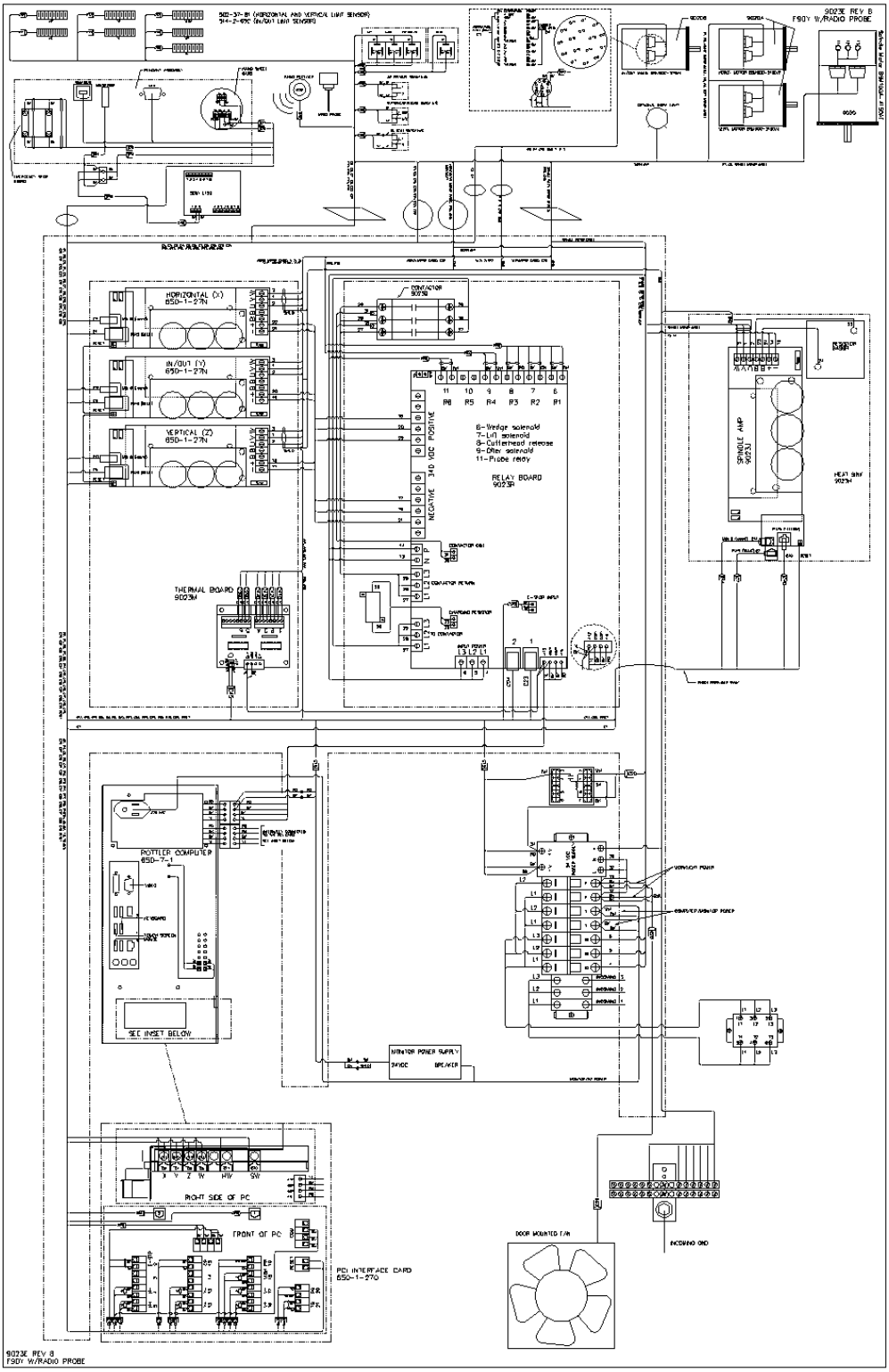


Typical pipe plug locations

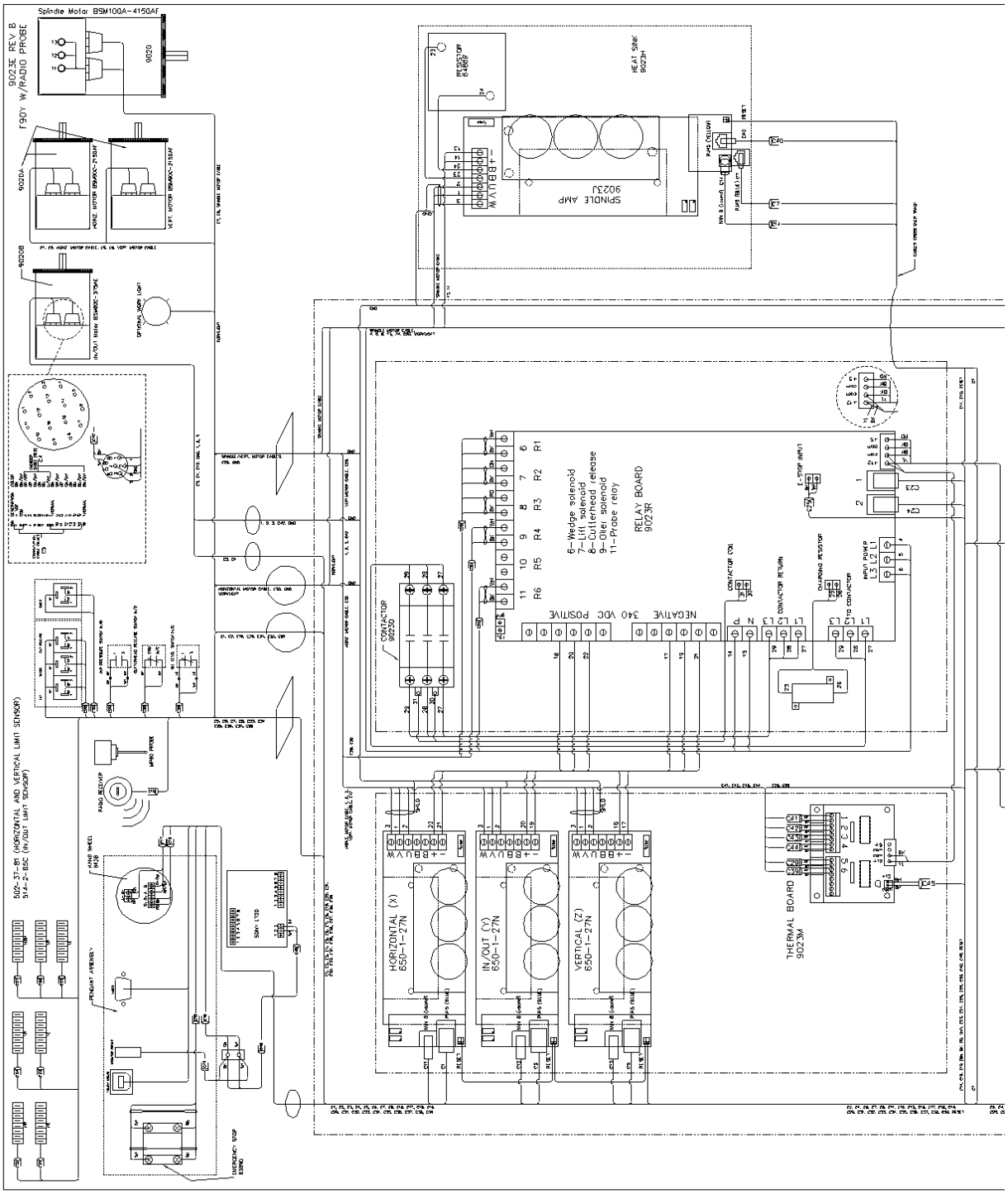
Air Logic:


BF90Y02
OILER SOLENOID
100 PSI
AIR SUPPLY
LOWER AIR DOOR
COLUMN
TOWER
OILER
CUTTER HEAD RELEASE
WEDGE
SPINDLE HEAD TILT LIFT
CUTTERHEAD RELEASE CYLINDER
COUNTER BALANCE CYLINDER
CUTTERHEAD RELEASE VALVE
WEDGE CYLINDER
LIFT TILT CYLINDER
PRESSURE RELEASE VALVE
VERTICAL BALL SCREW
ROTTLER MANUFACTURING CO.
KENT, WASHINGTON
AIR LOGIC DIAGRAM/OILER
F90Y
DRAWING NO. F90Y02
FILE NO. F90Y02
SCALE NONE
DRWN SEAN
DISK #
DATE 08-12-2008
TOLERANCES UNLESS NOTED
DECIMALS
1 PLACE ±.1
2 PLACE ±.01
3 PLACE ±.001
ANGLES ±.5°
FINISH 125
HEAT TREAT NONE
MATERIAL
NO DATE REVISION
1 10-4-2010 Removed channel cover, rout at air box access

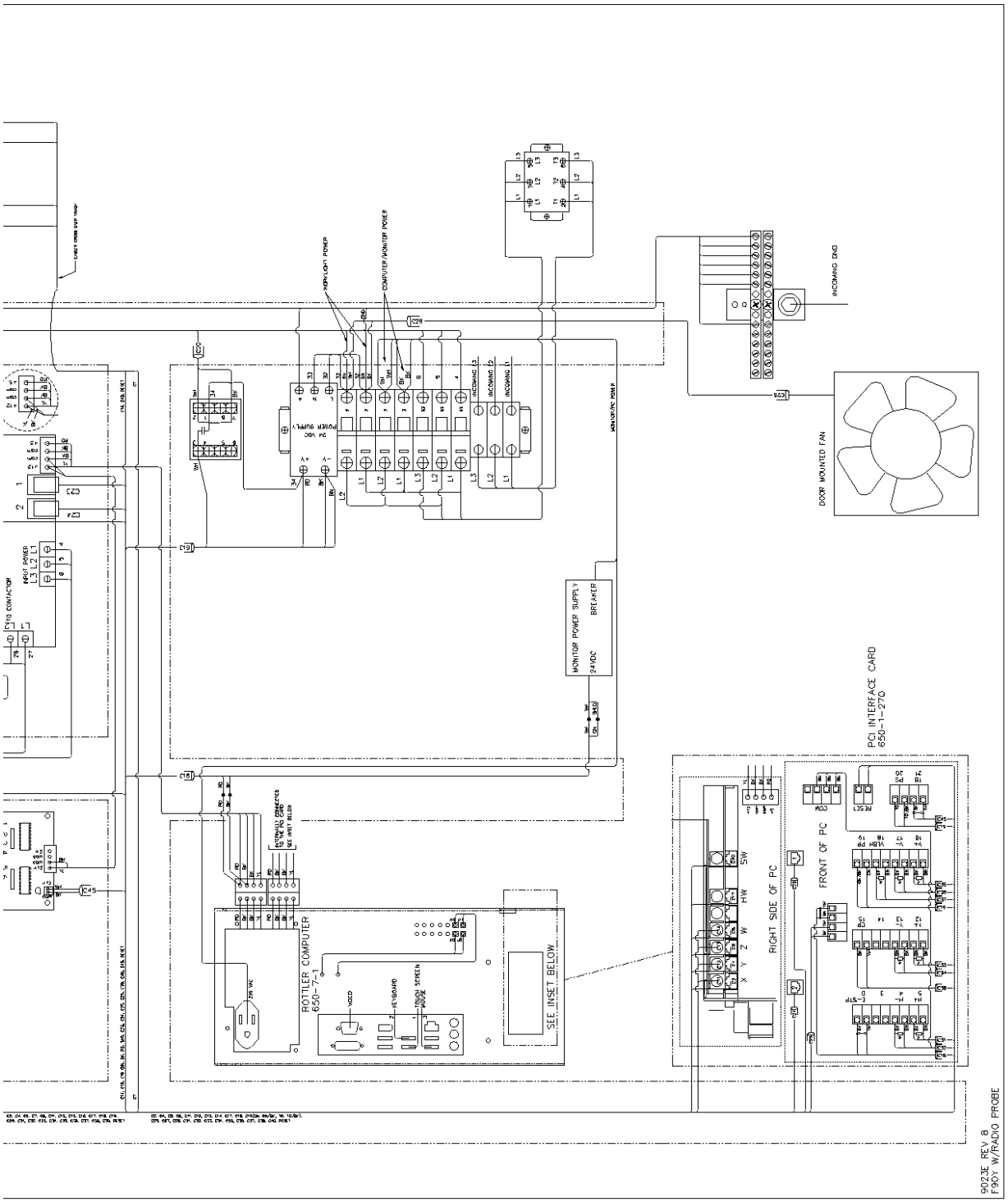
F109 Wiring Diagram 9023E Radio Probe:



F109 Wiring Diagram 9023E Continued:



F109 Wiring Diagram 9023E Continued:



502-12-7B Sony LT20 Set Up Instructions:

A standard initialization is carried out at the time of shipment, however it is possible to make the following selections depending on the intended use. Details of the settings at the time of shipment are given in each section.

Changing between Inches and mm:

Turn on the power while holding down the “RESET A” button and press the “MODE” key/ Press the Up arrow to change between inches/mm. Press the “SET” button to set and return to the measuring state.
This device was set to mm st the time of shipment from Sony.
To change the initial settings… Press and hold the “SET” key and “MODE” key for approximately 2 seconds.

Basic Operation:
“MODE” – To the next item.
“UP ARROW” – Select the item.
“SET” – Set Item.

Note: Even if you select and item with the “UP ARROW” key, no changes will be made until you press the “SET” key.

Note: Once the initial setting modes had been entered it is not possible to return to the measuring state partway through. Press the “MODE” key repeatedly to skip items.

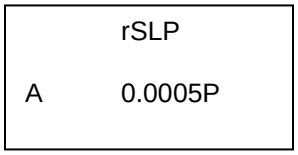
Basic Settings:
Setting the display (2 channel Models).

One of the following may be chosen: A and B or Only A+B.

Setting the input signal resolution (channel A)

One of 0.0005, 0.001, 0.005 or 0.01 mm can be chosen.

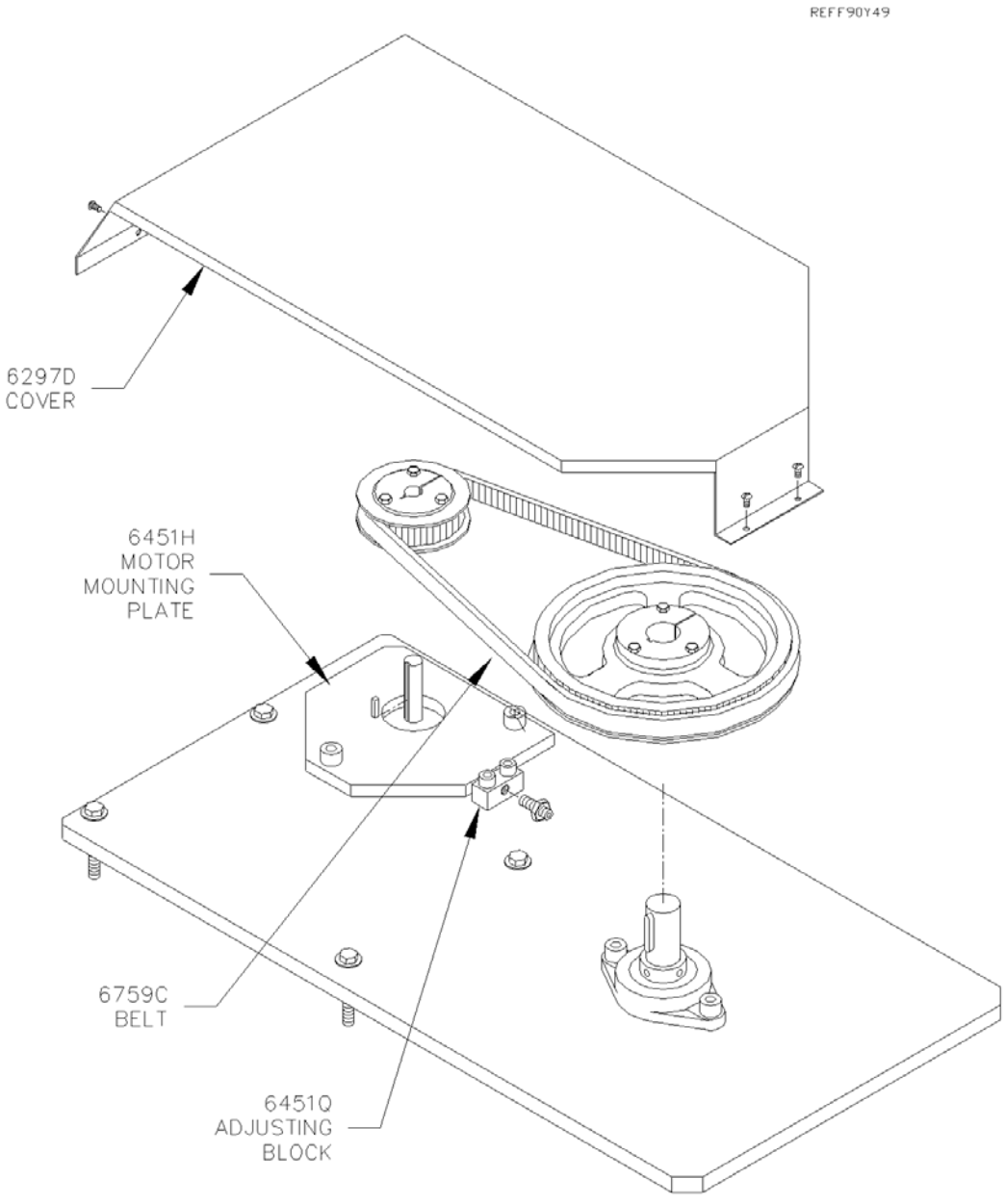
Set the resolution to match the resolution of the connected measuring probe.



Vertical Servo Drive Belt Replacement / Adjustment:

⚠ CAUTION Turn off all power to machine before attempting to adjust or replace belt. Serious injury may result.

The Vertical servo drive belt is located on top of the Spindle Unit.
Remove the four screws holding the top cover down. Remove top cover.
Loosen the two bolts securing the motor mounting plate and the tensioning set screw. Slide the motor mounting plate to loosen. Replace belt is needed.
Adjust servo motor mounting plate, using the tensioning set screw so the belt will deflect 5/16" when a force of 2 to 4 pounds is applied midway between the pulleys.
Fully tighten the two bolts mounting the plate.
Replace the cover on the top plate.



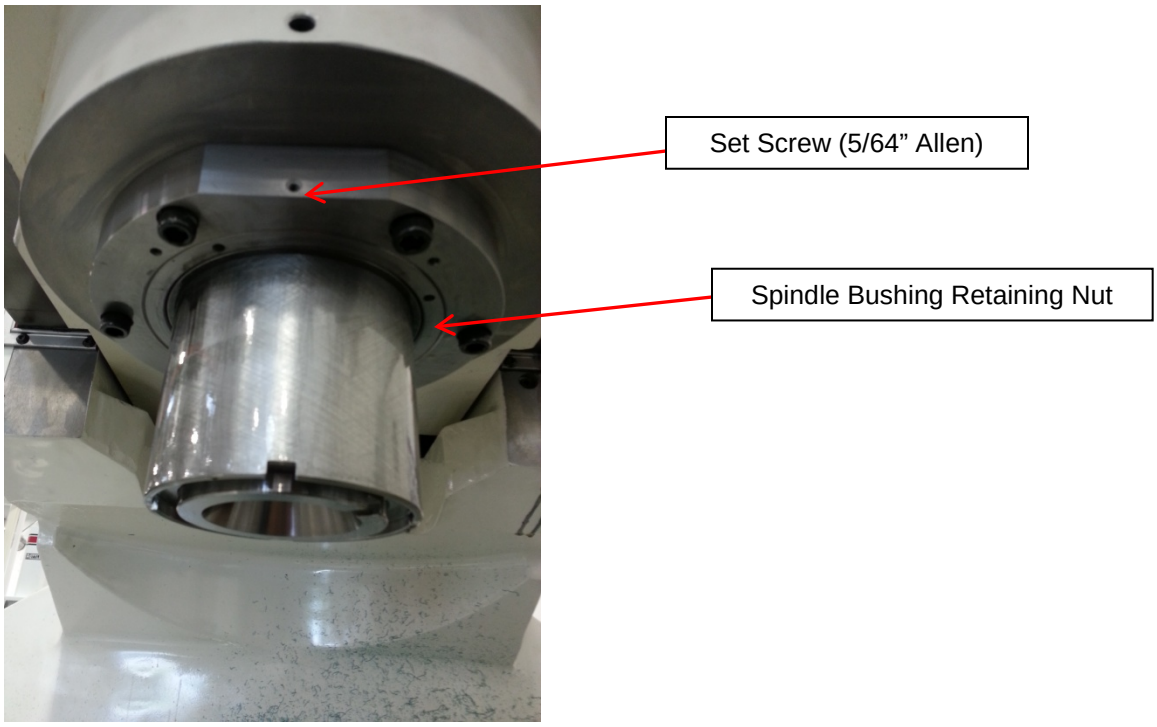
Outer Spindle Bushing Adjustment:

The Lower Spindle Bushing will be adjusted in this demonstration.

1) Start the Rottler Software.
2) Move the spindle to its full downward position.

Retainer – O-Ring and felt are underneath

3) Loosen the four 10-24 bolts in the Retainer and pull out the O-Ring and Felt.
4) Loosen set screw at top of Bushing Carrier.
5) Take a punch and tighten Lower Bushing Nut with palm of hand. **Raise** spindle 5" and repeat. This helps set the bushing in the bushing carrier.
   (WARNING: Do not tighten Spindle bushing retaining nut when spindle is at the top 3" of travel. Excessive wear and premature failure could result.)



6) Once the Retaining Nut will not tighten any more, a couple soft taps with a punch and a hammer to tighten it is all that is necessary to finish procedure.
7) Re-Install Felt, O-Ring, then Retainer in that order. Tighten down (4) 10-24 bolts.
8) Tighten Set Screw in Bushing Carrier.

Upper Bushing Adjustment

9) Be sure Spindle is at its home position (full upward position).
10) Repeat steps 3 and 4.
11) Take a punch and tighten Lower Bushing Nut with palm of hand. This time **Lower** spindle 5” and repeat.
(WARNING: Do not tighten Spindle bushing retaining nut when spindle is at the top 3” of travel. Excessive wear and premature failure could result.)
12) Once the Retaining Nut will not tighten any more, a couple soft taps with a punch and a hammer to tighten it is all that is necessary to finish procedure.
13) Re-Install Felt, O-Ring, then Retainer in that order. Tighten down (4) 10-24 bolts.
14) Tighten Set Screw in Bushing Carrier.

Note: It is recommended to sweep in your spindle after this maintenance procedure.

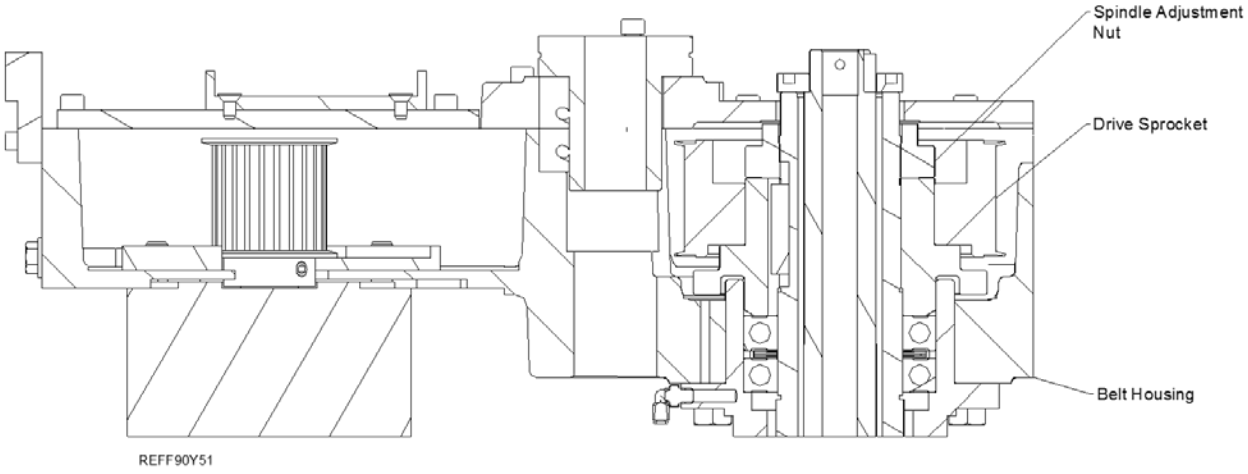
Inner Spindle Adjustment:

This adjustment should be made if you getting chatter or out of round bores.

Open the main spindle base door.
Install the surfacing cutterhead or a boring cutterhead with a long tool holder installed into the machine.
Locate the opening on the belt housing. This is located at the top of the outer spindle. Inside is the inner spindle adjustment nut (6091A). The adjustment nut has hole drilled in it along it's perimeter to allow for an adjustment rod.
Insert the adjustment rod into one of the holes in the adjustment nut.
Rotate the head 1 turn Clockwise looking from the top, letting the adjustment rod move up against the end of the slot in the belt housing. This will loosen the inner spindle adjustment.
Now carefully turn the cutterhead Counter Clockwise looking from the top. The cutterhead will turn easily and you should be able to feel the spring loaded ball detent in the nut. At some point the torque required to turn the cutterhead will sharply increase, immediately stop turning the cutterhead. This indicates that the Belleville washers have collapsed and the bearing is bottomed out.

IMPORTANT: DO NOT OVER TIGHTEN, SEVERE BEARING DAMAGE WILL OCCUR AND REPLACEMENT WILL BE NECESSARY.

Now turn the cutterhead Clockwise of detent.
Remove the adjustment rod, the inner spindle is now properly adjusted.



F109 Upper Housing Disassembly:

Travel the machine to the right Home position.
Remove the spindle base door and right side cover.
Place a board across the spindle base directly below the spindle motor (6790K or 6790U). Lower the spindle until the motor just touches the board.

⚠ CAUTION Disconnect all power and air to the machine before continuing, severe bodily injury may occur.

Remove the four (4) bolts securing the motor the belt housing. Remove the two (2) bolts that secure the cable carrier (6314K) to the upper housing. Remove the oil and air lines from the upper housing.

Note: It is not necessary to disconnect the spindle motor wiring.

Rotate the vertical ballscrew by hand until it is about eight (8) inches from the top plate.
Place a board, of proper length, between the bottom of the upper housing and the top of the spindle base to prevent it from falling.
Remove the two bolts that secure the centering gear housing (6168H) to the belt housing. Work the centering housing up off the centering shaft. Tie it up to the top plate.

IMPORTANT!!: Do not attempt to move the vertical under power when the centering housing is not bolted to the belt housing or the upper plate. Severe damage will result to the centering shaft!!

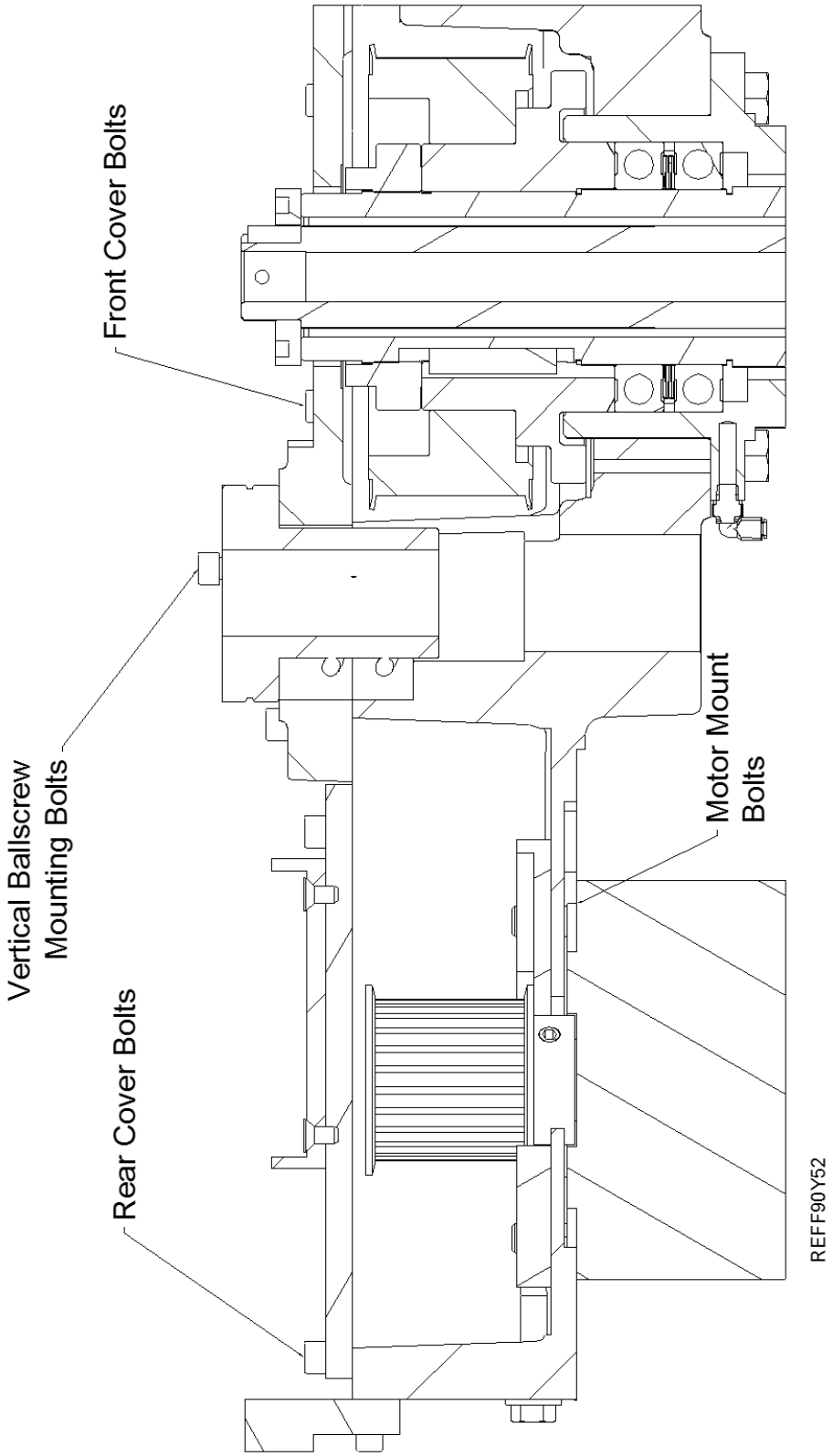
Remove the Clevis Pin (7210B) from the draw bar actuator bracket (6174B). Lift the actuator arm (6173B), move the arm and cylinder off to the side. Remove the air cylinder (6204A), clevis pin (6189A) and mount bracket (6188C) from the side of the belt housing. Remove the two (2) bolts that attach the draw bar actuator bracket (6174B) to the to belt housing cover.
Remove the counter weight cable (6453 F or 6453G) from the upper housing by loosening the lock nut and unscrewing the cable nut.

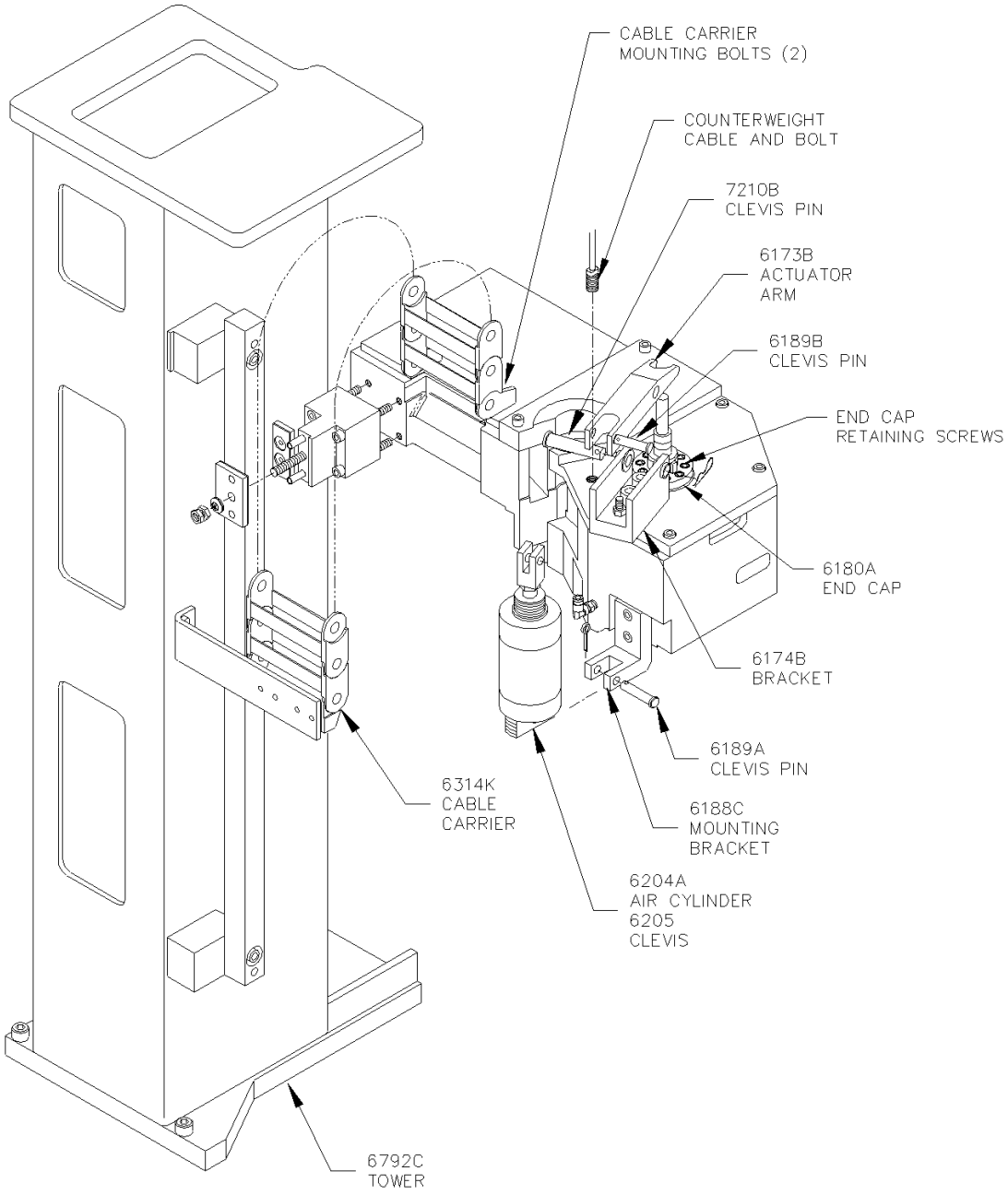
Note: When reassembling, be sure not to thread the cable nut in too far as it may come in contact with the driven pulley.

Remove the eight (8) screws holding the inner spindle end cap (6180A). Unscrew these bolts slowly around the diameter of the end cap as they are under spring pressure from the draw bar. Remove the cap by pulling straight up.

Note: When reinstalling, the end cap must be aligned concentric to the draw bar.

Remove the three (3) screws that secure the vertical ballscrew nut to the belt housing. Holding the nut with one hand, turn the ballscrew with the other to move it up and out of the way so the belt housing lid can be removed.
Remove the bolts securing the belt housing covers. The covers are pinned to the belt housing. Use a soft face mallet to carefully remove the covers.
From this position you can remove and/or replace pulleys and belts.


Front Cover Bolts
Vertical Ballscrew
Mounting Bolts
Motor Mount
Bolts
Rear Cover Bolts
REFF90Y52


CABLE CARRIER
MOUNTING BOLTS (2)
COUNTERWEIGHT
CABLE AND BOLT
7210B
CLEVIS PIN
6173B
ACTUATOR
ARM
6189B
CLEVIS PIN
END CAP
RETAINING SCREWS
6180A
END CAP
6174B
BRACKET
6189A
CLEVIS PIN
6314K
CABLE
CARRIER
6188C
MOUNTING
BRACKET
6204A
AIR CYLINDER
6205
CLEVIS
6792C
TOWER

F109 Inner Spindle Removal:

Prior to following these instruction, perform the steps in Upper Housing Disassembly.

IMPORTANT: When removing bearings, bellevilles and spacers, not the direction they come off for correct reassembly.

The driven pulley and inner spindle adjustment nut must be in place before continuing. Remove the LEFT HAND THREAD throwback ring (6305D) from the bottom of the outer spindle.

Note: If the driven pulley and inner spindle adjustment nut are not in place the inner spindle will be able to fall out of the outer spindle.

While supporting the inner spindle from the bottom, remove the inner spindle adjustment nut and driven pulley from the top.
The inner spindle is now free to be removed from the bottom. This spindle is precision fit into the outer spindle, it may be necessary to tap the top of the inner spindle with a soft face mallet to get the spindle to drop out.

Note: Be sure of the thrust direction of the bearings on reassembly.

Reassemble in the reverse order.

Inner Spindle Angular Contact Bearing Replacement:

Prior to following these instruction, perform the steps in Upper Housing Disassembly and Inner Spindle Removal.

Loosen the three (3) Allen head set screws on the shoelock nut (6116F).
Loosen the shoelock nut and slide off of the top of the spindle.

Note: Be very careful not to damage the threads when sliding nuts, bearings and sleeves off the top of the inner spindle. These are very fine threads used for the inner spindle adjustment nut.

Remove the top bearing by tapping lightly and evenly on both sides of the bearing. After the bearing is moved slightly off of the spacer set (6172E) tap the inner race.

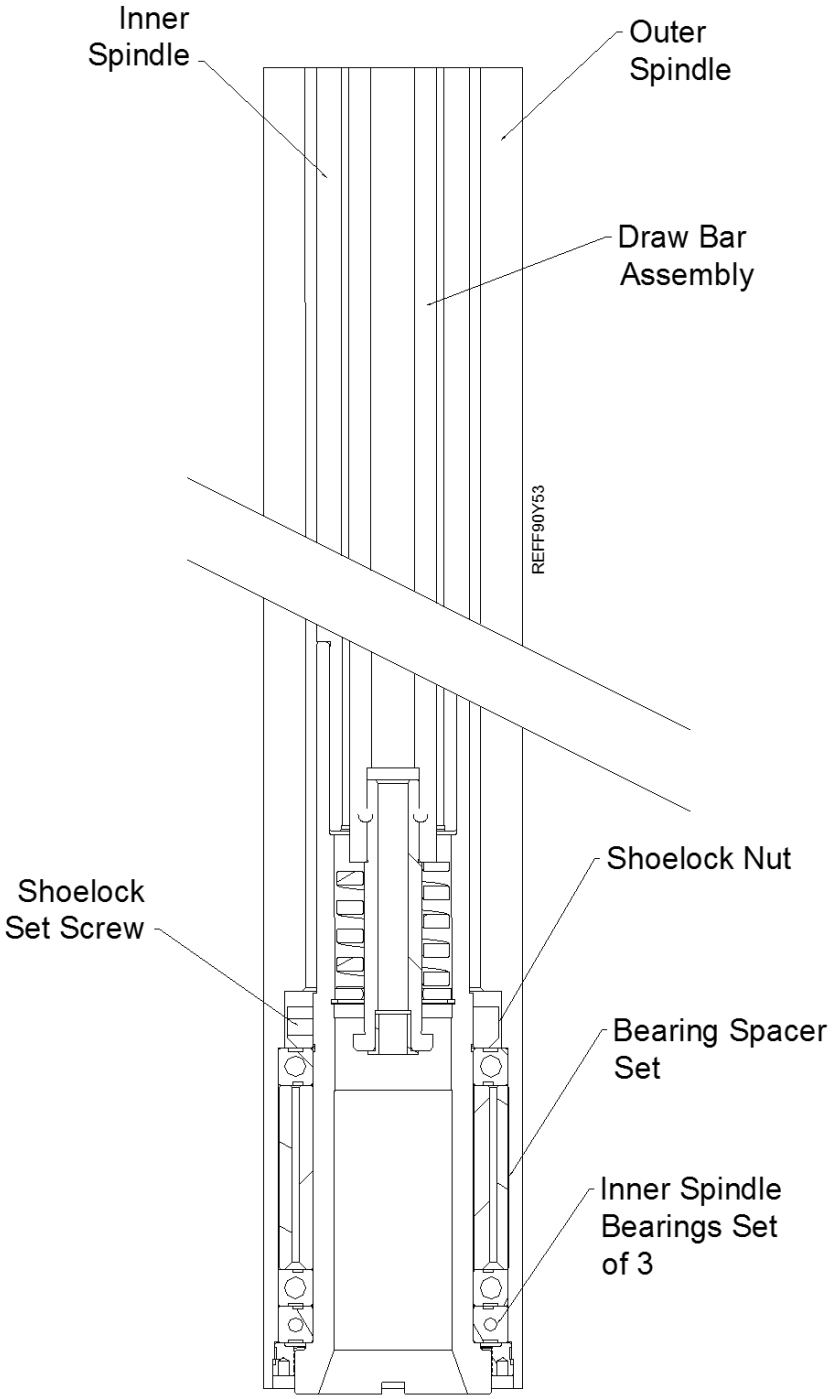
Note: Tapping on the outer race can cause it to roll off of the bearings. Generally after removing the bearings from the inner spindle they are not suitable for re-use.

Remove the spacer set.
Remove the two lower bearings (6116E) set of three (3) the same way as the top bearing.
Stand the spindle on end so that the bearing pack is nearest the floor.
Make sure inner spindle is free of all dirt and debris.
Lightly coat the lower bearing pack area with a light weight #10 oil.

If you have a bearing heater available to you, it is the preferred method of bearing installation. If not, follow the instructions below.

Slide the two (2) lower bearings onto the inner spindle with the correct bearing thrust direction until they stop. Use a small brass punch to lightly tap each side of the bearing on the inner race until both bearings are seated at the bottom of the spindle.
Install the spacer set.

Install the top bearing using the same procedure as the lower bearings until it is seated against the spacer set.
Install the shoelock nut and tighten with a spanner wrench until the inner races of the bearings and spacer set are fully seated together.
Tighten the three (3) set screws on the shoelock nut.
Place the inner spindle in a vise near the bearing pack and lock the vise.
Indicate the bearing set to within .0005” all the way around. Adjust the spacer set by tapping the high side lightly with a brass drift.



Spindle Sweep:

The outer spindle must be swept into the main bed of the machine to achieve accurate bores.

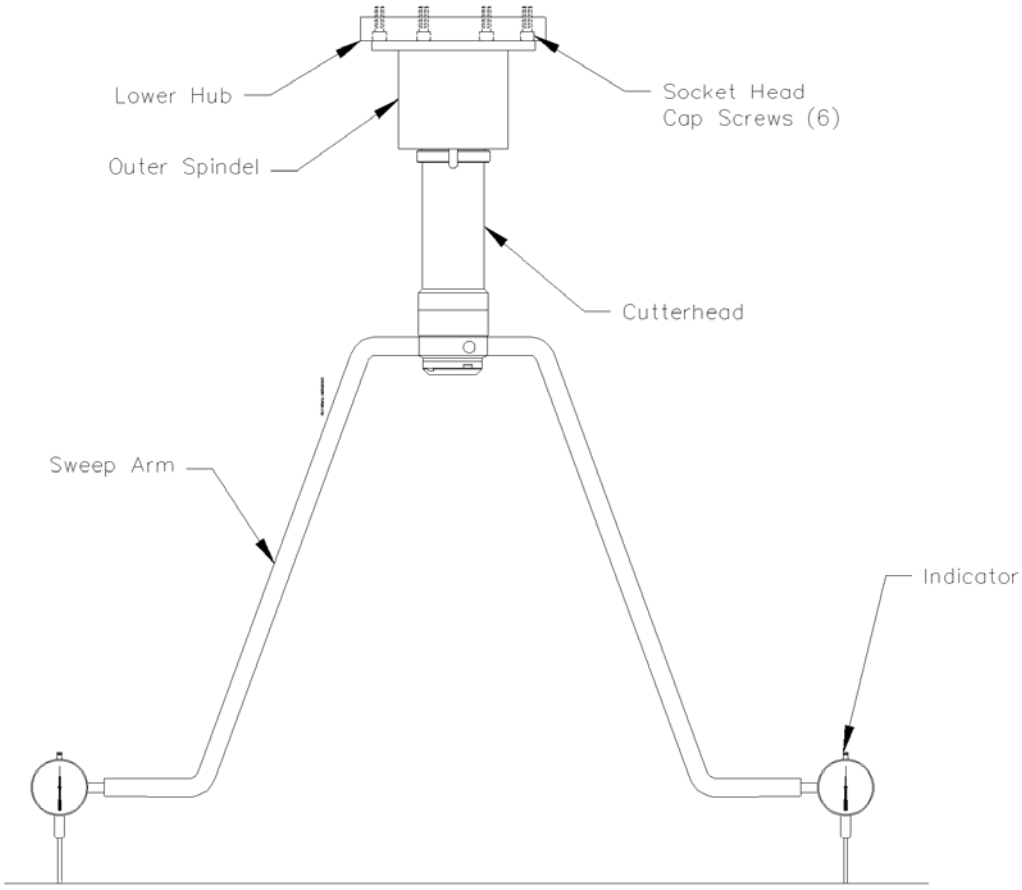
Remove all fixturing from the machine bed, clean and stone if needed.
Install a boring cutterhead into the machine.
Install the sweep are into the cutterhead.
Bring the machine down until you have about .005” pressure on the indicator.

⚠ CAUTION Disconnect all power and air to the machine before continuing, severe bodily injury may occur.

Turn the sweep arm to the 9 O’clock position. Zero the indicator here.
Loosen the 6 socket head cap screws on the lower spindle hub. You do not want them all the way loose, just snug.
Use the three (3) set screws in the spindle base to move the spindle until the indicator reads within .0005” with a full 360 degree sweep of the indicator.

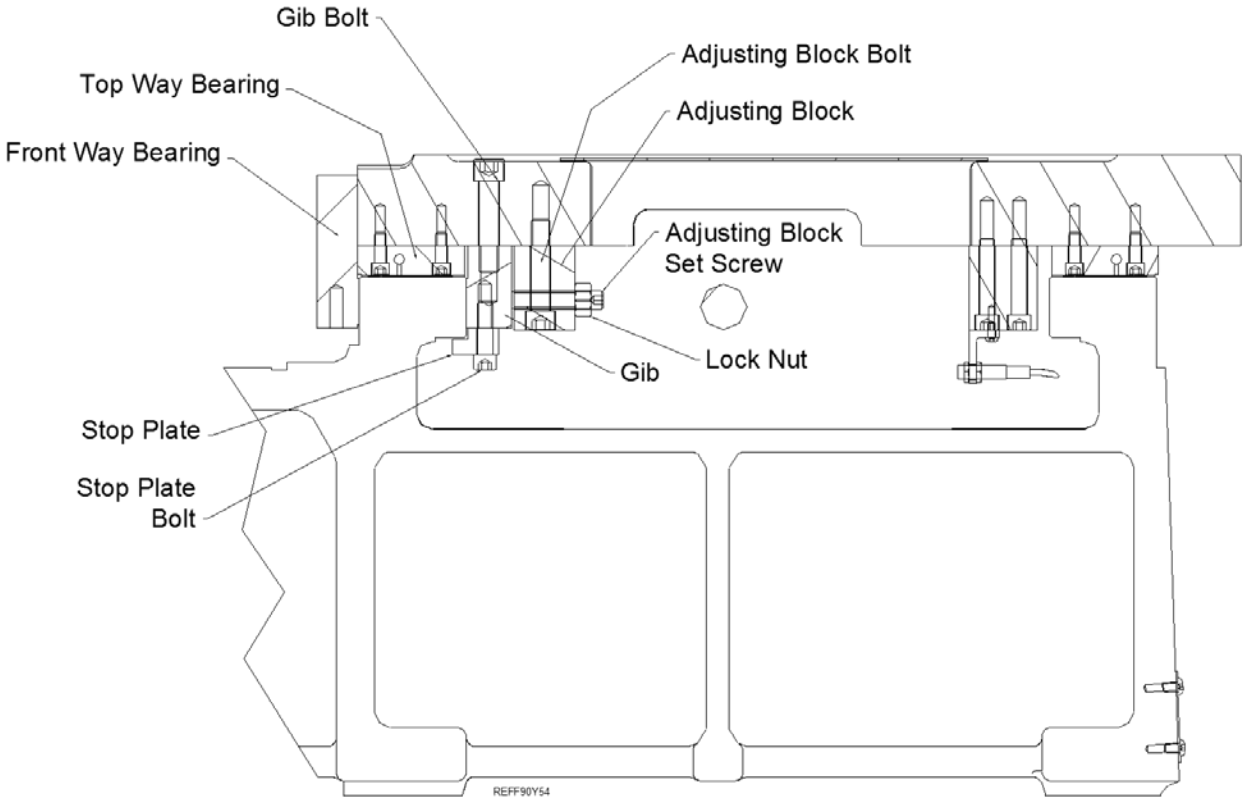
Note: You do not want the right hand side of the spindle to be more positive than the left, it will interfere with the automatic tilt of the machine when in Mill mode.

Once the spindle is swept in tighten the six (6) socket head cap screws and double check that the sweep did not move.



Horizontal Gibs:

The Horizontal gibs are located under the main column, on the back side of the front way. These gibs keep the column from “cocking” when the direction of travel is changed. This adjustment becomes more critical when line boring. If the gibs are too loose the column will turn slightly side ways when traveling. This will cause the alignment of the right angle drive to be off. The cutterhead will then cut heavier on one side of the bore.



To adjust:
Loosen the Gib bolts (two on each side)
Loosen the Lock Nut on the set screw.
Tighten the set screw as much as possible using only the correct size Allen Wrench. This will pull the Front Way bearing up against the front way while pressing the Gib up against the back of the Front Way.
Loosen the Set Screw.
Tighten the set screw up until you can feel it contact the Gib.
Lock the Lock nut.
Run the machine back and forth to let the gibs adjust to adjust in.
Tighten the Gib bolts.

If the machine will not travel full speed or the handwheel movement is erratic the gibs may be too tight. Re-adjust leaving the Set Screw a little bit looser than the previous adjustment.

Another way to check for correct adjustment is to attach a magnetic base dial indicator (.0001 resolution) to the column with the indicator tip contacting the machine way surface.

Now using the handwheel in .010” per click mode, move the column back and forth, about two turns on the handwheel in each direction at a rapid rate.
Note the amount of movement on the dial indicator.
The acceptable amount of movement on the dial indicator is between .0002”-.0005”.
Adjust as necessary. This procedure must be performed at both, the right, and left, sides of the column.

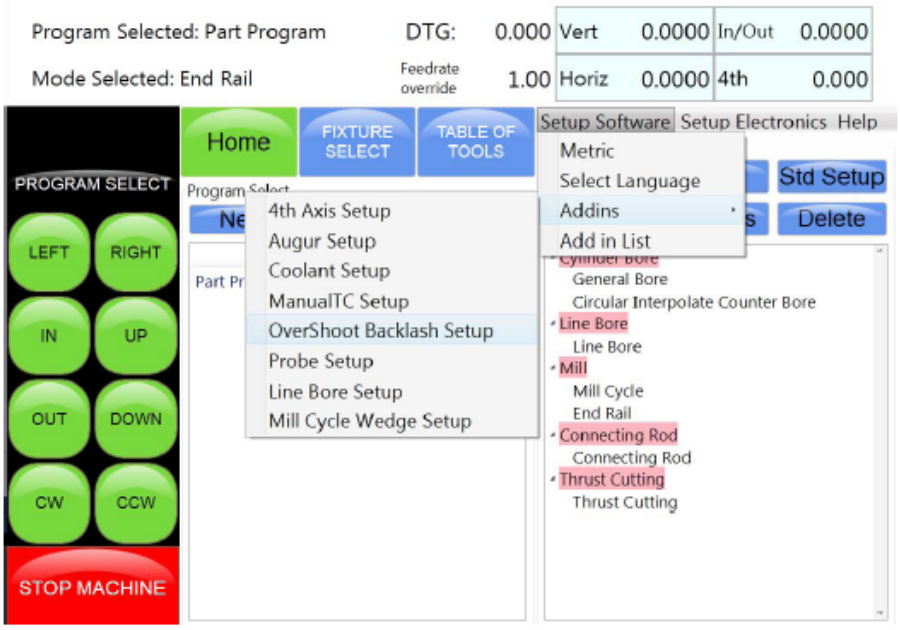
Backlash Setting .NET Software

The Screens depicted below are for setting Backlash compensation values only. DO NOT use any other information on these screens to change information on the machine.

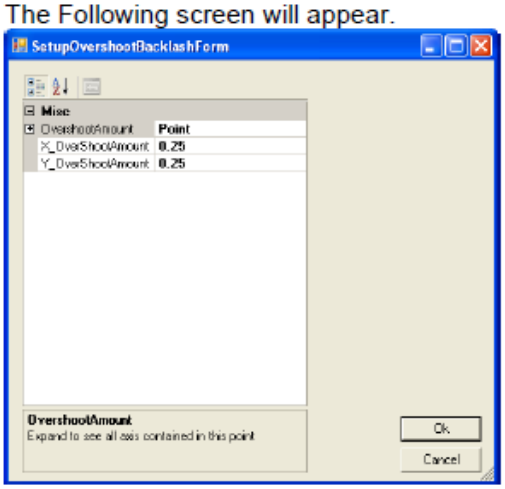
1. Turn off "Overshoot Backlash Setup"

Note: Only the F70-90 and 100 machines use the overshoot feature.

Go to Setup Software>Addins>Overshoot Backlash Setup

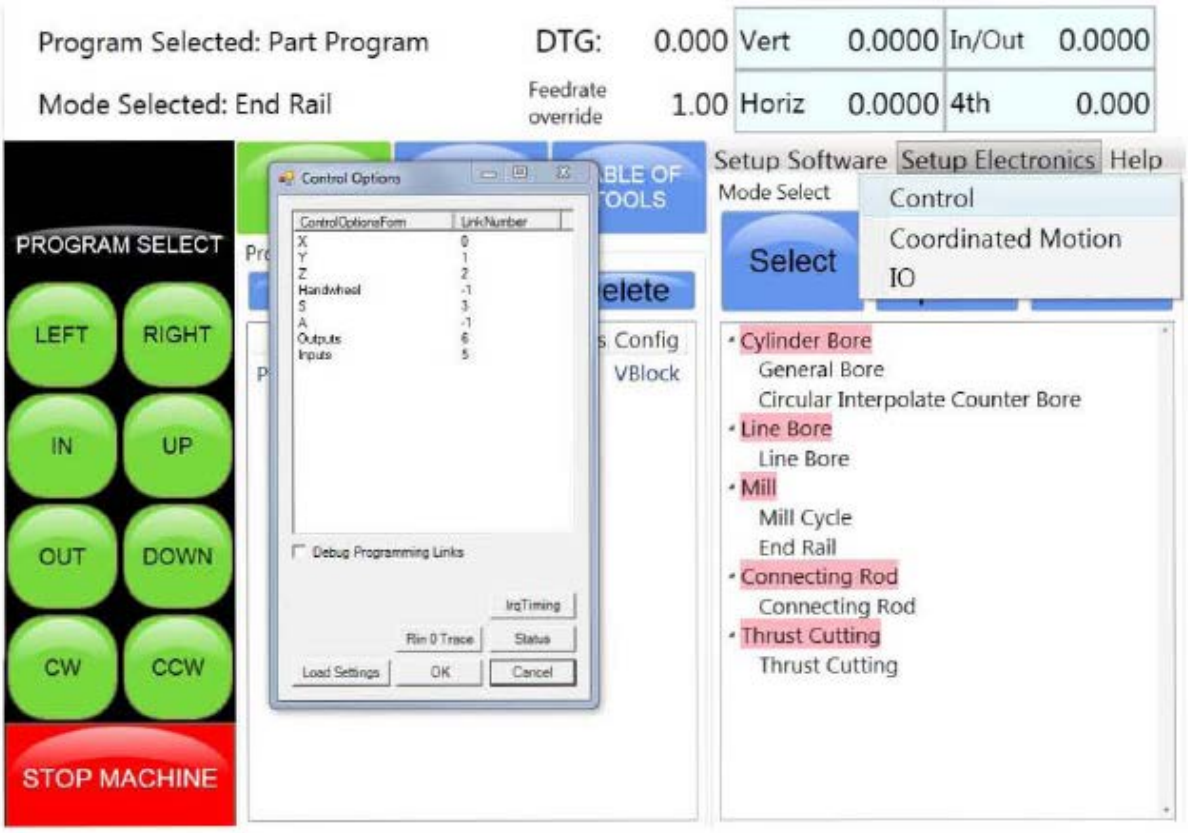


The Following screen will appear.

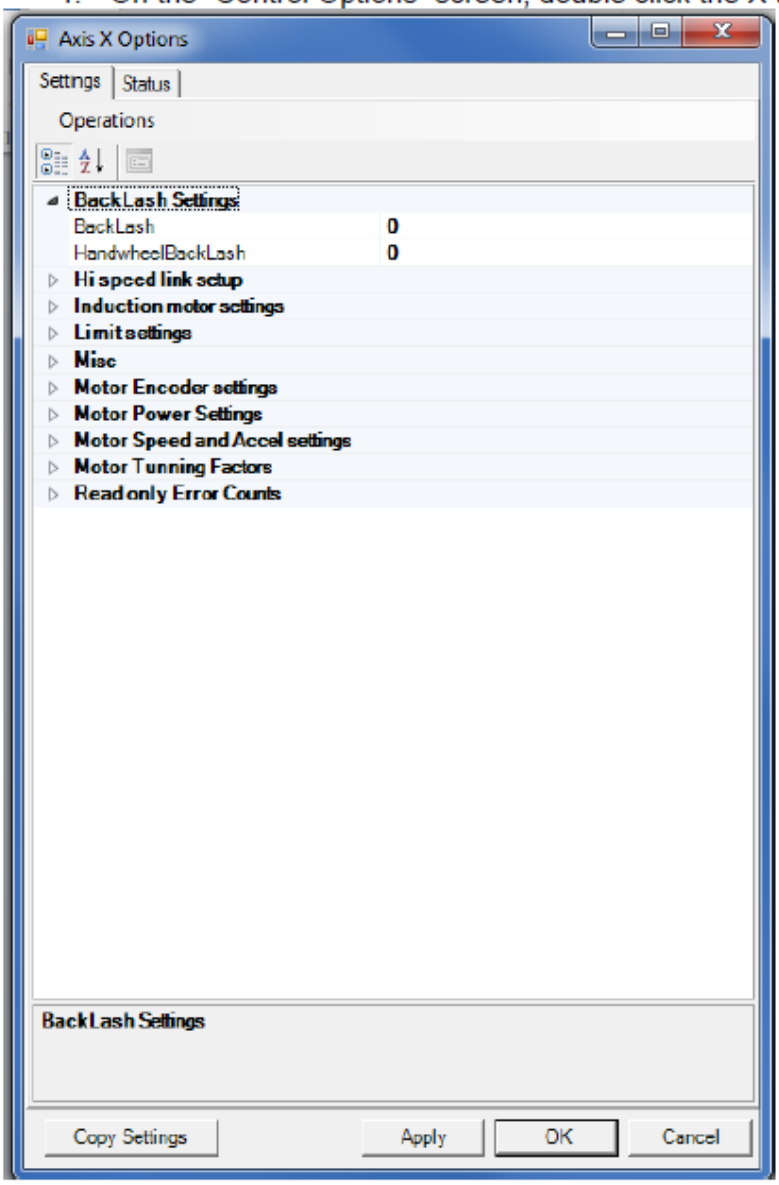


1. Record the existing X and Y "Overshoot Amount". Generally .250
2. Use the "On Screen Keyboard", or plug in the full size keyboard, and change the amounts to 0.00, and click on OK. Close the "Setup" screen.

3. Go to Setup Electronics>Control



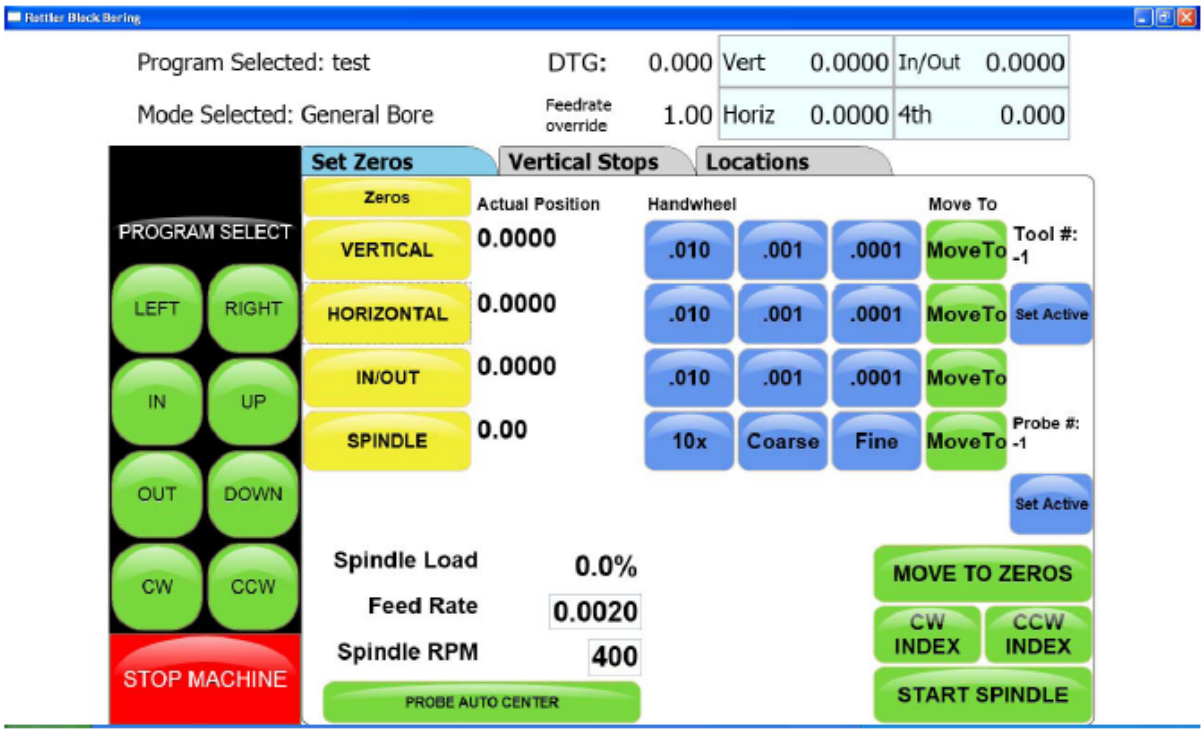
4. On the “Control Options” screen, double click the X to bring up the “X Options” screen.



Now minimize the screen.

5. Repeat step 4 for the Y and Z axis.
6. Close the “Control Options “screen.

7. Select a program (block), then select any cylinder bore mode.



Notes:

******The photos shown are demonstrating the X axis (horizontal) backlash adjustment. The Y and Z axis are adjusted following the same steps.***

******The direction of machine travel to put the initial load on the dial indicator, are as follows:***

X (horizontal), from the right toward the left.

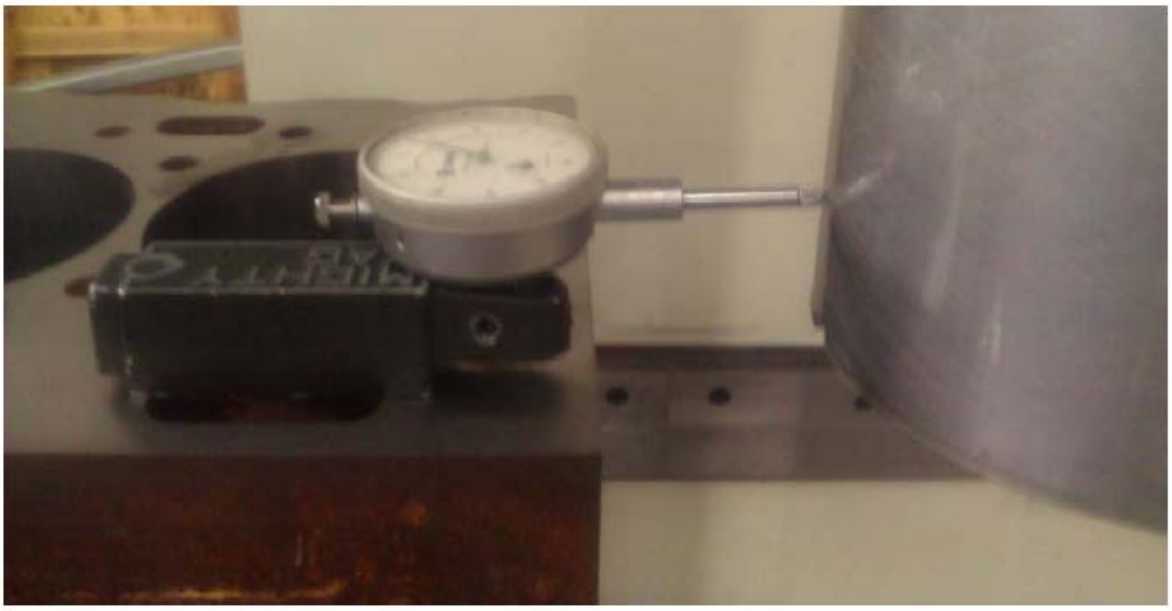
Y (in/out), from back toward the front.

Z (vertical) from top toward the bottom.

A Dial Indicator with 1.0" to 1.5" of travel should be used for several reasons.

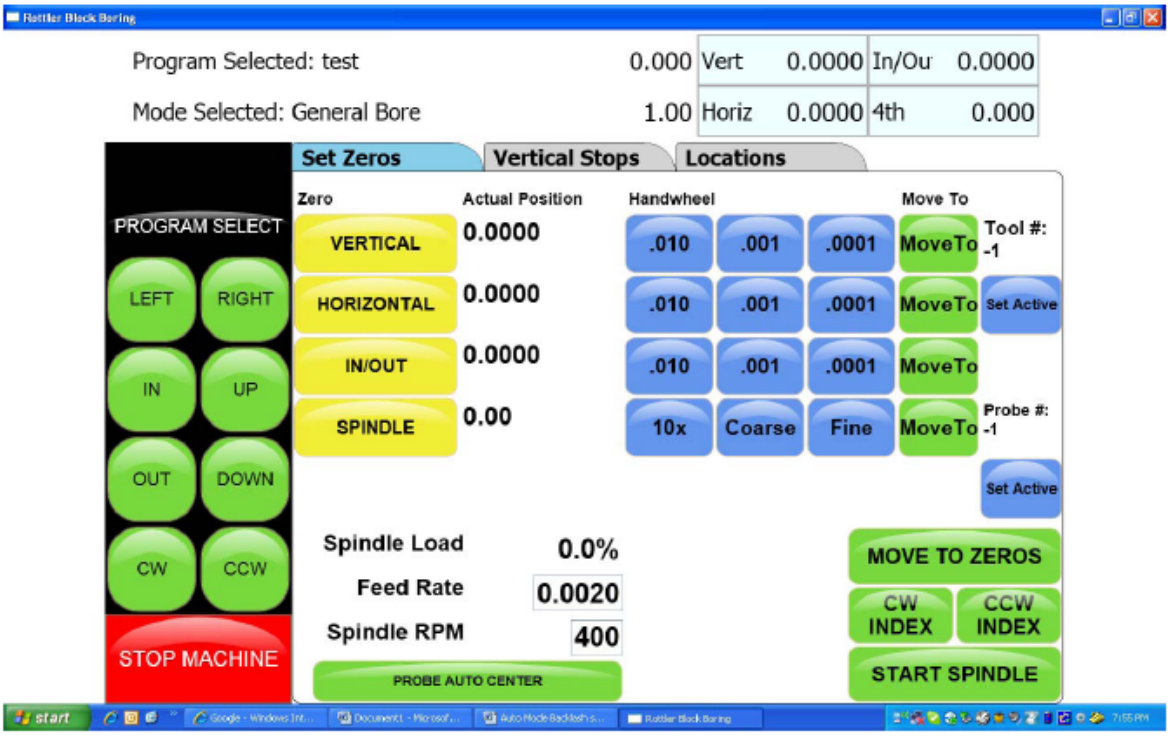
If the axis is overshooting or coming to position slowly you will be able to see it with a dial indicator. With Digital indicator you will only see the end position. The Magnascale indicator should be used to dial or tram in. The automatic moves of the machine can "Shock" the sensitive plunger of the Magnascale.

8. Attach the magnetic base and dial indicator to a stationary stand, parallel, or engine block fixed to the machine bed.



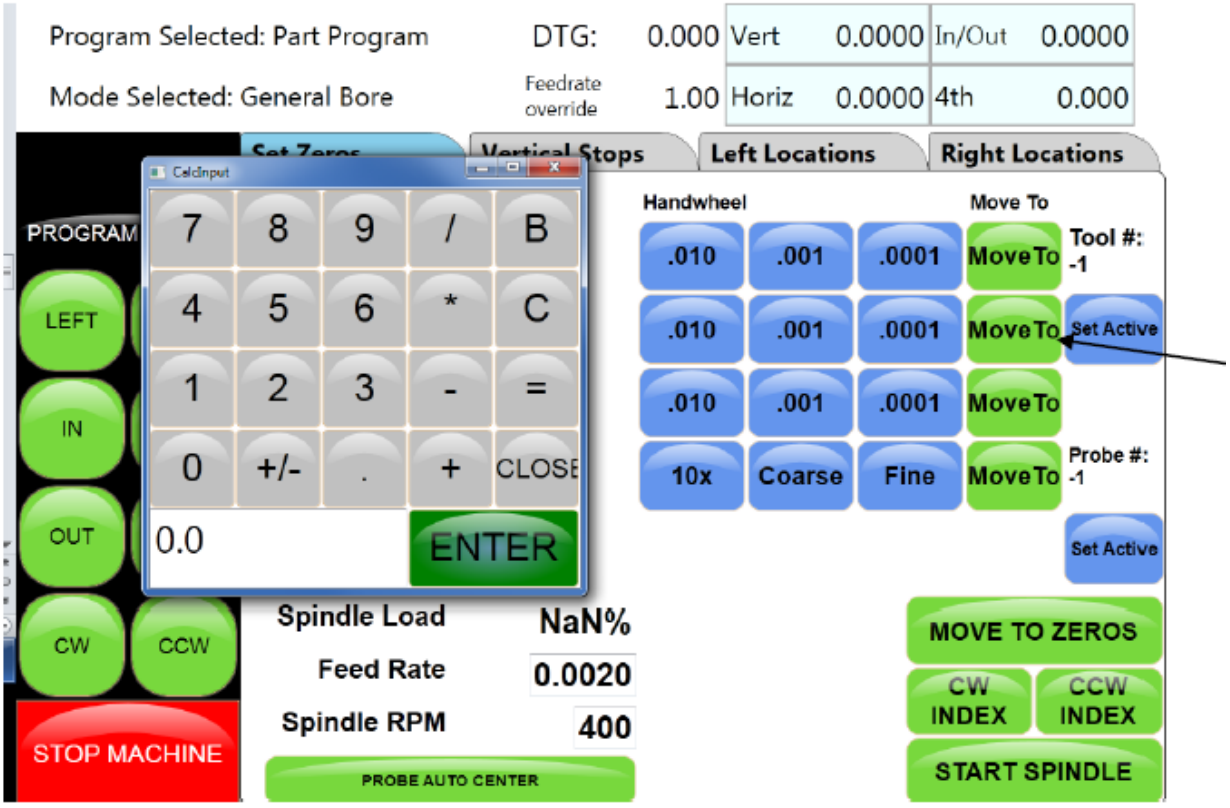
9. Bring the spindle of the machine in position to put a slight load on the Plunger, about .020".

10. Set "Vertical, Horizontal, In/Out" zero.



11. Set all vertical stops to "zero".

12. Move the machine spindle away from the Plunger a few inches, and press "Move to" and then 0 and Enter from the pop up keypad for the axis that is being measured..

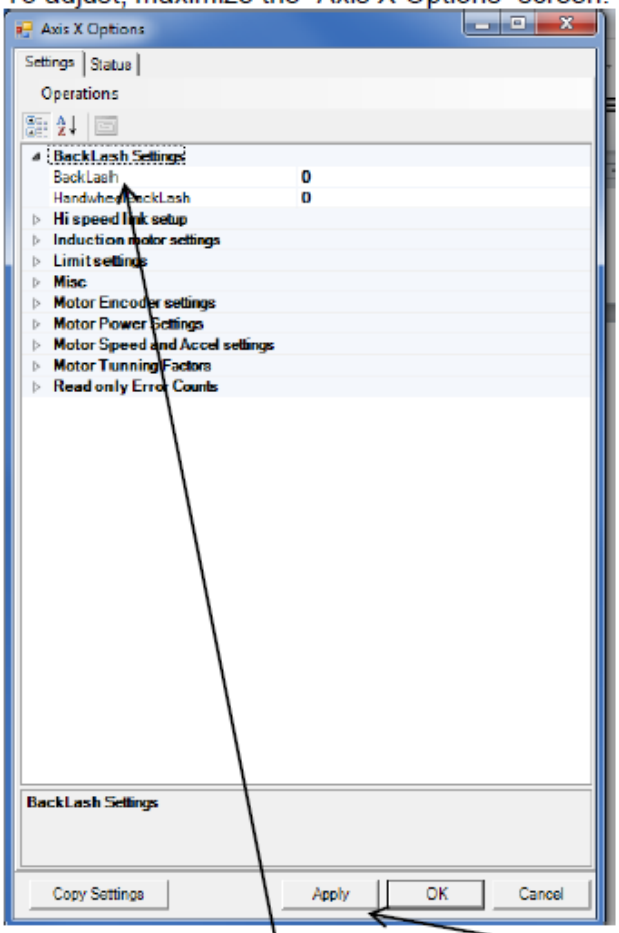


13. Repeat the movement to verify the machine will repeatedly position itself at zero.
14. Now, use the "Move To" button and then -.200 to move the spindle -.200" in the opposite direction.

15. Press "Move to" and then 0 and Enter from the pop up keypad for the axis that is being measured..

If the machine did not position itself to bring the digital readout to zero, a backlash compensation adjustment is needed.

16. To adjust, maximize the "Axis X Options" screen. Go to Backlash Setting>Backlash.



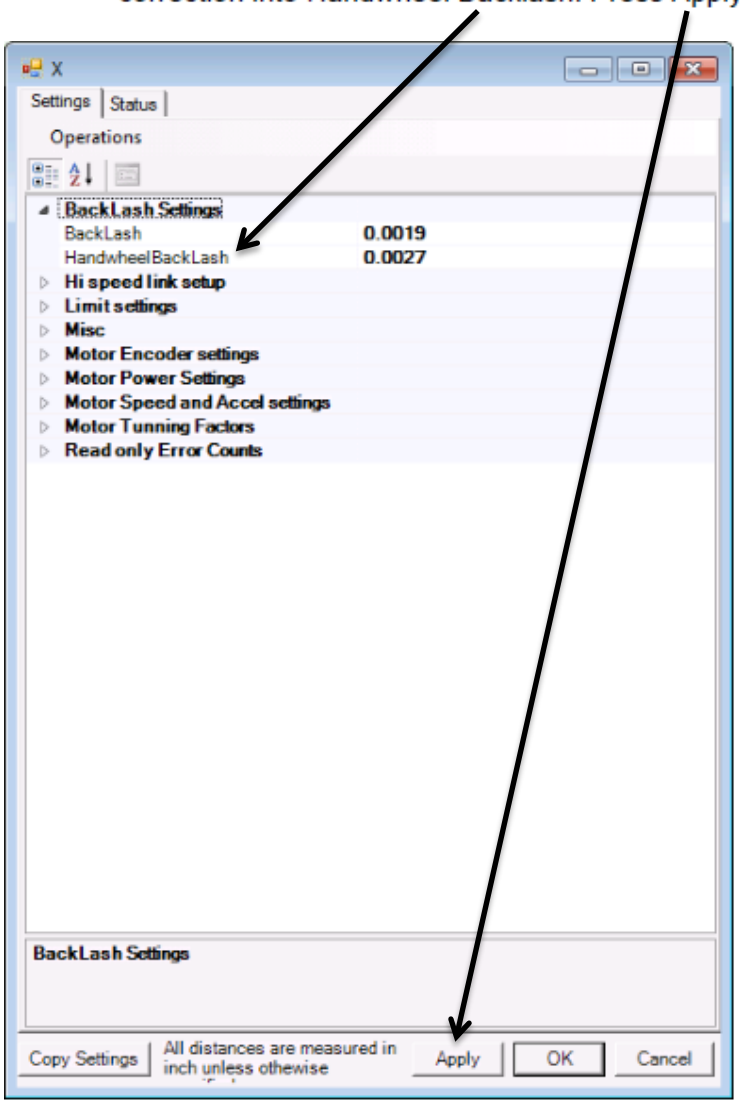
17. Use the "On Screen Keyboard", or plug in the full size keyboard to enter the amount of correction in the Backlash area. After entering a value, click "Apply", for the new setting to take effect.

18. Repeat steps 13 through 17 and adjust as necessary until the machine positions itself to "Zero" on the digital readout from both directions.

Handwheel Backlash is measured in a similar way to Backlash but the axes is moved by the Handwheel – the Move To buttons are NOT used.

19. Set up the Dial Indicator as described in #8 and #9.
20. Touch the .001" Handwheel button and move the axis to away. Turn the handwheel at a **constant speed** and move the axis back until the control panel displays zero. If the axis travels past zero, start again - move back again and turn the Handwheel at **constant speed** until the axis stops on zero on the machine display. Check that the Dial Indicator is zero, if not, move away and back again until both the machine control and Dial Indicator both read zero.

21. Now move the axis in the opposite direction and be sure to stop about.020" less that total plunger travel before compressing the plunger all the way. Now move the axis back by turning the Handwheel at a **constant speed** until the machine display reads zero. Check the reading on the Dial Indicator.
22. Use the "On Screen Keyboard", or plug in the full size keyboard to enter the amount of correction into Handwheel Backlash. Press Apply when you are done.



23. Follow steps 9 through 22 for the Y and Z axis.
24. When finished, re-enter the "Overshoot Backlash Amounts", as recorded in step 2 and click OK and close the window.

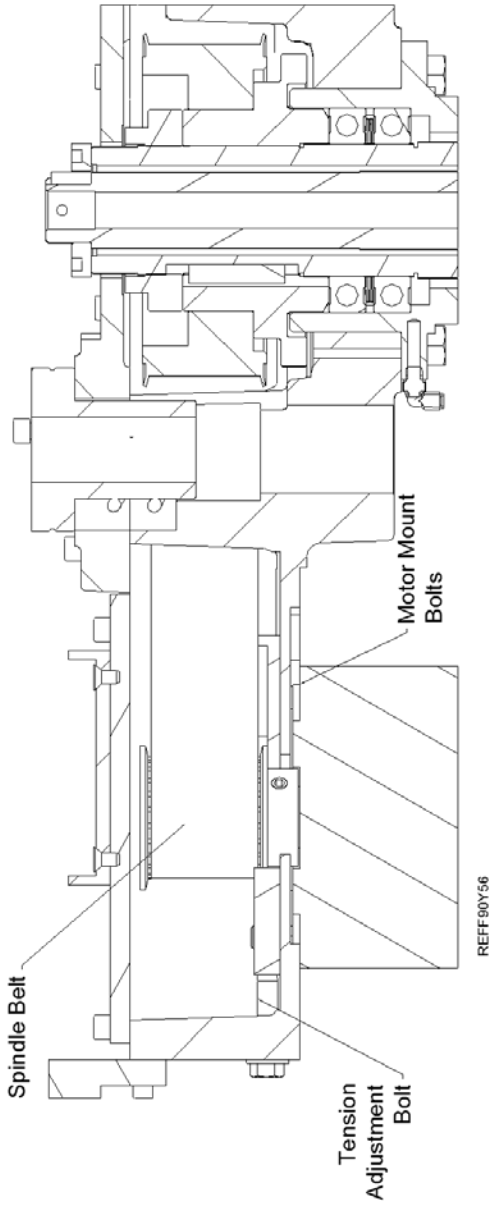
Spindle Belt Adjustment:

The spindle belt should not require adjustment very often, but if required use the following instructions.

Open the Spindle Base shroud.
Loosen the four Motor mounting bolts on the spindle motor.
Tighten or loosen the Tension adjustment bolt on the rear of the belt housing until 5 pounds of pressure causes the spindle belt to deflect ¼".

If the spindle motor is run at high speed and a high pitched wining is heard from the belt housing area the belt adjustment is probably too tight.

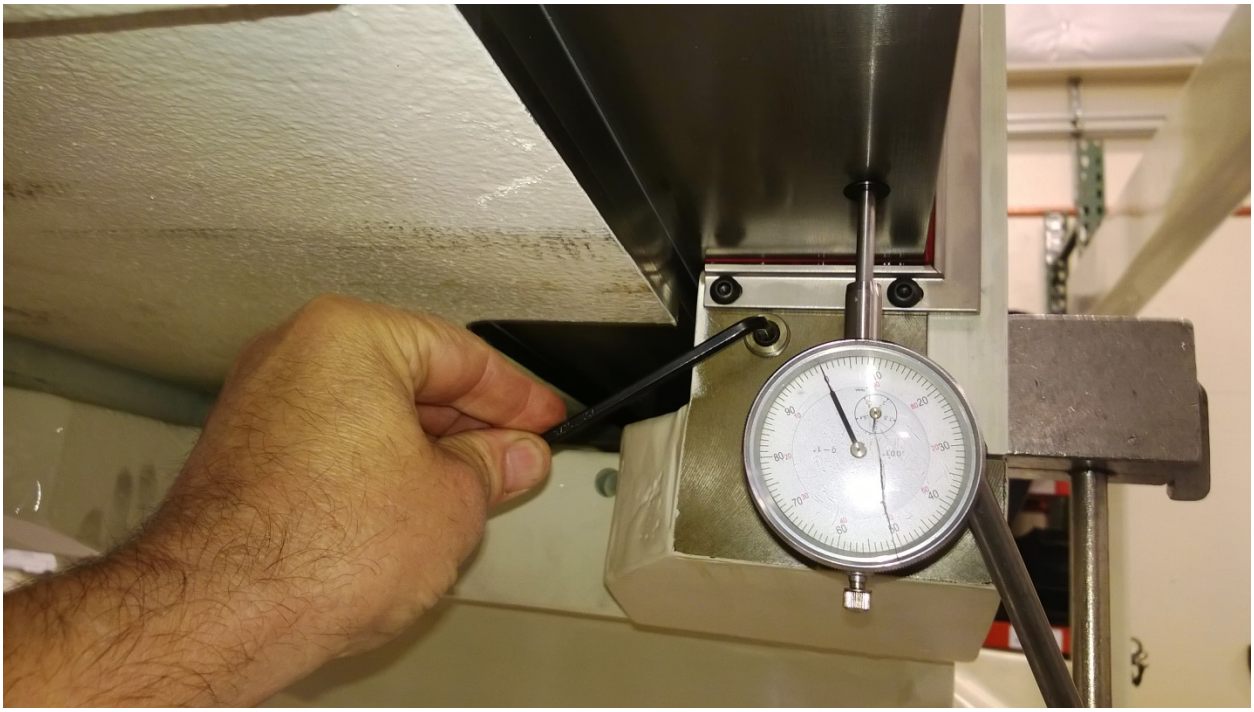
If you can visually see the belt jumping around while running the belt is too loose.



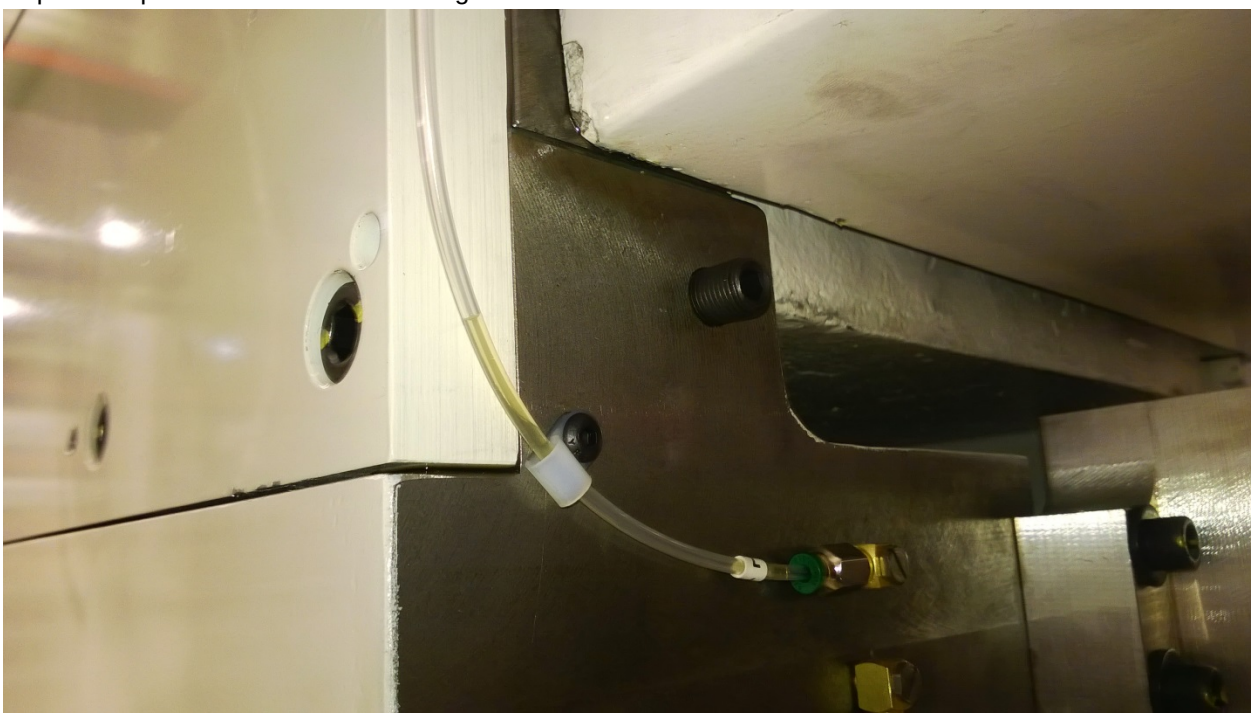
Mill Tilt Adjustment Procedure

1. Position the Y axis in the middle of its travel. Using a 5/32” hex key, loosen the locking set screw through the access hole in the right side guide rail

2. Put the machine in “Mill Cycle” mode, with the wedge turned off. Attach an indicator as shown in the following photo, and set to zero position.



3. Using a 3/16” hex key, turn the adjustment screw in or out to increase, or decrease, the amount of mill tilt. Turn the screw CCW to increase, or turn CW to decrease the amount as shown in the photo at step #2. After each adjustment, turn the “Wedge On”, to check the amount. Set to .002”- .004” (.05mm - .1mm) of lift with the wedge turned on. Turn the wedge off to readjust, and then turn the wedge on to check the amount.
4. When finished, tighten the locking set screw as shown in the photo in step #1.
5. Repeat the procedure for the rear wedge.



6. After adjusting the rear wedge, re-check the front, to make sure it did not change.

Preventative Maintenance Quick Reference Chart:

Refer to the procedures above to make or check these adjustments. Not all of the items listed in the table below have adjustment. The information should be recorded and the amount of wear tracked so the part can be replaced before down time on the machine occurs.

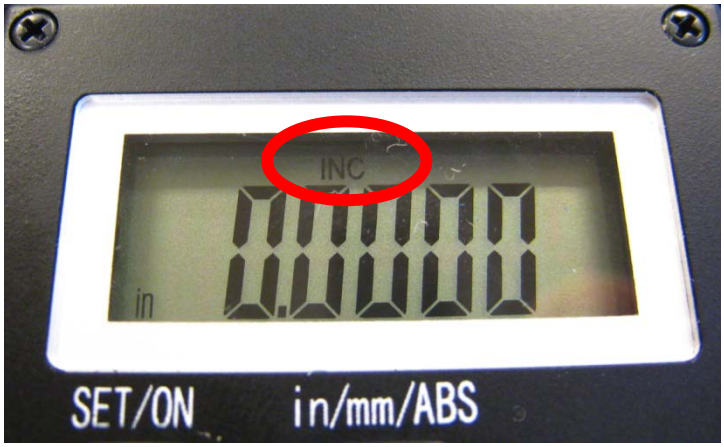
Procedure	Frequency
Inner Spindle	1000 Hours
Outer Spindle	500 Hours
Horizontal Gibs	2000 Hours
Vertical Belt	1000 Hours
Spindle Belt	1000 Hours
Spindle Sweep	150 Hours
Horizontal Ballscrew	2000 Hours
Horizontal Backlash	1000 Hours
Vertical Backlash	1000 Hours
In/Out Backlash	1000 Hours
Spindle Tilt	500 Hours
Machine Level	1000 Hours
Spindle Wear	2000 Hours
Horizontal Way Wear	2000 Hours

Digital Micrometer setting instructions:

Turn the thimble until the ‘0’ line on the thimble lines up with the vertical line nearest the spindle lock ring.

Determine which cutter head bore range the micrometer is going to be used on. (example; 2.9 – 6.0) We want to initially set the micrometer to the minimum bore diameter of this cutterhead.

NOTE: MICROMETER CAN NOT BE PROGRAMMED IF THE LETTERS INC APPEAR IN THE DISPLAY. To get rid of INC, quickly press the in/mm/ABS button.



To set or edit micrometer:

Press and hold the set/on button and the + or – button at the same time. “Set” will flash in the display. This places the micrometer in edit mode. (CAUTION: use a pencil tip or something similar to gently push the small round buttons - they are quite small and a bit delicate.)

Press and hold the + or – buttons to change the display number to the minimum bore diameter determined earlier (example; 2.9). Caution: Pushing the + or – buttons and holding in place will cause the numbers to scroll automatically. The numbers will count slowly at first and once 0.010” has been counted off the scrolling speed will pick dramatically.

After you have reached the desired number in the display, ***press the set/on button twice quickly*** to exit the edit mode. “Set” should no longer be flashing in the display. The micrometer is now ready for use.

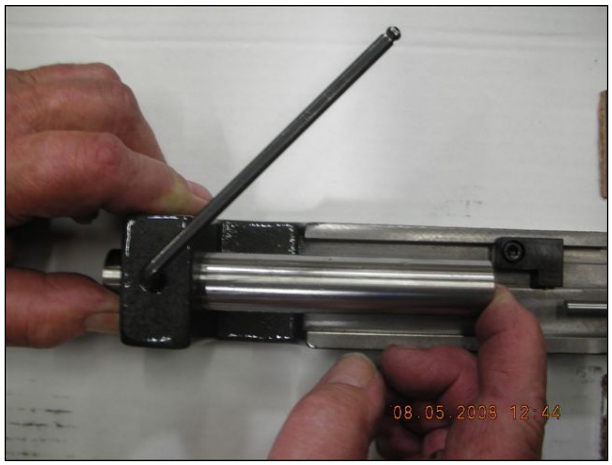
CAUTION: AFTER MICROMETER SET-UP IS COMPLETE, DO NOT PUSH SET/ON BUTTON AGAIN. PUSHING THE SET/ON BUTTON DURING USE WILL RETURN THE DISPLAY TO THE ORIGINAL MINIMUM BORE DIAMETER.THE ONLY TIME YOU SHOULD USE THE SET/ON BUTTON AGAIN IS TO- A.To shut micrometer off at which time you push and hold the button or B. to turn micrometer display back on at which time you push button one time. The display will then show the last reading before micrometer was shut off.

CAUTION: DO NOT BACK THE THIMBLE ALL THE WAY OUT TO THE END OF IT’S TRAVEL.ONCE THE THIMBLE IS BACKED ALL THE WAY OUT, IT WILL NO LONGER ROTATE PROPERLY AND THE DIGITAL HEAD WILL NEED TO BE REPLACED.

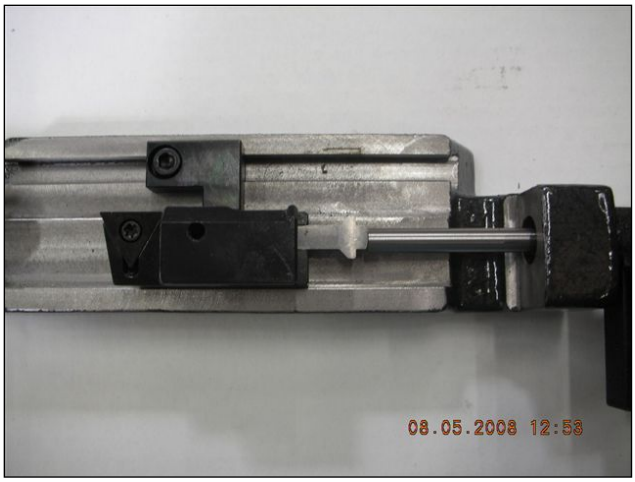
Micrometer is calibrated in inch mode. If metric is desired, press and hold in/mm/ABS button until mode changes to metric (approximately 3-4 seconds). A quick press of the in/mm/ABS button will put micrometer in ABS mode: 0.000, with another quick press returning it to initial setting.

Set up the cutter head and bore a set up hole. Measure the bore accurately. Set the digital display to this bore dimension and then -

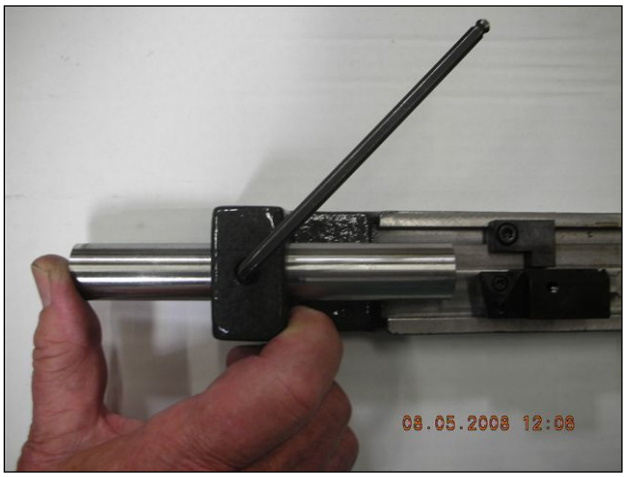
Loosen the set screw holding the large diameter anvil. Slide the anvil back out of the way.

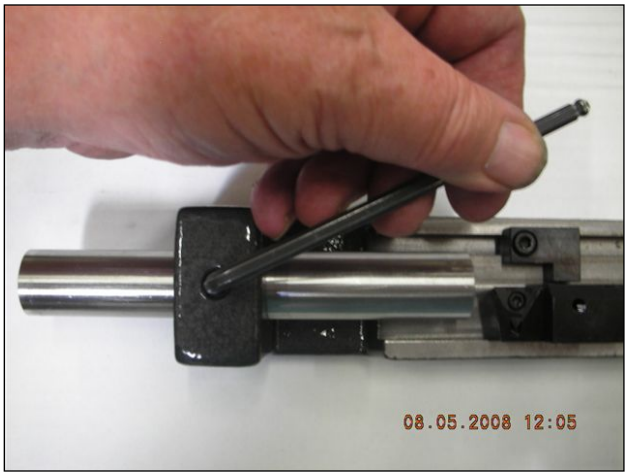


Place the tool holder used to bore the hole into the micrometer frame. Slide the location nub on the back of the tool holder gently up against the end of the digital micrometer shaft.

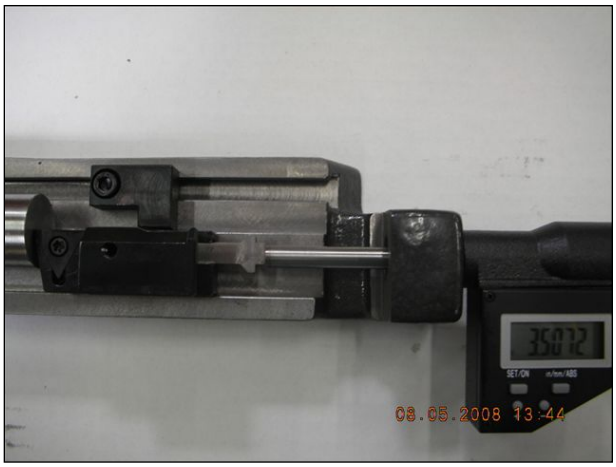


Slide the large diameter anvil up until it touches the end of the cutting tip of the tool holder. Tighten the set screw.





Back the digital micrometer shaft off, then bring it up to touch the tool holder and recheck that the numbers in the display are the same as the numbers previously shown.

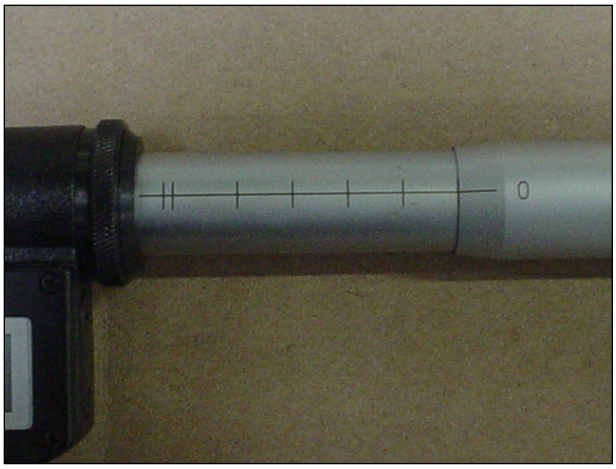


The micrometer is now set up for use with this cutter head.

Note: this procedure must be repeated to set the micrometer to a different cutter head. The micrometer can only be set to one cutter head at a time.

To shut off micrometer press and hold set/on button until screen goes blank or let micrometer set until display disappears.

With initial setting of micrometer it is recommended that you use the procedure detailed below in the event you think you have size problems.



Procedure:
The short vertical lines that cross the horizontal scale on the micrometer sleeve are reference marks. Set the zero on the micrometer thimble even with the first vertical line and note the size shown in the digital display. Record this size for future reference. Now follow the same procedure for each line and record the sizes. At any time you feel your micrometer is reading incorrectly, you can quickly refer to the recorded size of the line closest to the range you are using and check that the micrometer is still accurate.

Probe “On-Center” Adjustment:

The optional shank adapter assembly allows the OMP40 to be mounted on shanks suitable for the MP10, MP12 and MP700 Probes.

Step 1 - Adapter Assembly:

Assemble the 650-3-59H adapter plate as shown. Fully tighten screw A to 0.68 lbf (3.0 Nm)

Step 2 – Probe / shank Mounting:

Fully loosen all screws and fit shank adapter to shank as shown on the following page. Tighten screw B to 1.35 lbf (6 Nm)

Fully tighten tighten screw C to 0.49 lbf (2.2 Nm)

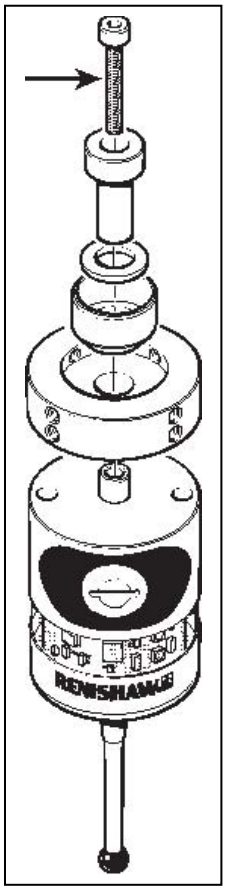
Fit Probe / Shank assembly into machine spindle.

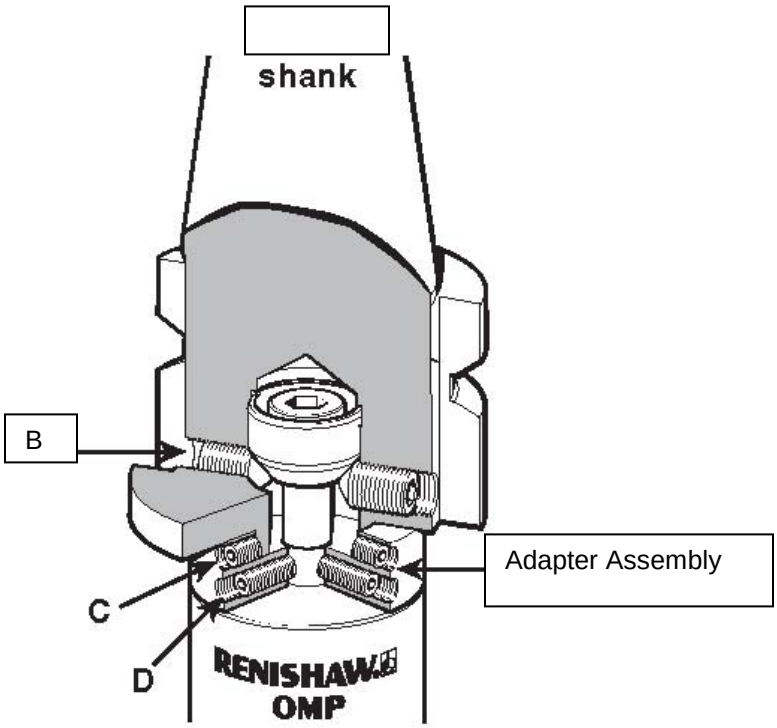
Step 3 – Adjustment:

There are four screws D. Each will move the probe relative to the shank in the X or Y direction as pressure is applied. Tighten screw individually, backing off after each movement.

Use screws D in opposition at the same time to move the probe, progressively tightening then as the final setting is approached. Use two Allen keys if needed. Tip run out should be .002” (5 Microns) should be achievable.

It is important that all four screws (D) are tightened to 0.49 lbf (2.2 Nm) once the final setting has been achieved.




shank
B
Adapter Assembly
C
D
RENISHAW
OMP

Ballscrew Assemblies Reference

Alignment Definitions for Angular Bearings and Belleville Washers

Bearing Alignment

VIEW OPEN END UP

VIEW CLOSED END UP

Belleville Washer Alignment

VIEW CUP UP

VIEW CUP DOWN

Z-Axis Lower Bearing and Belleville Washer Stacking Order

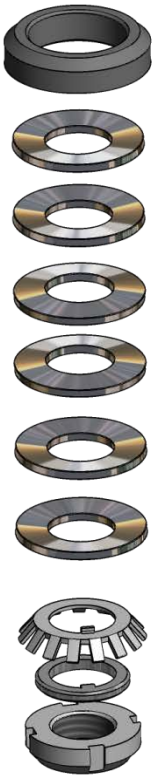
Install 1st and 2nd bearings with the open end up.

Install 3rd and 4th bearings with the open end down.

Install 1st and 2nd Belleville washers with cup side up.

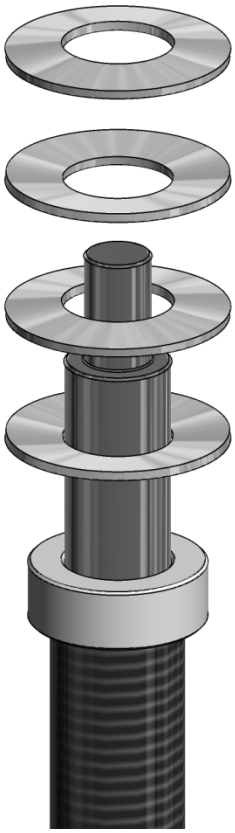
Install 3rd and 4th Belleville washers with cup side down.

Install 5th and 6th Belleville washers with cup side up.



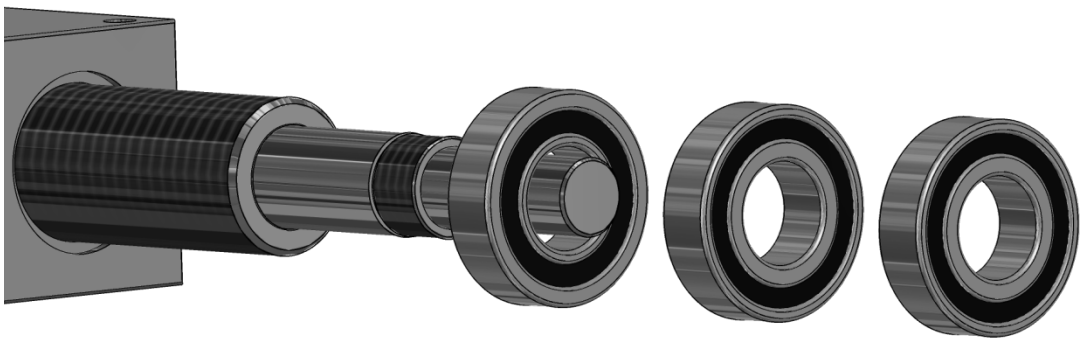
Z-Axis Upper Belleville Washer Stacking Order

Install 1st washer with cup side facing out, then alternate next 3 washers.



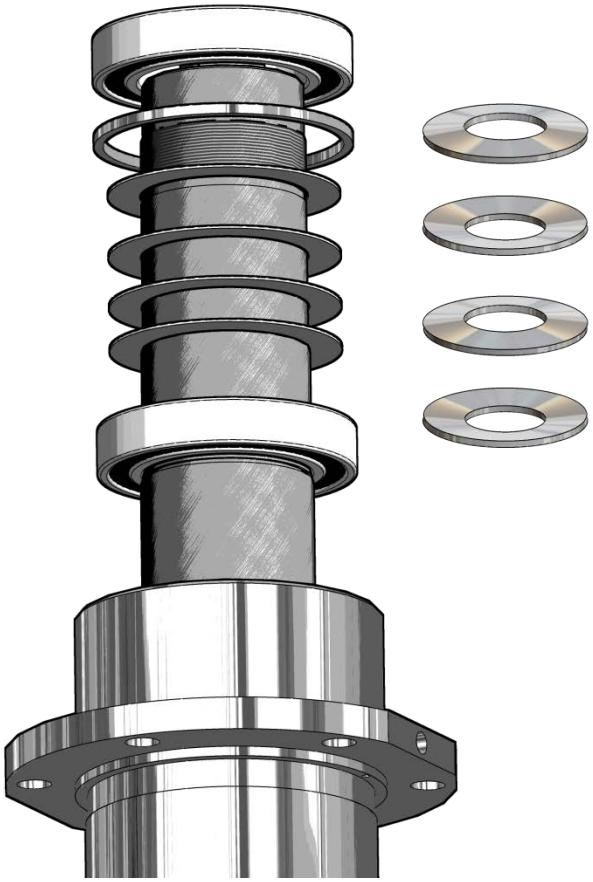
Y-Axis Bearing Stacking Order

Install 1st bearing with open end toward ballscrew shoulder. Install 2nd and 3rd bearings with closed end toward 1st bearing.

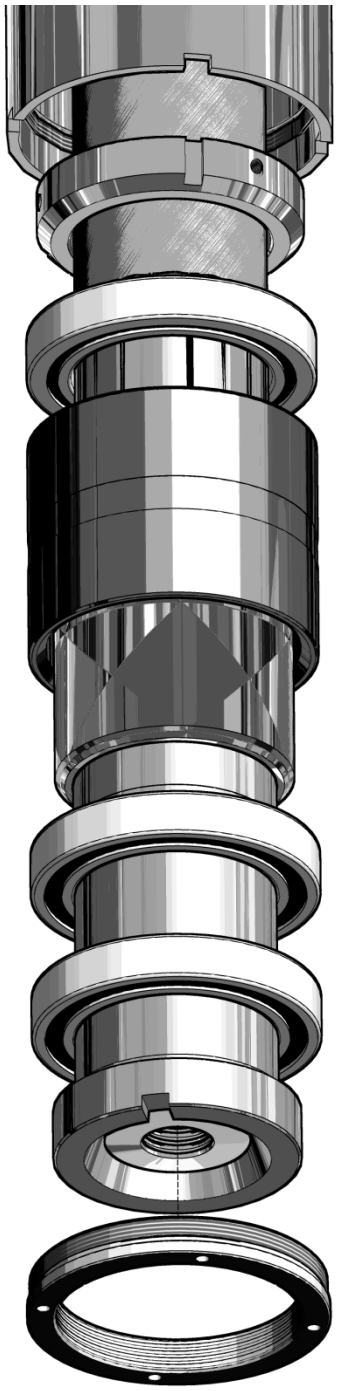


Inner Spindle Upper Section Belleville Washer Stacking Order

6113 Bellville washers are stacked in an alternating pattern with the bottom washer installed cup face up. (see illustration or right side)



Inner Spindle Lower Section Bearing Stacking Order



Install 3rd bearing with the closed side down.

Install inner and outer spacer assembly with beveled end facing up.

Install 2nd bearing with the open side down.

Install 1st bearing with the open side down.

Troubleshooting

Contents

Rottler Replacement and Specialty Inserts

Below is a description of the cutting inserts available from Rottler. The inserts have gone through extensive performance testing. To take full advantage of the capabilities of your Rottler machine, we highly recommend Rottler cutting tools be used. Rottler machine performance can be significantly reduced if qualified tooling is not used. Using an incorrect insert can result in bore geometry inconsistency, short tool life, and poor surface finish.

Below are general guidelines. When using these inserts it is best to refer to the operator manual of the particular machine you are using. Rottler Manufacturing's latest operator manuals have more detailed information on feeds and speeds for the particular machine and cutterhead that you are using.

GENERAL INFORMATION

Rottler CBN and PCD Inserts are laser marked with our part number on one side. On single sided inserts, the part number is on the back side of the insert.

Rottler surfacing insert toolholders are designed so they can hold square and round inserts that are of the same basic size. For example, a 3/8" (9.52 mm) IC round and 3/8" (9.52 mm) IC square insert will fit into the standard 3/8" (9.52 mm) IC Rottler toolholders. IC refers to inscribed circle.

Rottler SF, F60, F80 and F90 Series surfacing cutterheads are supplied standard with Rottler 3/8" (9.52 mm) IC toolholders fitted to our surfacing heads. Optional 1/2" (12.7 mm) toolholders are interchangeable with 3/8" (9.52 mm) toolholders.

INSCRIBED CIRCLE

Insert breaking or chipping can be caused by several things. It can be caused by not operating the insert at the correct RPM. It is very typical for an insert to break or chip when cutting too slow. Interrupted cuts can cause an insert to break as well. When making a heavy sleeve cut in a cylinder that has been cracked it is often required to slow the RPM down to ½ the normal operating speed to prevent chipping of the insert.

Tool Nose Radius

The tool nose radius has an important effect on the cutting process. If you use the same feed rate per revolution on two different sized tool nose radius the larger tool radius will give a smoother finish. There are two other important characteristics of the tool radius. The larger the tool radius the stronger the cutting edge. The larger radius will hold up to interrupted cuts better than a smaller radius.

A disadvantage of a larger tool radius is that is creates more tool pressure than a smaller radius. When using long small diameter boring bars or large diameter milling cutterheads the high tool pressure of a large radius can cause chatter in the finish.

Edge Preparation

Rottler inserts have edge preparations specifically designed for proper cutting performance. Some inserts have sharp edges, Some have a few ten thousandths of an inch honed edge. Others have a T land which is actually a beveled edge. Generally the sharp edge will require the minimum amount of cutting pressure but the edge will not be as strong and long lasting. The T land insert is at the opposite end of the spectrum. It generates a lot of cutting force and can create chatter. The advantage of a T land is that is very tough. Most Rottler inserts have a honed edge which gives a good balance between cutting performance and tool life.

Surfacing Inserts Cutting Speed Calculation

Inserts are designed to cut within a speed range – S.F.P.M. In order to convert from cutting speed to RPM, use the following formula:

$$RPM = \frac{S.F.P.M. \times 3.82}{DIAMETER}$$

S.F.P.M. = Surface Feet per Minute
RPM = Revolutions per Minute
DIAMETER in Inches

The feed rate on most Rottler machines is designated in inches / revolution. The F65M and the SFM have feed rates designated in inches / minute. It is important to adjust the inches / minute rate to obtain the correct load (inches / revolution). Following are the formulas to use. You do not have to perform this calculation with an "A" model machine

If you know the RPM and the Feed Rate per Revolution you want, use the following formula to obtain the correct Feed Rate per minute.

FRM = RPM X FRR
FRM = Feed Rate Inches per Minute
FRR = Feed Rate Inches per Revolution
RPM = Spindle Revolutions per Minute

METRIC CONVERSIONS
1 inch = 25.4 mm = 2.54 cm = .0254 meters
1 mm = .040 inches

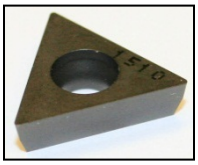
CYLINDER BORING INSERTS

Rottler has just completed the development of group of new triangular inserts for cylinder boring. Extensive trials were made to come up with new inserts that would outperform the older inserts. The result is a group of inserts that are the same unit cost but have 5 – 50% increased tool life. The increased tool life decreases overall operation cost to the end user.

Rottler offers either triangular or square inserts for cylinder boring, sleeving, and counter boring. Triangular inserts are excellent general purpose inserts for doing all boring, sleeving and counterboring operations..When doing counter boring operations it is important to use a tool nose radius small enough that it will not interfere with the mating corner on the part that is installed in the counterbore.

When removing less than.060" (1.50mm) on the diameter a square insert is the most economical insert to use. The square inserts Rottler offers have 8 cutting edges. A Triangular insert only has 3 cutting edges.

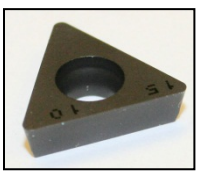
RT321 (General purpose and sleeving)



A 3/8" (9.52 mm) IC triangular insert with a black ceramic coating and 1/64" (.4 mm) cutting radius. This insert is the best to use for counterboring when the small corner radius is required for clearance or when the machine is at its extended travel limits. The 1/64" (.4 mm) radius should be used when machining to a step where the mating part requires a smaller radius to eliminate an interference problem in the radius. If you are machining a long bore where the spindle must be extended towards the limits of its travel or if a long stub bar is being used, the 1/64" (.4 mm) radius will minimize the possibility of chatter. A feed rate of .002" - .005" (.05 mm - .12 mm) per revolution should be used to obtain a typical surface finish. When machining large counter bores typically found in Cummins or Cat Blocks, a feed rate of .002" - .004"/rev (.02 mm-.1 mm/rev) should be used. When cutting gray cast iron use a speed in the 800 – 1200 S.F.P.M. area for best productivity and tool life.

When cutting nodular, ductile, or compacted graphite cast iron the speed should be in the 200 – 400 S.F.P.M. area – 300 RPM on a 4" (100 mm) diameter bore. Nodular, ductile, or compacted graphite cast irons, is found most often in high performance engine blocks or sleeves. When cutting these tuff cast irons it is best to use a feed rate of between .002 and .005 (.05 mm and .13 mm) per revolution.

RT322 (General purpose and sleeving)

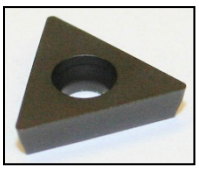


This is the same insert as RT321, except it has a 1/32" (.8 mm) radius. This insert is the best to use for heavy sleeve cutting and can also be used for general machining and counterboring. This larger radius insert will give a smoother finish for a given feed

rate when sleeve cutting to allow easier sleeve fitting and closer metal to metal contact for heat transfer. It is possible to use a feed rate that is 30% faster with the RT322 compared with the RT321 and still obtain the same finish. The 1/32" (.8 mm) radius is stronger than the 1/64 (.4mm) radius of the RT321. The RT322 should always be used for heavy sleeve cuts unless the finish part requires the smaller radius for clearance or you are cutting a long bore. The larger radius creates more tool pressure than the small radius. The increased tool pressure may cause chatter in the finish if machining very long bores. A feed rate of .006" - .012" (.15 mm - .3 mm) per revolution should be used to obtain a typical surface finish. When machining large counter bores typically found in Cummins or Cat Blocks, a feed rate of .002" - .004"/rev (.05 mm-.1 mm/rev) should be used. When cutting gray cast iron use a speed in the 800 – 1200 S.F.P.M. area for best productivity and tool life.

When cutting nodular, ductile, or compacted graphite cast iron the speed should be in the 200 – 400 S.F.P.M. area – 300 RPM on a 4" (100 mm) diameter bore. Nodular, ductile, or compacted graphite cast irons, is found most often in high performance engine blocks or sleeves. When cutting these tuff cast irons it is best to use a feed rate of between .006" and .010" (.15 mm and .25 mm) per revolution.

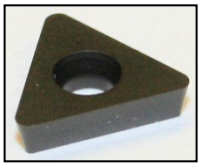
RT211 (General purpose and sleeving)



A ¼" (6.35 mm) IC triangular insert with a black ceramic coating and 1/64" (.4 mm) cutting radius. The 1/64" (.4 mm) radius should be used when machining to a step where the mating part requires a smaller radius to eliminate an interference problem. If you are machining a long bore where the spindle must be extended towards the limits of its travel or if a long stub bar is being used, the 1/64" (.4 mm) radius will minimize the possibility of chatter. A feed rate of .002" - .005" (.05 mm - .12 mm) should be used to obtain a typical surface finish. When machining large counter bores typically found in Cummins or Cat Blocks, a feed rate of .002" - .004"/rev. (.05 mm - .1 mm/rev) should be used. When cutting gray cast iron use a speed in the 800 – 1200 S.F.P.M. area for best productivity and tool life.

When cutting nodular, ductile, or compacted graphite cast iron the speed should be in the 200 – 400 S.F.P.M. area – 300 RPM on a 4" (100 mm) diameter bore. Nodular, ductile, or compacted graphite cast irons, is found most often in high performance engine blocks or sleeves. When cutting these tuff cast irons it is best to use a feed rate of between .002 and .005 (.05 mm and .13 mm) per revolution.

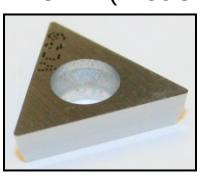
RT212 (General purpose and sleeving)



This is the same insert as RT212, except it has a 1/32" (1.6 mm) radius. This larger radius insert will give a smoother finish when sleeve cutting to allow easier sleeve fitting and closer metal to metal contact for heat transfer. The 1/32" (1.6 mm) radius is stronger than the 1/64 (.8 mm) radius of the RT321. The RT322 should always be used for sleeve cuts unless the finish part requires the smaller radius for clearance or you are cutting a long bore. The larger radius creates more tool pressure than the small tool radius. The increased tool pressure will create chatter in the finish. A feed rate of .006" - .012" (.15 mm - .3 mm) per revolution should be used to obtain a typical surface finish. When machining large counter bores typically found in Cummins or Cat Blocks, a feed rate of .002" - .004"/rev. (.05 mm -. 1 mm/rev) should be used. When cutting gray cast iron use a speed in the 800 – 1200 S.F.P.M. area for best productivity and tool life.

When cutting nodular, ductile, or compacted graphite cast iron the speed should be in the 200 – 400 S.F.P.M. area – 300 RPM on a 4" (100 mm) diameter bore. Nodular, ductile, or compacted graphite cast iron is found most often in high performance engine blocks or sleeves. When cutting these tuff cast irons it is best to use a feed rate of between .006" and .010" (.15 mm and .25 mm) per revolution.

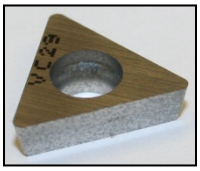
RT321F (Precision Counterboring and Finishing)



A 3/8" (9.52 mm) IC triangular, uncoated insert with a 1/64" (.8 mm) cutting radius. Gives the best finish results when machining precision counter bores often machined in diesel engine blocks. The 1/64" (.8 mm) radius should be used when machining to a step where the mating part requires a smaller radius to eliminate an interference problem. If you are machining a long bore where the spindle must be extended

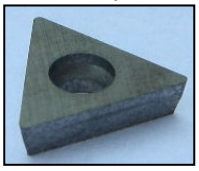
towards the limits of its travel or if a long stub bar is being used, the 1/64” (.8 mm) radius will minimize the possibility of chatter. A feed rate of .002” - .005” (.05 mm - .12 mm) should be used to obtain a typical surface finish. When machining large counter bores typically found in Cummins or Cat Blocks, a feed rate of .002 - .004/rev. (.05 mm - .1 mm/rev) should be used.

RT322F (Precision Counterboring and Finishing)



A 3/8” (9.52 mm) IC triangular, uncoated insert with a 1/32” (1.6 mm) cutting radius. Gives the best finish results when machining precision counter bores often machined in diesel engine blocks. A feed rate of .004” - .008” (.05 mm - .1 mm) should be used to obtain a typical surface finish. When machining large counter bores typically found in Cummins or Cat Blocks, a feed rate of .002 - .004/rev. (.05 mm - .1 mm/rev) should be used. When cutting gray cast iron use a speed in the 300 - 600 S.F.P.M. area for best productivity and tool life. Tool life of this insert is significantly less than the RT322.

RT211F (Precision Counterboring and Finishing)

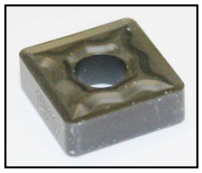


A ¼” (6.35 mm) IC triangular, uncoated insert with a 1/64” (.8 mm) cutting radius. Gives the best finish results when machining precision counter bores often machined in diesel engine blocks. The 1/64” (.8 mm) radius should be used when machining to a step where the mating part requires a smaller radius to eliminate an interference problem. If you are machining a long bore where the spindle must be extended towards the limits of its travel or if a long stub bar is being used, the 1/64” (.8 mm) radius will minimize the possibility of chatter. A feed rate of .002 - .005 (.05 mm - .12 mm) should be used to obtain a typical surface finish. When machining large counter bores typically found in Cummins or Cat Blocks, a feed rate of .002 - .004/rev. (.05 mm - .1 mm) should be used. When cutting gray cast iron use a speed in the 300 - 600 S.F.P.M. area for best productivity and tool life. Tool life of this insert is significantly less than the RT211

RT212F (Precision Counterboring and Finishing)

A ¼” (6.35 mm) IC triangular insert with a gold coating and 1/32” (1.6 mm) cutting radius. The coating gives the best finish results when machining precision counter bores often machined in diesel engine blocks. A feed rate of .002 - .005 (.05 mm - .12 mm) should be used to obtain a typical surface finish. When machining large counter bores typically found in Cummins or Cat Blocks, a feed rate of .002 - .004/rev. (.05 mm - .1 mm/rev.) should be used. When cutting gray cast iron use a speed in the 300 - 800 S.F.P.M. area for best productivity and tool life. Tool life of this insert is significantly less than the RT211.

RS322 (High speed oversize through boring)



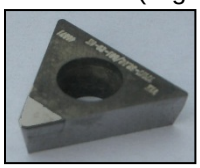
A 3/8” (9.52 mm) IC, square insert with a black ceramic coating. It is used on Rottler boring machines for through boring when removing .010” - .060” (.25 mm - 1.5 mm) on the diameter. A very economical insert as it has 8 cutting edges. On a 4” (100mm) bore use 1000 - 1200 RPM and a feed rate of .008” - .012” (.2 mm - .3 mm) per rev feed rate to obtain the typical surface finish. The insert can also be used for sleeve cuts when a square step is not required. For example, when used on an F80 or F5 machine it can be run at 1000 – 1200 RPM and .005/rev (.12 mm/rev) feed rate to remove up to .200” (5 mm) on the diameter from a 4.200” (106 mm) bore.

When cutting nodular, ductile, or compacted graphite cast iron the speed should be in the 200 – 400 S.F.P.M. area – 300 RPM on a 4” (100 mm) diameter bore. Nodular, ductile, or compacted graphite cast iron is found most often in high performance engine blocks or sleeves. When cutting these tuff cast irons it is best to use a feed rate of between .006” and .010” (.15 mm and .25 mm) per revolution.

6301E (High speed oversize through boring)

This is a square 3/8” (9.52 mm) IC, 1/32” (1.6 mm) radius, double sided, CBN Insert. These inserts are intended for use on high speed boring on Rottler F80 and F60 series machines. On common cast iron blocks the RPM should be set to achieve 1000 – 2200 S.F.P.M. On harder cast irons the RPM should be reduced to obtain acceptable tool life. A feed rate of .010” - .014” (.25 mm - .36 mm) per revolution. They have exceptional long life when removing up to .040” (1.02 mm) on the diameter. They do not give good tool life on some cast irons with high sulfur content.

501-29-6K (High speed aluminum boring)



This is a 3/8” (9.52 mm) IC, triangle insert with a black diamond tip. It has a 1/32” (1.6 mm) radius. This insert is used to bore aluminum cylinders. It cannot be used to bore any other material. It is the best insert for finishing aluminum. For best tool life and finish the insert can be run from 400 – 4000 SFM. Feed rates between .004” and .010” (.1 mm and .25 mm) should be used.

511-29-20E (Steel boring)

A 3/8” (9.52 mm) IC triangular insert with a gold coating and 1/32” (1.6 mm) cutting radius. This insert is for boring steel and ductile iron. It features a chip breaker to break-up the “string” of metal that can often form when boring steel.

SURFACING INSERTS

Rottler offers a wide variety of inserts used for surfacing. There are many applications in surfacing that include a variety of materials.to be surfaced. Cylinder heads with pre-combustion chambers are particularly challenging because there are such a variety of materials used by the different cylinder head manufactures. One of the latest inserts we have tested for cutting cylinder heads with pre-combustion chambers is the 7202Z. It is probably the best for cutting a wide variety of heads with pre-combustion chambers. The 6303B is our standard for cutting a wide variety of cast iron heads. The 6303B will cut aluminum but is not ideal. The best insert for cutting aluminum is the 6303M which is a diamond insert.

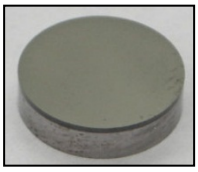
When machining large cylinder blocks with larger precision depth counter bores using a 18" (450mm) or larger diameter fly cutter it is important to use a square 6301J insert. The smaller radius minimizes cutter deflection and will result in more accurate counterbore depths.

Below are the inserts commonly used on Rottler machines in surfacing/milling applications. Please read carefully..

6303B

A round 3/8" (9.52 mm) IC, double sided, CBN Insert. An excellent, long life insert for surfacing cast iron heads and blocks - round shape gives many cutting edges on each side of insert. When using a 14" (355.6 mm) cutterhead (SF, F65, F80) speeds range from 900-1200 RPM. When using an 18" (457 mm) cutterhead speeds range from 600-800 RPM.

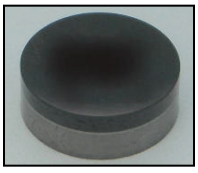
6303M



A round 3/8" (9.52 mm) IC, single sided, PCD Insert. For use on aluminum only - heads and blocks without liners. This insert has a thin layer of PCD applied to a carbide disk. The diamond appears to be a shiny black wafer. The hardness of the diamond resists the abrasive nature of the silica in aluminum heads and blocks. RPM speeds with a 14" (355.6 mm) cutter range from 900-2000 RPM.

6303U

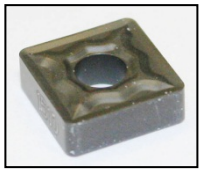
A round 3/8" (9.52 mm) IC, single sided, CBN Insert. This insert does an excellent job when cutting hard cast iron blocks and heads of a single material or bi-metal. This insert is the best to use when machining compacted graphite cast iron heads and blocks often found in the performance industry. RPM speeds with a 14" (355.6 mm) cutter range from 650-750 RPM.



6303K

A round, gold-colored, 3/8" (9.52 mm) IC, single sided, coated carbide insert. This is a very economical, general purpose insert for surfacing aluminum. It is advisable to use this insert for rough cutting to remove welding or contaminants before. A PCD insert should be used for the final cut to give the super fine finish required for MLS (multi layer steel) head gaskets. RPM speeds with a 14" (355.6 mm) cutterhead range from 600-1000 RPM.

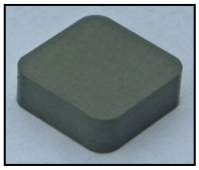
RS322



A square 3/8" (9.52 mm) IC carbide insert with a very dark purple ceramic coating. This carbide insert is normally used for high speed boring. It works well as an economical insert for rough surfacing or heavy stock removal of cast iron. A CBN insert should be used for the final finish cut.

6301J

A square 3/8” (9.52 mm) IC, 1/16” (.0039 mm) radius, double sided, CBN Insert. The 1/16” (.0039 mm) radius of this insert will produce a more accurate (flatter) finish than a round insert typically used for surfacing on F80/F90 Series machines when surfacing large diesel blocks and heads which are high in nickel. The square surfacing insert is intended for F80/F90 applications where it may encounter heavier cuts and greater interrupted cuts. When using an 18” (457 mm) cutter speeds range from 600-800 RPM, and with a 14” (355.6 mm) cutter speeds range from 900-1200 RPM.



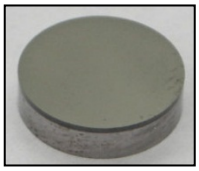
6303V

An octagonal 3/8” (9.52 mm) IC, .094” (2.4 mm) corner radius, double sided, solid CBN Insert with 16 cutting corners. The .094” (2.4mm) corner radius of this insert will produce a more accurate (flatter) finish than a round 3/8” (.52mm) or square 1/16” (1.6mm) corner radius insert typically used for surfacing on F70/F80/F90/F100 Series machines when surfacing large diesel blocks and heads which are high in nickel. The octagonal surfacing insert is intended for applications where it may encounter interrupted cuts. When using an 18” (457 mm) cutterhead, speeds range from 600-800 RPM, and with a 14” (355.6 mm) cutter speeds range from 900-1200 RPM. The .094” (2.4mm) corner radius will allow faster feed rates compared to the 6301J square insert.

1/2” (12.70mm) SURFACING INSERTS

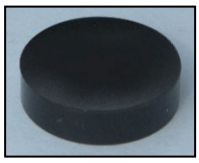
6303P

A round 1/2” (12.7 mm) IC, single sided, PCD Insert. For use on aluminum only - heads and blocks without liners. This insert has a thin layer of PCD applied to the top of a carbide disk. The diamond appears to be a shiny black wafer. The hardness of the diamond resists the abrasive nature of the silica in aluminum heads and blocks. RPM speeds with a 14” (355.6 mm) cutter range from 1000-2000 RPM. Requires the purchase of 1/2” (12.7 mm) negative rake tool holders. The standard Rottler 3/8” (9.52 mm) IC tool holders will not hold this insert.

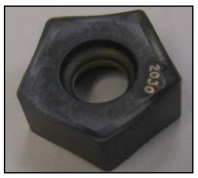


6303Q

A round 1/2” (12.7 mm) IC double sided, CBN Insert. An excellent insert for machining cast iron heads and blocks. Round shape gives many cutting edges on each side of insert. Requires the purchase of 1/2” (12.7 mm) negative rake tool holders. The standard Rottler 3/8” (9.52 mm) IC tool holders will not hold this insert.



6864E



A five sided / five cornered insert coated carbide insert. There are a total of ten cutting corners on this inserts. This is the best insert for roughing and finishing spray weld. This is used in Rottler milling heads that are designed specifically for cutting spray weld. Currently they cannot be used in Rottlers common “flycutter” style surfacing cutterheads.

Bi-metal Surfacing

Cylinder Heads with Pre-combustion Chambers and Aluminum Blocks with Hard Sleeves

Cylinder heads with pre-combustion chambers or aluminum engine blocks with cast iron or steel cylinder sleeves are a challenge to cut and most often require a special cutting insert and special cutting

technique. There are many different material combinations so there is not one insert that works the best on all applications. Below is information to use as a guide to the best insert to use and some of the required cutting parameters.

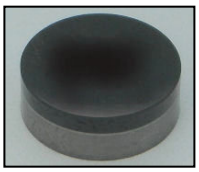
Generally the tool life when using any of these inserts in the cutting of bi-metal surfaces will be short when compared to cutting a single material. The cost of the insert per surfacing job will be higher compared with cutting single materials. The customer must incorporate the higher insert cost into the price charged for the surfacing job.

Another excellent alternative to cutting cylinder heads with pre-combustion chambers is to remove the combustion chamber from the head, surface the cylinder head, then use the Rottler Pre-combustion Chamber Re-seating Tool to machine the combustion chamber counterbore back to OEM specification depth. It is fast and economical to use. See Bulletin C49.

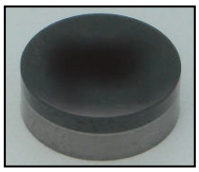
Cylinder Heads with Protruding Valve Seats
Some cylinder heads have valve seats that protrude into the head gasket surface. Valve seats are made out of a wide variety of material. Some are very hard or difficult to cut when compared with the aluminum or cast iron head surface. In many cases it is best to cut the valve seat down below the head surface in a seat and guide machine. This takes a few more minutes when cutting the valve seats but it can save a lot of time and minimize tooling cost when surfacing the head.

The following inserts use Rottler 3/8" (9.52mm) Toolholders supplied with Rottler Surfacing Cutterheads;

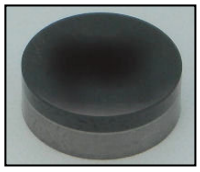
6303S
A round 3/8" (9.52 mm) IC, single sided, CBN Insert. For use on aluminum blocks with iron liners and aluminum heads with steel pre-combustion chambers. RPM speeds with a 14" (355.6 mm) cutter range from 650-750 RPM.



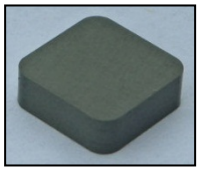
6303U
A round 3/8" (9.52 mm) IC, single sided, CBN Insert. This insert does an excellent job when cutting hard cast iron blocks and heads of a single material or bi-metal. This insert is the best to use when machining compacted graphite cast iron heads and blocks often found in the performance industry. RPM speeds with a 14" (355.6 mm) cutter range from 650-750 RPM.



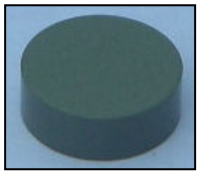
6303R
A round 3/8" (9.52 mm) IC, single sided, CBN Insert. For use on cast iron heads with steel pre-combustion chambers. RPM speed with a 14" (355.6 mm) cutter range from 600-700 RPM and with an 18" (457 mm) cutter range from 500-600 RPM.



6301I
A square 3/8" (9.52 mm) IC, double sided, ceramic insert. For use on cast iron heads with pre-combustion chambers. You can make one finish cut and two rough cuts with each new cutting edge. Always use a new edge when making a finish cut. Use 350-500 RPM on a 14" (355.6 mm) diameter cutterhead. See Bulletin C49.

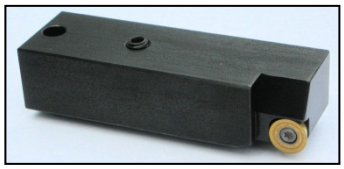


6301V
A round 3/8" (9.52 mm) IC, double sided, ceramic insert. For use on cast iron heads with pre-combustion chambers. You can make one finish cut and two rough



cuts with each new cutting edge. Always use a new edge when making a finish cut. Use 350-500 RPM on a 14” (355.6 mm) diameter cutterhead. See Bulletin C49.

SPECIAL TOOLHOLDER AND INSERT FOR SURFACING
DIESEL ALUMINUM HEADS WITH STEEL PRE-CHAMBERS
7202X
Fly Cutter Tool Holder Assembly uses special 7202Z insert for surfacing aluminum cylinder heads with steel pre-combustion chambers.



7202Z
Round Insert, 3/8" (9.52 mm) IC gold coated for aluminum cylinder heads with steel pre-combustion chamber. For use with 7202X tool holder only. RPM speeds with 14” (355.6 mm) cutter range from 450-550 RPM and with a 16” (406.4 mm) cutter, 400-500 RPM. Requires very slow feed rate. Surfacing these heads is a difficult operation and only the minimum amount of material can be removed per pass. For best results, rotating the insert so that a new ‘corner’ is used for the final pass should give good results.

INSERTS FOR SHELL MILLING CUTTERHEADS
6514T

Parallelogram configuration, carbide material. Special insert used with the Rottler 650-2-44P 4” (101.6 mm) shell mills only. Designed for general purpose applications.

MAIN LINE BORING INSERTS

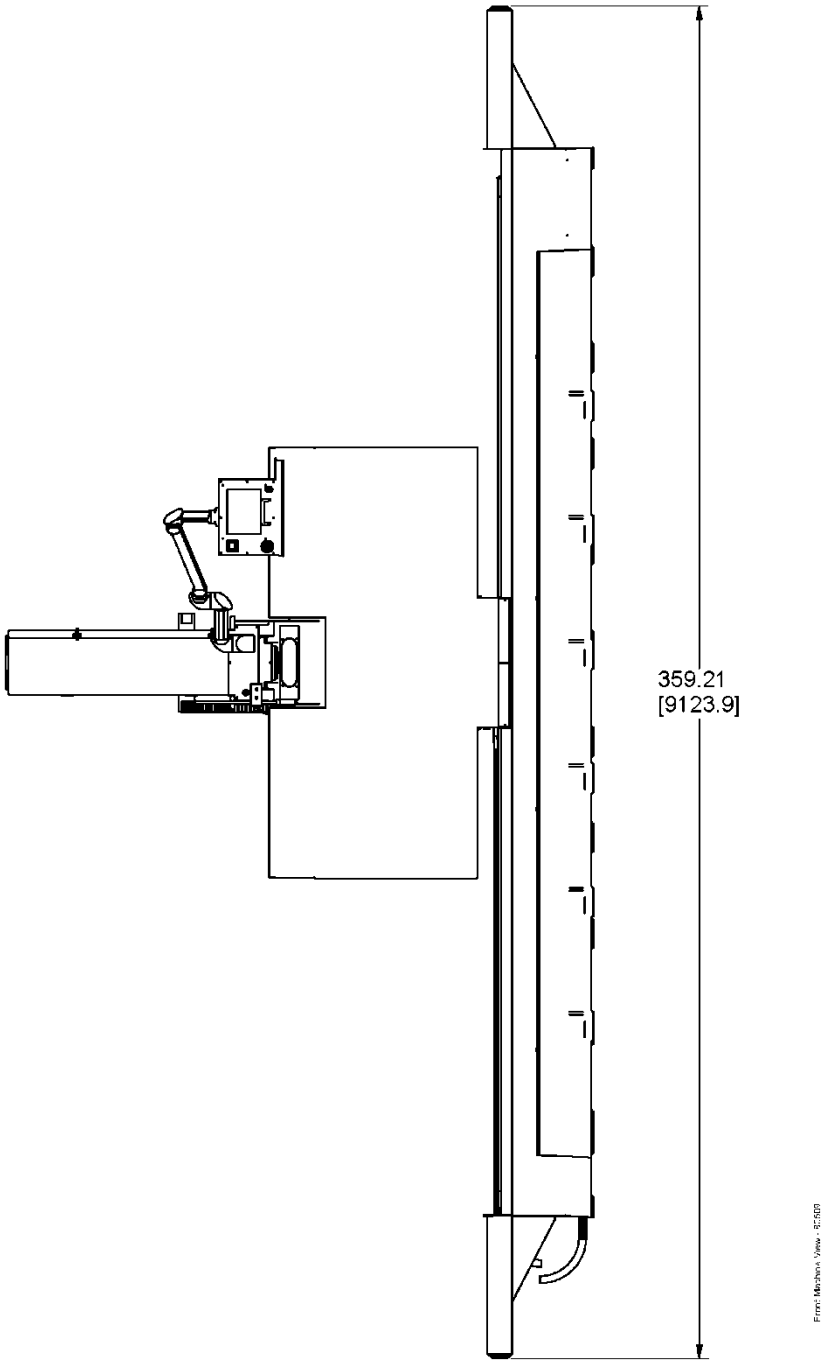
Use the same RT series inserts as defined under cylinder boring. Depending on type of toolholder, either ¼” (6.35 mm) IC or 3/8” (9.52 mm) IC inserts will be required. Commonly 1/64” (.8 mm) radius inserts are used for rough or heavy cutting, and 1/32” (.4 mm) radius inserts are used for finish boring for a smooth surface finish. In extreme conditions were the material is hard or the tool is extended and prone to chatter, use the 1/64” (.8 mm) inserts.

CONNECTING ROD INSERTS

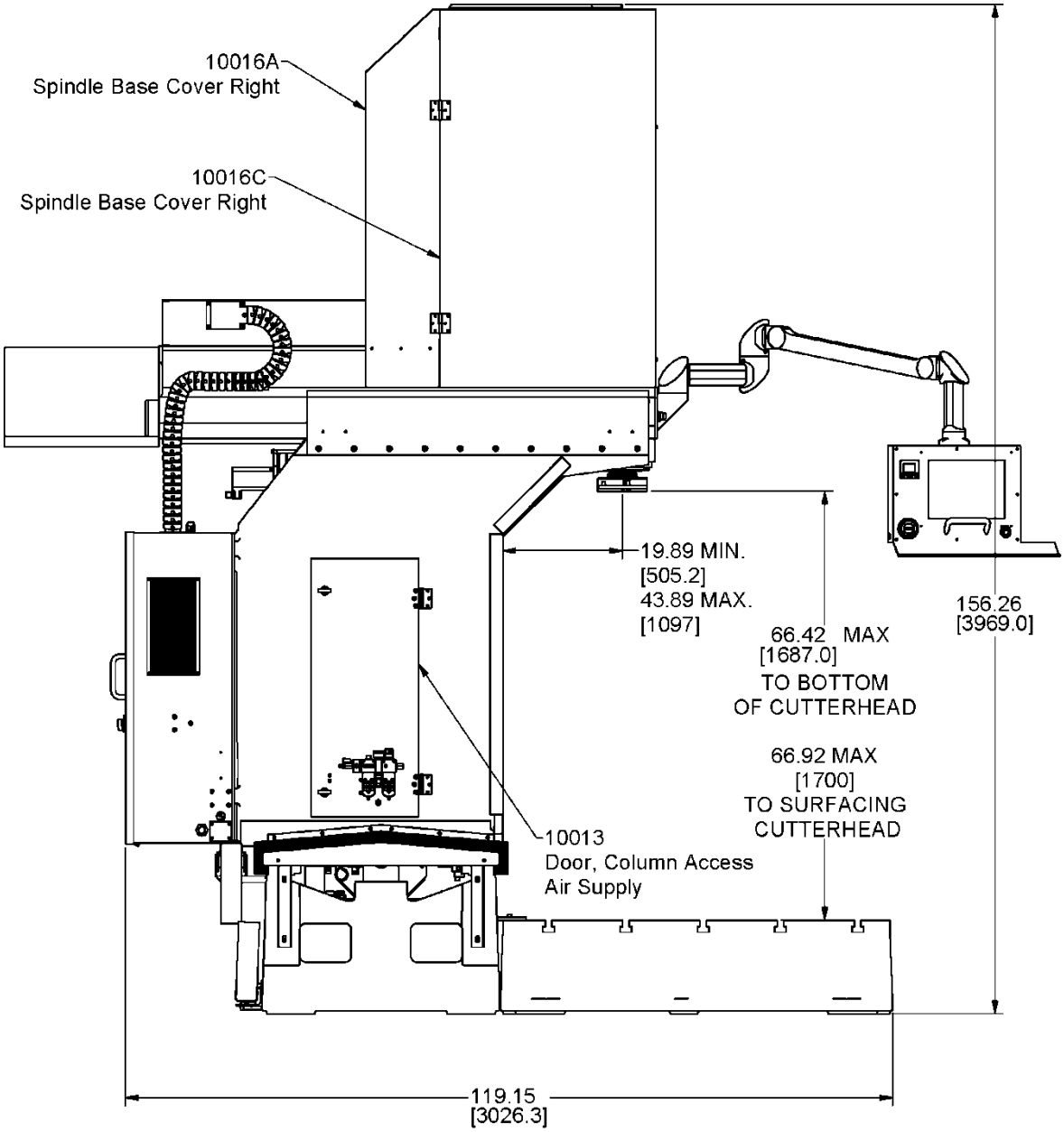
Many customers have reported good results boring connecting rods with Rottler RT inserts. When boring small end bearings made of bronze, the RTF series of inserts should be used.

Machine Parts:

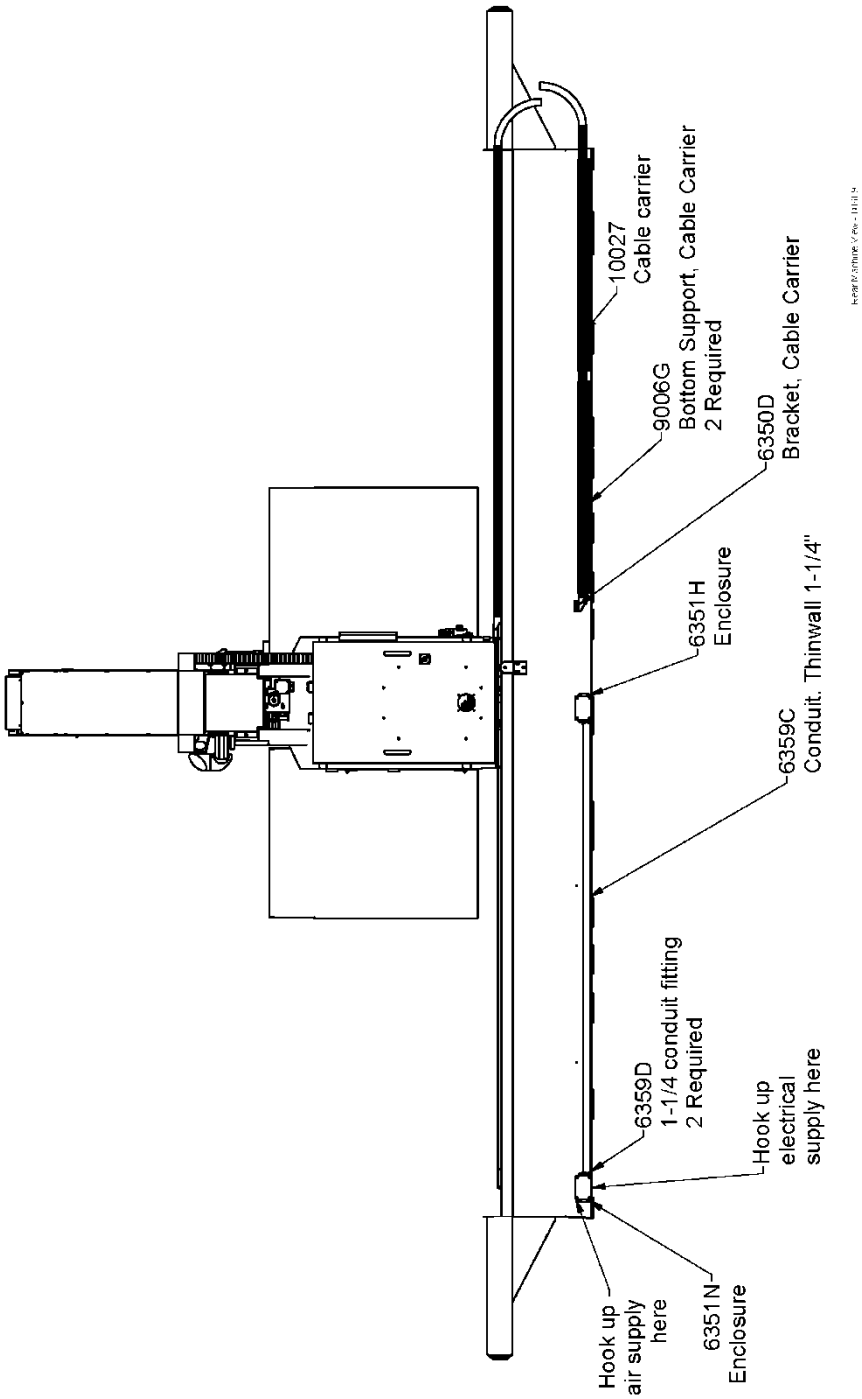
F109 Front View:



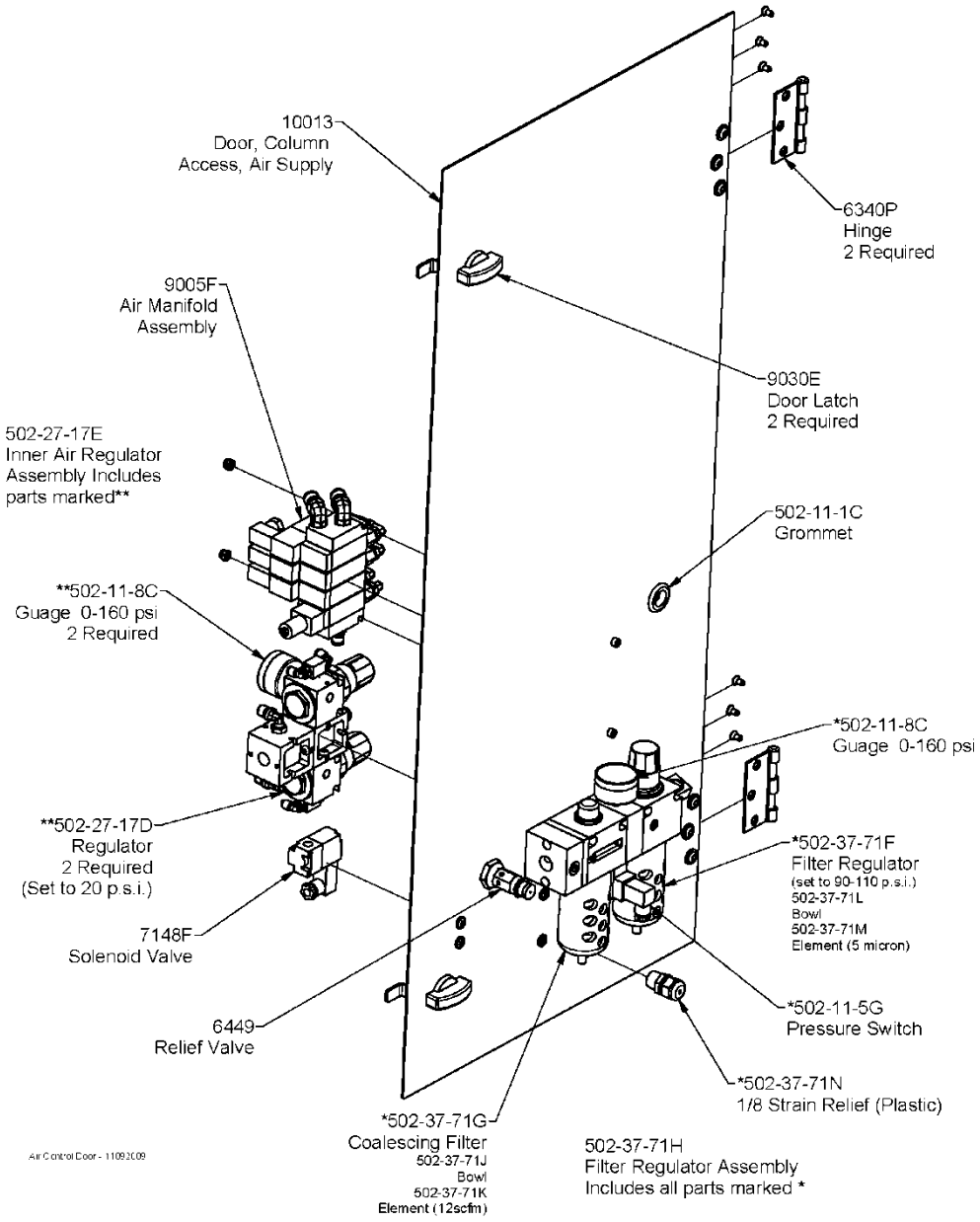
F109 Left Side View:



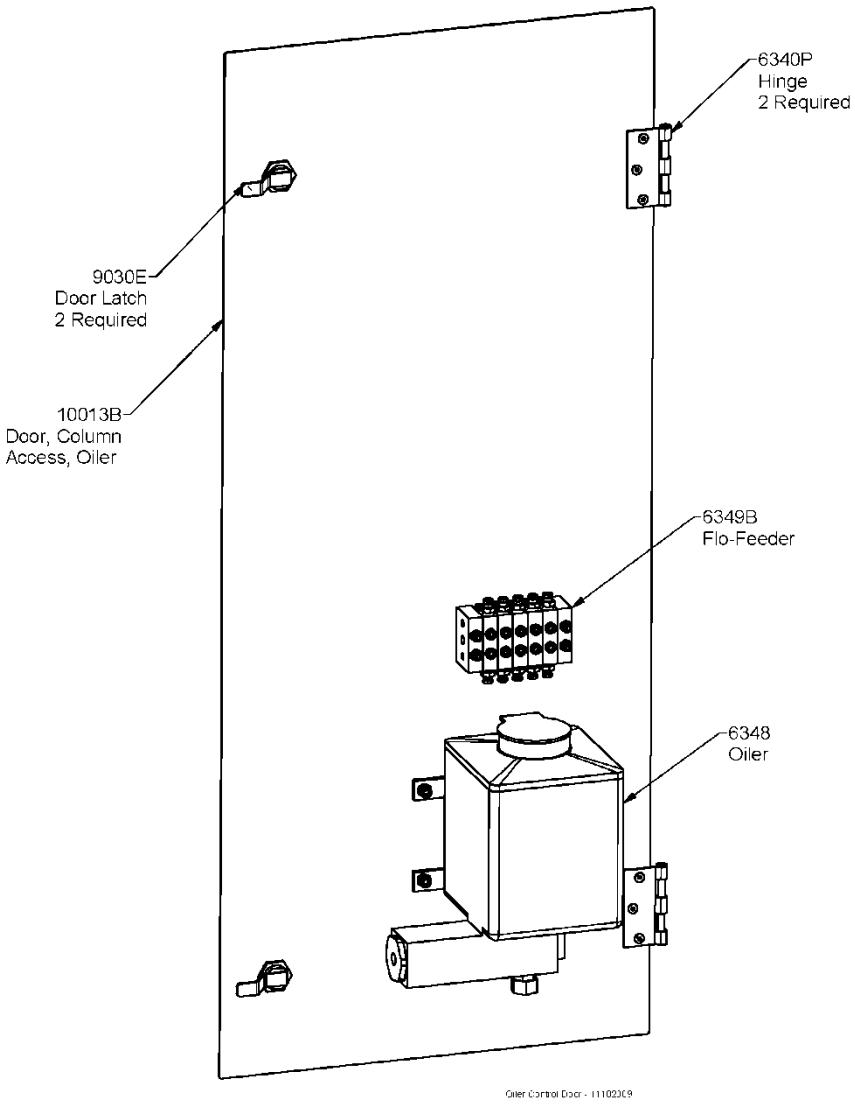
F109 Rear View:



Air Control Door:

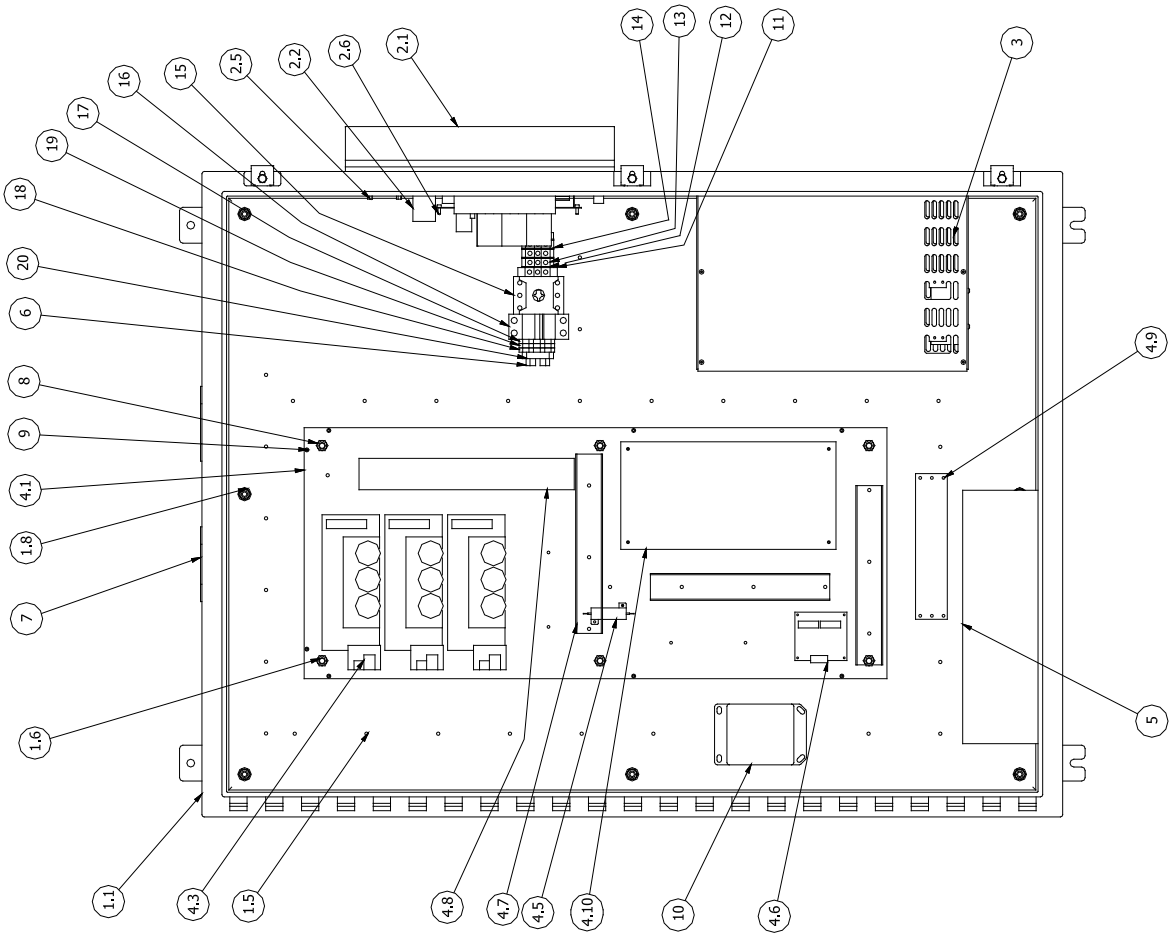


Oiler control Door:



Oiler Control Door - 11102309

Electrical Enclosure F109 Series:

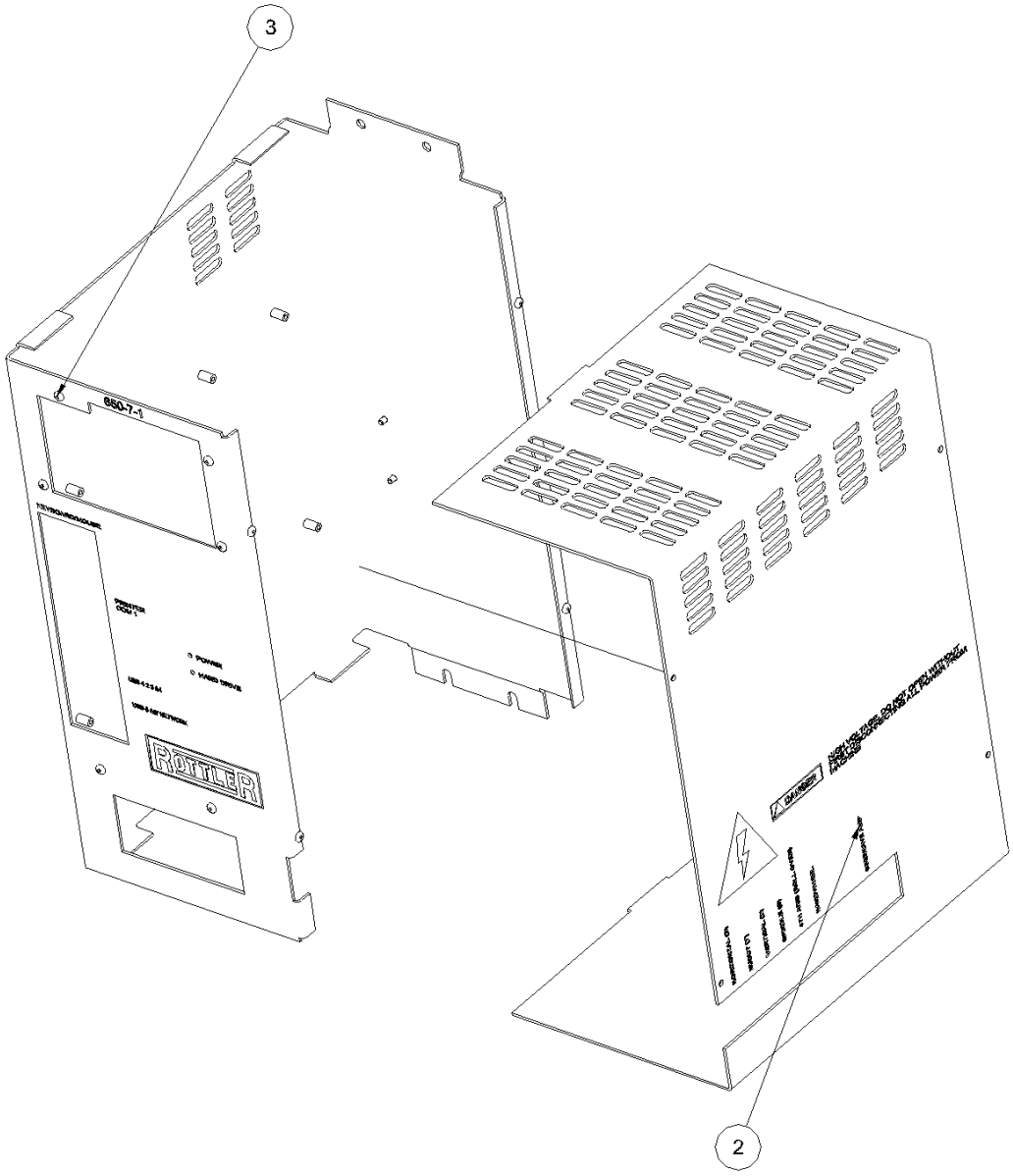


Rear Enclosure Parts List

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	9023E	Rear Enclosure Assembly
1.5	1	9023F	Panel
1.6	6	ANSI B18.3 - 3/8 - 16 UNC - 1 3/4	Hexagon Socket Head Cap Screw
1.7	12	ANSI B18.2.2 - 3/8 - 16	Hex Jam Nut
1.8	8	IFI - I0.375 - 16	Hex Flange Nut
2	1	Heat Sink Spindle Amp Assembly	
2.1	1	9023H	Spindle Heat Sink
2.2	1	9023J	F90Y Spindle Amp
2.3	1	9023K	Spindle Amp Cover
2.4	1	650-1-28H	Cross Flow Fan
2.5	1	6486R	Braking Resistor 50 OHM, 1000 Watts
2.6	9	ANSI B18.3 - 6-40 UNF - 0.375	Hexagon Socket Head Cap Screw
3	1	650-1-27M	Computer Assembly, Complete
4	1	F99Y Drive Assembly	
4.1	1	650-1-27S	F67A Heat Sink
4.2	1	650-1-27R	F67A Drive Cover
4.3	5	650-1-27N	Dm Axis Drive
4.4	1	6486P	Charge Resistor 100 OHM 50 Watt
4.5	1	9023M	Thermal Board
4.6	4	6554L	Wire Track
4.7	1	6554M	Wire Track Cover
4.8	1	650-1-28H	Cross Flow Fan
4.9	1	9023R	Relay Board
5	1	650-5-3	Power Var
6	1	504-35-3F	Din Rail
7	2	9023P	IGUS Mounting Bracker
8	6	ANSI B18.2.2 - 3/8 - 16	Hex Nut
9	8	ANSI B18.3 - 6-40 UNF - 0.375	Hexagon Socket Head Cap Screw
10	1	9023Q	Main Contactor
11	1	9022	Ground Terminal Block, Large
12	1	9022A	Terminal Block End, Ground
13	3	9022B	Terminal Blcok, Large, Blue
14	3	9022E	End Barrier, Terminal Block Large
15	1	650-5-1	Disconnect Switch
16	1	504-35-3Q	Breaker, 3 Amp
17	1	514-7-74E	Ground Block
18	1	514-7-74C	Terminal Block, Blue
19	1	514-7-74D	Terminal Block, Grey
20	2	504-35-3M	End Cap

REFF90Y13-05162006

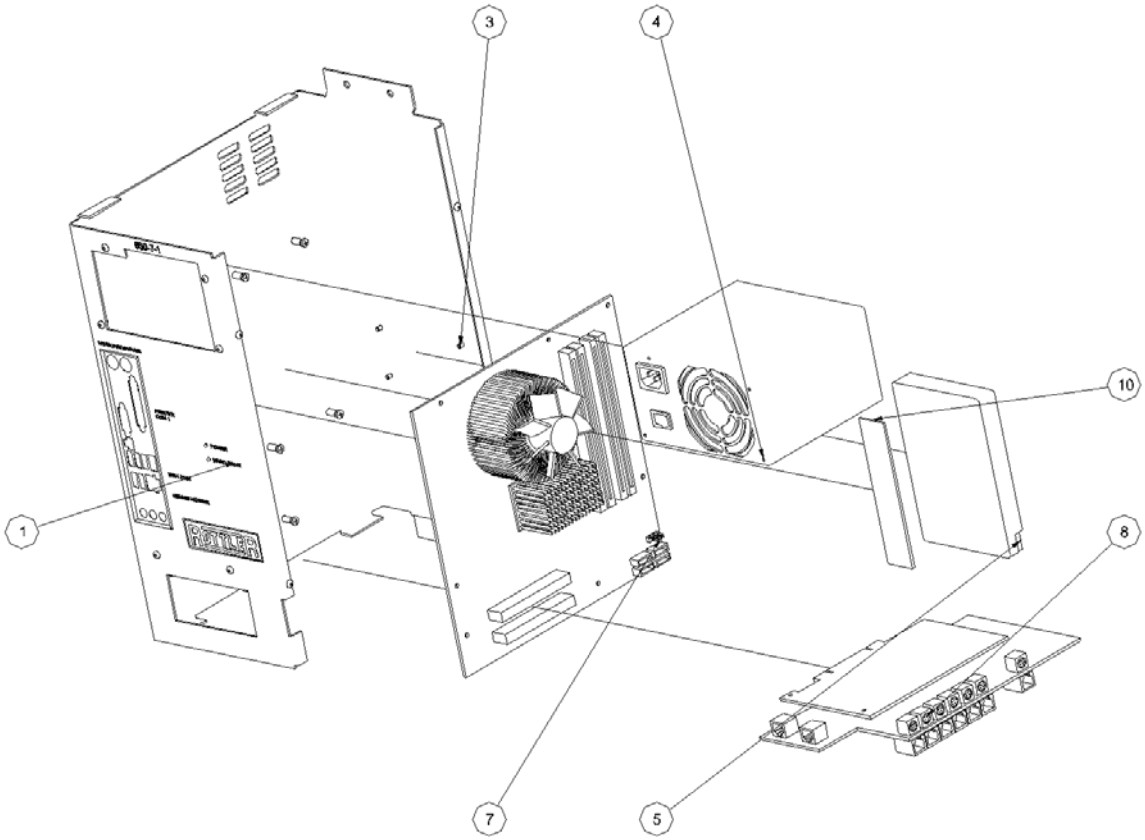
650-1-27X Computer Enclosure Assembly:



REFF90Y19-02092007

Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	650-1-27Y	Computer Case, Front
2	1	650-1-27Z	Case, Computer, Side

650-7-1 Computer Components:



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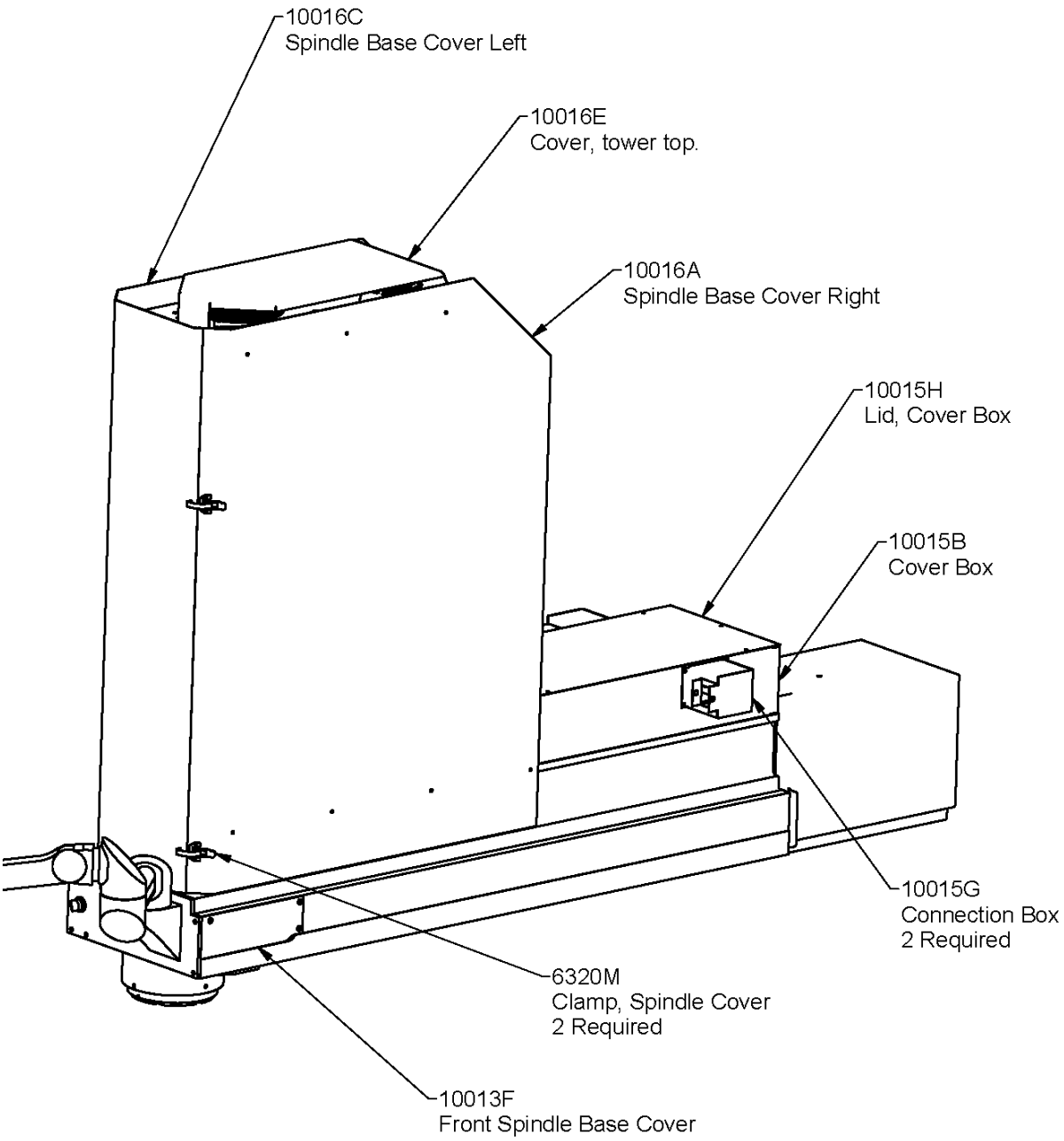
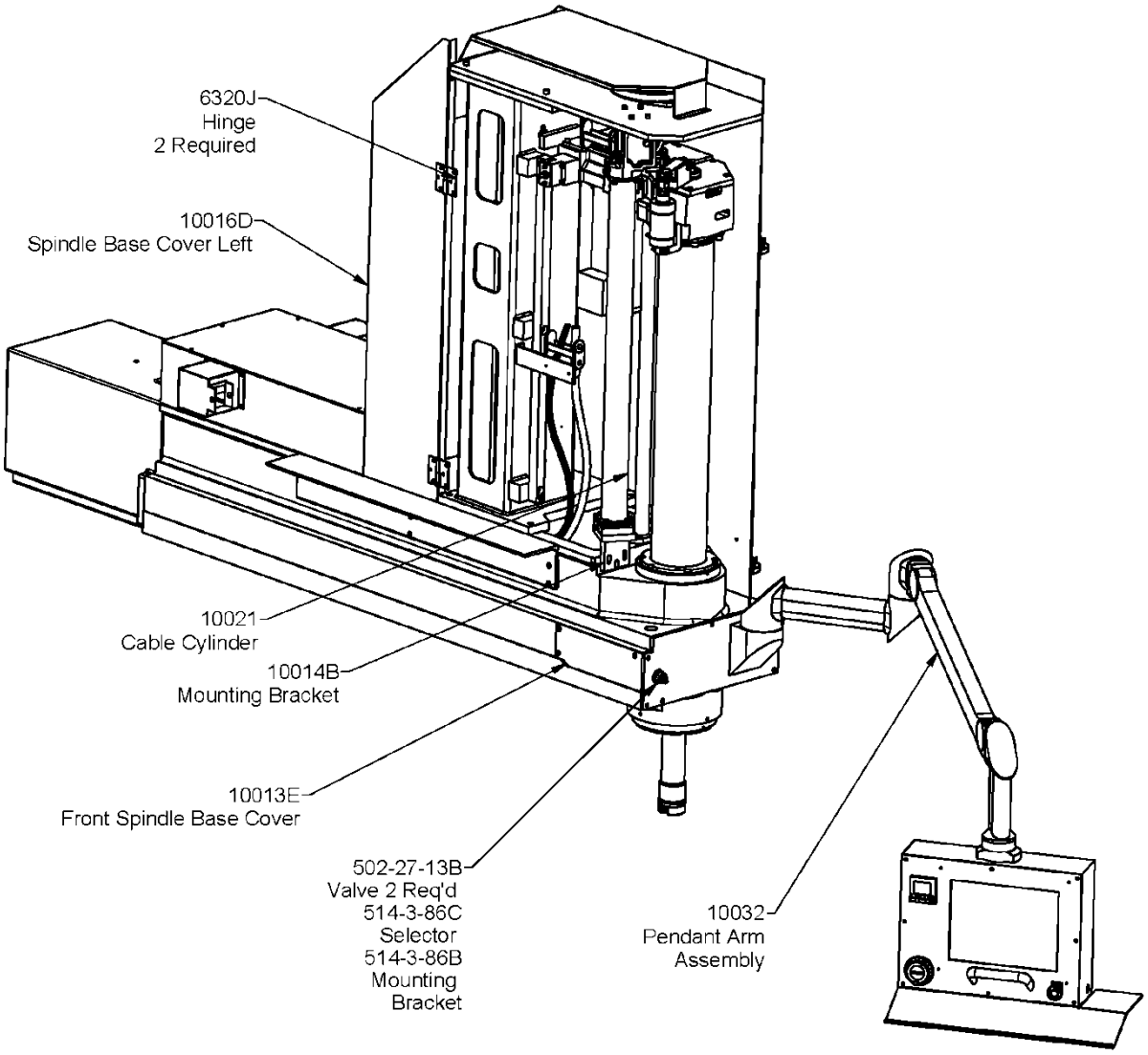
Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	650-1-27Y	Computer Case, Front
2	1	650-1-27Z	Case, Computer, Side
4	1	650-7-1C	Power Supply
5	1	650-7-1F	Hard Drive
7	1	650-6-1A	Mother Board
8	1	650-1-27Q	PCI Card
9	2	650-1-29F	Bracket, PCI Card
10	1	650-7-1B	512 Mb DDR2 RAM

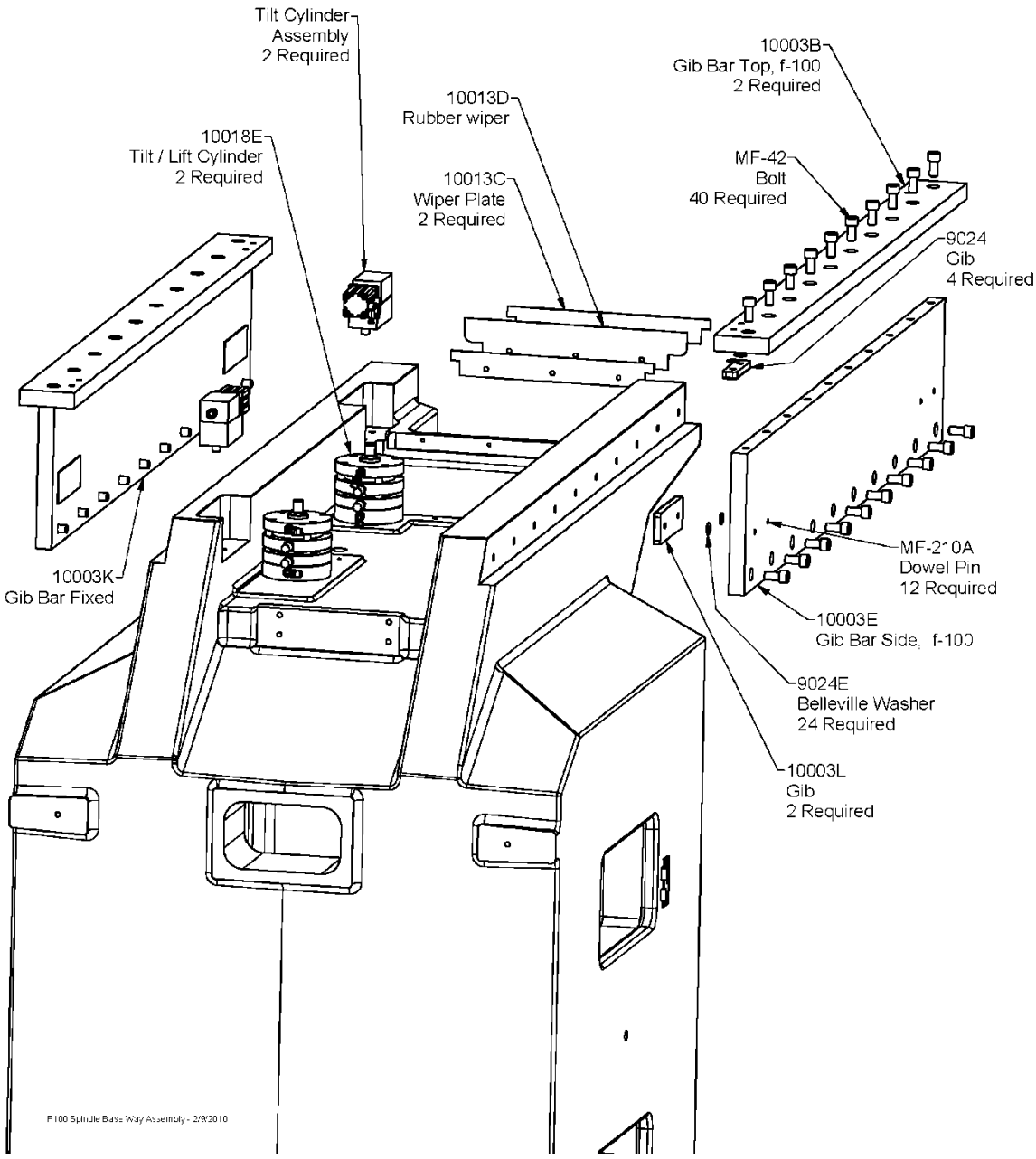
Spindle Base, Right Side:



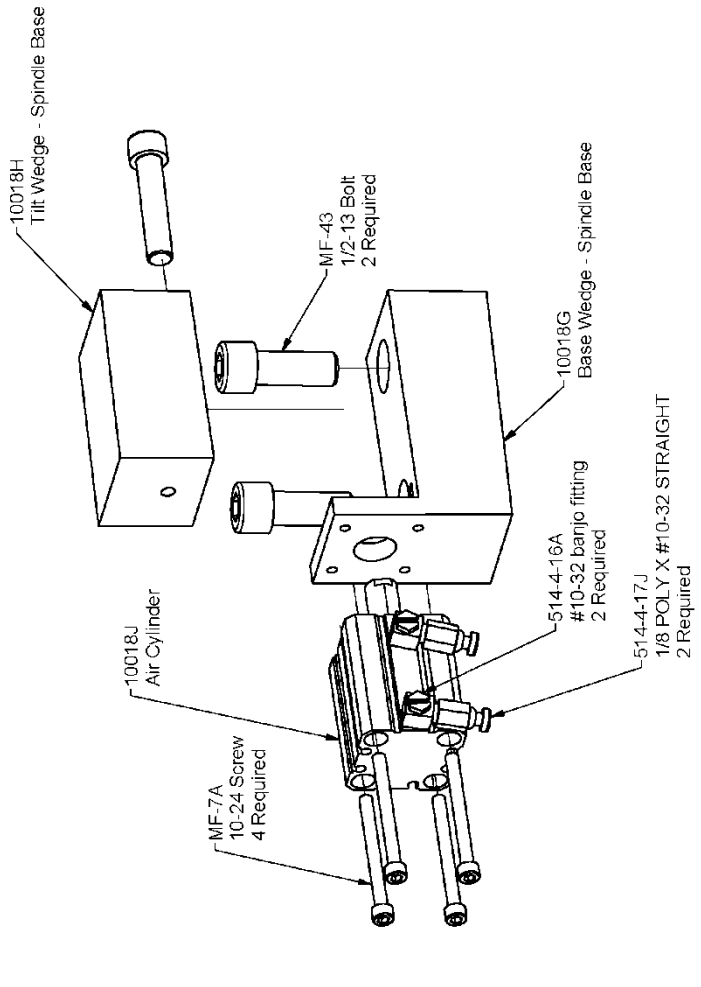
Spindle Base, Left Side:



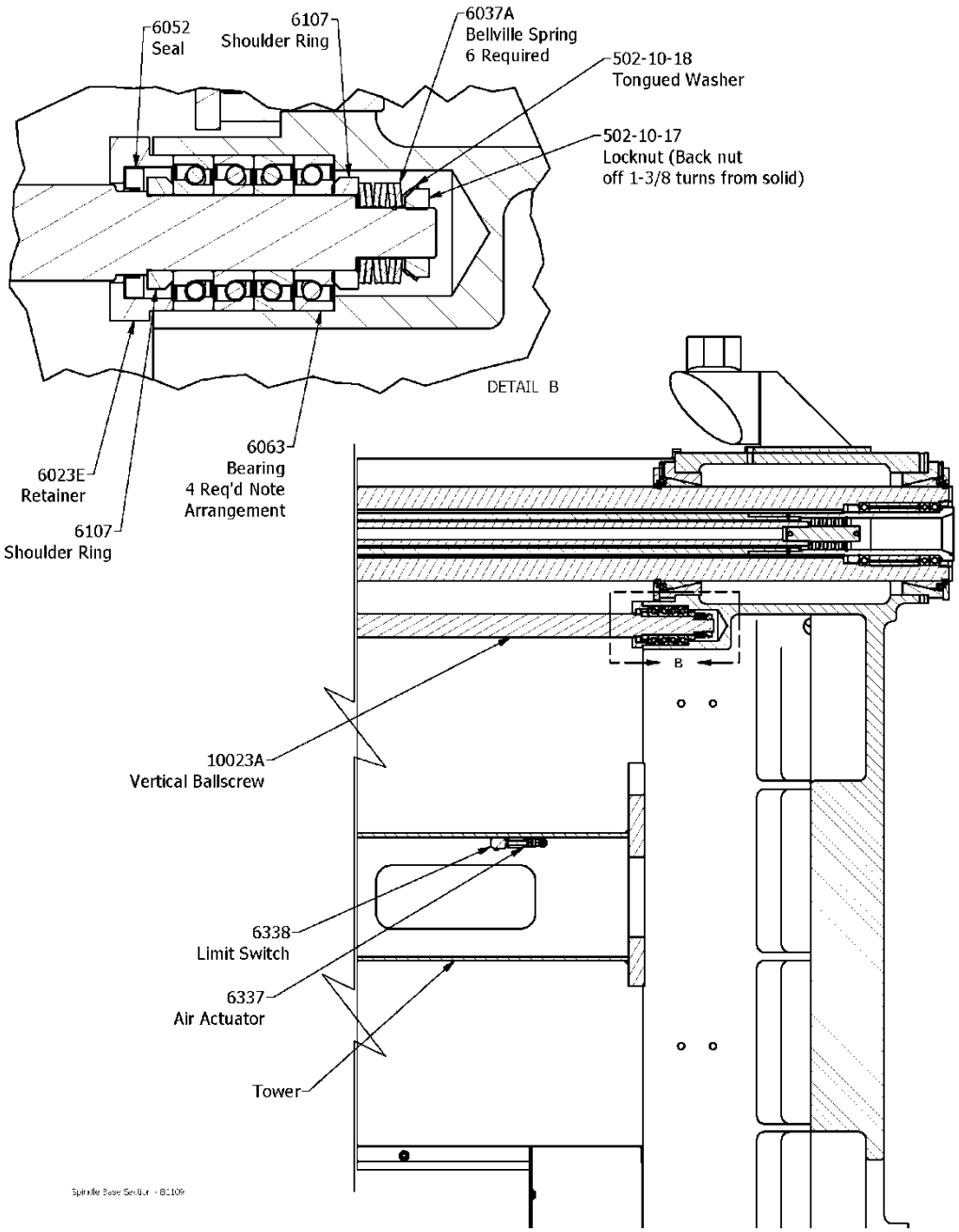
Column


Tilt Cylinder
Assembly
2 Required
10018E
Tilt / Lift Cylinder
2 Required
10013D
Rubber wiper
10013C
Wiper Plate
2 Required
10003B
Gib Bar Top, f-100
2 Required
MF-42
Bolt
40 Required
9024
Gib
4 Required
10003K
Gib Bar Fixed
MF-210A
Dowel Pin
12 Required
10003E
Gib Bar Side, f-100
9024E
Belleville Washer
24 Required
10003L
Gib
2 Required
F100 Spindle Base Way Assembly - 2/9/2010

Tilt Wedge Assembly:

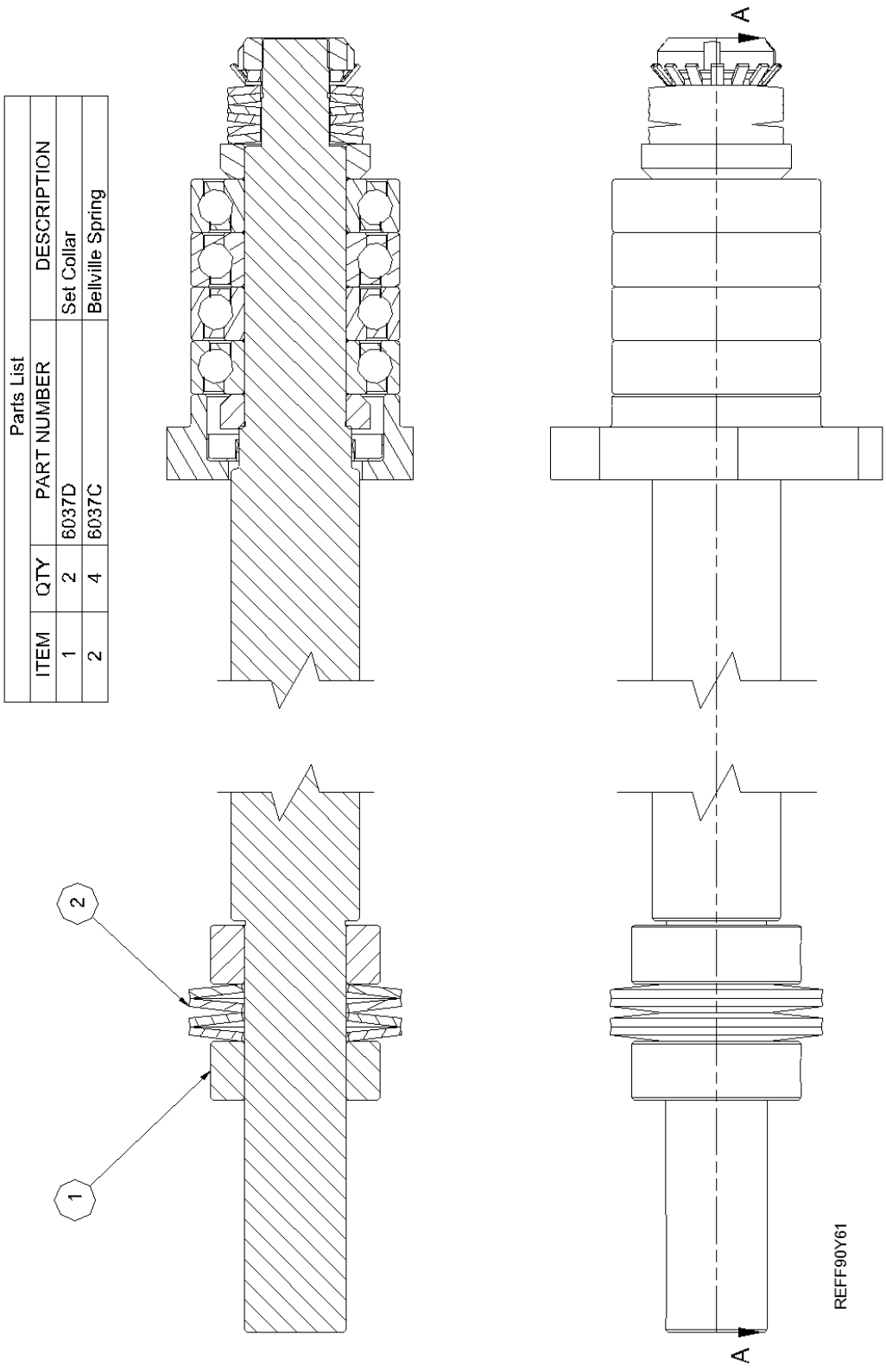


Vertical Ballscrew Assembly:

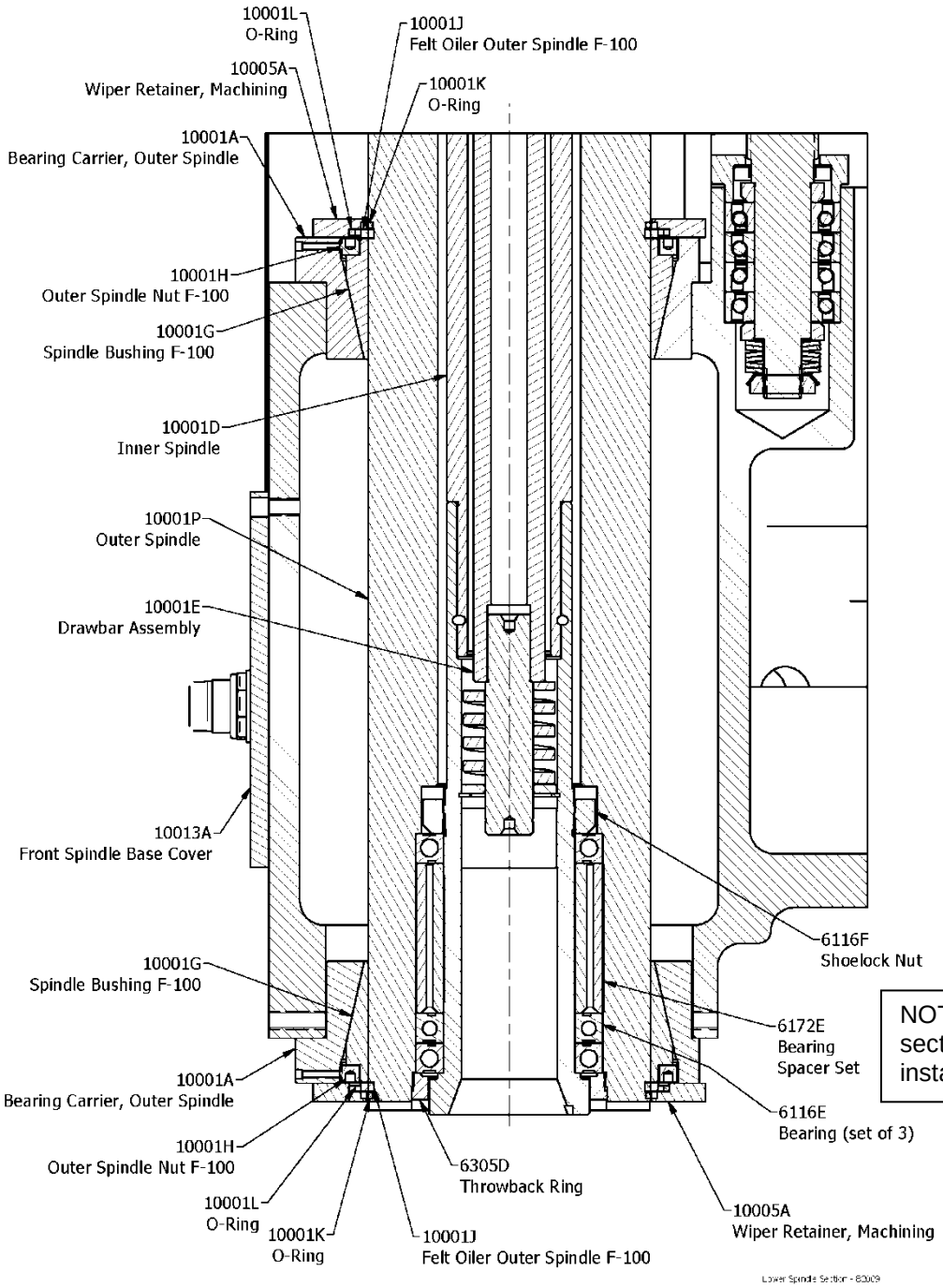


Vertical Ballscrew Bumper Package:

Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	6037D	Set Collar
2	4	6037C	Bellville Spring

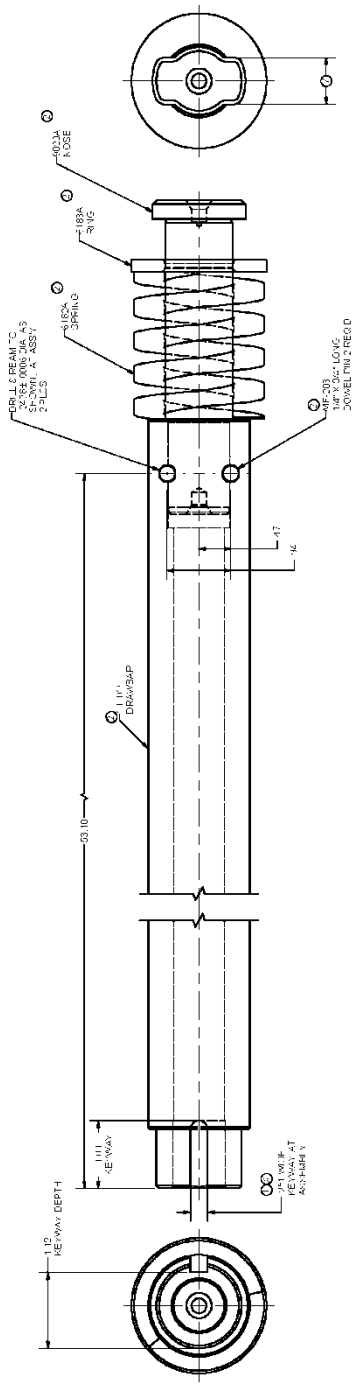


Lower Spindle:



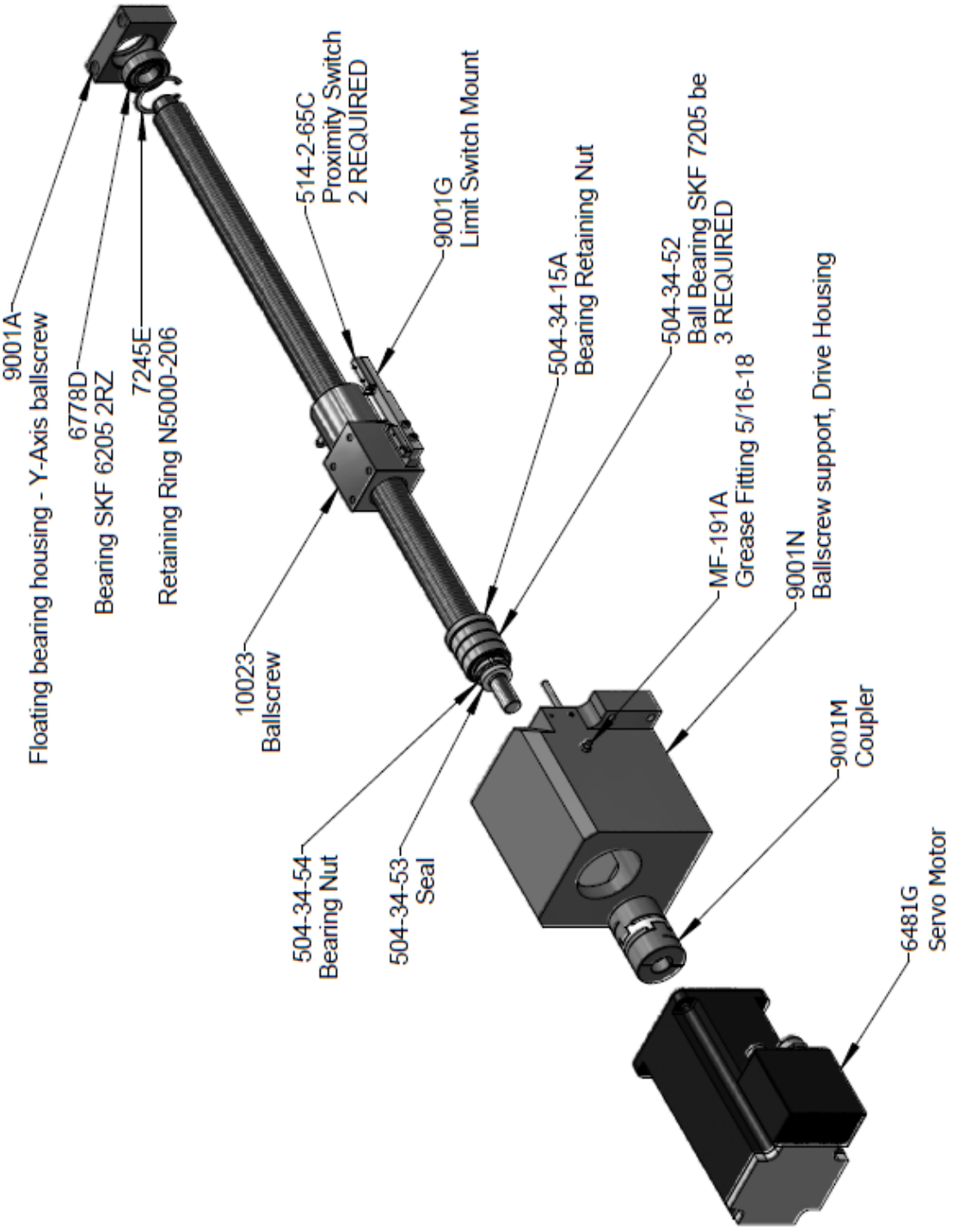
NOTE: See maintenance section for correct bearing installation procedure.

Draw Bar / Centering Assembly:

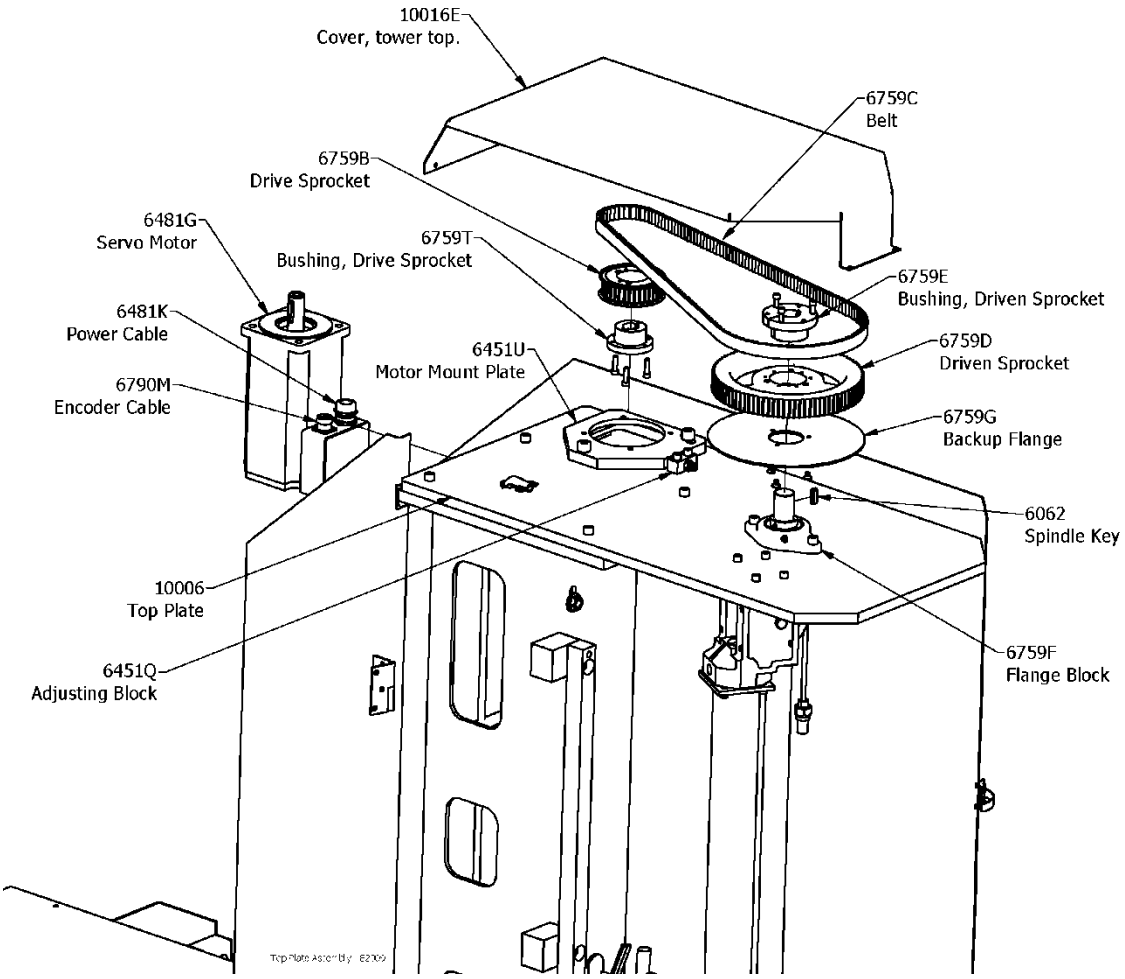


Y-Axis Ballscrew Drive:

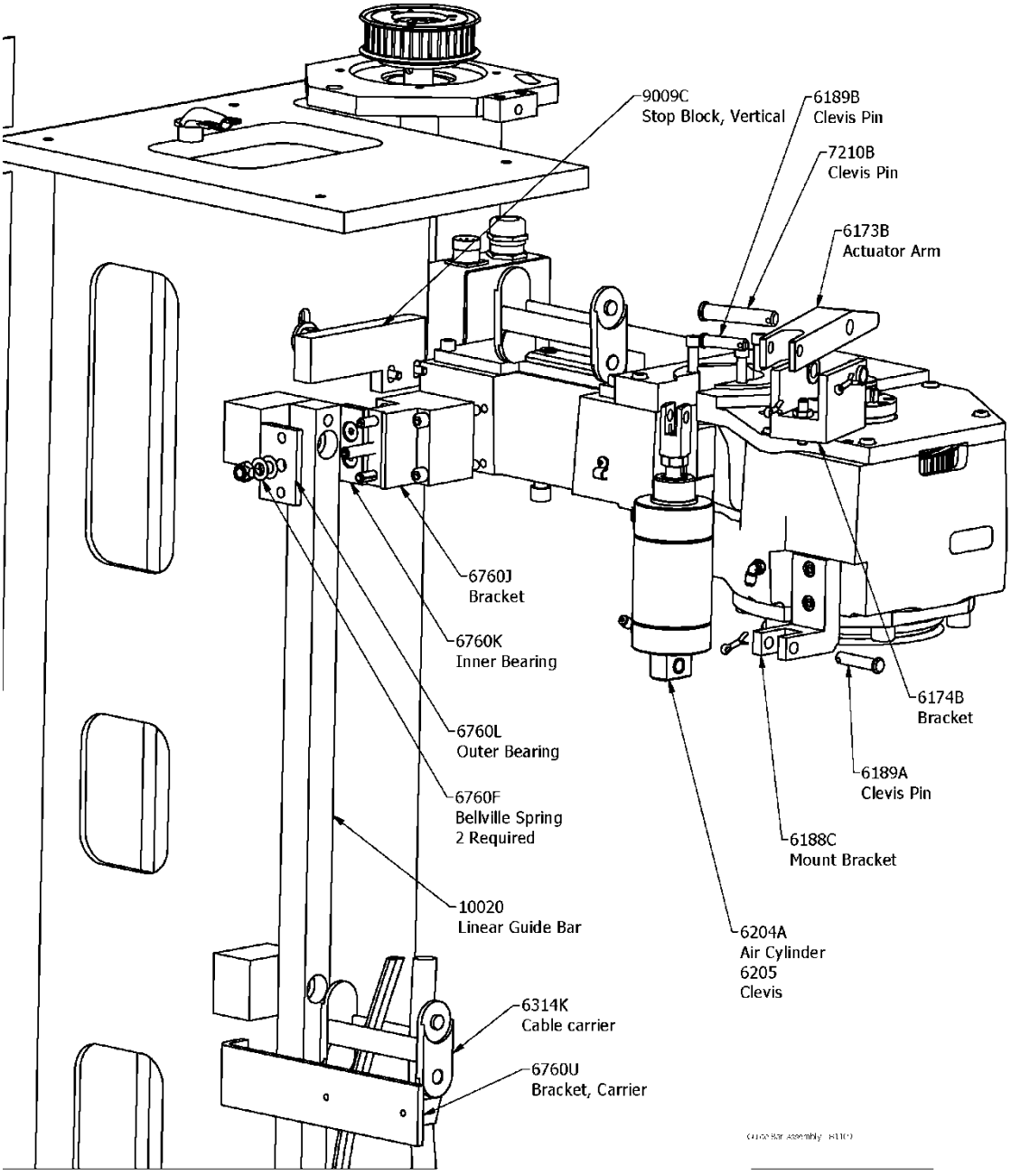
Y-Axis Ball Screw, Direct Drive:



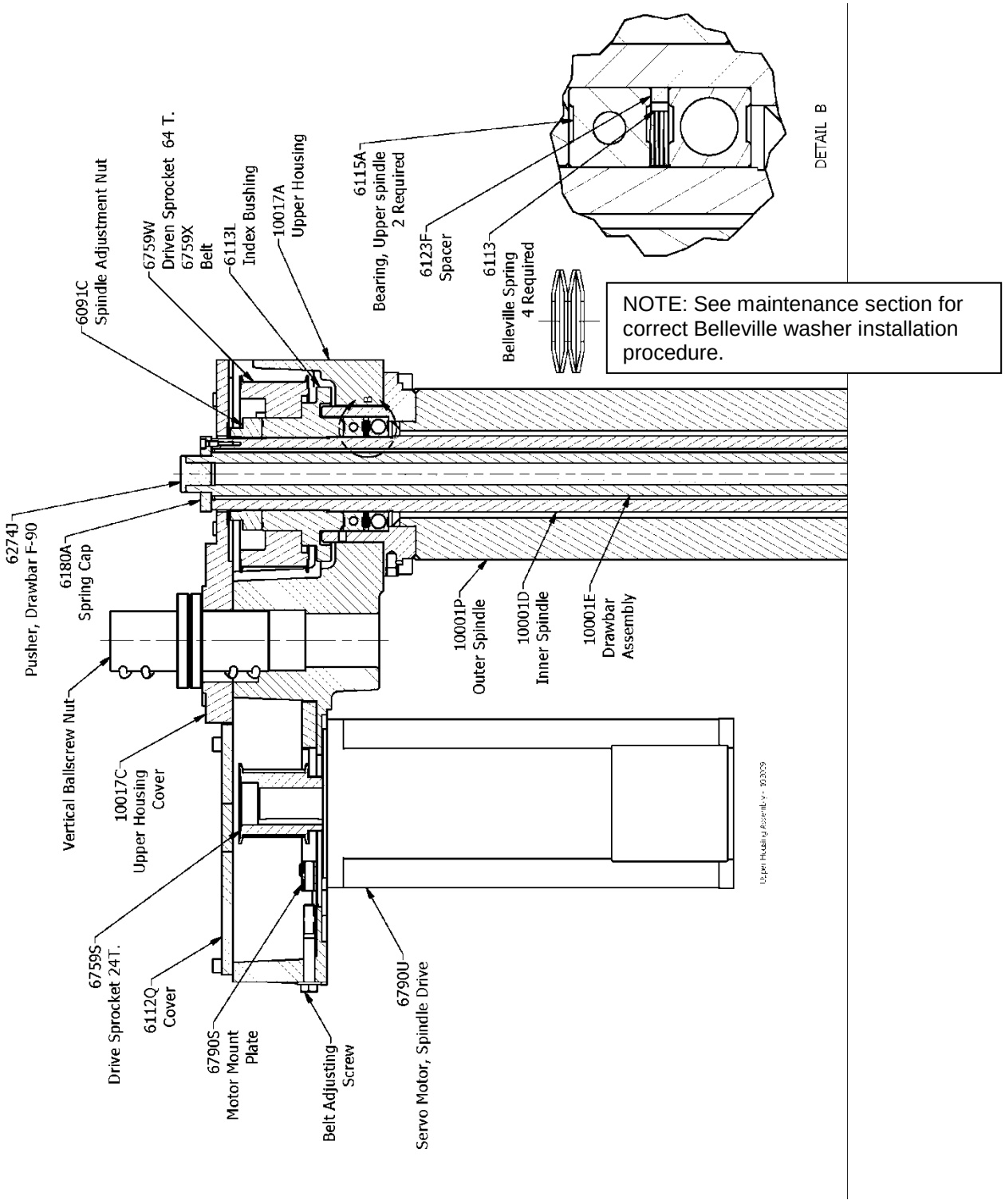
Top Plate Assembly:



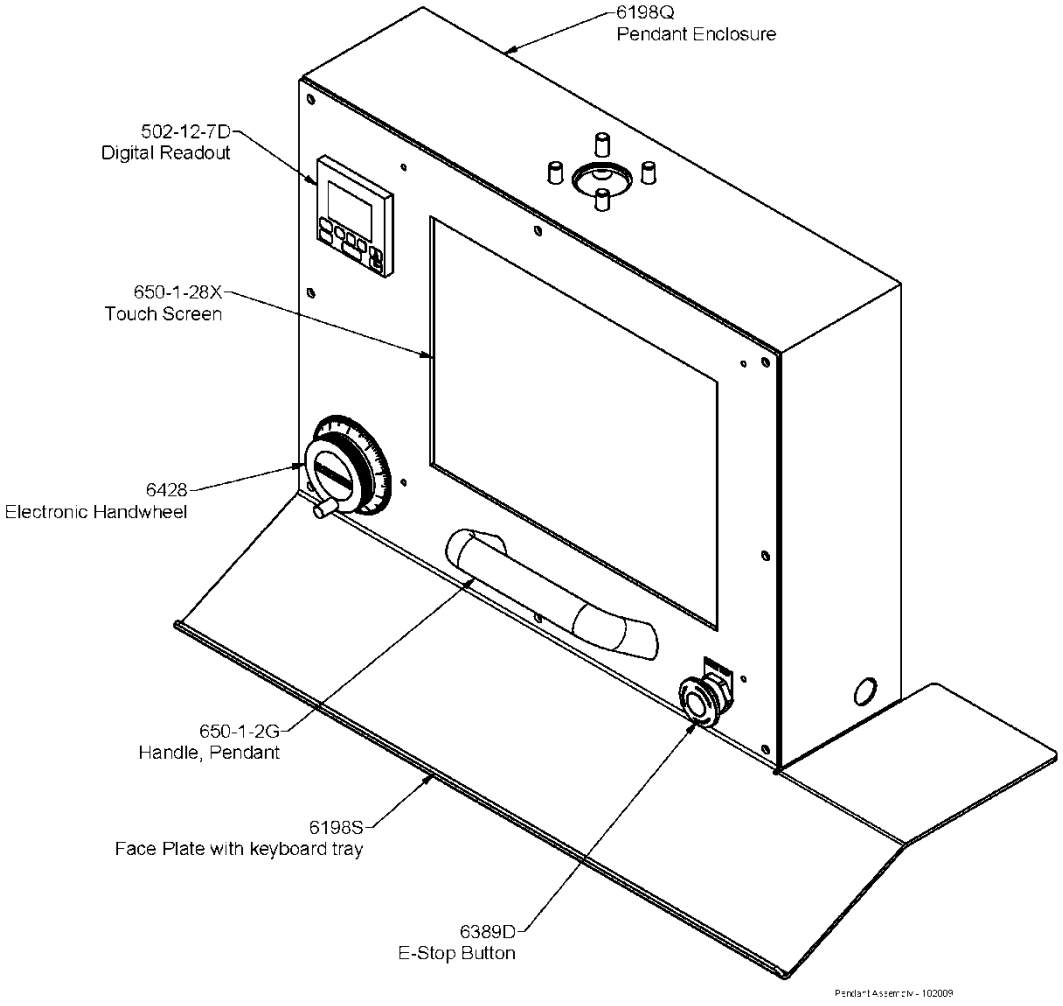
Guide Bar Assembly:



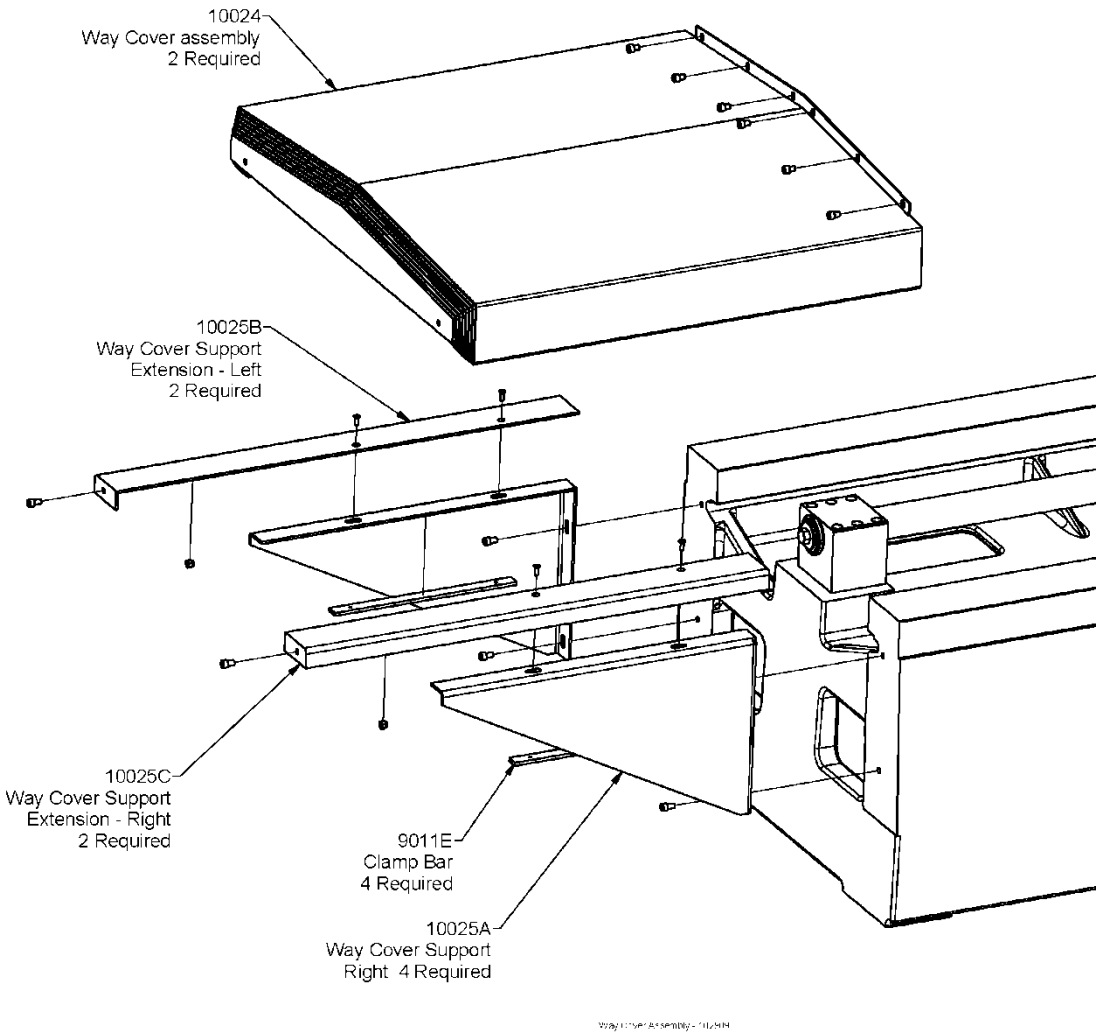
Upper Housing tower Guide:



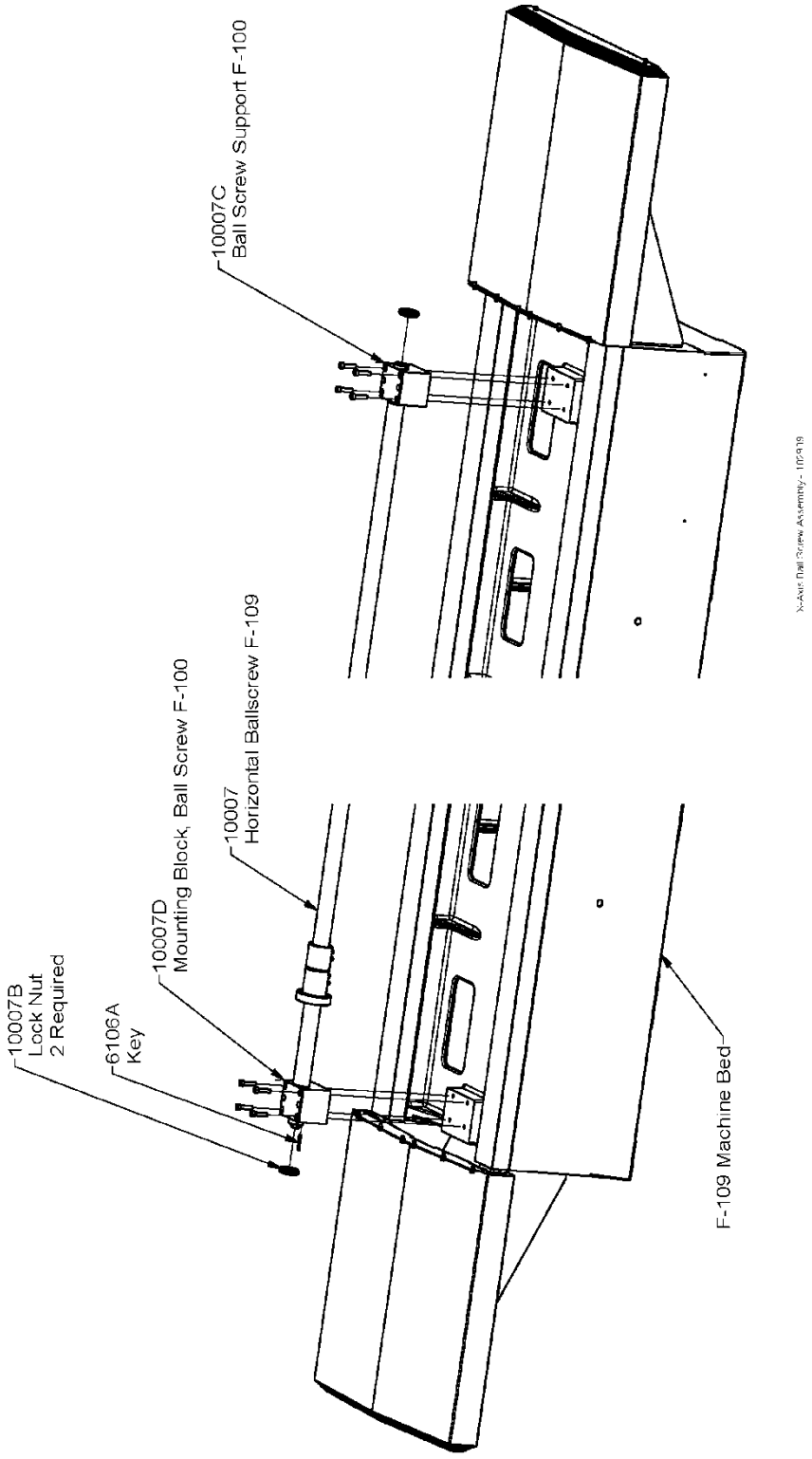
Pendant Assembly:



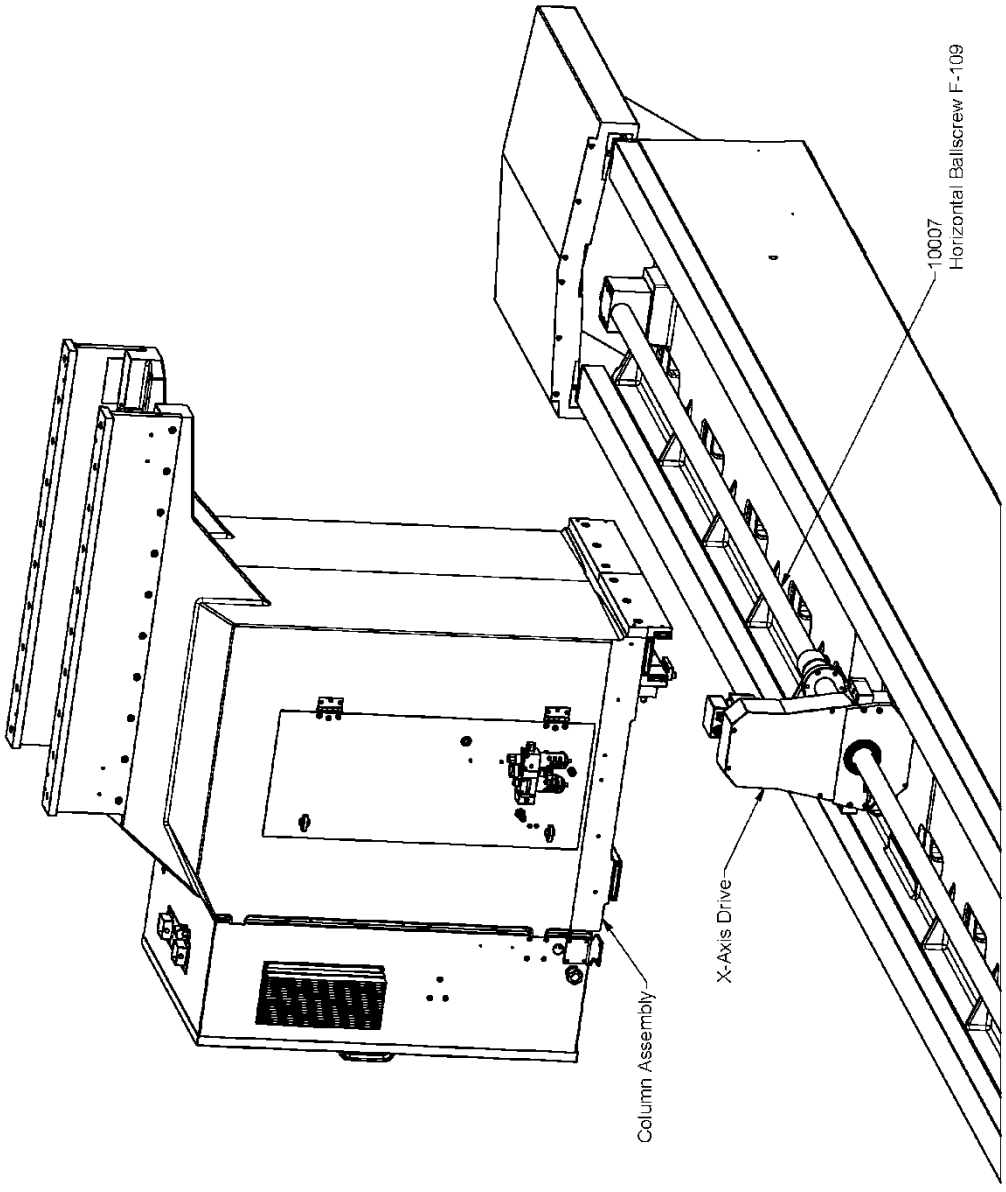
Way Cover Assembly:



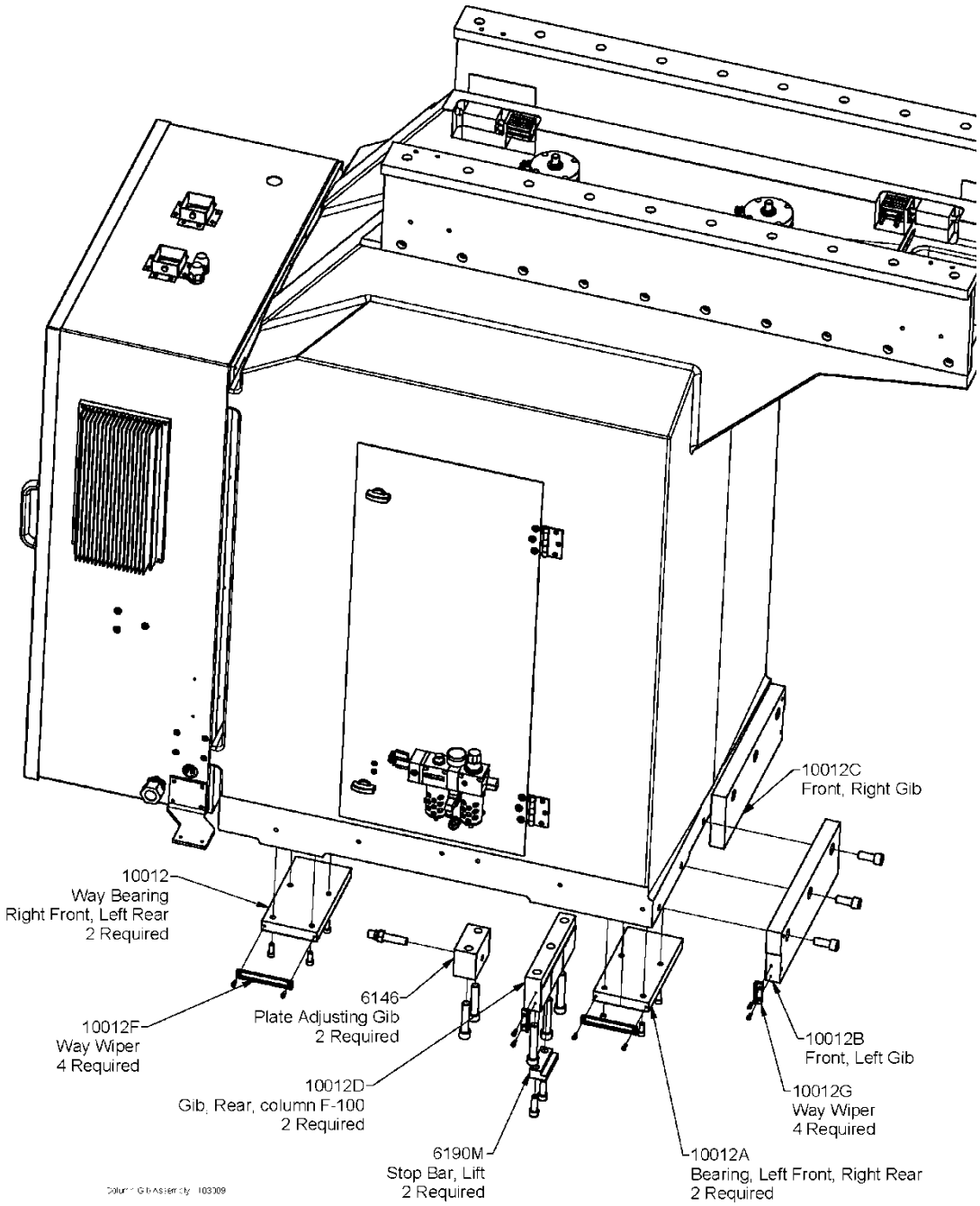
X-Axis Ballscrew Assembly:



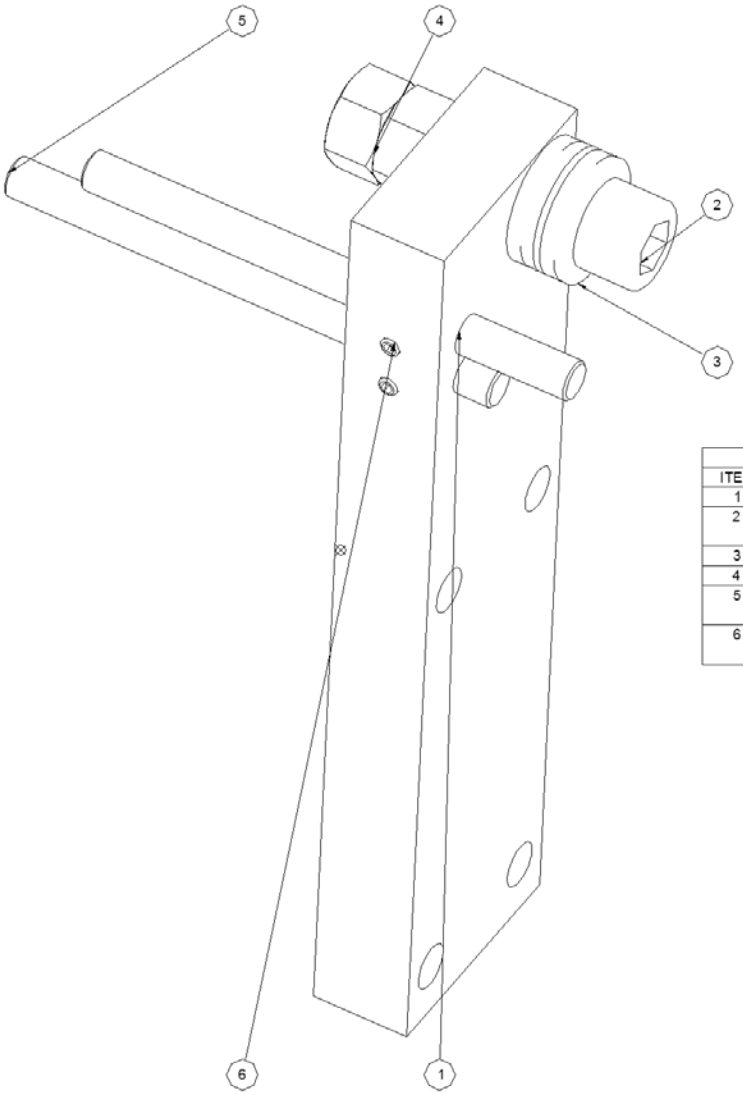
Machine Column Bed Assembly:



Column Gib Assembly:



Horizontal End Stop Bumper Package:



Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	9010A	Stop Bracket - F-90
2	1	ANSI B18.3 - 3/4 - 10 UNC - 3	Hexagon Socket Head Cap Screw
3	7	6037A	Bellville Spring
4	2	ANSI B18.2.2 - 3/4 - 10	Hex Nut
5	2	9010C	Stop Rod - Column travel F-90
6	2	ANSI B18.3 - 1/4-20 UNC x 0.38	Hexagon Socket Set Screw - Flat Point

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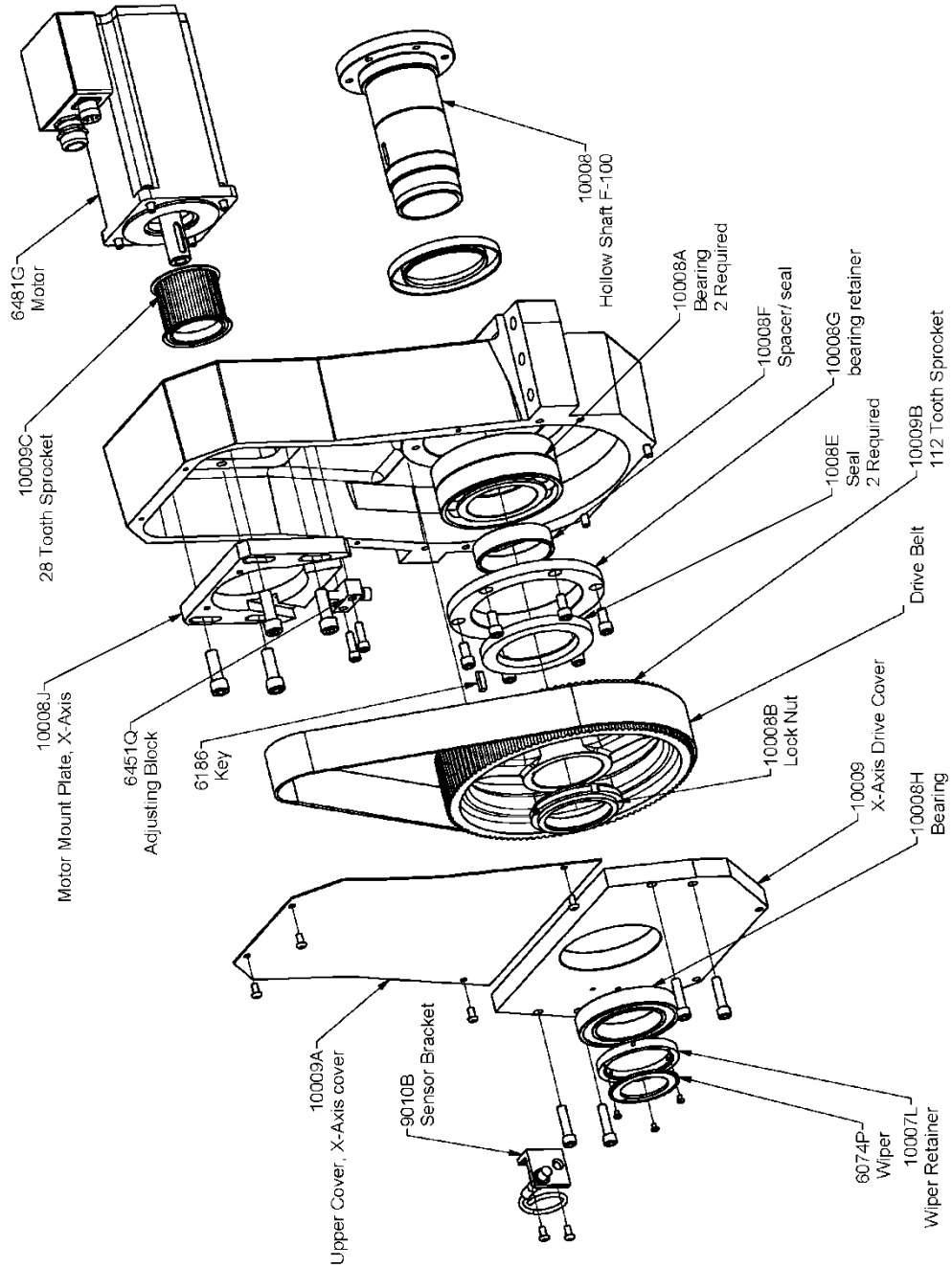
Column Belt Drive Assembly:



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Options

Options and Tooling are in separate manuals.

Material Safety Data Sheets