

ROTTLER

THE CUTTING EDGE H75 OPTIONAL EQUIPMENT PARTS MANUAL



ORDERING PROCEDURE

Contact your regional Rottler sales rep for assistance in ordering optional equipment, replacement parts, or tooling.

If you are unable to contact your regional Rottler sales rep, call the factory at 253-872-7050 and ask to speak to the parts sales specialists.

Have the following information handy to expedite the ordering process:

1. Your name, business name, and contact number
2. Customer number
3. If you don't have a customer number, your billing address
4. Shipping address if different from billing address
5. Machine model and serial number
6. Part number and description of what you want to order
7. Preferred method of shipment

You may also contact us via e-mail with the above information. Send e-mail requests to: parts@rottermfg.com

In some cases you may be requested to send a photo of the part you are ordering if it is a replacement part, or doesn't appear in the database.

If you are unsure which part you need to order, contact our service department and ask to speak to one of our service consultants. They will assist you in determining which part you require.

THERE IS A MINIMUM ORDER OF \$25.00

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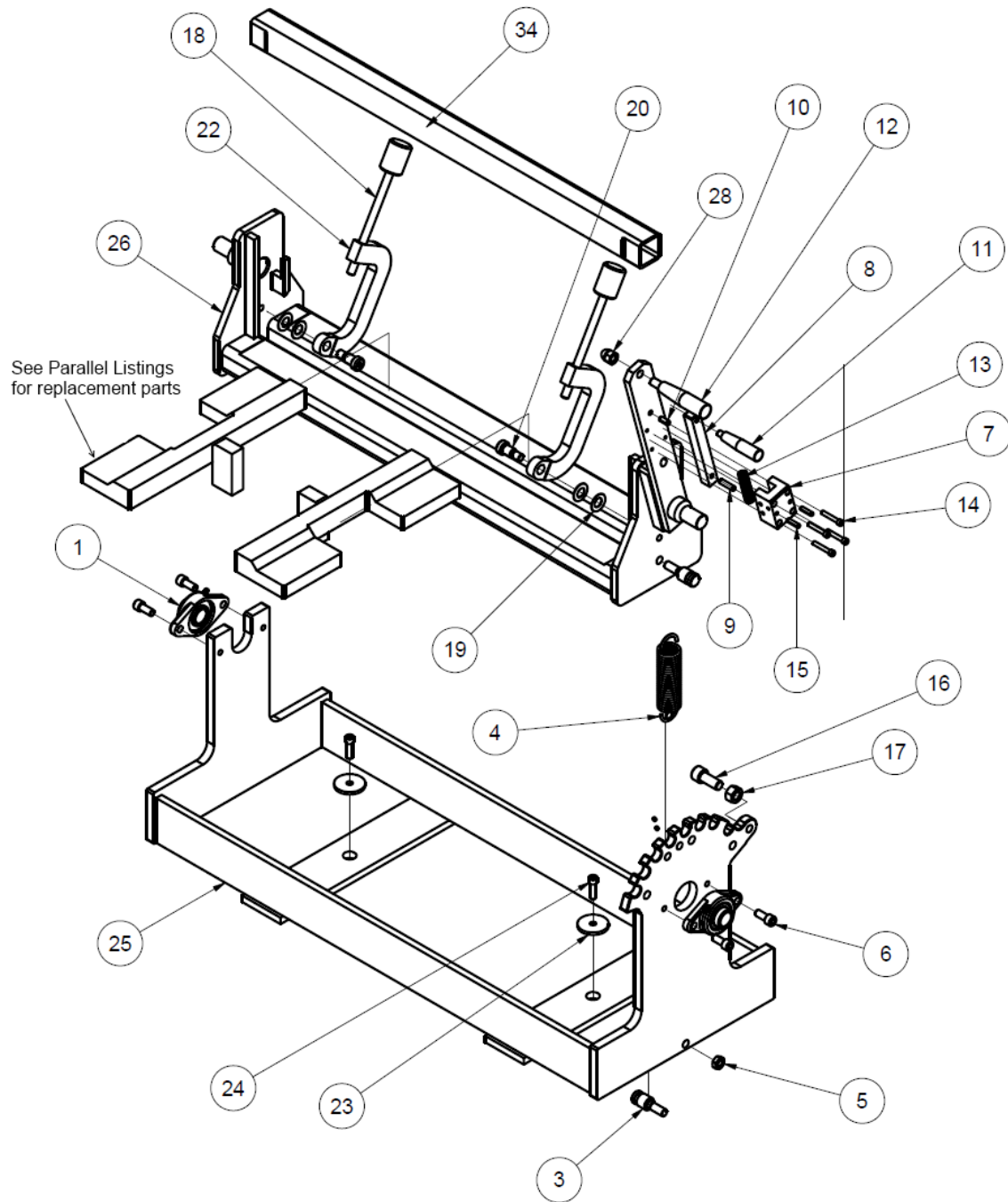
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FIXTURES

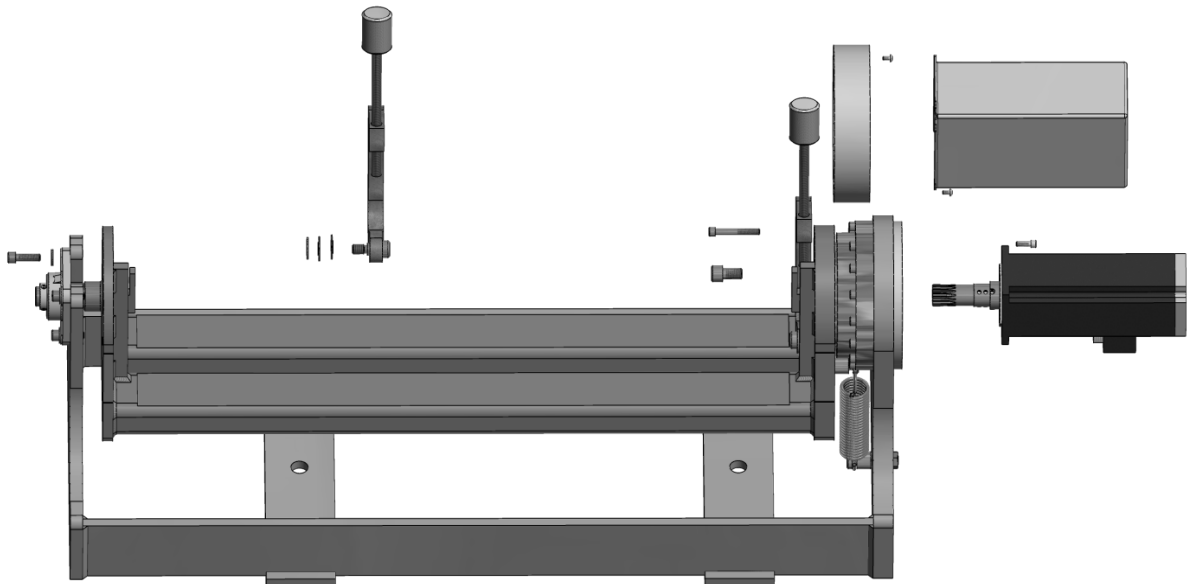
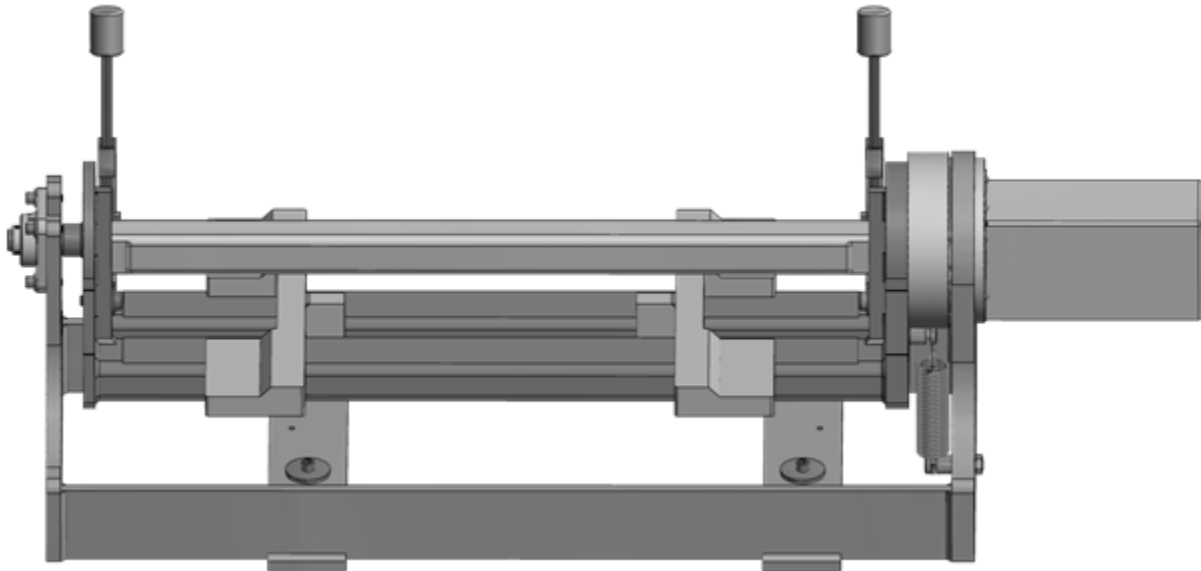
BLOCK FIXTURES

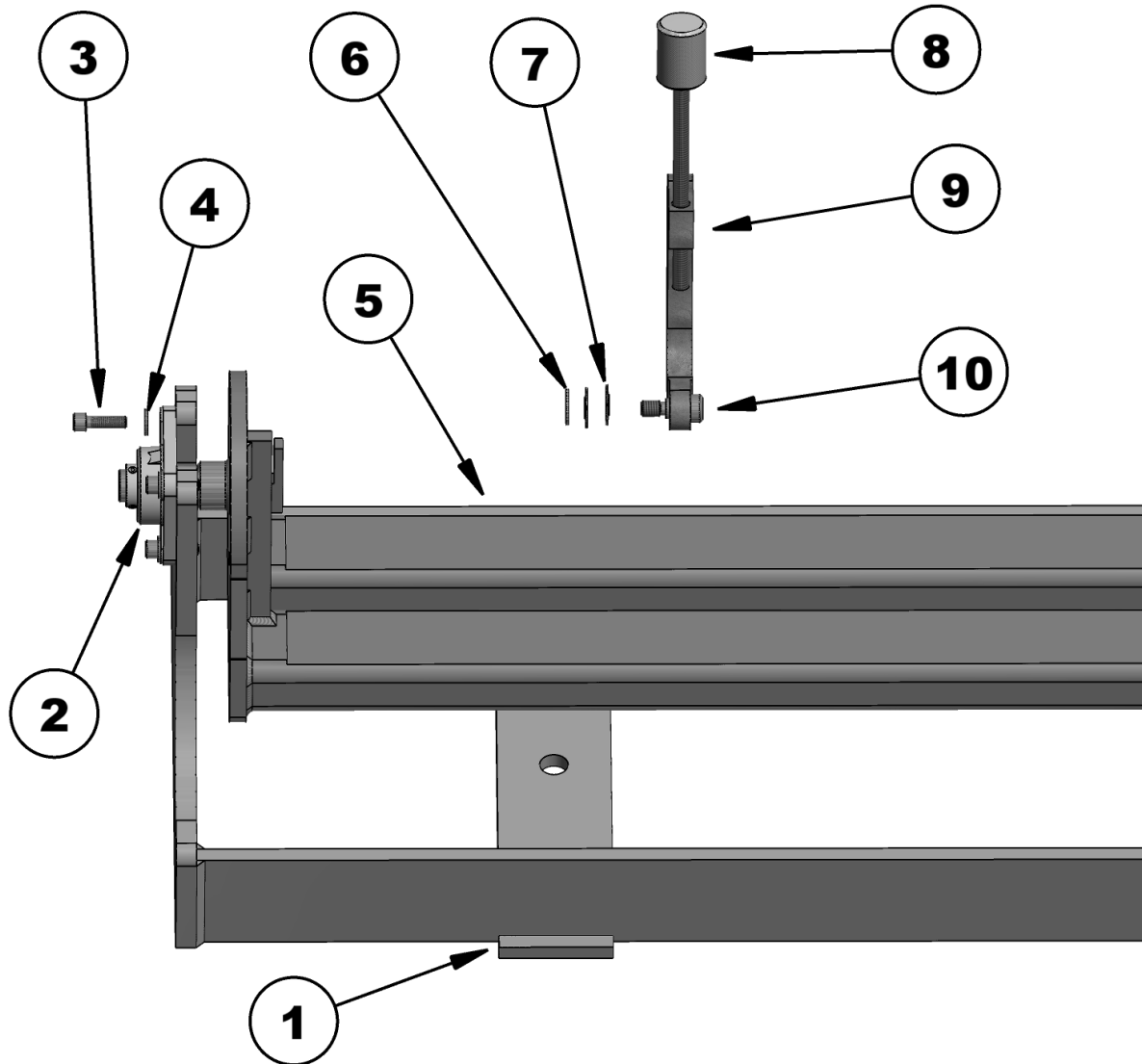
514-7C Manual Indexable Roll Over Fixture Parts

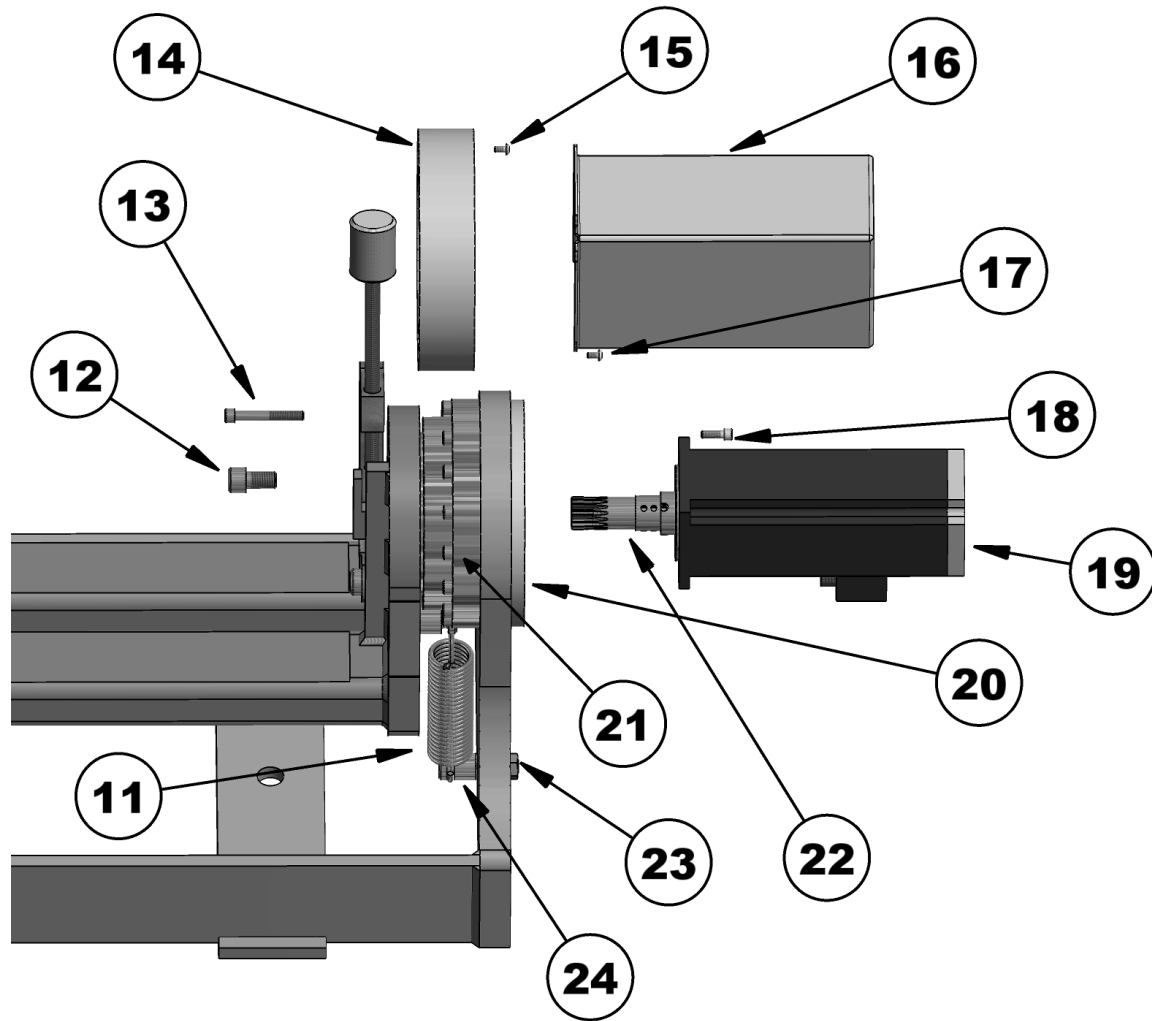


514-7C BLOCK HOLD DOWN FIXTURE ASSEMBLY - HONE			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	514-7-13	BLOCK, FLANGE, BLOCK HOLDDOWN FIXTURE
3	2	514-3-72A	PIN, SPRING RETAINER, BLOCK HOLD DOWN FIXTURE
4	1	514-3-34A	SPRING, EXTENSION - BLOCK HOLD DOWN FIXTURE
5	2	MF-165	1/2-13UNC HEX NUT
6	4	MF-39	Hexagon Socket Head Cap Screw
7	1	514-3-56A	INDEX PIN SUPPORT - BLOCK HOLD DOWN FIXTURE HONE
8	1	514-7-9B	INDEX PIN - BLOCK HOLD DOWN FIXTURE - HONE
9	1	MF-227A	Pin - Slotted Spring
10	1	MF-227B	Pin - Slotted Spring
11	1	514-3-58A	HANDLE, INDEX - BLOCK HOLD DOWN FIXTURE - HONE
12	1	514-3-59B	HANDLE, PIVOT ARM - BLOCK HOLD DOWN FIXTURE & V6/V8 AIR FIXTURE
13	1	514-3-70	SPRING, HANDLE RETURN
14	4	MF-17	Hexagon Socket Head Cap Screw
15	2	MF-226	Pin - Slotted Spring
16	1	MF-46A	Hexagon Socket Head Cap Screw
17	1	MF-166	5/8-11UNC HEX NUT
18	2	7223	CLAMP ASSEMBLY - MANUAL V6/V8 COMB. FIXTURE
19	4	514-7-21	Bellville Spring
20	2	514-7-22A	5/8 x 3/4" LG. SOCKET SHOULDER SCREW
22	2	514-7-10A	CLAMP ARM (MACHINING), BLOCK HOLD DOWN FIXTURE - HONE
23	2	514-7-1C	WASHER, HOLDDOWN - BLOCK HOLDDOWN FIXTURE - HONE
24	2	MF-32	S.H.C.S.3/8 - 16 UNC - 1 1/4
25	1	514-7-1E	MAIN FRAME REDESIGN (MACHINING)
26	1	514-7-3C	CRADLE (MACHINING), BLOCK HOLD DOWN FIXTURE
27	2	514-7-15	SUPPORT, BLOCK - BLOCK HOLD DOWN FIXTURE
28	1	514-3-59C	1/2-13UNC ACORN NUT
35	2	514-3-56B	TERCITE PAD

514-13-14 Automatic Programmable Roll Over Fixture Parts

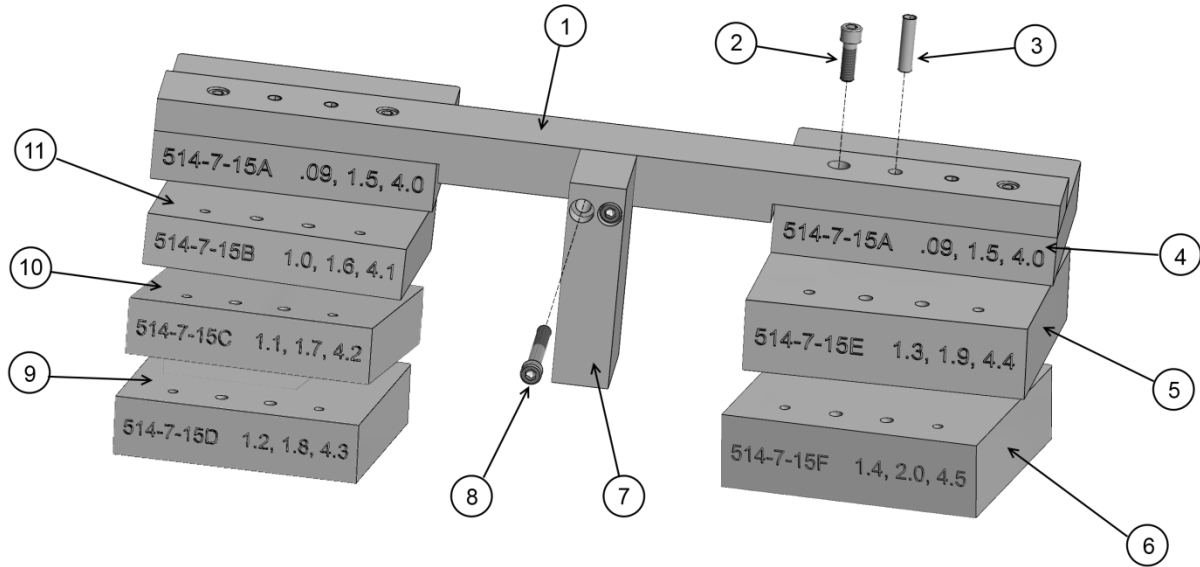






AUTOMATIC ROLL OVER FIXTURE PARTS			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	514-13-14A	BASE FRAME	1
2	514-13-14L	BEARING BLOCK	1
3		3/8-16X1 1/4 SHCS	4
4		3/8 FLAT WASHER	4
5	514-13-14C	CRADLE	1
6	514-7-20	THRUST WASHER	2
7	514-7-21	BELLEVILLE WASHER	4
8	7223	HOLD DOWN KNOB ASSY	2
9	514-7-10A	CLAMP ARM	2
10	514-7-22A	SHOULDER SCREW	2
11	514-3-34A	SPRING	1
12	650-4-51	M14 X 2 X 55 SHCS	2
13		5/16-18 X 2 1/4	16
14	514-13-14K	GEARBOX COVER	1
15		10-24 X 3/8 BHCS	7
16	514-13-14M	MOTOR COVER	1
17		10-24 X 3/8 BHCS	6
18		1/4-20 X 3/4 SHCS	4
19	650-3-93B	SERVO MOTOR	1
20	514-13-14J	ADAPTOR	1
21	5506C	GEARBOX ASSY	1
22	5506D	INPUT SHAFT	1
23		1/2-13 JAM NUT	2
24	514-3-72A	SPRING RETAINER PIN	2

Parallel Block Riser Sets



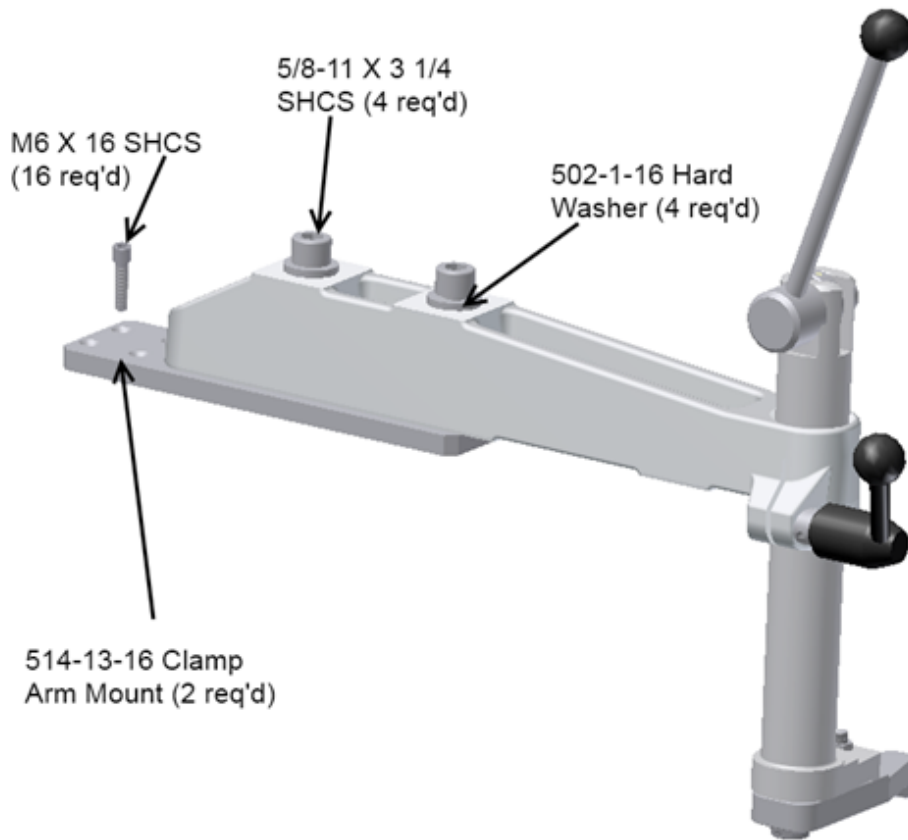
PARALLEL BLOCK RISER PARTS			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	514-7-15Q	PARALLEL CROSS SUPPORT	2
2	MF-14	1/4-20 X 3/4 SHCS	8
3	MF-226	1/4 X 1 ROLL PIN	8
4	514-7-15A	A SPACER	4
5	514-7-15E	E SPACER	4
6	514-7-15F	F SPACER	4
7	514-7-15R	PARALLEL NUB	2
8	MF-19	1/4-20 X 2 SHCS	4
9	514-7-15D	D SPACER	4
10	514-7-15C	C SPACER	4
11	514-7-15B	B SPACER	4

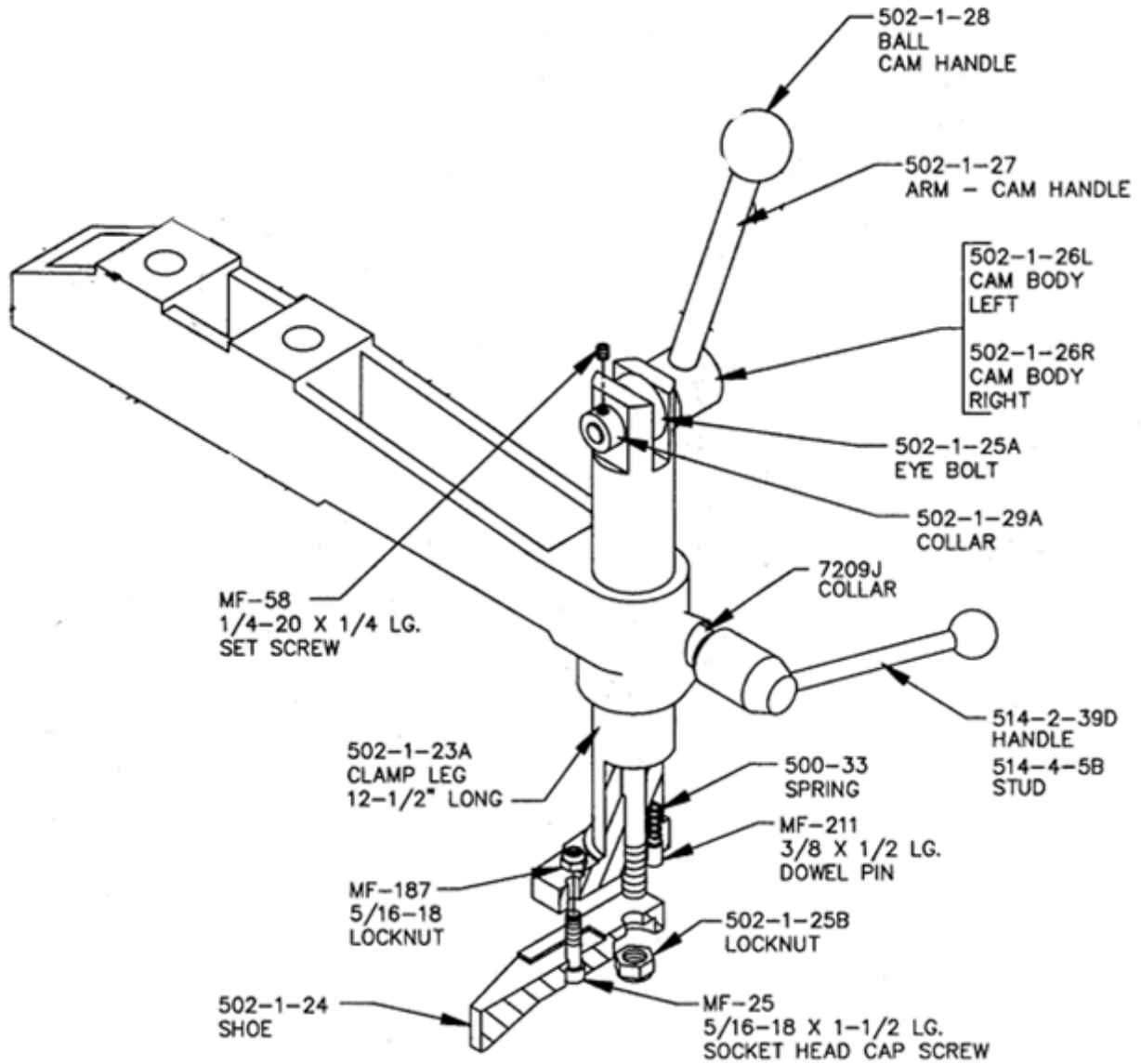
Splash Tray & Magnet

514-7-65S Splash Tray
514-7-65T Magnet Assembly

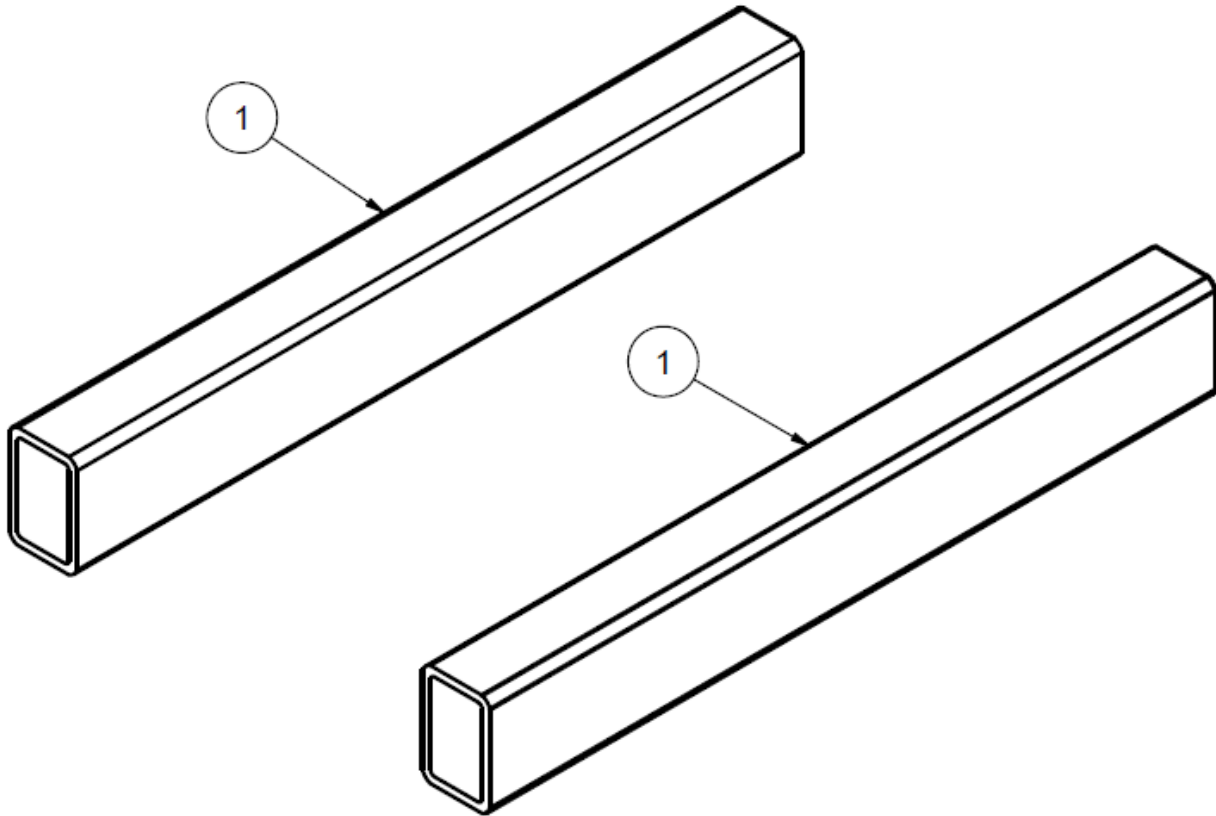


502-1-30H Clamp Arm Parts



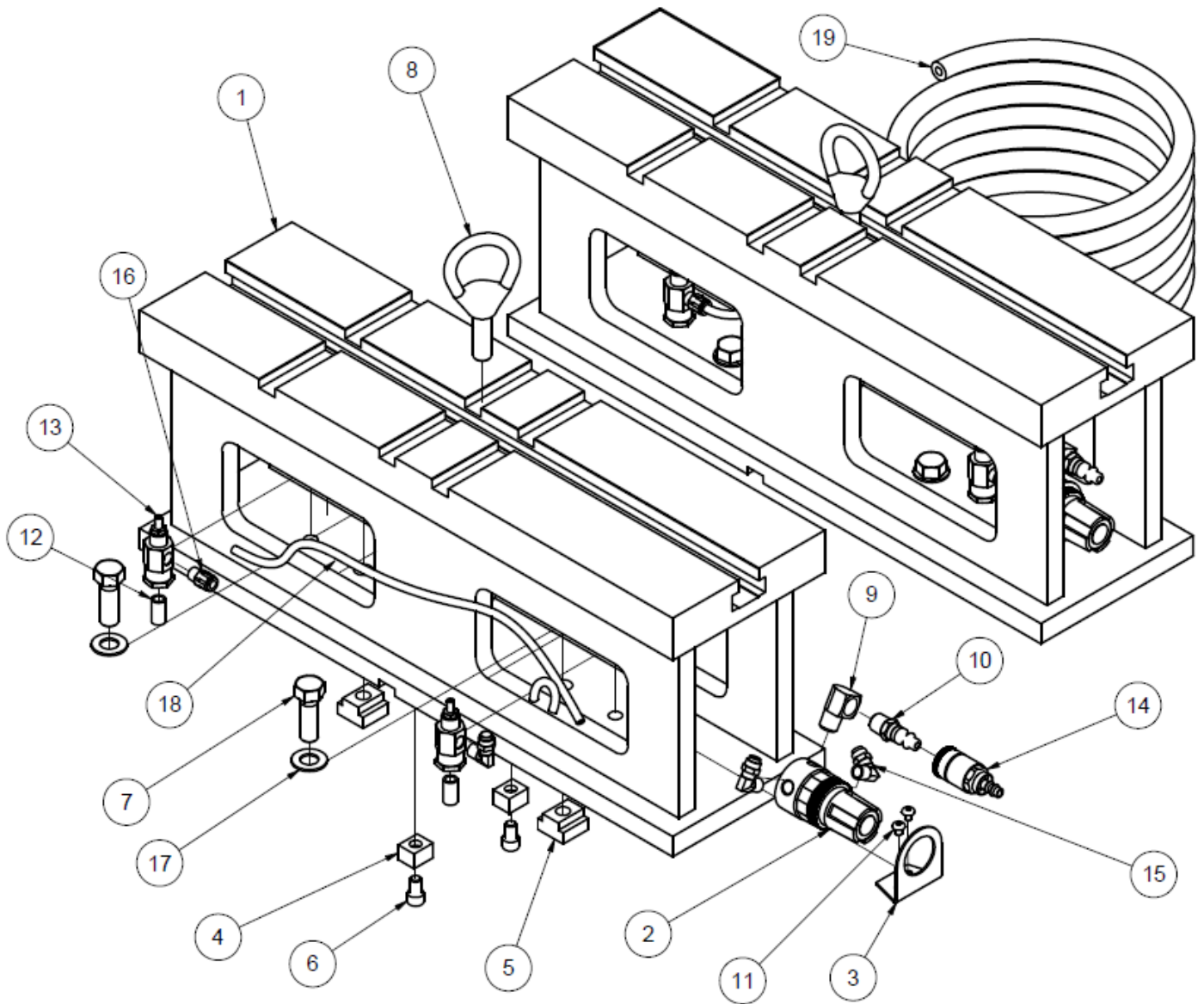


11115 2" (50mm) X 3" (75mm) Parallels



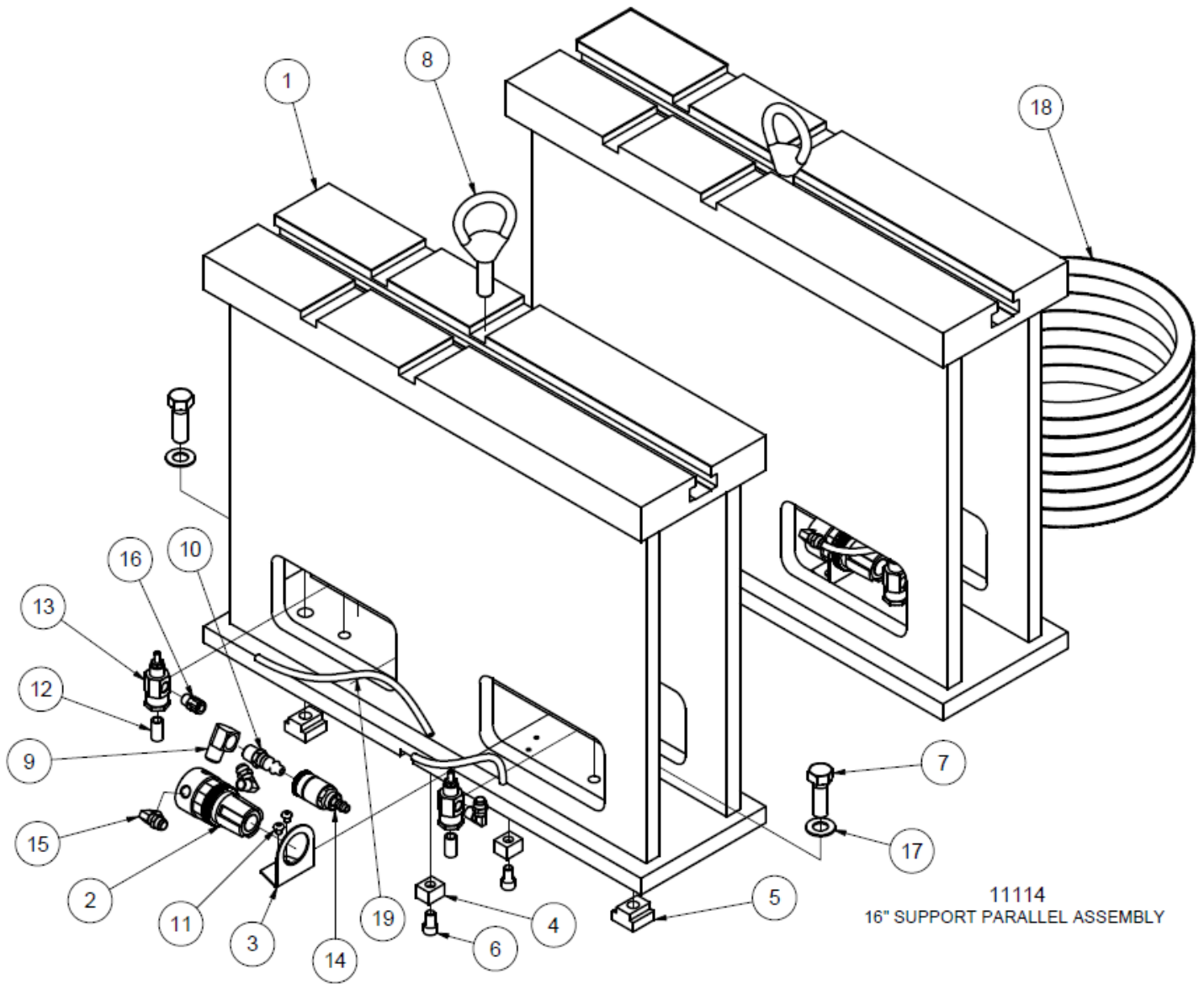
11115 2" x 3" PARALLEL SET			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	11115A	2" x 3" PARALLEL

11112 Universal Heavy Duty T-Slot Parallels Parts



11112 SUPPORT PARALLEL ASSEMBLY 8"			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	11112A	SUPPORT PARALLEL 8" (MACHINING)
2	2	502-27-17	Regulator 0 - 60 PSI
3	2	502-27-17A	Regulator Bracket
4	4	650-3-9	Key
5	4	650-3-10	TN-5 T-Nut
6	4	MF-21A	5/16-18UNC x 1/2" LG. S.H.C.S.
7	4	MF-137A	1/2-13UNC x 1-1/2" LG. HEX BOLT
8	2	502-3-13	Lift Eye
9	2	502-11-17S	1/4 STREET ELL
10	2	502-11-16X	Quick Connect air Fitting Male
11	4	MF-87	10-24UNC x 1/4" LG. SOCKET BUTTONHEAD SCREW
12	4	502-11-17J	Nipple, Close 1/8" NPT
13	4	502-11-35A	Flo Control
14	1	502-11-16W	Quick connect air fitting female
15	6	502-11-16I	Elbow, Male 1/4 FPT x 1/8 PT
16	2	514-4-17W	FITTING 1/8NPT x 1/4" POLY STRAIGHT
17	4	MF-180	1/2" FLAT WASHER
18	3 FT.	502-11-15	1/4" OD BLACK POLYFLO
19	15 FT.	502-1-98	1/4" AIR HOSE

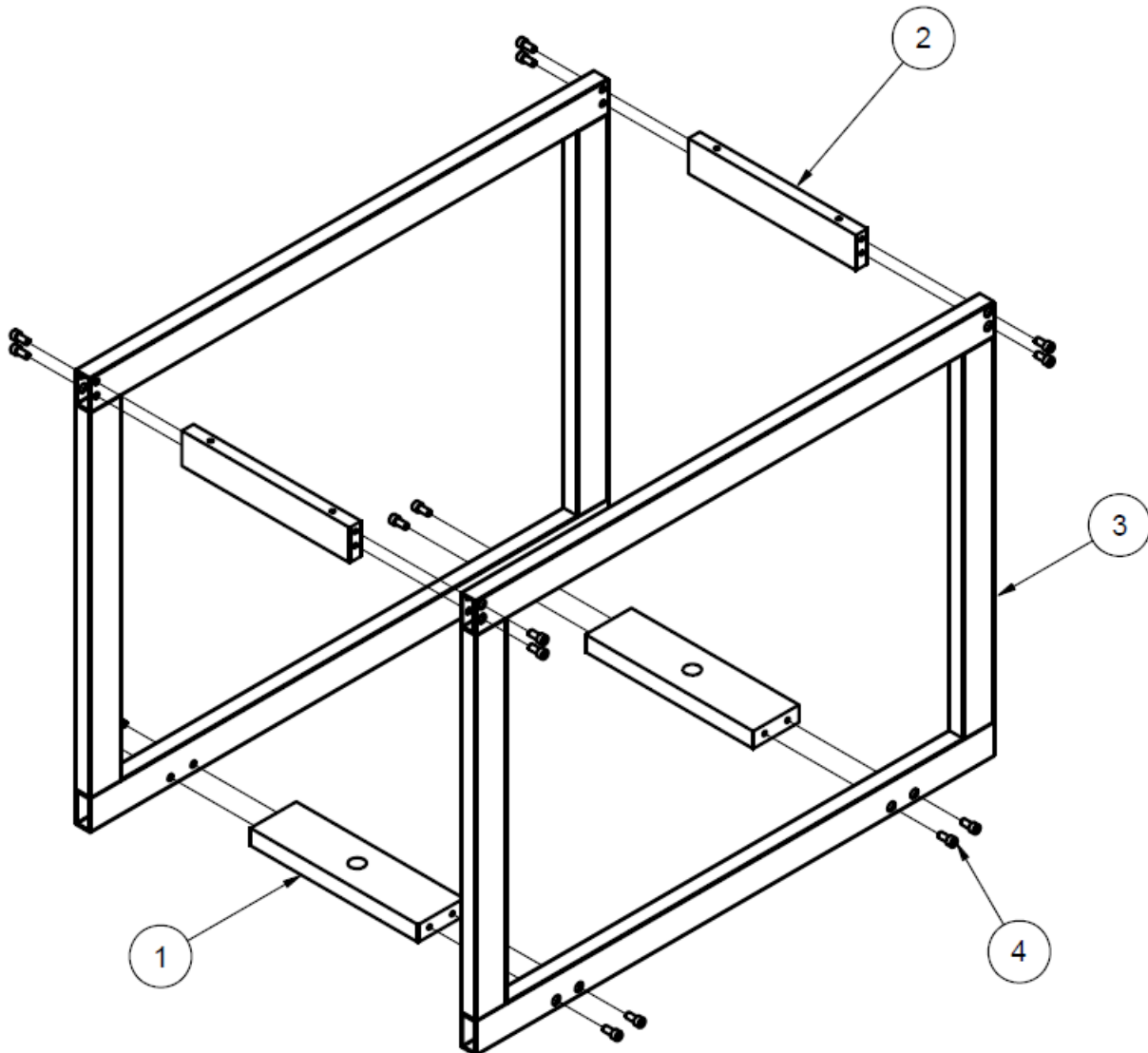
11114 Universal Heavy Duty T-Slot Parallels Parts



11114 SUPPORT PARALLEL ASSEMBLY 16"			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	11114A	SUPPORT PARALLEL 16" (MACHINING)
2	2	502-27-17	Regulator 0 - 60 PSI
3	2	502-27-17A	Regulator Bracket
4	4	650-3-9	Key
5	4	650-3-10	TN-5 T-Nut
6	4	MF-21A	5/16-18UNC x 1/2" LG. S.H.C.S.
7	4	MF-137A	1/2-13UNC x 1-1/2" LG. HEX BOLT
8	2	502-3-13	Lift Eye
9	2	502-11-17S	1/4 STREET ELL
10	2	502-11-16X	Quick Connect air Fitting Male
11	4	MF-87	10-24UNC x 1/4" LG. SOCKET BUTTONHEAD SCREW
12	4	502-11-17J	Nipple, Close 1/8" NPT
13	4	502-11-35A	Flo Control
14	1	502-11-16W	Quick connect air fitting female
15	6	502-11-16I	Elbow, Male 1/4 FPT x 1/8 PT
16	2	514-4-17W	FITTING 1/8NPT x 1/4" POLY STRAIGHT
17	4	MF-180	1/2" FLAT WASHER
18	15 FT.	502-1-98	1/4" AIR HOSE
19	3 FT.	502-11-15	1/4" OD BLACK POLYFLO

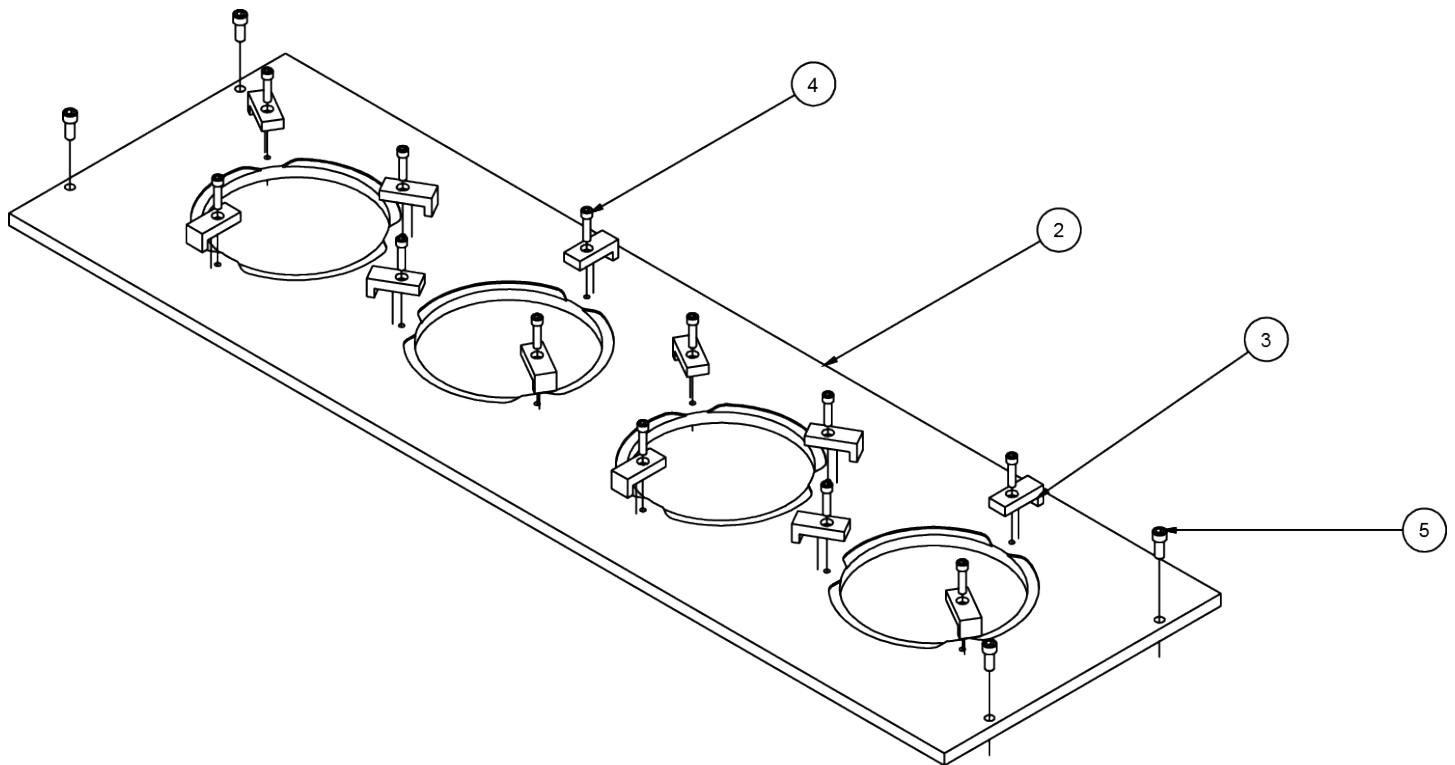
CYLINDER LINER FIXTURES

514-11-5 Cylinder Liner Honing Fixture Parts



514-11-5 Cylinder Liner Honing Fixture			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	514-11-1E	LOWER CROSS BAR, CAT CYLINDER SLEEVE HONE FIXTURE
2	2	514-11-1D	UPPER CROSS BAR, CAT CYLINDER SLEEVE HONE FIXTURE
3	2	514-11-1B	FRONT/REAR FRAME (MACHINING), CAT CYLINDER SLEEVE HONE FIXTURE
4	16	MF-21	S.H.C.S. 5/16 - 18 UNC - 5/8

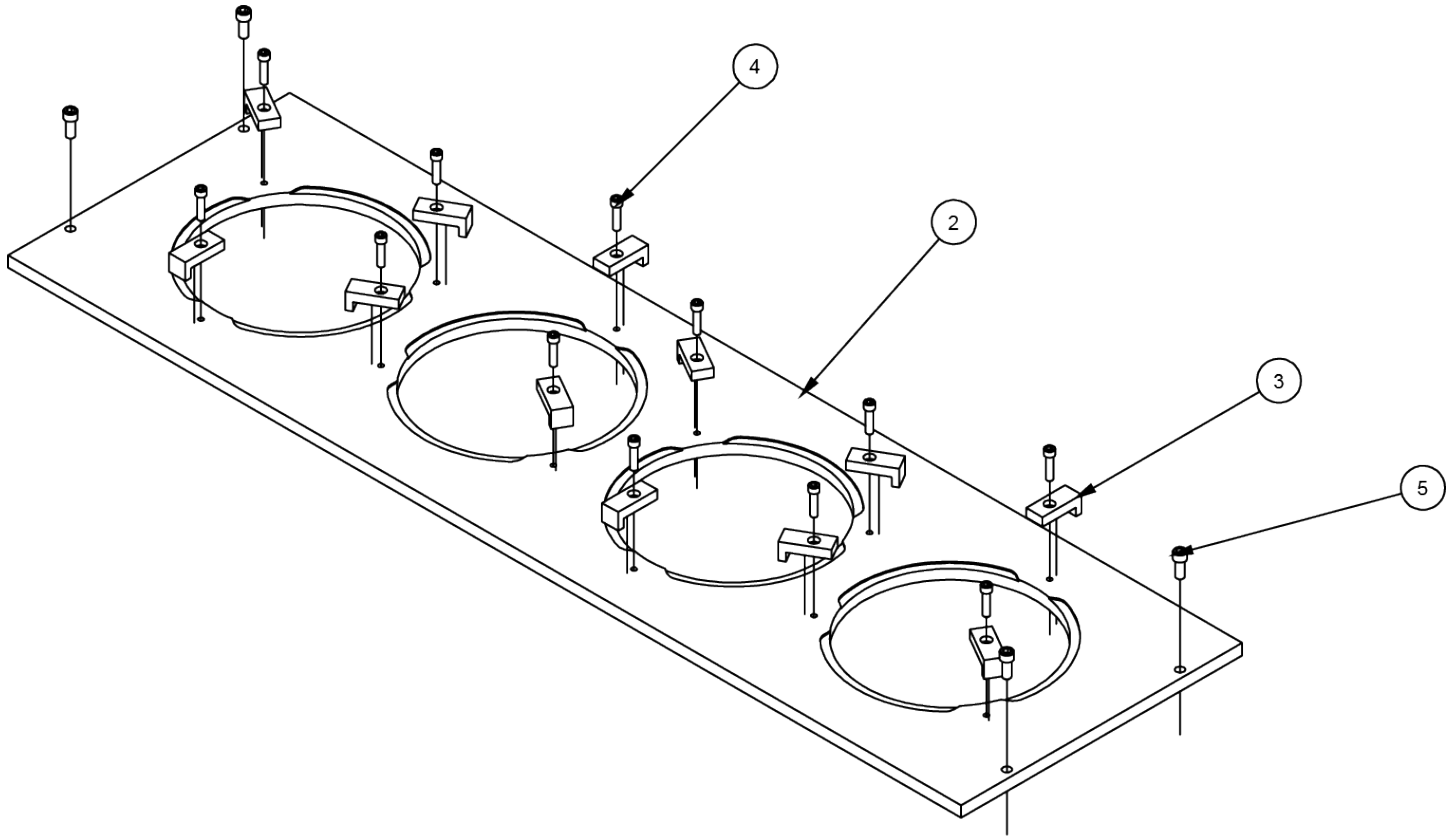
514-11-6 Fixture Plate, CAT 3400 Parts



Parts List

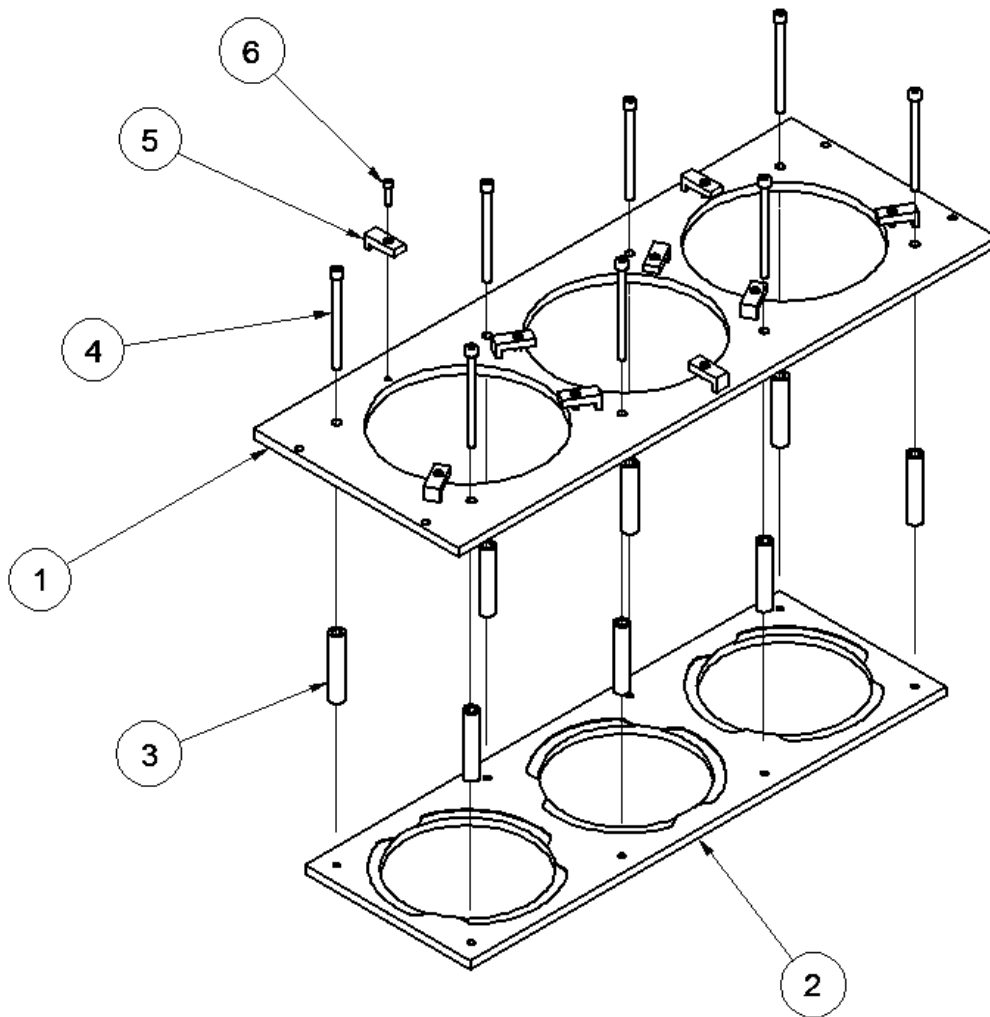
ITEM	QTY	PART NUMBER	DESCRIPTION
2	1	514-11-6A	3400 SLEEVE TOP PLATE FIXTURE
3	12	514-11-2C	CLAMP
4	12	MF-15	1/4 - 20 UNC - 1"
5	4	MF-22	5/16 - 18 UNC - 3/4"

514-11-7 Fixture Plate, CAT 3500 Parts



Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
2	1	514-11-7A	3400 SLEEVE TOP PLATE FIXTURE
3	12	514-11-2C	CLAMP
4	12	MF-15	1/4 - 20 UNC - 1"
5	4	MF-22	5/16 - 18 UNC - 3/4"

514-11-4 Fixture Plate, CAT C175 Parts



514-11-4 CAT C175 FIXTURE PLATE ASSEMBLY			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-11-4A	FIXTURE PLATE TOP - CAT C175 SLEEVE
2	1	514-11-4C	UPPER PLATE, CAT C175 FIXTURE, CAT CYLINDER SLEEVE HONE FIXTURE
3	8	514-11-4E	SPACER, CAT C175 SLEEVE FIXTURE
4	8	MF-38	3/8-16UNC x 5" LG. S.H.C.S.
5	9	514-11-2C	CLAMP
6	9	MF-15	1/4-20UNC x 1" LG. S.H.C.S.

Optional Coolant and Filter Equipment

514-4-71C Synthetic Coolant

(for use with diamond stones) 5 gal (20 liter) (mix with water 20:1)



514-4-71D Coolant Refractor

Sold as complete package only. No service parts available.

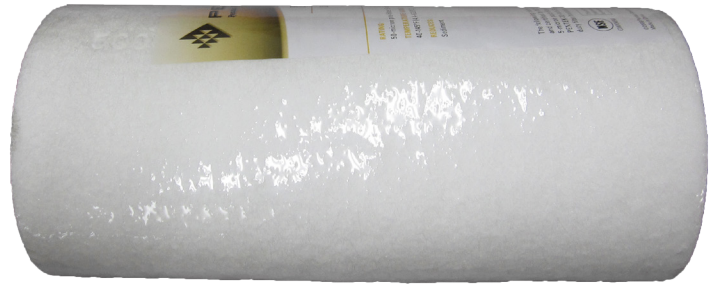


514-7-66Gfilter Paper Sheets

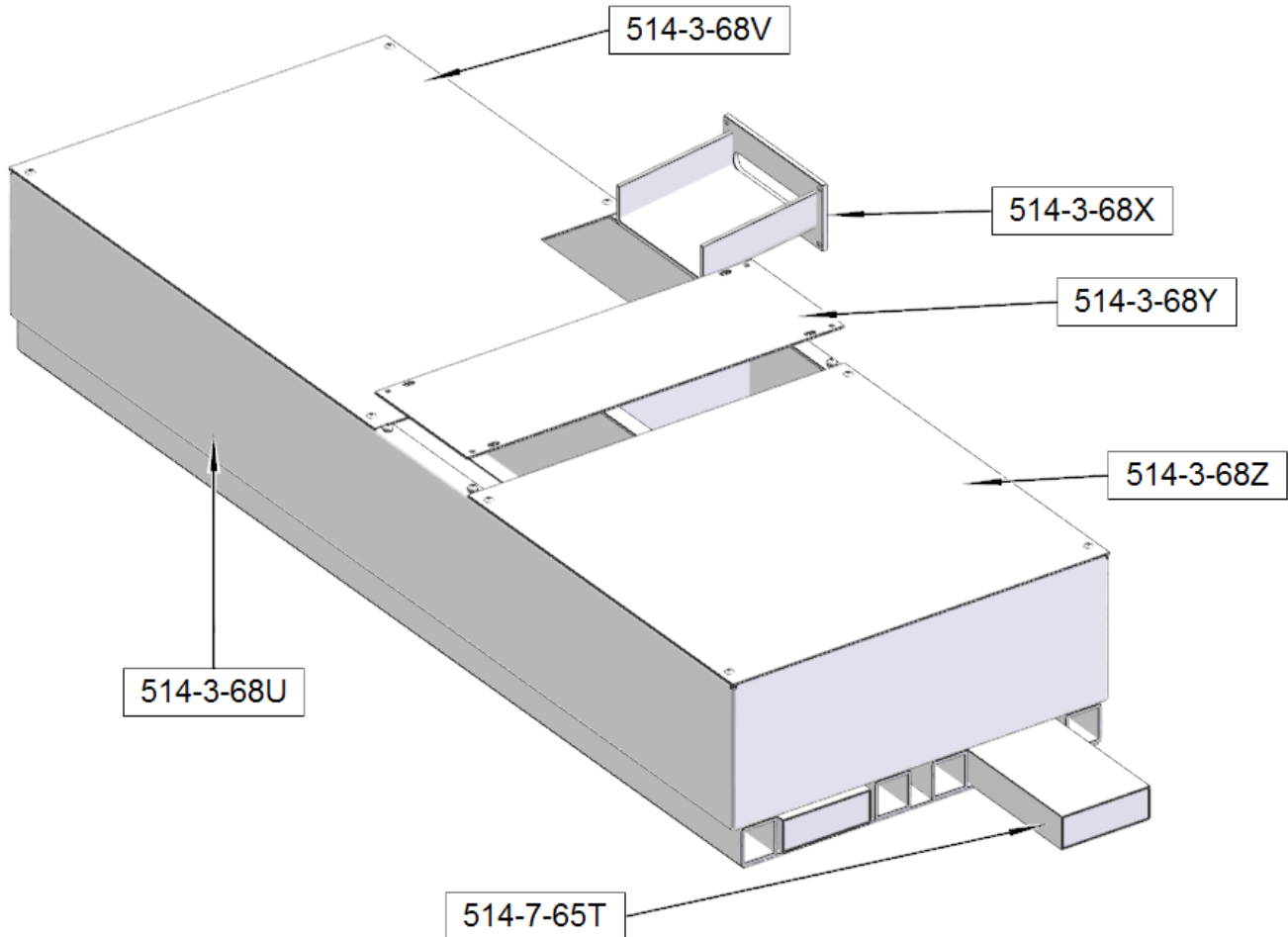
for inside cabinet/tank coolant system (minimum order of 25)



514-2-42C Dual Gradient 50-5 Micron Replacement Filter Cartridge

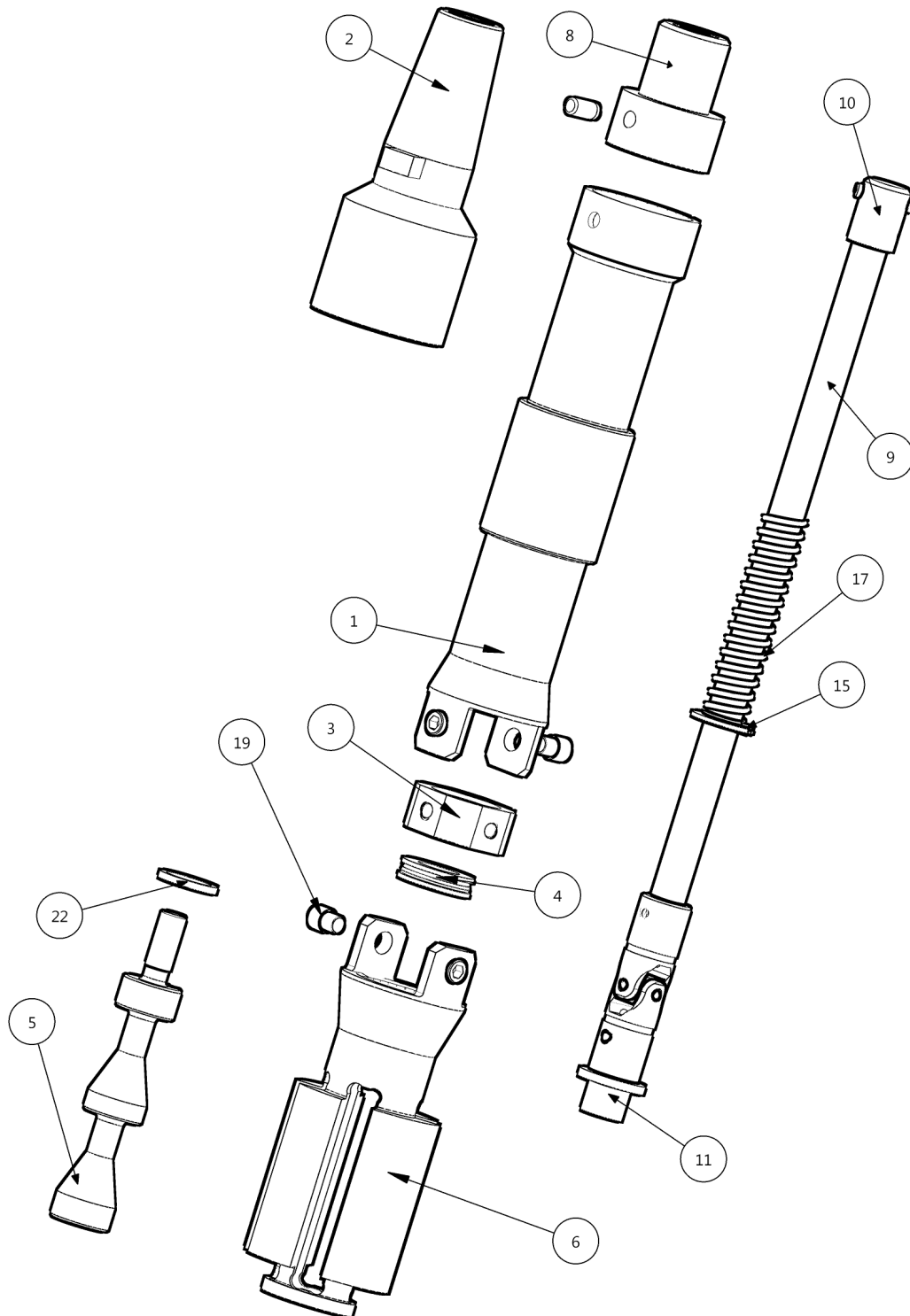


514-3-68W External Coolant Tank System Parts



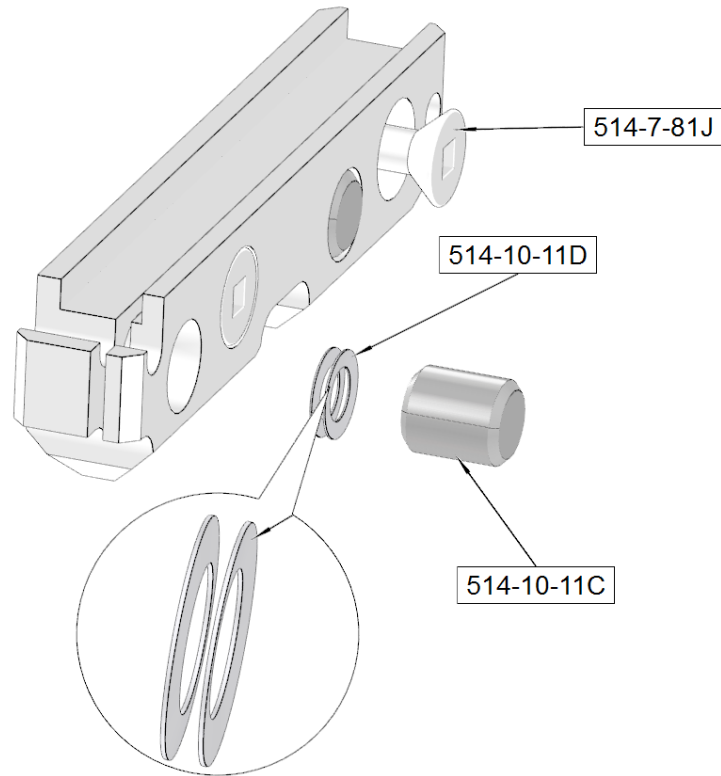
Rottler Precision Hone Heads, Sleeves and Stone Holders

514-9J Medium Rottler Precision 4 Stone Holder Hone Head

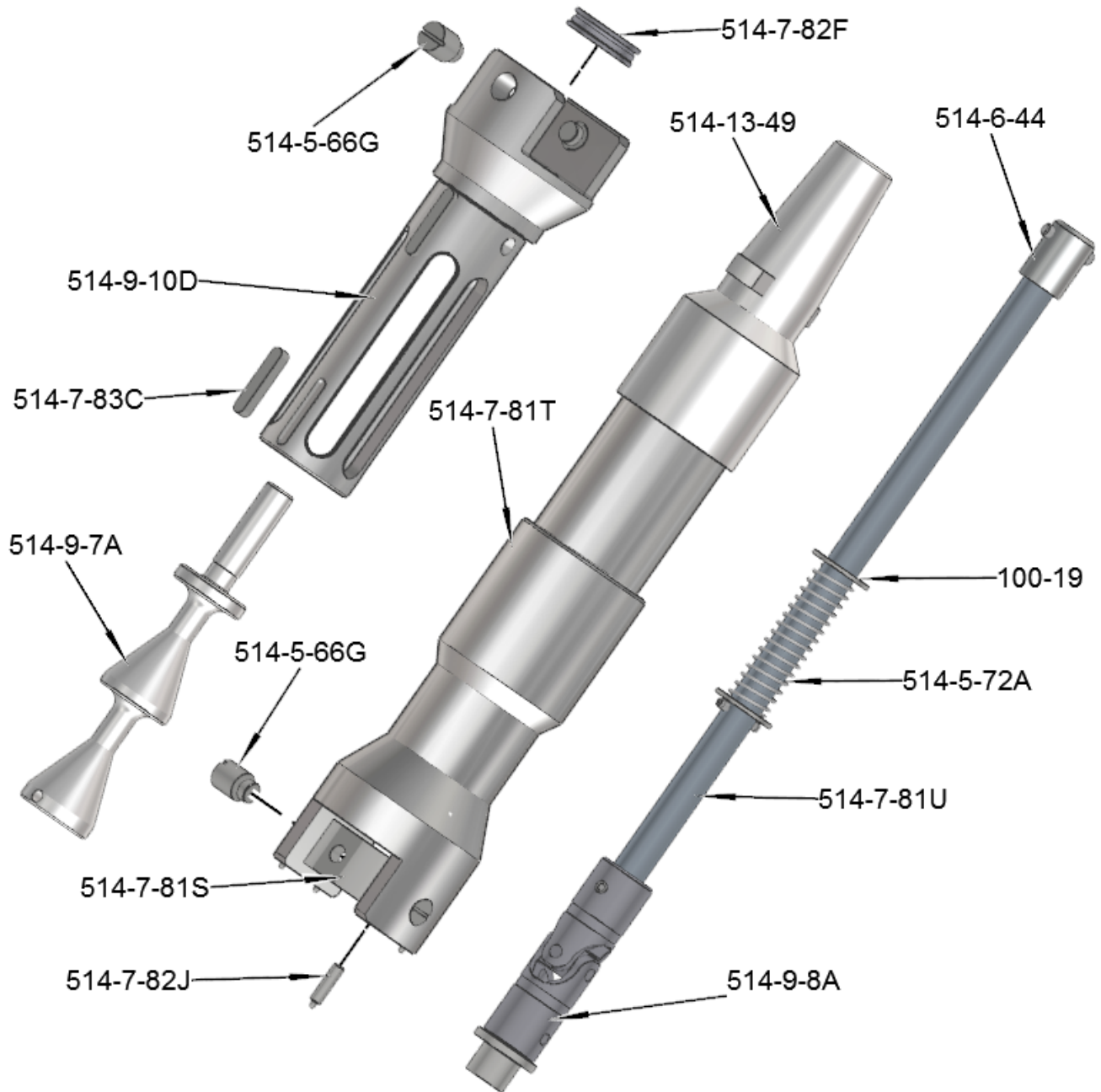


514-9J MEDIUM HONE HEAD PARTS LIST			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	514-10-20A	DRIVE SHAFT	1
2	514-13-49	KWIK SWITCH ADAPTOR	1
3	514-10-6	PIVOT BLOCK	1
4	514-7-82F	THRUST BEARING	1
5	514-10-2A	CONE ROD	1
6	514-10-1A	BODY	1
8	514-7-81A	DRIVE CONNECTOR	1
9	514-10-20B	ADJUSTING SHAFT	1
10	514-6-44	DRIVE COUPLER	1
11	514-10-5A	ADJUSTING NUT UNIVERSAL ASSEMBLY	1
15	100-19	THRUST WASHER	1
17	514-5-72A	SPRING	1
19	514-10-10	PIVOT SCREW	4
22	514-10-9	BUMPER	1

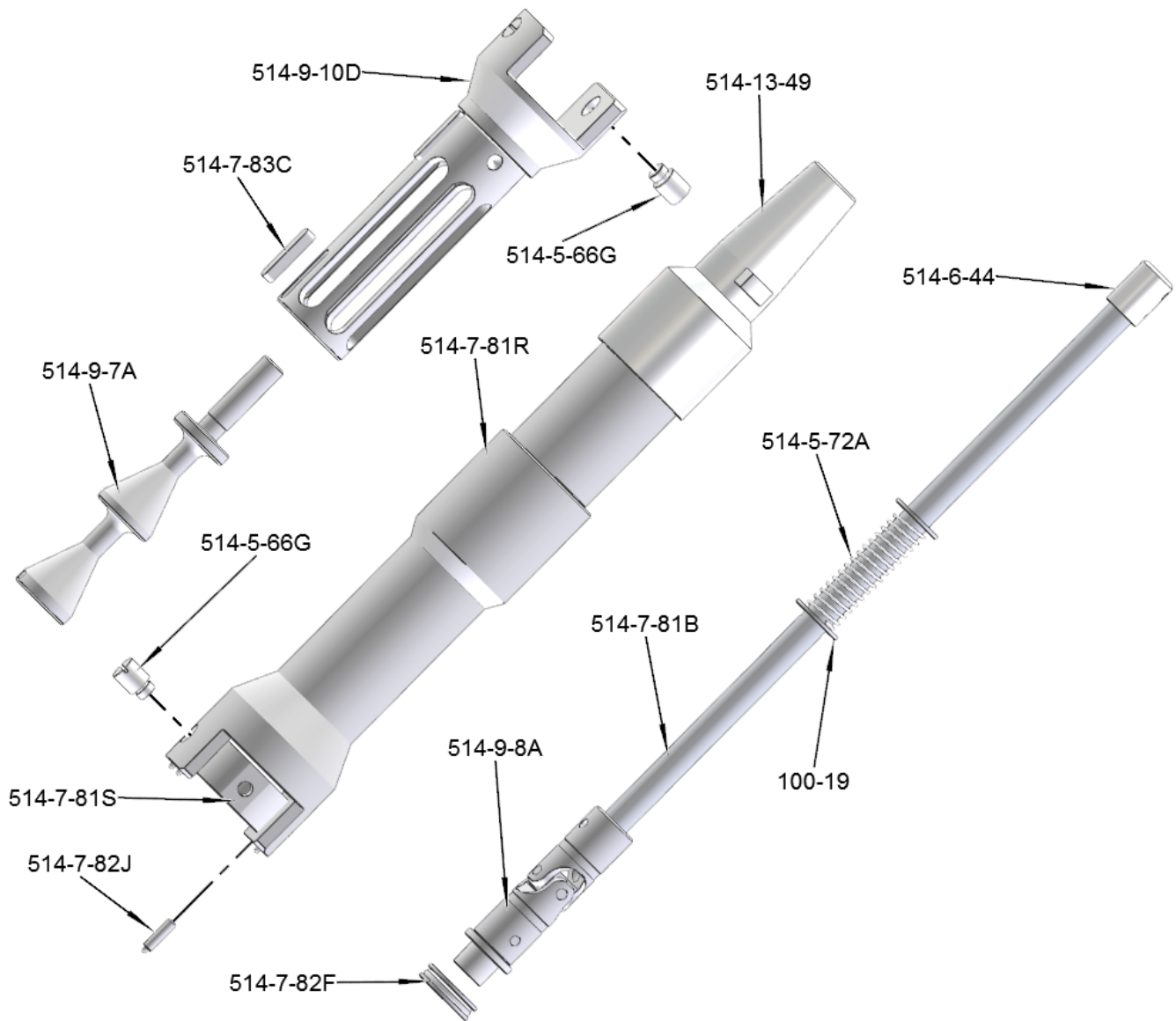
514-10-13 Series Stone Holder Parts



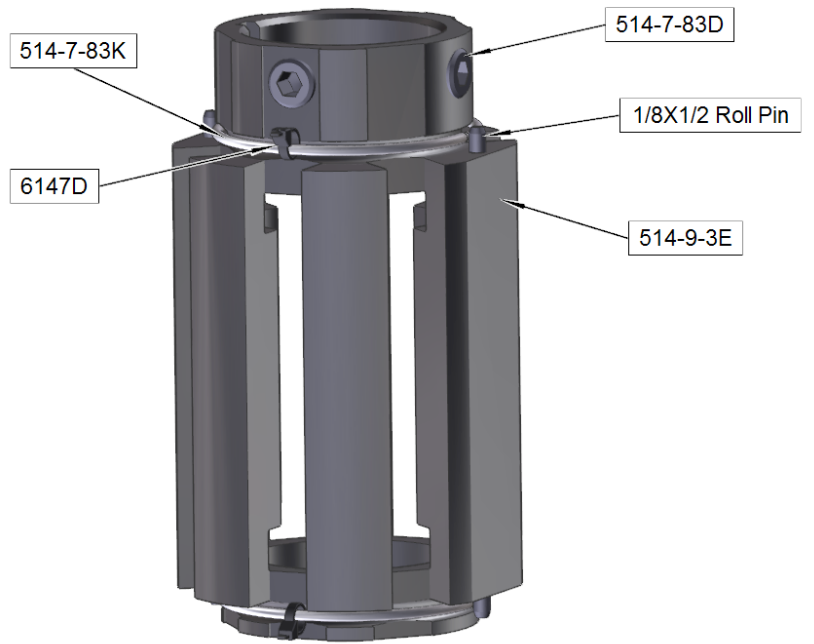
514-9Q Large Rottler Precision Heavy Duty 6 Stone Hone Head Assembly Parts



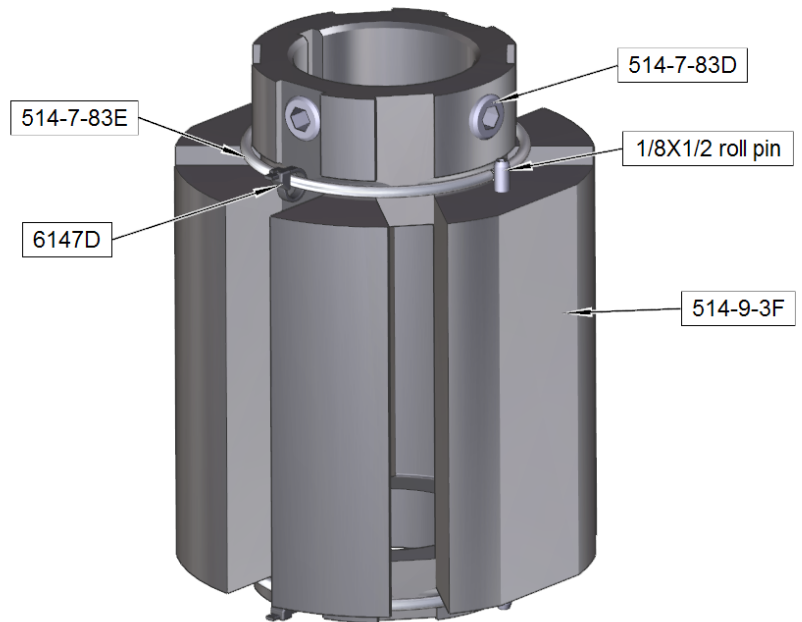
514-9S Large Rottler Precision Heavy Duty 6 Stone Hone Head Assembly Parts



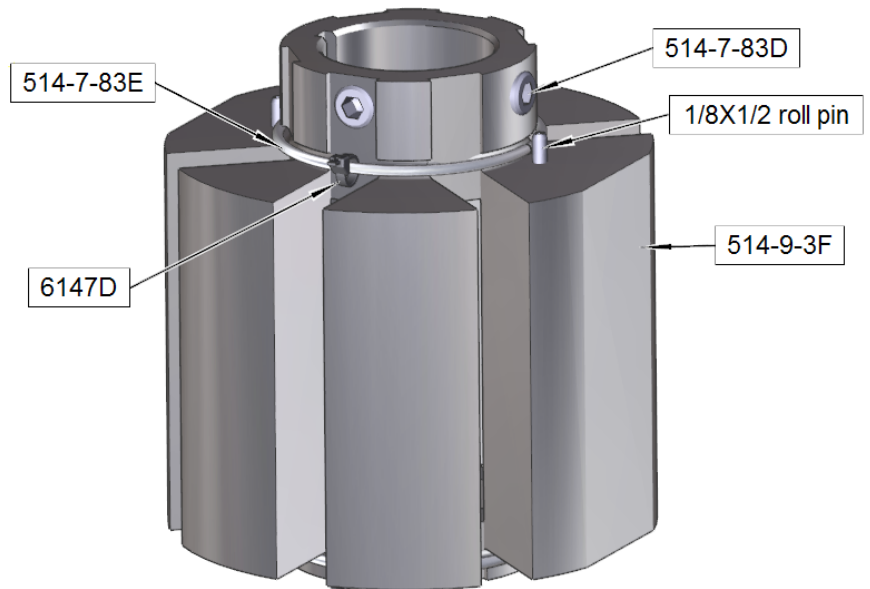
514-9-4E Sleeve Assembly Parts



514-9-4F Sleeve Assembly Parts



514-9-4G Sleeve Assembly Parts



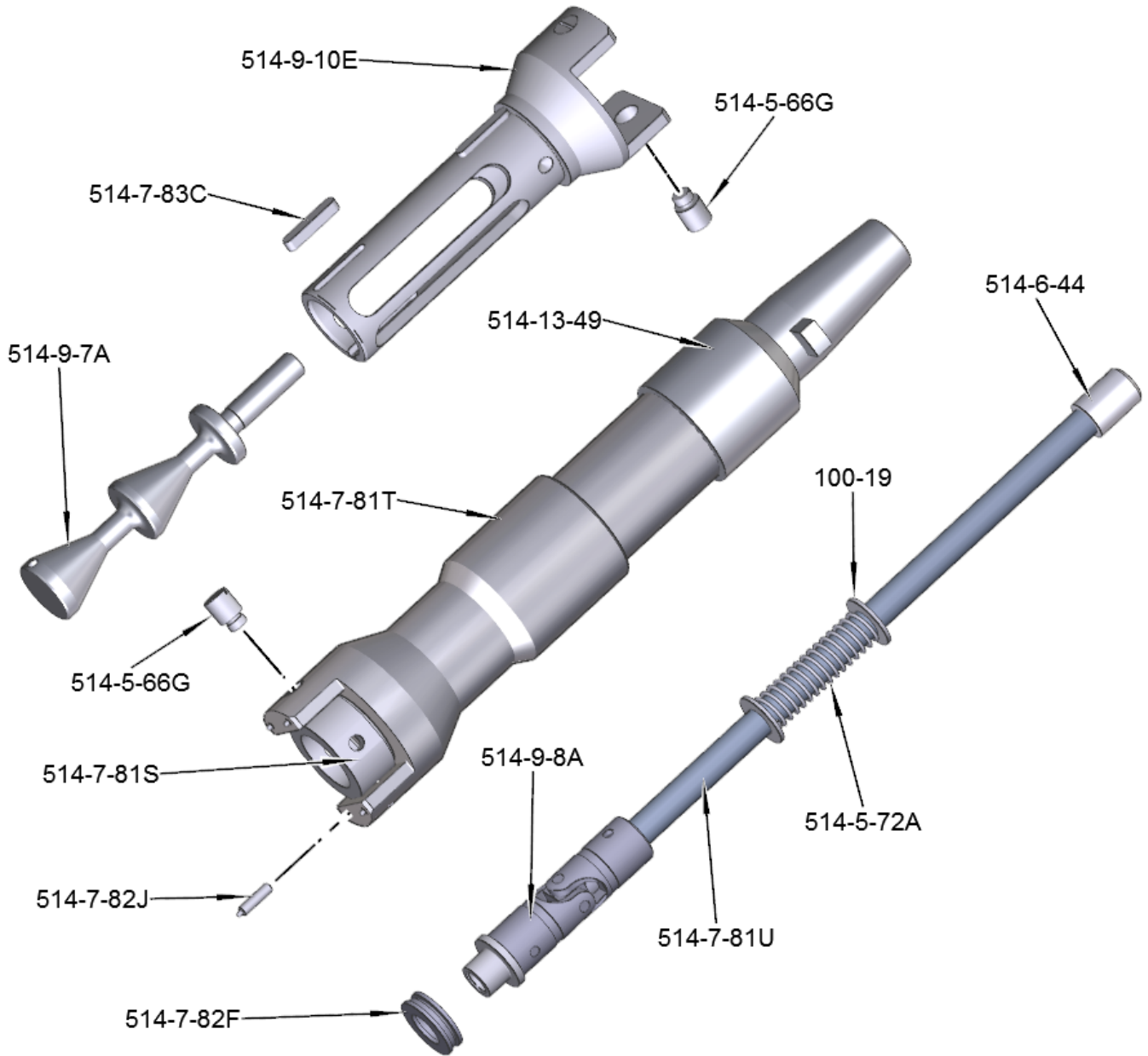
514-9-31 Series Stone Holders Parts & Size Range Chart

Stone Set #	Size Range	Sleeve Used In	Lock Screw #
514-9-31J	2.990 - 3.44" (75.95 - 87.38mm)	514-9-4E	514-7-81J
514-9-31A	3.165 - 3.630" (80.39 - 92.20mm)	514-9-4E	514-7-81J
514-9-31B	3.415 - 3.880" (86.74 - 98.55mm)	514-9-4E	514-7-81J
514-9-31C	3.665 - 4.130" (93.09 - 104.90mm)	514-9-4F	514-7-81J
514-9-31D	3.915 - 4.380" (99.44 - 111.25mm)	514-9-4F	514-7-81J
514-9-31E	4.165 - 4.630" (105.79 - 117.60mm)	514-9-4F	514-7-81J
514-9-31F	4.415 - 4.880" (112.14 - 123.95mm)	514-9-4G	514-7-81J
514-9-31G	4.665 - 5.130" (118.49 - 130.30mm)	514-9-4G	514-7-81J
514-9-31H	4.915 - 5.380" (124.84 - 136.65mm)	514-9-4G	514-7-81J
514-9-31K	5.165 - 5.630" (131.19 - 143.00mm)	514-9-4G	514-7-81J
514-9-31L	5.415 - 5.880" (137.54 - 149.35mm)	514-9-4G	514-7-81J
514-9-31M	5.665 - 6.130" (143.89 - 155.70mm)	514-9-4G	514-7-81J
514-9-31N	5.915 - 6.380" (150.24 - 162.05mm)	514-9-4G	514-7-81J
514-9-31P	6.165 - 6.630" (156.59 - 168.40mm)	514-9-4G	514-7-81J
514-9-31Q	6.415 - 6.880" (162.94 - 174.75mm)	514-9-4G	514-7-81J
514-9-31R	6.665 - 7.130" (169.29 - 181.10mm)	514-9-4G	514-7-81J
514-9-31S	6.915 - 7.380" (175.64 - 187.45mm)	514-9-4G	514-7-81J

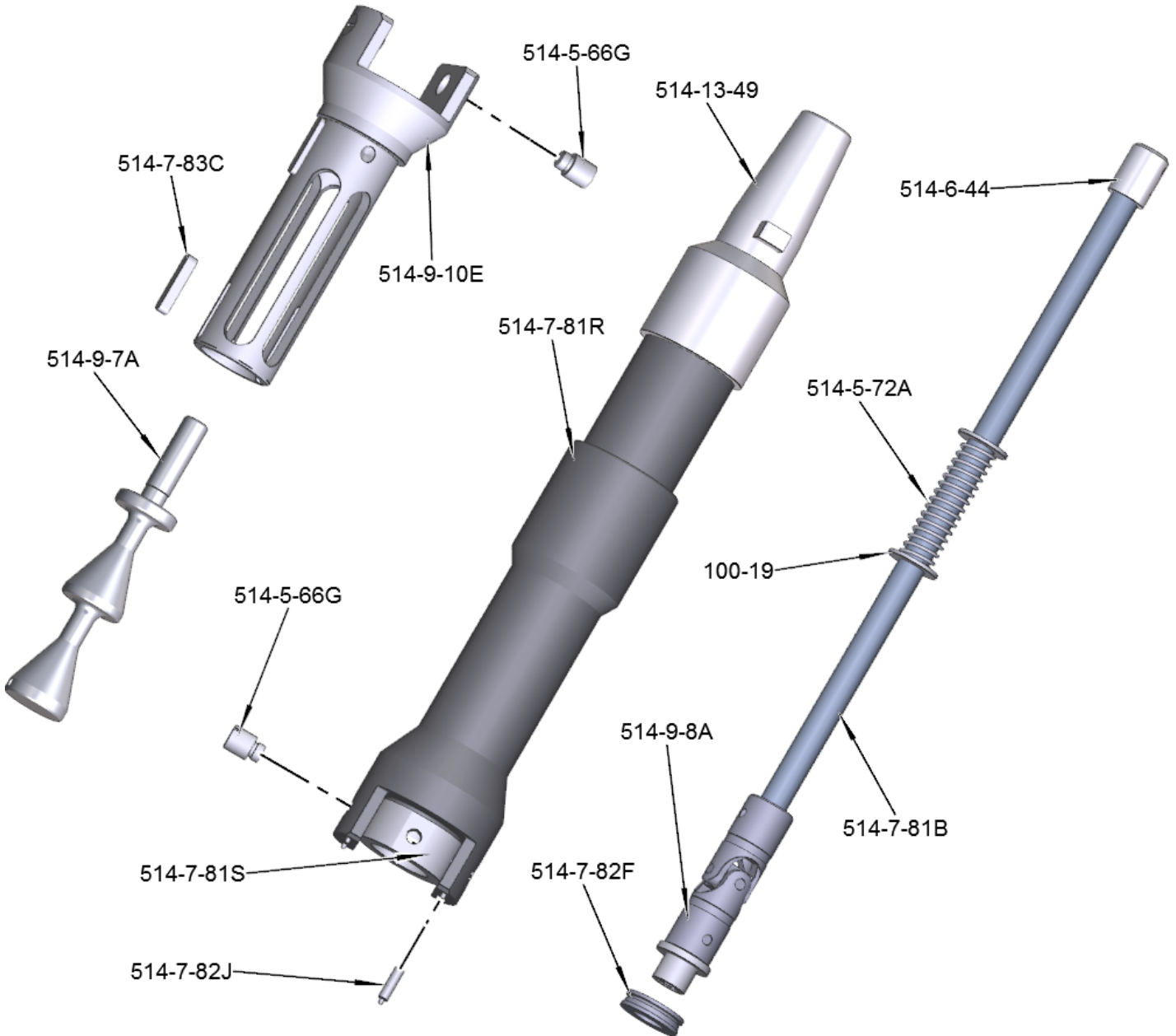
Diamond Stone Sets for 6 Stone Heads Chart

Set #	Material	Stone Height	Length	Grit	Finish
514-9-32F	Diamond	.312 (7.90MM)	3" (76mm)	80	90 Ra, (2.25um)
514-9-32R	Diamond	.312 (7.90MM)	3.5" (89mm)	80	90 Ra, (2.25um)
514-9-32W	Diamond	.312 (7.90MM)	3" (76mm)	140/170	50-75 Ra, (1.25 - 1.875um)
514-9-32K	Diamond	.312 (7.90MM)	3" (76mm)	170/200	45-60 Ra, (1.125 - 1.5um)
514-9-32J	Diamond	.312 (7.90MM)	3" (76mm)	270/325	35-45 Ra, (.875 - 1.125um)
514-9-32E	Diamond	.312 (7.90MM)	3" (76mm)	325/400	24-30 Ra, (.6 - .75um)
514-9-32C	Diamond	.312 (7.90MM)	3" (76mm)	500	18-22 Ra, (.45 - .55um)
514-9-32L	Diamond	.312 (7.90MM)	3" (76mm)	550	15-19 Ra, (.375 - .475)
514-9-32G	Diamond	.312 (7.90MM)	3" (76mm)	600	8-12 Ra, (.2 - .3um)
514-9-33	Diamond	.312 (7.90MM)	3" (76mm)	800	
514-9-33C	Diamond	.312 (7.90MM)	4" (102mm)	800	
514-9-33J	Diamond	.312 (7.90MM)	3" (76mm)	1200	
514-9-33B	Diamond	.200 (5.08MM)	3.5" (89mm)	270/325	35-45 Ra
514-9-32D	Diamond	.200 (5.08MM)	3" (76mm)	325/400	18-22 Ra
514-9-33A	Diamond	.200 (5.08MM)	3.5" (89mm)	800	

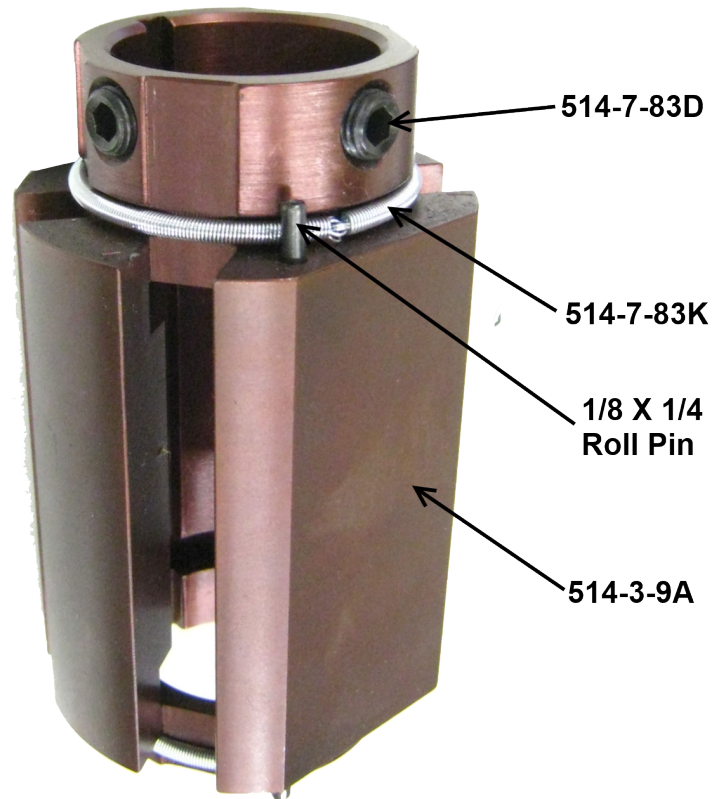
514-9P Large Rottler Precision Heavy Duty 4 Stone Hone Head Assembly Parts



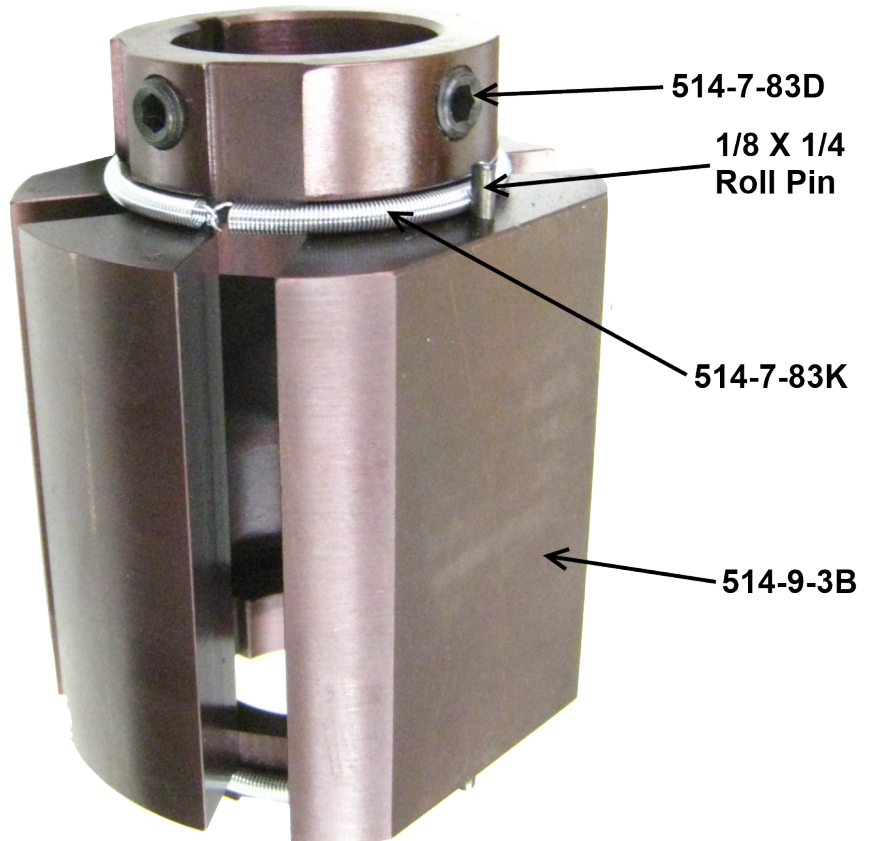
514-9R Large Rottler Precision Heavy Duty 4 Stone Hone Head Assembly Parts



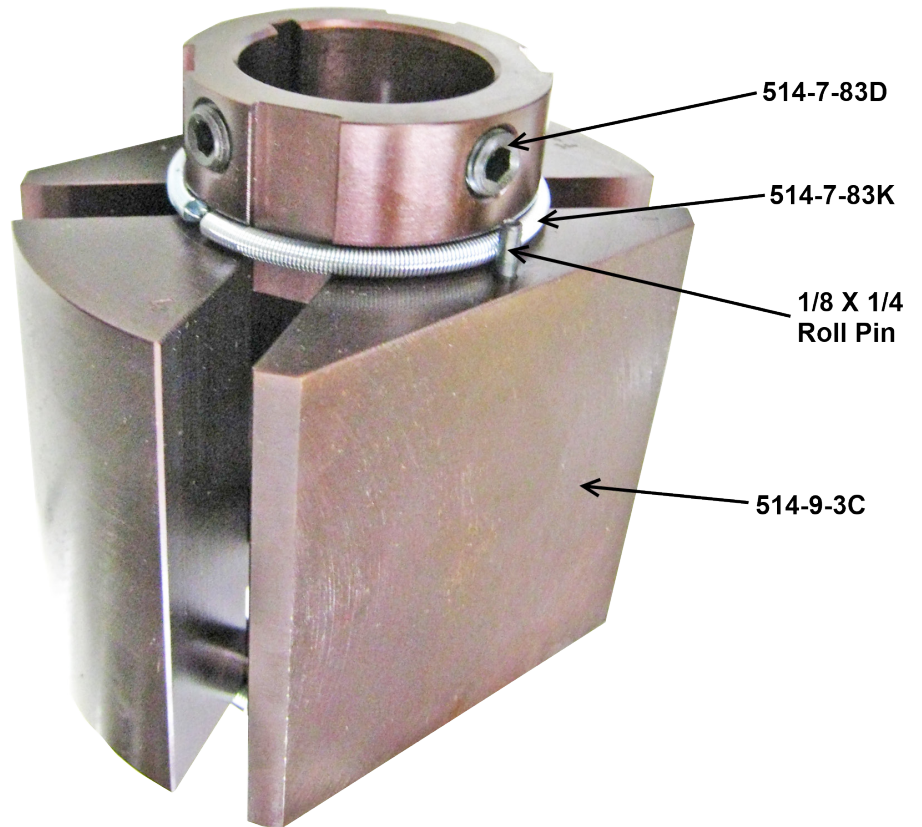
514-9-4A Sleeve Assembly Parts



514-9-4B Sleeve Assembly Parts



514-9-4C Sleeve Assembly Parts



514-9-6 Series Stone Holders Parts & Size Range Chart

Stone Set #	Size Range	Sleeve Used In	Lock Screw #
514-9-6J	2.990 - 3.44" (75.95 - 87.38mm)	514-9-4A	514-7-81J
514-9-6A	3.165 - 3.630" (80.39 - 92.20mm)	514-9-4A	514-7-81J
514-9-6B	3.415 - 3.880" (86.74 - 98.55mm)	514-9-4A	514-7-81J
514-9-6C	3.665 - 4.130" (93.09 - 104.90mm)	514-9-4B	514-7-81J
514-9-6D	3.915 - 4.380" (99.44 - 111.25mm)	514-9-4B	514-7-81J
514-9-6E	4.165 - 4.630" (105.79 - 117.60mm)	514-9-4B	514-7-81J
514-9-6F	4.415 - 4.880" (112.14 - 123.95mm)	514-9-4C	514-7-81J
514-9-6G	4.665 - 5.130" (118.49 - 130.30mm)	514-9-4C	514-7-81J
514-9-6H	4.915 - 5.380" (124.84 - 136.65mm)	514-9-4C	514-7-81J
514-9-6K	5.165 - 5.630" (131.19 - 143.00mm)	514-9-4C	514-7-81J
514-9-6L	5.415 - 5.880" (137.54 - 149.35mm)	514-9-4C	514-7-81J
514-9-6M	5.665 - 6.130" (143.89 - 155.70mm)	514-9-4C	514-7-81J
514-9-6N	5.915 - 6.380" (150.24 - 162.05mm)	514-9-4C	514-7-81J
514-9-6P	6.165 - 6.630" (156.59 - 168.40mm)	514-9-4C	514-7-81J
514-9-6Q	6.415 - 6.880" (162.94 - 174.75mm)	514-9-4C	514-7-81J
514-9-6R	6.665 - 7.130" (169.29 - 181.10mm)	514-9-4C	514-7-81J
514-9-6S	6.915 - 7.380" (175.64 - 187.45mm)	514-9-4C	514-7-81J

Diamond Stone Sets for 4 Stone Heads Chart

Set #	Material	Stone Height	Length	Grit	Finish
514-9-14F	Diamond	.312" (7.90mm)	3" (76mm)	80	90Ra (2.25um)
514-9-14R	Diamond	.312" (7.90mm)	3 1/2" (89mm)	80	90Ra (2.25um)
514-9-14W	Diamond	.312" (7.90mm)	3" (76mm)	140/170	50-75Ra (1.25 - 1.875um)
514-9-14K	Diamond	.312" (7.90mm)	3" (76mm)	170/200	45-60Ra (1.125 - 1.5um)
514-9-14M	Diamond	.312" (7.90mm)	3 1/2" (89mm)	170/200	45-60Ra (1.125 - 1.5um)
514-9-14J	Diamond	.312" (7.90mm)	3" (76mm)	270/325	35-45Ra (.875 - 1.125um)
514-9-14T	Diamond	.312" (7.90mm)	3 1/2" (89mm)	270/325	35-45Ra (.875 - 1.125um)
514-9-14Z	Diamond	.312" (7.90mm)	4" (102mm)	270/325	35-45Ra (.875 - 1.125um)
514-9-14E	Diamond	.312" (7.90mm)	3" (76mm)	325/400	24-30Ra (.6 - .75um)
514-9-14Q	Diamond	.312" (7.90mm)	3 1/2" (89mm)	325/400	24-30Ra (.6 - .75um)
514-9-14X	Diamond	.312" (7.90mm)	4" (102mm)	325/400	24-30Ra (.6 - .75um)
514-9-14V	Diamond	.312" (7.90mm)	3" (76mm)	400	15-19Ra (.375 - .475um)
514-9-14C	Diamond	.312" (7.90mm)	3" (76mm)	500	18-22Ra (.45 - .55um)
514-9-14P	Diamond	.312" (7.90mm)	3-1/2" (89mm)	500	18-22Ra (.45 - .55um)
514-9-14D	Diamond	.200" (5.1mm)	3" (76mm)	325/400	18-22Ra (.45 - .55um)
514-9-14U	Diamond	.312" (7.90mm)	2 1/2" (64mm)	500	18-22Ra (.45 - .55um)
514-9-14L	Diamond	.312" (7.90mm)	3" (76mm)	550	15-19Ra (.375 - .475um)
514-9-14N	Diamond	.312" (7.90mm)	3 1/2" (89mm)	550	15-19Ra (.375 - .475um)
514-9-14G	Diamond	.312" (7.90mm)	3" (76mm)	600	8-12Ra (.2 - .3um)
514-9-14S	Diamond	.312" (7.90mm)	3 1/2" (89mm)	600	8-12Ra (.2 - .3um)
514-9-21G	Diamond	.312" (7.90mm)	3" (76mm)	800	
514-9-21H	Diamond	.312" (7.90mm)	3" (76mm)	1000	
514-9-21J	Diamond	.312" (7.90mm)	3" (76mm)	1200	
514-9-35C	CBN	.312" (7.90mm)	3" (76mm)	320	
514-9-35D	CBN	.312" (7.90mm)	3" (76mm)	400	
514-9-35B	CBN	.312" (7.90mm)	3" (76mm)	600	