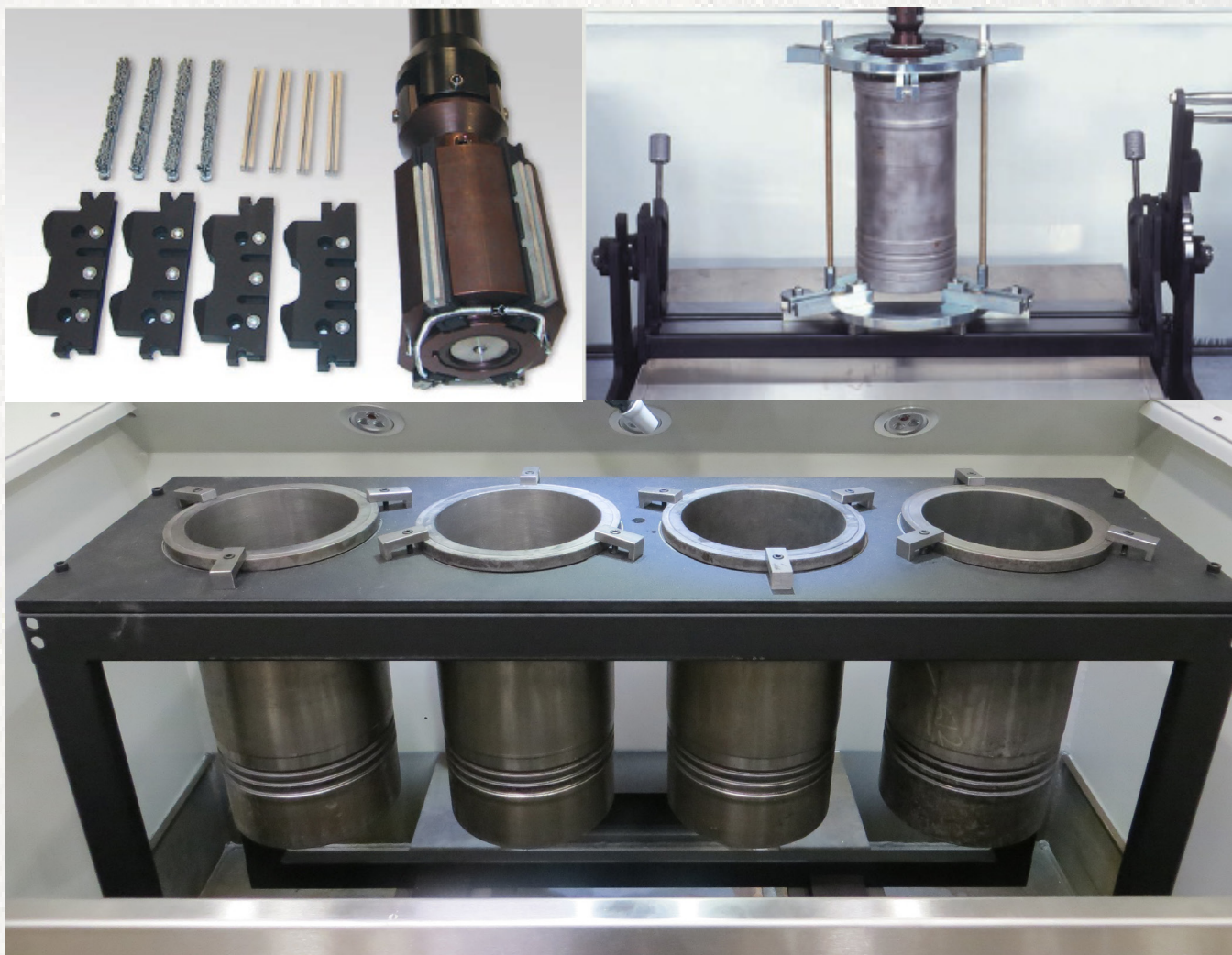


ROTTLER

THE CUTTING EDGE HP7A 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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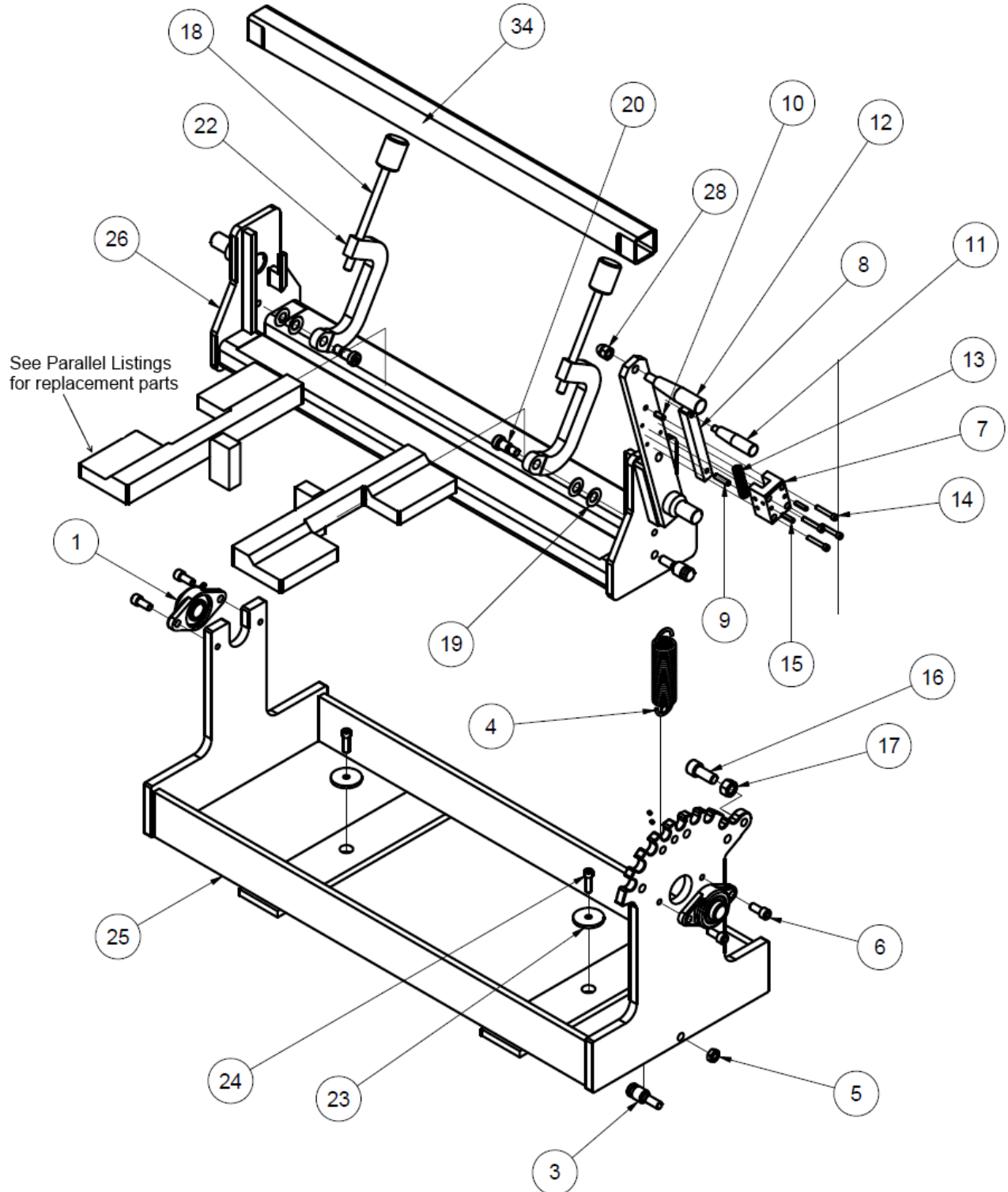
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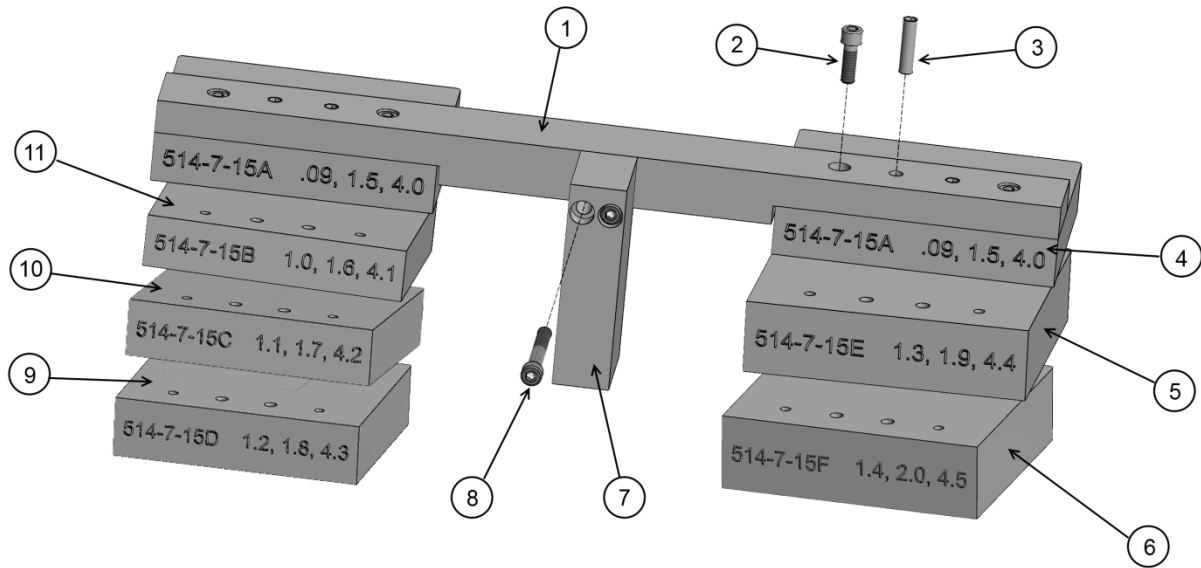
Fixturing

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

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

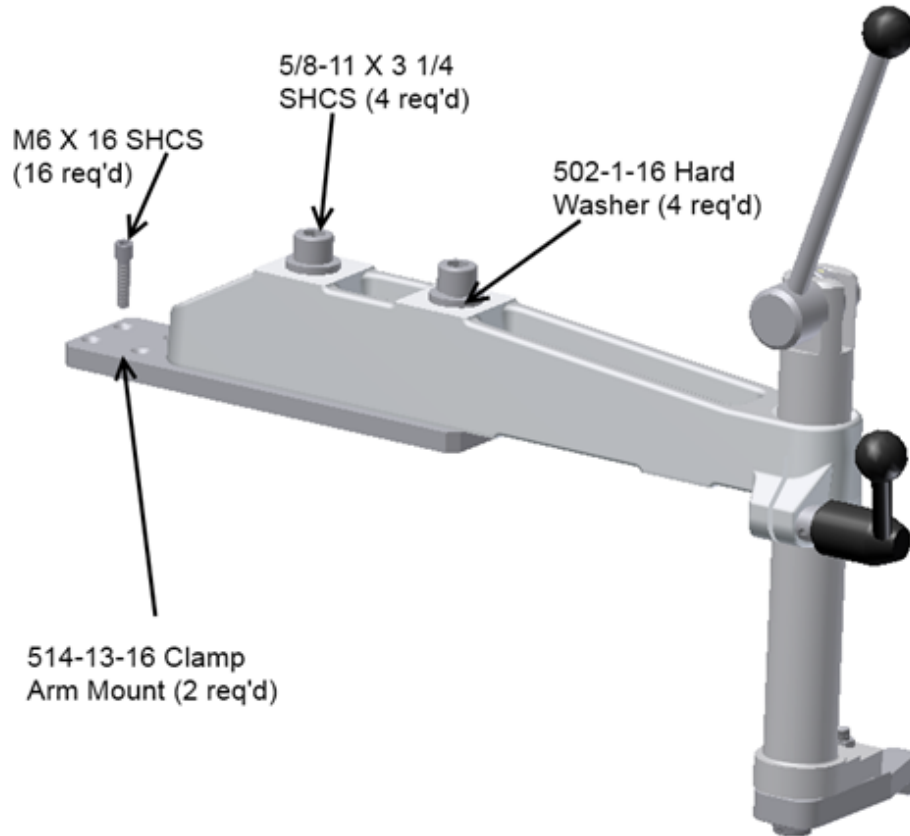
Splash Tray & Magnet

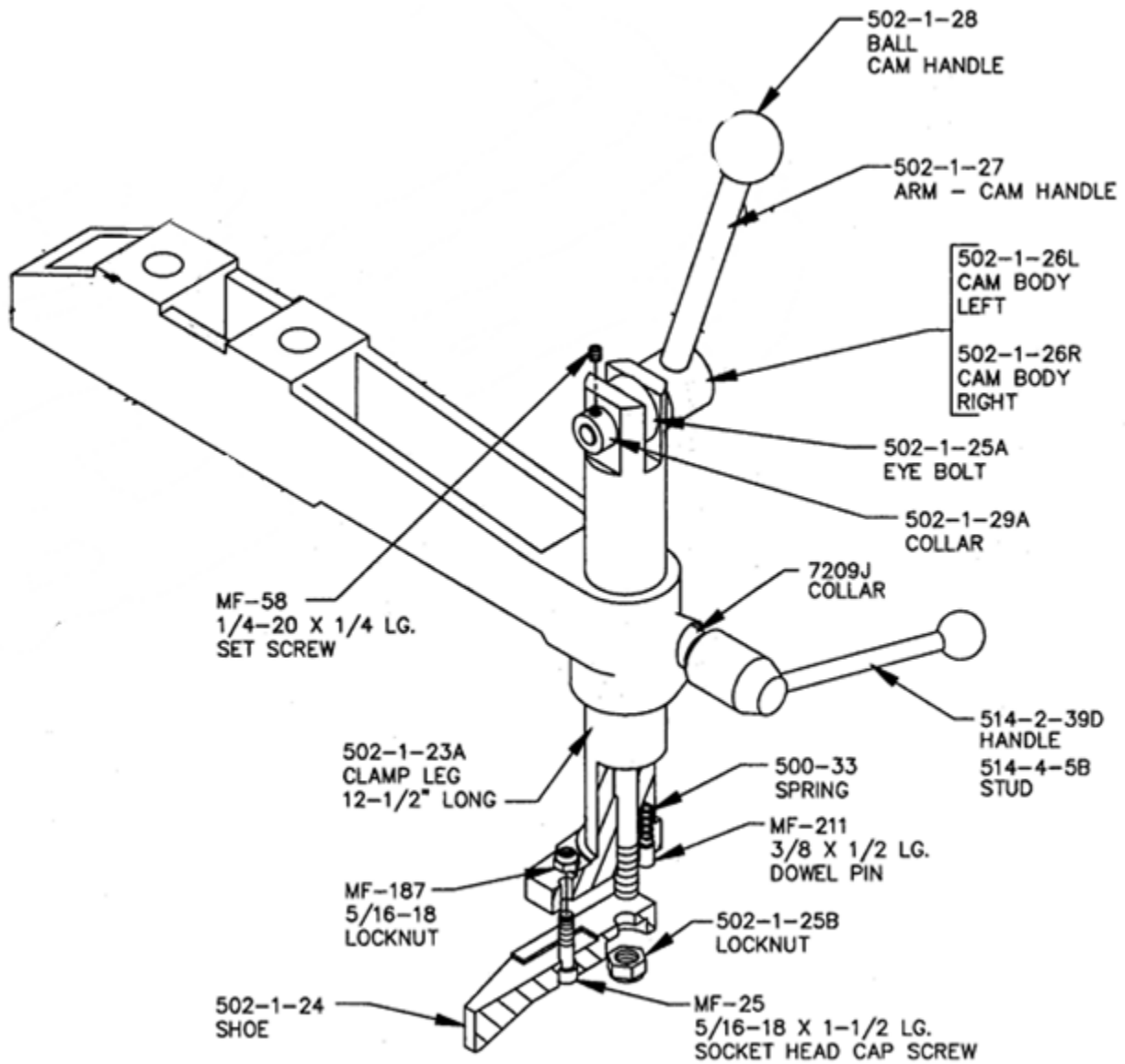
514-7-65S Splash Tray

514-7-65T Magnet Assembly

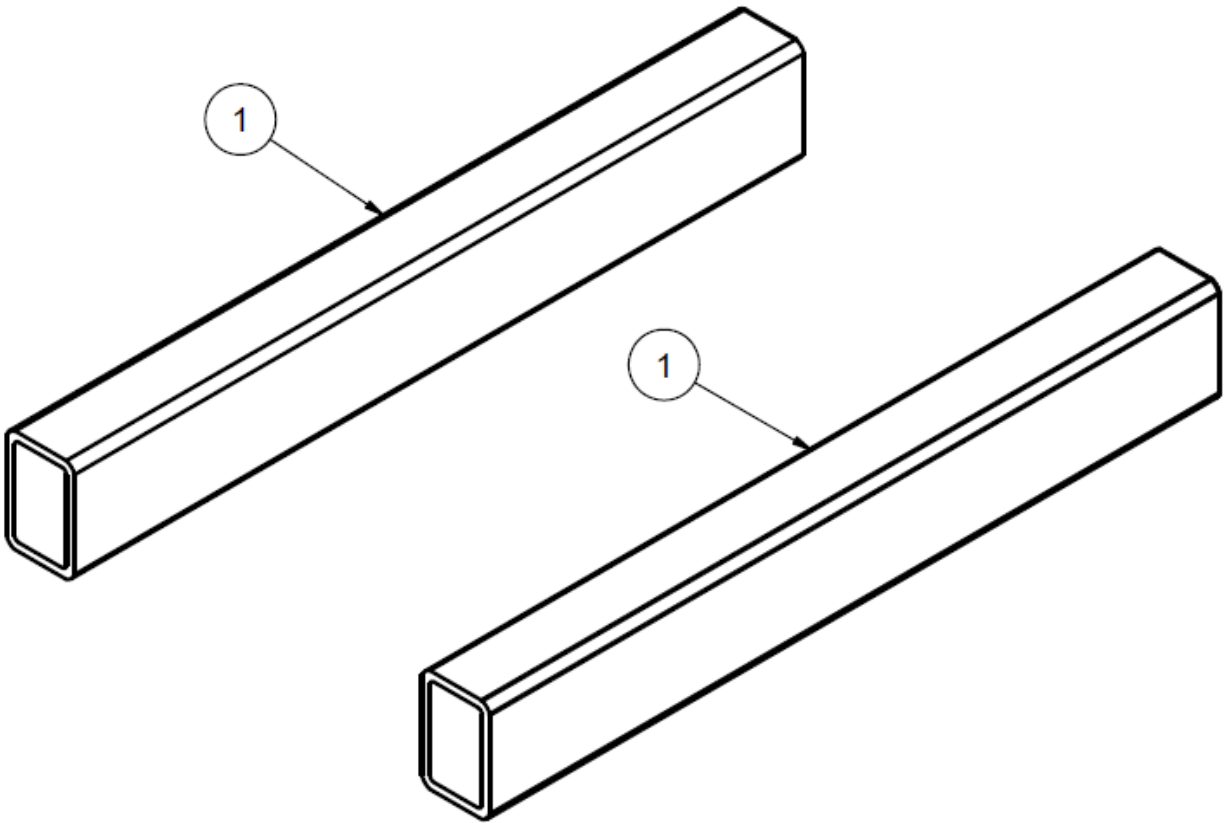


502-1-30H Clamp Arm Parts



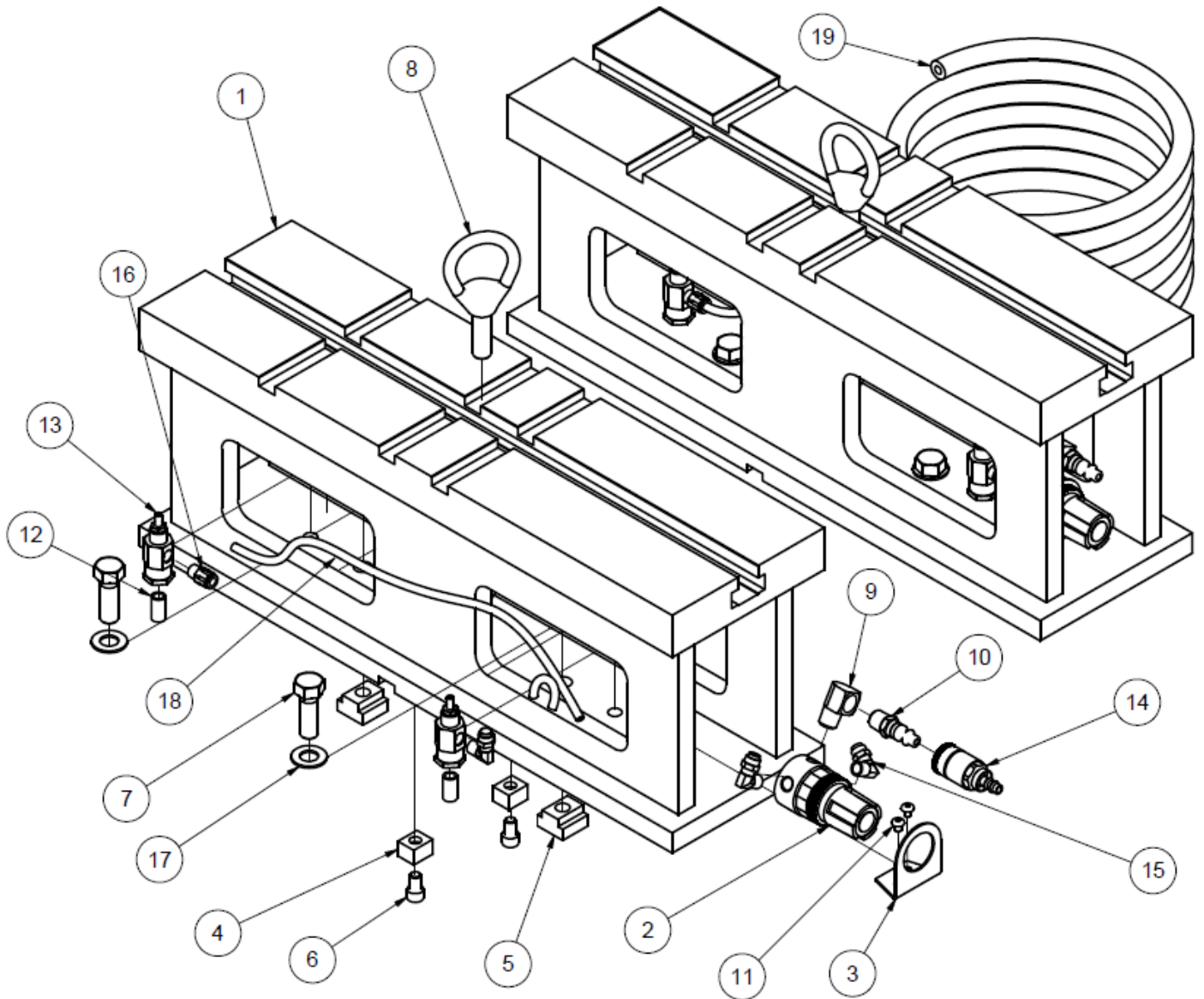


11115 2" (50mm) X 3" (75mm) Parallels



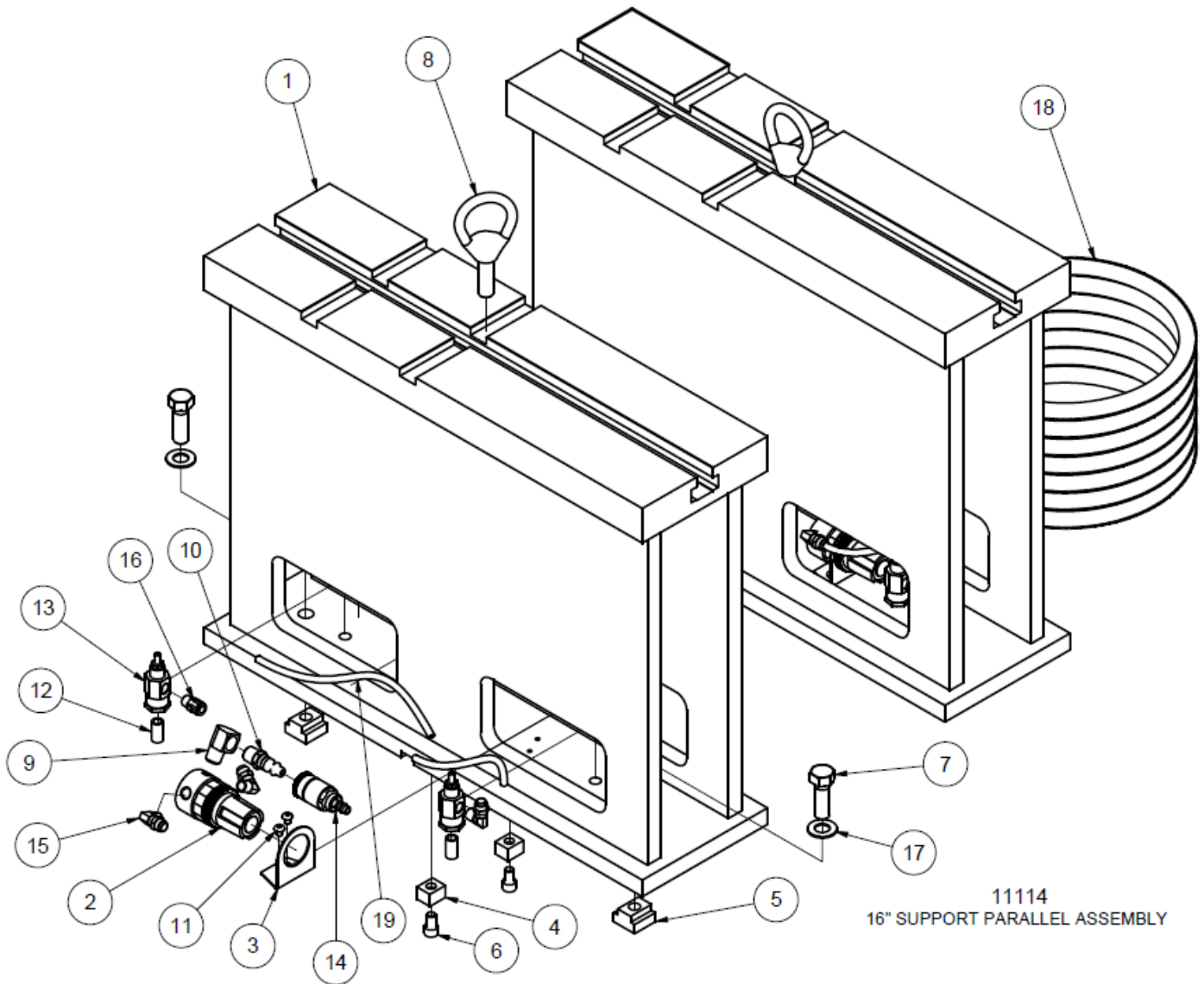
11115 2" x 3" PARALLEL SET			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	11115A	2" x 3" PARALLEL

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

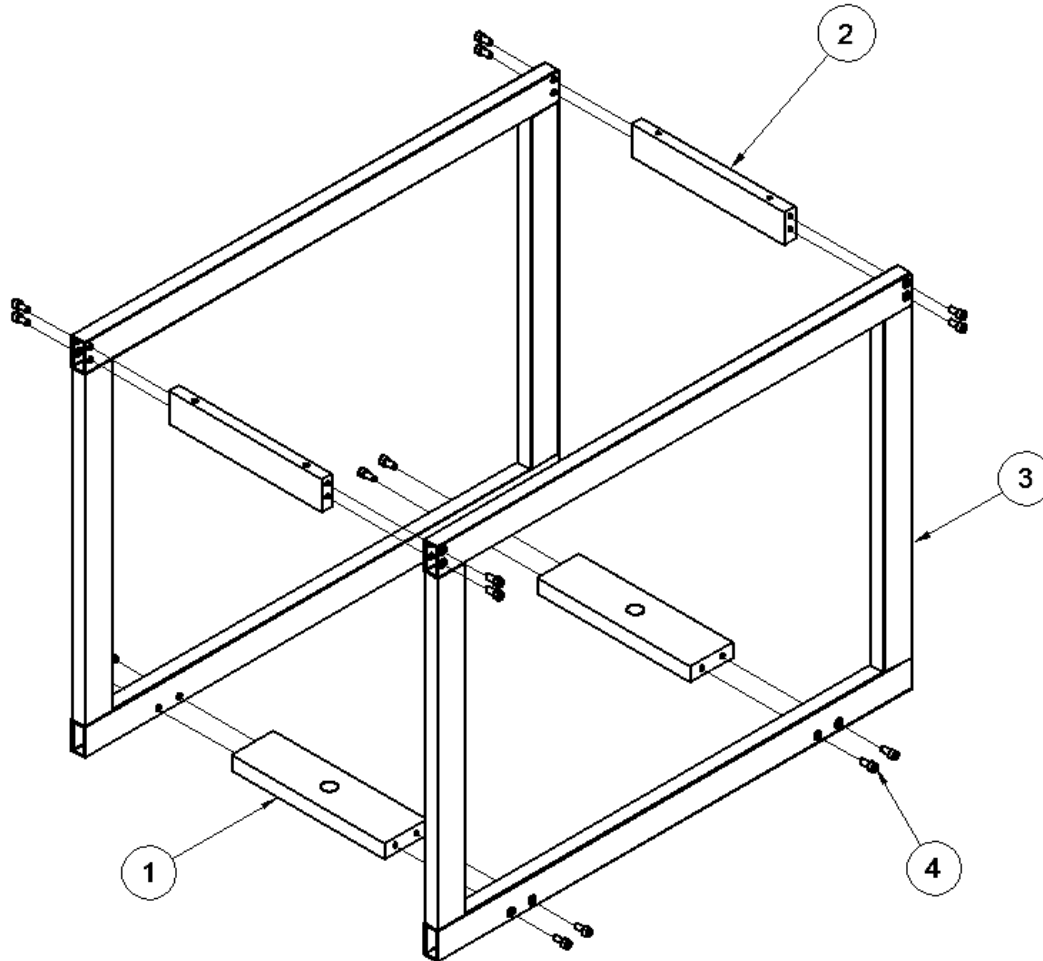
11114 Universal Heavy Duty T-Slot Parallels Parts



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

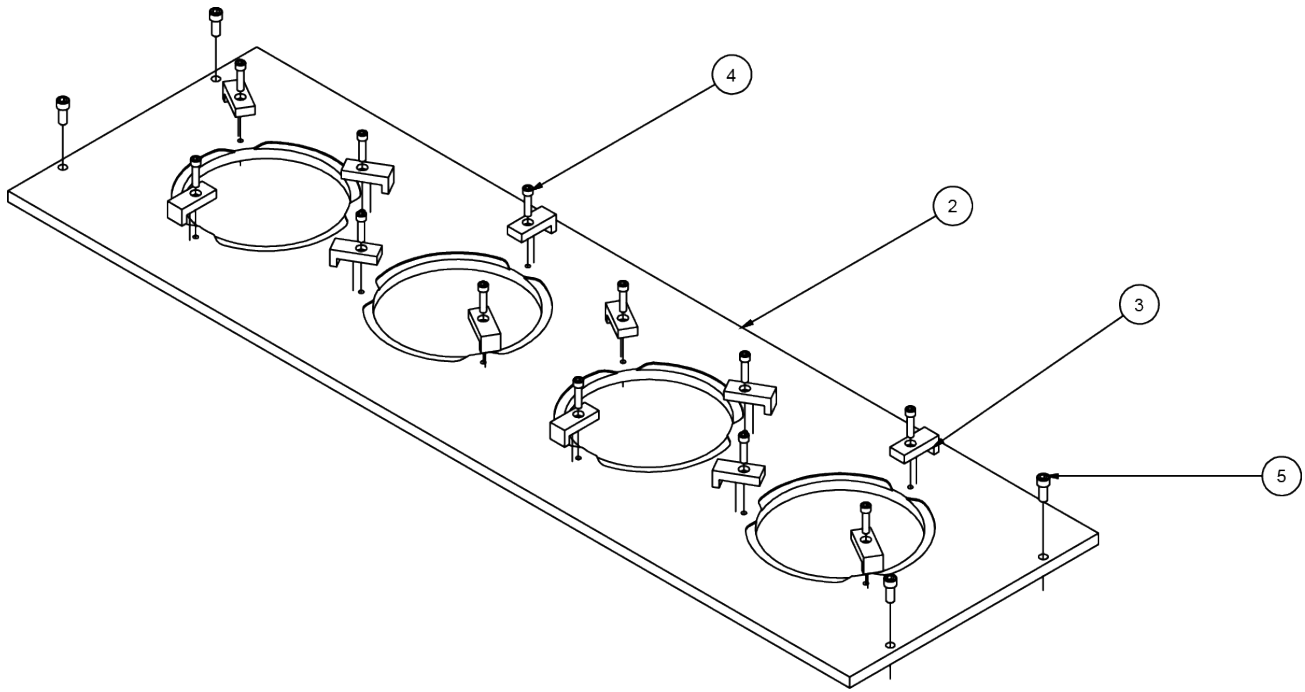
Cylinder Liner Fixtures

514-11-5 Cylinder Liner Honing Fixture Parts



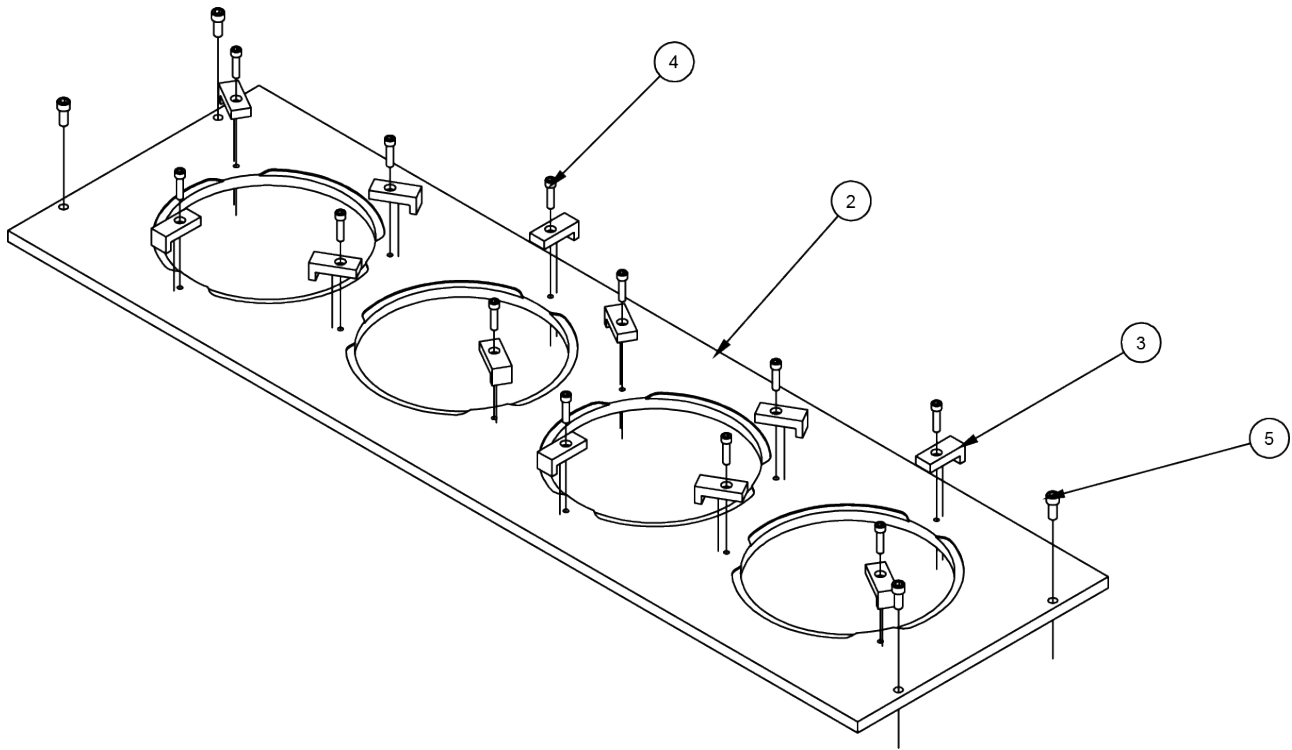
514-11-1A MAIN FRAME ASSEMBLY, CAT CYLINDER SLEEVE HONE FIXTURE			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	514-11-1E	LOWER CROSS BAR, CAT CYLINDER SLEEVE HONE FIXTURE
2	2	514-11-1D	UPPER CROSS BAR, CAT CYLINDER SLEEVE HONE FIXTURE
3	2	514-11-1B	FRONT/REAR FRAME (MACHINING), CAT CYLINDER SLEEVE HONE FIXTURE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

514-11-6 Fixture Plate Parts



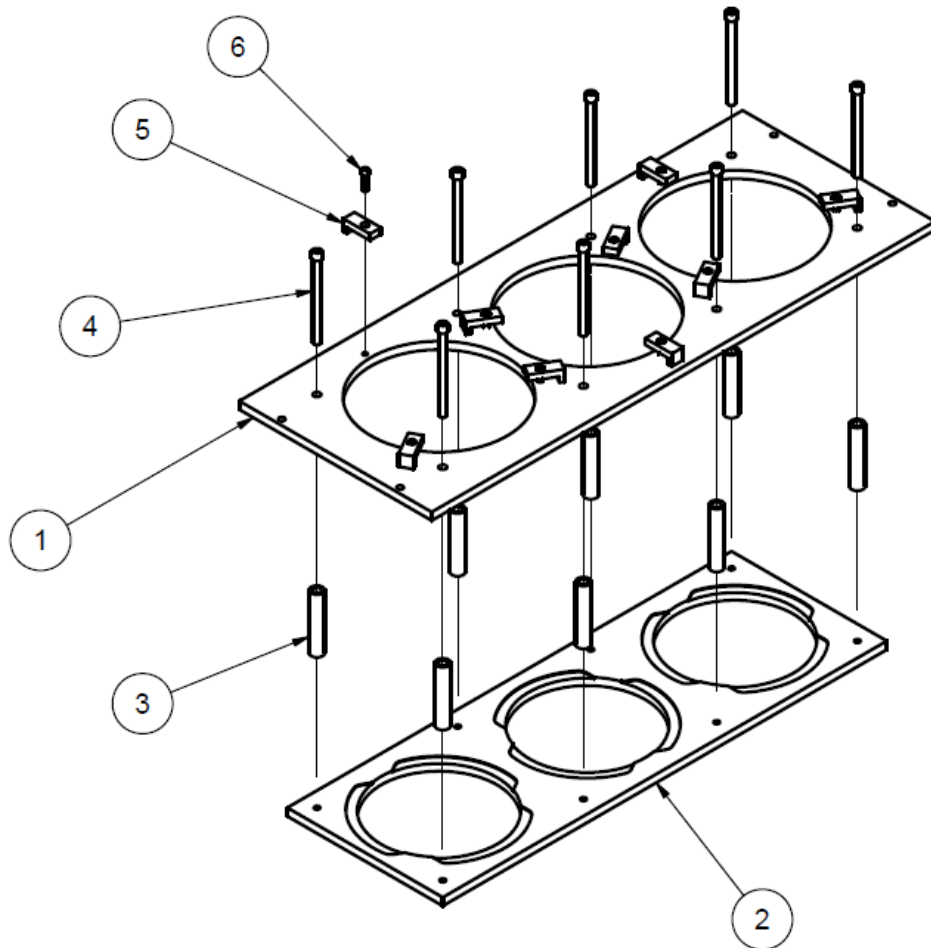
Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
2	1	514-11-6A	3400 SLEEVE TOP PLATE FIXTURE
3	12	514-11-2C	CLAMP
4	12	MF-15	1/4 - 20 UNC - 1"
5	4	MF-22	5/16 - 18 UNC - 3/4"

514-11-7 Fixture Plate 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 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 kit only



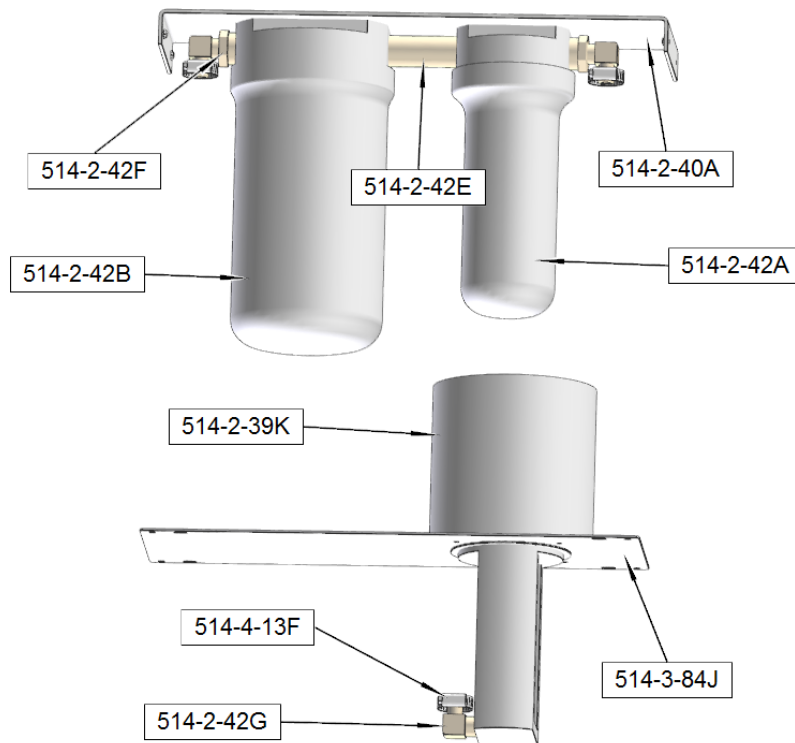
514-7-66D Filter paper

For standard coolant system (minimum order of 25)



514-2-40 Optional canister filter system

With high volume pump includes (1) one 10 micron and (1) one 20 micron canister filter



514-2-39P Filter Cartridge 10 micron

(replacement filter for 514-2-40) for synthetic coolant only

514-2-39Q Filter Cartridge 20 micron

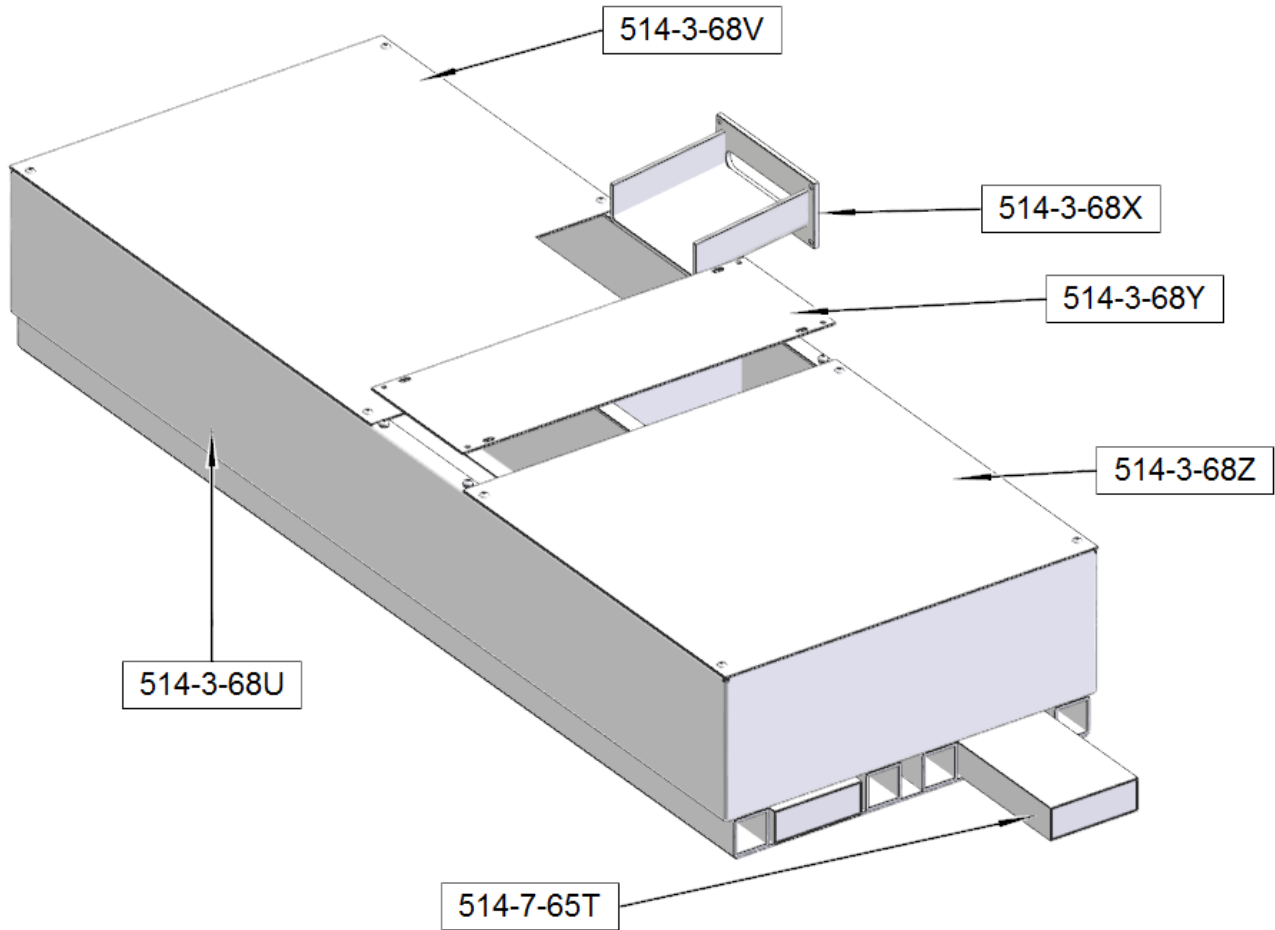
(replacement filter for 514-2-40) for synthetic coolant only

514-2-39Z Filter Cartridge 150 micron

(replacement filter for 514-2-40 for oil base coolant only)

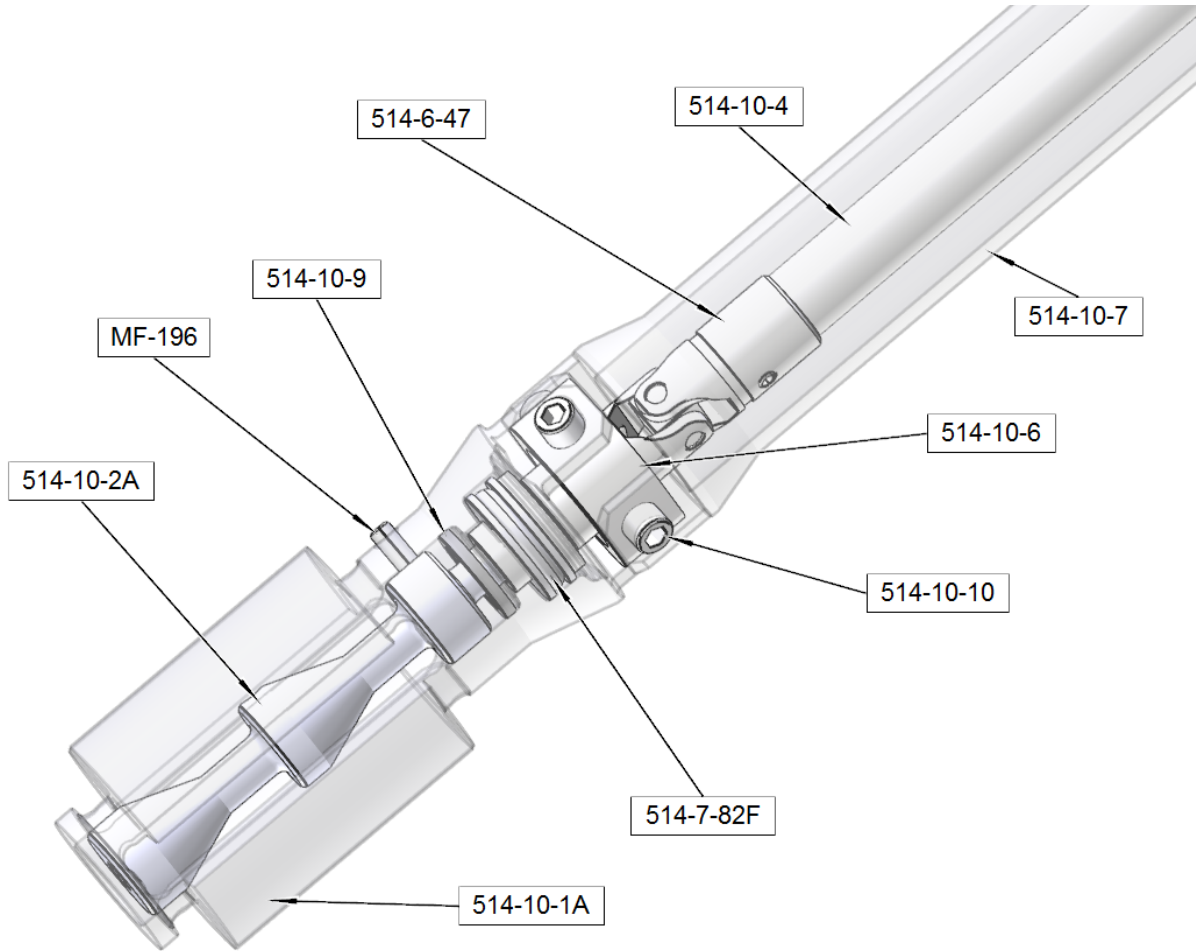


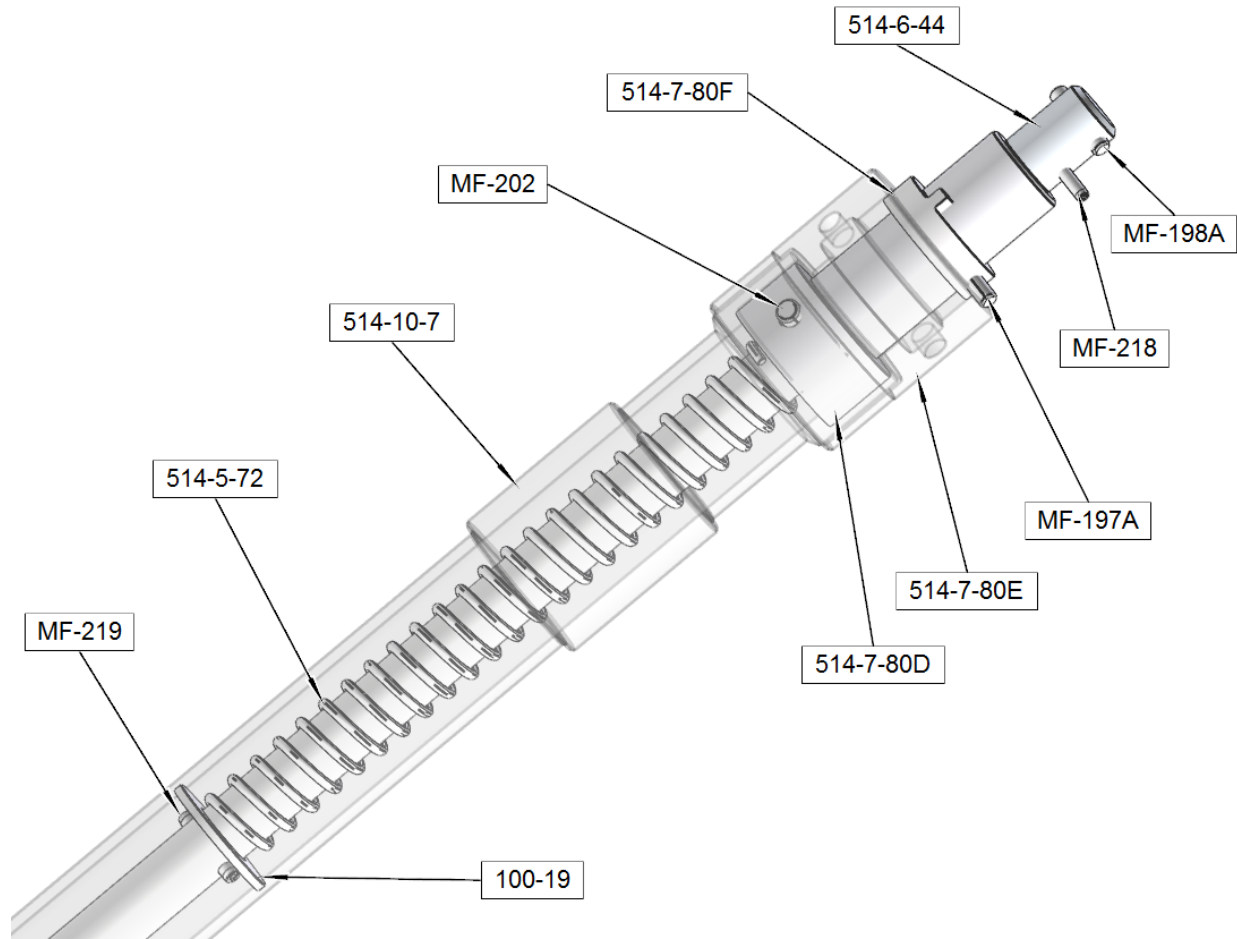
514-3-68W External Coolant Tank Parts



Precision Hone Heads, Sleeves and Stone Holders

514-10 Medium Hone Head Parts





Stone Holders for Medium Hone Head

514-10-13A Stone holder, 2.25 - 2.43" (57.15 - 61.72mm), set of 4



514-10-13B Stone holder, 2.38 - 2.63" (60.45 - 66.80mm), set of 4



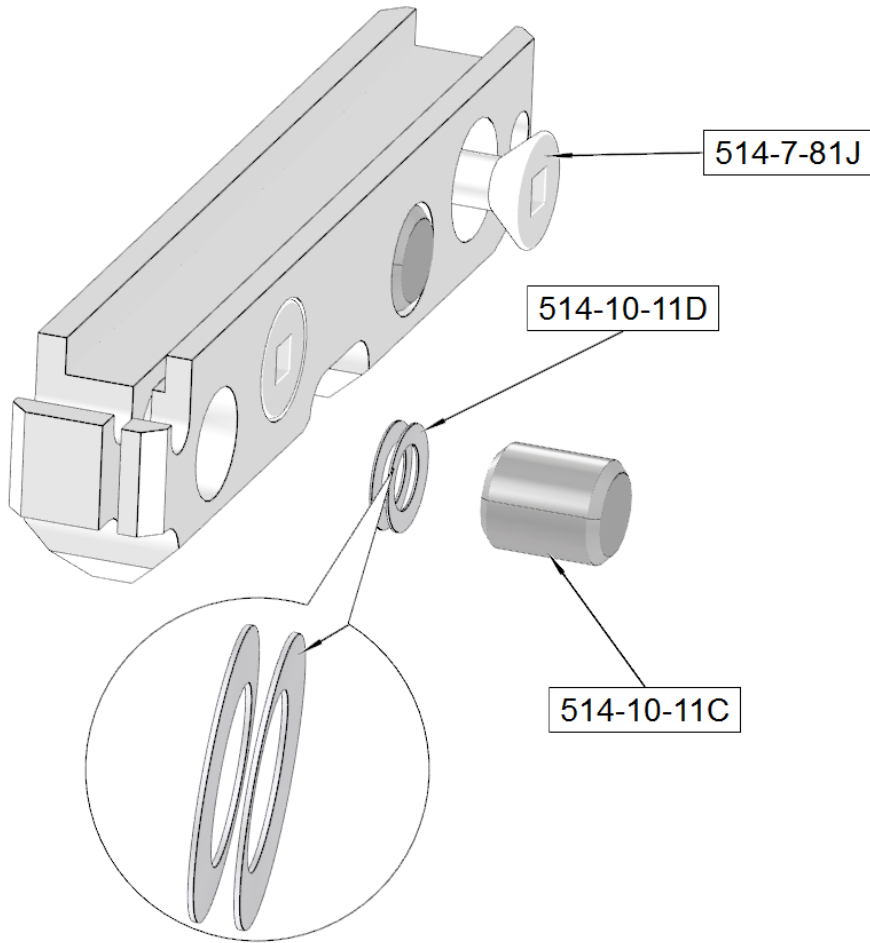
514-10-13C Stone holder, 2.58 - 2.83" (65.53 - 71.88mm), set of 4



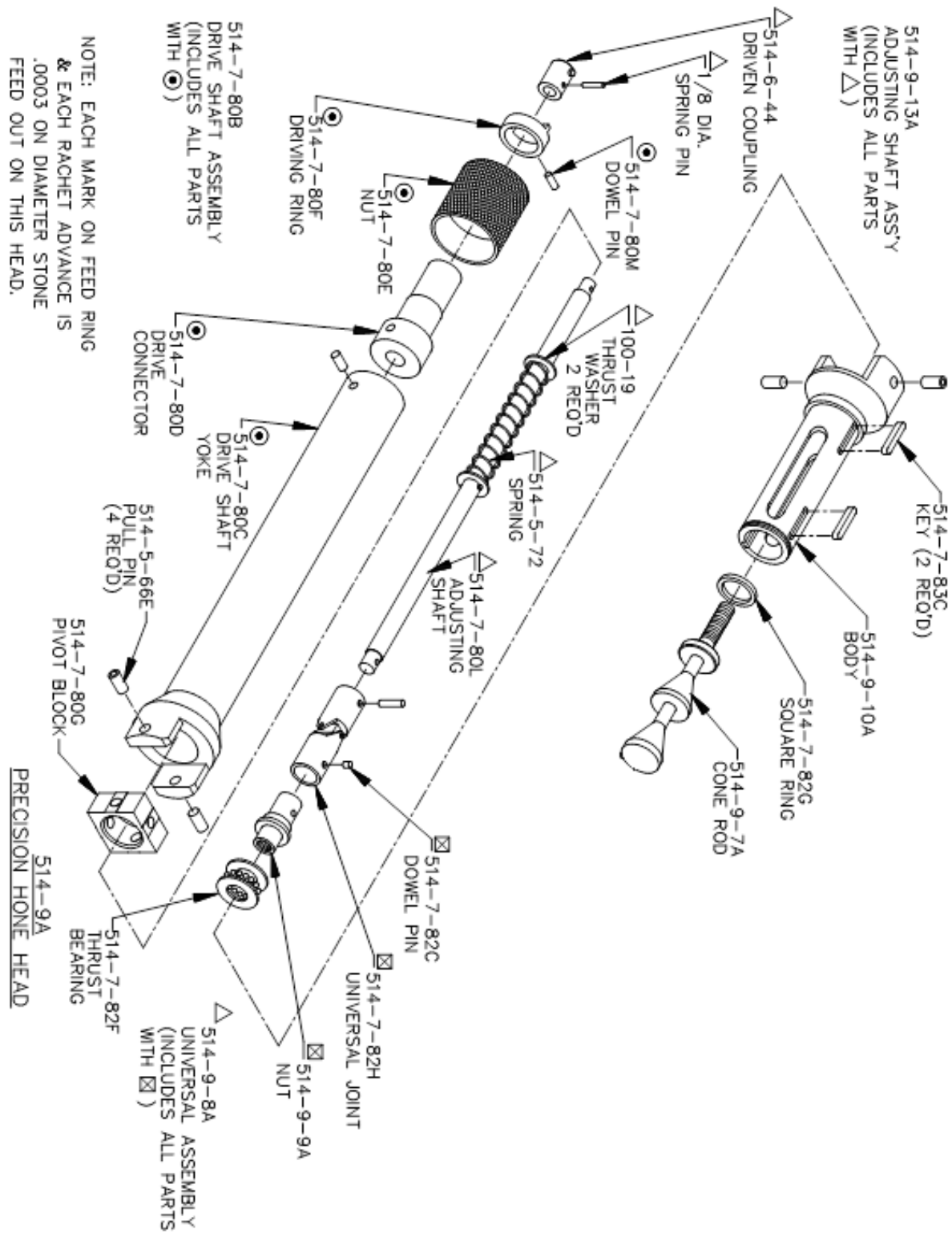
514-10-13D Stone holder, 2.78 - 3.03" (70.61 - 76.96mm), set of 4



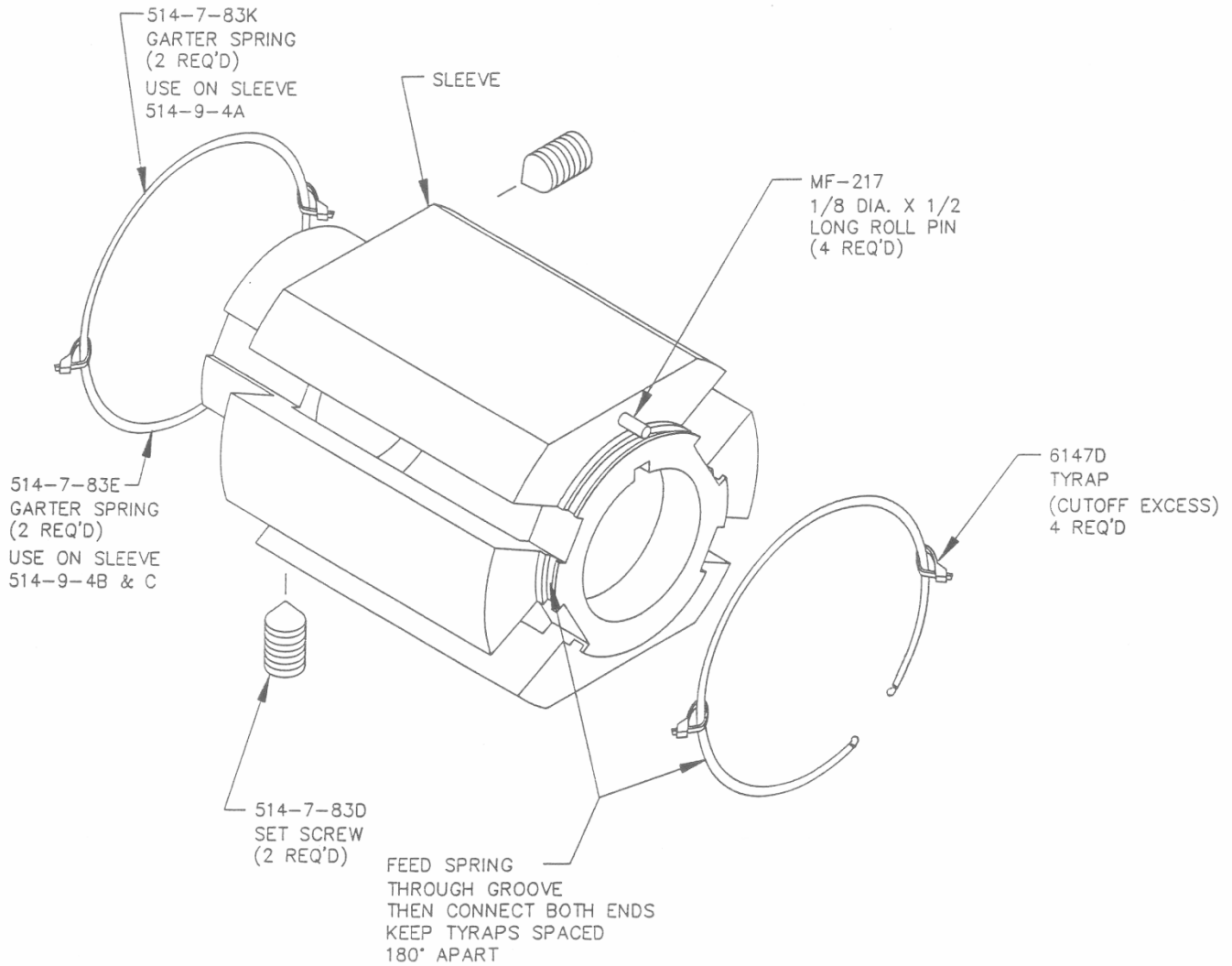
514-10-13 Series Stone Holder Parts



514-9A Large Hone Head Parts



514-9-4 Series Sleeve Parts



514-9-6J Stone Holder

2.990 - 3.44" (75.95 - 87.38mm) set of 4 (Requires Sleeve 514-9-4A)

Note: To hone diameter 2.84" (72.14mm) use 514-9-14D Stone Set .200" (5.1mm) height with 514-9-6J Stone Holders



514-9-6A Stone Holder

3.165 - 3.630" (80.39 - 92.20mm) set of 4 (Requires Sleeve 514-9-4A)



514-9-6B Stone Holder

3.415 - 3.880" (86.74 - 98.55mm) set of 4 (Requires Sleeve 514-9-4A)



514-9-6C Stone Holder

3.665 - 4.130" (93.09 - 104.90mm) set of 4 (Requires Sleeve 514-9-4B)



514-9-6D Stone Holder

3.915 - 4.380" (99.44 - 111.25mm) set of 4
(Requires Sleeve 514-9-4B)



514-9-6E Stone Holder

4.165 - 4.630" (105.79 - 117.60mm) set of 4
(Requires Sleeve 514-9-4B)



514-9-6F Stone Holder

4.415 - 4.880" (112.14 - 123.95mm) set of 4
(Requires Sleeve 514-9-4C)



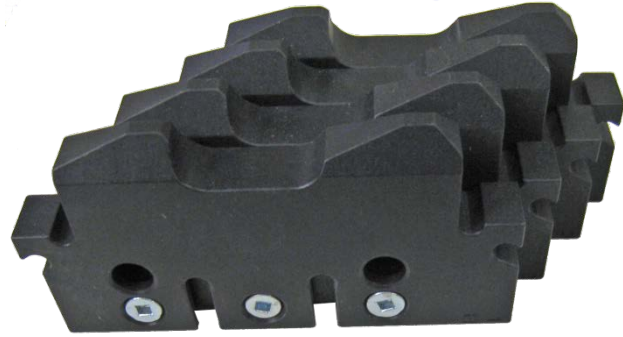
514-9-6G Stone Holder

4.665 - 5.130" (118.49 - 130.30mm) set of 4
(Requires Sleeve 514-9-4C)



514-9-6H Stone Holder

4.915 - 5.380" (124.84 - 136.65mm) set of 4
(Requires Sleeve 514-9-4C)



514-9-6K Stone Holder

5.165 - 5.630" (131.19 - 143.00mm) set of 4
(Requires Sleeve 514-9-4C)



514-9-6L Stone Holder

5.415 - 5.880" (137.54 - 149.35mm) set of 4
(Requires Sleeve 514-9-4C)



514-9-6M Stone Holder

5.665 - 6.130" (143.89 - 155.70mm) set of 4
(Requires Sleeve 514-9-4C)



514-9-6N Stone Holder

5.915 - 6.380" (150.24 - 162.05mm) set of 4
(Requires Sleeve 514-9-4C)



514-9-6P Stone Holder

6.165 - 6.630" (156.59 - 168.40mm) set of 4
(Requires Sleeve 514-9-4C)



514-9-6Q Stone Holder

6.415 - 6.880" (162.94 - 174.75mm) set of 4
(Requires Sleeve 514-9-4C)



514-9-6R Stone Holder

6.665 - 7.130" (169.29 - 181.10mm) set of 4
(Requires Sleeve 514-9-4C)

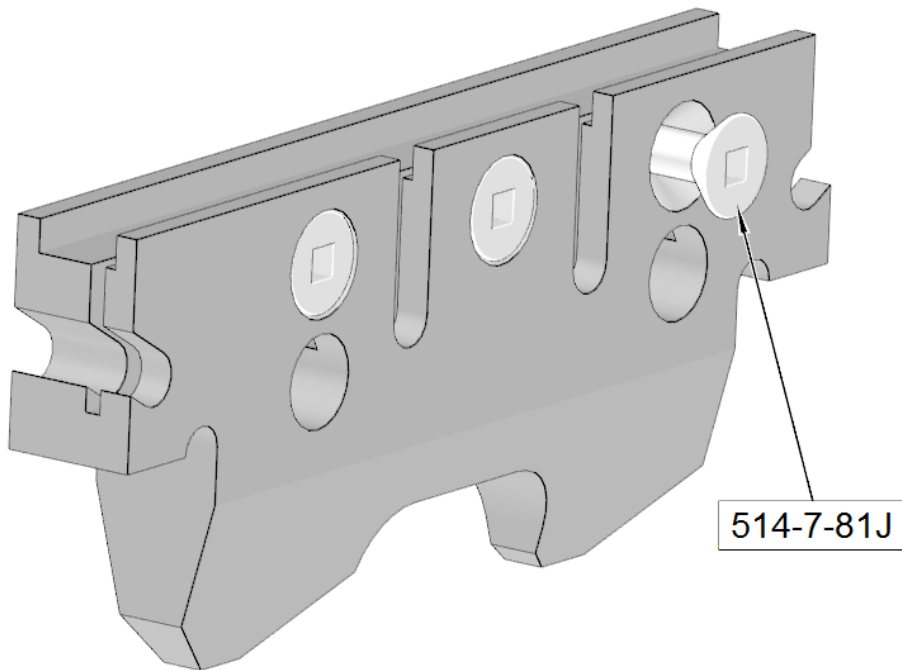


514-9-6S Stone Holder

6.915 - 7.380" (175.64 - 187.45mm) set of 4
(Requires Sleeve 514-9-4C)



514-9-6 Series Stone Holder Parts



Abrasives for Precision Hone Heads

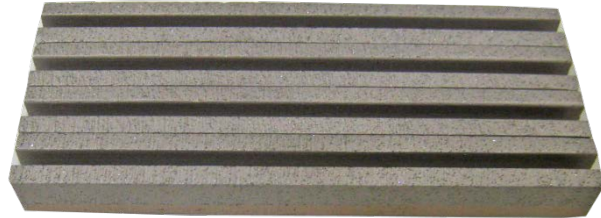
NOTE: Ra - Roughness Average. Value before Ra is in micro inches. Value in brackets um is micro meters. Long designates length of stone. Height designated thickness of stone.

Diamond Stones

.312" (7.90mm) Height

514-9-14F Diamond stones, 80 grit

3" (76mm) long, 90Ra (2.25um)
stock removal .004-.007/min.



514-9-14R Diamond stones

80 grit, 3 1/2" (89mm) long, 90Ra (2.25um)
stock removal .004-.007/min. (.102 - .178mm)



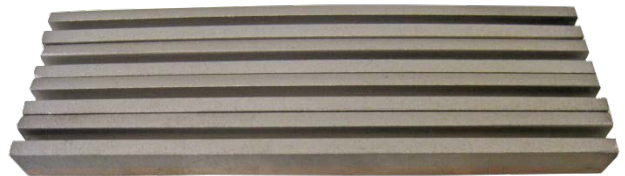
514-9-14W Diamond stones, 140/170 grit

3" (76mm) long, 50-75Ra (1.25 - 1.875um)



514-9-14K Diamond stones, 170/200 grit

3" (76mm) long, 45-60Ra (1.125 - 1.5um)



514-9-14M Diamond stones, 170/200 grit

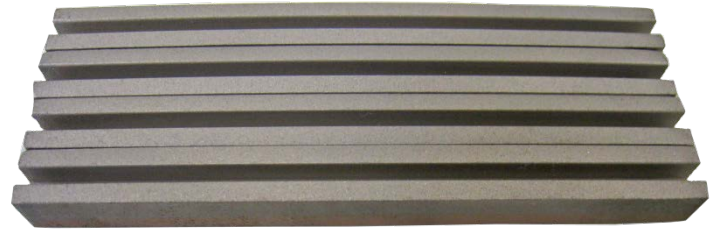
3 1/2" (89mm) long, 45-60Ra (1.125 - 1.5um)



514-9-14J Diamond stones, 270/325 grit
3" (76mm) long, 35-45Ra (.875 - 1.125um)



514-9-14T Diamond stones, 270/325 grit
3 1/2" (89mm) long, 35-45Ra (.875 - 1.125um)



514-9-14Z Diamond Stones 270/325 grit
4" (102mm) long, 35-45Ra (.875 - 1.125um)



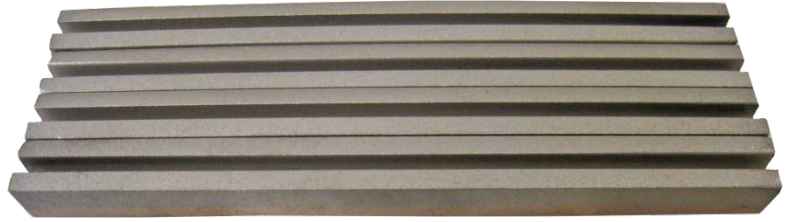
514-9-14E Diamond stones, 325/400 grit
3" (76mm) long, 24-30Ra (.6 - .75um)



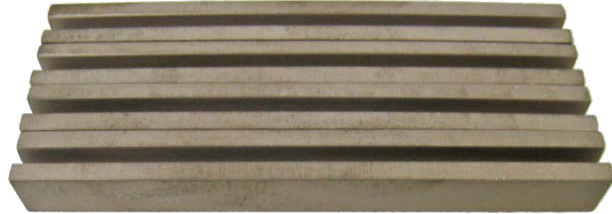
514-9-14Q Diamond stones, 325/400 grit
3 1/2" (89mm) long, 24-30Ra (.6 - .75um)



514-9-14X Diamond stones, 325/400 grit
4" (102mm) long, 24-30Ra (.6 - .75um)



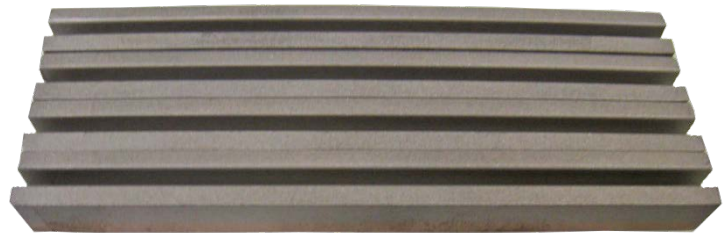
514-9-14V Diamond stones, 400 grit
3" (76mm) long, 15-19Ra (.375 - .475um)



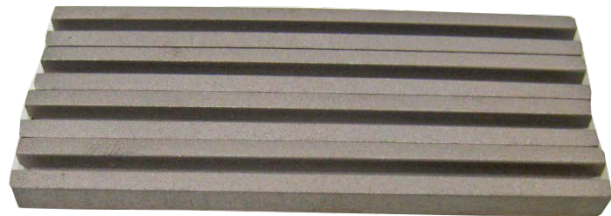
514-9-14C Diamond stones, 500 grit
3" (76mm) long, 18-22Ra (.45 - .55um)



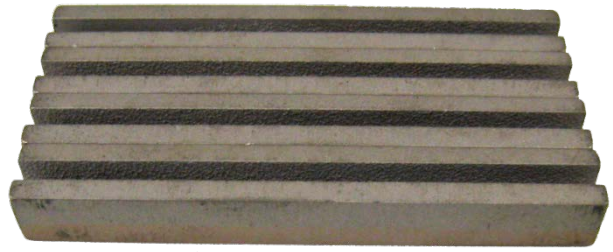
514-9-14P Diamond stones, 500 grit
3-1/2" (89mm) long, 18-22Ra (.45 - .55um)



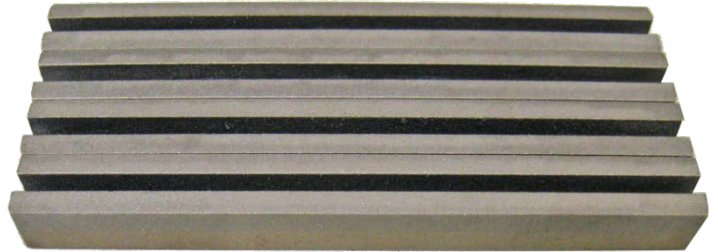
514-9-14D Diamond stones, 325/400 grit
3" (76mm) long, 18-22Ra (.45 - .55um)
Special required for bores under 2.990" diameter
(75.94mm) .200" (5.1mm) Height



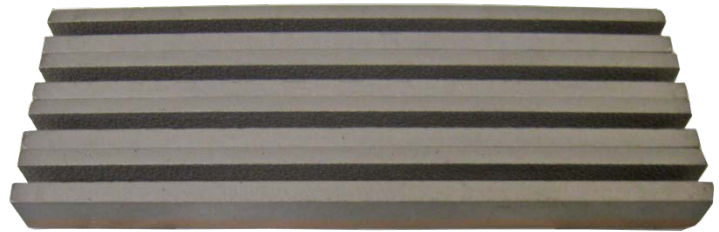
514-9-14U Diamond stones, 500 grit
2 1/2" (64mm) long, 18-22Ra (.45 - .55um)



514-9-14L Diamond stones, 550 grit
3" (76mm) long, 15-19Ra (.375 - .475um)



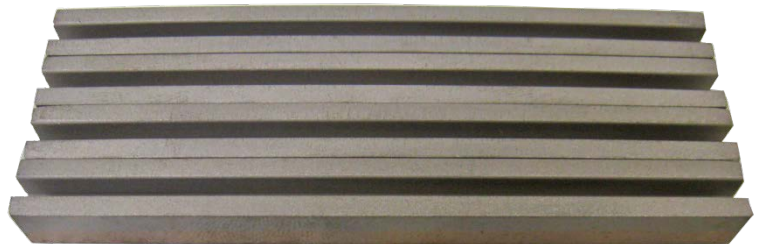
514-9-14N Diamond stones, 550 grit
3 1/2" (89mm) long, 15-19Ra (.375 - .475um)



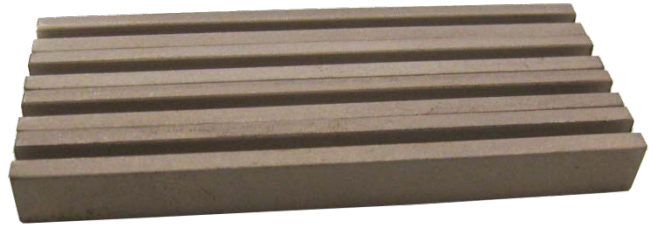
514-9-14G Diamond stones, 600 grit
3" (76mm) long, 8-12Ra (.2 - .3um)



514-9-14S Diamond stones, 600 grit
3 1/2" (89mm) long, 8-12Ra (.2 - .3um)



514-9-21G Diamond stones, 800 grit
3" (76mm) long



514-9-21H Diamond stones, 1000 grit
3" (76mm) long



514-9-21J Diamond stones, 1200 grit
3" (76mm) long



Brushes for Plateau Finishing

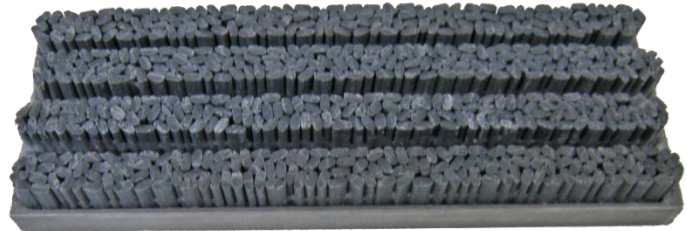
514-9-14H Brushes, for Plateau Finishing

.550" (14mm) height, 3 1/2" (89mm) long, requires one or two size smaller stone holder compared to .312" (7.90mm) height diamond stone. For diameter range, please see HP7A manual.



514-9-14Y Brushes, for Plateau Finishing

.395" (10mm) height, 3 1/2" (89mm) long, requires same or one size smaller stone holder compared to .312" (7.90mm) height diamond stone. For diameter range, please see HP7A manual.



Special Stones for Finishing Aluminum Silicone Cylinders

(Refer to bulletin No. 284) Requires Rottler Precision Hone Heads

514-9-18P Special Red Finish Diamonds

For final sizing (set of 4)



514-9-18N Silicone Abrasive Exposing Stones

For Removing Aluminum (set of 4)



514-9-21 Polishing felt pads

For use with 514-9-21F silicon paste. (set of 4)

514-9-21F Silicone Paste

For use with 514-9-21 Polishing felt pads



Optional Measuring Equipment

201 Mitutoyo Surface Tester Surftest

Sold only as complete unit



514-8-27 Stone Depth Scale and Holder Assembly (inch)

Sold only as complete unit

514-8-27F Stone Depth Scale and Holder Assembly (metric)

Sold only as complete unit

