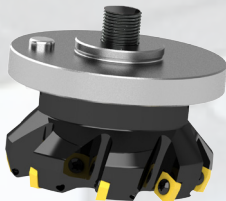
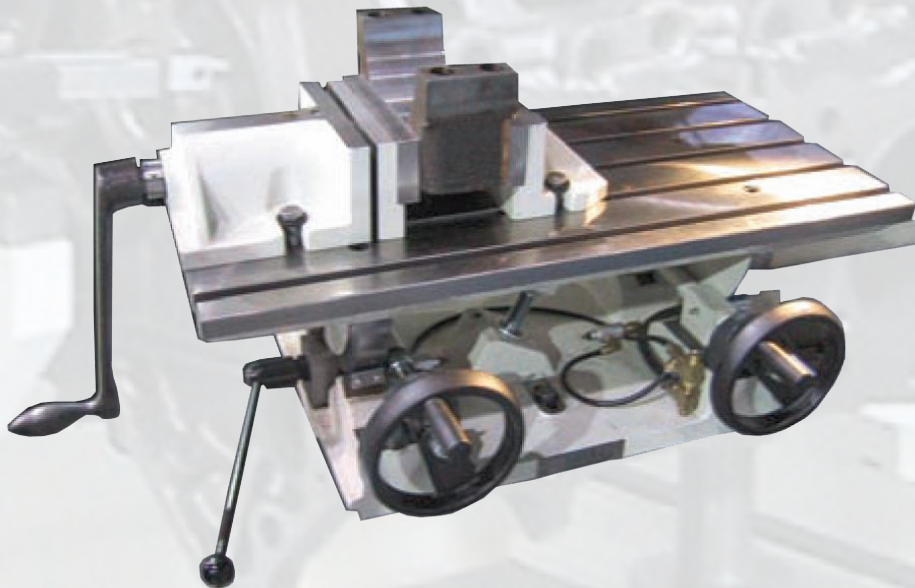


ROTTLER

SAD SERIES 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@rottlermfg.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

S7AD /S8AD OPTIONAL EQUIPMENT PARTS MANUAL

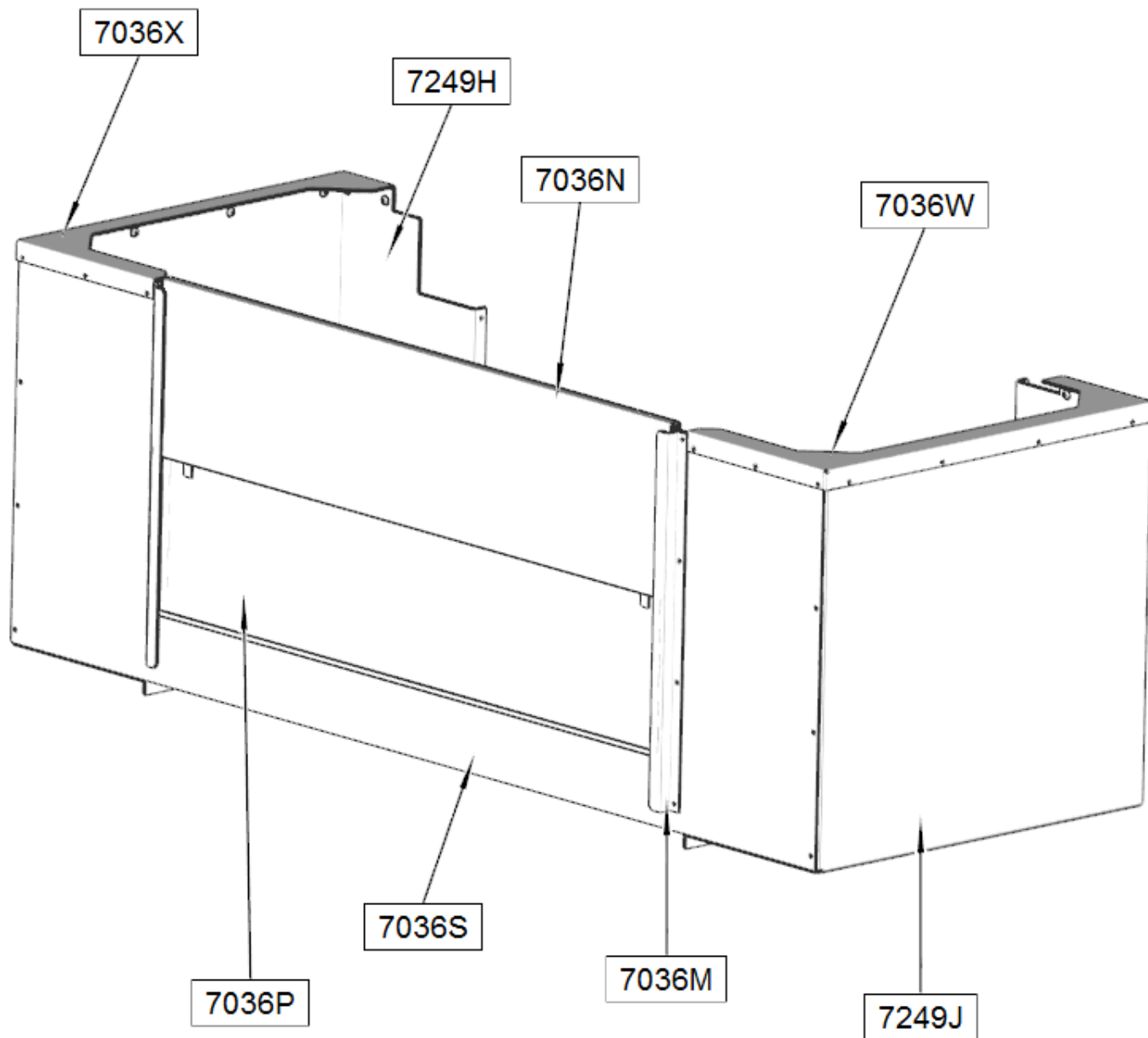
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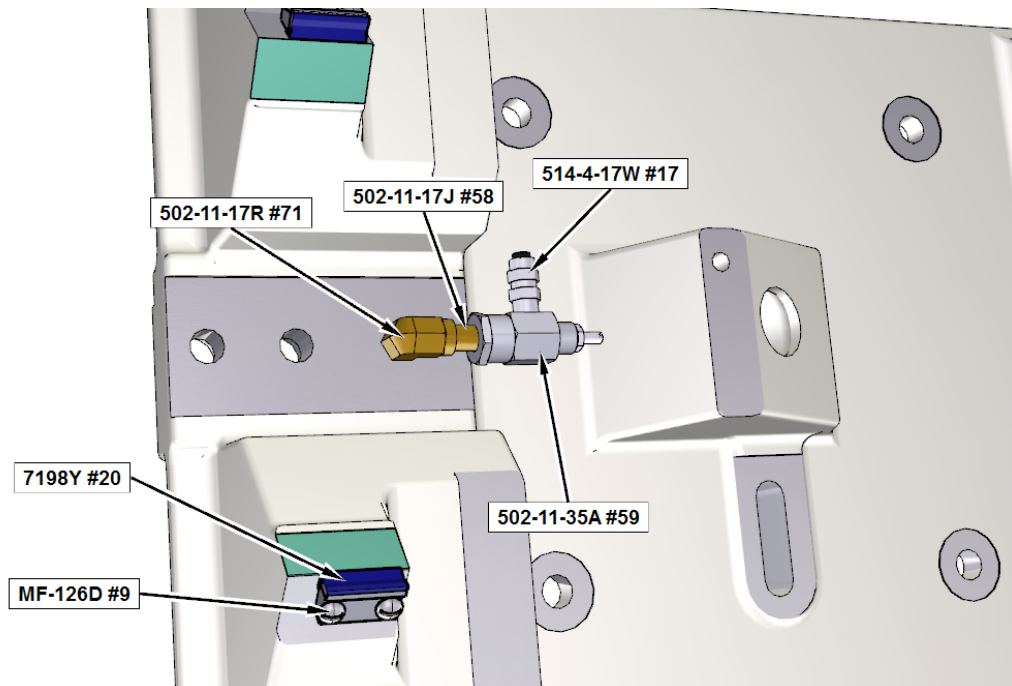
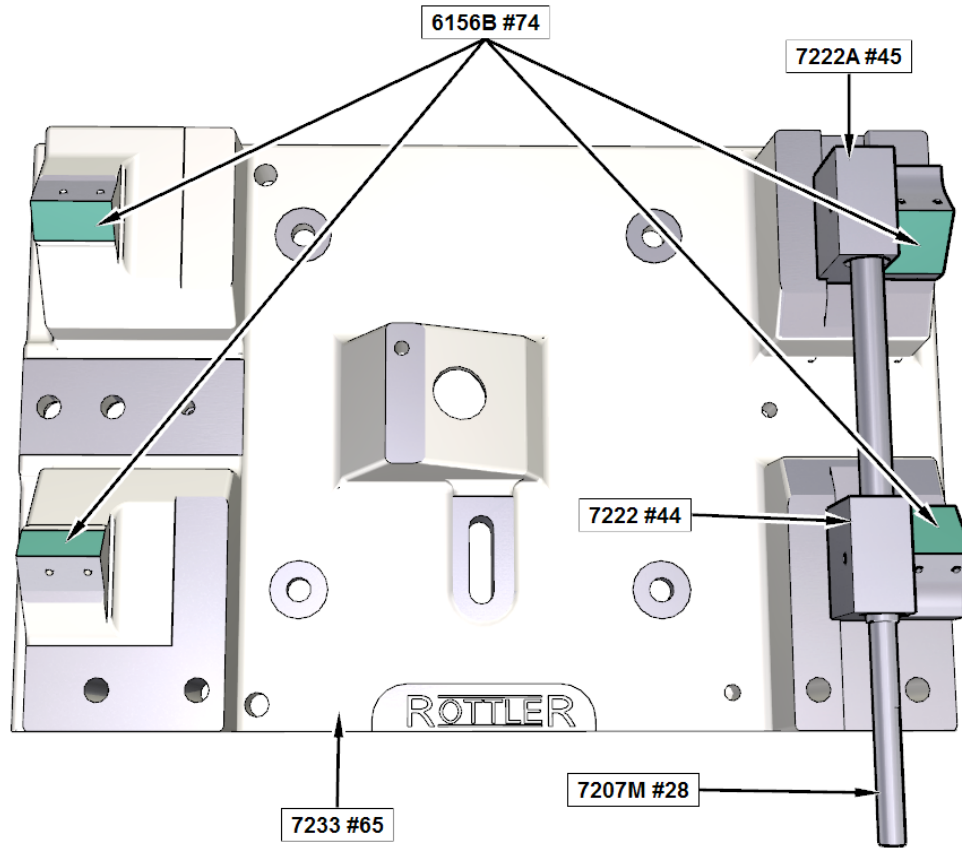
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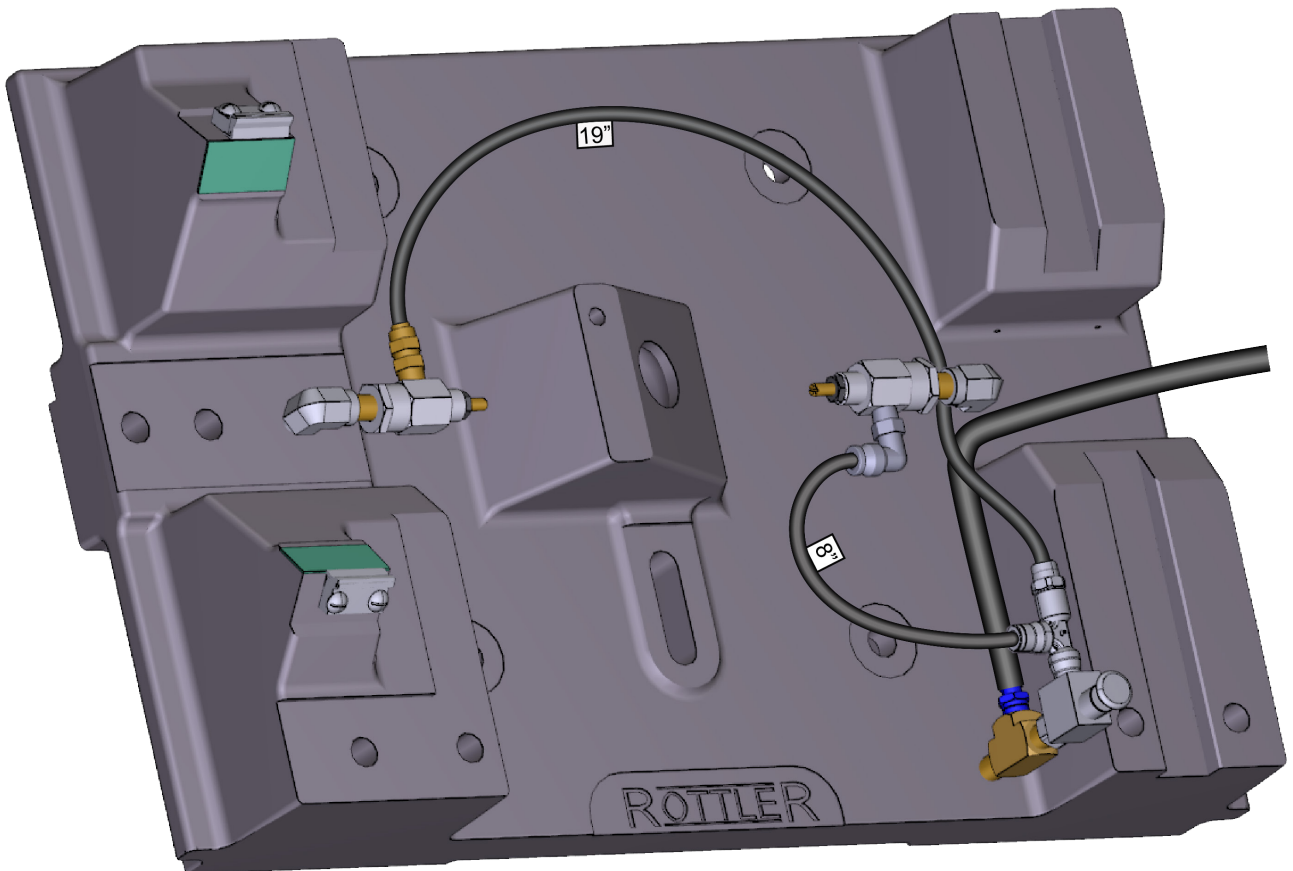
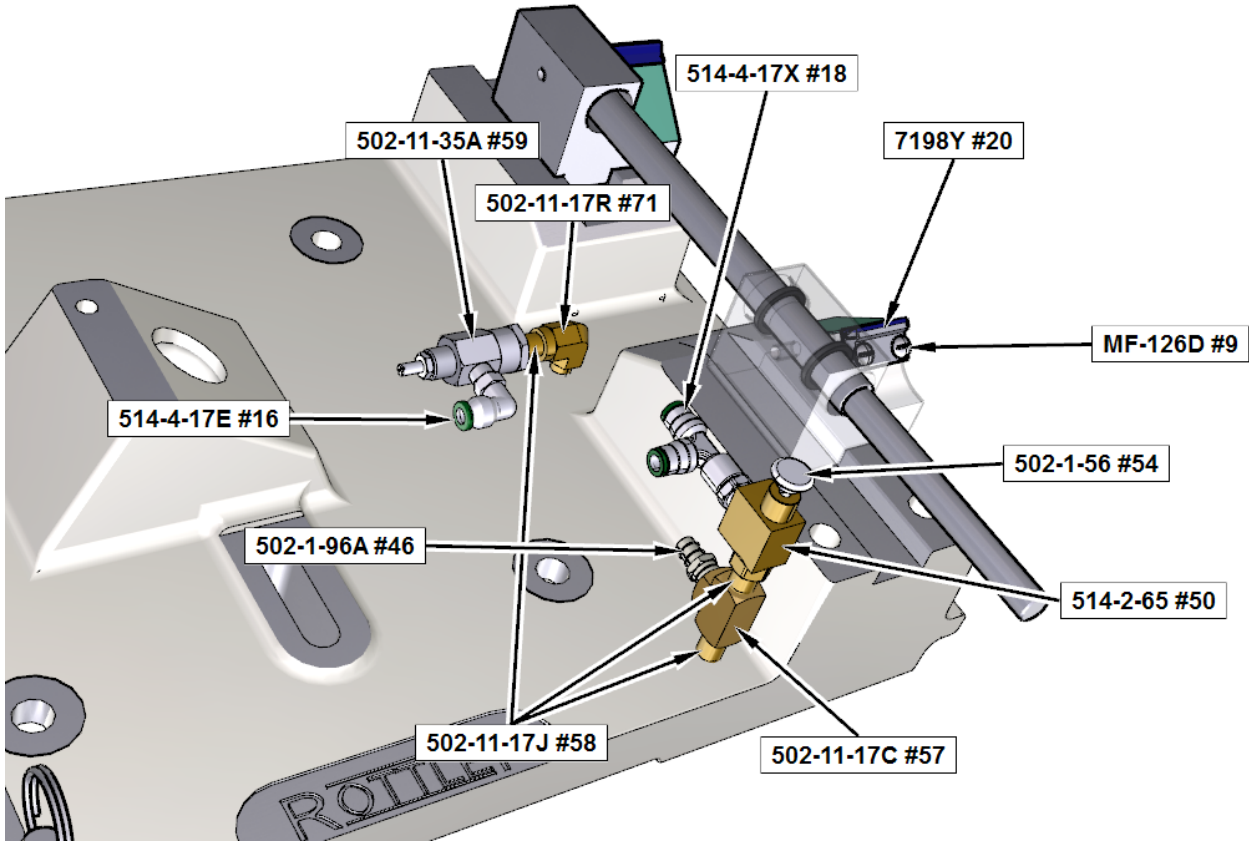
Safety Equipment

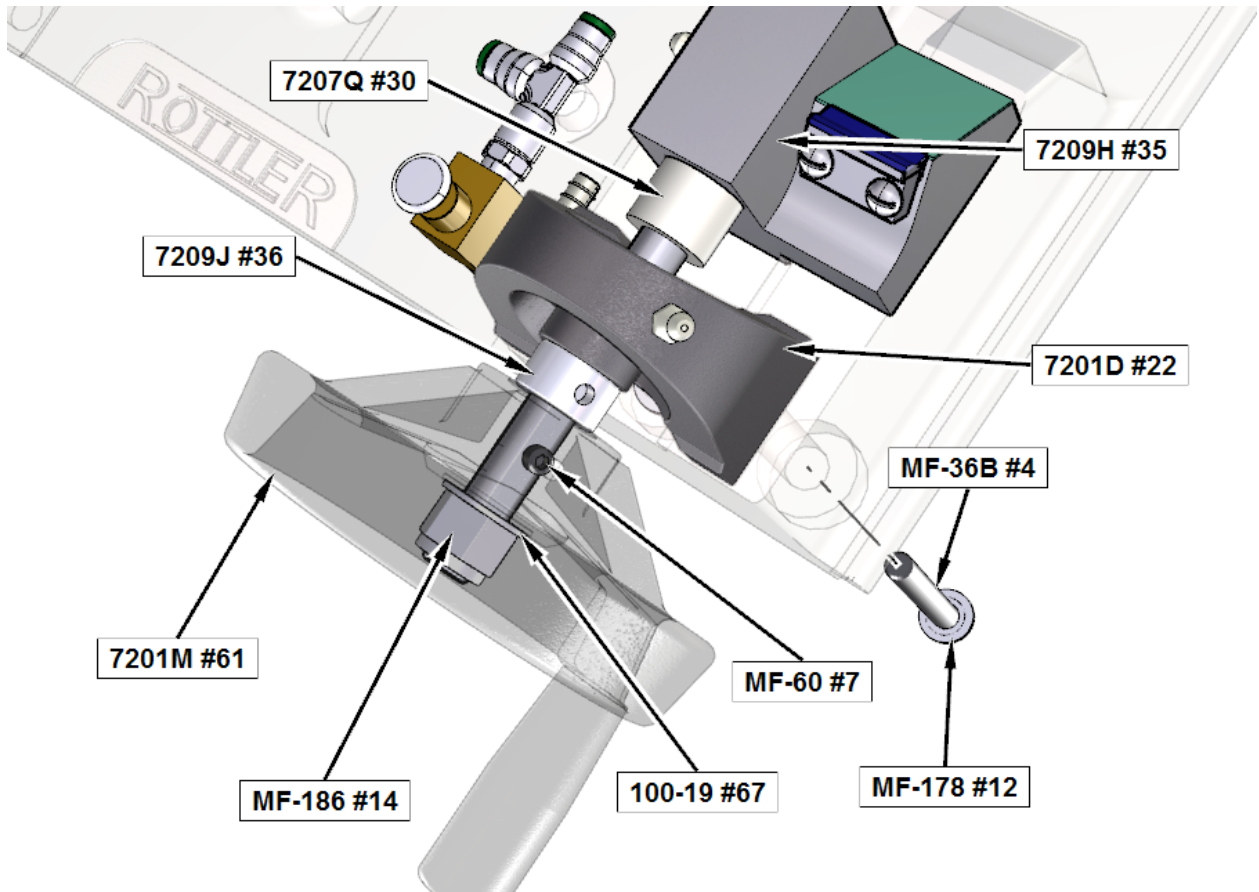
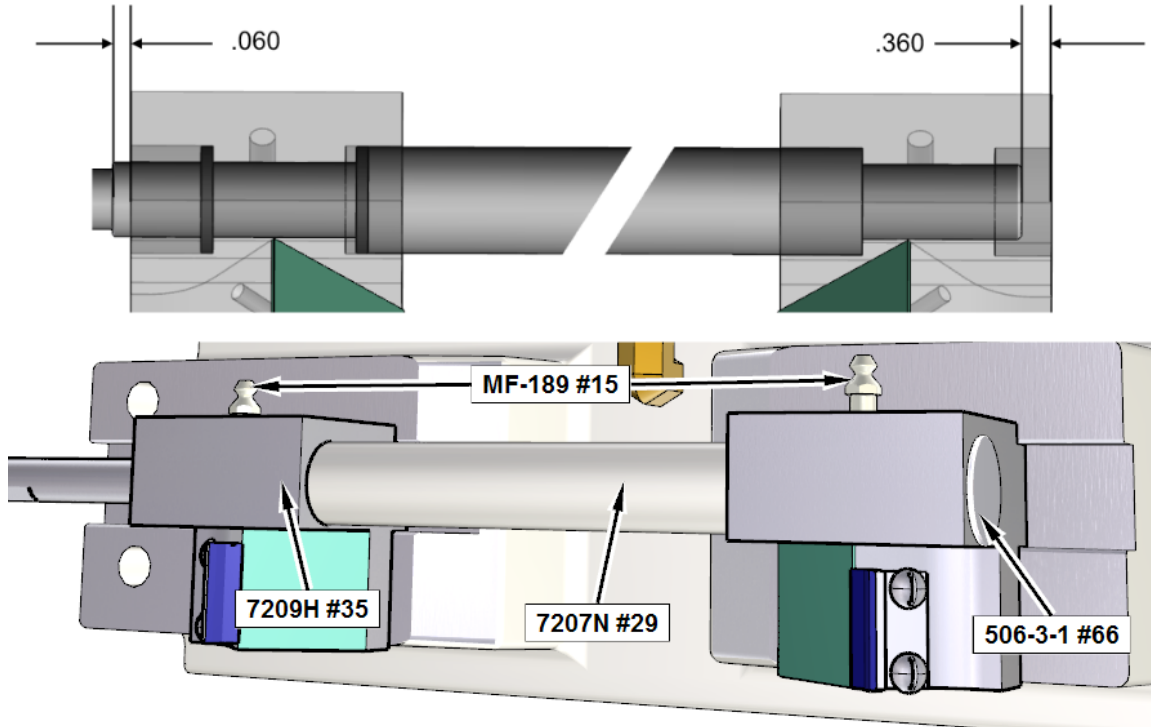
7036Y Full Steel Enclosure with Folding Door Parts

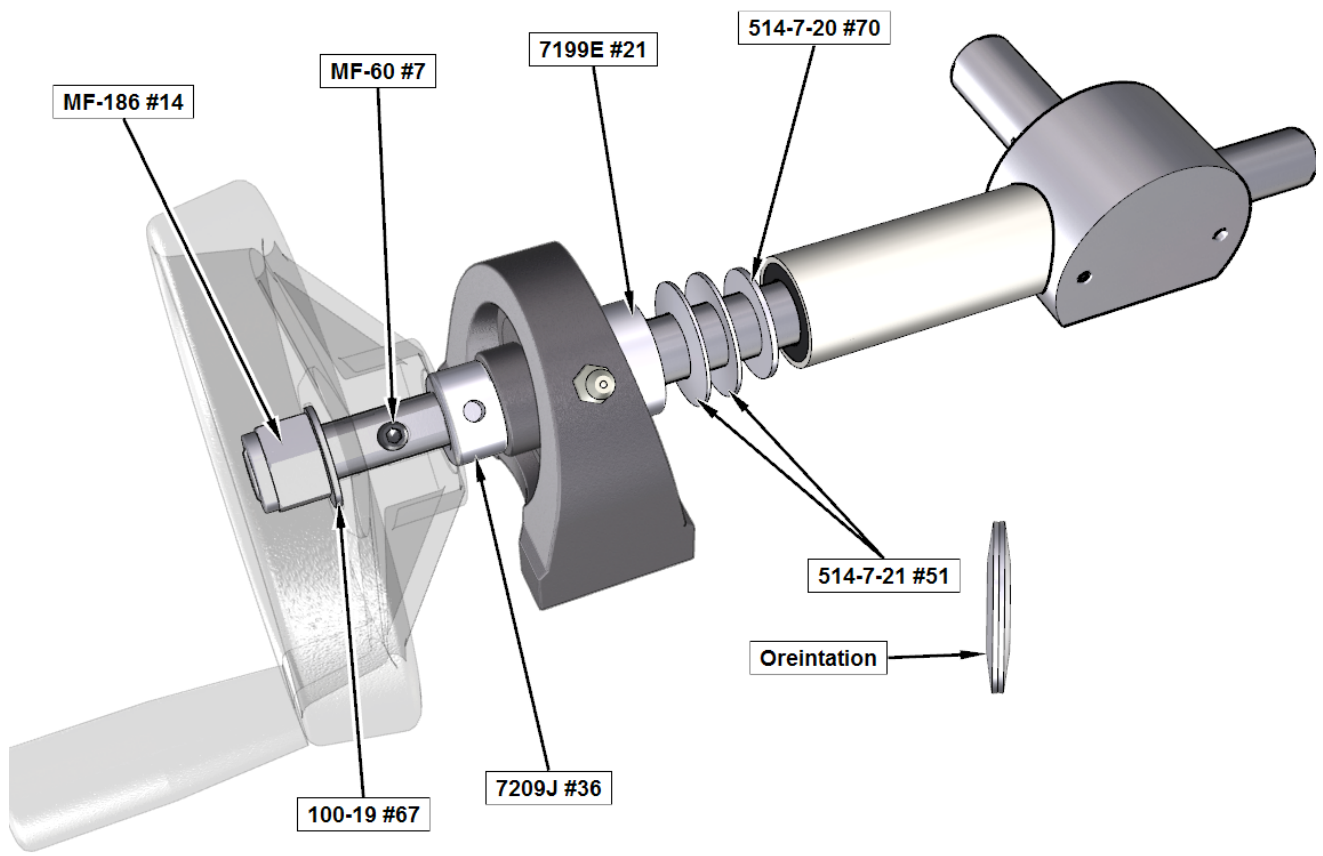
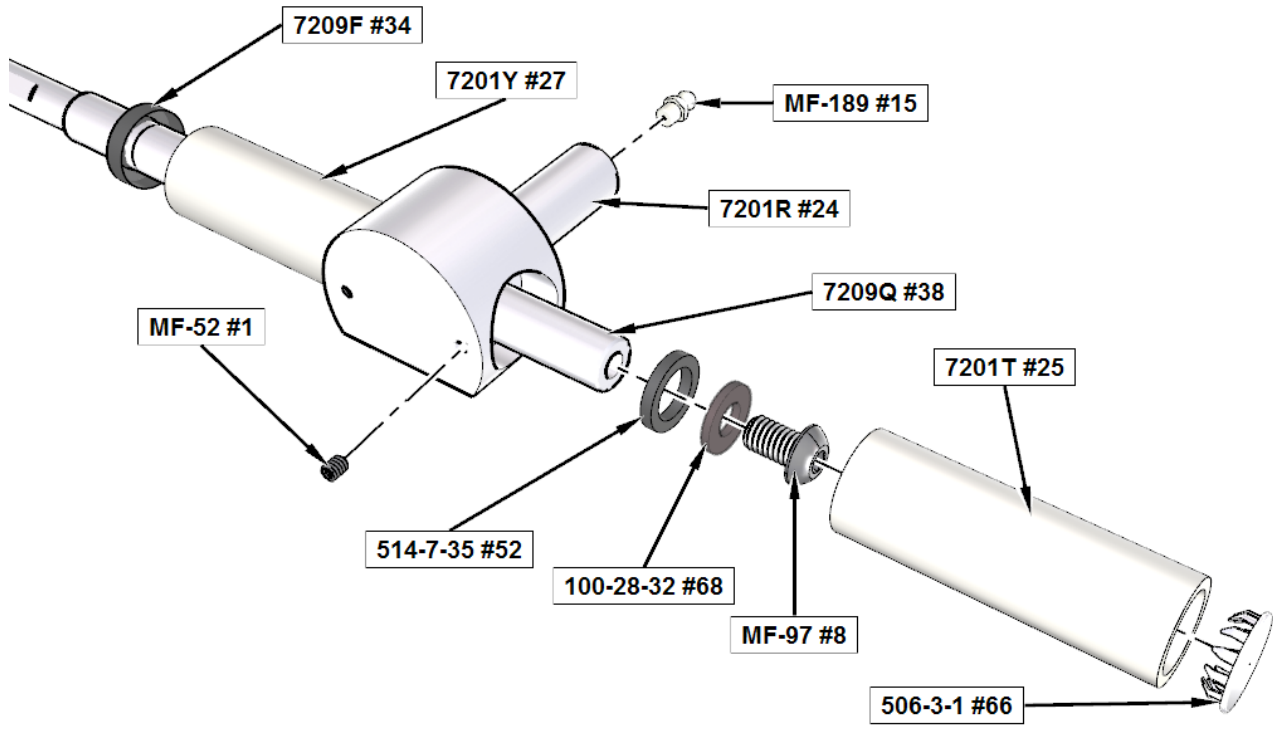


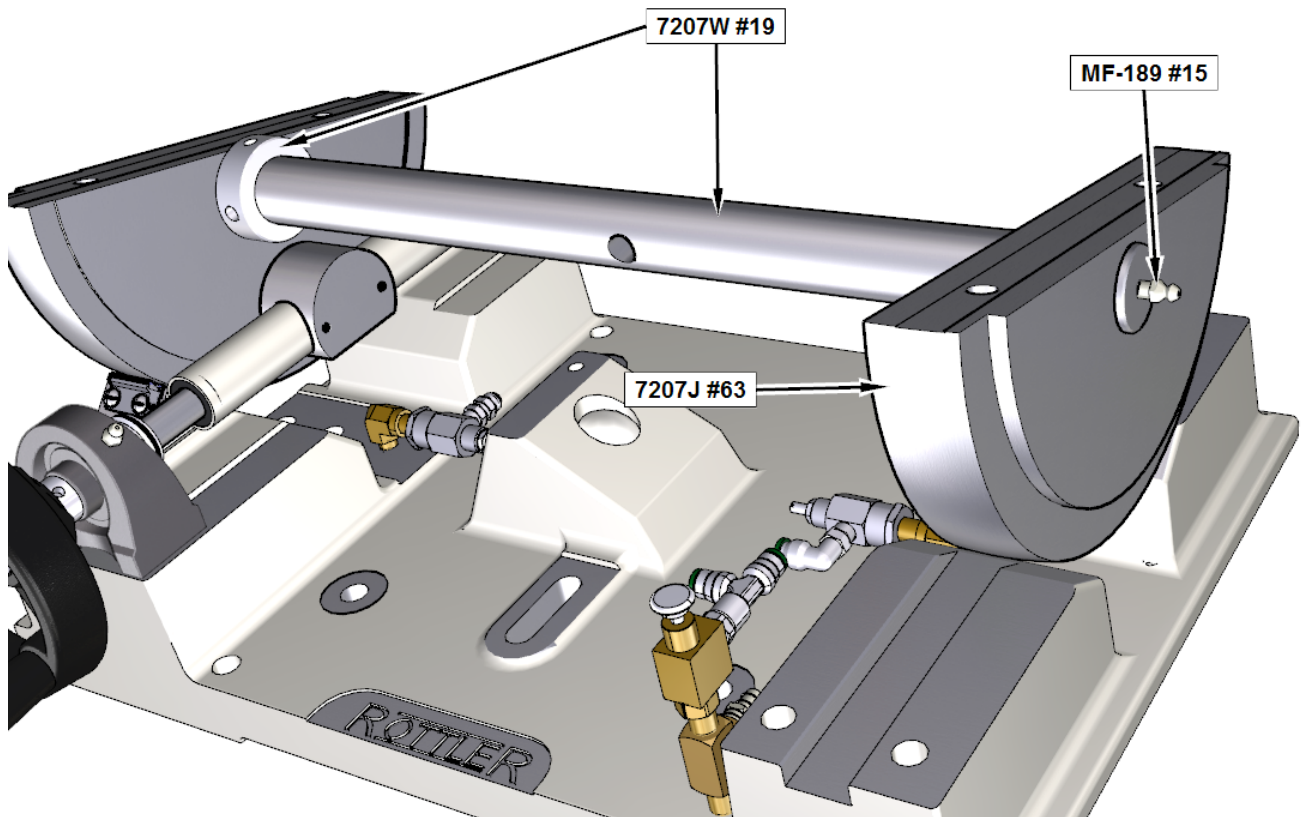
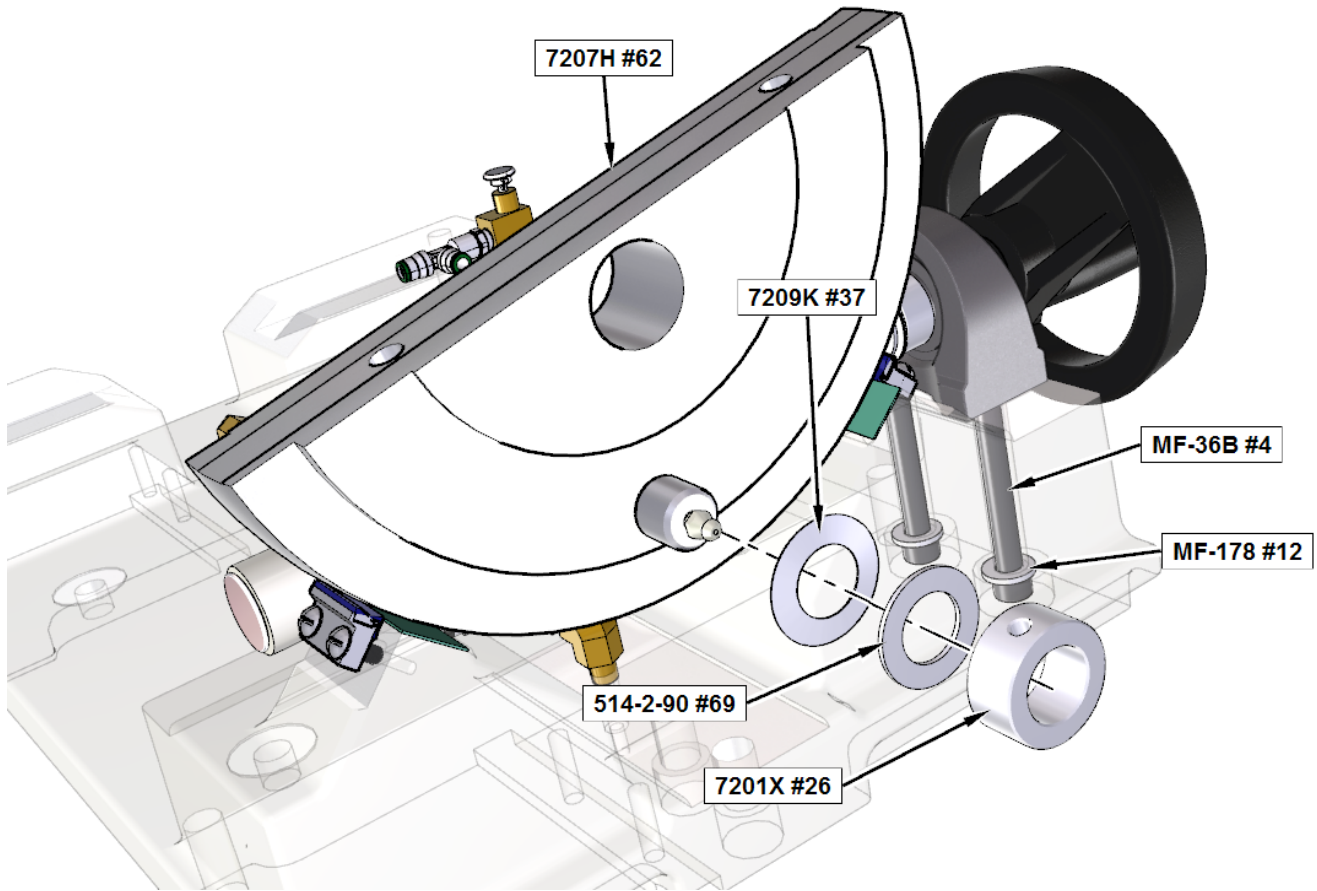
Fixtures and Parallels 7209M Leveling Table Parts

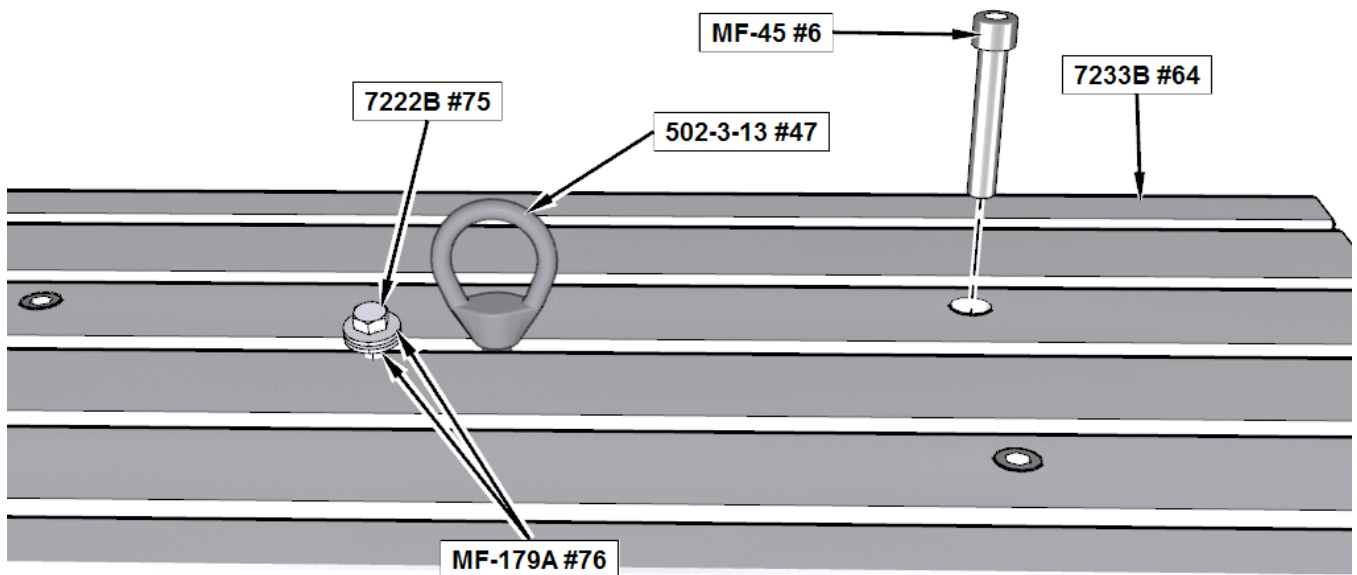
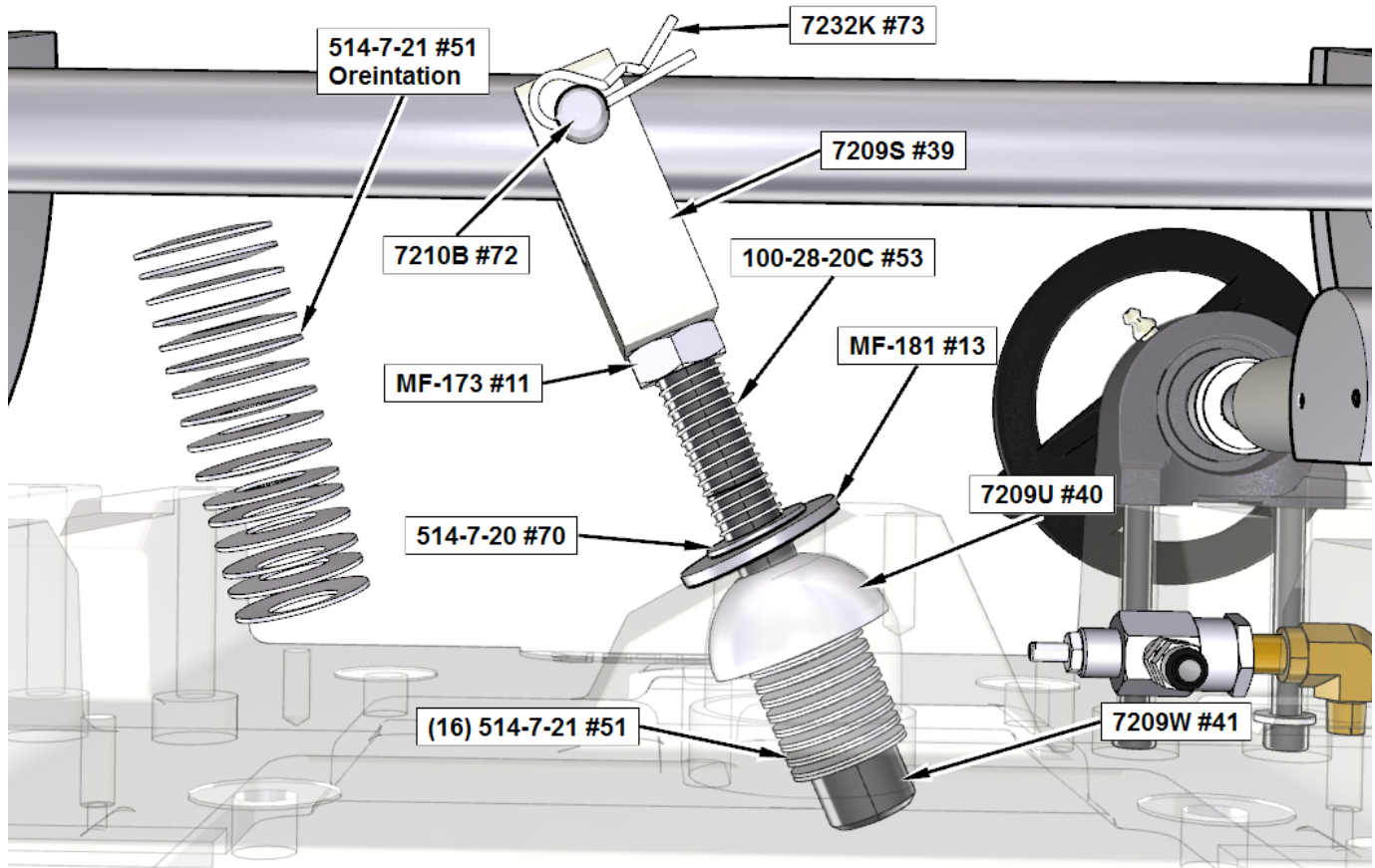


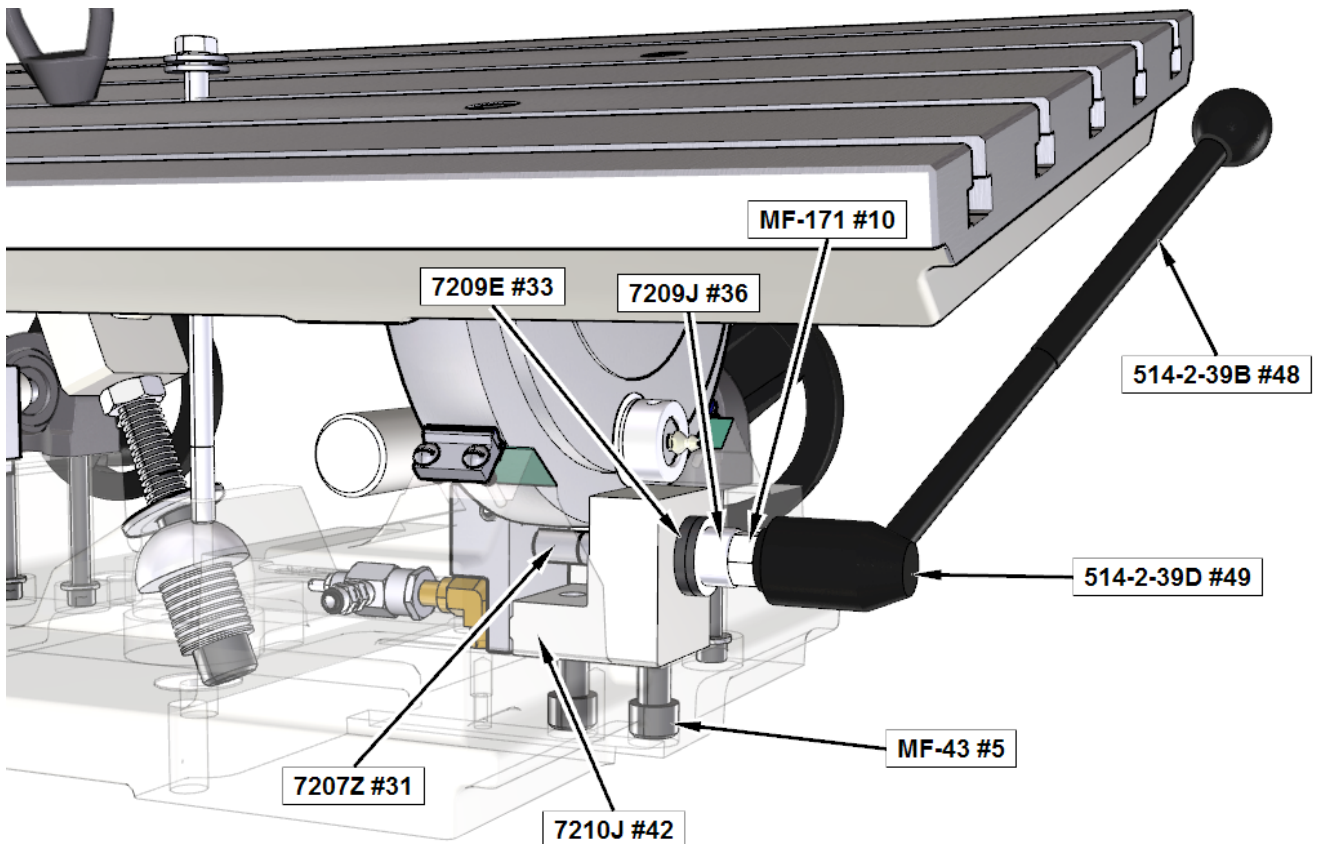
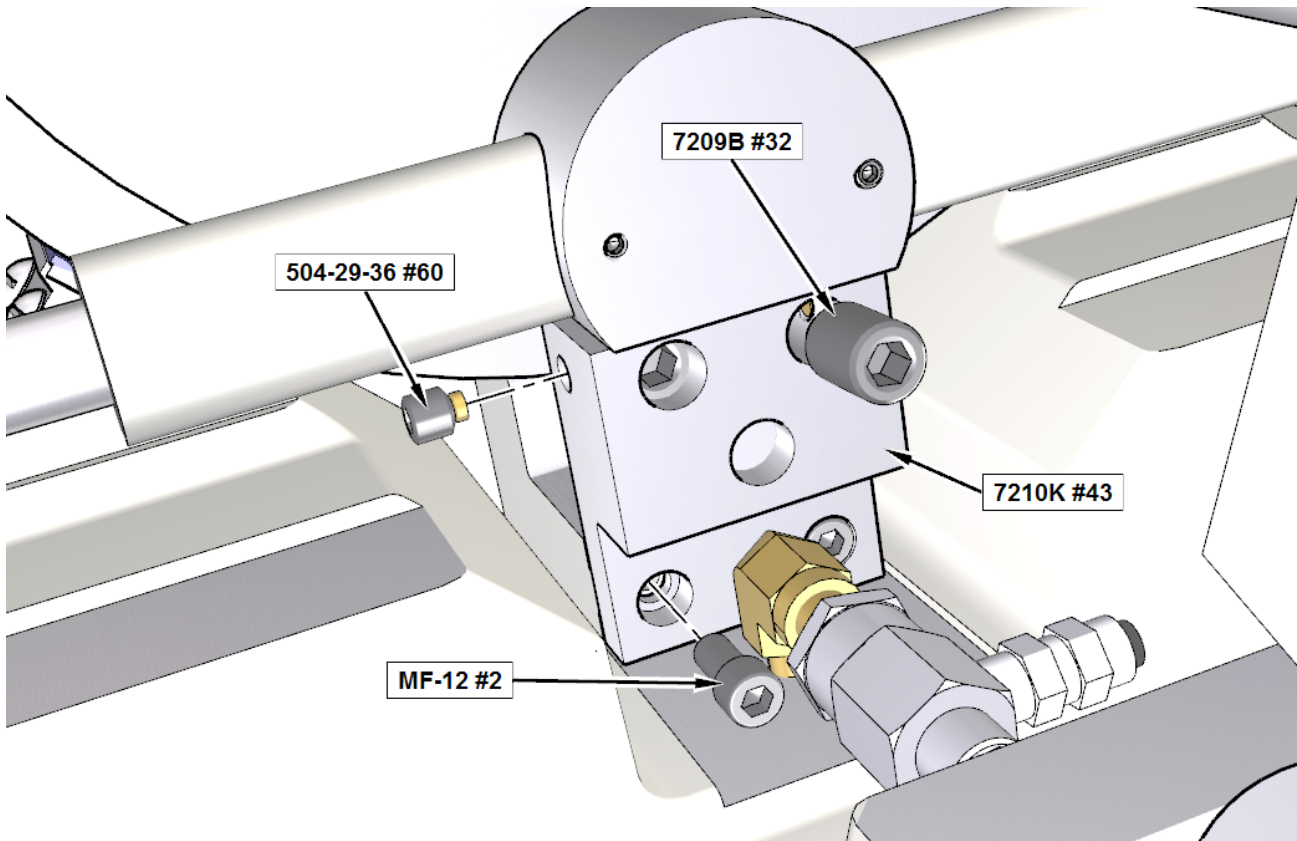






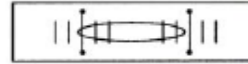




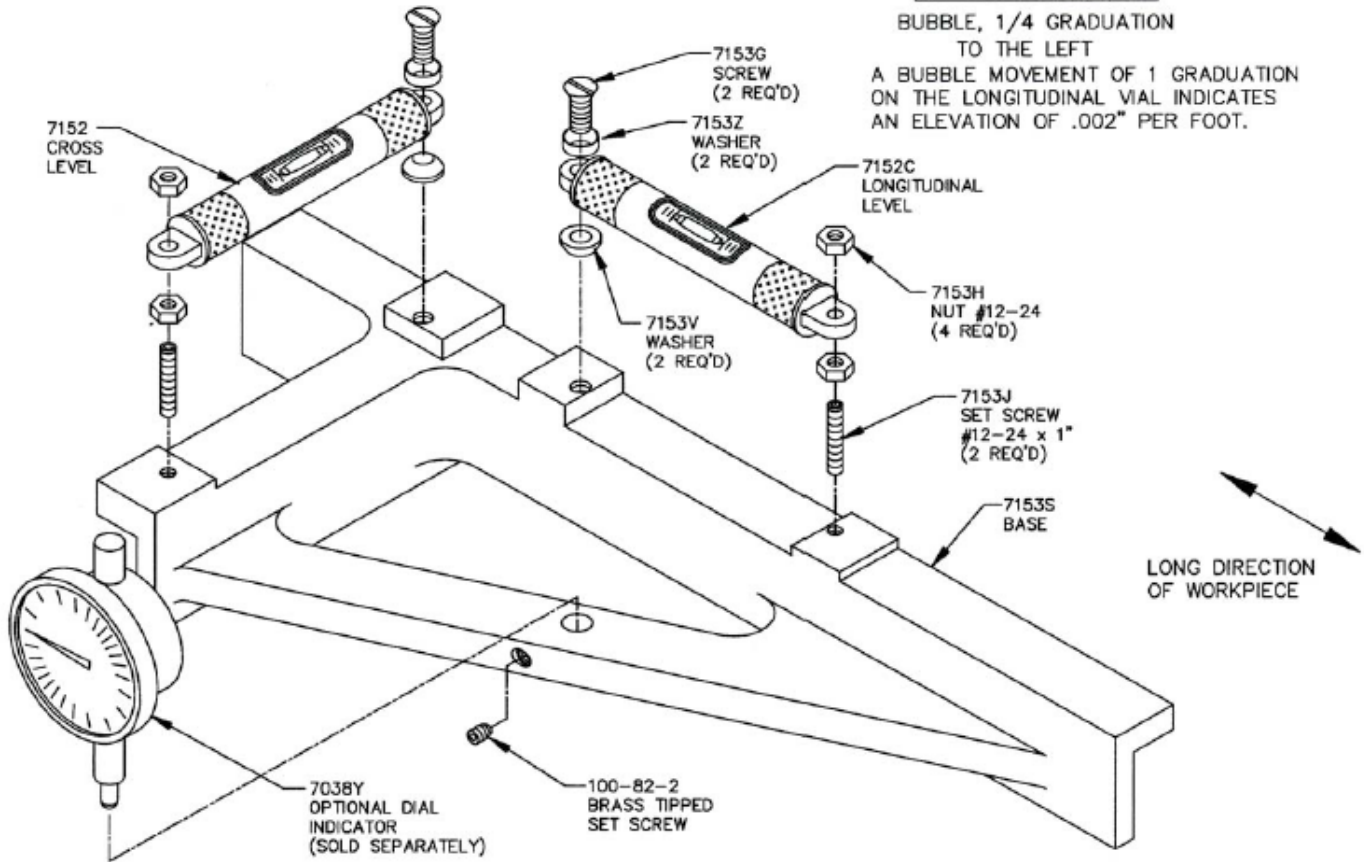


7152A Dual Axis Level Assembly Parts

ILLUSTRATION (A)



BUBBLE, 1/4 GRADUATION
TO THE LEFT
A BUBBLE MOVEMENT OF 1 GRADUATION
ON THE LONGITUDINAL VIAL INDICATES
AN ELEVATION OF .002" PER FOOT.

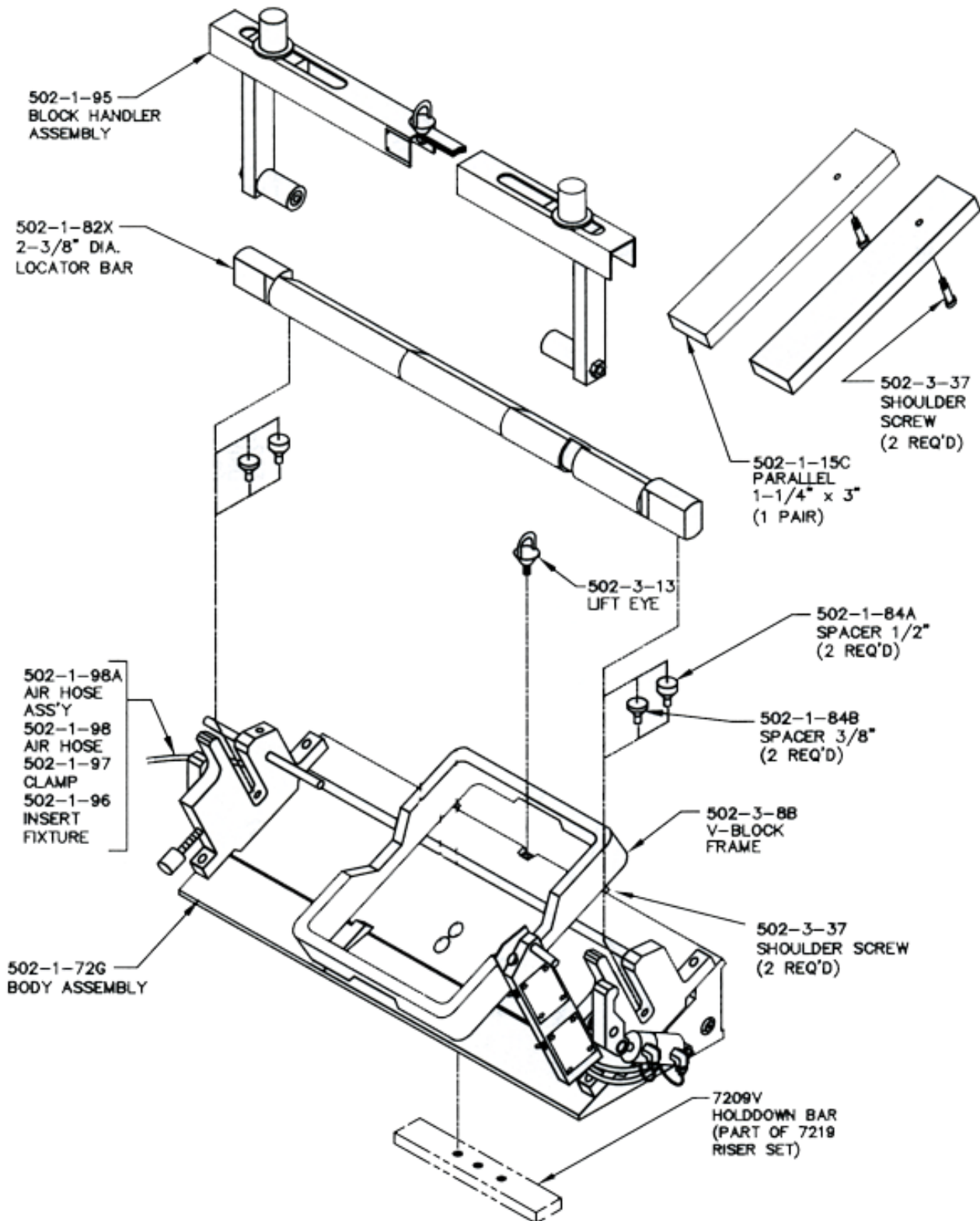


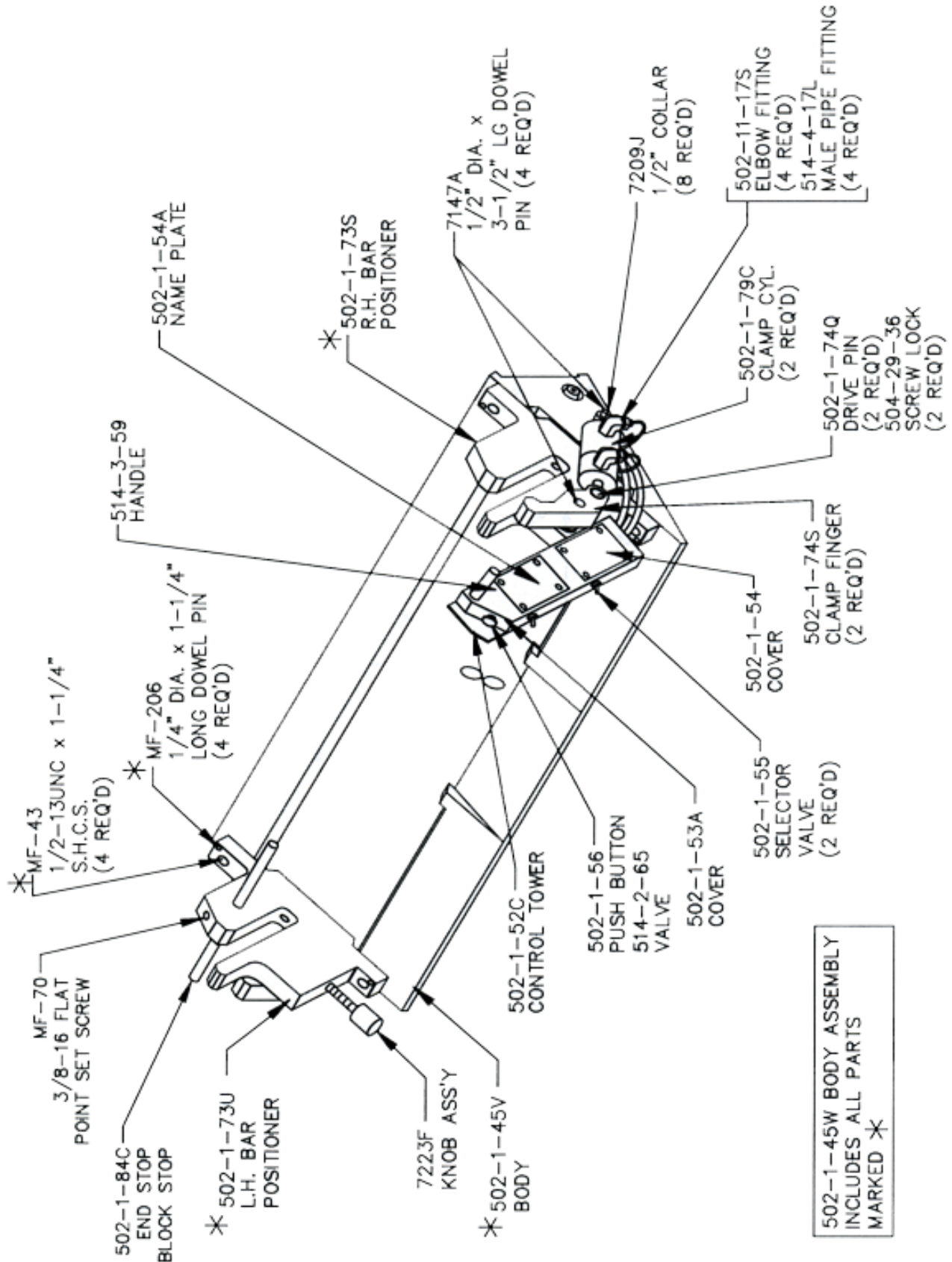
7152A - OPTIONAL DUAL
AXIS LEVEL ASSEMBLY

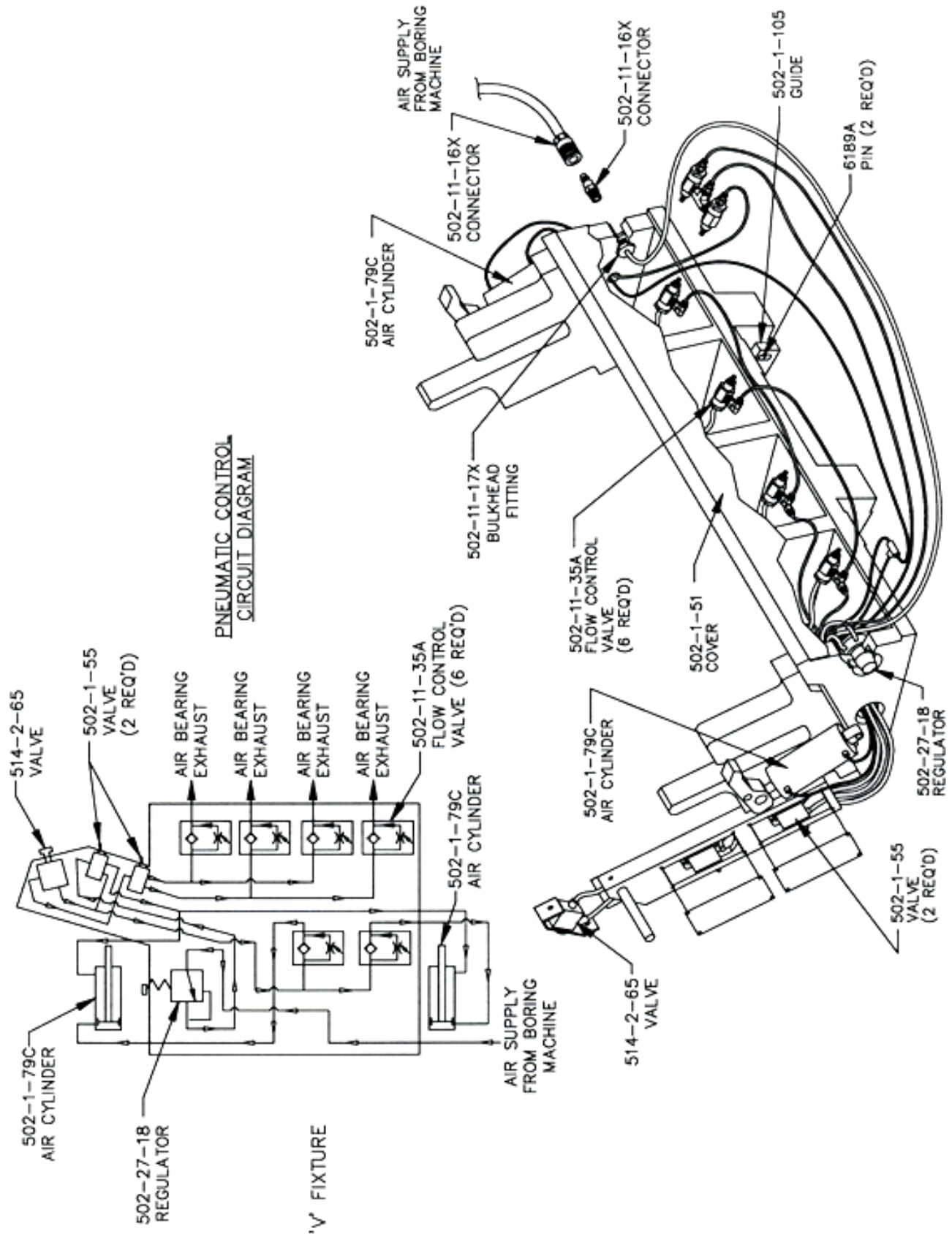
NOTE: 7152A ASSEMBLY DOES NOT INCLUDE 7038Y DIAL INDICATOR

Fixed Angle Fixtures for Blocks

502-1-72F V Block Fixture Parts

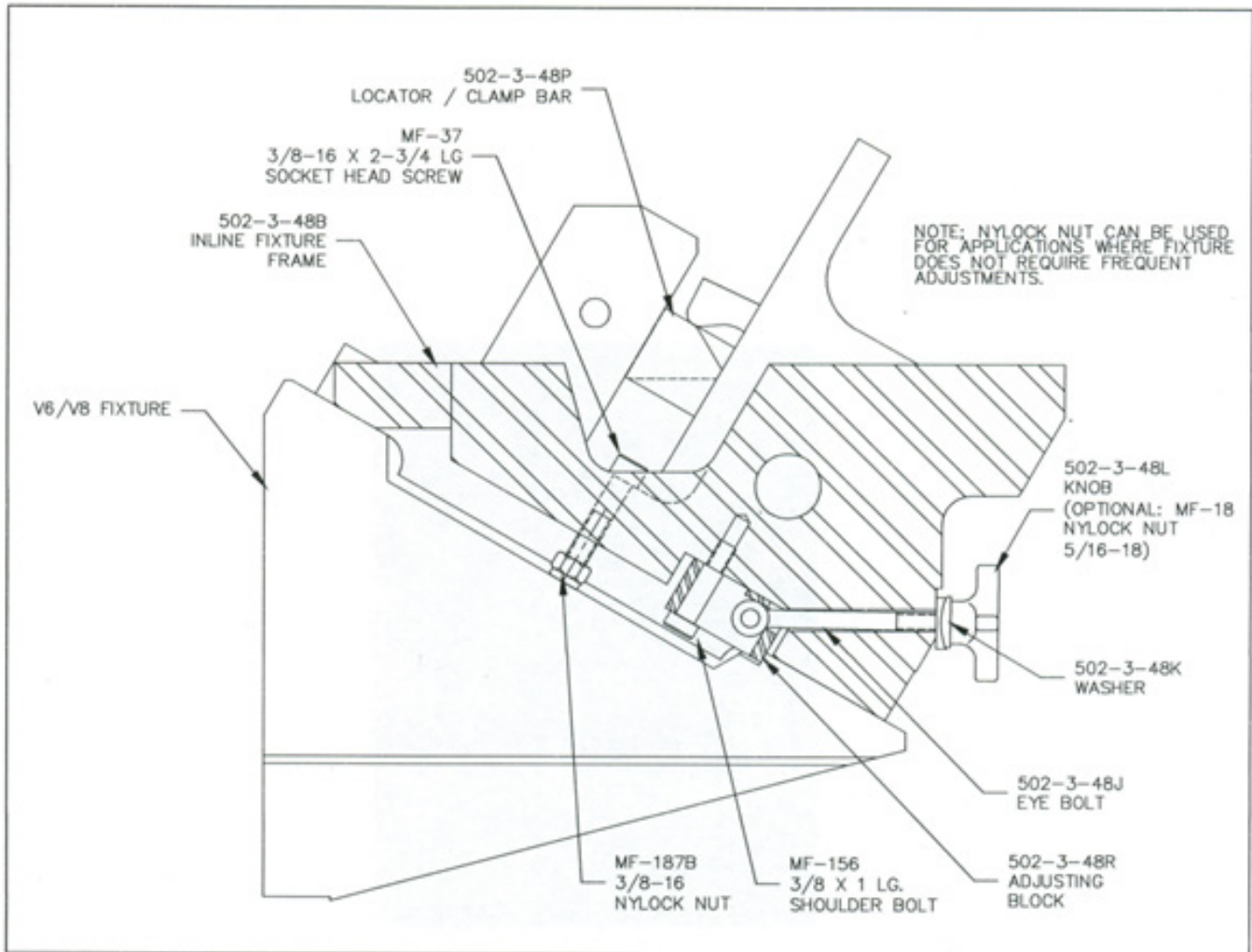






502-3-48Q In-line Block Frame Parts

The In-Line Frame is factory assembled. Be sure all the parts shown in this cut-away view are assembled on the frame. If the frame is sold with a V6/V8 fixture the fixture will already be drilled for the In-Line Frame. If you purchased this frame for use on an existing V6/V8 fixture, you may have to drill and tap a 3/8-16 unc hole to accept the mount bolt (MF-37). Locate the fixture in the appropriate machined slots in the V6/V8 fixture and mark through the hold down slot (in approximately the center). Drill and tap the hole, then mount the In-Line Frame as shown in the following illustrations.



502-3-49 V Block Fixture Parts

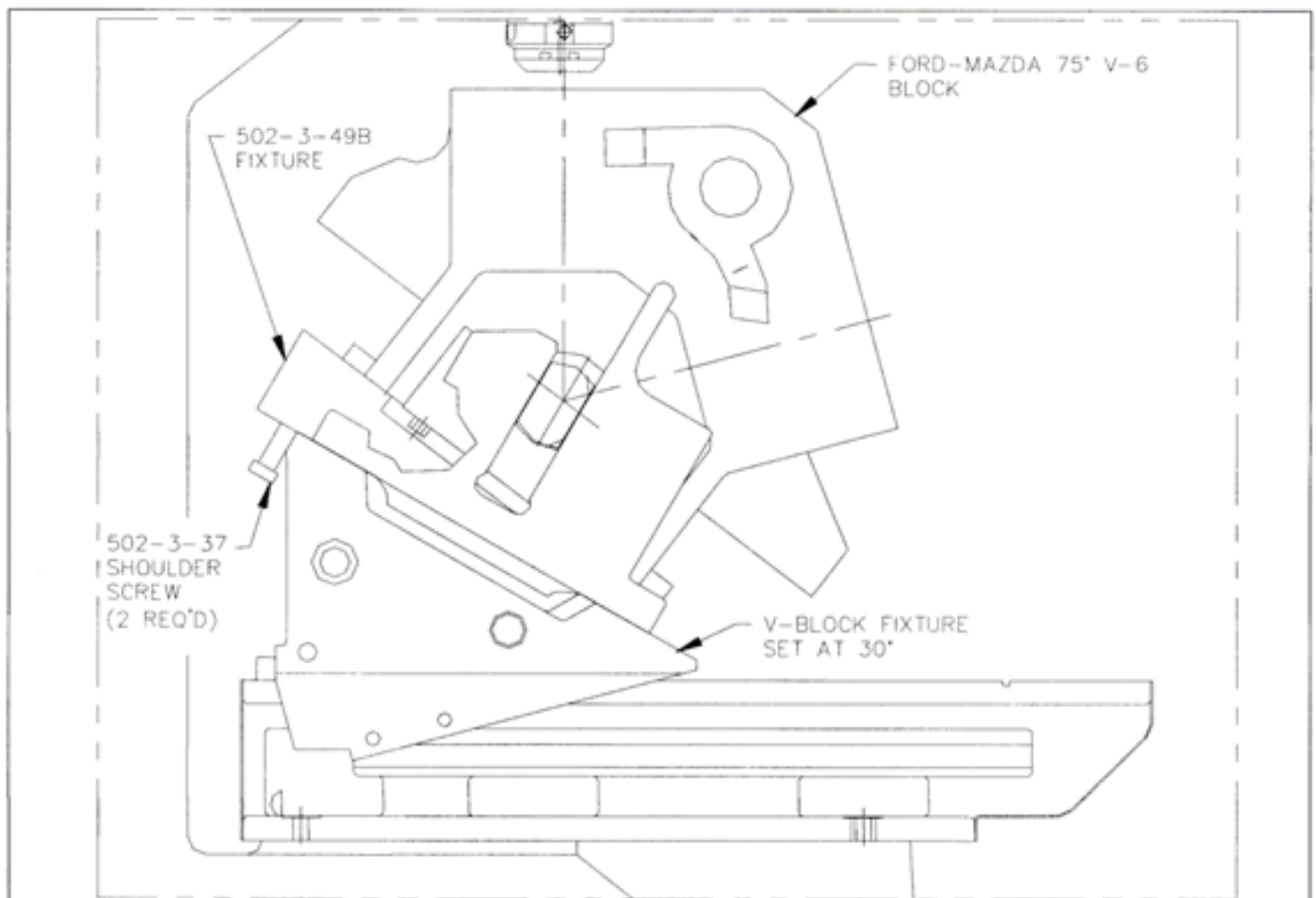
502-3-49

15 Deg. VW V6 / 75 Deg. Ford-Mazda V6 Fixture 75 Deg. Ford-Mazda V6 Application

This fixture is designed to be used with a customer's V8/V6 block fixture on either an SF series surfer or an F series boring machine. Clamping the block will be the same as clamping other v-blocks in the V8/V6 fixture.

The fixture, with (2) 502-3-37 shoulder screws installed, hangs over the top edge of the V8/V6

fixture. The block rests on the fixture with the outboard main caps in the reliefs cut in the fixture. This V6 engine block has main bearing caps that hang down below the pan rail surface. Use caution that the block rests on the fixture with the pan rails flush to the fixture.



15 Deg. VW V6 / 75 Deg. Ford-Mazda V6 Fixture 15 Deg. VW V6 Application

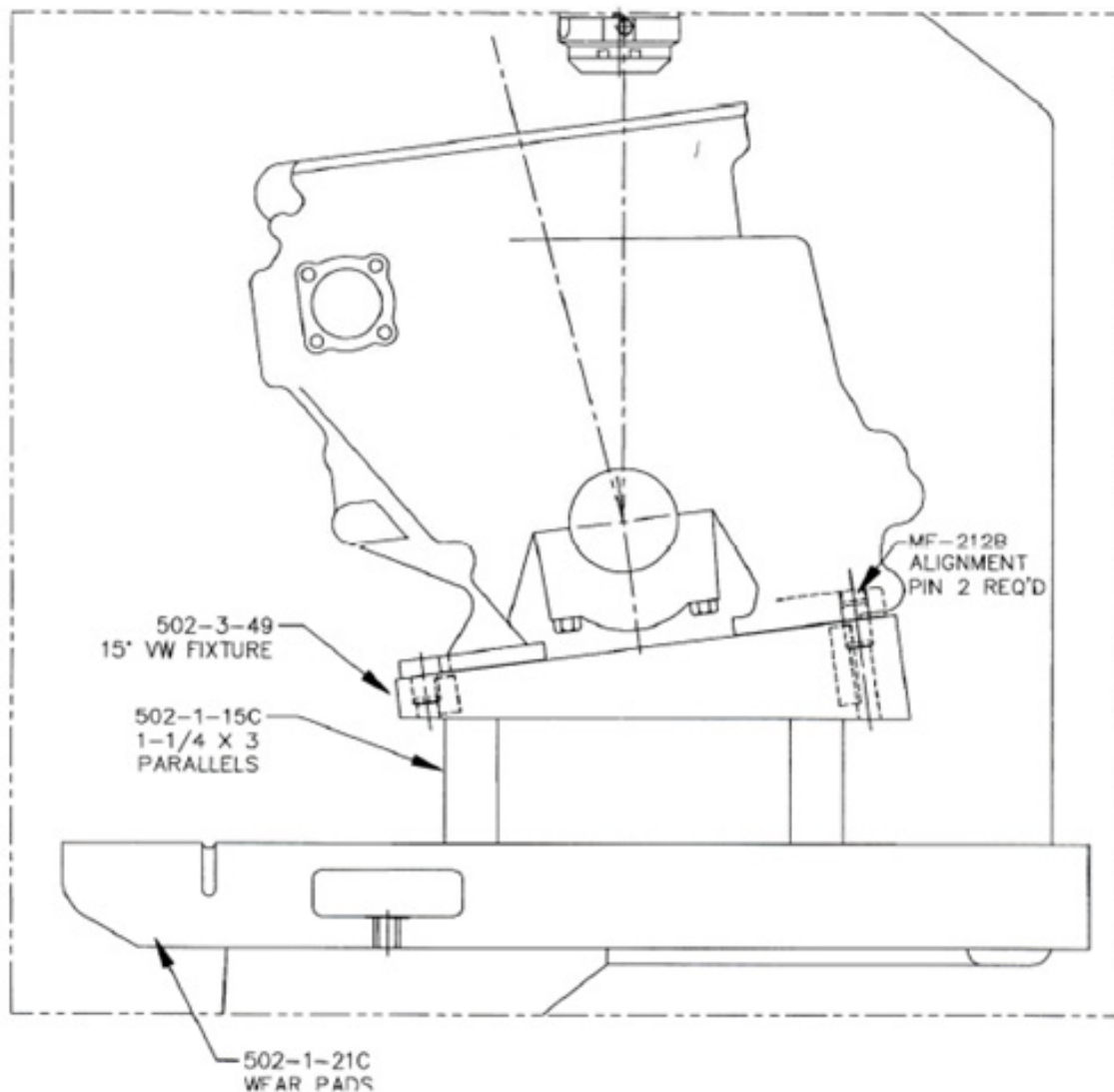
This fixture is designed to be used with a customer's existing 1-1/4 x 3 parallels, sitting on top of the 2-1/2" wear pads. The boring machine block clamps must be used to secure the block while boring. Use care in selecting the placement of the clamps, be sure the block is not shifted or tipped when the clamps are applied. Insert the two alignment pins in the corresponding holes in the fixture, and place the block on the fixture using its mating tooling holes.

After the first cylinder bank is bored, lift the block and pull out the two pins. Place the pins in the other set of alignment holes and reposition the block for

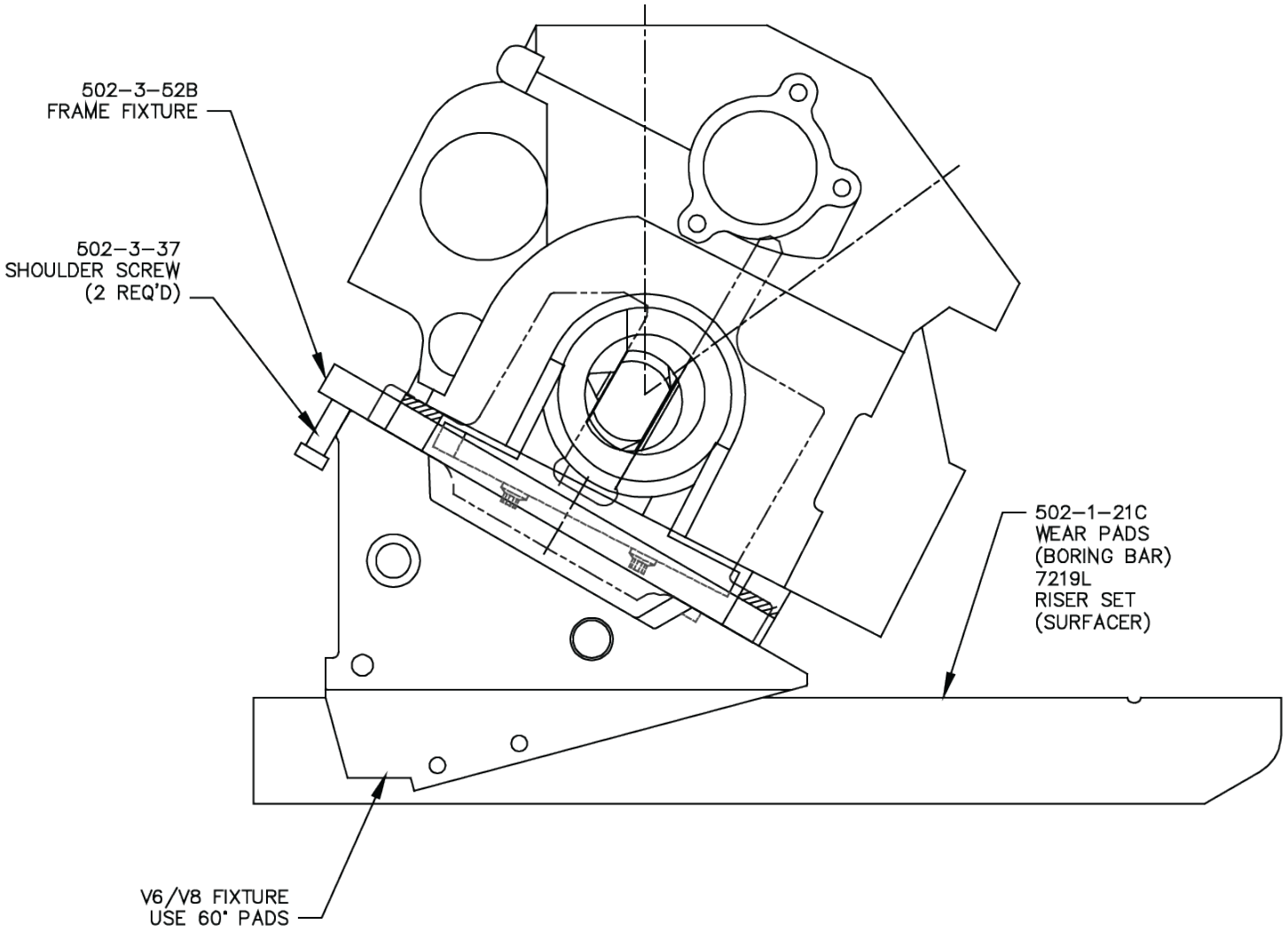
boring the second bank. Be sure the engine block is setting down all the way on the fixture and not resting on any burrs or chips. Also be sure the parallels are clean and free from chips.

Care must be taken when centering the cutterhead. Be sure you are far enough in the bore for all of the centering fingers to come in contact with the bore, below the ridge if possible.

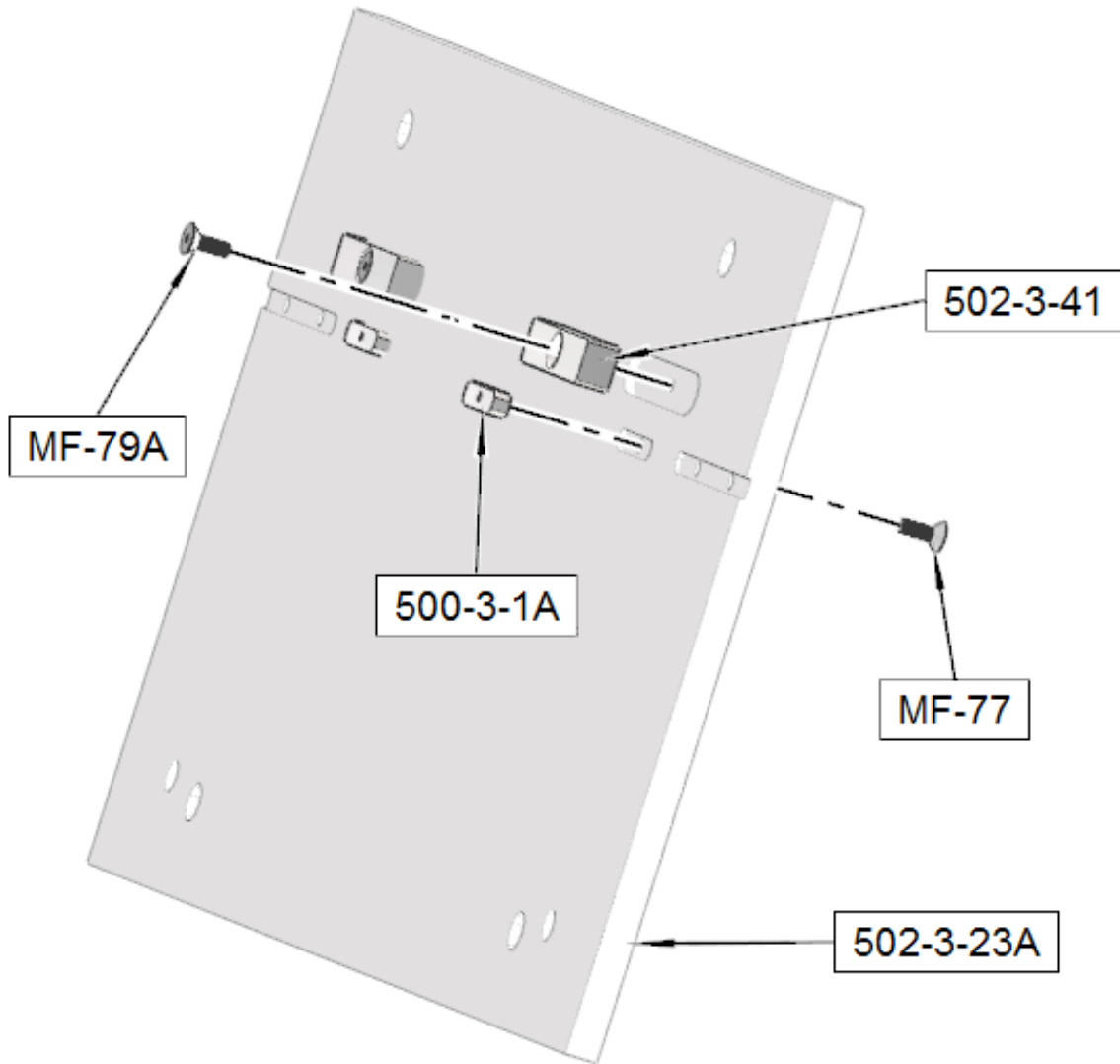
For honing the fixture and the engine block will fit into the hone cradle for normal hone operation.



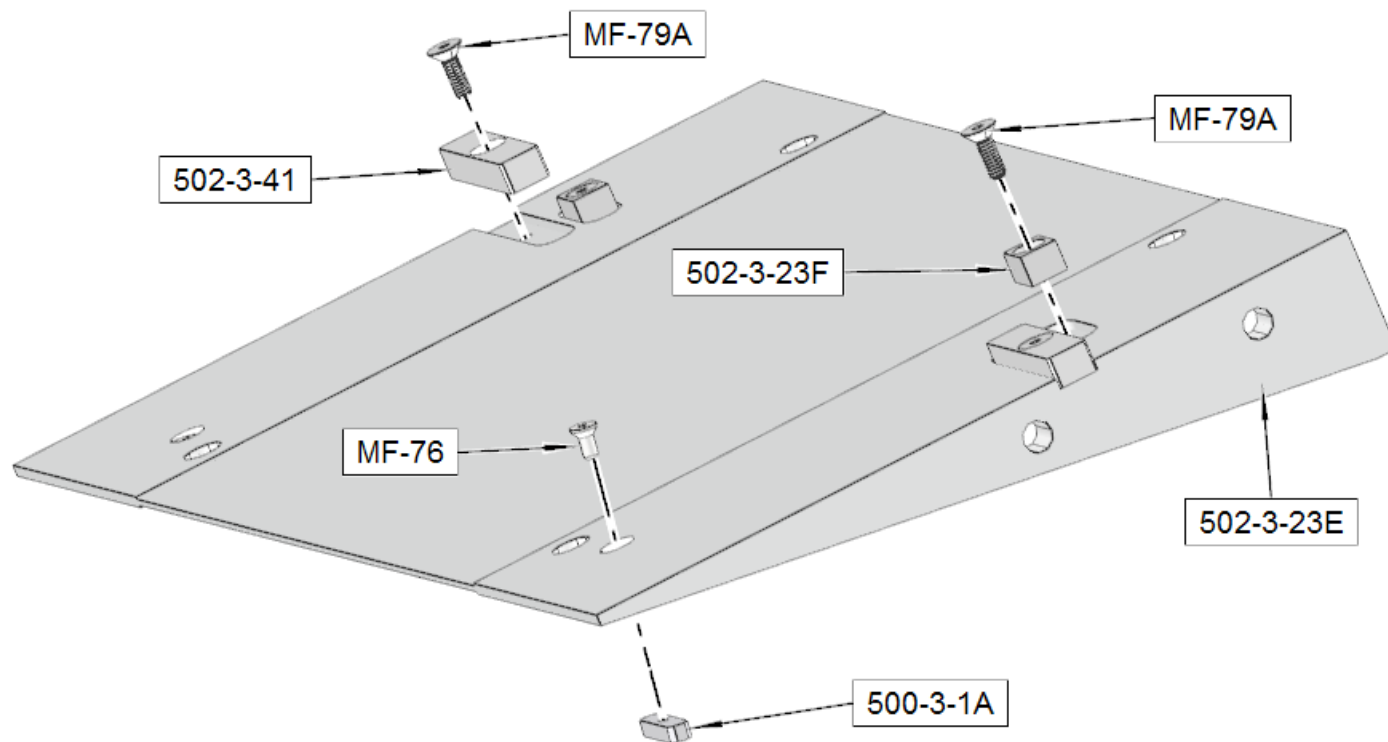
502-3-52 Cadillac Catera V Block Fixture Parts



502-3-23 Marine Outboard Fixture Parts



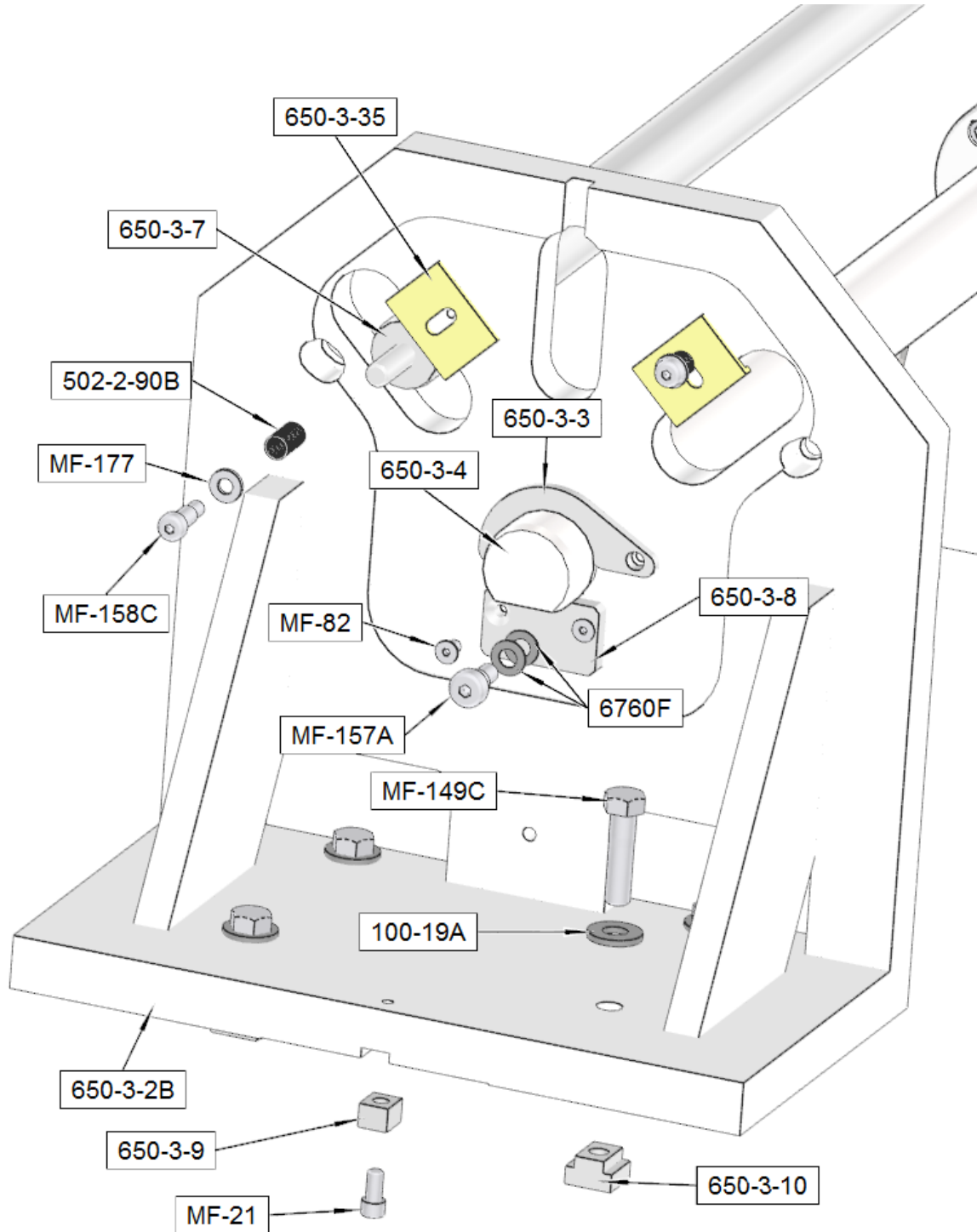
502-3-23C Marine Outboard Fixture Parts



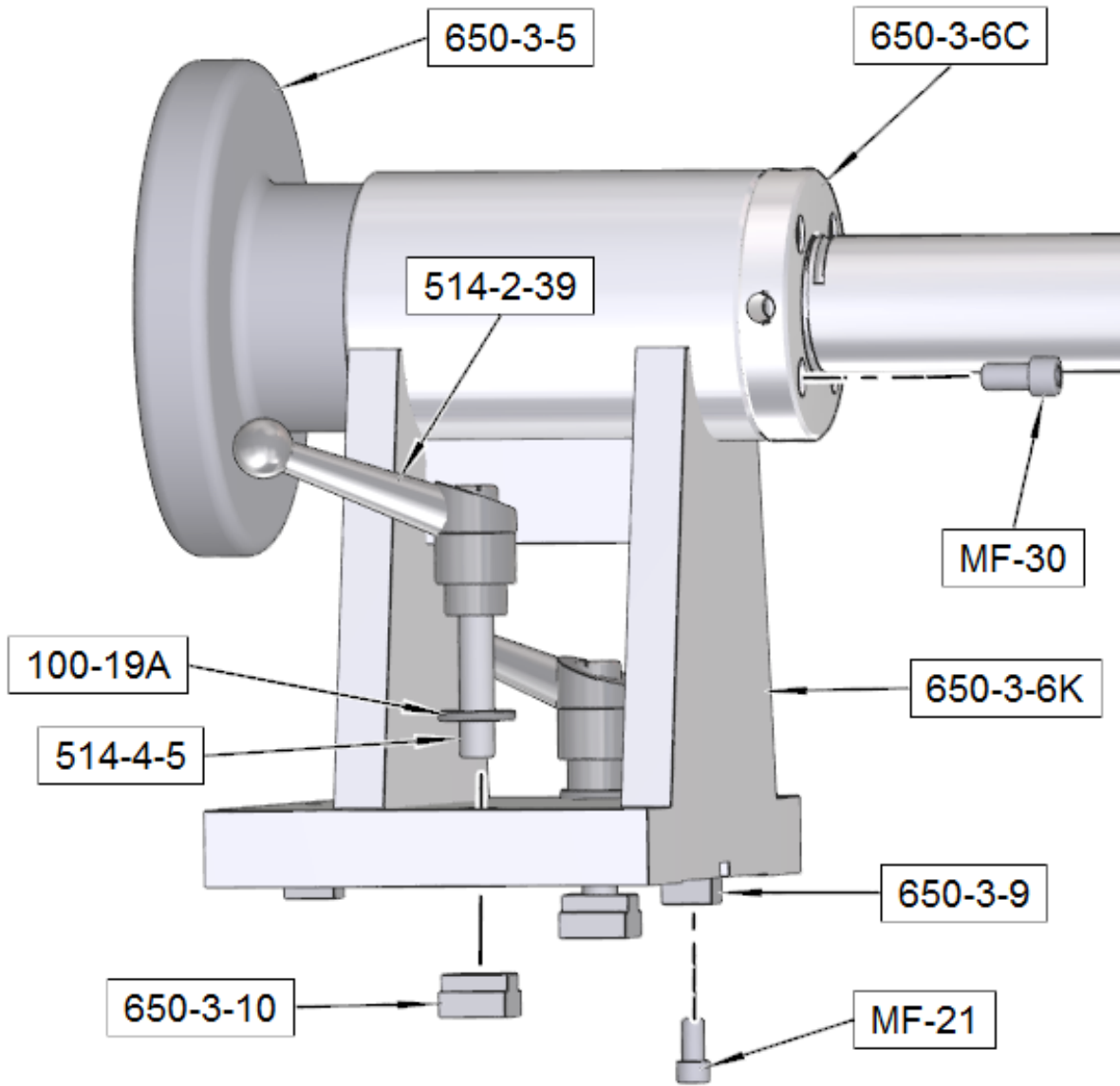
Adjustable Angle Fixtures for Blocks

650-3-1 Performance Fixture Assembly Parts

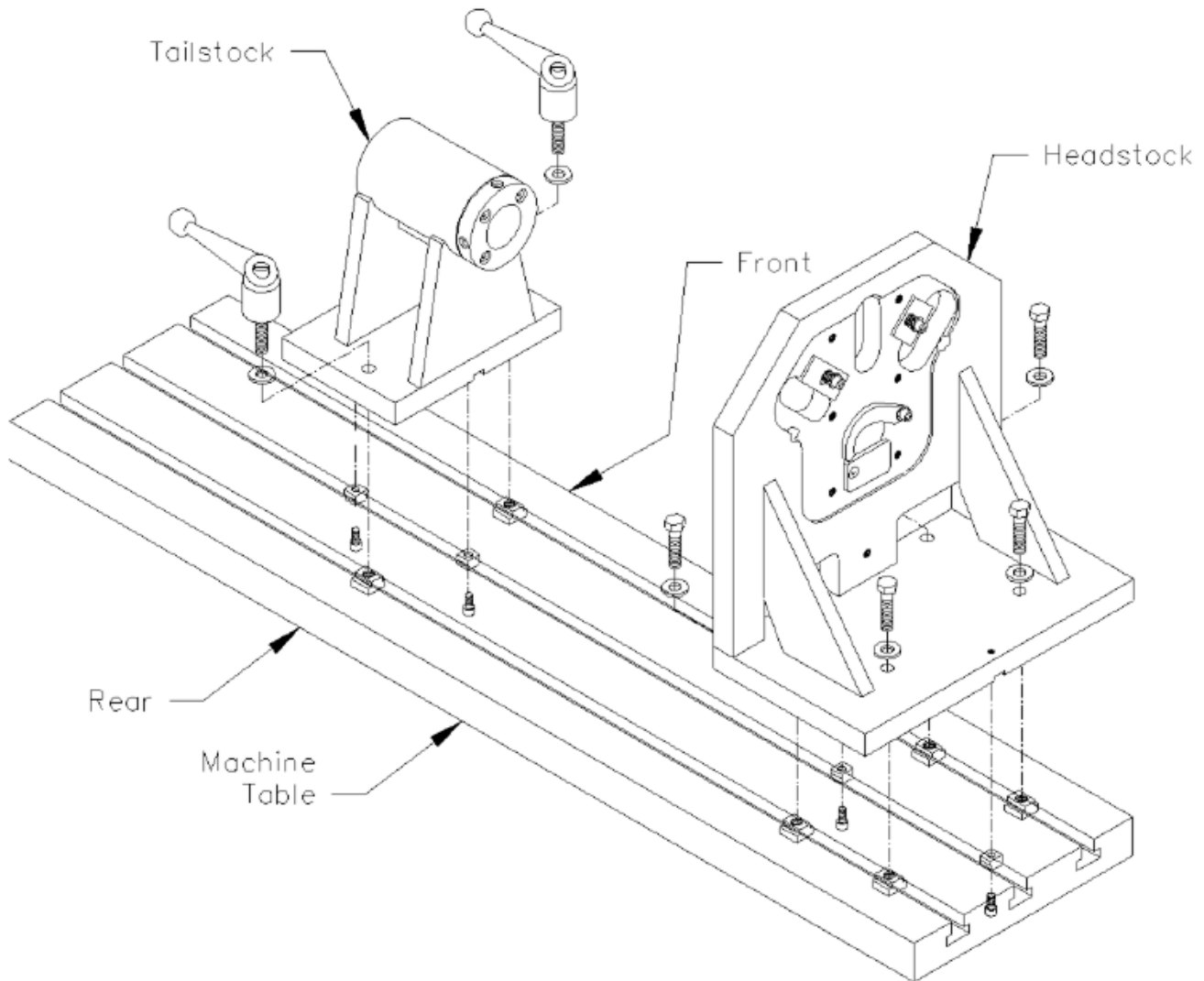
Headstock Parts

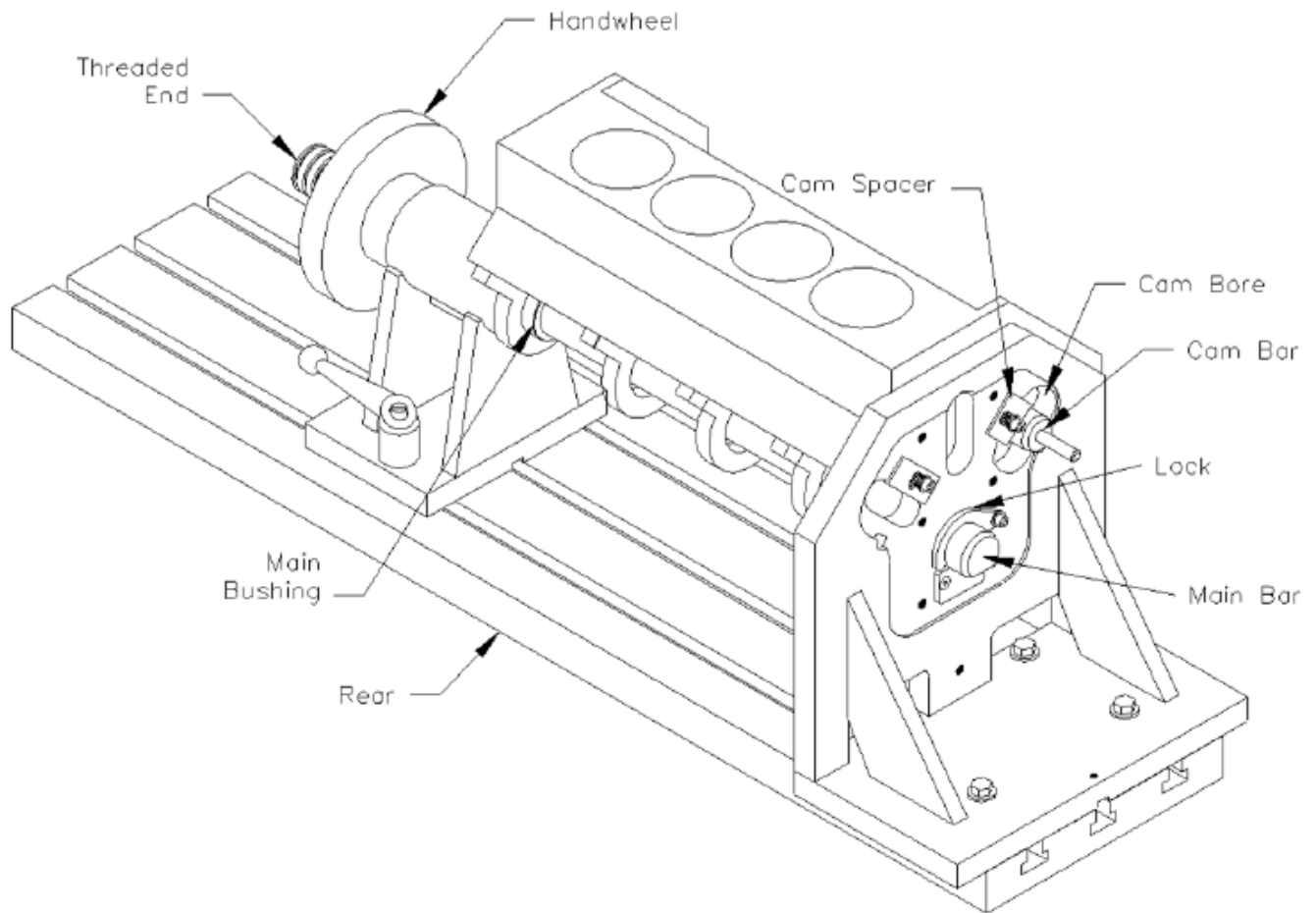


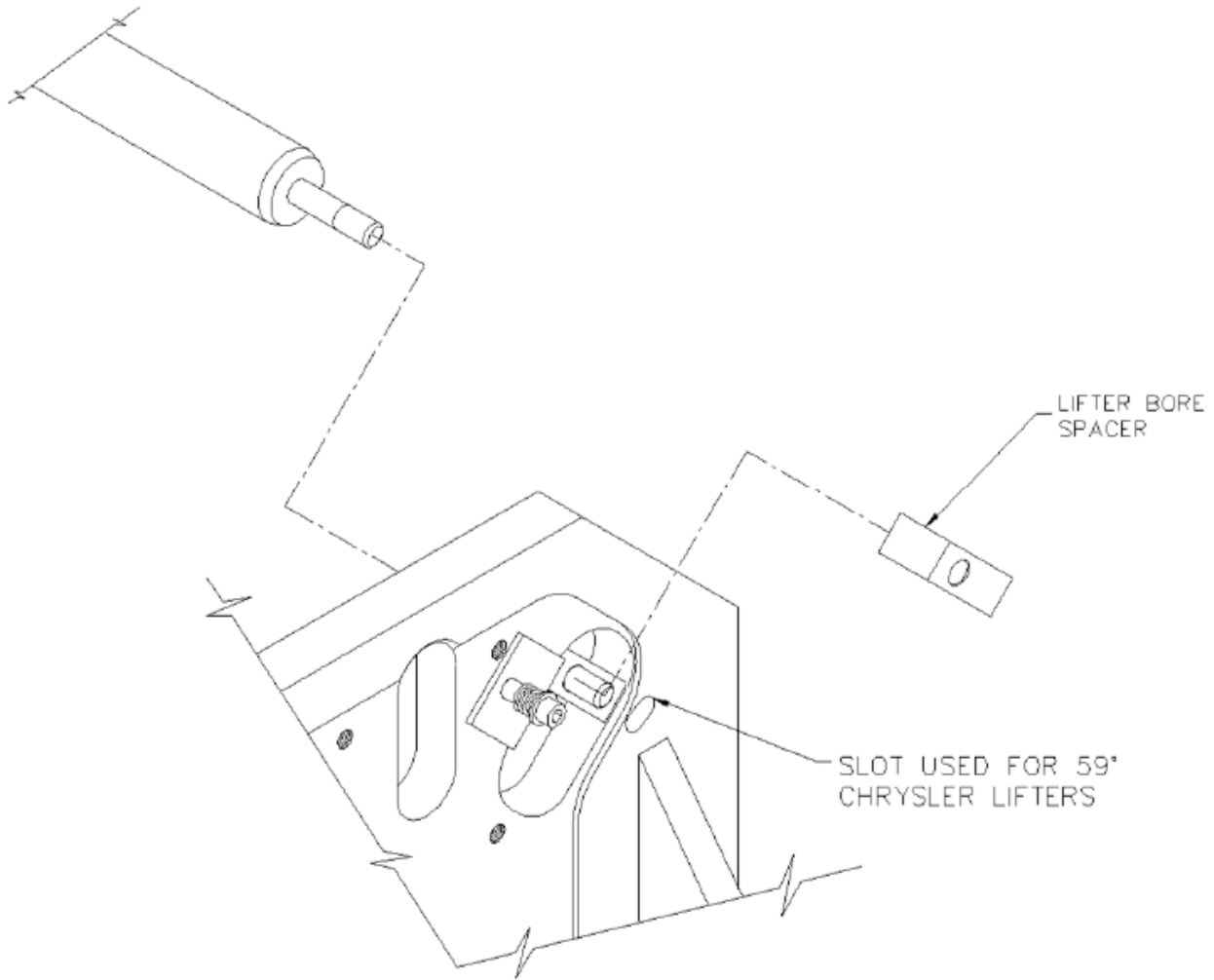
Tailstock Parts

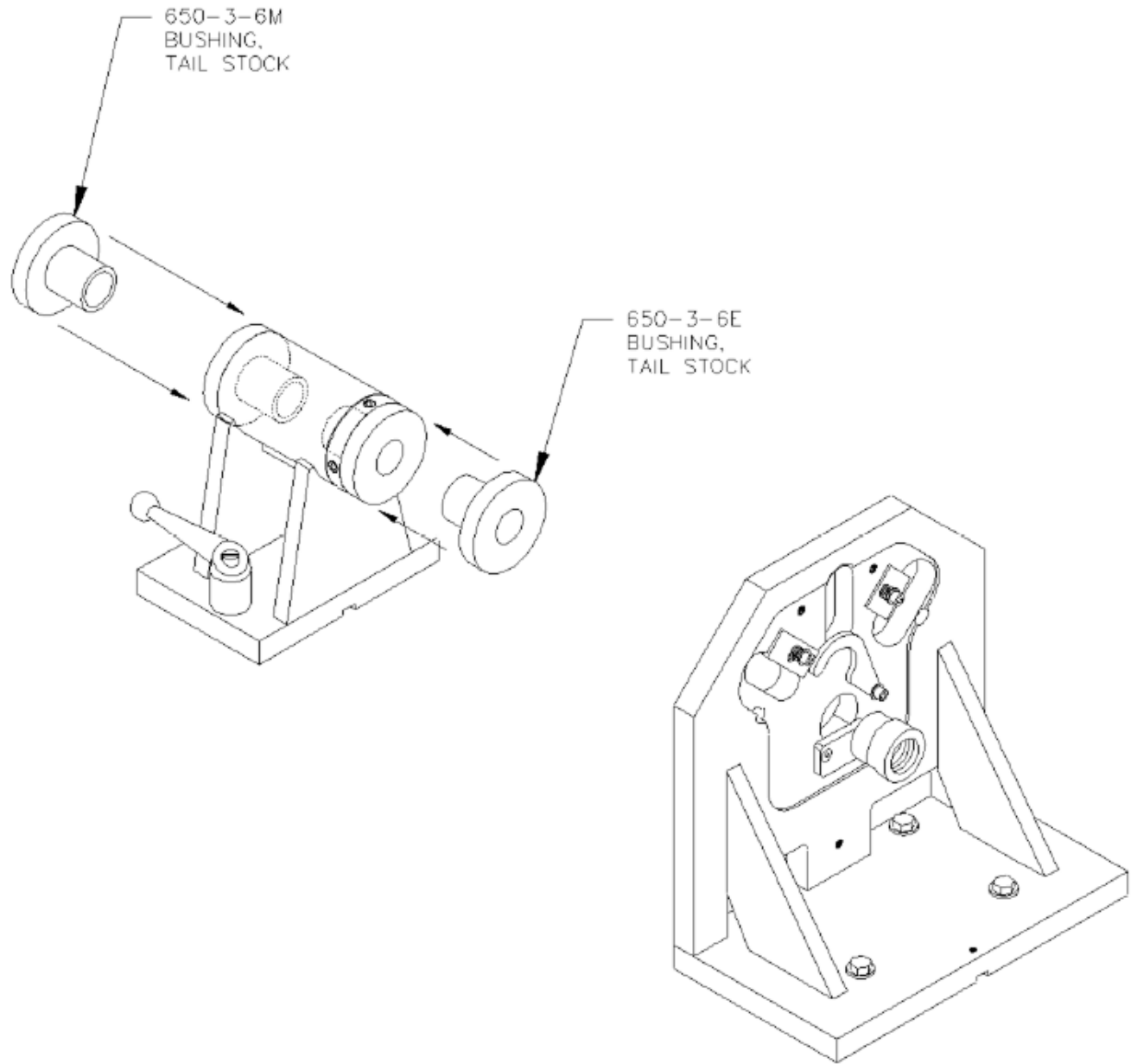


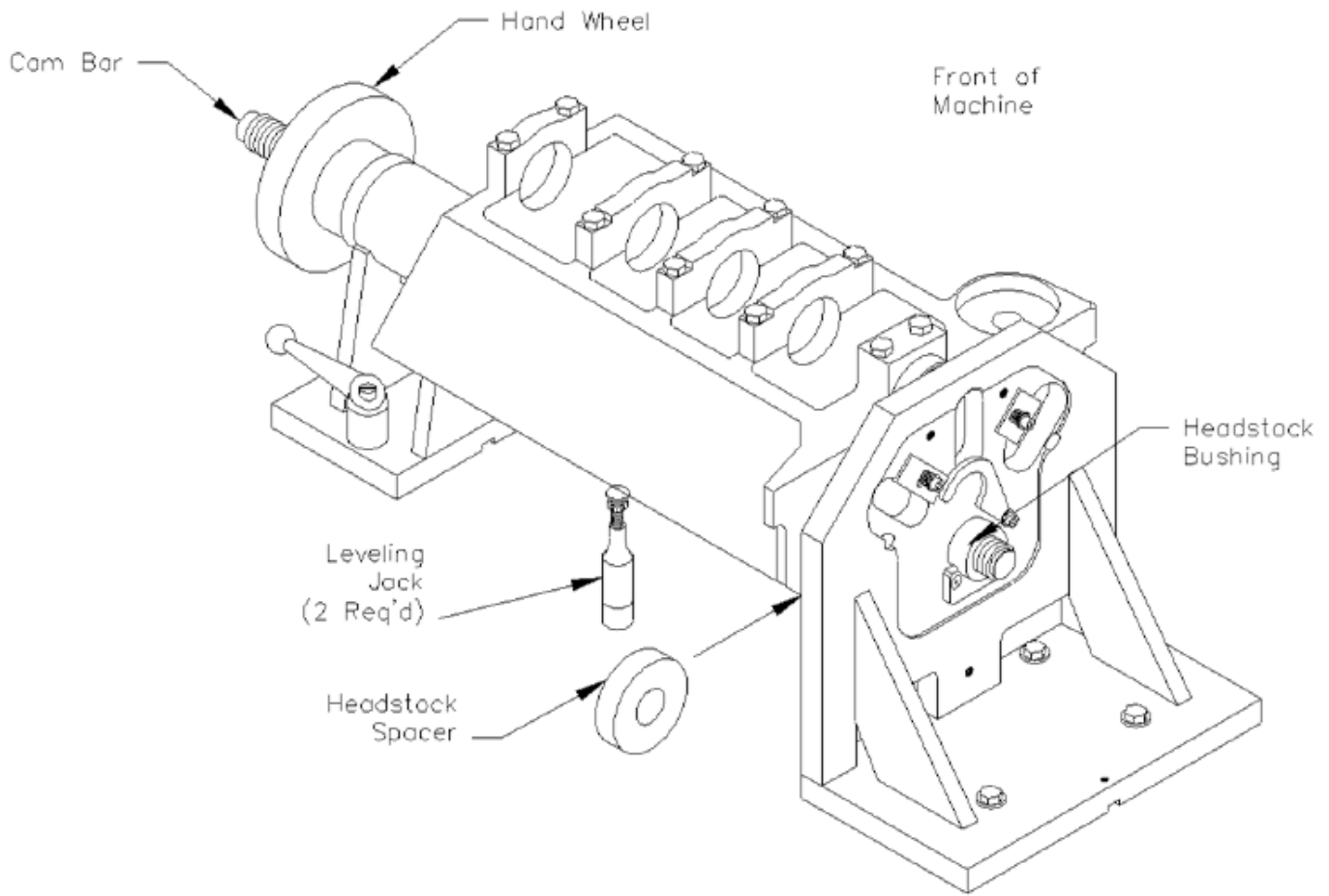
650-3-1 Performance Fixture Set Up

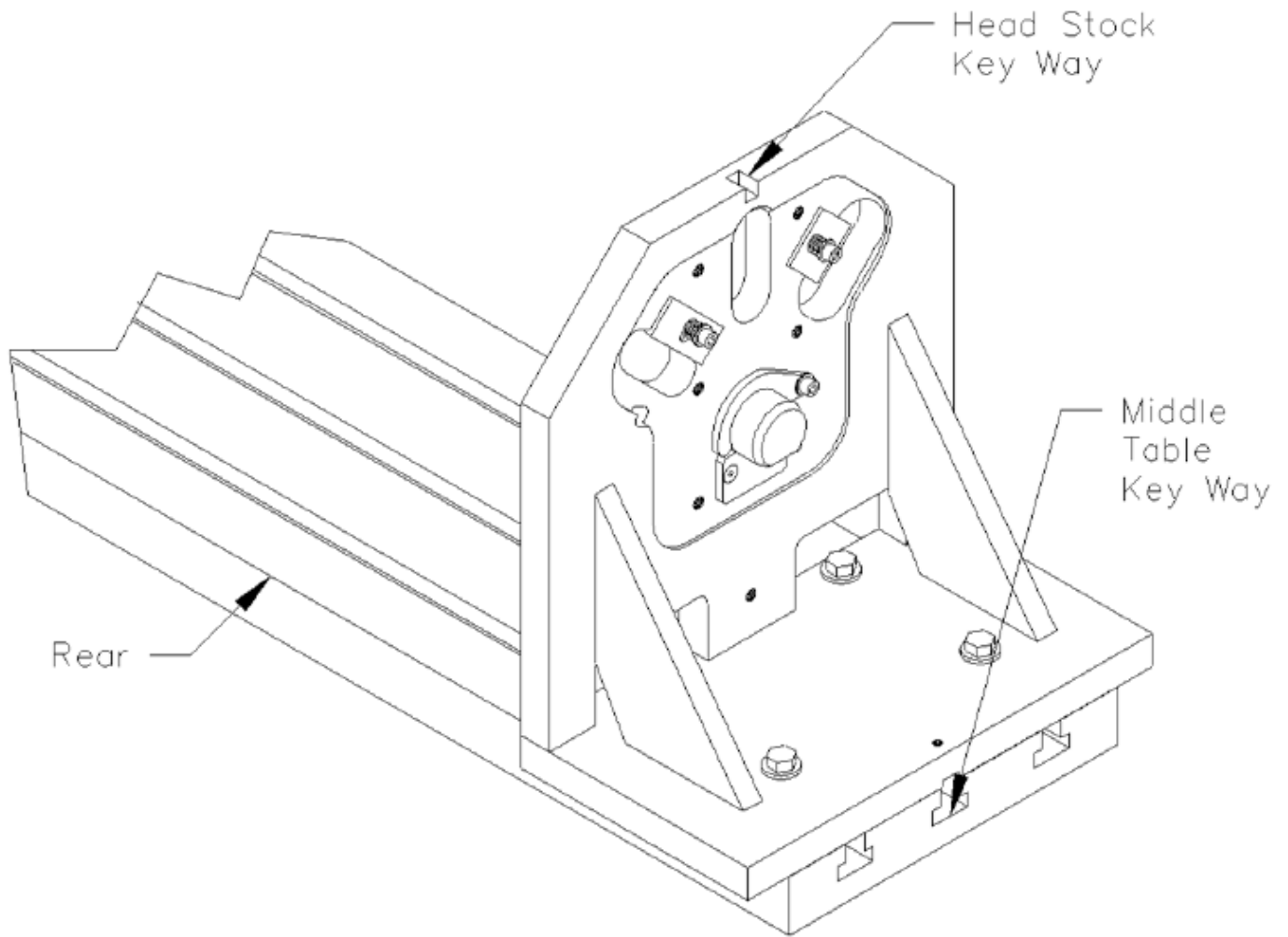


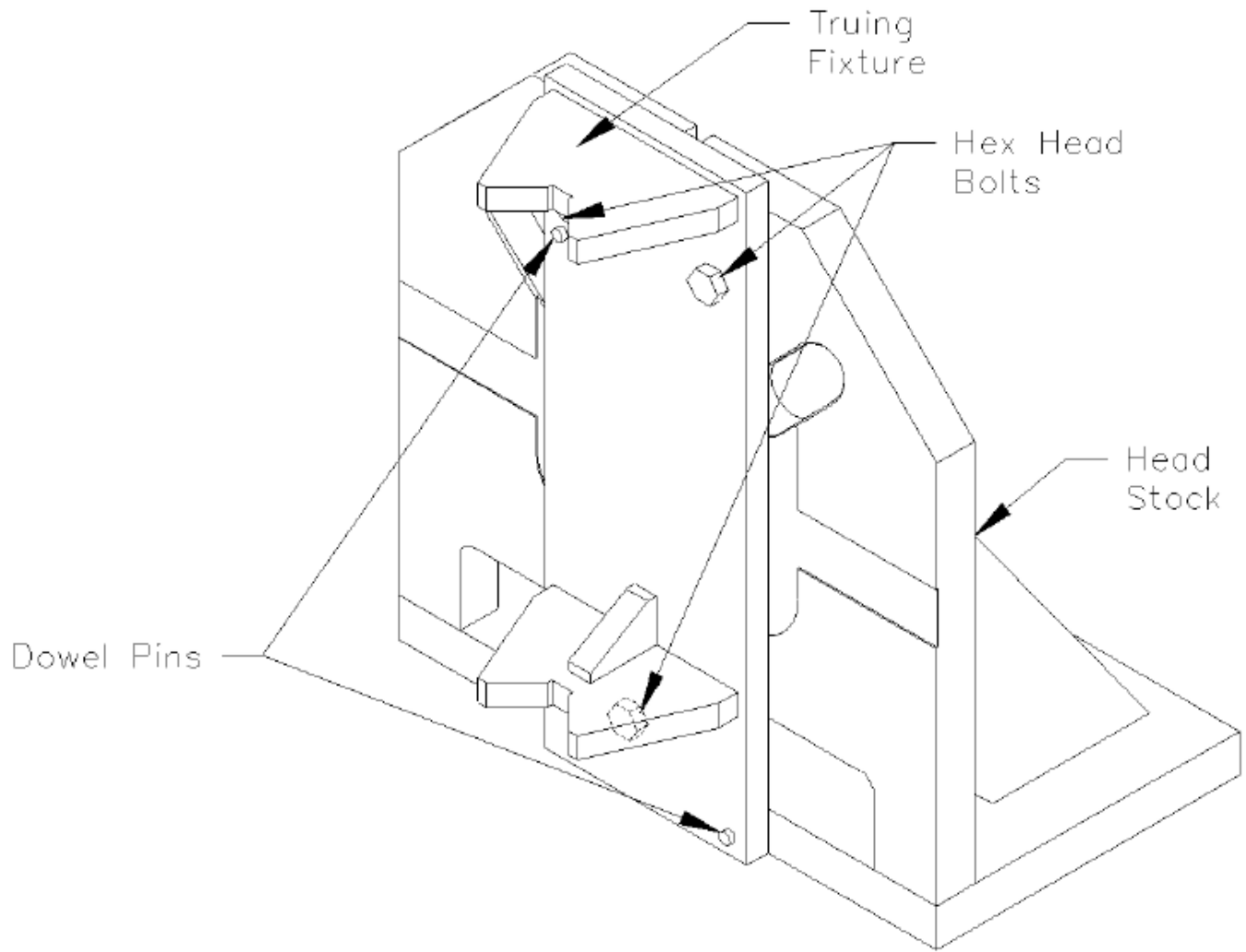


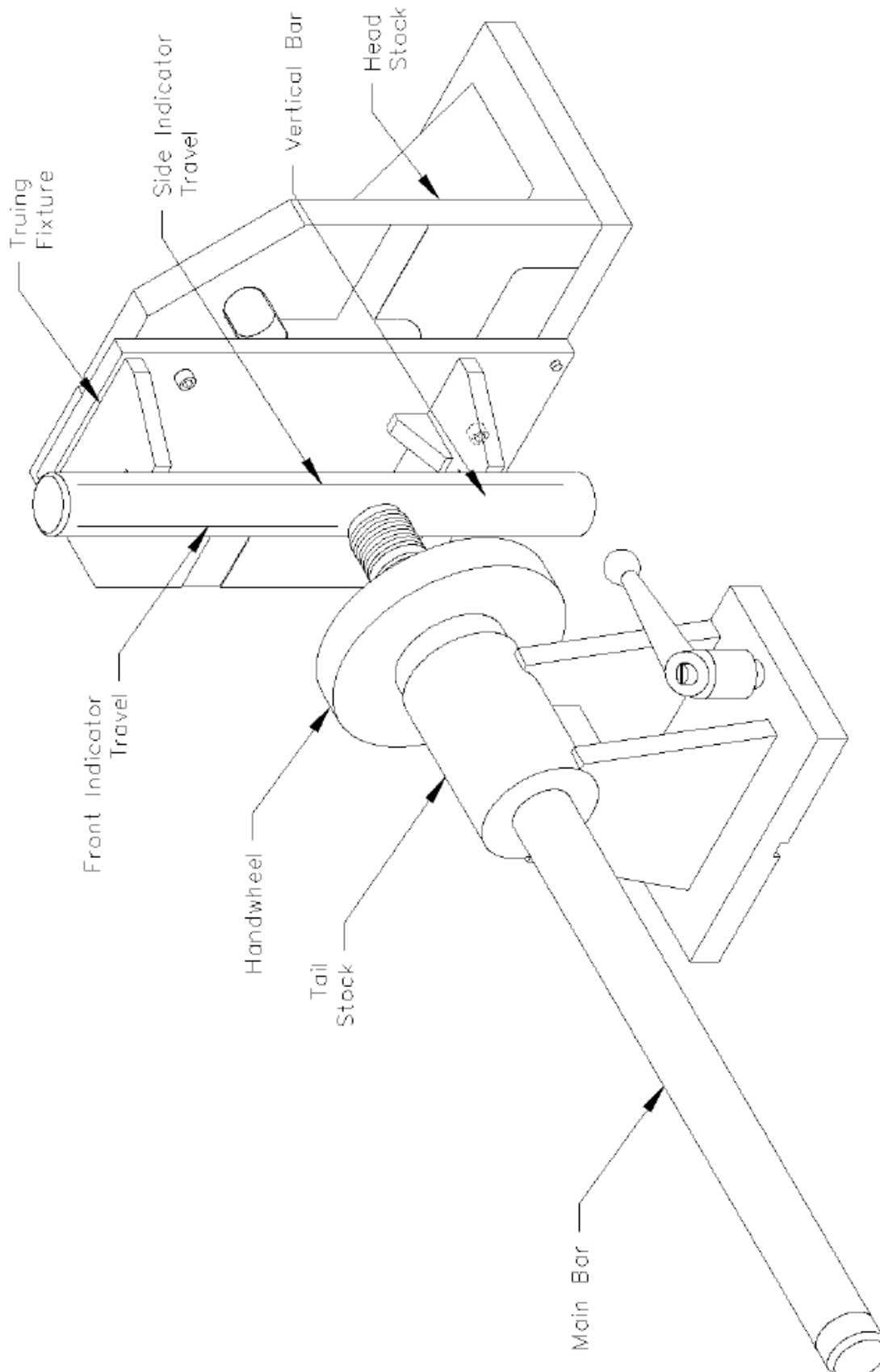


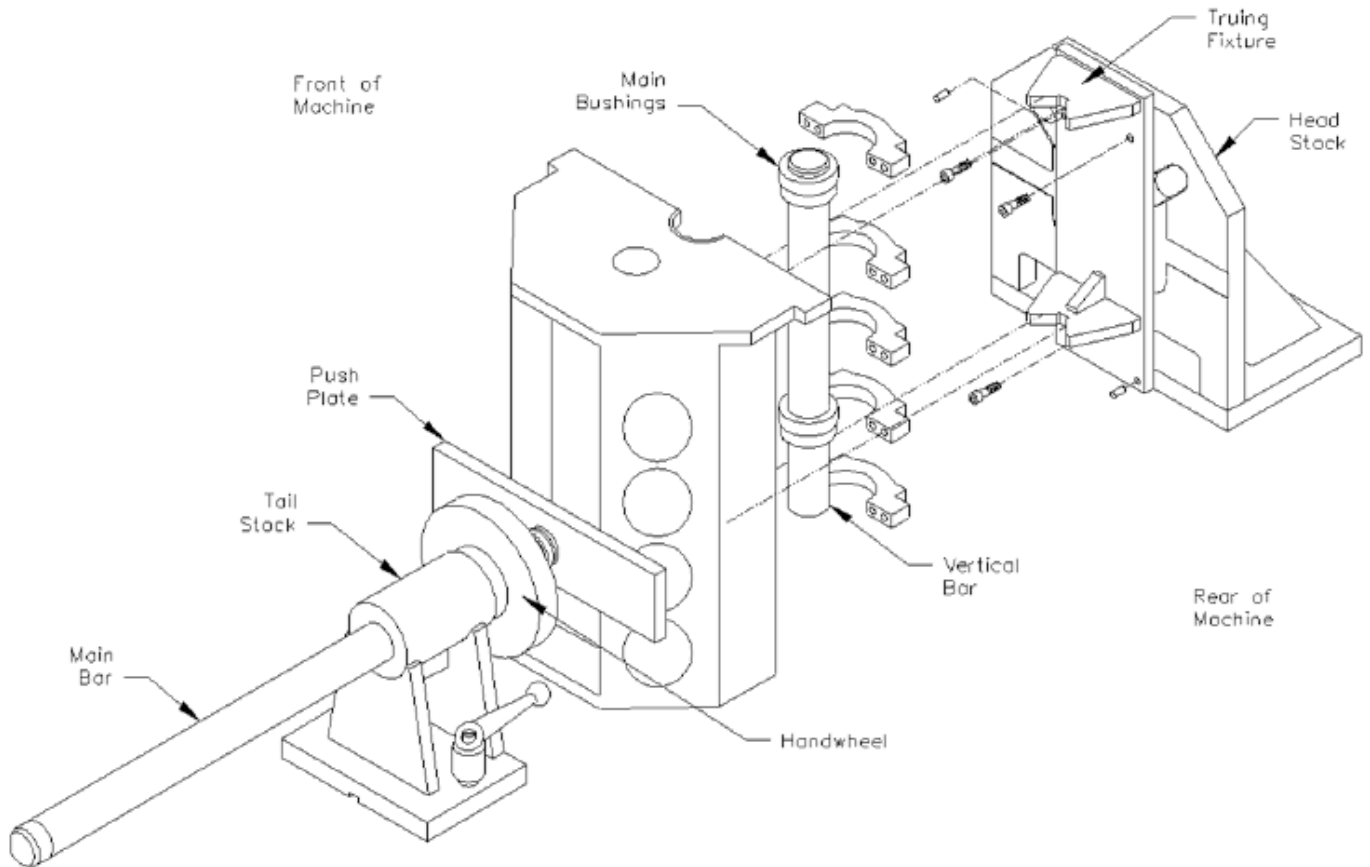


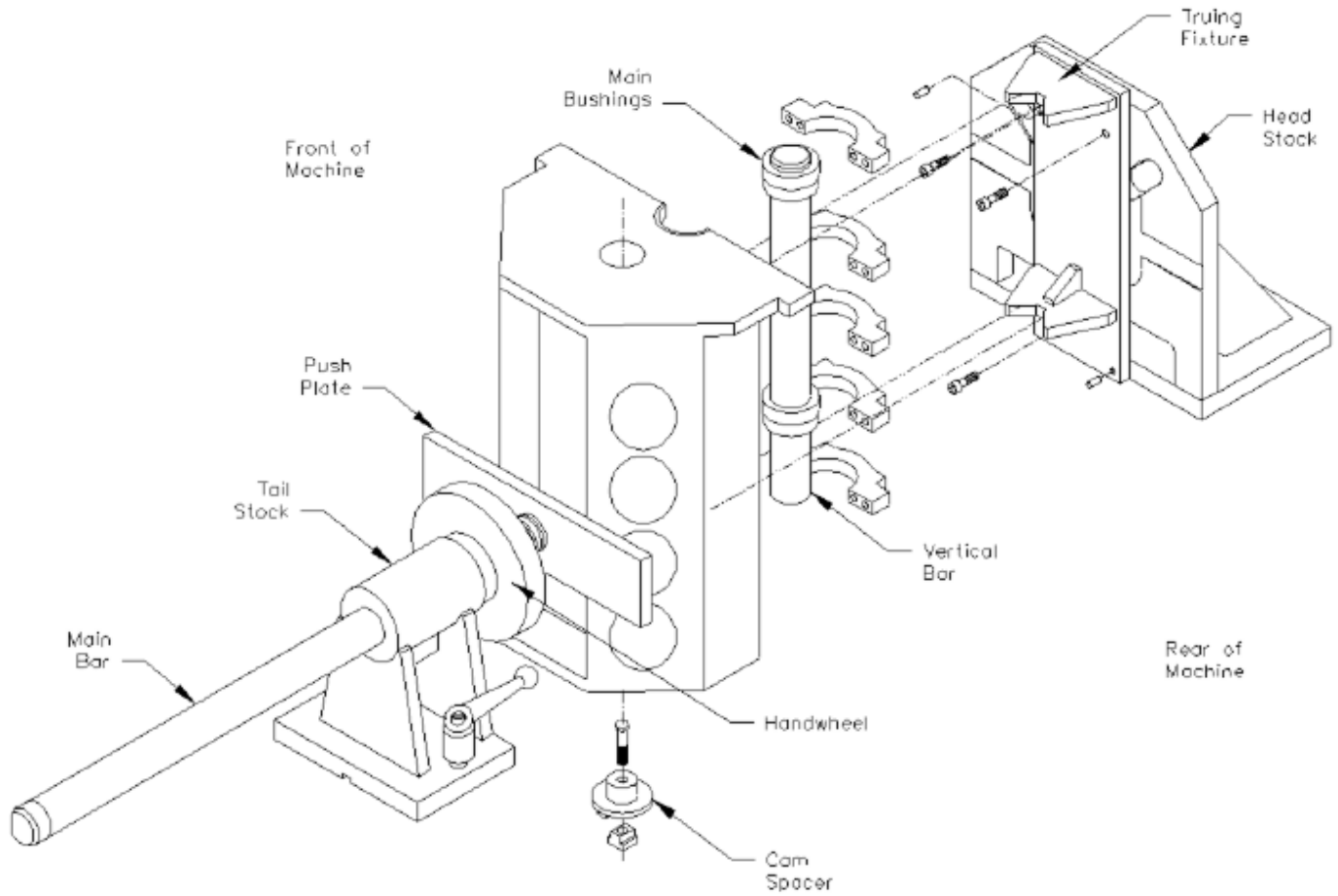


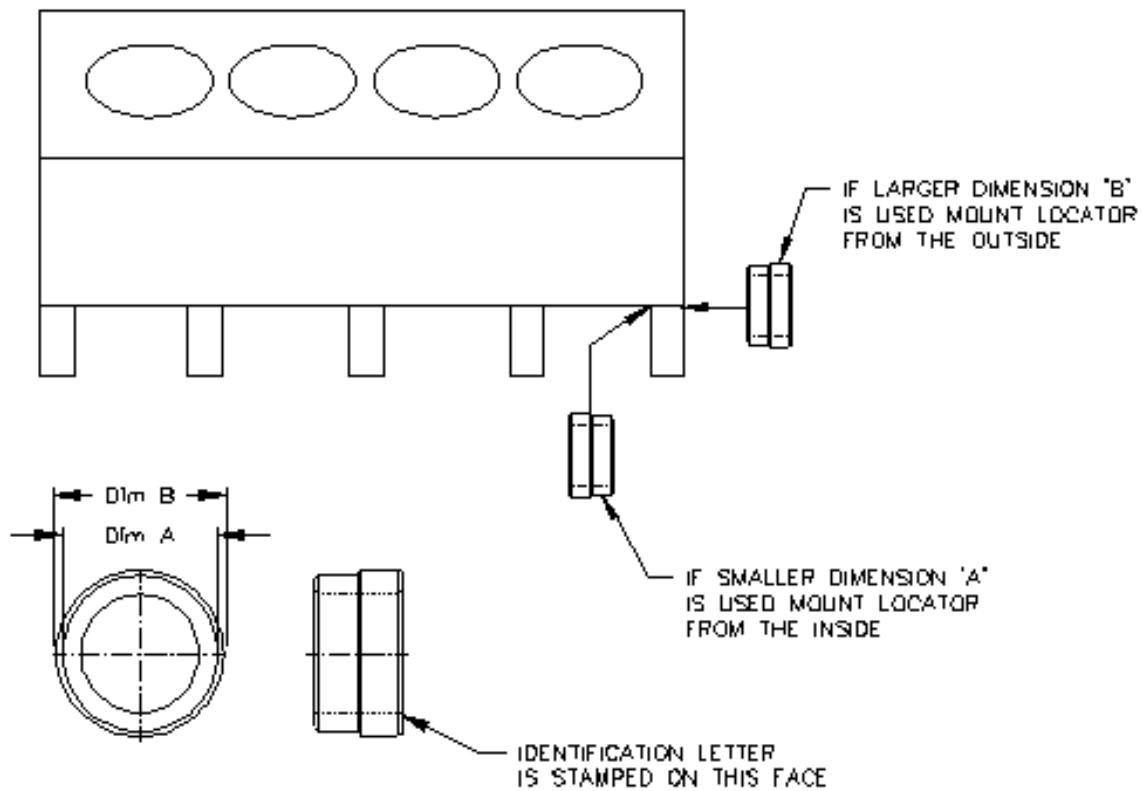
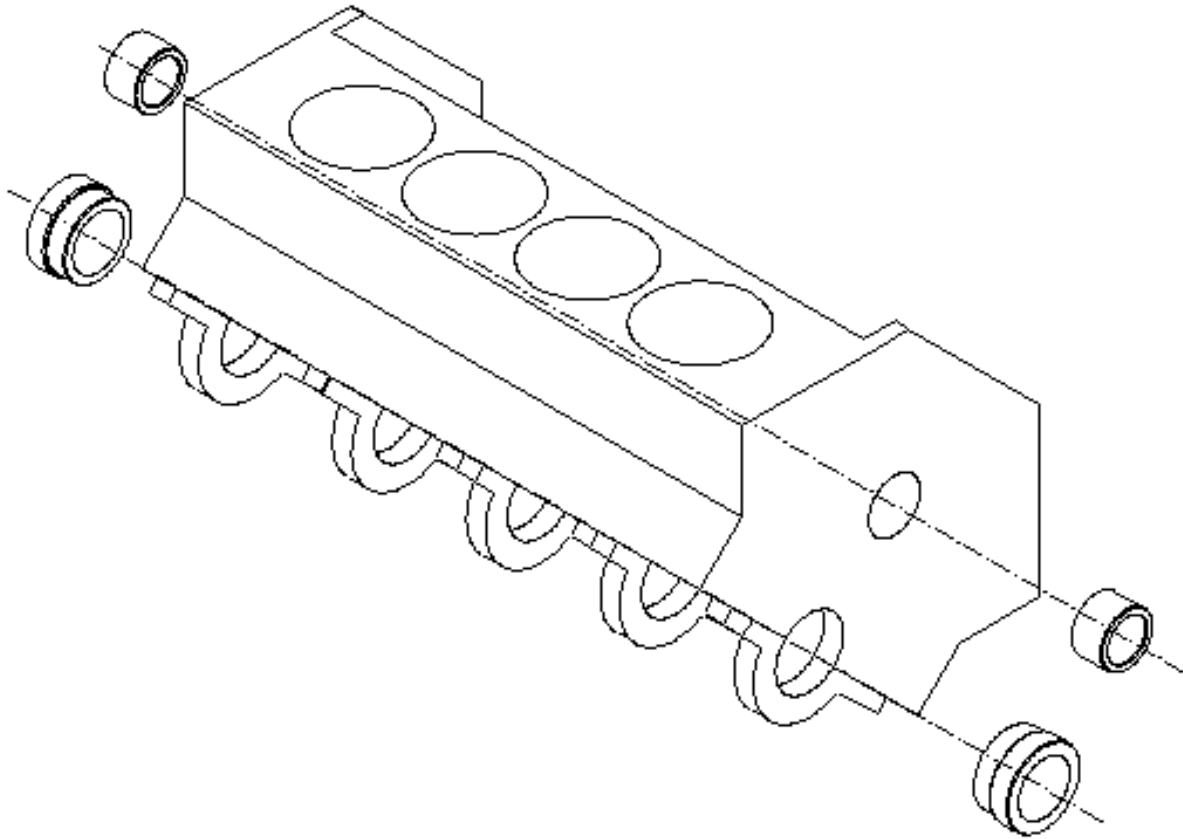




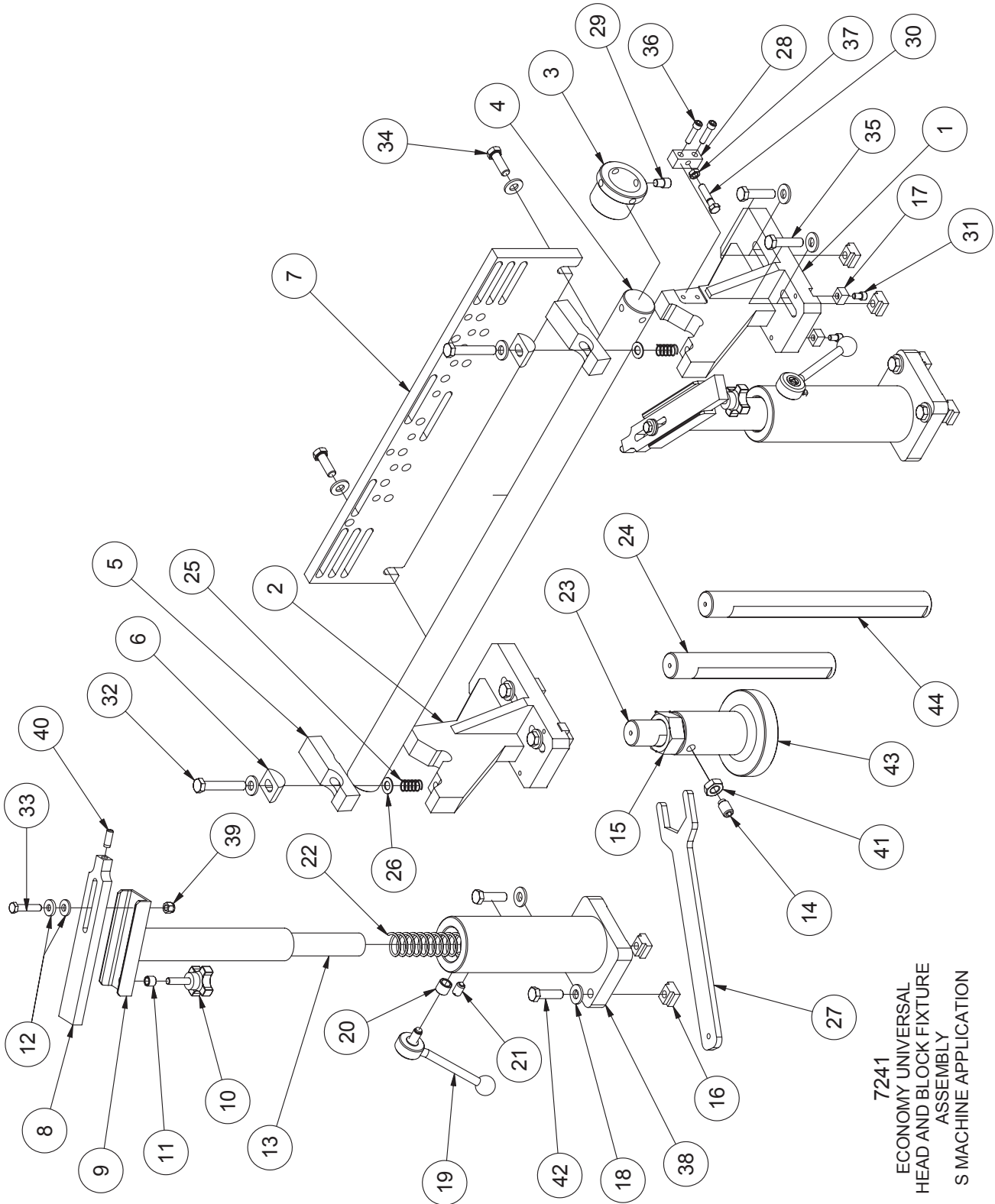








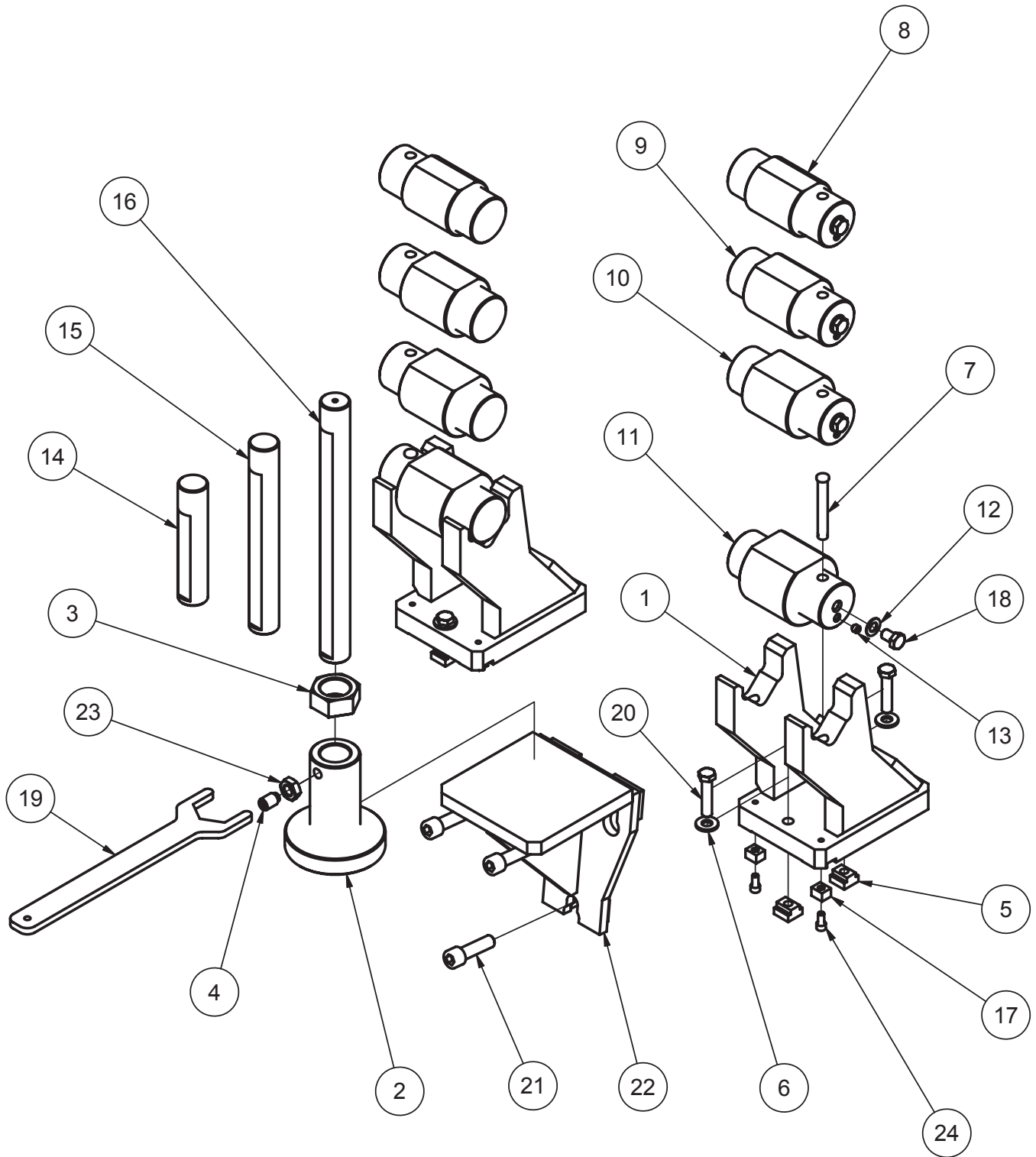
7241 Universal Block Fixture Parts



7241
ECONOMY UNIVERSAL
HEAD AND BLOCK FIXTURE
ASSEMBLY
S MACHINE APPLICATION

7241 ECONOMY UNIVERSAL HEAD AND BLOCK FIXTURE ASSEMBLY S7/S8			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	7241L	SUPPORT, RIGHT, F60 ECONOMY HEAD & BLOCK FIXTURE
2	1	7241K	Left Support
3	1	7241D	Cam Bushing
4	1	7241E	LOCATOR BAR, ECONOMY HEAD AND BLOCK FIXTURE
5	2	7241F	CLamp Finger
6	2	7241G	PIVOT
7	1	7241H	Mount Plate
8	2	7242E	SHOE, CLAMP - CLAMP TOWER SF-8
9	2	7242F	Clamp Tower Leg
10	2	7242H	Knob
11	2	7242J	Thread Insert 3/8-16
12	2	7242K	SPHERICAL WASHER SET
13	2	7242L	Spacer Tube
14	1	6395B	5/8-11 Half Dog 1" long SET SCREW
15	1	6566H	Jacking Nut
16	8	650-3-10	TN-5 T-Nut
17	4	650-3-9	Key
18	12	100-19A	Hardened washer 17/32 I.D.
19	2	6310N	HANDLE ASSEMBLY, CLAMP TOWER - F80
20	2	6310R	Thread Insert
21	2	502-8-52C	Spring Plunger
22	2	650-3-49M	Spring
23	1	6396	JACKING SCREW 7" LG.
24	1	6396A	JACKING SCREW 11-1/4" LG.
25	2	502-2-11F	Spring
26	2	100-19	Washer
27	1	6566K	WRENCH, JACKING NUT - DIESEL FIXTURING
28	1	6451Q	Block, Adjusting Belt, Servo Motor
29	1	7241X	7/16-14 CAPSCREW REWORK
30	1	7241Y	STOP - CAM BUSHING
31	4	MF21A	Hexagon Socket Head Cap Screw
32	2	MF-150B	1/2-13UNC x 3" LG. HEX BOLT
33	2	MF-145	3/8-16UNC x 1-3/4" LG. HEX BOLT
34	2	MF-150A	1/2-13UNC x 1-1/2" LG. HEX BOLT
35	4	MF-149C	1/2-13UNC x 2" LG. HEX BOLT
36	2	MF-24	S.H.C.S.5/16 - 18 UNC - 1 1/4
37	1	MF-167	3/8-16UNC HEX JAM NUT
38	2	7242	BASE, CLAMP TOWER (10.9" TALL) ECONOMY HEAD AND BLOCK FIXTURE
39	2	MF-187B	3/8-16UNC NYLOCK NUT
40	2	MF-212	3/8"x 1" LG. DOWEL PIN
41	1	502-1-12G	5/8-11UNC HEX JAM NUT
42	4	MF-137F	1/2-13UNC x 1-3/4" LG. HEX BOLT
43	1	6395D	JACK BODY
44	1	6396B	JACKING SCREW 15-1/2" LG.

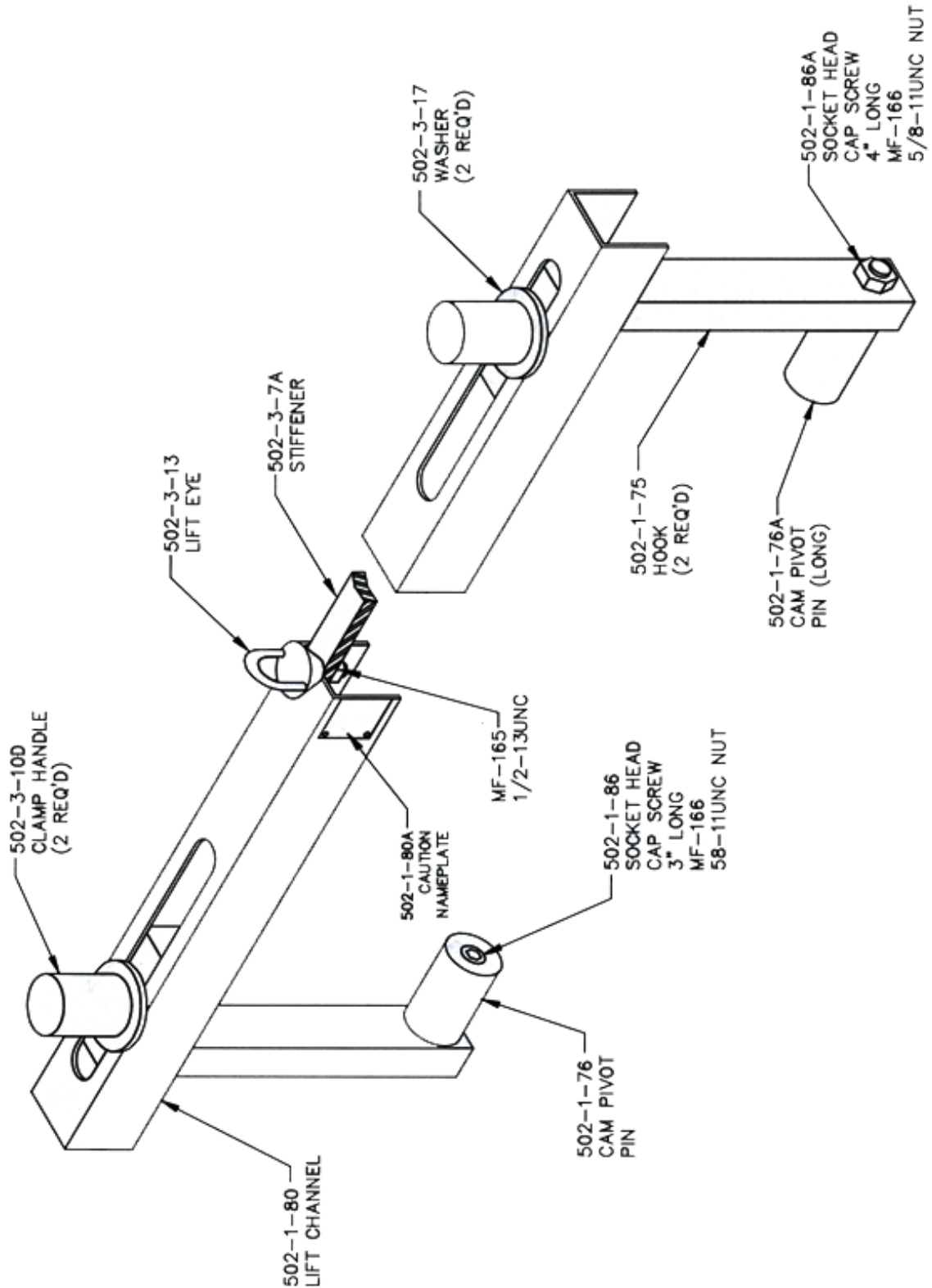
7243 Mid-size Diesel Block Fixture Parts



7243

7243 DIESEL FIXTURE ASSEMBLY, INLINE AND MID RANGE V BLOCK			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	6553M	SUPPORT, MAIN BEARING FIXTURE - F5
2	1	6395D	JACK BODY
3	1	6566H	Jacking Nut
4	1	6395B	5/8-11 Half Dog 1" long
5	4	650-3-10	TN-5 T-Nut
6	4	100-19A	Hardened washer 17/32 I.D.
7	2	6553H	PIN, LOCATION - DIESEL FIXTURE
8	2	6787B	LOCATOR, MAIN BEARING 3.0" TO 3.225" DIA., DIESEL FIXTURE
9	2	6787C	LOCATOR, MAIN BEARING 3.22 TO 3.50 DIA.
10	2	6787D	Locator, main Bearing 3.50 to 4.00 dia.
11	2	6787E	Locator, main Bearing 4.00 to 5.00 dia.
12	8	100-19	Washer
13	8	6788Q	SCREW, SET - BRASS TIPPED 3/8-16UNC x 5/16"
14	1	6396	JACKING SCREW 7" LG.
15	1	6396A	JACKING SCREW 11-1/4" LG.
16	1	6396B	JACKING SCREW 15-1/2" LG.
17	4	650-3-9	Key
18	8	MF-137E	1/2-13UNC x 3/4" LG. HEX BOLT
19	1	6566K	WRENCH, JACKING NUT - DIESEL FIXTURING
20	4	MF-149A	1/2-13UNC x 2-1/4" LG. HEX BOLT
21	3	502-11-61	5/8-11UNC x 2-1/4" LG. S.H.C.S.
22	1	502-11-51	CENTER SUPPORT
23	1	MF-173	5/8-11UNC JAM NUT
24	4	MF-21	5/16-18UNC x 5/8" LG. S.H.C.S.

Accessories for Fixtures
502-1-95 Block Handler Parts



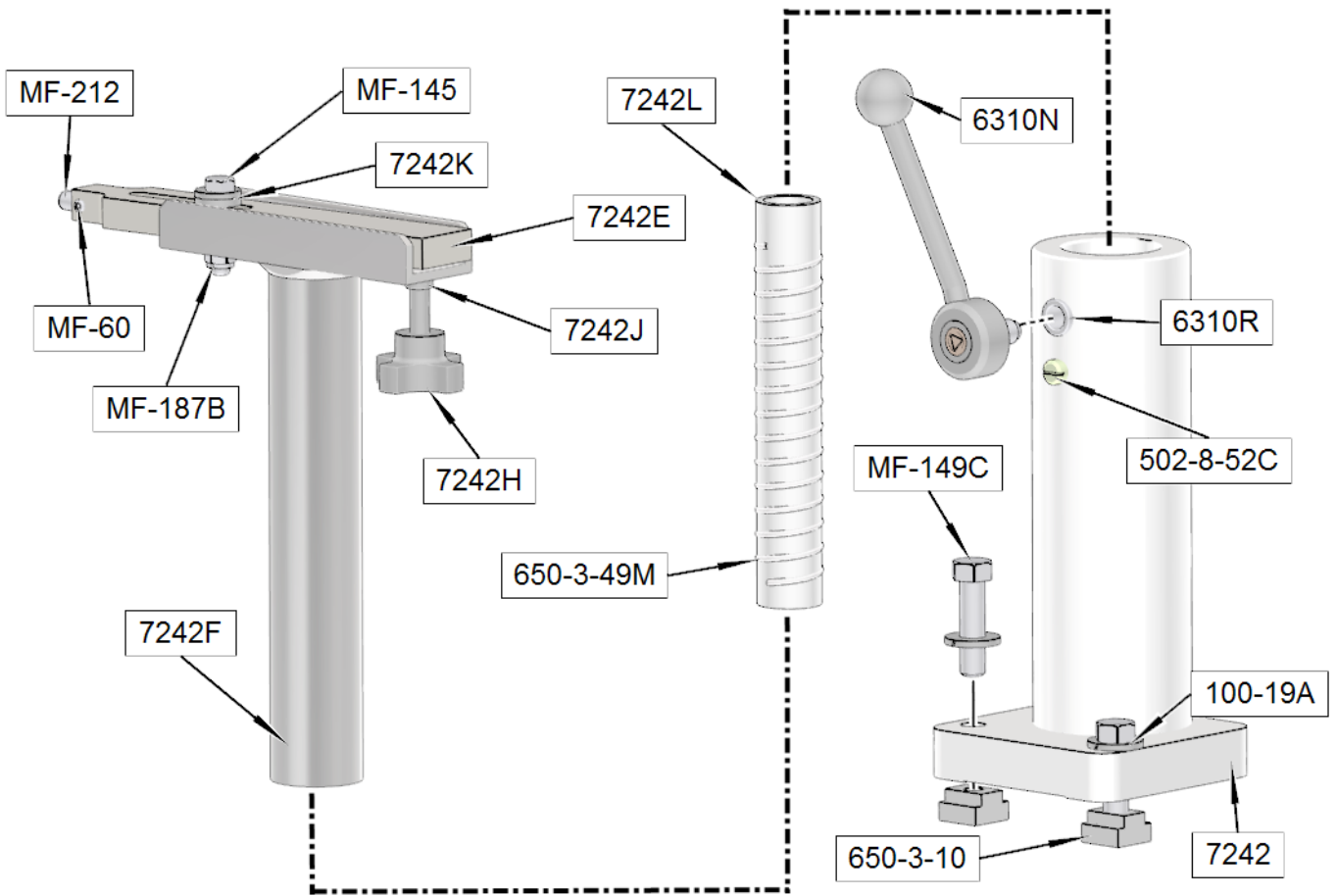
502-1-46T Precision 2" (50.8mm) Locator Bar



550-5-10 (1) pair of Main bearing bushings for Detroit 8.2 liter diesel



7242M Clamp Tower Assembly Parts



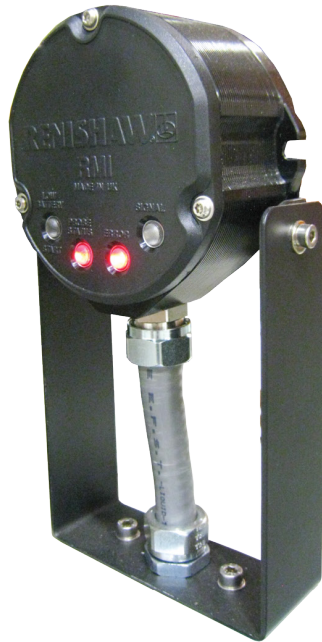
Height Probing

650-3-59W Renishaw Wireless Probing System Components

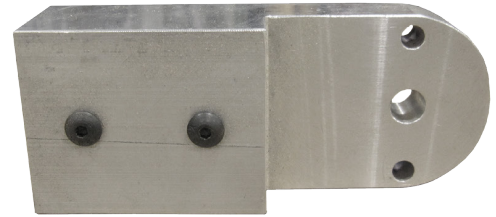
650-3-59Z
Probe



650-3-59U Radio
Probe Hardware Kit



650-3-59R Bracket



650-3-59V Spacer



6648Q Stylus

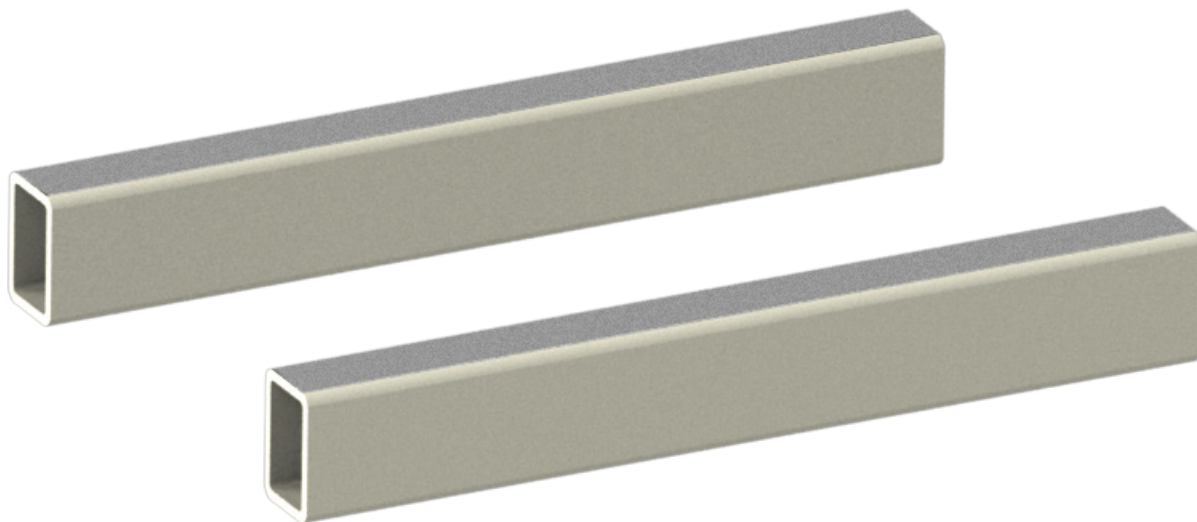


6648U
Battery

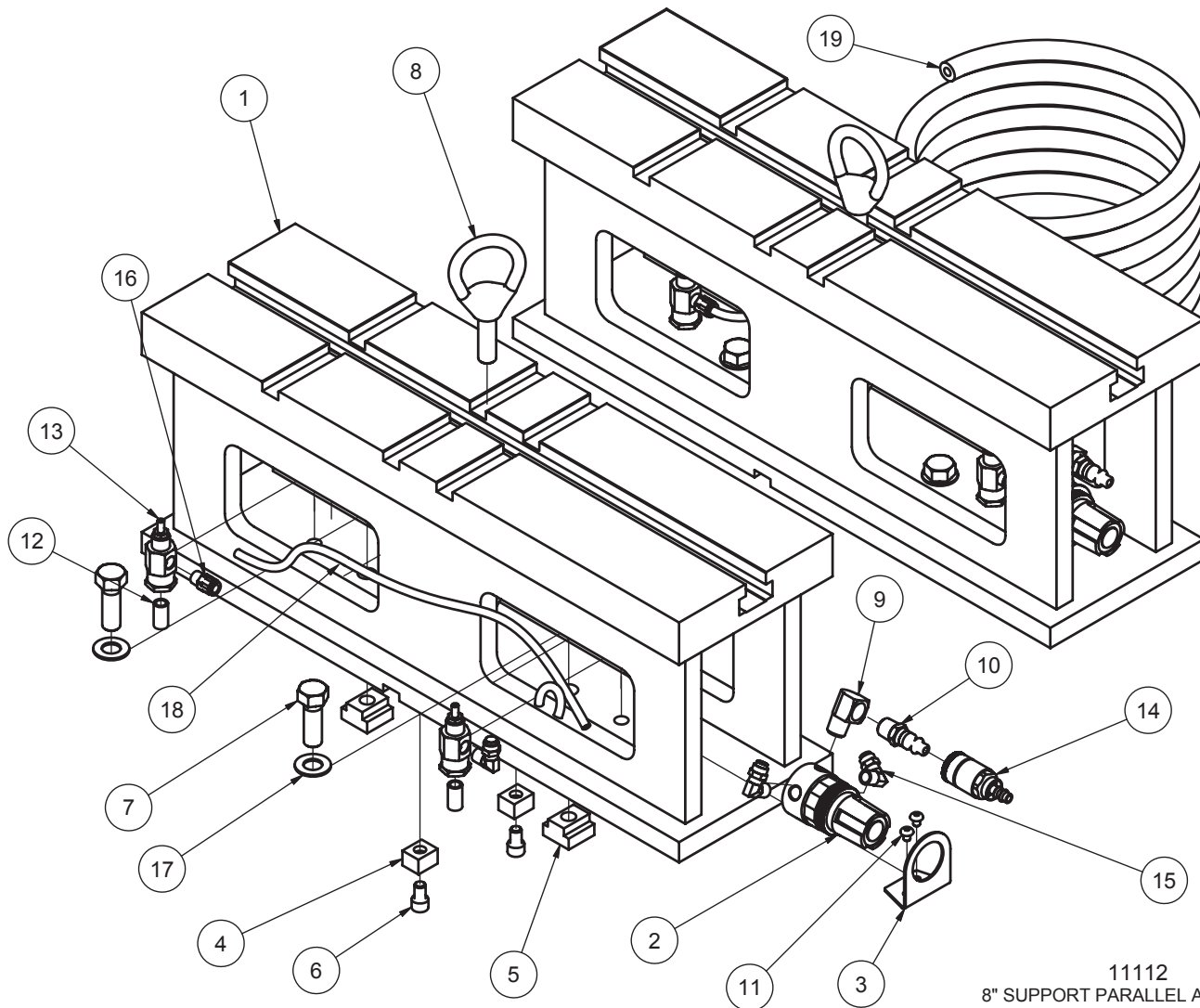


Parallels

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



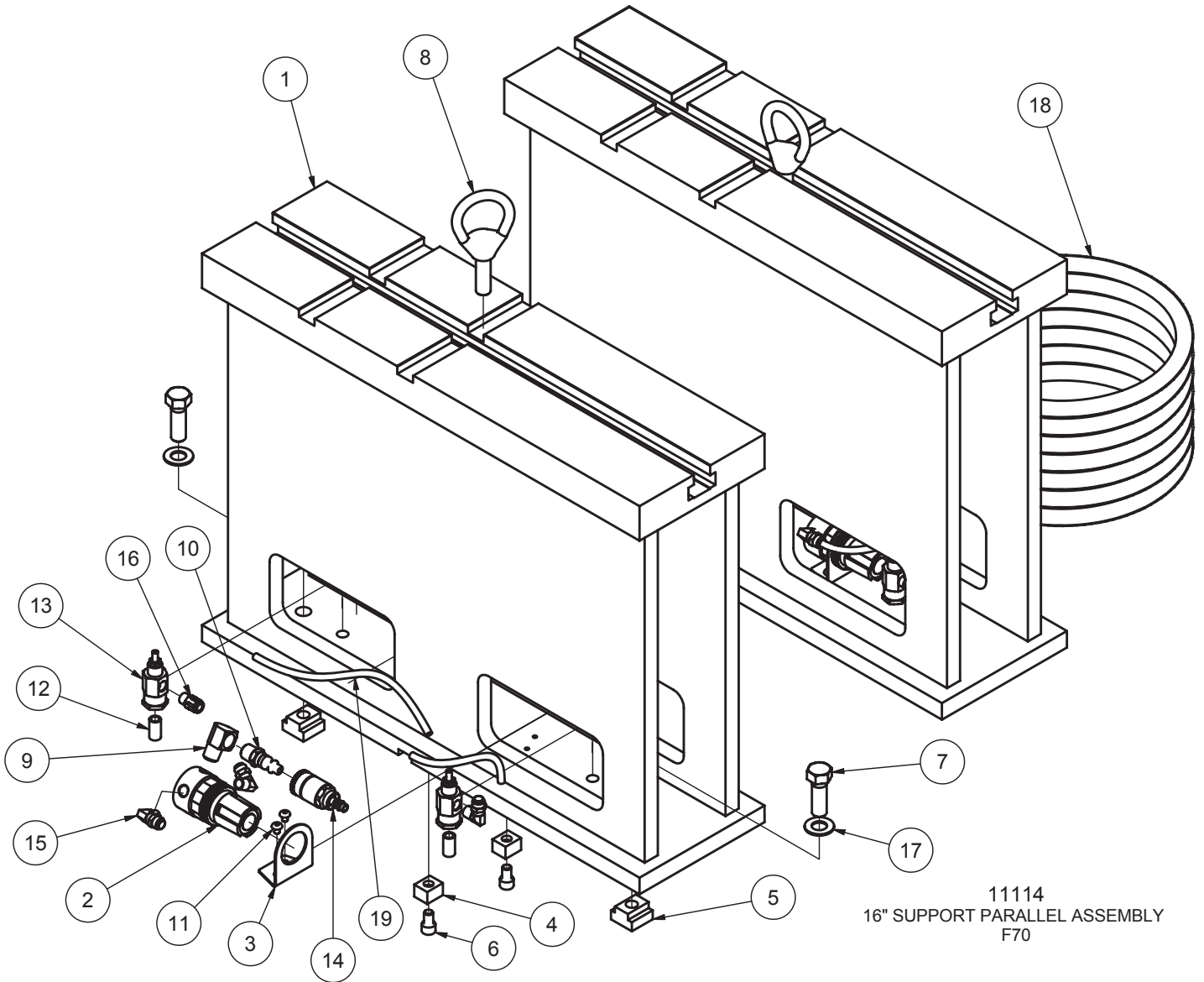
11112 Universal 8" (203mm) Heavy Duty T-Slot Parallels Parts



11112
8" SUPPORT PARALLEL ASSEMBLY
F70

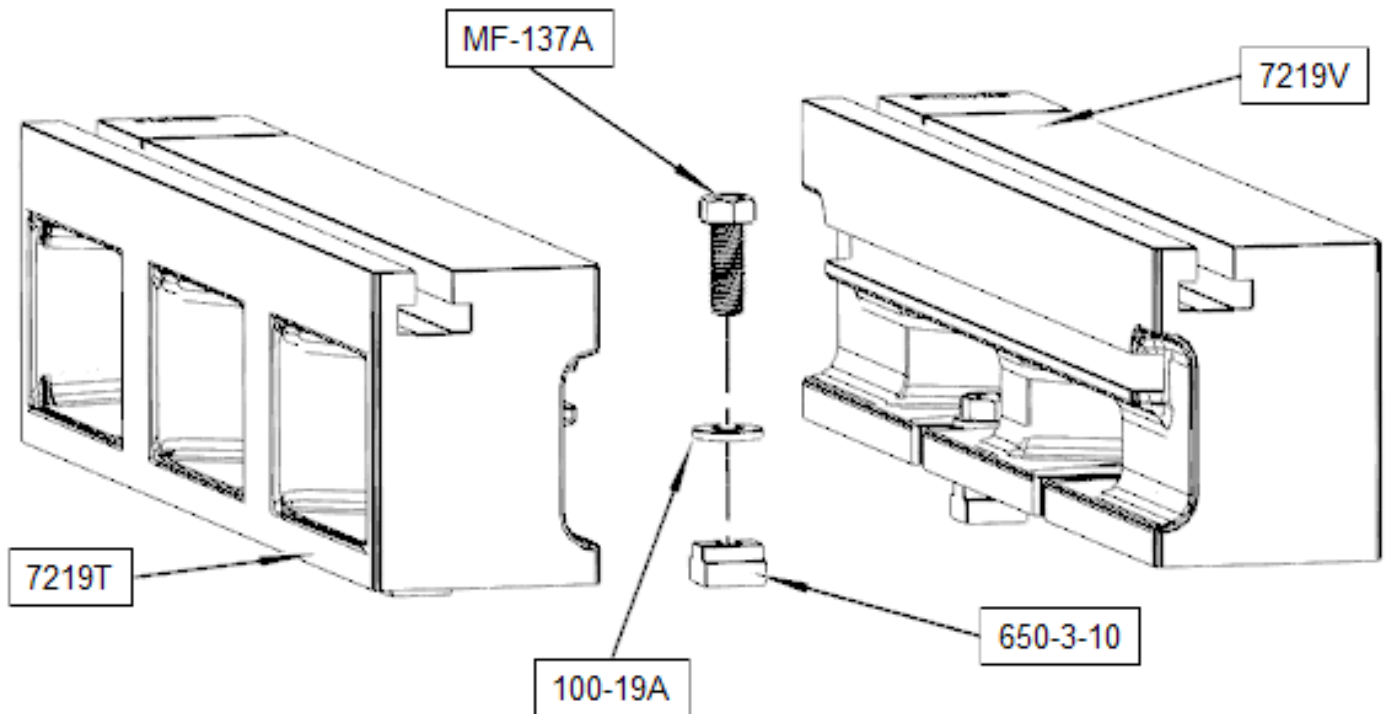
11112 SUPPORT PARALLEL ASSEMBLY 8" - F70			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	11112A	SUPPORT PARALLEL 8" (MACHINING) - F70
2	2	502-27-17	Regulator 0 - 60 PSI
3	2	502-27-17A	Regulator Bracket
4	4	650-3-9	Key
5	4	650-3-10	TN-5 T-Nut
6	4	MF-21A	5/16-18UNC x 1/2" LG. S.H.C.S.
7	4	MF-137A	1/2-13UNC x 1-1/2" 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 16" (405mm) Heavy Duty T-Slot Parallels Parts



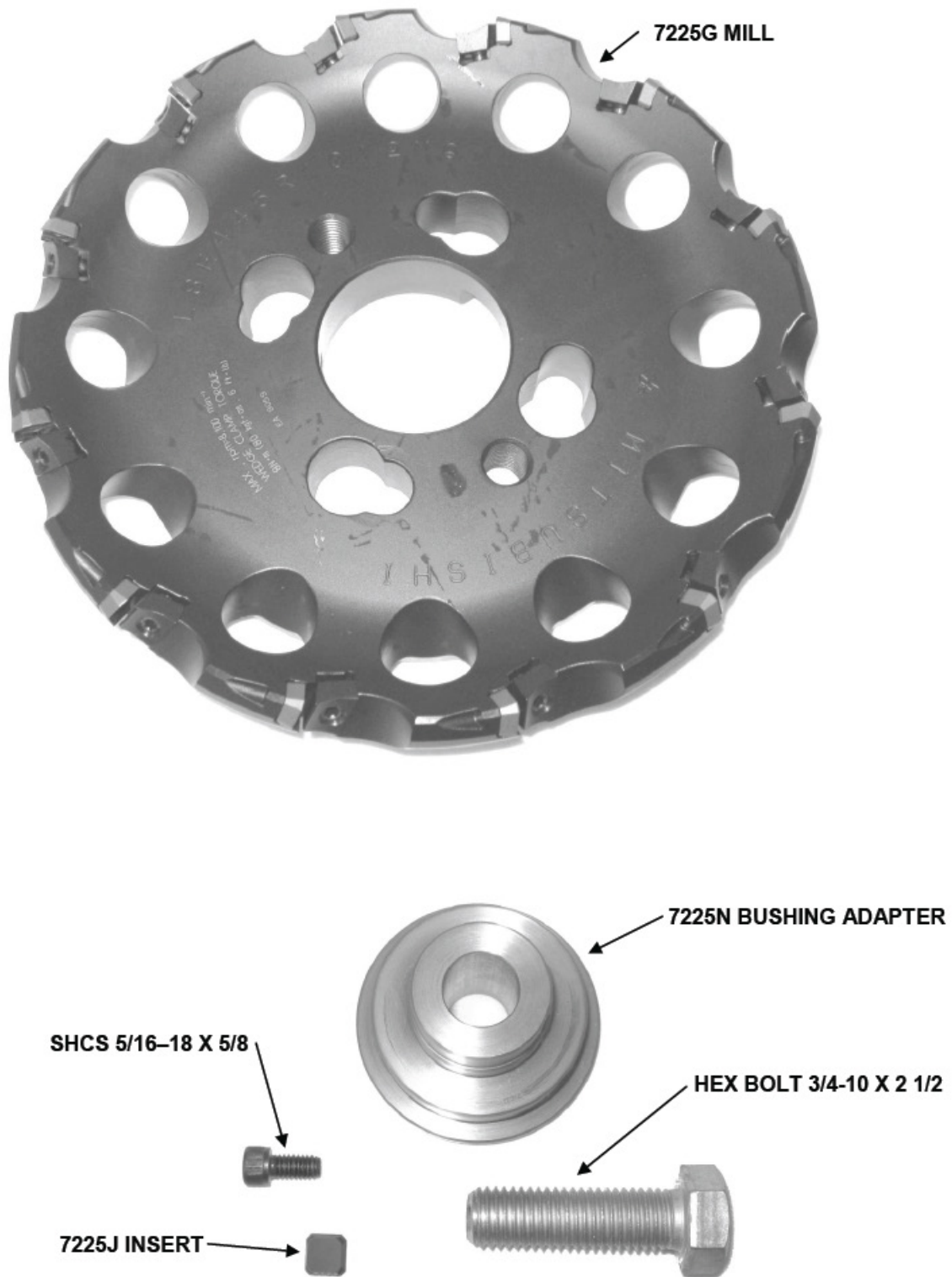
11114 SUPPORT PARALLEL ASSEMBLY 16" - F70			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	11114A	SUPPORT PARALLEL 16" (MACHINING) - F70
2	2	502-27-17	Regulator 0 - 60 PSI
3	2	502-27-17A	Regulator Bracket
4	4	650-3-9	Key
5	4	650-3-10	TN-5 T-Nut
6	4	MF-21A	5/16-18UNC x 1/2" LG. S.H.C.S.
7	4	MF-137A	1/2-13UNC x 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

7219W 5.2" (132mm) Heavy Duty T-Slot Universal Parallels Parts

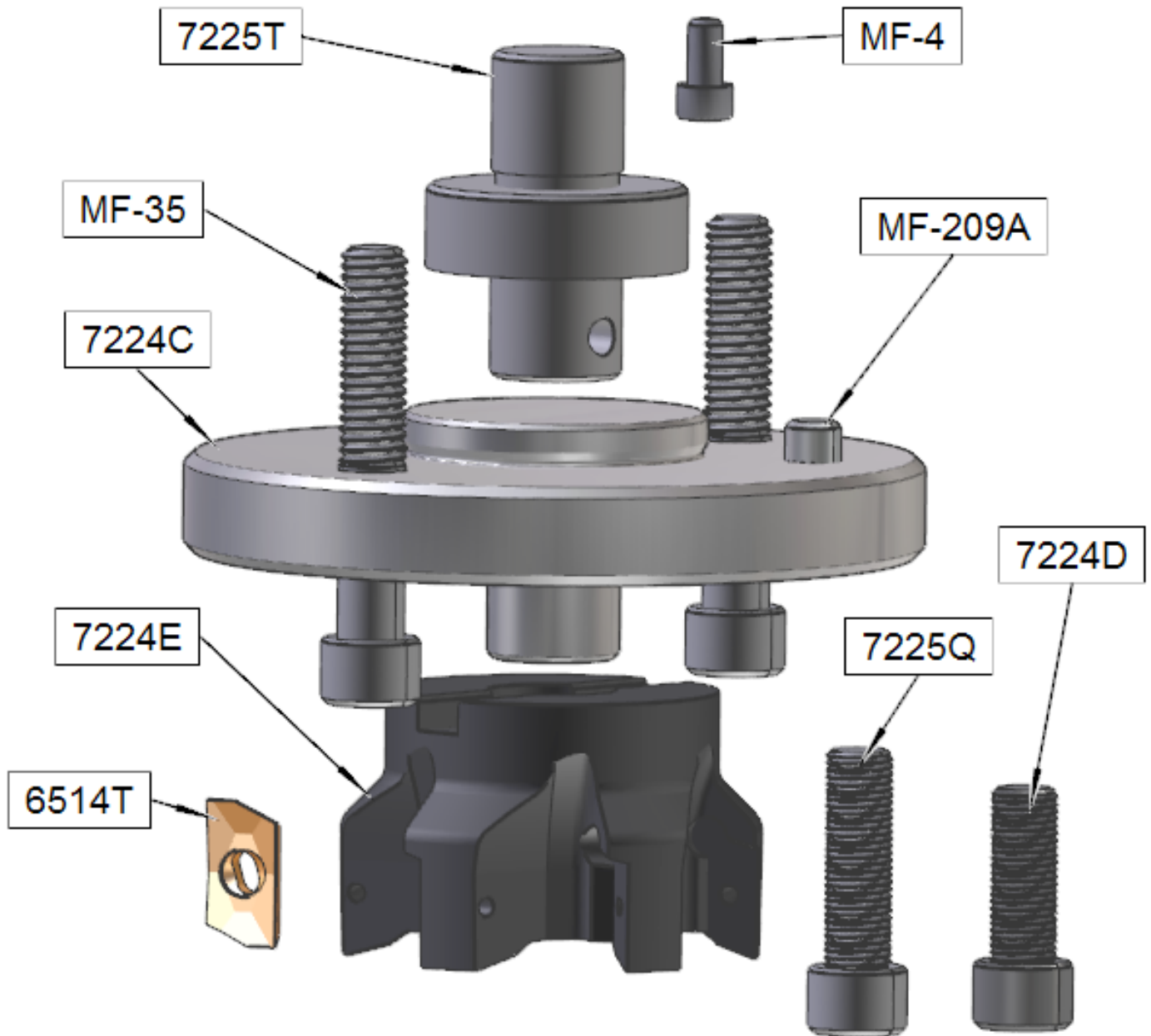


Optional Tooling

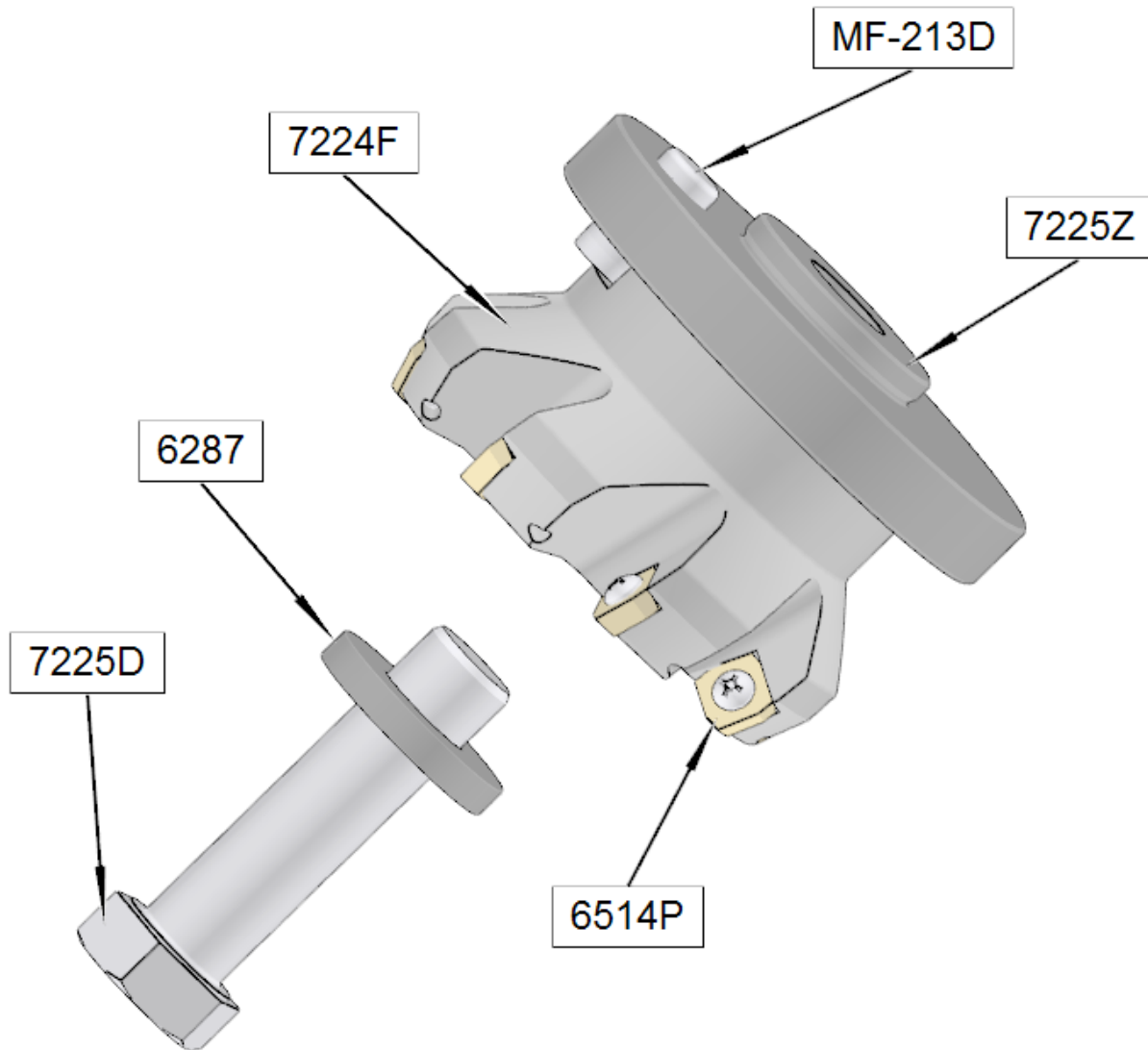
7225F 10" (254mm) Multi-tooth Face Mill Assembly Parts



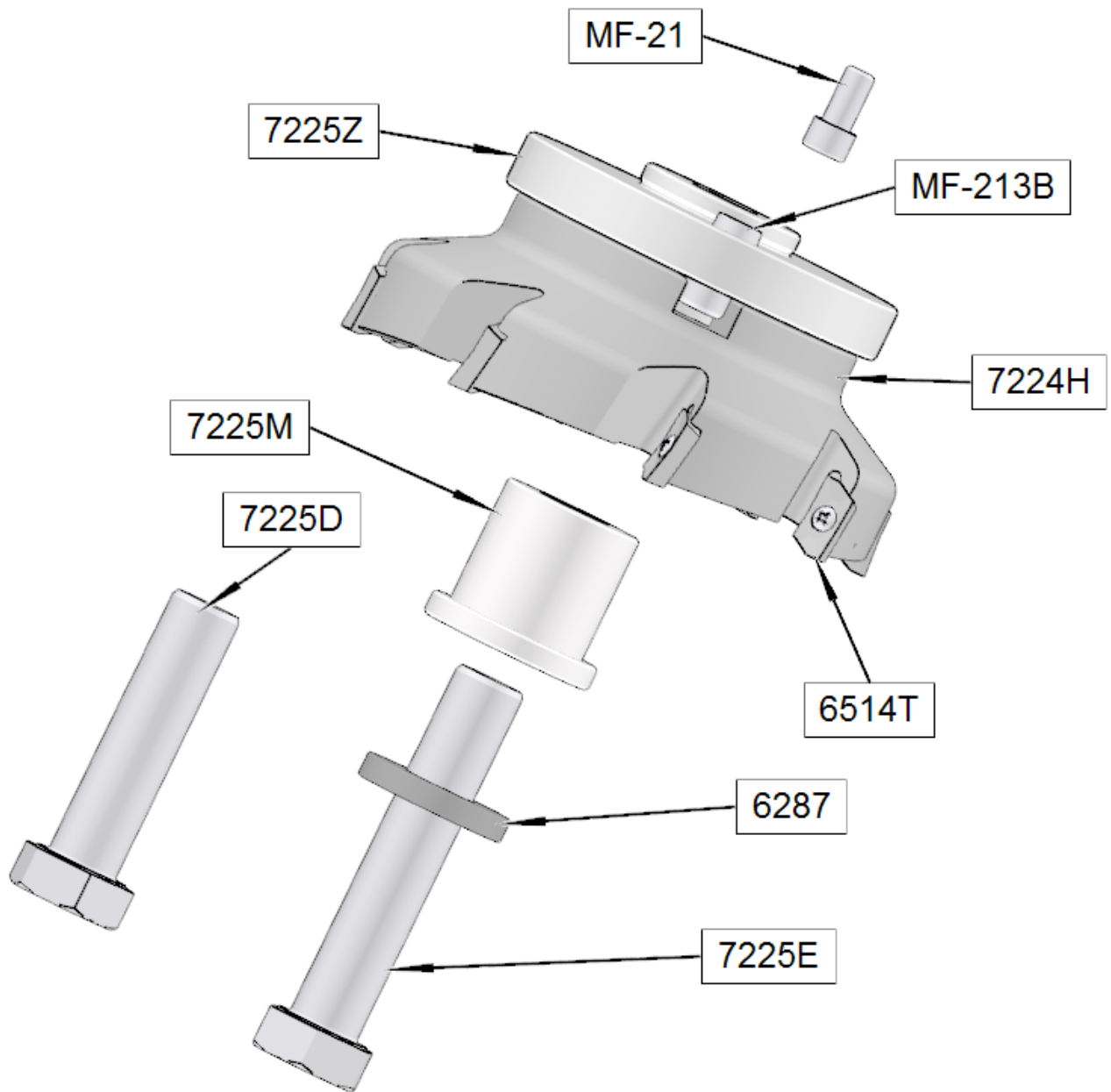
7224 Shell Mill Assembly Parts



7225Y Shell Mill Assembly Parts

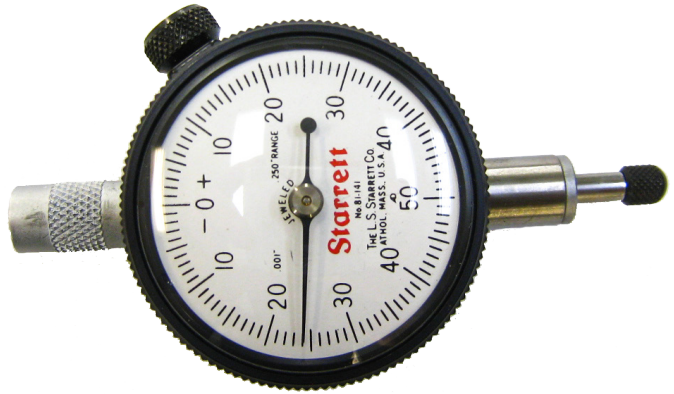


7224G Shell Mill Assembly Parts

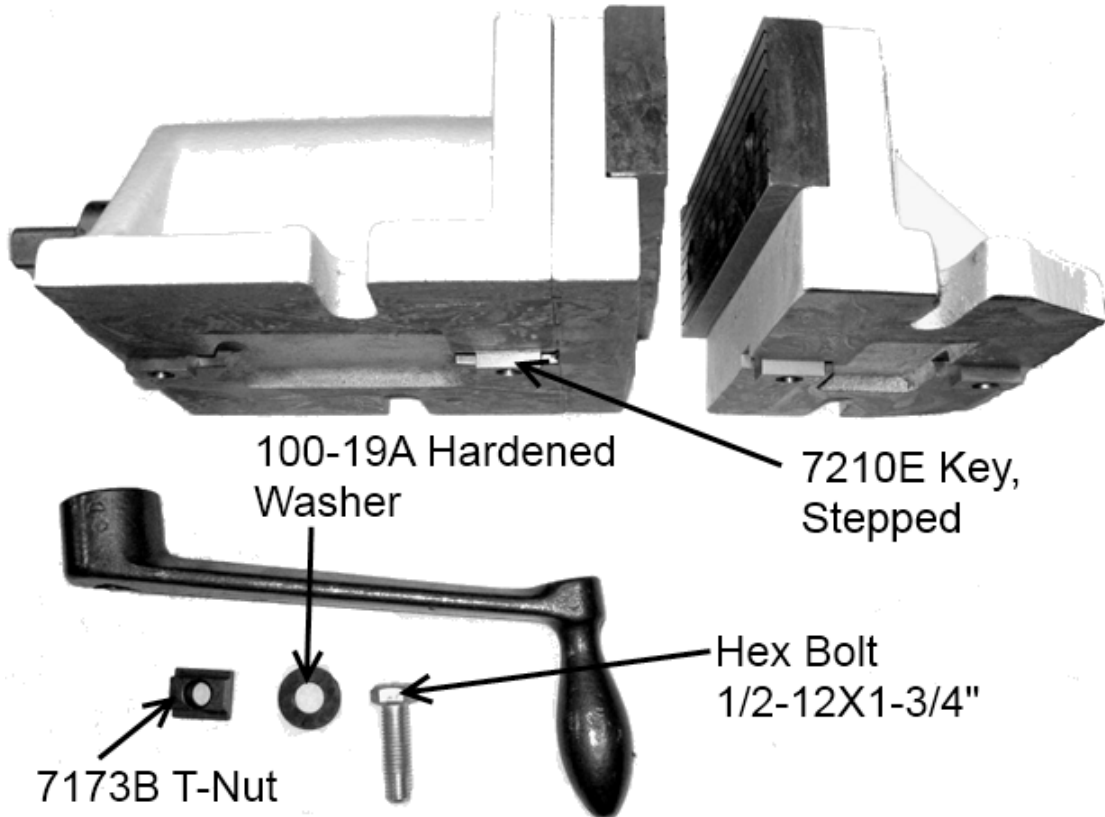


7038Y Flatness Probe Dial Indicator for Level Assembly

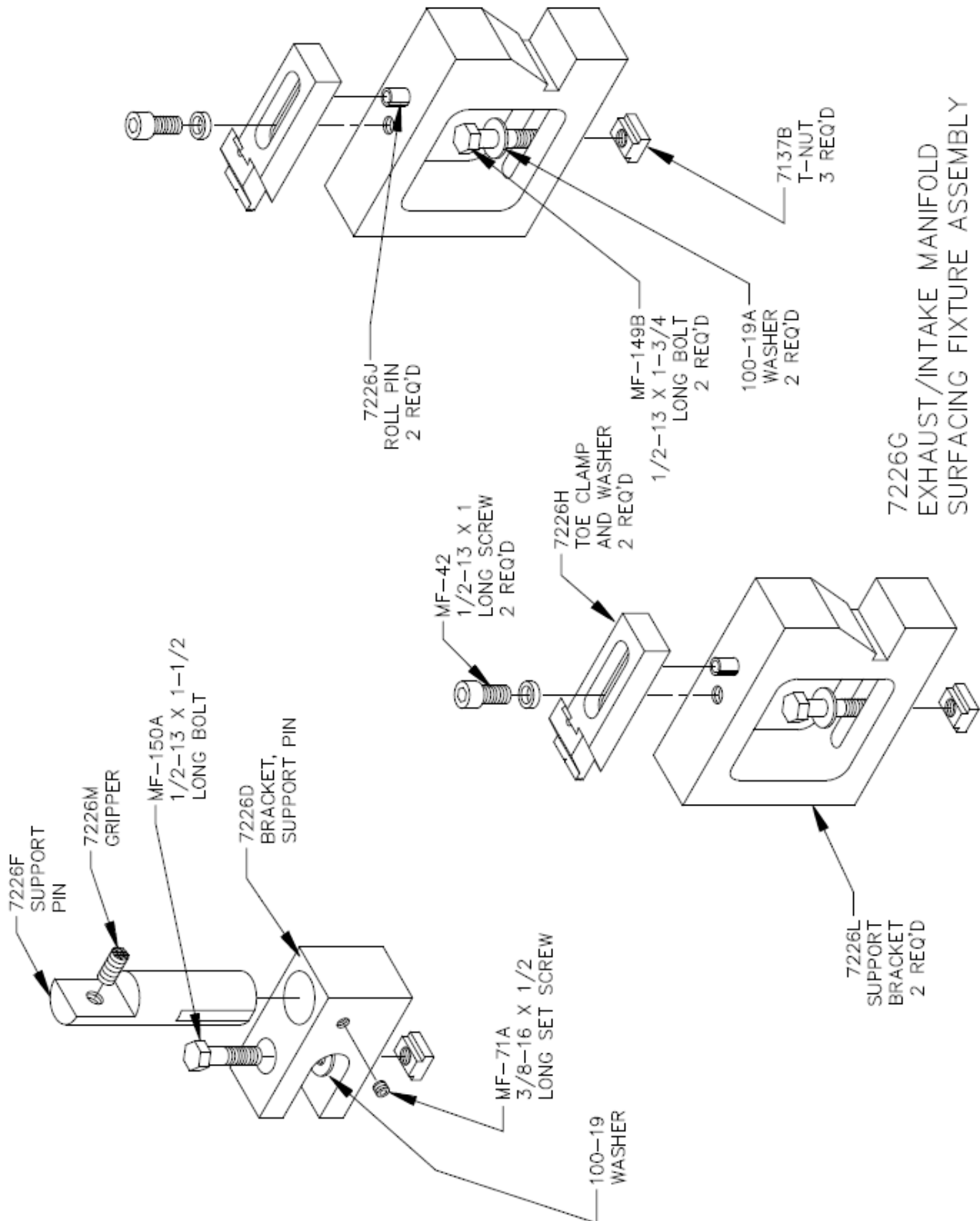
Sold as complete unit only.



7209N 2-Piece Vise Parts

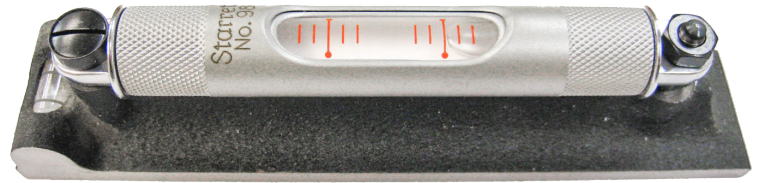


7226G Exhaust/Intake Manifold Surfacing Fixture Parts



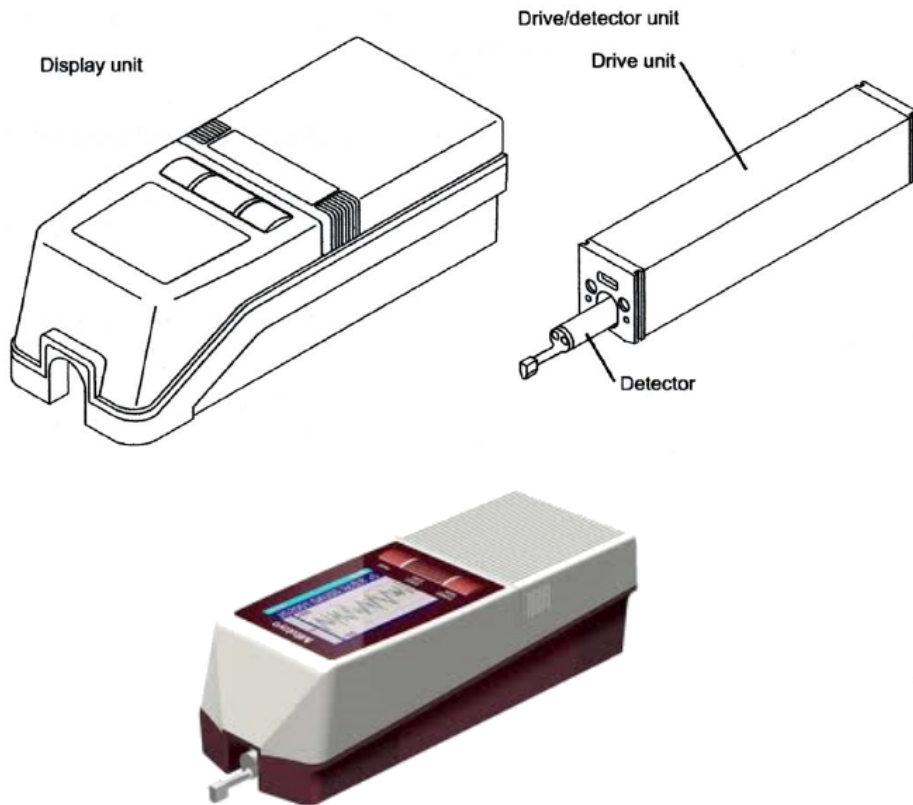
650-3-38 Machinist Level for Intake and Exhaust Manifolds

Sold as complete unit only.

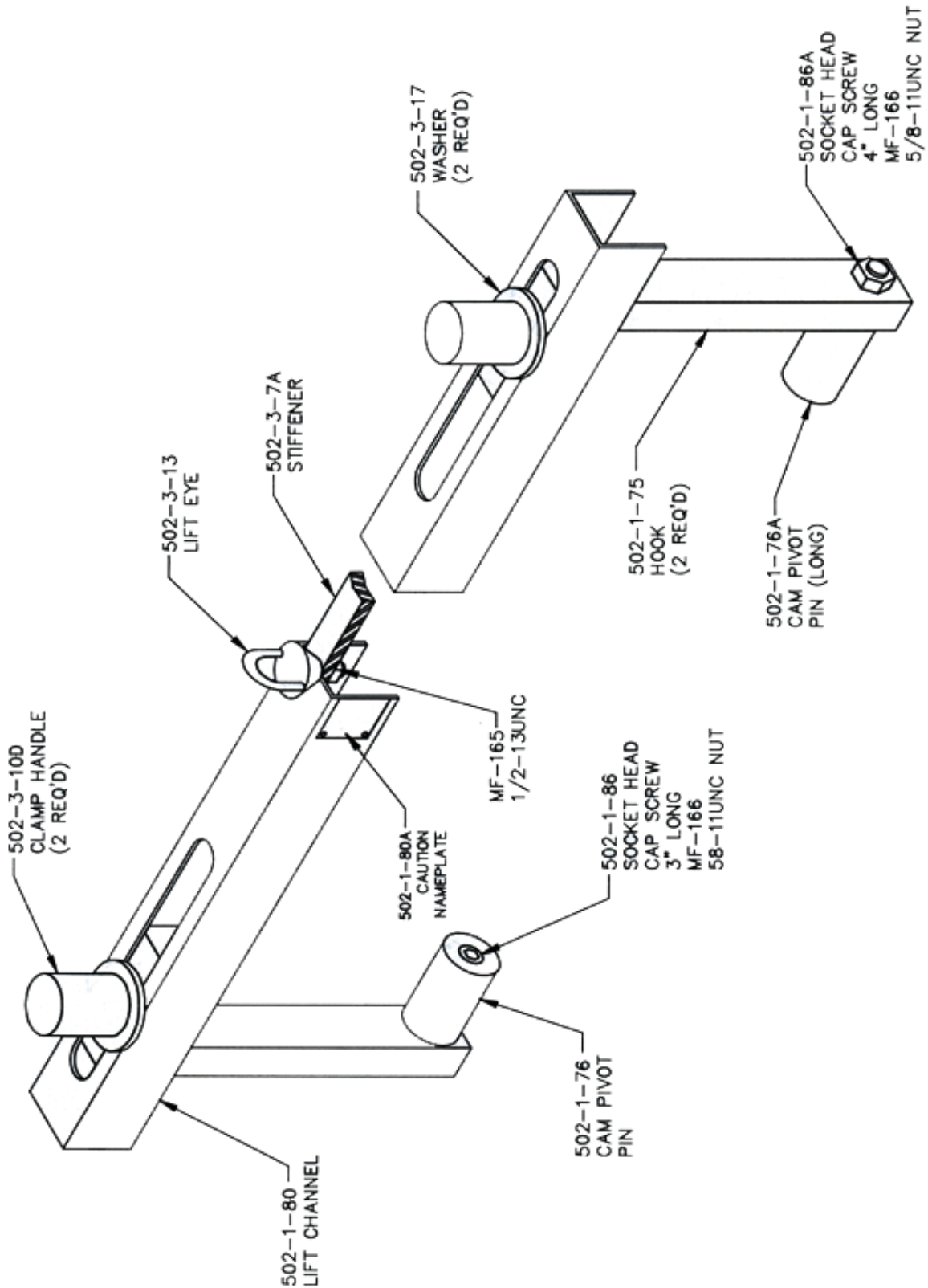


201 Mitutoyo Surface Tester

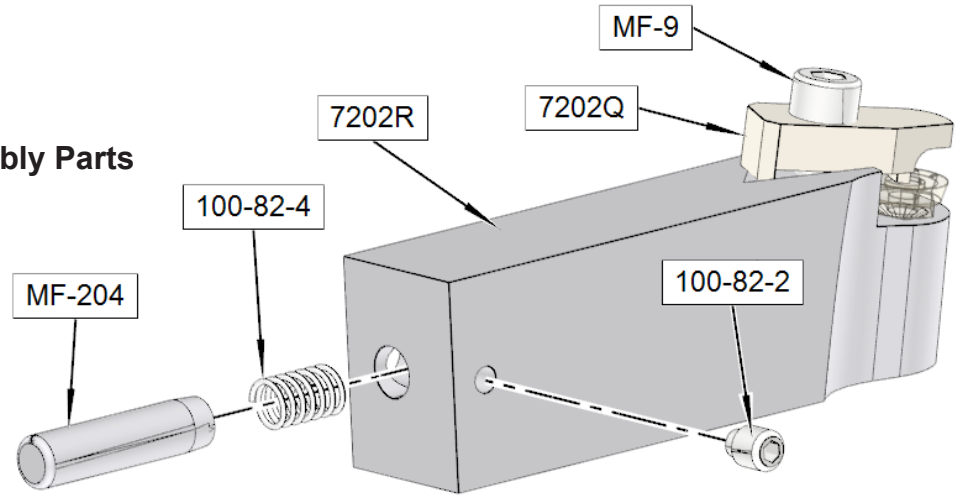
Sold as complete unit only.



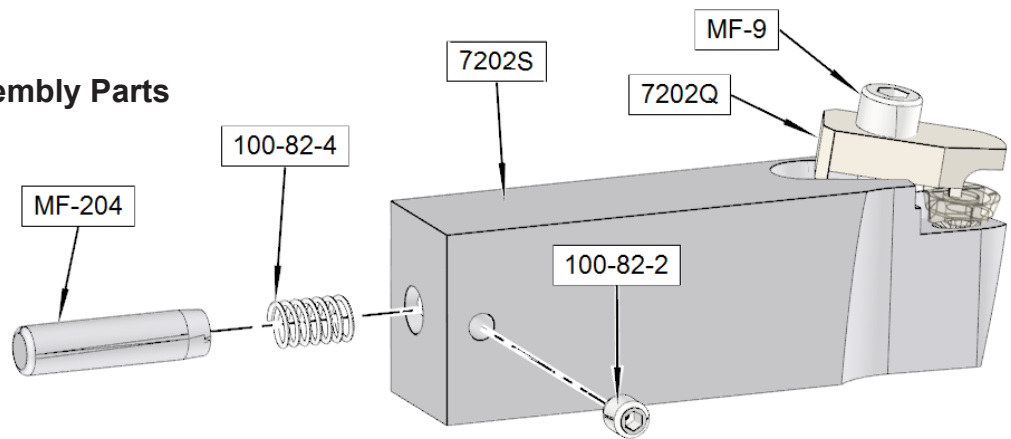
502-1-95 V-Block Handler Assembly Parts



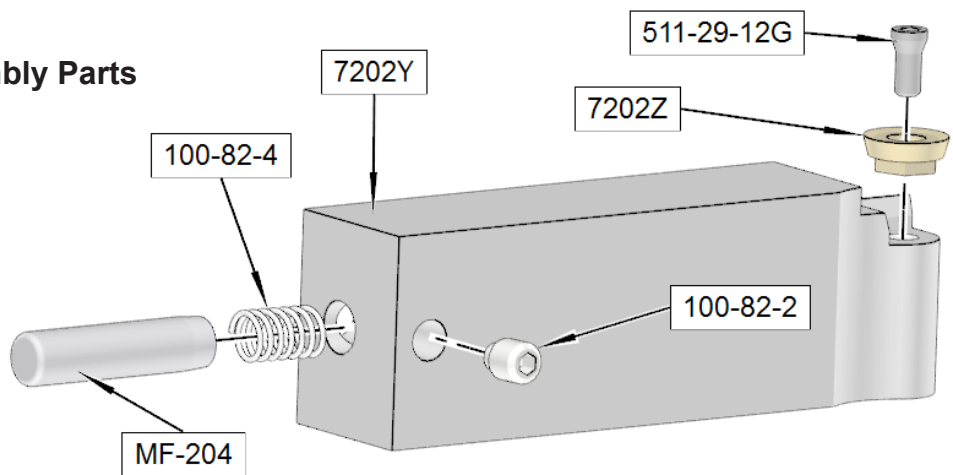
7202V Insert Holder Assembly Parts




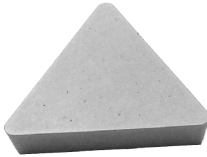
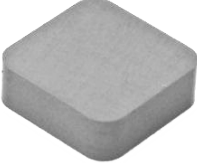







7202U Insert Holder Assembly Parts




7202X Insert Holder Assembly Parts



Cutting Inserts

<p>6514T Inserts For Shell Mills (7225Y, 7224G, and 7224 - Requires 8 Inserts)</p> 	<p>7224B Triangle Inserts For 2-1/2" (63.50mm) Shell Mill 3/8" IC</p> 
<p>6301I Ceramic Composite Insert For cutting precombustion chambers, square negative rake 3/8" IC</p> 	<p>6301V Ceramic Composite Insert For cutting precombustion chambers, round negative rake 3/8" IC</p> 
<p>6303K Coated Carbide Insert 3/8" IC, for aluminum and cast iron</p> 	<p>6303M PCD Round Insert 3/8" IC, for super finishing aluminum (15% Discount on orders of 10 or more)</p> 
<p>6303B CBN Round Insert Double Sided, 3/8" IC, for cast iron (15% Discount on orders of 10 or more)</p> 	<p>6303R CBN Round Insert 3/8" IC, for cast iron heads with steel pre-cups</p> 
<p>6303S CBN Round Insert 3/8" IC, for cutting aluminum heads with steel pre-cups and aluminum blocks with liners</p> 	<p>6301J CBN Square Insert Double Sided, 3/8" IC, 1/16" Radius, for heavy stock removal</p> 

<p>6303Q CBN Round Insert Double Sided, 1/2" IC, for general cast iron surfacing</p> 	<p>6303P PCD Round Insert 1/2" IC, for super finishing aluminum</p> 
<p>6303U CBN Round Insert Single Sided, 3/8" IC. For hard cast iron</p> 	<p>6303V CBN Insert Octagonal (16-Cutting Corners) for surfacing large diesel blocks</p> 
<p>RS322 Insert Square negative rake, 1/32" radius for roughing</p> 	<p>7202Z Round Insert 3/8" gold coated for aluminum cylinder head precup cutting, also for soft cast iron precups like Landrover. Use with 7202X tool holder only.</p> 