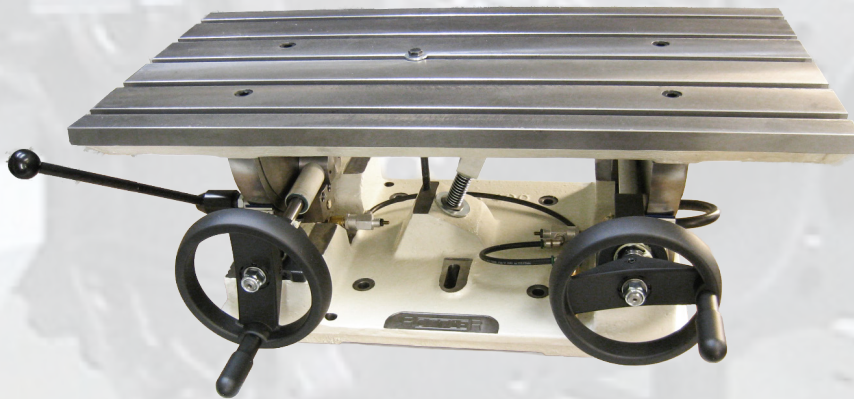


ROTTLER

SM SERIES OPTIONAL EQUIPMENT PARTS MANUAL



8029 S 200th St, Kent, WA 98032 USA | Ph: 253-872-7050 | Fax: 253-395-0230 www.rottlermfg.com

21.02.2017

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

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

S7M /S8M OPTIONAL EQUIPMENT PARTS MANUAL

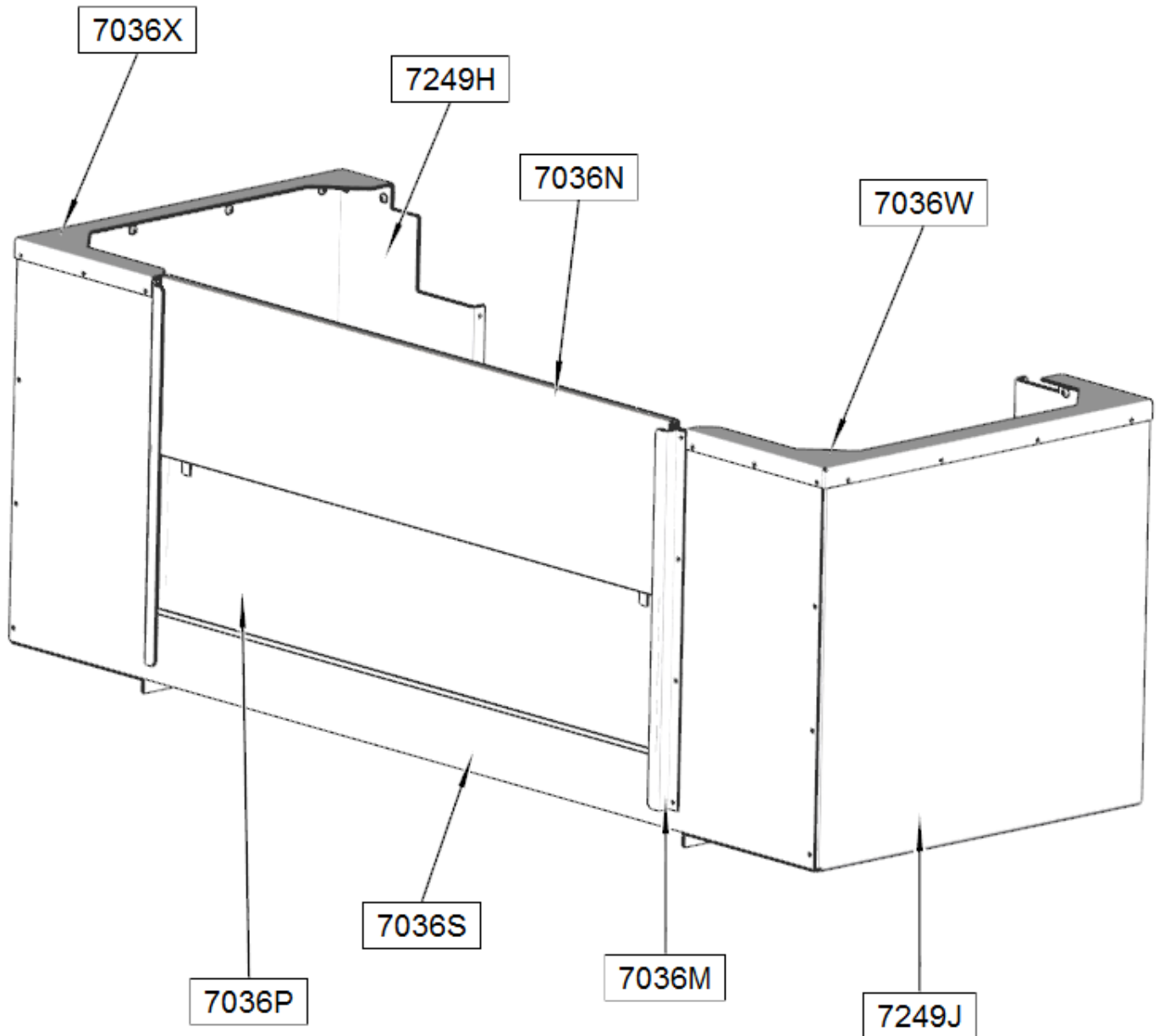
Contents

Safety Equipment	1
7036Y Full Steel Enclosure with Folding Door Parts	1
Digital Display of Vertical Position of Spindle	2
7246M Digital Readout Display Parts	2
Fixtures and Parallels	3
7209M Leveling Table Parts.....	3
Table Assembly Parts.....	4
Tensioner Assembly Parts.....	4
Front / Rear Tilt Assembly Parts	5
Left / Right Tilt Assembly Parts.....	6
Tilt Clamp Assembly Parts	7
Base Assembly Parts	8
7152A Dual Axis Level Assembly Parts.....	9
Fixed Angle Fixtures for Blocks	10
502-1-72F V Block Fixture Parts.....	10
502-3-48Q In-line Block Frame Parts	13
502-3-49 V Block Fixture Parts	14
502-3-52 Cadillac Catera V Block Fixture Parts.....	15
502-3-23 Marine Outboard Fixture Parts	16
502-3-23C Marine Outboard Fixture Parts.....	17
Adjustable Angle Fixtures for Blocks	18
650-3-1 Performance Fixture Assembly Parts	18
7241 Universal Block Fixture Parts.....	19
7243 Mid-size Diesel Block Fixture Parts	21
Accessories for Fixtures	23
502-1-95 Block Handler Parts	23
502-1-46T Precision 2" (50.8mm) Locator Bar	24
550-5-10 (1) pair of Main bearing bushings for Detroit 8.2 liter diesel	24
7242M Clamp Tower Assembly Parts	25
Parallels	25
11115 2" (50mm) X 3" (75mm) Parallels.....	25

11112 Universal 8" (203mm) Heavy Duty T-Slot Parallels Parts	26
11114 Universal 16" (405mm) Heavy Duty T-Slot Parallels Parts	28
7219W 5.2" (132mm) Heavy Duty T-Slot Universal Parallels Parts	30
Optional Tooling	31
7225F 10" (254mm) Multi-tooth Face Mill Assembly Parts	31
7224 Shell Mill Assembly Parts	32
7225Y Shell Mill Assembly Parts	33
7224G Shell Mill Assembly Parts	34
7038Y Flatness Probe Dial Indicator for Level Assembly	35
7209N 2-Piece Vise Parts	35
7226G Exhaust/Intake Manifold Surfacing Fixture Parts	36
650-3-38 Machinist Level for Intake and Exhaust Manifolds	37
201 Mitutoyo Surface Tester	37
7202V Holder Assembly Parts	38
7202U Holder Assembly Parts	38
7202X Tool Holder Assembly Parts	38
Cutting Inserts	39
6514T Inserts	39
7224B Triangle Inserts	39
6301I Ceramic Composite Insert	39
6301V Ceramic Composite Insert	39
6303K Coated Carbide Insert	39
6303M PCD Round Insert	39
6303B CBN Round Insert	39
6303R CBN Round Insert	39
6303S CBN Round Insert	39
6301J CBN Square Insert	39
6303Q CBN Round Insert	40
6303P PCD Round Insert	40
6303U CBN Round Insert	40
6303V CBN Insert	40
RS322 Insert	40
7202Z Round Insert	40
Transformer	40
650-5-25 Buck-Boost Transformer	40

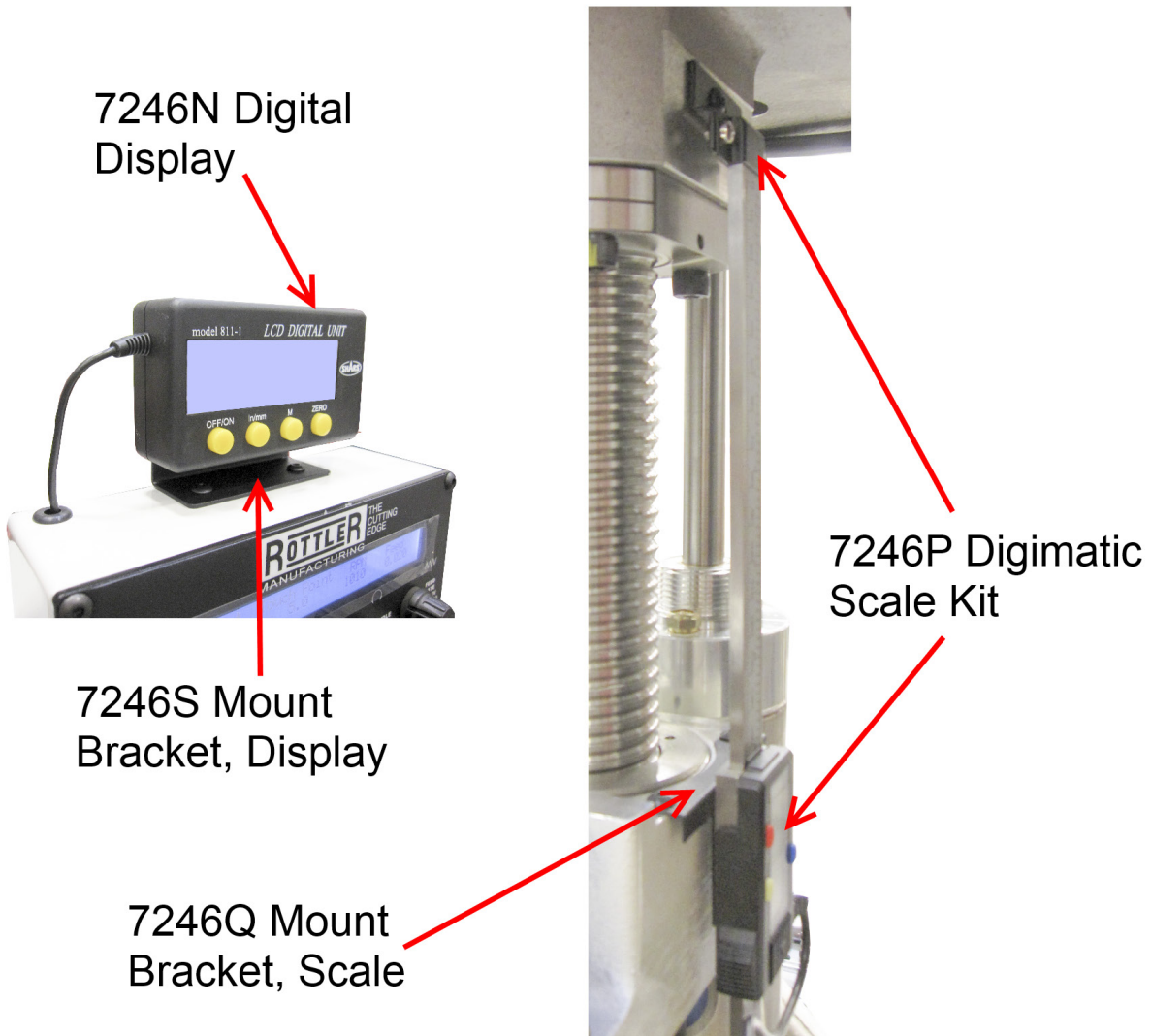
Safety Equipment

7036Y Full Steel Enclosure with Folding Door Parts



Digital Display of Vertical Position of Spindle

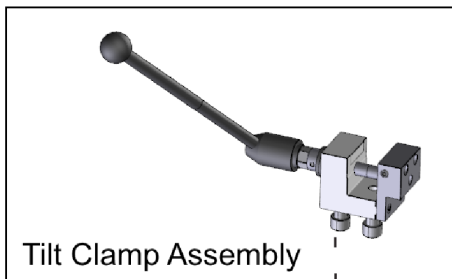
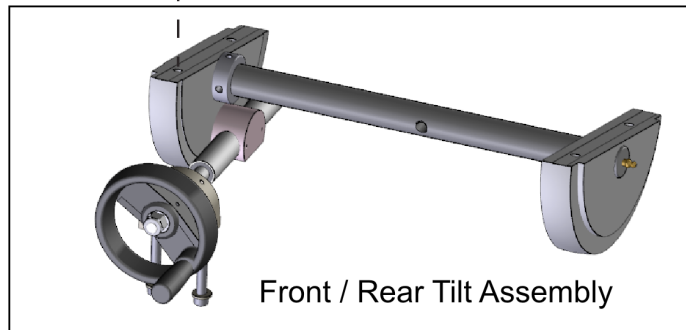
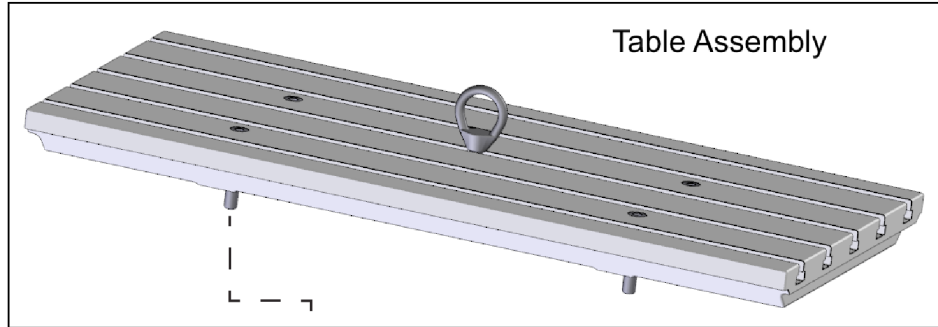
7246M Digital Readout Display Parts



Fixtures and Parallels

7209M Leveling Table Parts

7209M Leveling Table Sections



Tensioner Assembly

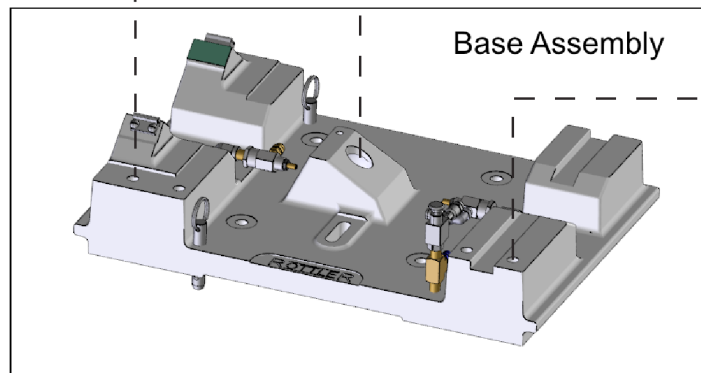
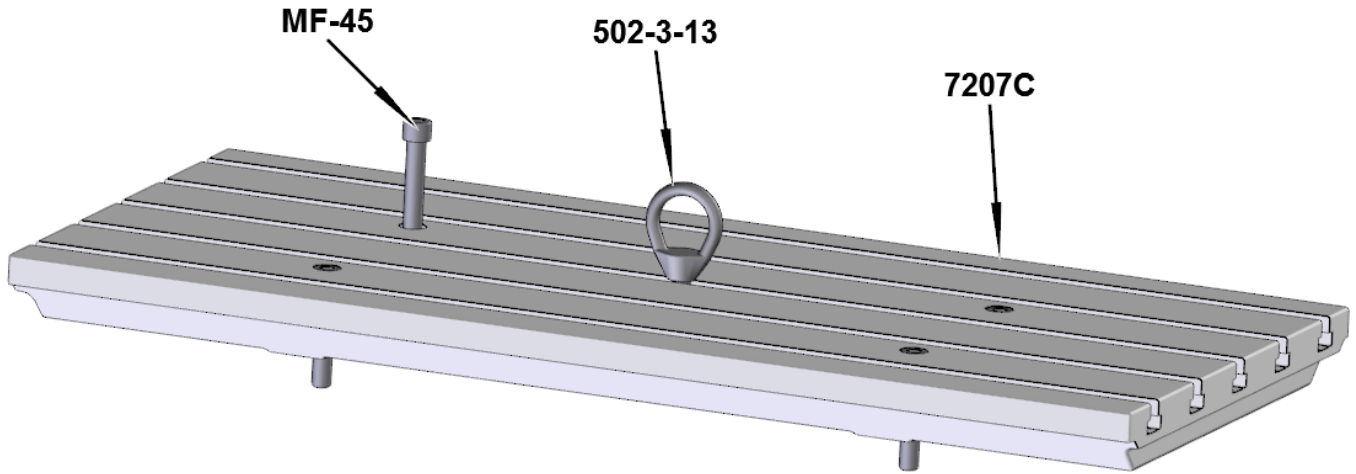
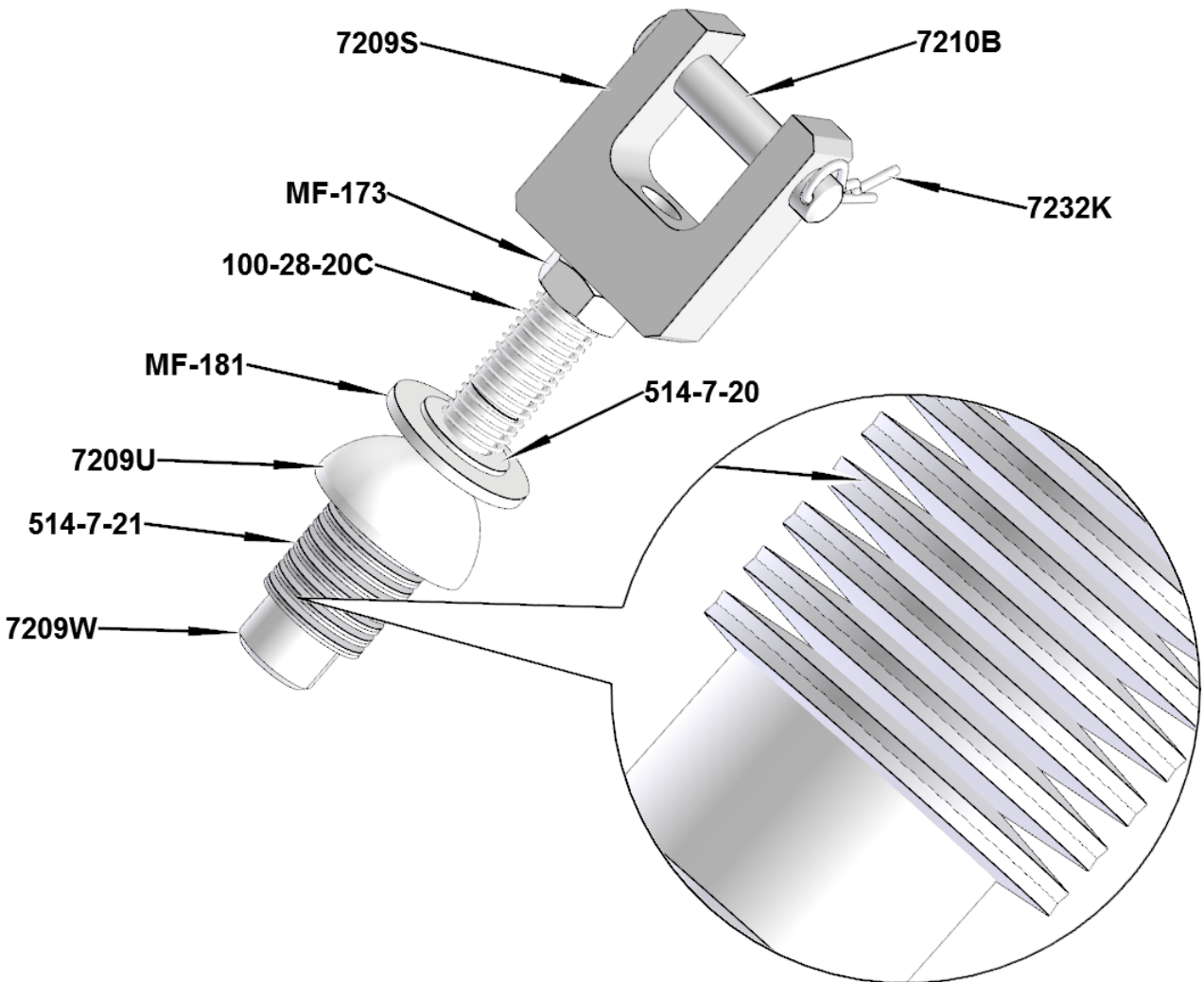


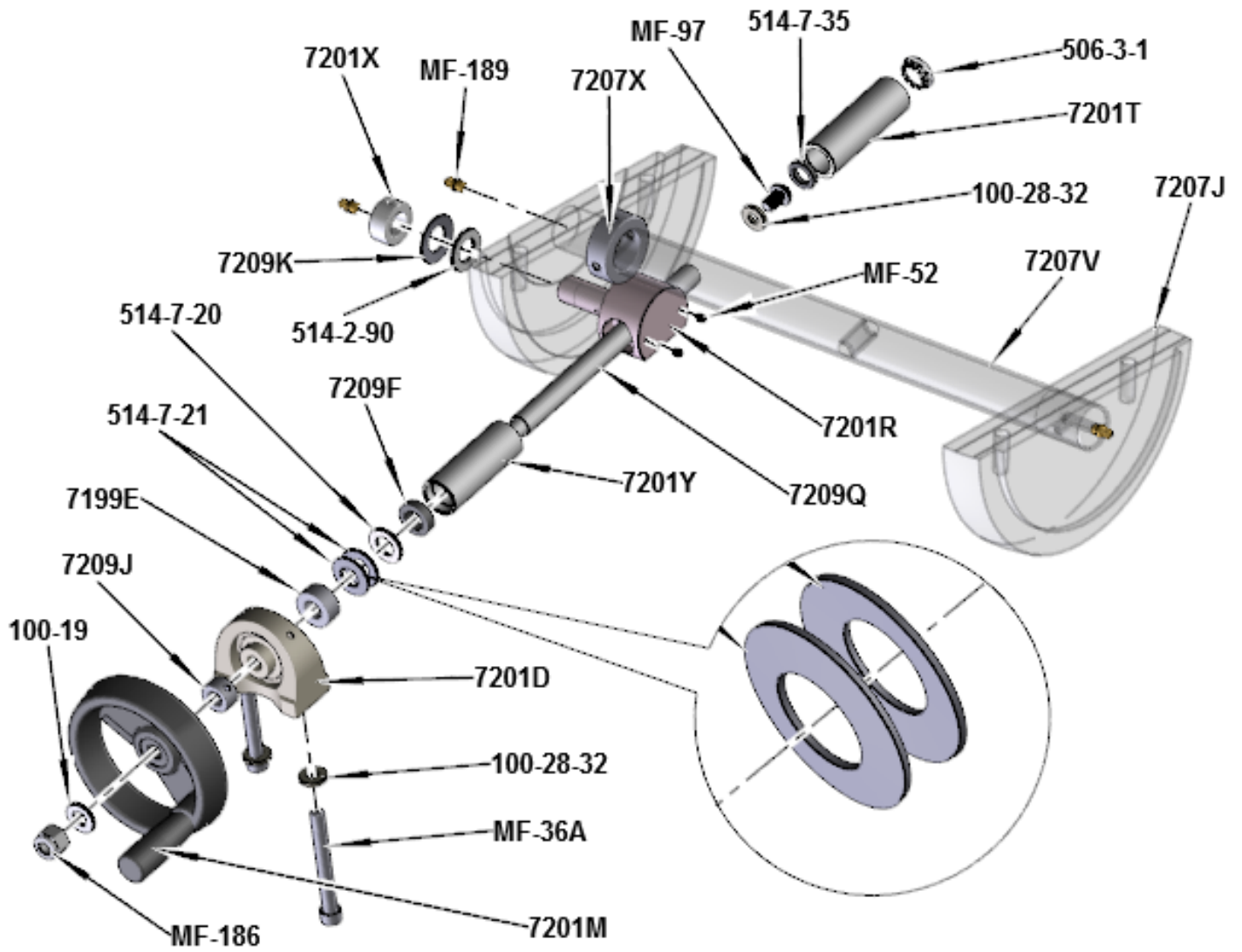
Table Assembly Parts



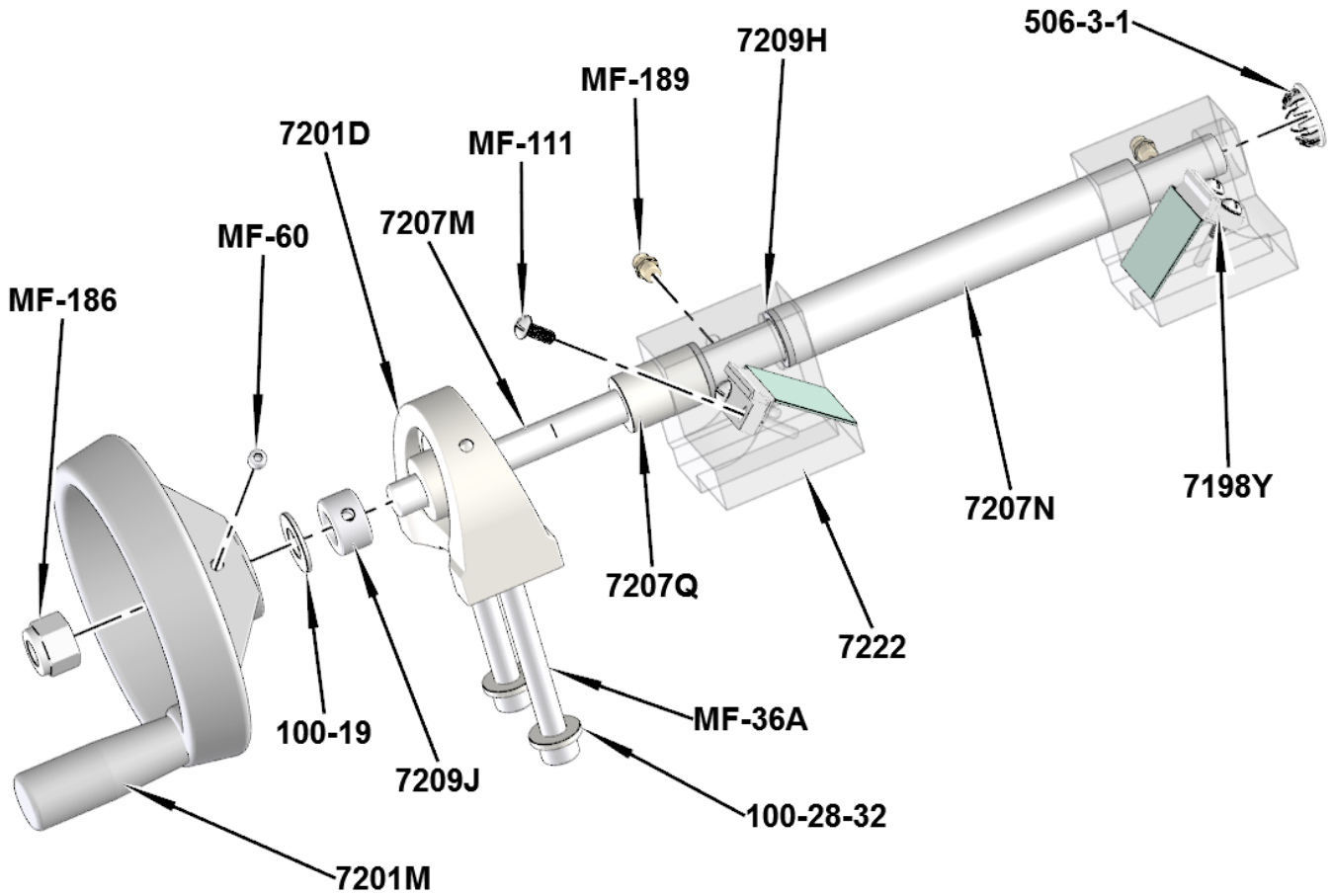
Tensioner Assembly Parts



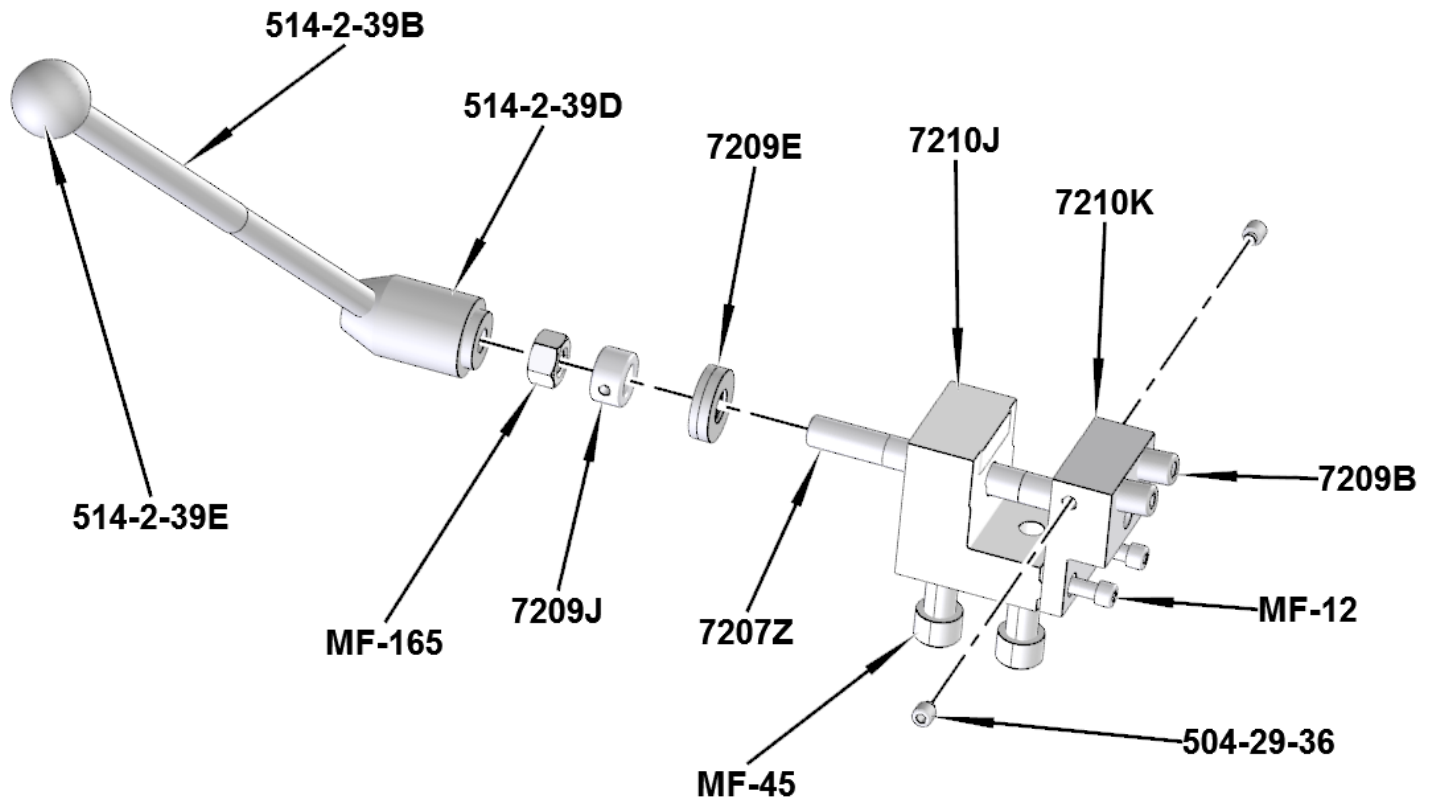
Front / Rear Tilt Assembly Parts



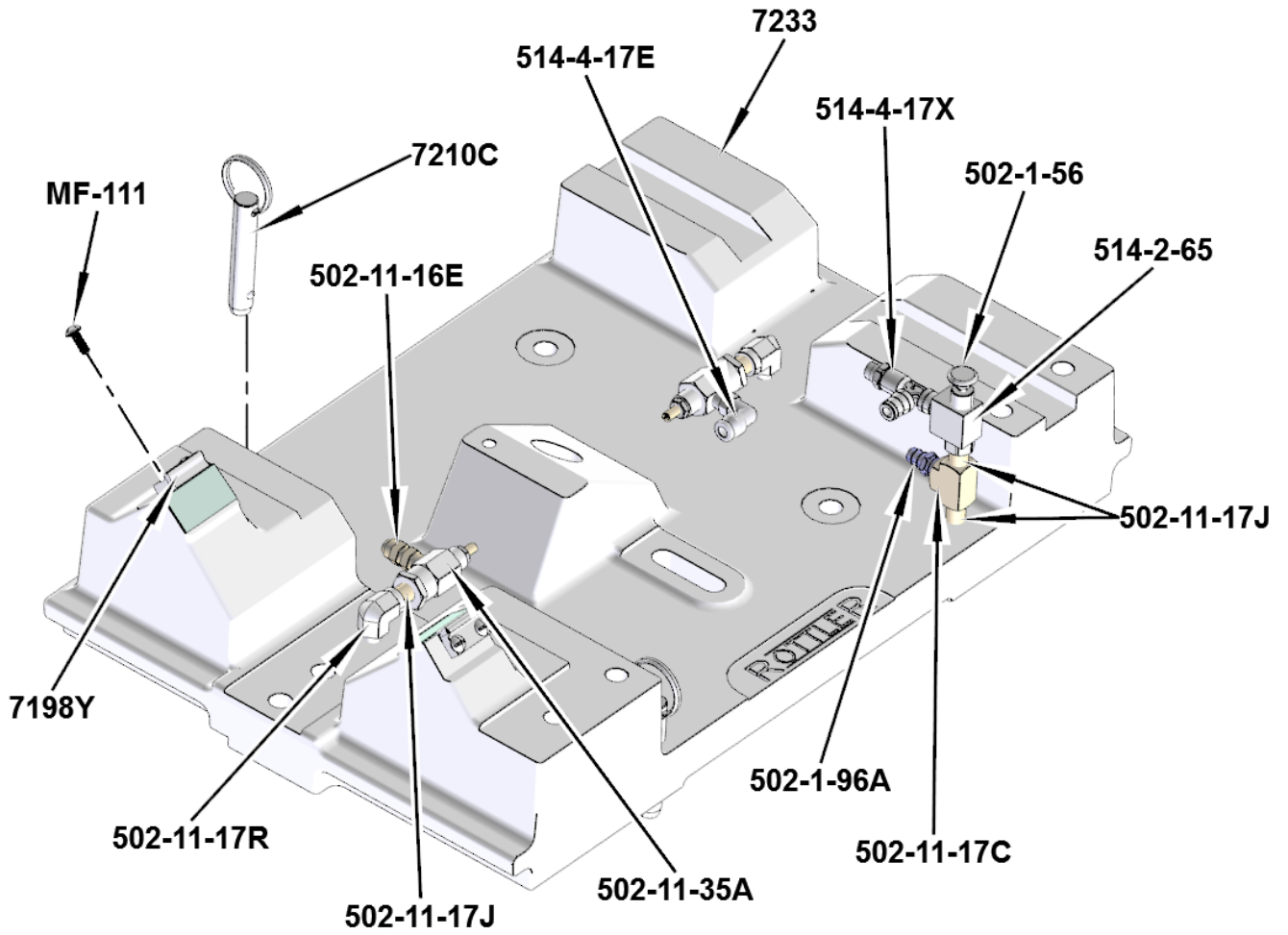
Left / Right Tilt Assembly Parts



Tilt Clamp Assembly Parts

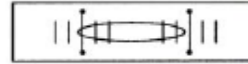


Base Assembly Parts

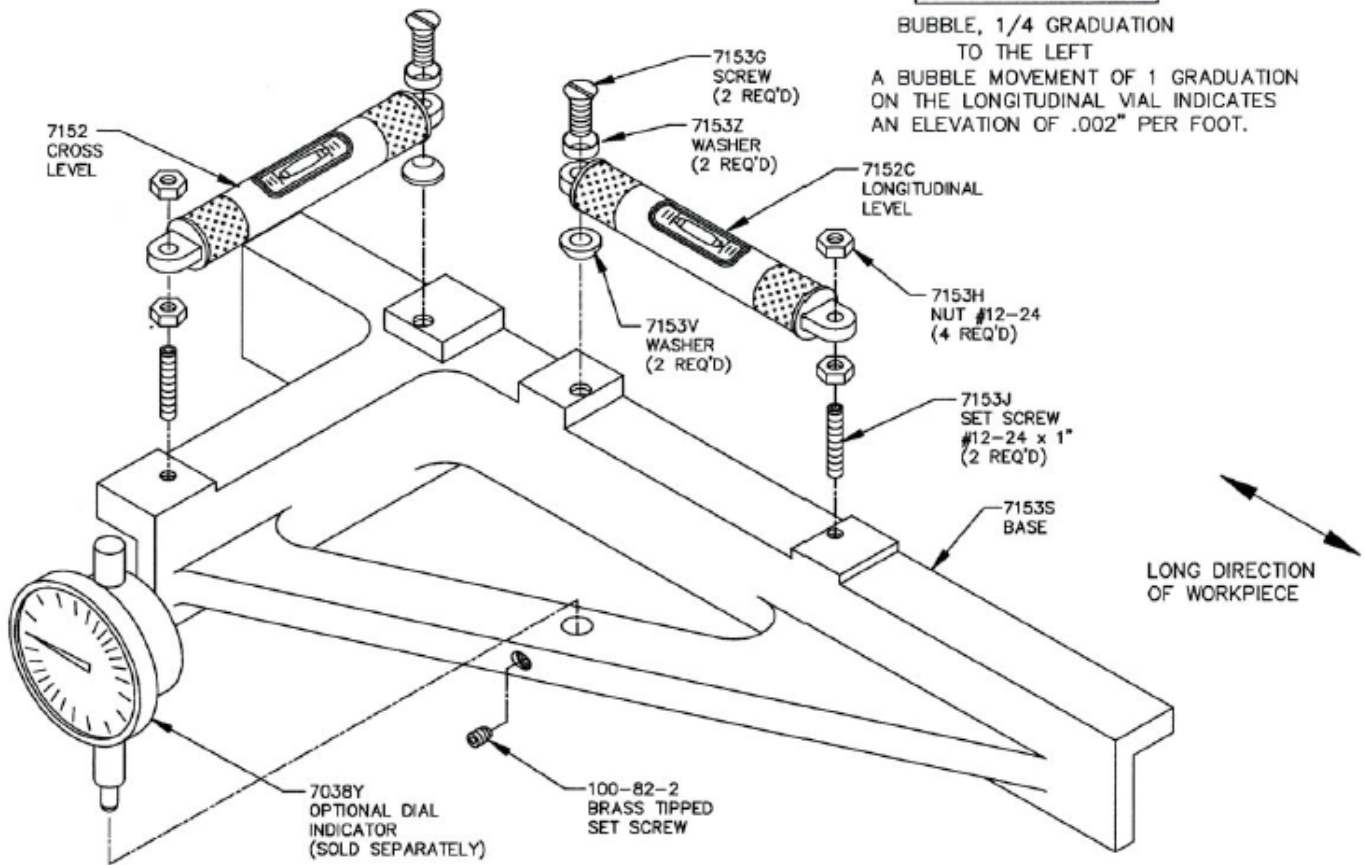


7152A Dual Axis Level Assembly Parts

ILLUSTRATION Ⓐ



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

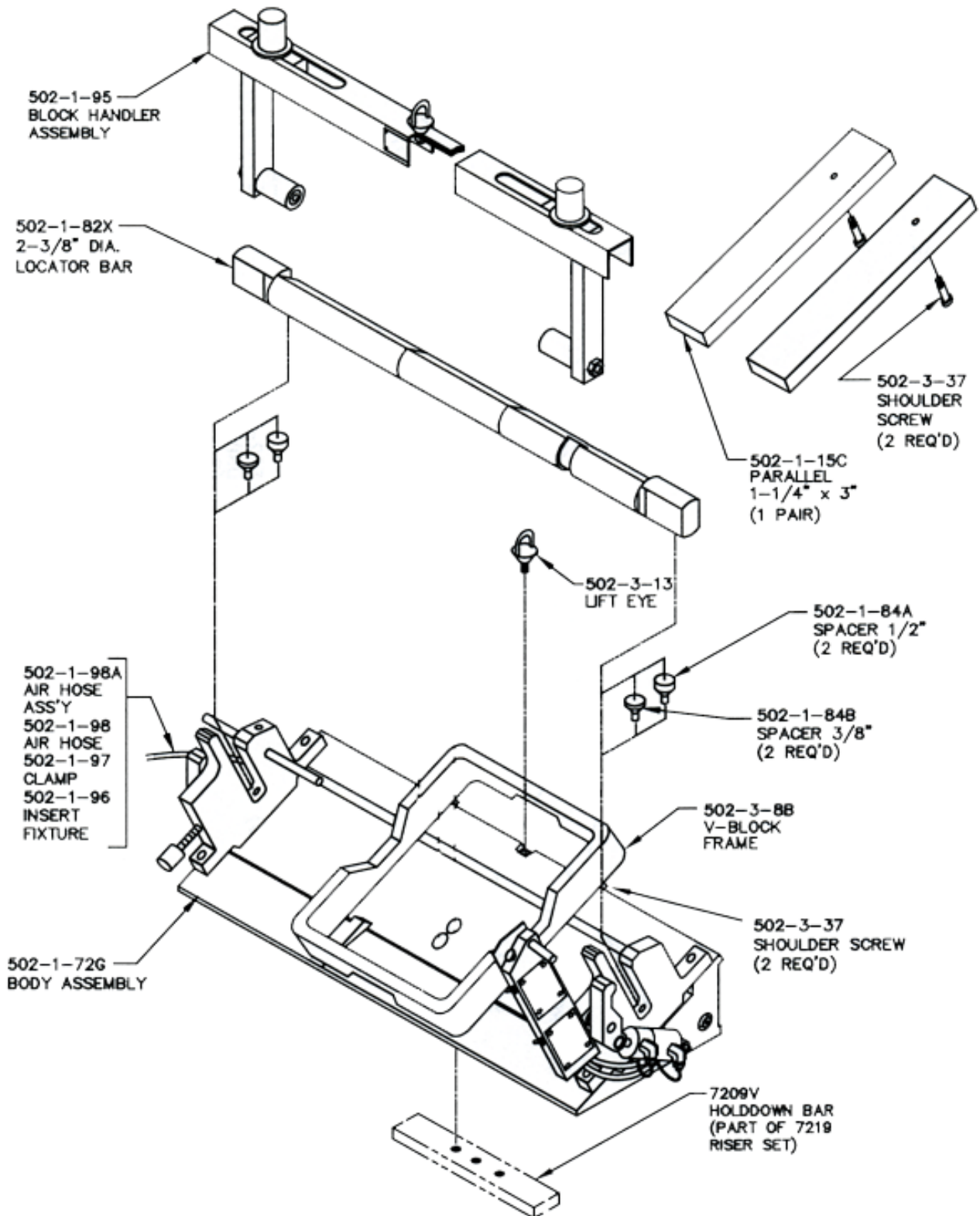


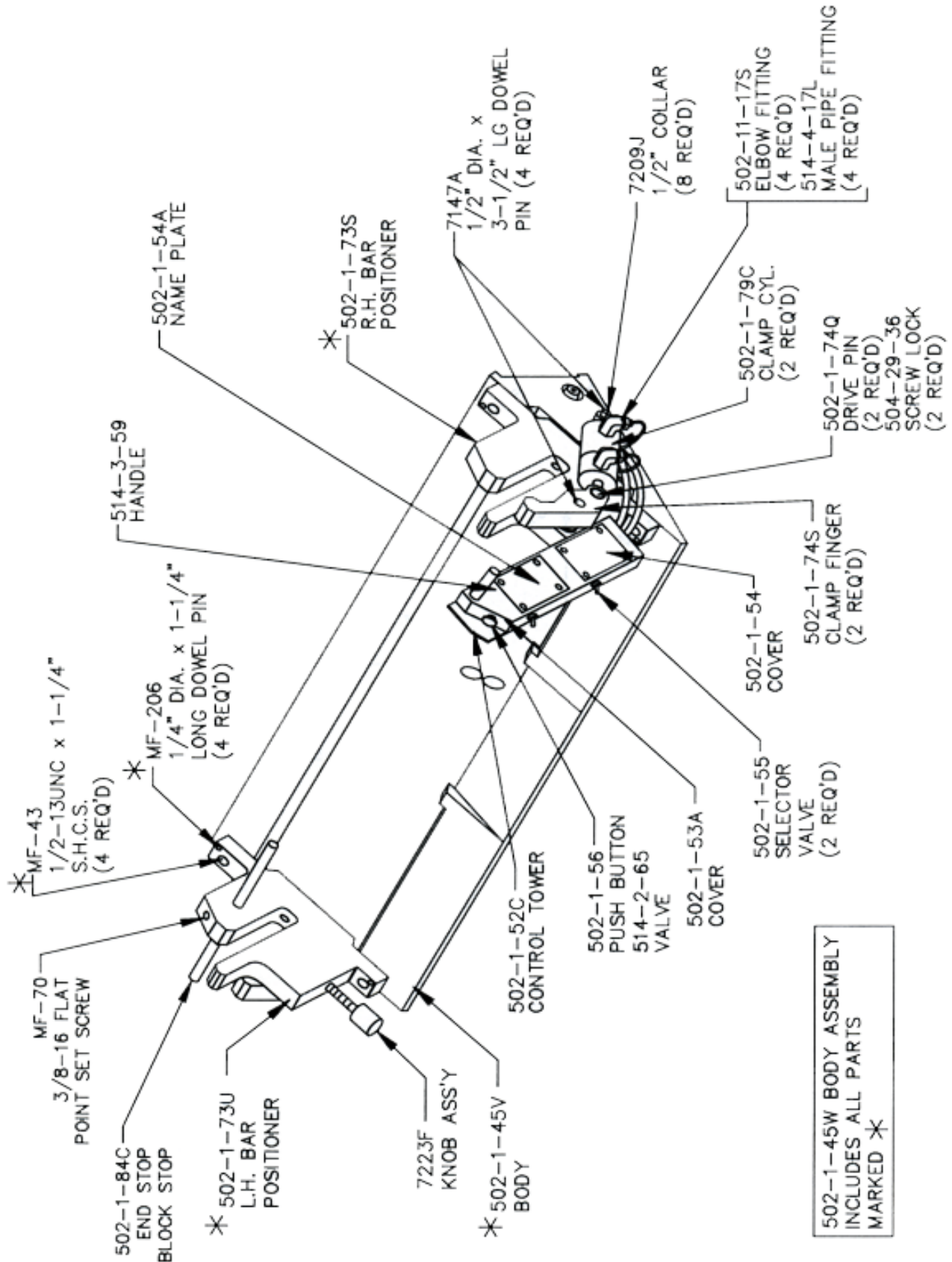
7152A - OPTIONAL DUAL
AXIS LEVEL ASSEMBLY

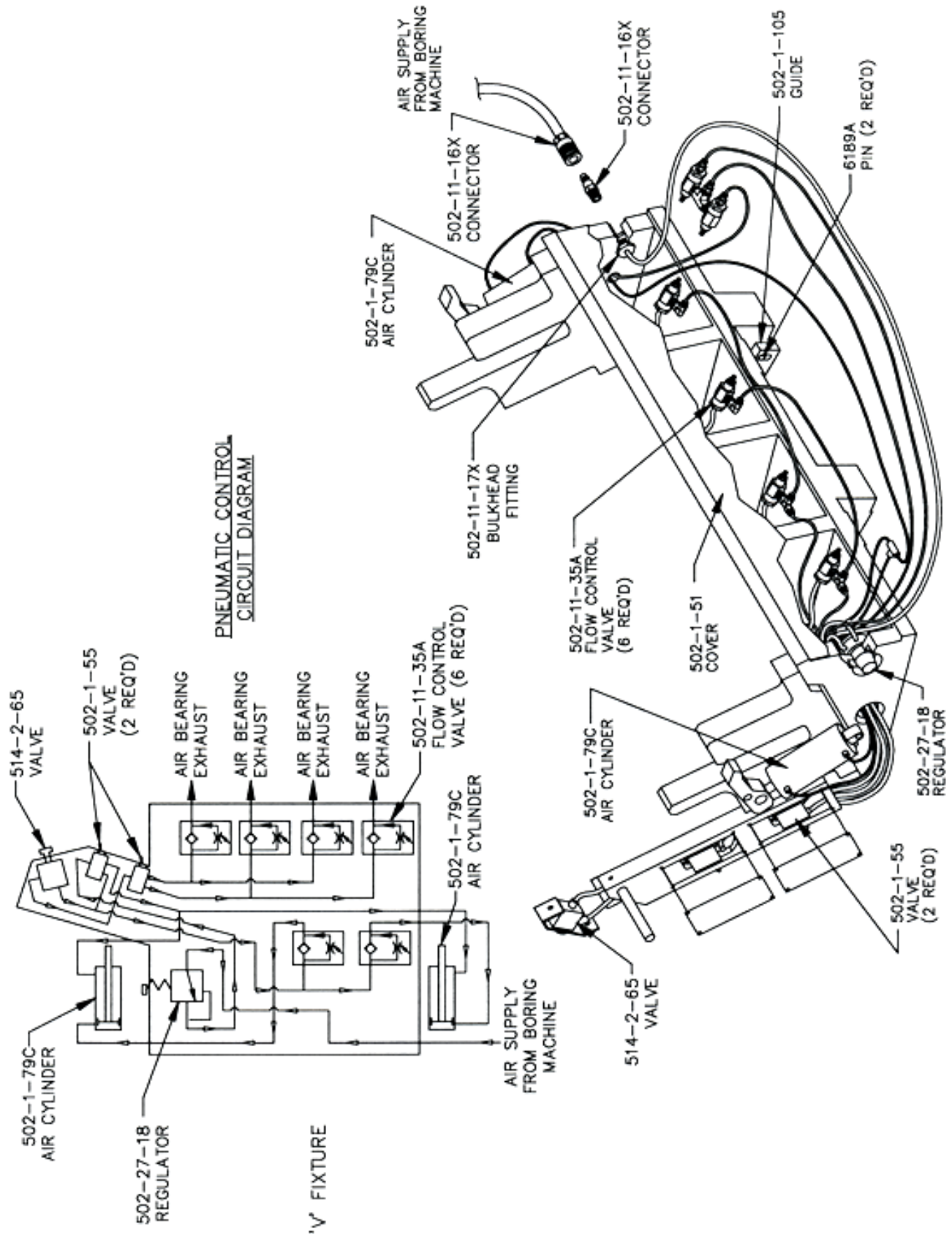
NOTE: 7152A ASSEMBLY DOES NOT INCLUDE 7038Y DIAL INDICATOR

Fixed Angle Fixtures for Blocks

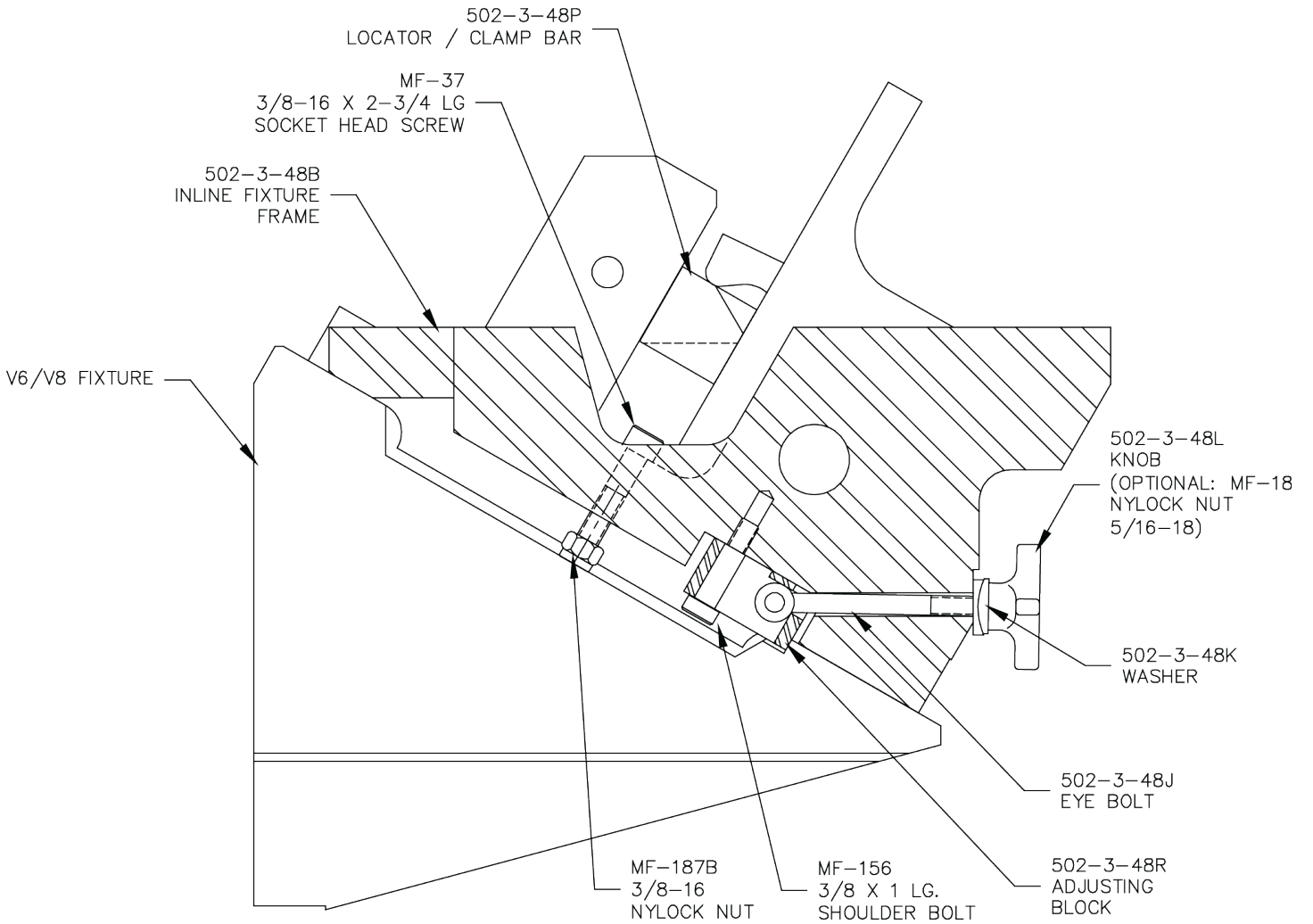
502-1-72F V Block Fixture Parts



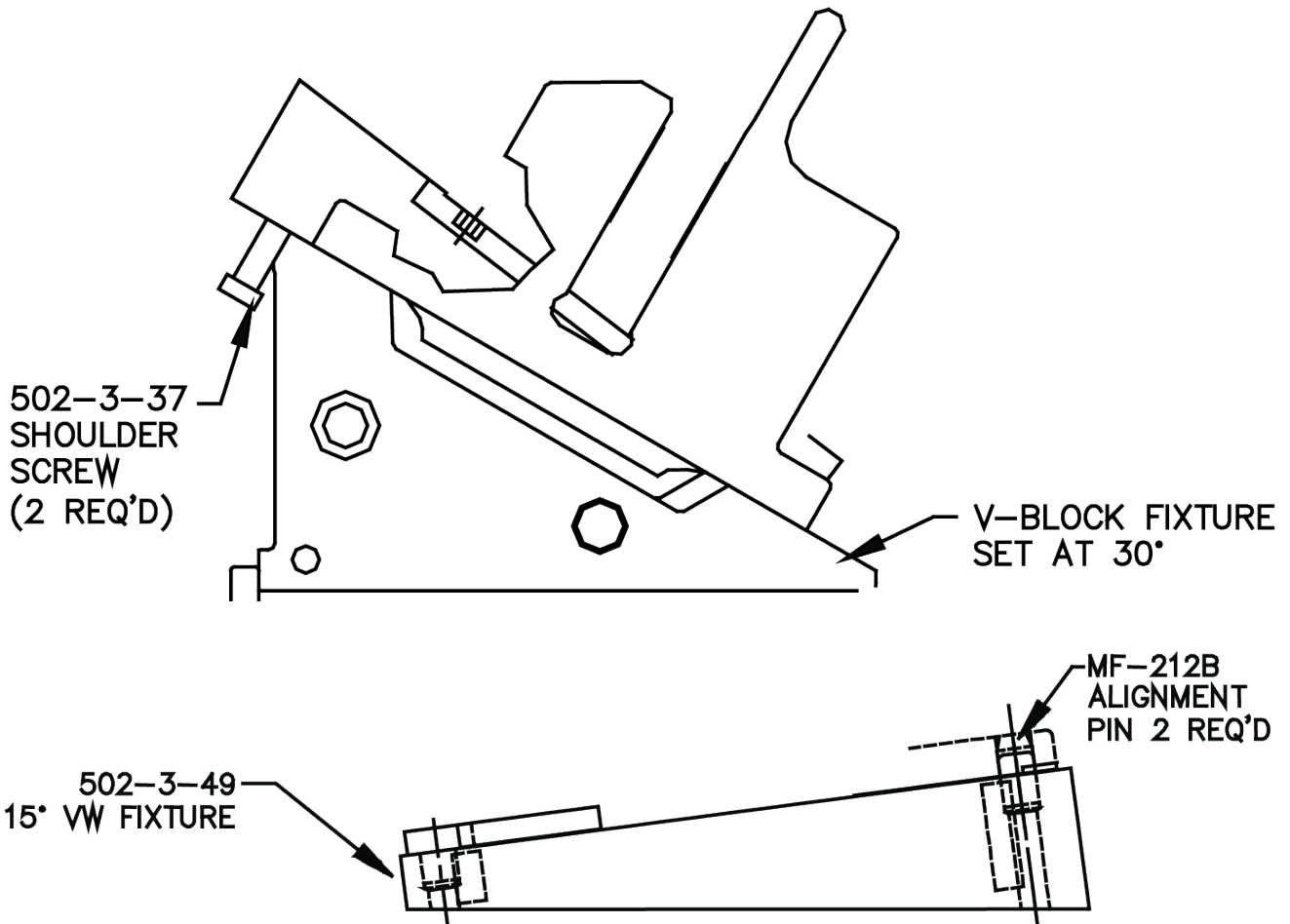




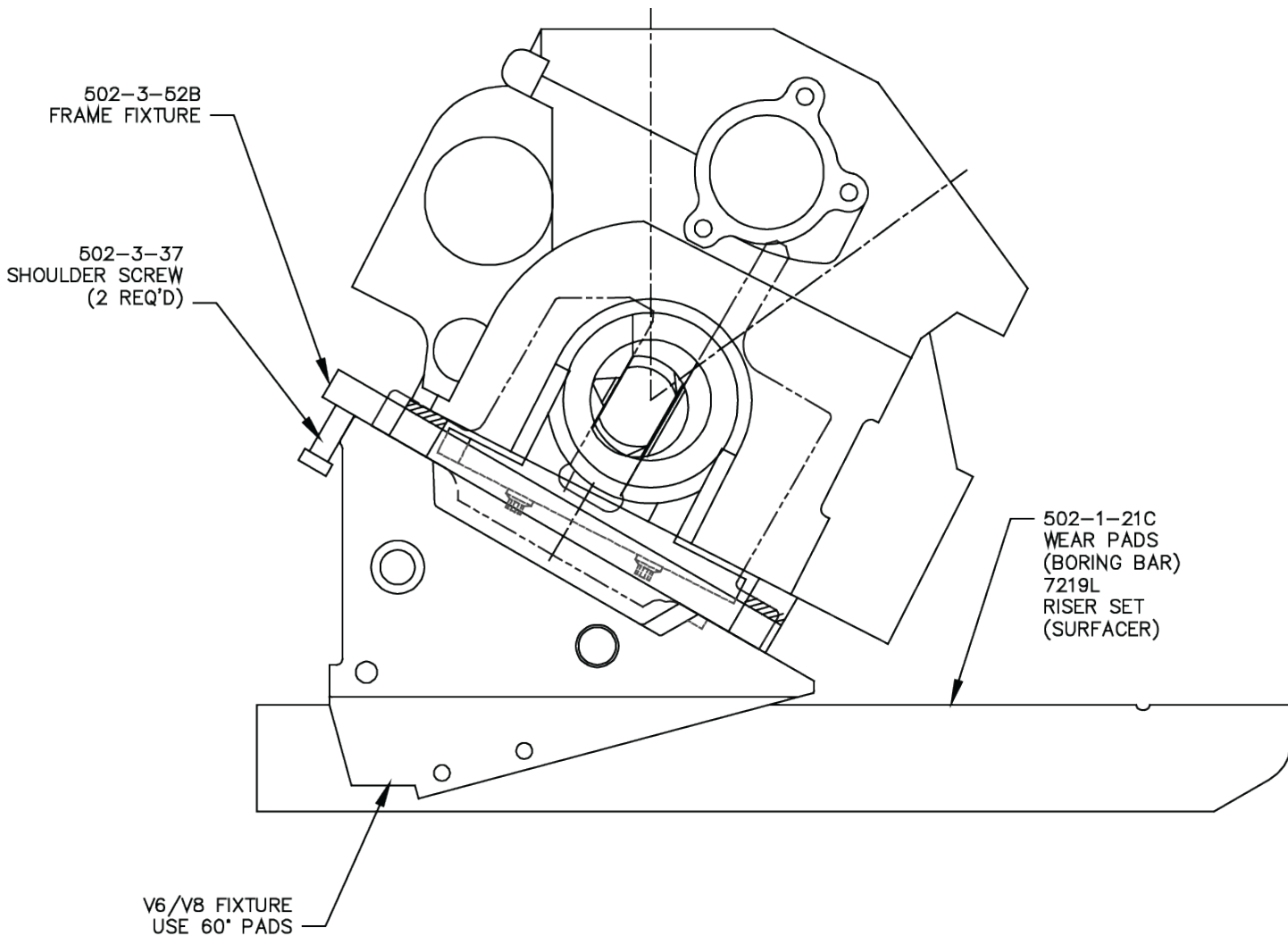
502-3-48Q In-line Block Frame Parts



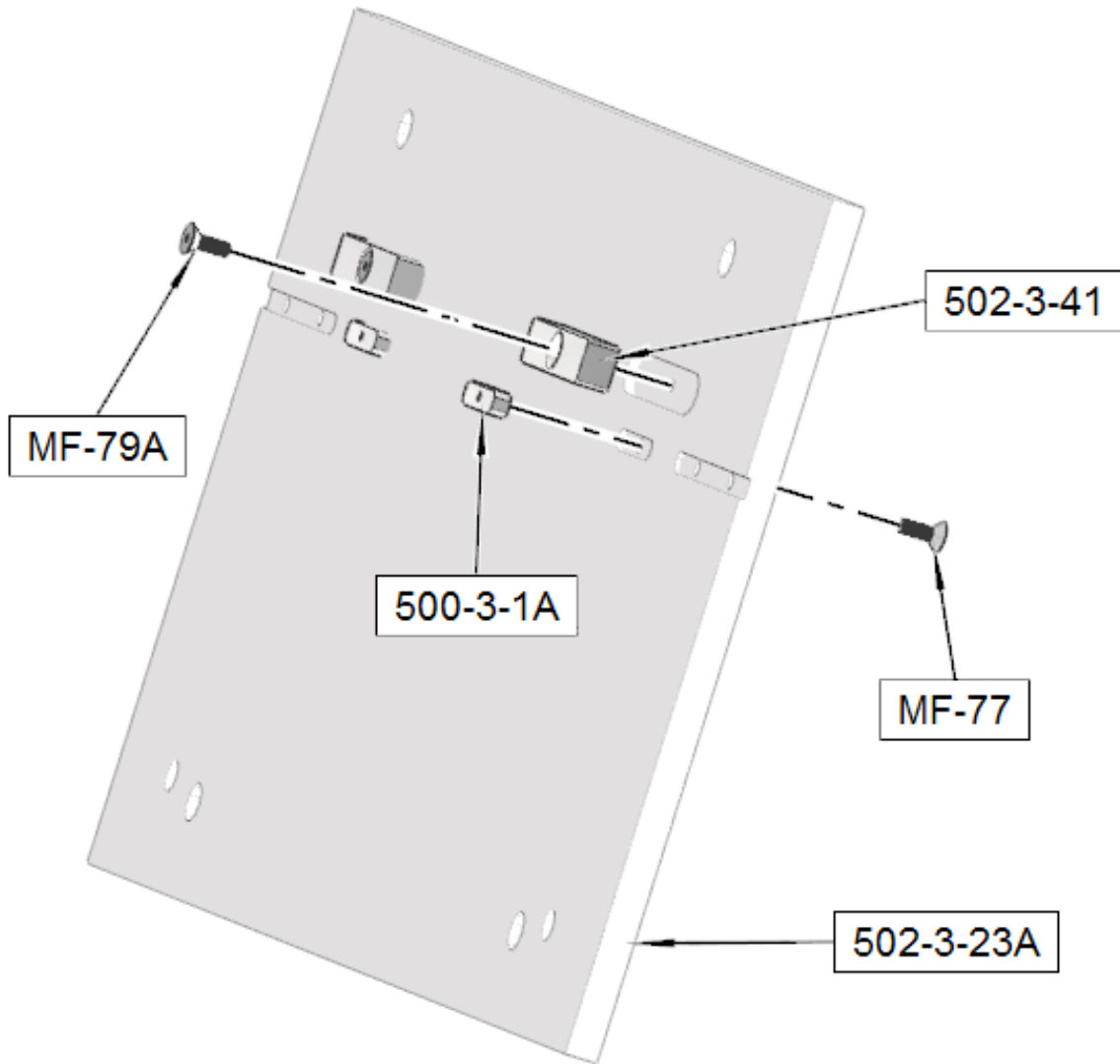
502-3-49 V Block Fixture Parts



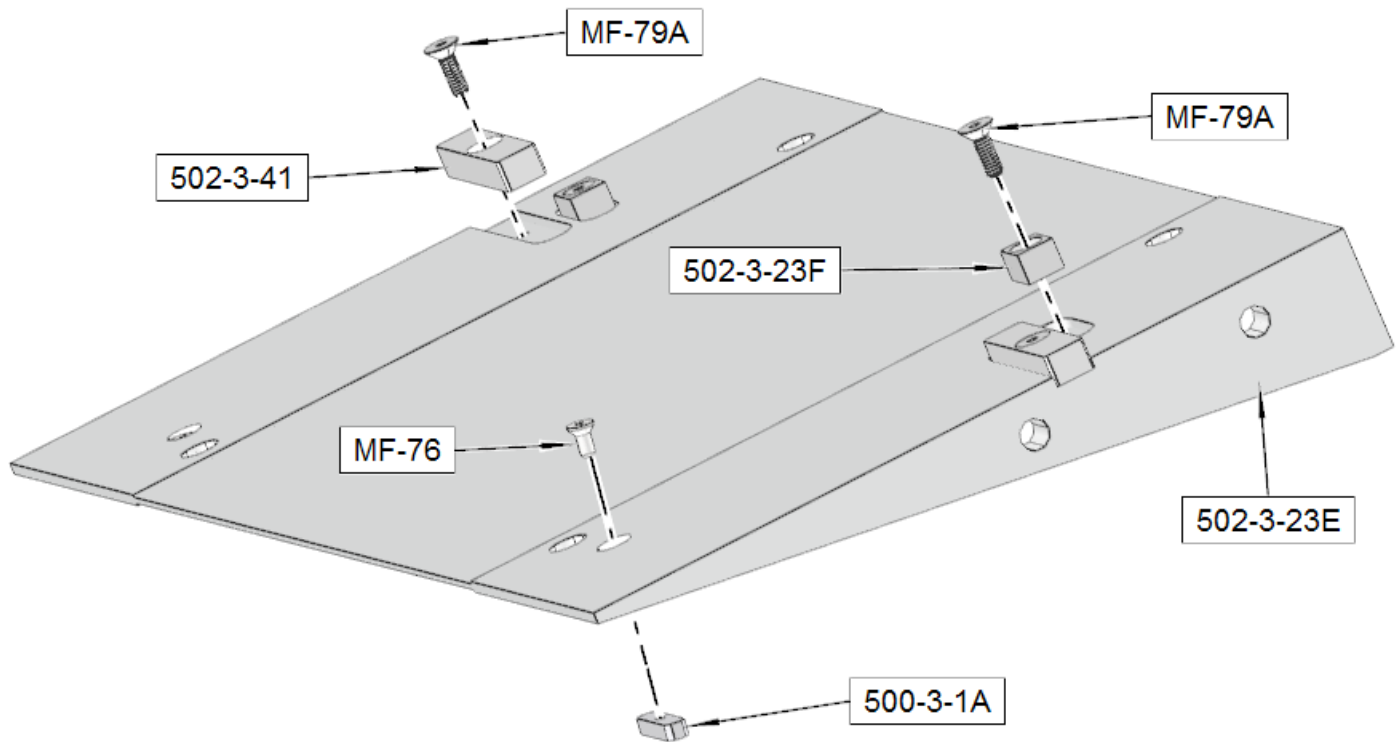
502-3-52 Cadillac Catera V Block Fixture Parts



502-3-23 Marine Outboard Fixture Parts

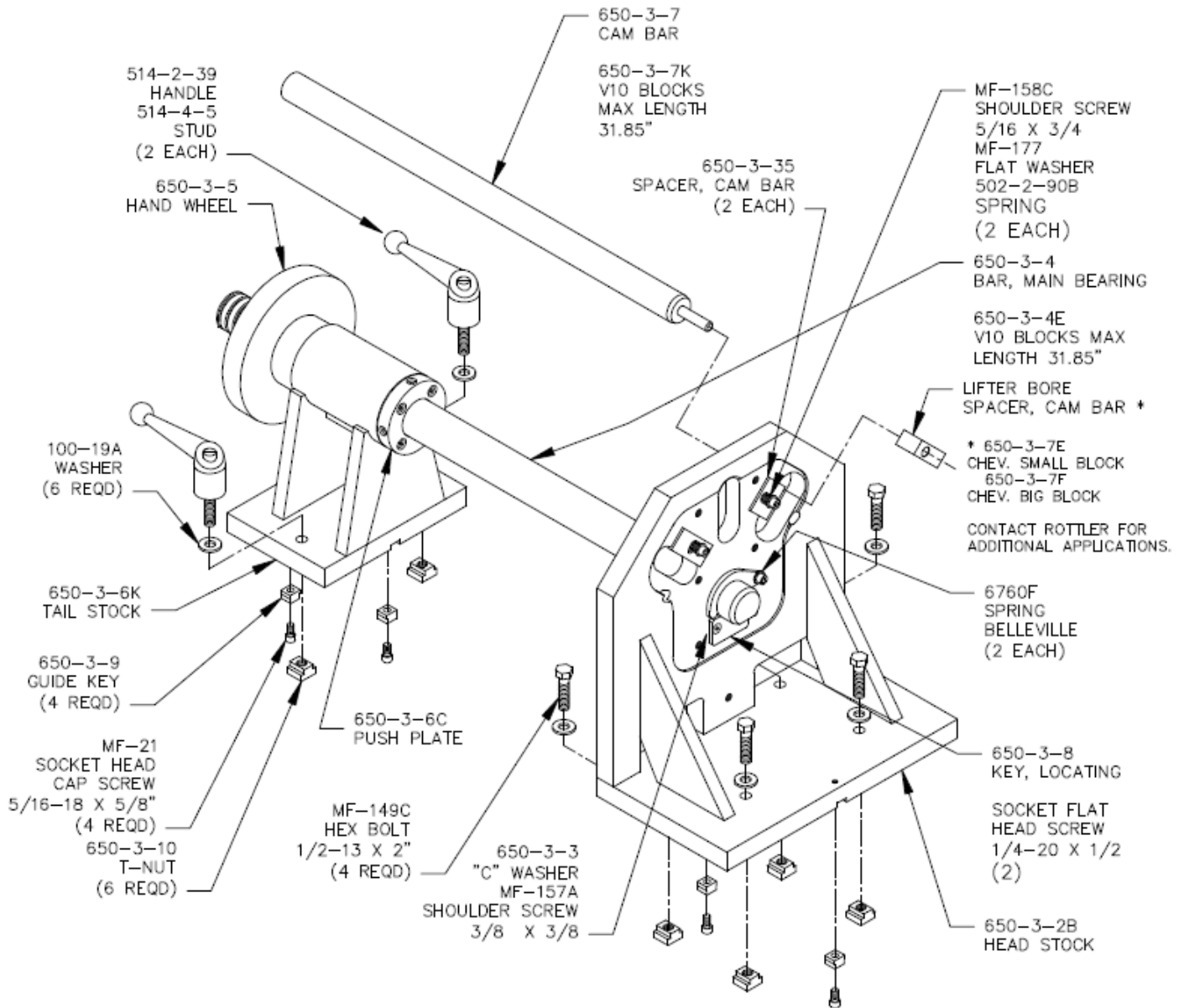


502-3-23C Marine Outboard Fixture Parts

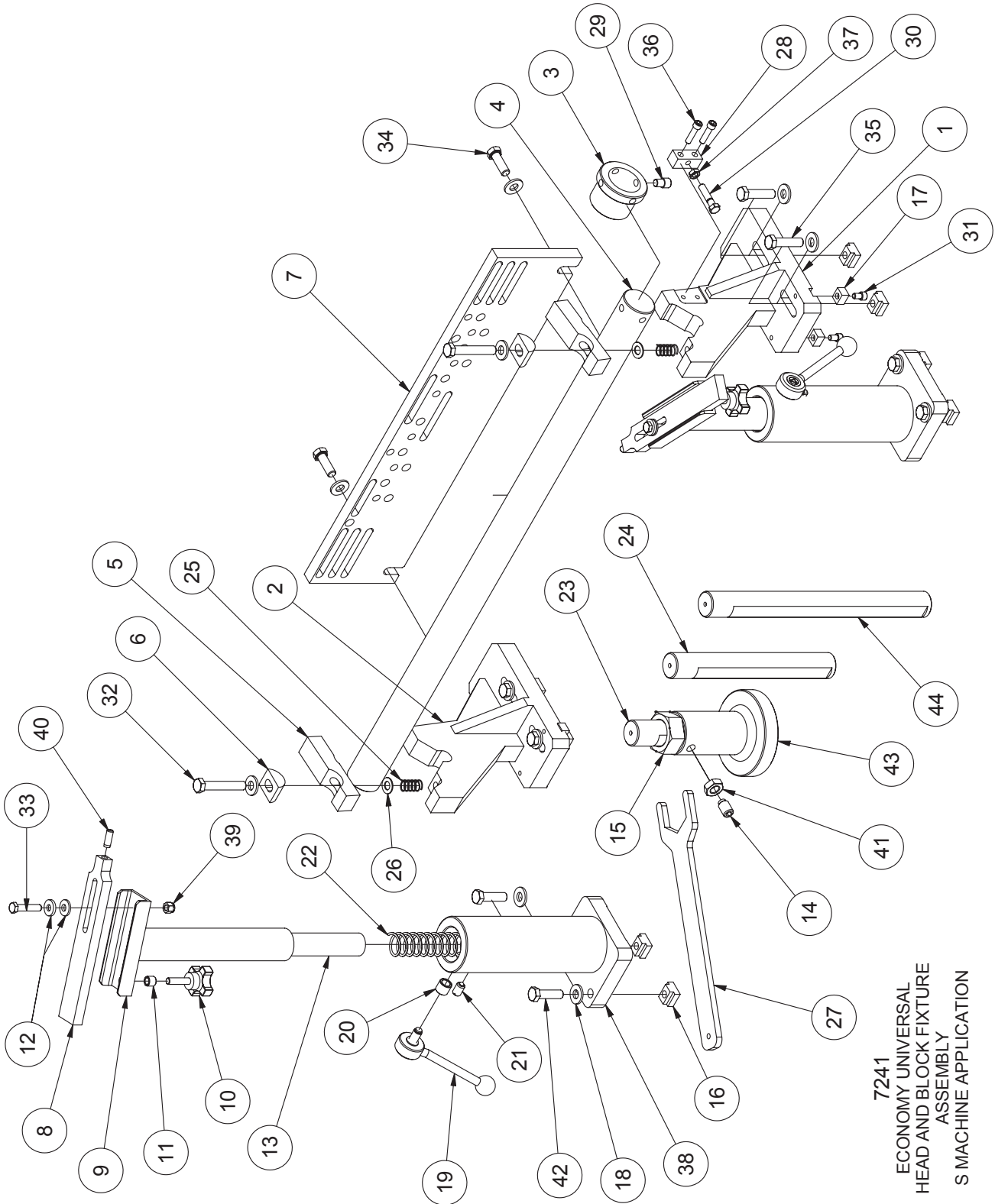


Adjustable Angle Fixtures for Blocks

650-3-1 Performance Fixture Assembly Parts

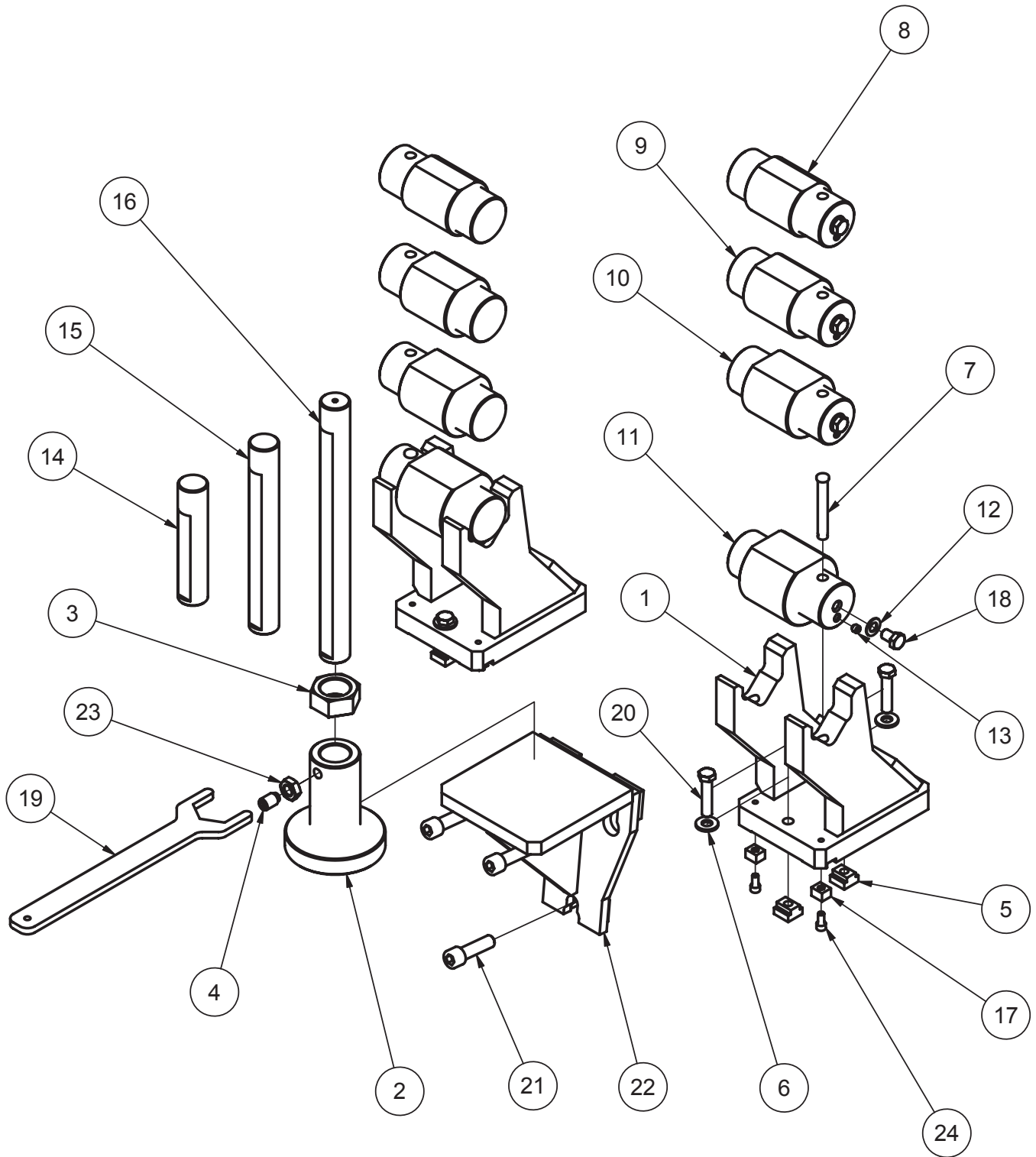


7241 Universal Block Fixture Parts



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.

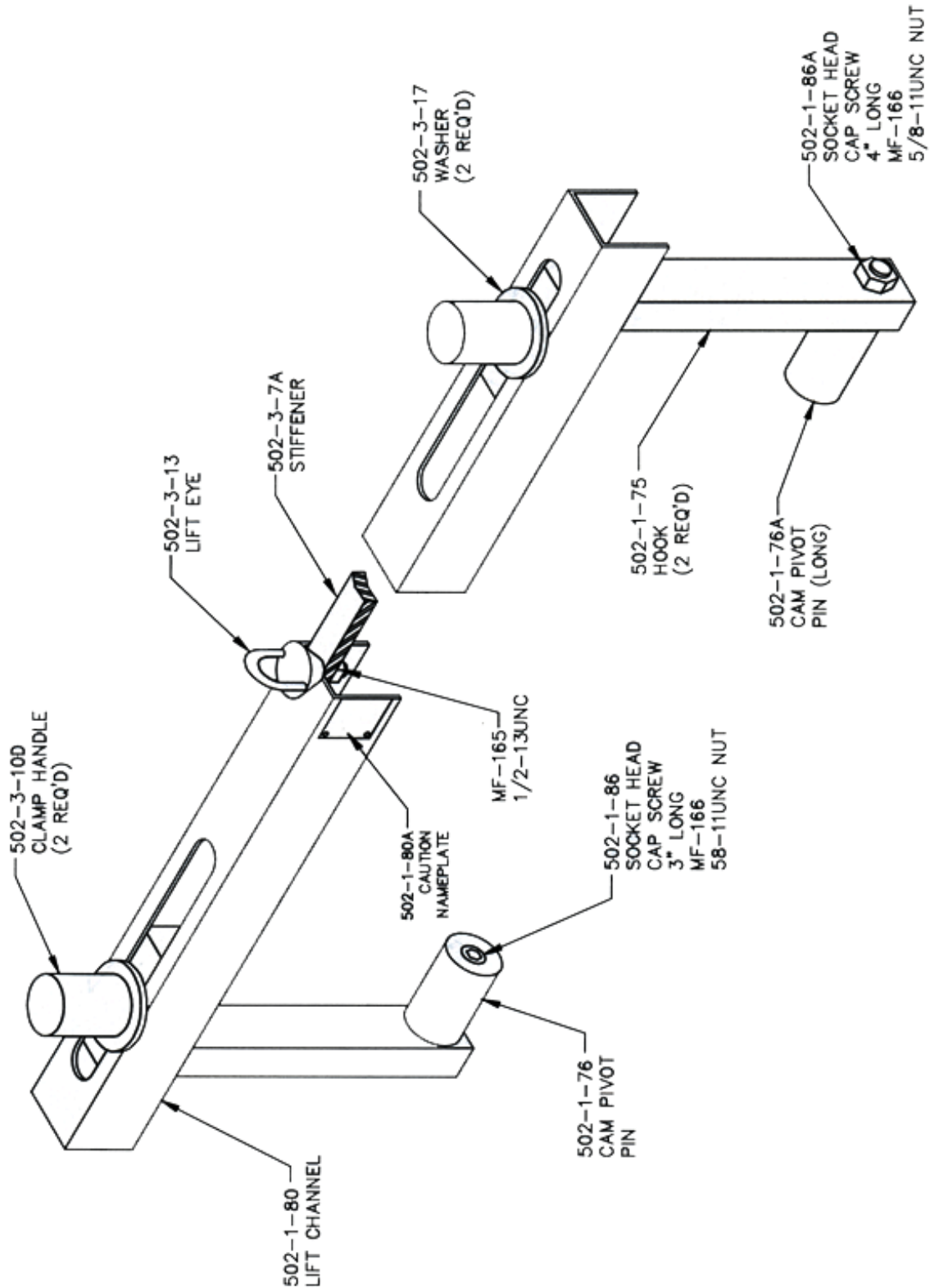
7243 Mid-size Diesel Block Fixture Parts



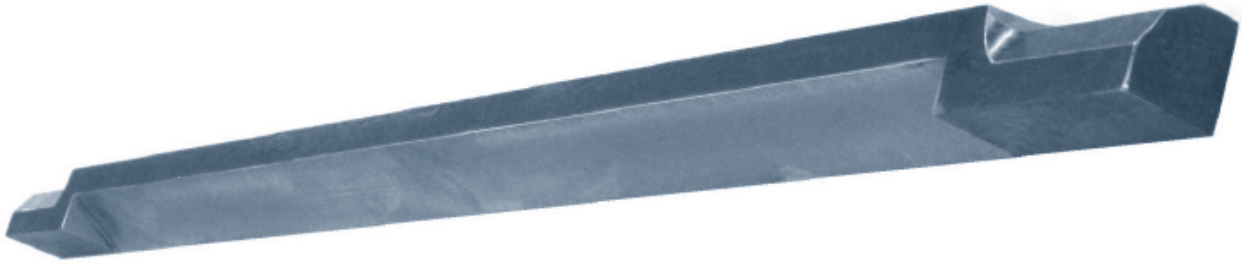
7243

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



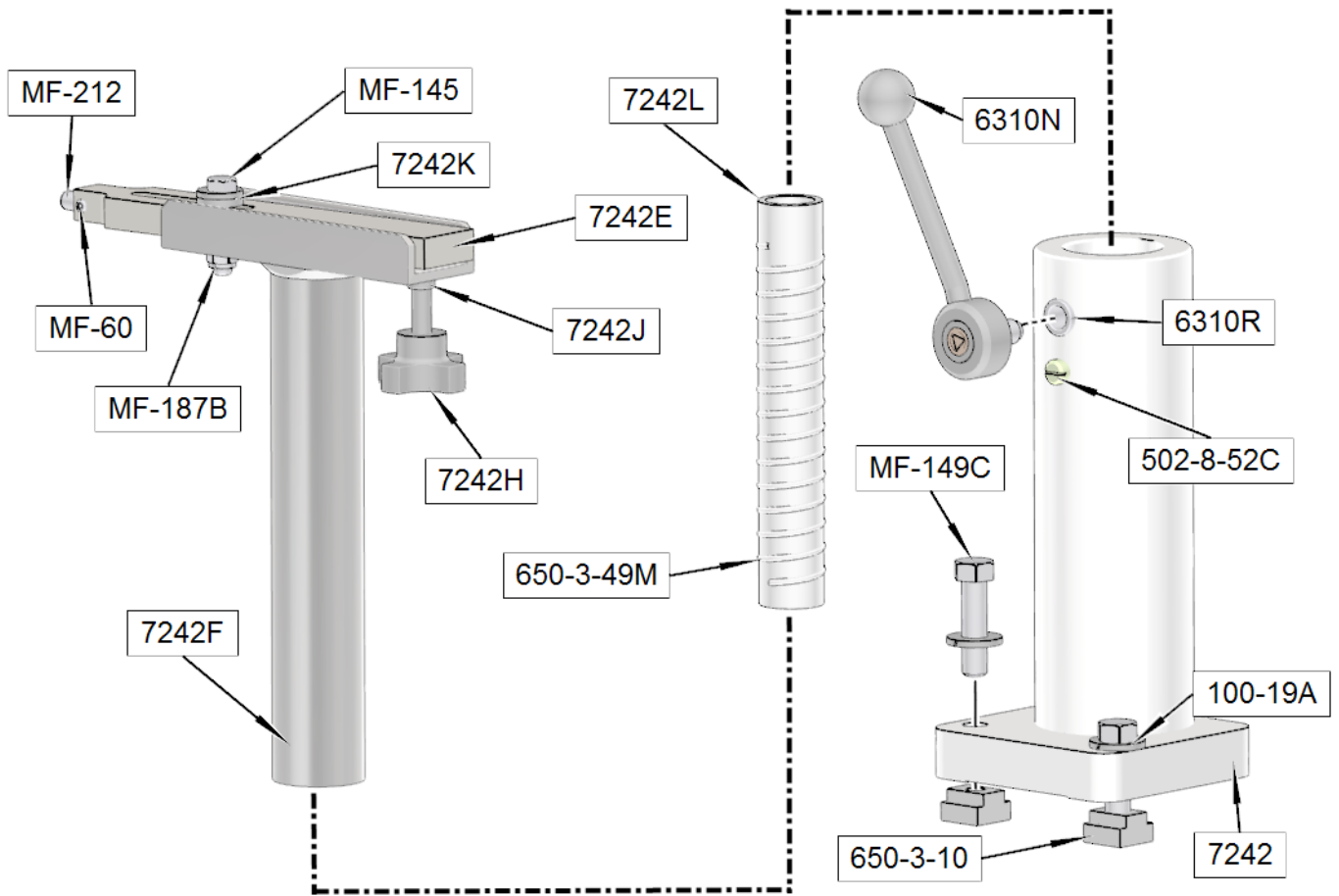
502-1-46T Precision 2" (50.8mm) Locator Bar



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

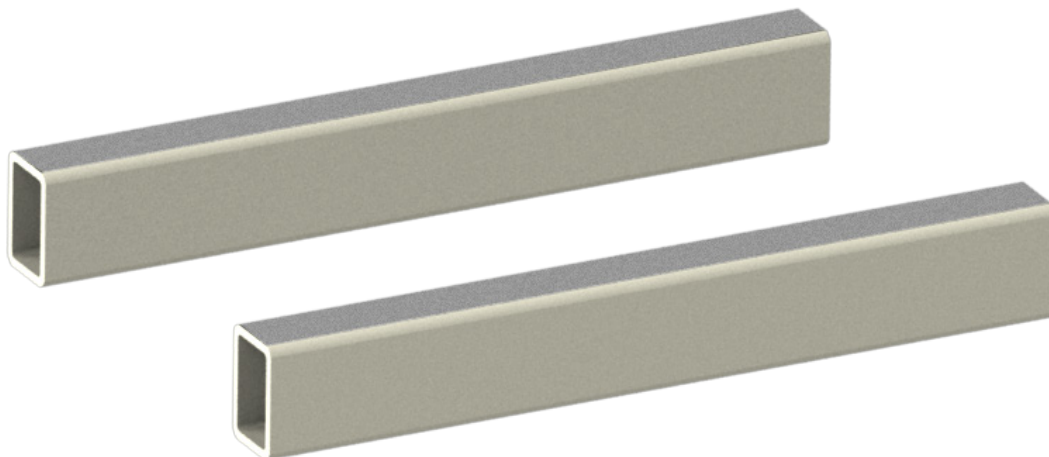


7242M Clamp Tower Assembly Parts

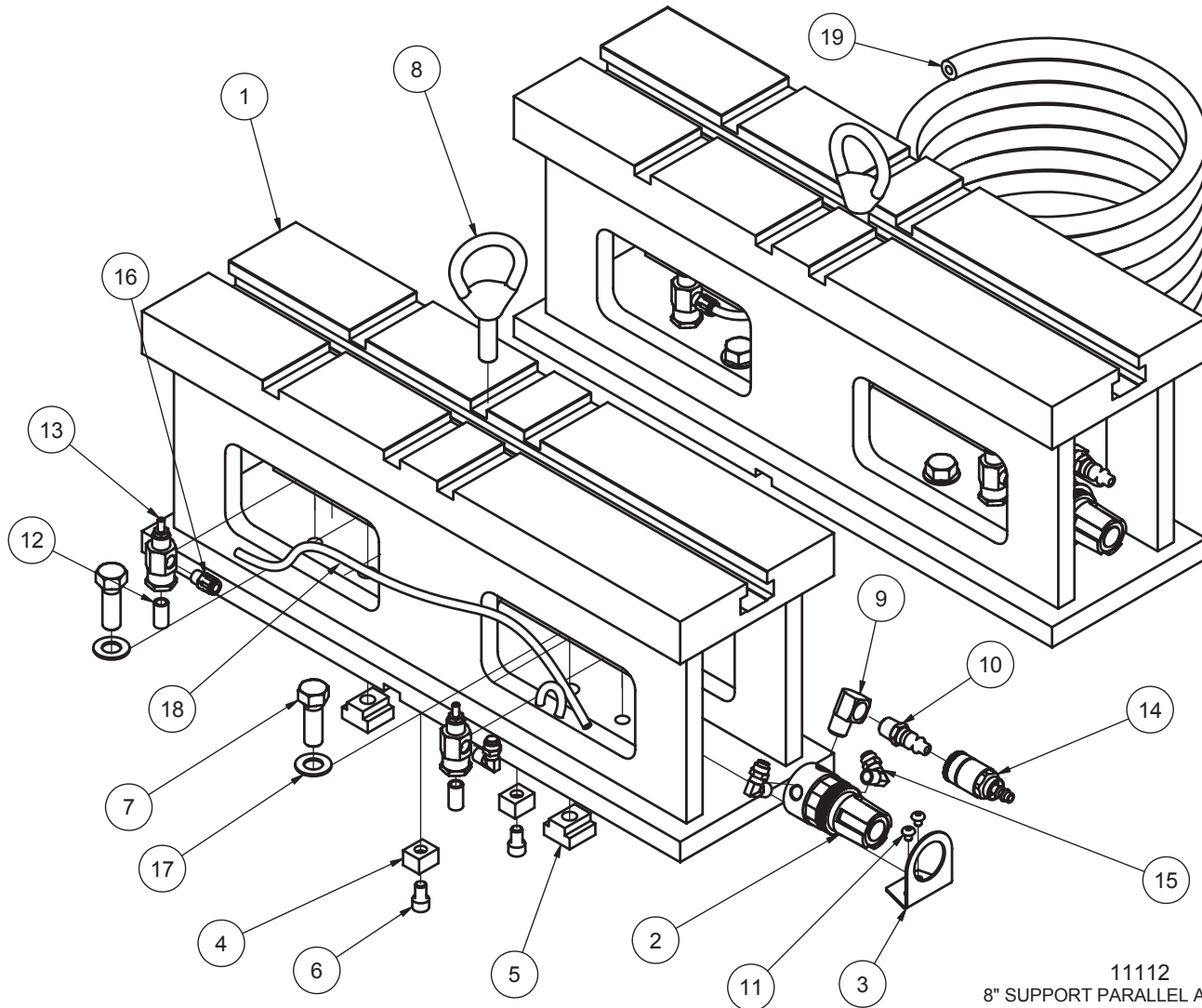


Parallels

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



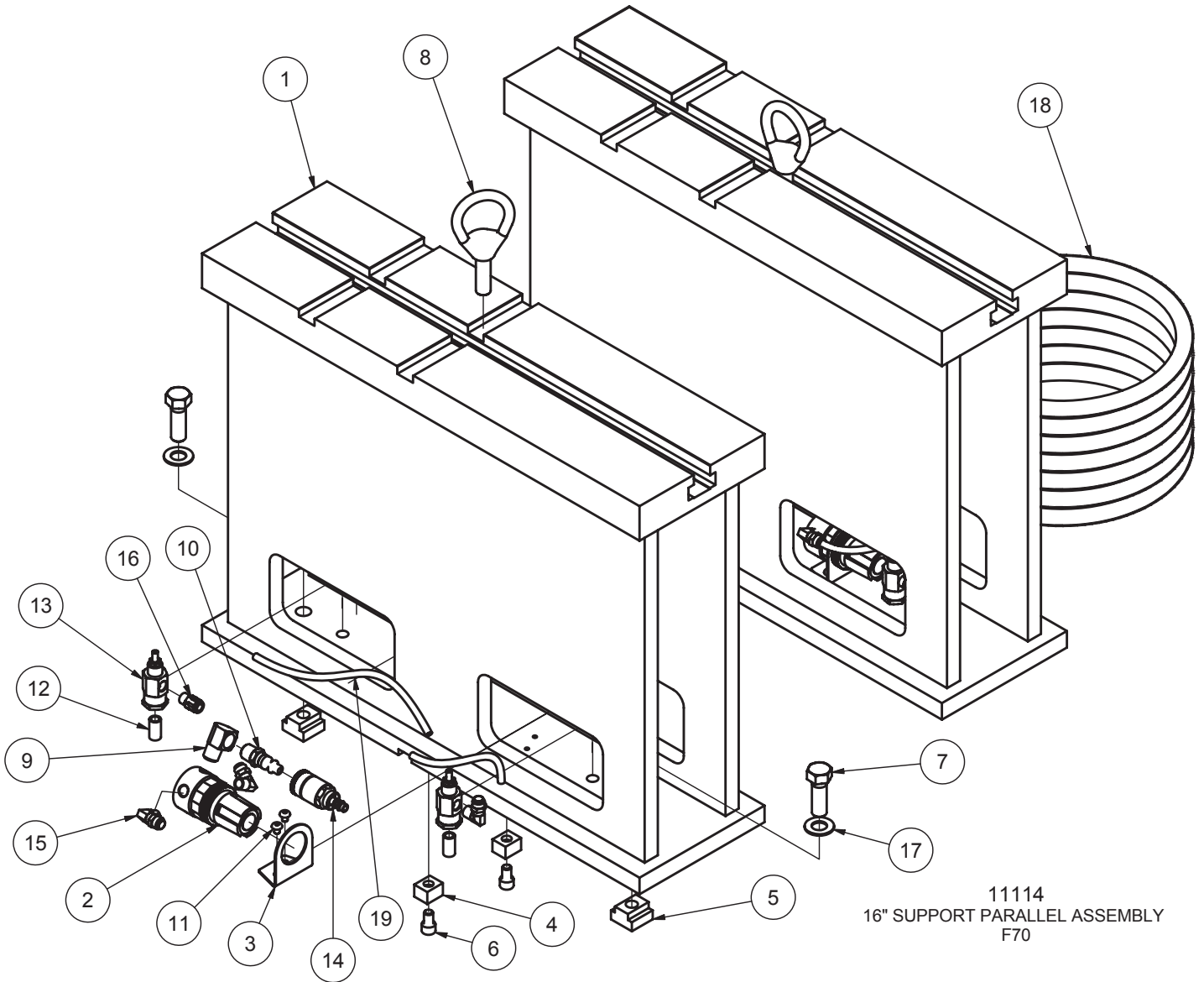
11112 Universal 8" (203mm) Heavy Duty T-Slot Parallels Parts



11112
8" SUPPORT PARALLEL ASSEMBLY
F70

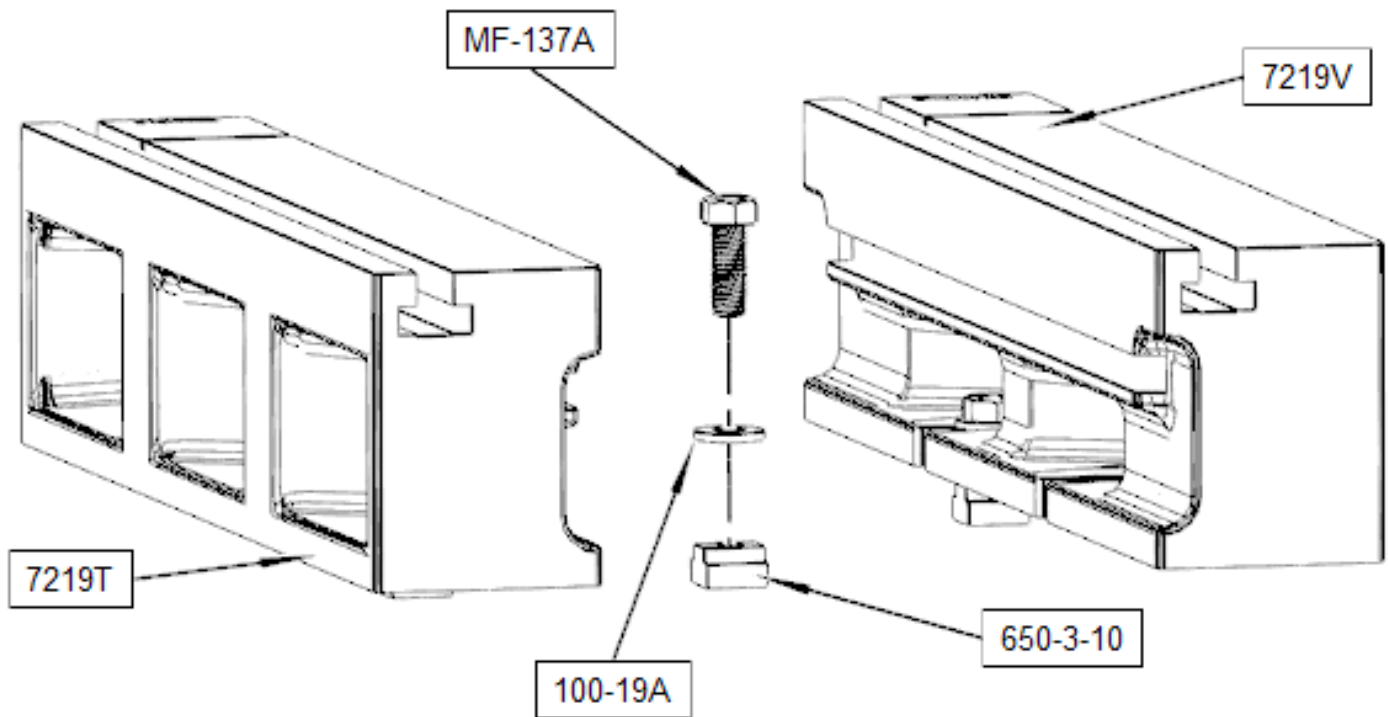
11112 SUPPORT PARALLEL ASSEMBLY 8" - F70			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	11112A	SUPPORT PARALLEL 8" (MACHINING) - F70
2	2	502-27-17	Regulator 0 - 60 PSI
3	2	502-27-17A	Regulator Bracket
4	4	650-3-9	Key
5	4	650-3-10	TN-5 T-Nut
6	4	MF-21A	5/16-18UNC x 1/2" LG. S.H.C.S.
7	4	MF-137A	1/2-13UNC x 1-1/2"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



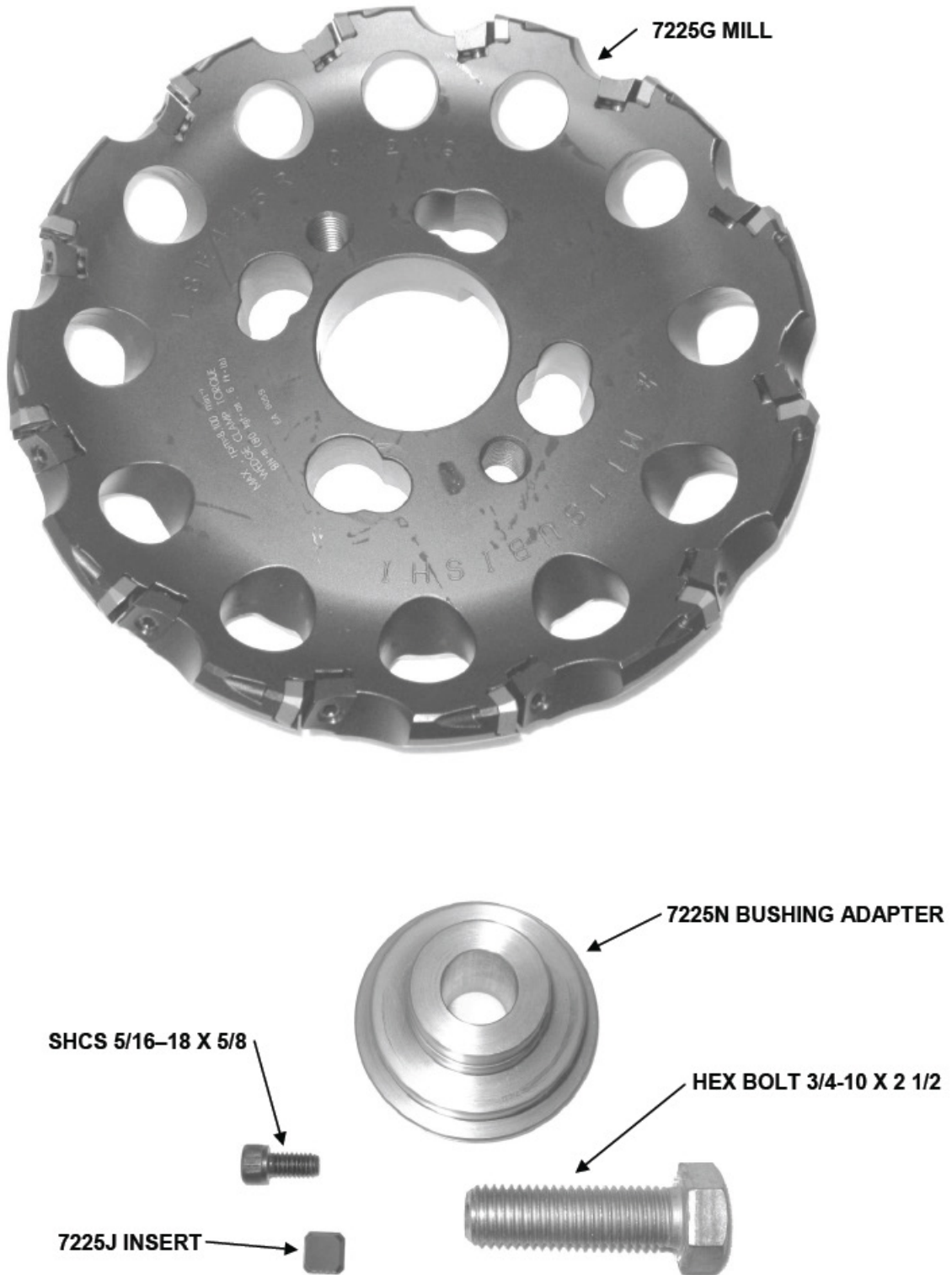
11114 SUPPORT PARALLEL ASSEMBLY 16" - F70			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	11114A	SUPPORT PARALLEL 16" (MACHINING) - F70
2	2	502-27-17	Regulator 0 - 60 PSI
3	2	502-27-17A	Regulator Bracket
4	4	650-3-9	Key
5	4	650-3-10	TN-5 T-Nut
6	4	MF-21A	5/16-18UNC x 1/2" LG. S.H.C.S.
7	4	MF-137A	1/2-13UNC x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

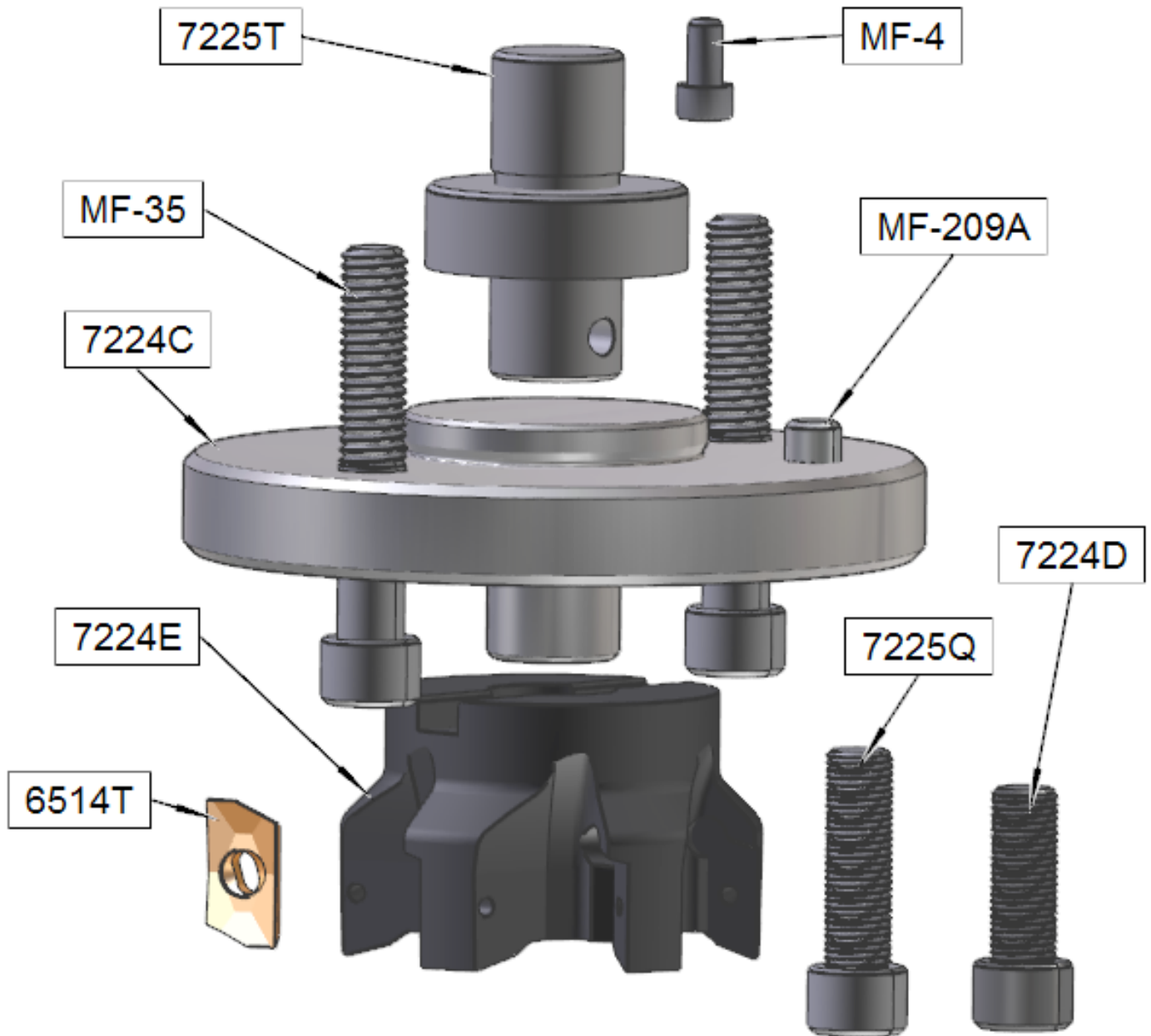


Optional Tooling

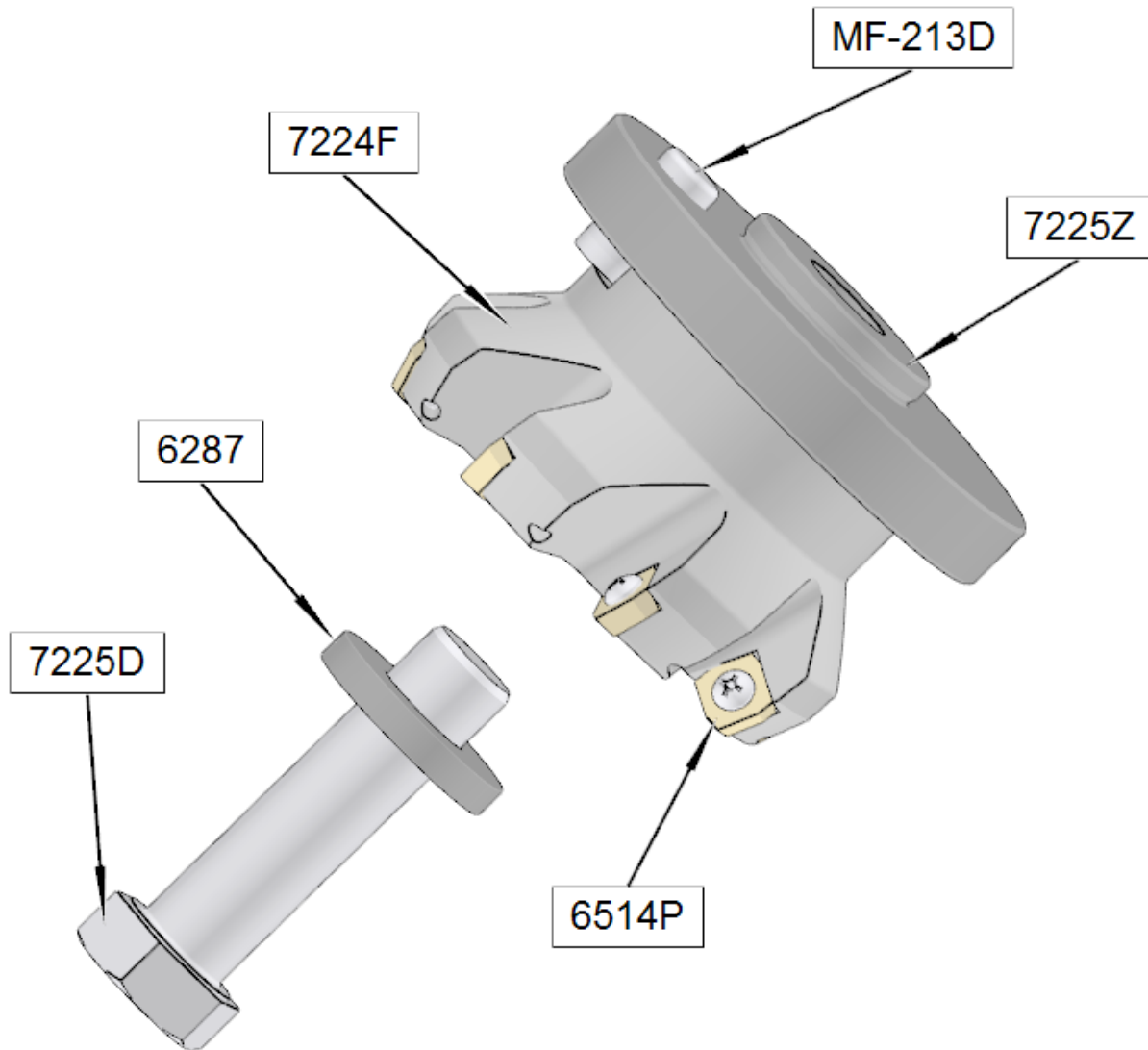
7225F 10" (254mm) Multi-tooth Face Mill Assembly Parts



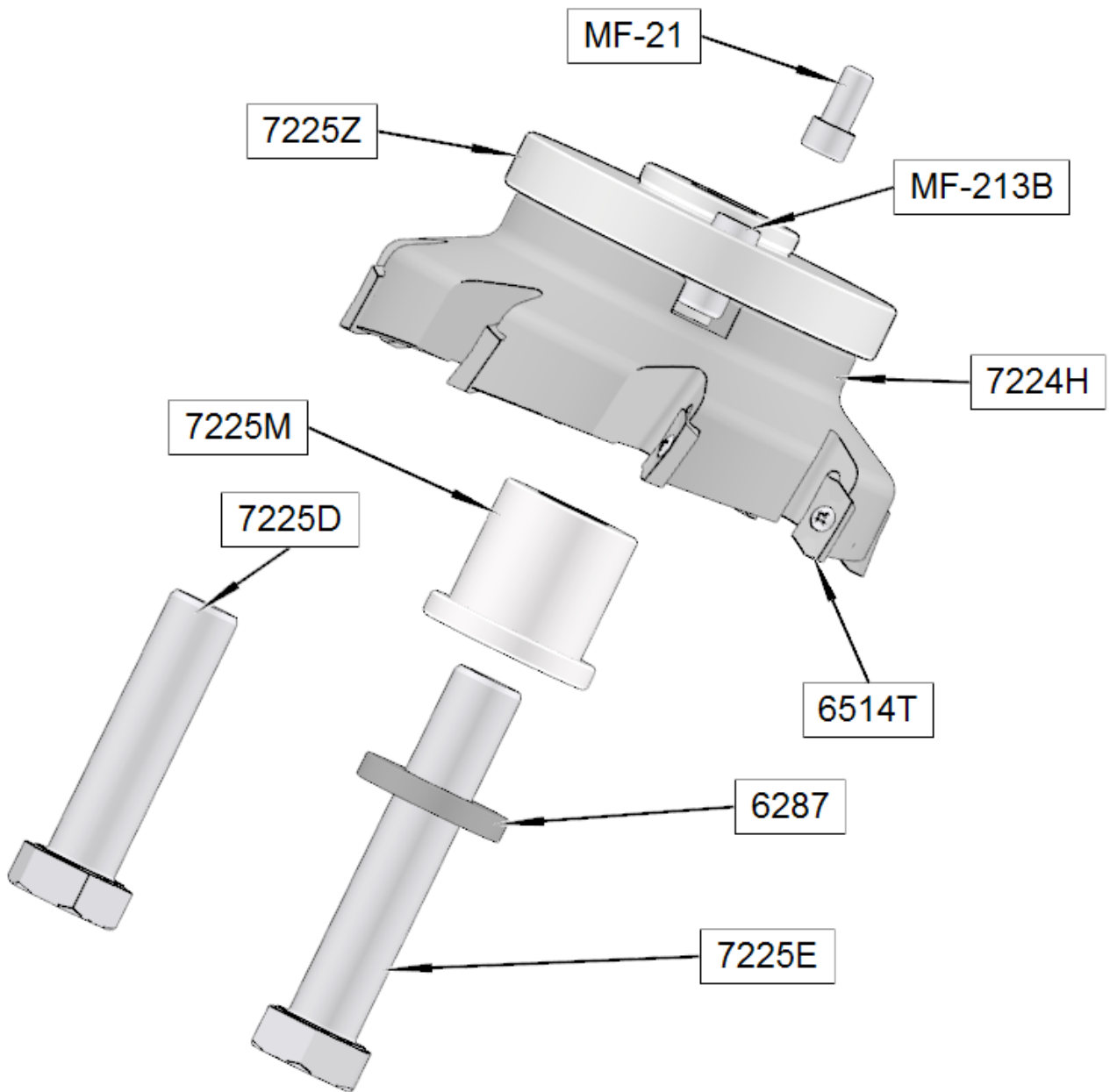
7224 Shell Mill Assembly Parts



7225Y Shell Mill Assembly Parts

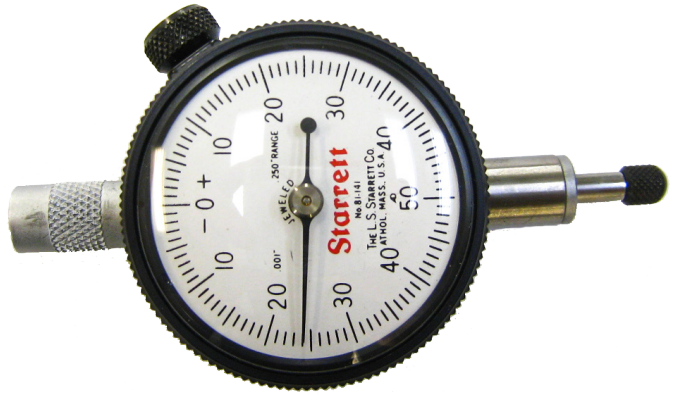


7224G Shell Mill Assembly Parts

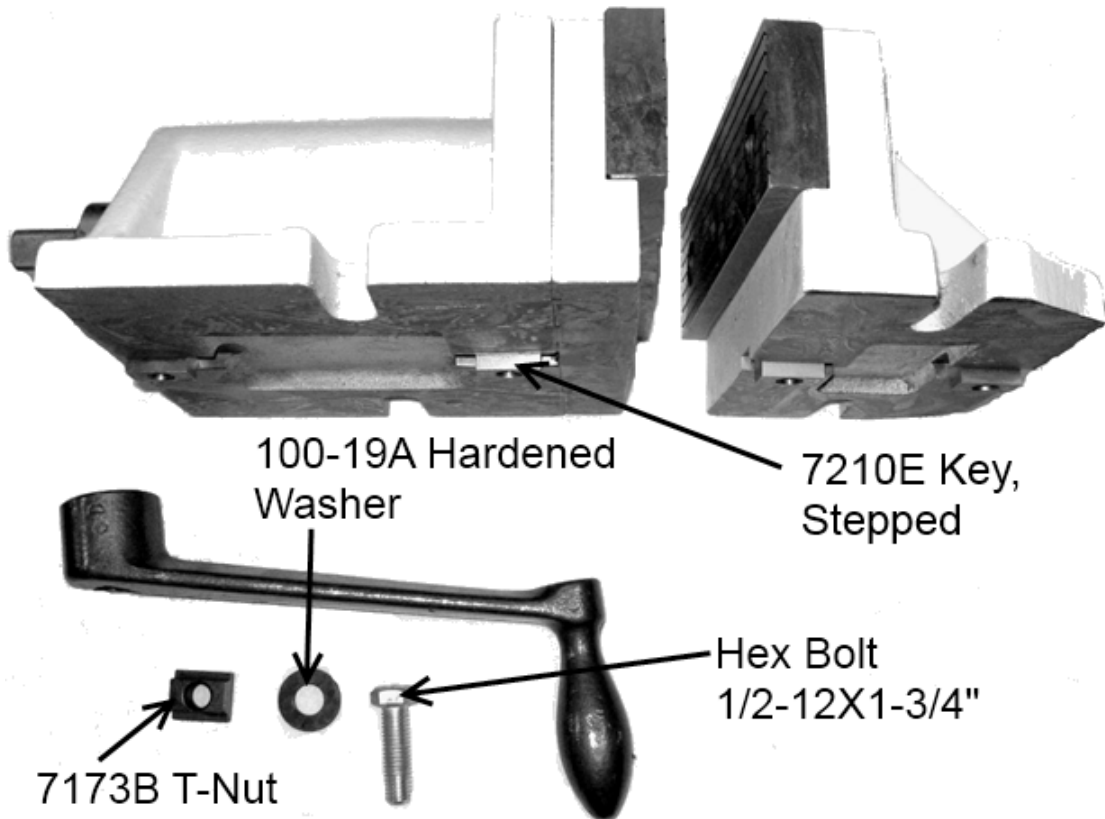


7038Y Flatness Probe Dial Indicator for Level Assembly

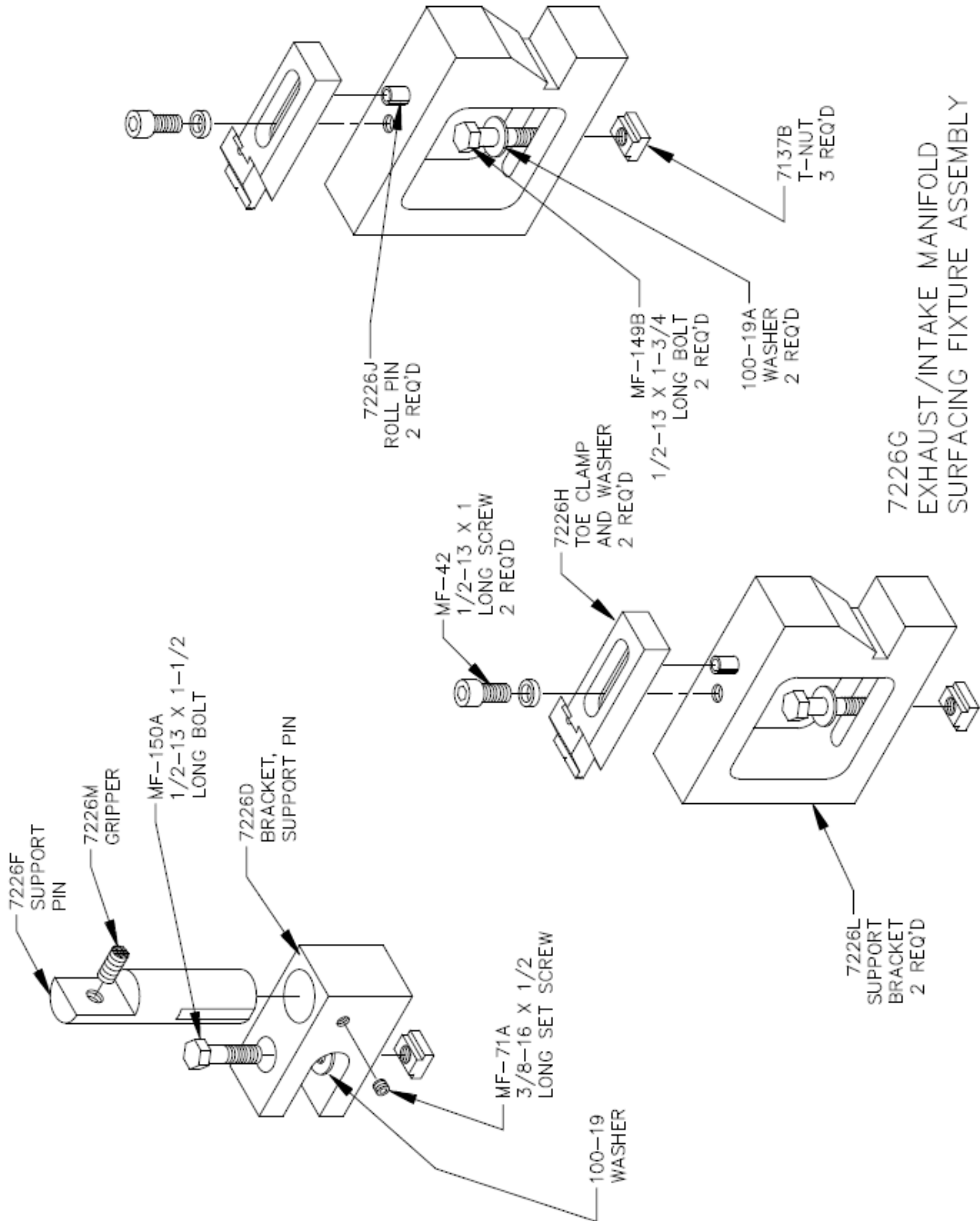
Sold as complete unit only.



7209N 2-Piece Vise Parts

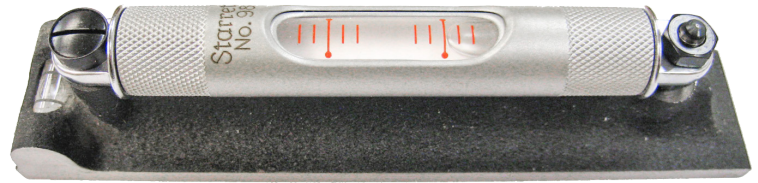


7226G Exhaust/Intake Manifold Surfacing Fixture Parts



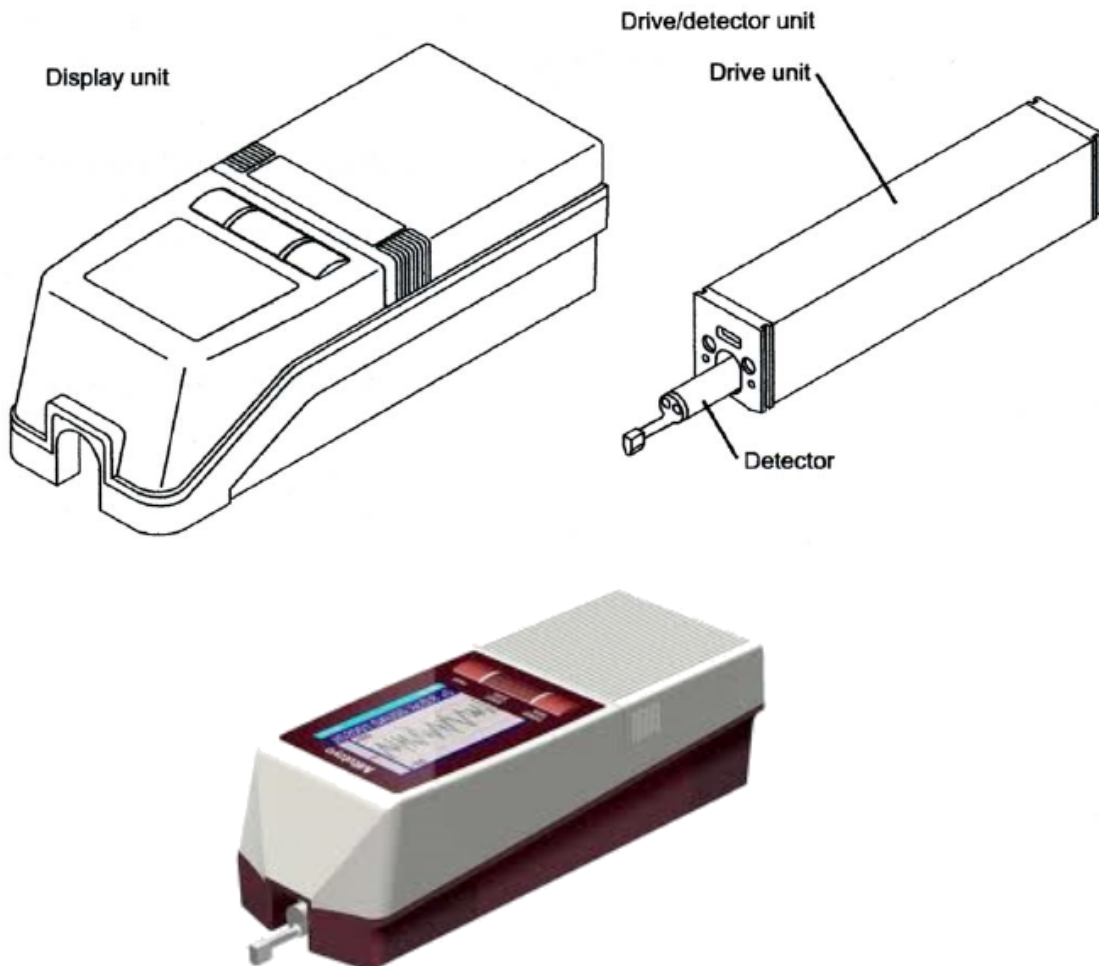
650-3-38 Machinist Level for Intake and Exhaust Manifolds

Sold as complete unit only.

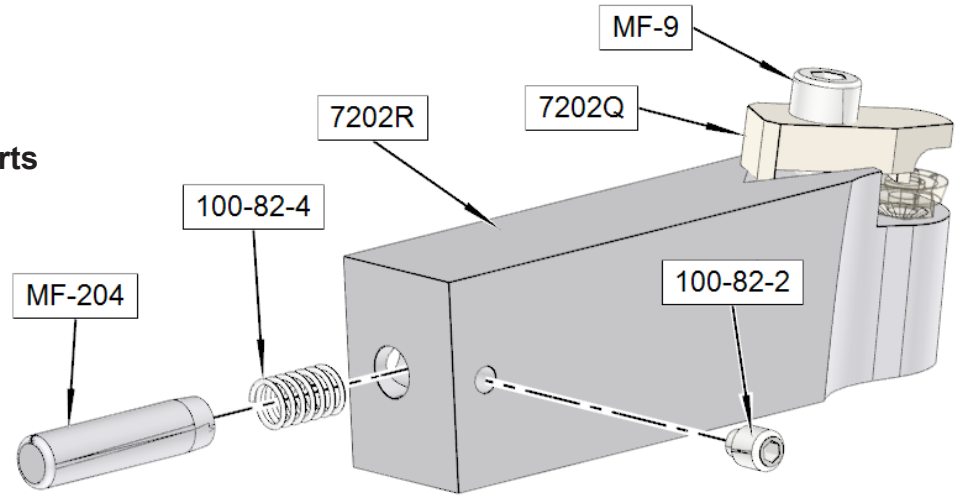


201 Mitutoyo Surface Tester

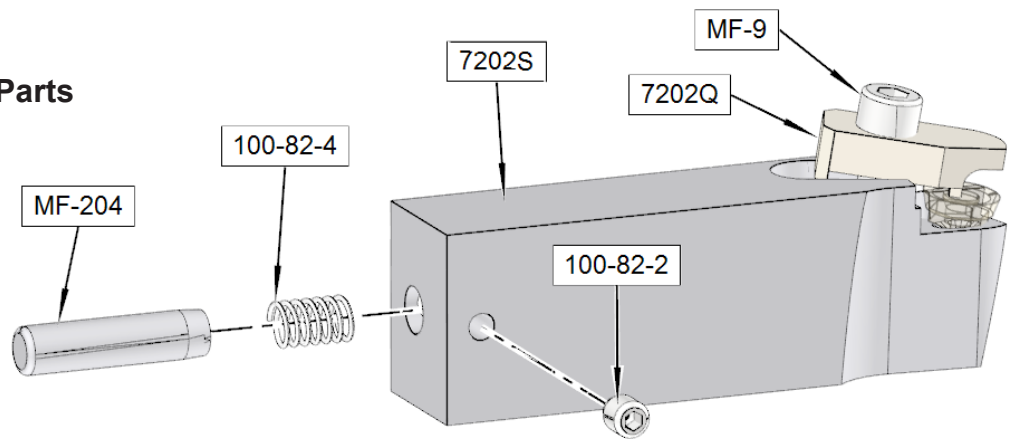
Sold as complete unit only.



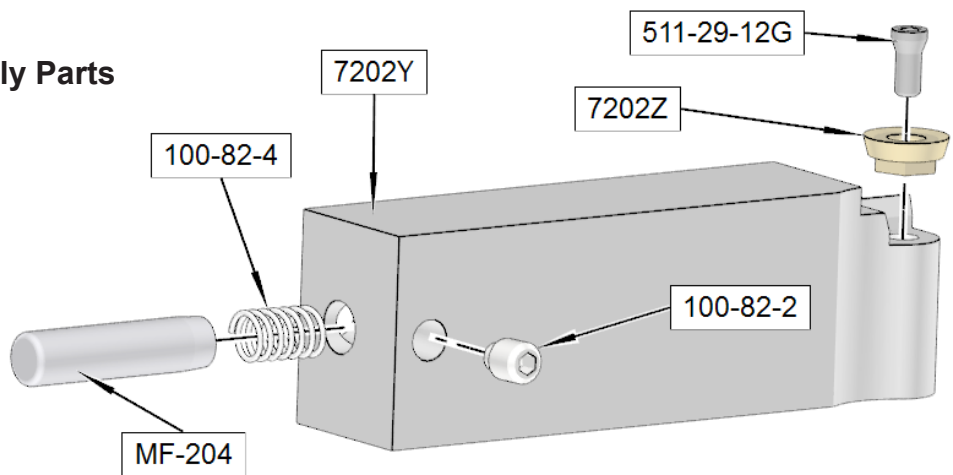
7202V Holder Assembly Parts




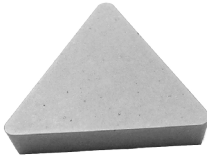
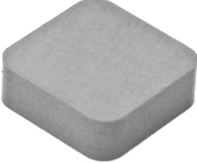







7202U Holder Assembly Parts



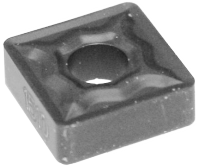


7202X Tool Holder Assembly Parts



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> 

Transformer

650-5-25 Buck-Boost Transformer

(Required for All Machine Installations where Power Supply higher than 240 Volts or lower than 208 volts)

Image Currently Unavailable