



VR416

MULTI PURPOSE 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.**

ORDER BY PART NUMBER.
THERE IS A MINIMUM ORDER OF \$25.00

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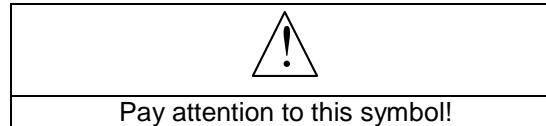
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Chapter 1 Introduction/Safety/Installation:

General warnings

The present Instruction manual constitutes a part of the supply. Read it carefully, giving particular attention to the warnings and recommendations related to the safety norms and fixtures.

Keep it with care for any further consultation.

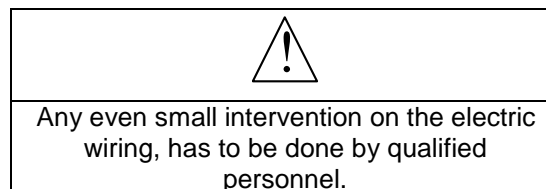


Machine purpose

The **RV 516** machine has been projected for the resurfacing by grinding wheel of engine valves.. The operating range is reported in the data sheet. Use the machine only for the purpose for which it has been projected. Any other use has to be considered as improper and irrational. The manufacturer declines any responsibility for damages caused by improper or irrational use.

General safety norms

The use of the machine is allowed only to the personnel duly trained and authorized. Any eventual non authorized tampering or modification of the machine, exempts the manufacturer from responsibility related to caused damages. The removal or the tampering of the safety fixtures means a clear violation of the EEC norms. The machine has to be installed in places far away from risk of fire or explosion. The use of original accessories is recommended, to have the warranty of a correct working. The installation has to be done by qualified personnel only upon the total fulfilment of the instructions reported in the present instruction manual. In case that, during the normal use should any dangerous situation arise, stop the machine immediately and call the technician.



Description

Engine valve resurfacing machine.

Technical data

Valve stem capacity	5.5 *÷ 16 mm (* con mandrino a richiesta inferiore a 5 mm- With optional chuck dia under 5 allowable)
Valve head capacity	min 25 mm max 120 mm
Valve length capacity	min 74 mm max 210 mm
Diameter of grinding wheel	215 mm
Grinding wheel rotation	2750 rpm
Grinding wheel speed	30m/sec

Voltage (+/- 15%)	~ 230 V ~ 400 V
Phases	~ 1 ~ 3
Min.protection degree	IP 44
Wheel head motor power	0.56 kW
Coolant pump motor power	0.1 kW
Valve drive motor	0.1 kW
Total power	0.9 kW
Environment conditions: temperature	10÷30 °C
umidity	15÷90 % RH
Weight: machine	160 kg
Weight:machine+ packing+standard equipment	182 kg
Dimensions: width	675 mm
length	700 mm
height	615 mm
Packing dimensions width	880 mm
length	880 mm
height	930 mm

Transport and handling information.

Packing

Packing type:

Wooden crate on pallet.

Note: weight and dimensions as per technical data.

How to remove the packing.

Place the packed machine (as per point 1.02.1) on a floor duly supporting the weight of the machine, as well as the weight of the operator, the accessories, the workable items, lifts, etc.

Keep around a suitable area to allow an easy disassembling of the packing. Laterally the free space has to be wider than any other removable item. The roof has to be one meter higher at least..

Remove any metal tape tying the packing.



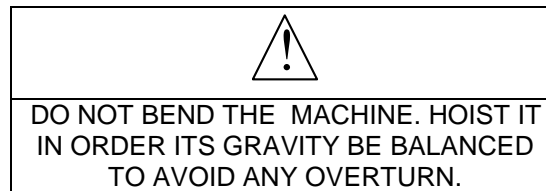
WARNING. Pay attention, if the tape is too tightened, once cut, can provoke any wound to the surrounding persons.

Handling

Packed machine

By **Fork lift**: use a proper lift. Slip the forks into the pallet in correspondence of the red marks.

By **crane**: let the ropes pass through the lower part of the pallet. Should the rope crash the packing, put some cardboard in between.

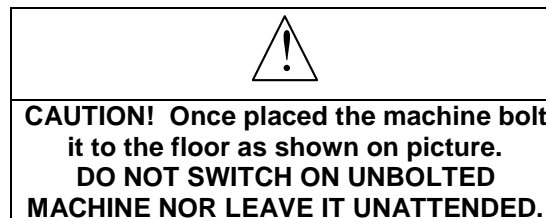


Eventual long distance transport have to be done only with packing in good condition. Should the machine arrive with broken packing, call our technicians to ascertain if any damage has been caused. Fix the packing properly for any prosecution of the transport.

Whether for land, or sea or air transport, it is advisable to duly fasten the packing, to avoid any overturn.

Unpacked machine

The machine can be lifted by ropes once duly secured by.



Emergency situations

Fire

Extinction

It is recommended not to use water but extinguishing powder or CO₂ or any other substance compatible with electronics. Switch off the machine before.

Reactivation

After any even partial fire occurred, for the machine reactivation it is recommended to turn to any technician.

Flooding

Cautions

Cut the feeding source off.

Drain the water from the room and immediately clean and dry the main components. Use some specific chemicals to prevent oxidation.

Reactivation

It can be done only after an exhaustive checking made by specialized personnel.

General warning

Machine emergency stop

In case of emergency, the machine can be totally stopped by pushing the emergency red button. The switchboard remains still connected to the line as well as the lamp. Turn the main switch off for a complete disconnection from the line.

Chapter 2 Control Definitons:

Machine into operation

Machine clamping

Floor base

For a suitable working level, suggest to rise the machine up to some 650 mm..
Avoid an excessive smoothness of the floor to prevent any sliding of the operator.

Machine bolting

Put it on a bench and duly bolt the machine to it through the holes located on the lower part of the machine base. Bolt the bench to the floor by using some studs drowned into the concrete By means of a spirit level, check in both ways the planarity of the machine.

Operating and maintenance space

The outline gives an indication of the suggested space for a convenient machine using and maintenance intervention. In respect of the roof height follow what requested by the local authority.

Installation requirements

Temperature range: 10°C÷ 30°C

Peak temperature: 4°C÷ 50°C

Humidity: 15÷90% RH

Vibrating floor avoidable

Keep out from explosive or gas areas.

Keep out from flammable.

Remove all polluting materials from the working surfaces to avoid any dangerous chemical reaction (combusted oil, asbestos, etc.).

Electrical connection to the source.

General warnings

The electrical connection to the power source has to be done by electricians only. Verify if the feed line is in accordance with the norms in force. In the negative, keep the due remedy. Make sure the wiring connection to the power source has been correctly done and not hinder the normal operation and maintenance of the machine.

The section of the feeding cable, as well as the protective covering have to be calculated accordingly with the fed power. Check the source voltage be as indicated in the machine data plate. Also check the cables are well insulated and the machine connected to the earth. On the feeding line there must be a cut-off device of 30 mA.

Caution: Plug the machine to the power source paying attention to the data reported on the plate fitted to the machine. Make sure the feeding cable be in accordance with the safety rules. Once connected the machine, pay attention its sense of rotation be correct. In the negative, invert one phase. Follow the marks and the cable colour to identify the phases.

Safety devices and advises

General warnings.

Pay attention all warning lights placed on the machine switchboard are duly working. Replace them if burned out.

Do not operate with the machine if not duly trained and authorised to use it. In absence of operator keep the machine and its switchboard duly locked.

Use of the machine

The machine has to be used only by authorised personnel duly trained. Read carefully the instruction manual before operating

Do not drink alcohol or ingere sleepy substances or medicines before or during the operating of the machine. Use the recommended working-suit duly buttoned. Avoid necklaces tie, scart, etc.

Time by time check the good functioning of the machine especially in respect of the safety fixtures. Carefully fulfil what required on the instruction manual concerning the periodical maintenance.

For any unproper functioning or breakdown call the after sale service.

Main fixtures

The machine is composed by:

A rigid cast iron guard over the grindwheel grindwheel guard.



Machine run in

Preliminary operation

Clean the machine carefully, removing the protective grease spread on unpainted parts.

Lubricate the points as indicated.

Before the delivery the machine has been duly tested therefore it is not necessary any particular setting up when using it.

Anyway, since damage might occur during the transport, it is advisable to verify its status before putting into operation.

Waste dissipation.

Waste materials can be of 2 different types:

Dust produced by dry grinding.

Emulsifiable coolant.

Suggestion:

1.-2. Once performed the resurfacing Do not let the coolant overflowing from the splash guard to prevent any sliding risk of the operator, also not to pollute the environments.

Recover the residuals into the settling tank and dissipate them accordingly with the law.



Chapter 3 Operating Instructions:

How are the lighting conditions?

Whether when operating or over hauling the lighting conditions have to be adequate.

Resurfacing procedure

1. Grinding angle setting
 - a) Check the valve angle
 - b) Loosen the handle A
 - c) Rotate the valve holding group up to the arrow indicates the requested angle
 - d) Block the handle A

2. Valve positioning
 - a) Shift the valve rest on the slide, in order the supporting of the valve stem is done at its end as much as possible.
 - b) By means of the handwheel B shift the valve driving unit in a convenient position.
 - c) By means of the lever, pull the machine arm to the operator to release the upper valve driving roller.
 - d) Rise up the valve pressing finger D located on the rest.
 - e) Insert the valve into its lodgement up to touch the swinging stop device. Eventually adjust the stop device in length C.
 - f) Lower the stem pressing finger of the rest.
 - g) Approach the arm to the grinding wheel

3. Adjusting
 - a) Switch on the grinding wheel motor as that one of the valve driving and of the coolant pump.
 - b) If necessary adjust position of the valve by shifting the driving unit. Once reached the right position, block the slide by screwing the knob.
 - c) By the lever, approach the valve to the grindwheel without touching it. Rise up the swinging stop. The valve automatically moves to left thus starting its grinding against the wheel.
 - d) Swing the machine arm in order the grind the valve on all the profile of the grinding wheel.
 - e) For any further pass turn the handwheel of the valve driving unit.
 - f) Once performed the grinding operation, push to left E the upper roller lever. The valve is automatically pushed to right, for away from the grinding wheel.

4. Valve grinding by sequence
 - a) Pull the machine arm towards the operator to rise the upper roller thus releasing the valve.
 - b) Rise up the rest pressing finger
 - c) Take out the ground valve.
 - d) Insert the second valve up to touch the swinging stop device
 - e) Let the rest finger go down.
 - f) Push the arm to approach the valve to the grinding wheel. Rise the swinging stop device in (b) to let the valve go towards the grinding wheel.
 - g) Once performed the grinding operation, push to left the upper roller lever to release the valve to right. Pull the arm towards the operator.

Chapter 4 Maintenance:

Maintenance indications

Lubrication

But just a periodical greasing by means the oil cups placed on the machine.

Coolant

The coolant is contained in a special tank. The tank should be filled with a mixture of 97 % water and 3% emulsifiable oil.

This mixture protects the machined parts and the workpieces against rust. We advise you to clean the pump and tank weekly.

Grindwheel replacement

1. Turn the main switch off
2. Take the grindwheel guard away
3. Unscrew the grindwheel blocking nut using the proper wrench supplied
4. Replace the grindwheel
5. Screw the grindwheel blocking nut using the proper wrench supplied
6. **Replace the grindwheel guard.**



Attention! The use of original parts is required.

Grinding wheel balancing

The quality of finish is a direct result of grinding wheel balancing. To balance the grinding wheel move the counter weights located under the wheel hub until a satisfactory result is achieved.

That operation in absence of adequate instruments can be performed manually by attempts.

Grindwheel dressing

1. Lower the dresser support A in position a
2. Swing it by means
3. To feed the diamond point turn the scaled knob

Chapter 5 Troubleshooting

Out of service

Temporary out of service

Electrical supply

Disconnect the machine from the source.

It is advisable to keep the earth cable connected to dissipate any static electricity.

Mechanical part protection

Lubricate all mechanical parts as indicated at the point lubrication.

Protect the parts from dust as well as from oxidation.

Centerlining fittings care

Particular care has to be given to the centering fittings to avoid their rusting, abrasion or dirtiness, thus compromising their perfect center lining. Replace them if necessary, as well as any cutting tool if not working properly.

Definitive out of service

Electrical supply

Disconnect the machine from the electrical source.

Machine removal

Dismount from the machine all the accessories and bulky parts.

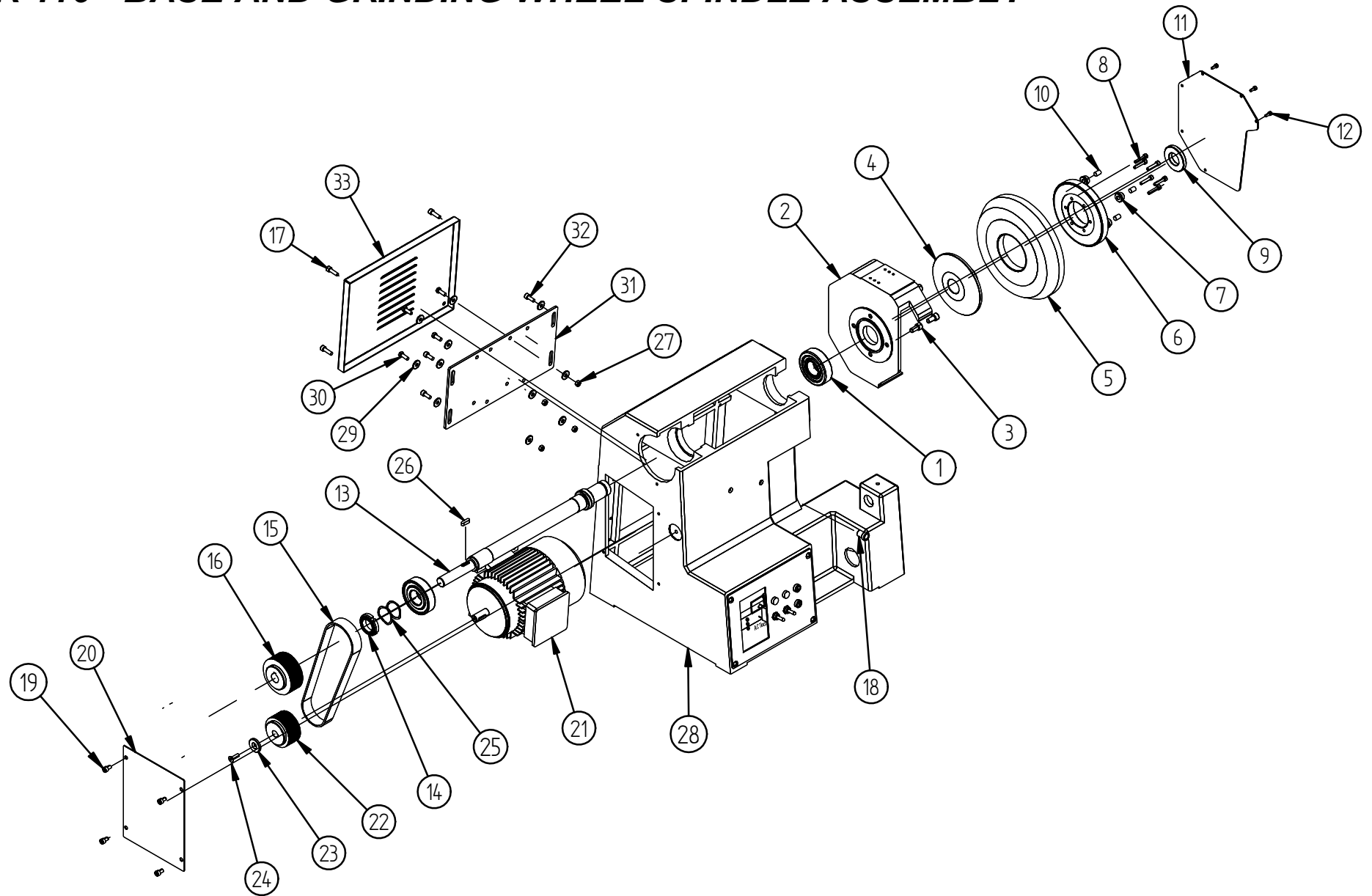
Loosen the bolts fixing the machine to the floor.

Final destinations admitted

a) Demolition after recovering of the oil contained into the gear box.

B) Delivery to any authorized dealer for an eventual overhaul and putting into service again, once safeguarded all the safety fixtures.

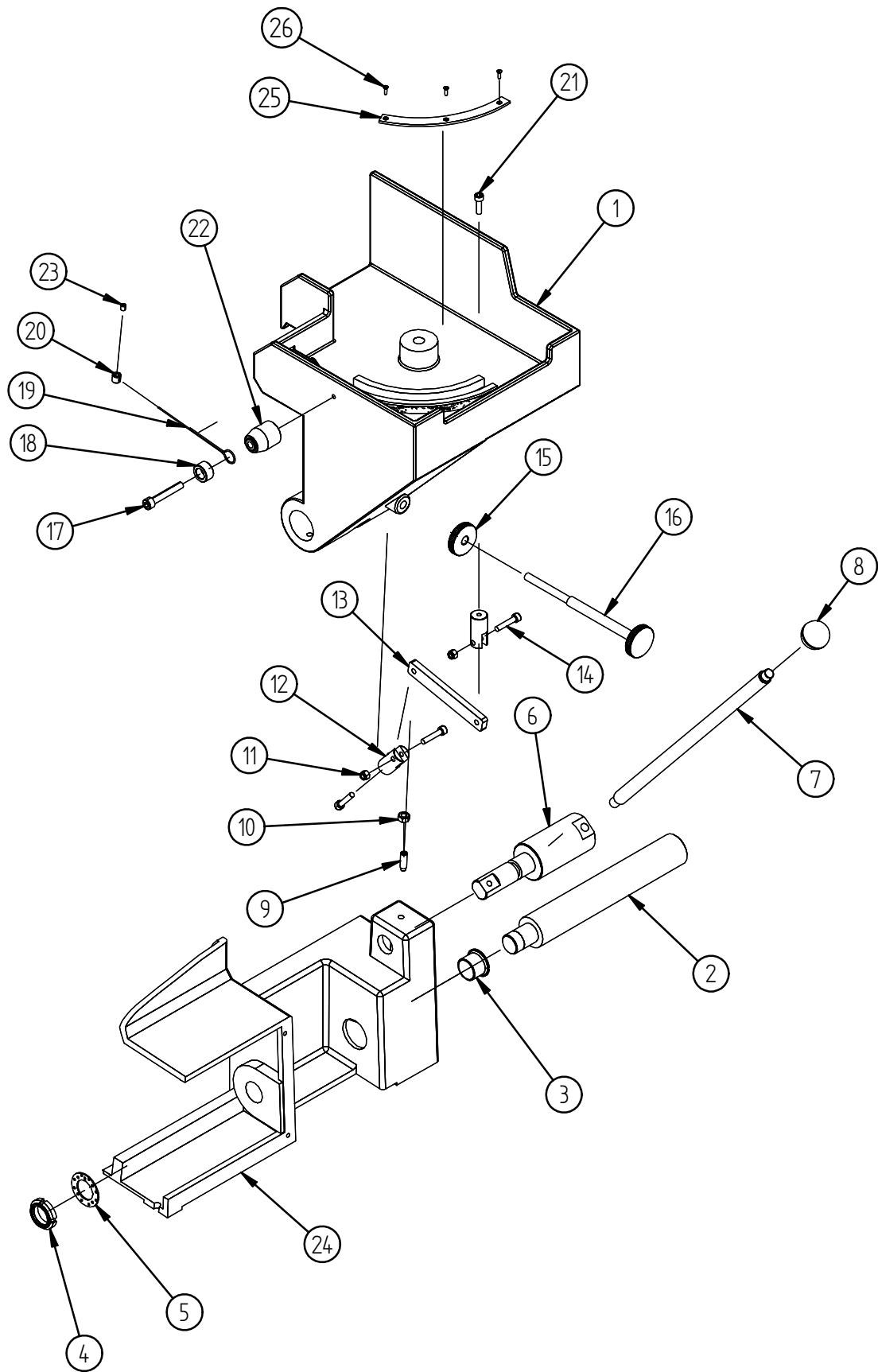
VR 416 - BASE AND GRINDING WHEEL SPINDLE ASSEMBLY



VR 416 - BASE AND GRINDING WHEEL SPINDLE ASSEMBLY

Ref	Code	Q	Part name
1	527 300 720	2	bearing 7306
2	251 800 120	1	grinding wheel cover
3	555 108 016	4	screw TCEI 8x16
4	251 801 180	1	internal flange - grinding wheel
5	535 200 000	1	grinding wheel RV0099
6	251 801 090	1	external flange - grinding wheel
7	251 801 120	3	balancing weight - wheel
8	555 105 025	6	screw TCEI 5x25
9	251 801 060	1	nut - grinding wheel
10	555 408 012	3	screw STEI 8x12 pna
11	251 808 190	1	sheet cover - grinding wheel
12	555 104 010	6	screw TCEI 4x10
13	251 801 210	1	grinding wheel spindle
14	550 130 150	1	nut ATBL 30x1.5
15	251 801 360	1	poly-v trasmission belt 660 J6
16	251 801 240	1	pulley - grinding wheel spindle
17	555 106 020	4	screw TCEI 6x20
18	251 801 030	1	bush - cable covering passing
19	555 106 010	7	screw TCEI 6x10
20	251 808 270	1	lateral belt cover
21	251 801 510	1	electric motor
22	251 801 420	1	pulley - electric motor
23	251 801 480	1	washer - motor pulley
24	555 306 020	1	screw TSPEI 6x20
25	551 610 395	2	waved ring 33x39x3
26	551 106 020	1	linguetta tipo A 6x6x20
27	555 751 006	4	nut M6
28	251 800 040	1	base casting
29	555 700 624	12	washer 6x24
30	555 206 016	4	screw TE 6x16
31	251 808 040	1	motor support plate
32	555 106 015	4	screw TCEI 6x15
33	251 808 240	1	main motor cover

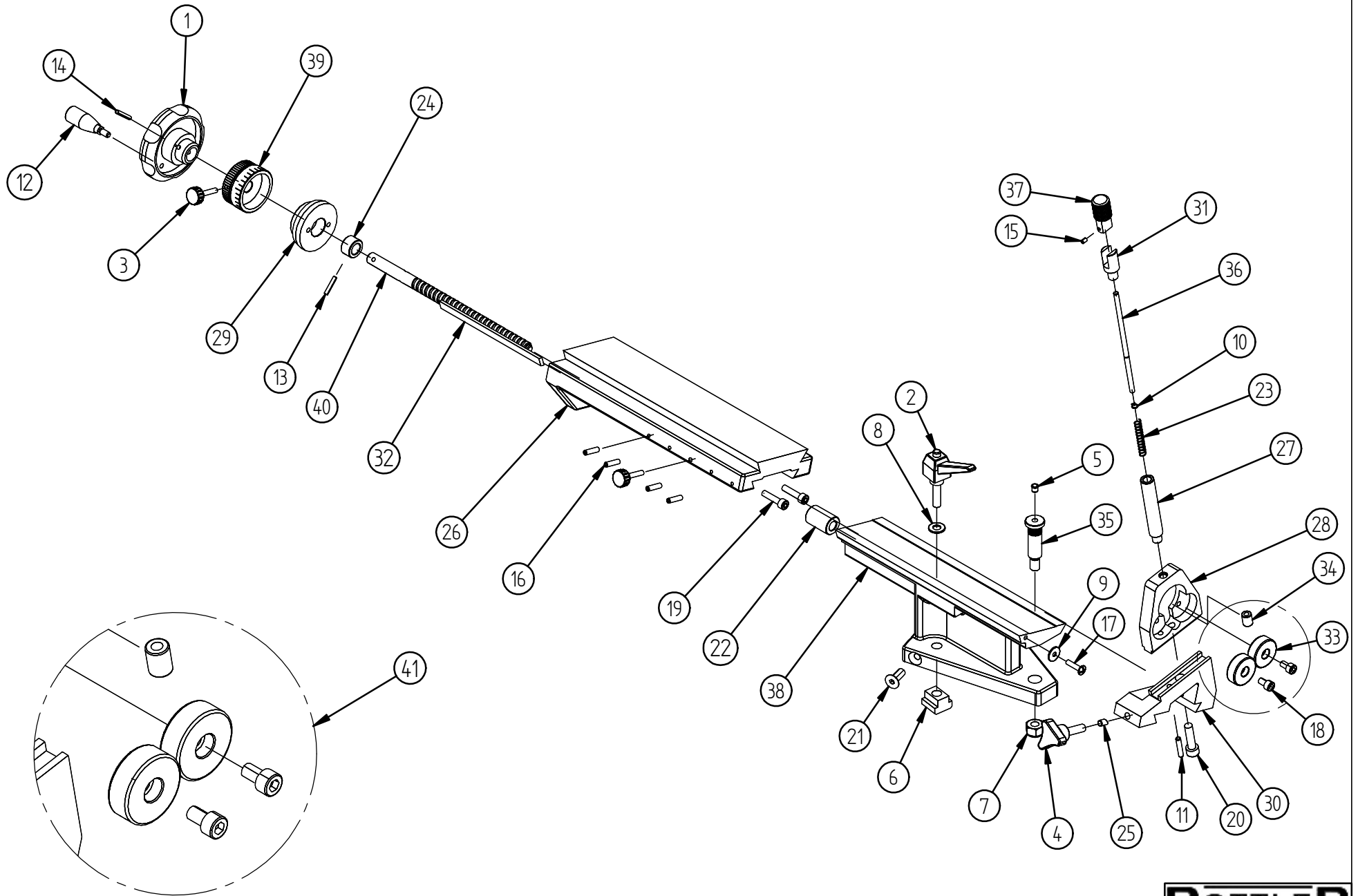
VR 416 - PIVOT ARM ASSEMBLY



VR 416 - PIVOT ARM ASSEMBLY

Ref	Code	Q	Part name
1	251 800 080	1	pivot arm - casting
2	251 802 060	1	spindel - pivot arm
3	550 402 521	1	bush - flange 25/28/21.5
4	550 125 150	1	self locking nut ATBL 25x1.5
5	550 502 644	1	flange 26/44/1.5
6	251 802 090	1	control shaft - pivot arm
7	251 802 120	1	control lever
8	547 000 132	1	knob PS.35
9	555 530 825	1	screw STEI 8x25 cil
10	555 751 008	1	nut M8
11	555 752 006	2	self-locking nut M6
12	251 802 210	2	fork
13	251 802 240	1	tie rod
14	555 106 030	3	screw TCEI 6x30
15	251 082 180	1	nut-depth stop
16	251 802 150	1	depth stop
17	555 108 050	1	screw TCEI 8x50
18	251 802 300	1	rondella bloccaggio fune
19	251 802 300	1	driving cable
20	251 802 330	1	cable clamp
21	555 106 020	1	screw TCEI 6x20
22	251 802 060	1	cone - cable blocking
23	555 406 006	1	screw STEI 6x6 pna
24	251 800 040	1	base casting
25	251 802 140	1	goniometer
26	555 303 008	3	screw TSPEI 3x8

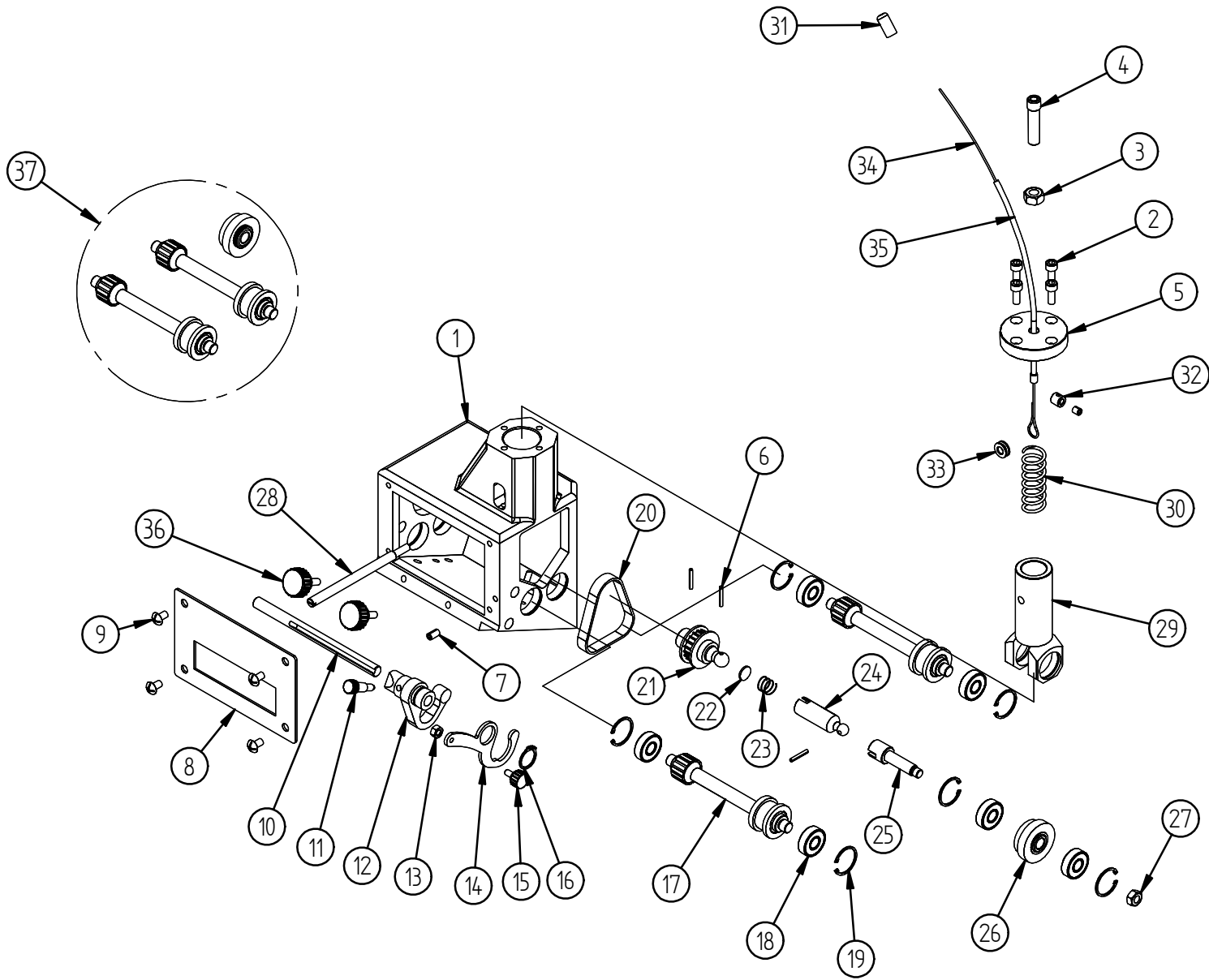
VR 416 - SLIDE SUPPORT ASSEMBLY



VR 416 - SLIDE-SUPPORT ASSEMBLY

Ref	Code	Q	Part name
1	251 803 280	1	handwheel - slide
2	547 000 264	1	handle M8x30
3	251 803 250	2	knurled handle 5x25
4	547 000 054	1	handwheel 3P M8x20 Ø34
5	543 060 630	1	oiler fitting Ø6
6	555 754 008	1	T nut M8
7	555 752 010	1	nut ATBL M10
8	555 700 817	1	washer 8x17
9	555 700 515	1	washer 5x16
10	551 500 005	1	circlip est. Ø5
11	551 405 025	1	cylindrical pin 5x25
12	547 000 110	2	handle M6 17x40
13	551 204 020	1	elastic pin 4x20
14	551 204 025	1	elastic pin 4x25
15	555 404 005	1	screw STEI 4x5 est.pna.
16	555 505 020	4	screw STEI 5x20 est.cnc.
17	555 570 512	1	screw COMBI 5x12
18	555 106 010	2	screw TCEI 6x10
19	555 106 025	2	screw TCEI 6x25
20	555 108 030	1	screw TCEI 8x30
21	555 308 020	1	screw TSPEI 8x20
22	251 803 200	4	bronze nut - slide
23	251 803 430	1	compression spring
24	251 803 180	1	bush - slide screw
25	251 803 310	1	bronze pin 6x10
26	251 602 160	1	slide support
27	251 803 370	1	cylinder - spring housing
28	251 803 300	1	support - fiber rollers
29	251 803 210	1	support flange - slide screw
30	251 800 240	1	cast iron support - rest
31	251 803 490	1	coupling - lower part
32	251 803 120	1	slide gib
33	251 803 330	2	fiber roller
34	251 803 400	1	fiber pad
35	251 803 090	1	centering pin
36	251 803 460	1	pin Ø5
37	251 803 520	1	coupling - upper part
38	251 800 160	1	support slide
39	251 803 240	1	graduated dial
40	251 803 150	1	feed screw
41	951 699 532	1	set of 2 fiber rollers and 1 fiber pad

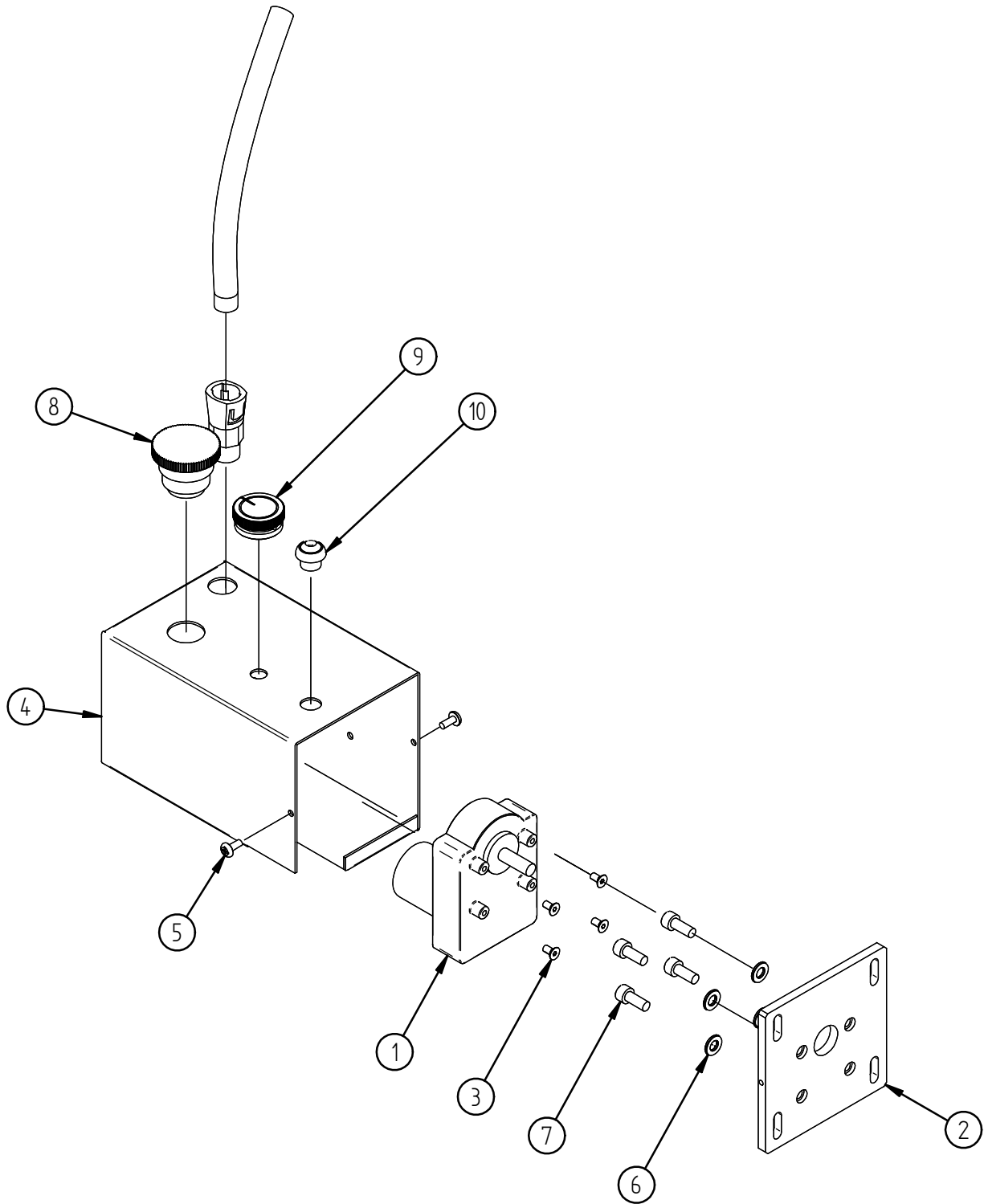
VR 416 - POWER HEAD ASSEMBLY



VR 416 - POWER HEAD ASSEMBLY

Ref	Code	Q	Part name
1	251 800 280	1	head casting
2	555 106 015	8	screw TCEI 6x15
3	555 751 010	1	nut M10
4	251 804 800	1	regulating screw - cable
5	251 804 770	1	flange - regulating screw
6	551 203 020	3	elastic pin 3x20
7	555 406 010	1	screw STEI 6x10 pna.
8	251 802 210	1	lateral plate - head
9	555 750 610	4	screw COMBI 6x10
10	251 804 500	1	stem shaft
11	251 804 560	1	locking screw
12	251 804 530	1	depth stop
13	555 751 006	1	nut M6
14	251 804 560	1	primary stop
15	547 000 205	1	knurled knob 5x10
16	551 500 018	1	circlip est. Ø18
17	251 804 470	2	splined shaft
18	520 100 262	6	bearing 6000 2RS
19	551 501 026	6	circlip int. Ø26
20	546 708 003	1	cog belt 80XL 037
21	251 804 110	1	cogged pulley - motoreducer
22	251 804 140	1	steel disc - spring
23	251 804 170	1	spring 12,7x12
24	251 804 200	1	drive shaft
25	251 804 230	1	shaft - upper roller
26	251 804 350	1	upper roller
27	555 751 008	1	nut M8
28	251 804 650	1	lever 8X120 M8/6
29	251 804 260	1	holder - upper roller
30	251 804 740	1	main spring
31	251 804 890	1	end cap - cable covering
32	251 802 330	1	cable clamp
33	251 804 680	1	ring - driving cable
34	251 804 830	1	driving cable
35	251 804 860	1	cable covering
36	547 000 210	2	knurled knob 6x16
37	951 699 530	1	set of 2 splined shafts and 1 upper roller

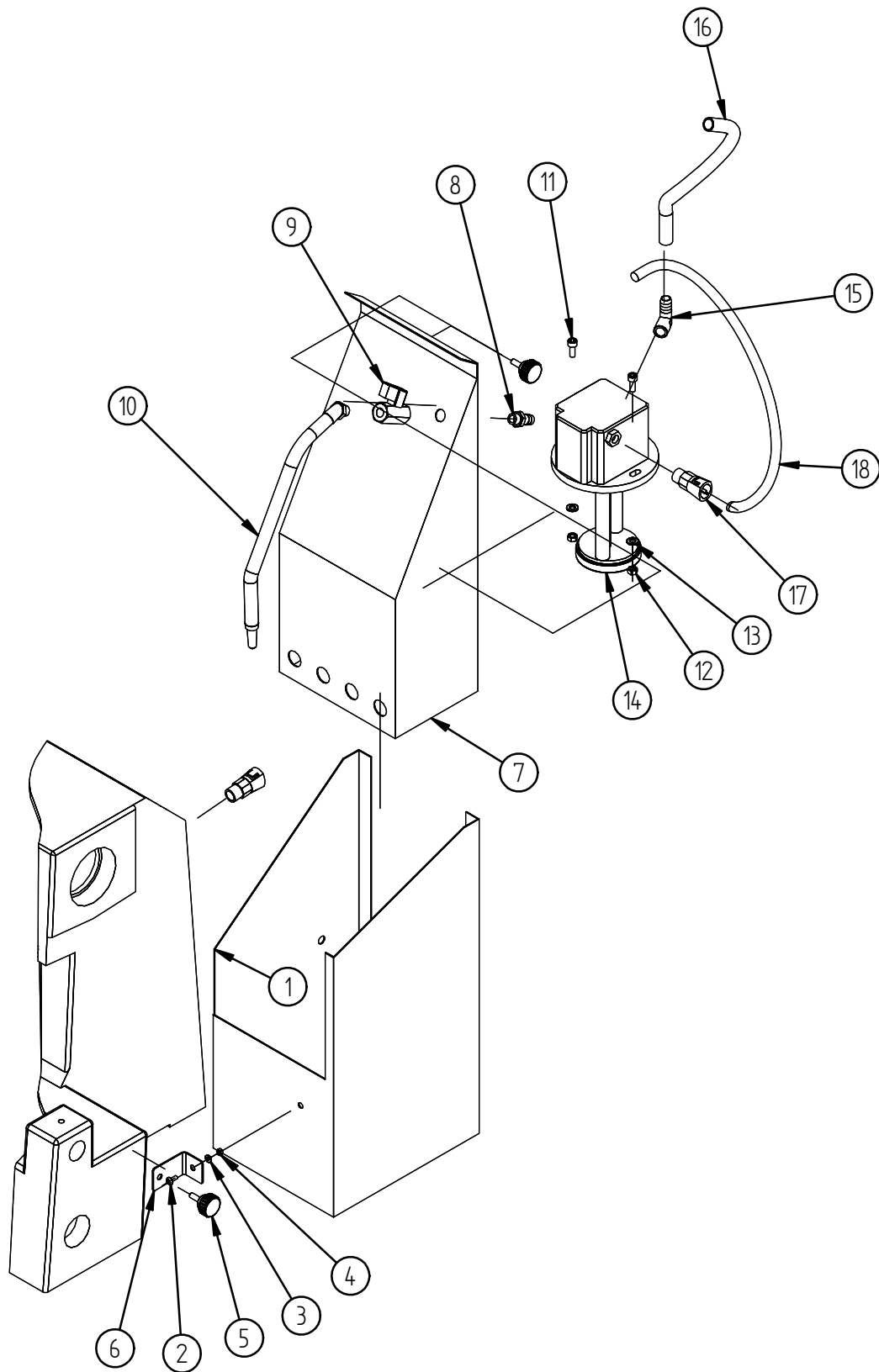
VR 416 - VALVE DRIVING UNIT ASSEMBLY



VR 416 - VALVE DRIVING UNIT ASSEMBLY

Ref	Code	Q	Part name
1	251 804 080	1	motoreducer TRSTC K31 1/140
2	251 804 050	1	flange - motoreducer support
3	555 304 008	4	screw TSPEI 4x8
4	151 607 350	1	motoreducer cover
5	555 660 010	2	screw COMBI 4x10
6	555 700 613	4	washer 6x13
7	555 106 015	4	screw TCEI 6x15
8	542 001 030	1	emergency push-button
9	541 900 029	1	potentiometer 10KO with handle
10	542 001 064	1	push button ISR3SAD300

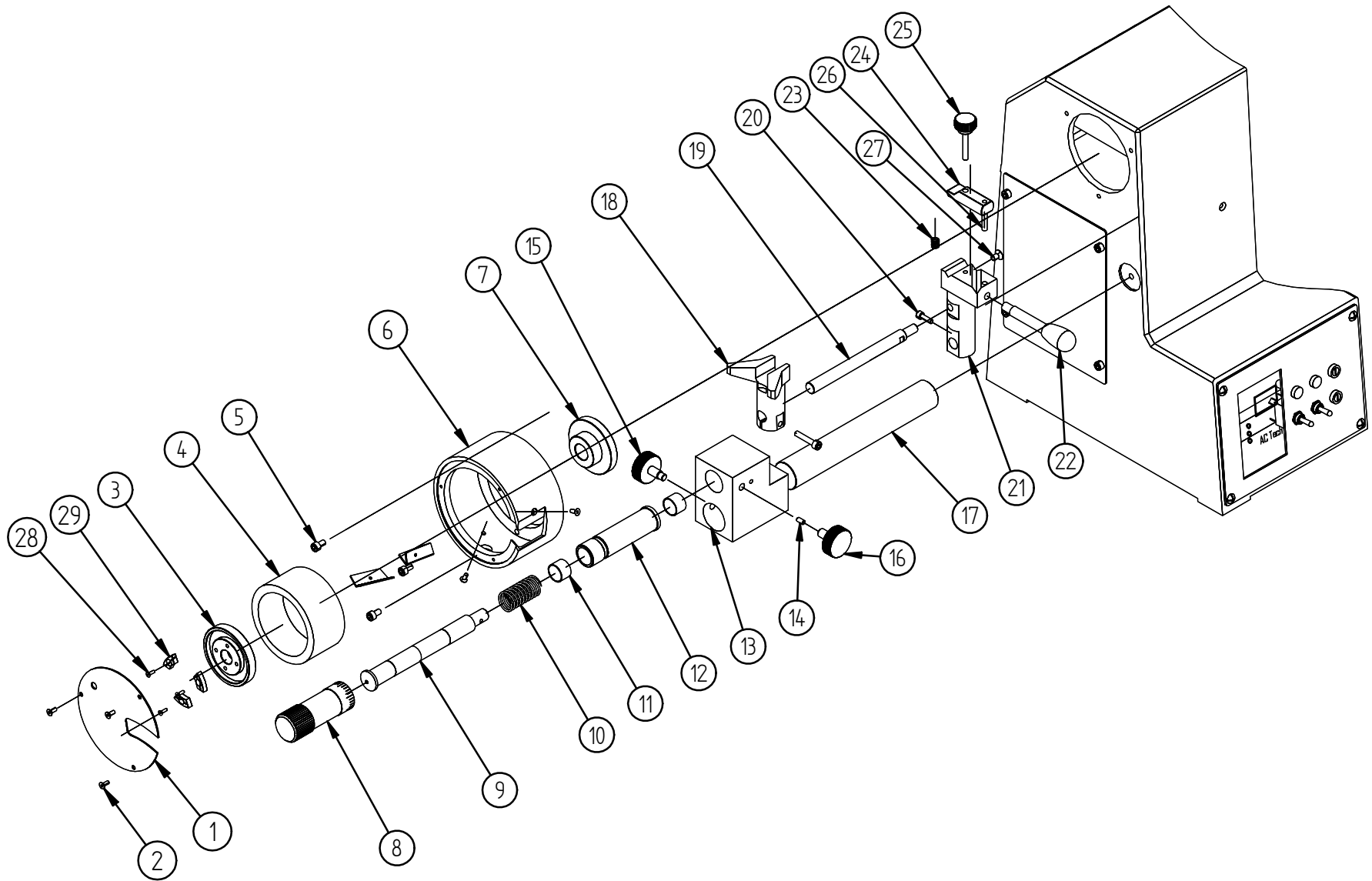
VR 416 - PUMP ASSEMBLY



VR 416 - PUMP ASSEMBLY

Ref	Code	Q	Part name
1	251 808 070	1	coolant tank
2	555 660 010	1	screw COMBI 4x10
3	555 700 409	1	washer 4x9
4	555 751 004	1	nut M4
5	547 000 210	2	knurled knob 6x16
6	251 808 130	1	bracket - coolant tank
7	251 808 130	1	pump support
8	543 016 015	1	hose connection 2601 12 ¼
9	543 028 020	1	tap F-F ¼ 4030
10	251 808 450	1	coolant spout
11	555 106 015	2	screw TCEI 6x15
12	555 751 006	2	nut M6
13	555 700 613	2	washer 6x13
14	517 500 200	1	pump SA85 24V
15	543 016 050	1	elbow connection
16	251 808 480	1	coolant hose 300 mm
17	541 106 855	2	fitting 12 - 3/8"
18	541 106 710	1	covering INDPL Ø10 3/8"

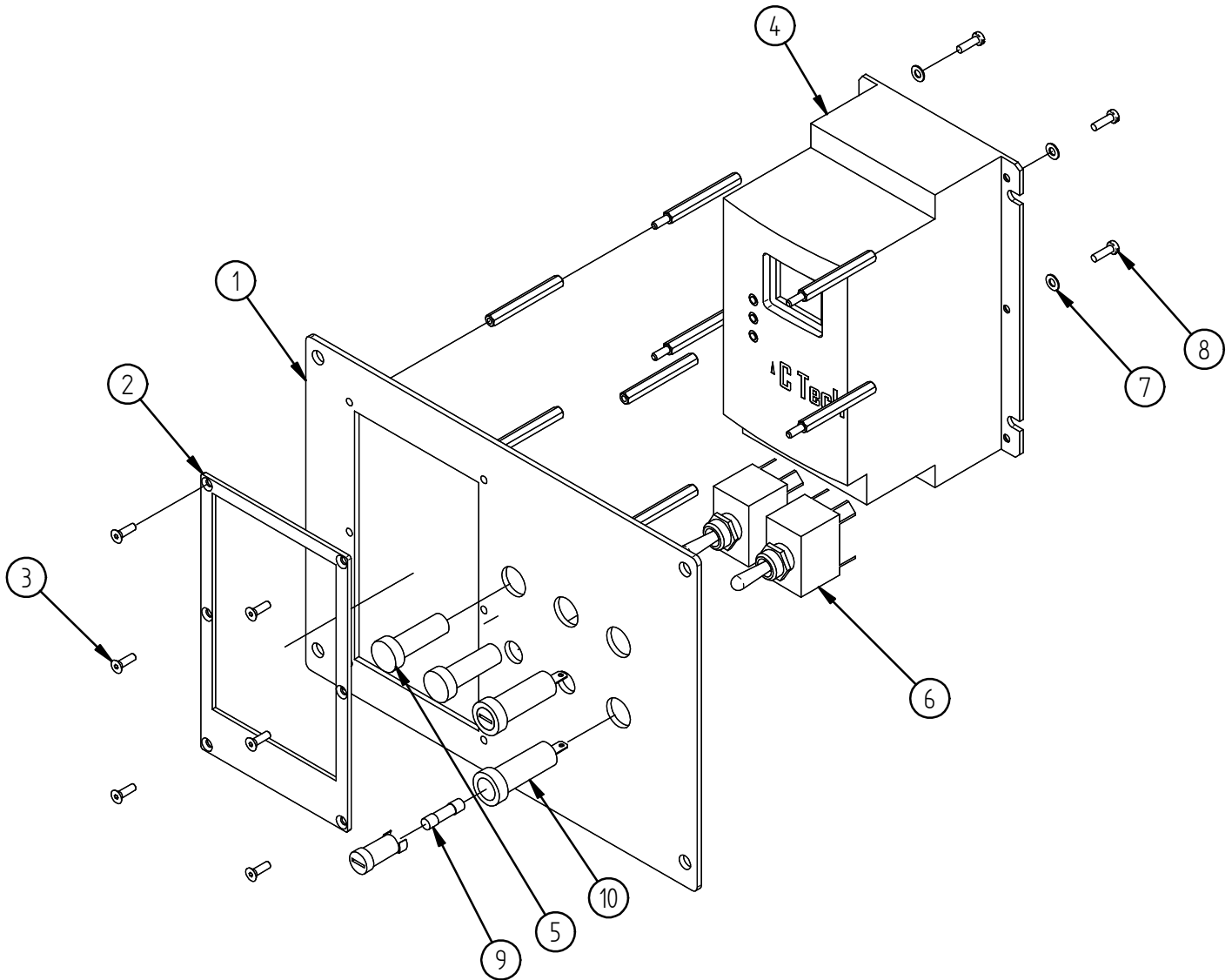
VR 416 - SECONDARY GRINDING WHEEL APPLICATION



VR 416 - SECONDARY GRINDING WHEEL APPLICATION

Ref	Code	Q	Part name
1	251 806 622	1	wheel protection - plate
2	555 304 010	3	screw TSPEI 4x10
3	251 806 330	1	wheel nut w/balance - ASM
4	535 200 030	1	secondary wheel RV0094
5	555 106 010	7	screw TCEI 6x10
6	251 806 390	1	wheel protection - ASM
7	251 806 300	1	wheel flange - ASM
8	251 805 190	1	regulating handle
9	251 805 160	1	shaft - wheel dresser
10	251 805 130	1	spring - wheel dresser
11	550 302 015	2	bush 20/30/15
12	251 805 100	1	sleeve - wheel dresser
13	251 806 060	1	block
14	251 806 120	1	pin - regul. locking knob
15	251 806 090	1	locking knob - ASM shaft
16	251 806 150	1	locking knob - ASM regulat.
17	251 806 040	1	supprting shaft - ASM
18	251 806 270	1	Y valve stop - ASM
19	251 806 240	1	pin - stem support L ASM
20	555 105 016	1	screw TCEI 5x16
21	251 806 180	1	stem support - ASM
22	547 000 236	1	lever BL368
23	251 806 450	1	spring 9x25
24	251 806 210	1	Plate - stem support ASM
25	547 000 210	1	knob 6x40
26	555 106 030	2	screw TCEI 6x30
27	555 306 010	1	screw TSPEI 6x10
28	555 303 010	3	screw TSPEI 3x10
29	251 806 360	1	balancing weight - ASM

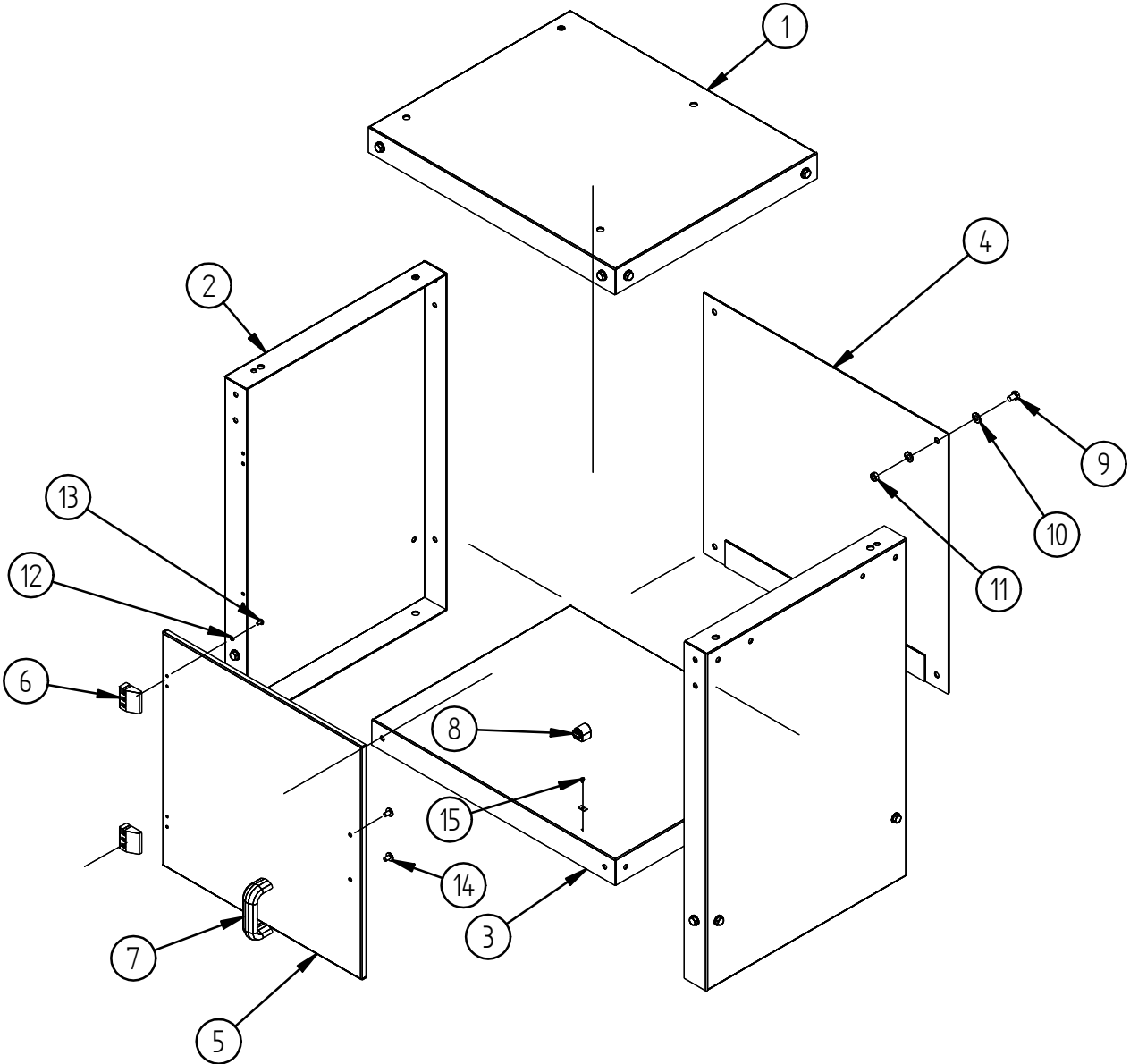
VR 416 - CONTROL PANEL ASSEMBLY



VR 416 - CONTROL PANEL ASSEMBLY

Ref	Code	Q	Part name
1	251 808 570	1	control panel
2	251 808 600	1	inverter frame
3	555 303 010	6	screw TSPEI 3x10
4	541 900 044	1	inverter SM210S
5	542 001 060	2	signal lamp Ø10
6	541 100 062	2	toggle switch T215K - A
7	555 700 409	4	washer 3.5x7
8	555 580 310	4	screw M3x10
9	540 902 110	2	fuse 5x20 1A
10	540 902 052	2	fuse holder 5x20 - panel

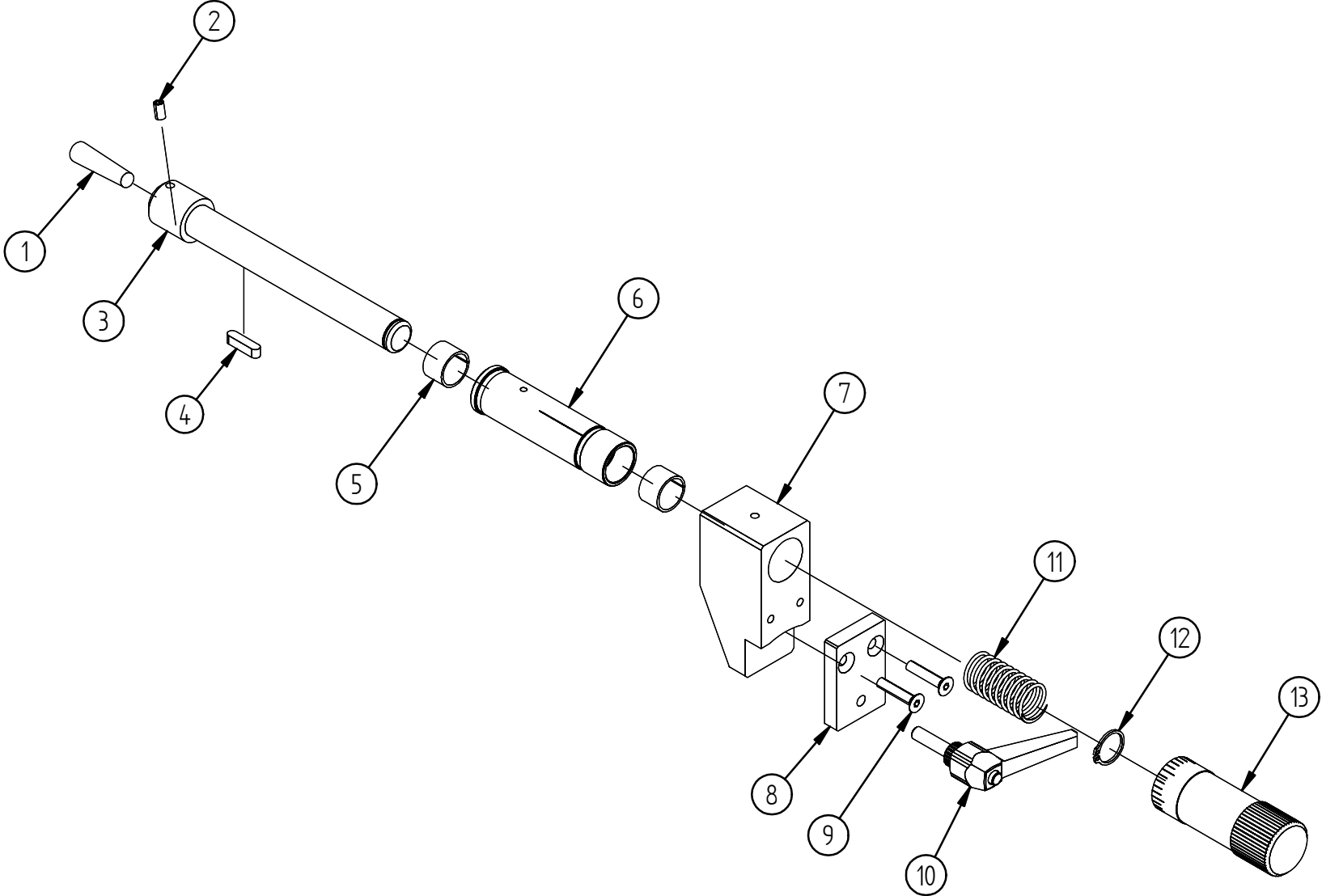
RV0110 - CABINET ASSEMBLY



RV0110 - CABINET ASSEMBLY

Ref	Code	Q	Part name
1	151 609 054	1	upper tray
2	151 609 074	2	lateral panel
3	151 609 064	1	lower tray
4	151 609 084	1	back panel
5	151 609 094	1	door
6	547 000 410	2	hinge - 422811 CFD.40B-M4
7	547 000 252	1	handle M243/100
8	548 010 060	1	magnetic block
9	555 208 012	20	screw TE 8x12
10	555 700 817	40	washer 8x17
11	555 751 008	20	nut M8
12	555 720 408	8	tab washer 4x8
13	555 570 408	8	screw COMBI 4x7.5
14	555 750 610	2	screw TBL COMBI 6x10
15	555 303 004	1	screw TSPEI M3x4

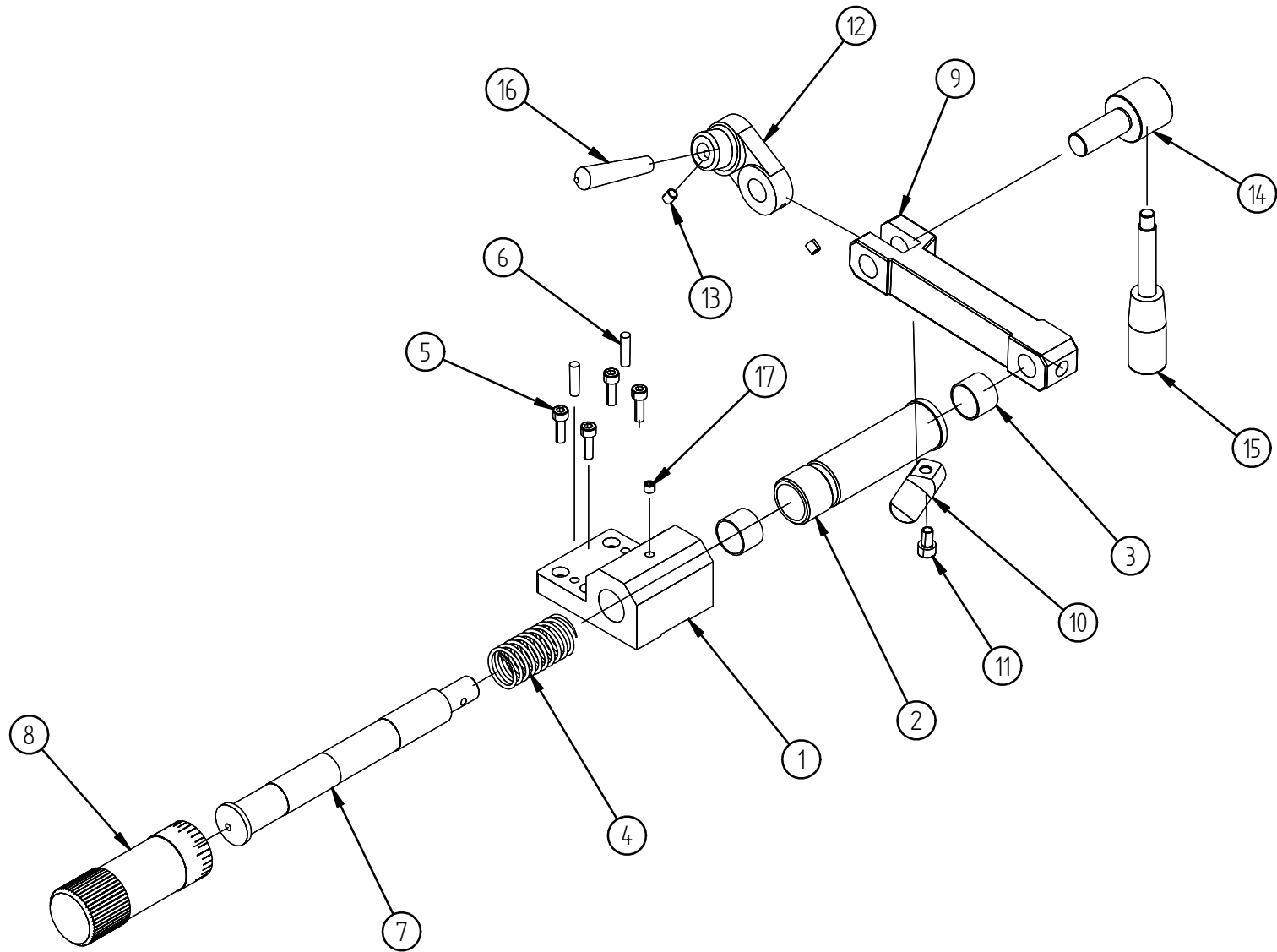
VR 416 - WHEEL DRESSER ASSEMBLY



VR 416 - WHEEL DRESSER ASSEMBLY

Ref	Code	Q	Part name
1	537 080 020	1	wheel dressing diamond RV0098
2	555 406 010	1	screw STEI 6x10 pna.
3	251 805 470	1	shaft
4	551 106 025	1	linguetta tipo A 6x6x25
5	550 302 015	2	autolubracating bush Ø20
6	251 805 410	1	sleeve
7	251 805 430	1	supporting block
8	251 805 450	1	plate
9	555 306 030	2	screw TSPEI 6x30
10	547 000 264	1	handle MRX.63 p-M8x30
11	251 805 130	1	spring - wheel dresser
12	551 500 020	1	circlip est. Ø20
13	251 805 190	1	regulating handle

VR 416 - WHEEL DRESSER ASSEMBLY



VR 416 - WHEEL DRESSER ASSEMBLY

Ref	Code	Q	Part name
1	251 800 360	1	base - wheel dresser
2	251 805 100	1	sleeve - wheel dresser
3	251 805 100	2	sleeve - wheel dresser
4	251 805 130	1	spring - wheel dresser
5	555 105 016	5	screw TCEI 5x16
6	551 305 020	2	conical pin Ø5x20
7	251 805 160	1	shaft wheel dresser
8	251 805 190	1	regulating handle
9	251 805 470	1	jocke - wheel dresser
10	251 805 220	1	rotation stop - wheel dresser
11	555 106 010	1	screw TCEI 6x10
12	251 800 440	1	diamond holder - wheel dresser
13	555 406 006	2	screw STEI 6x6 pna
14	251 805 250	1	shaft - diamond holder
15	547 000 233	1	lever BL.336
16	537 080 020	1	dressing diamond RV0098
17	555 506 006	1	screw STEI 6x6 cnc