

ROTTLER

H85AXY 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 or intlparts@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



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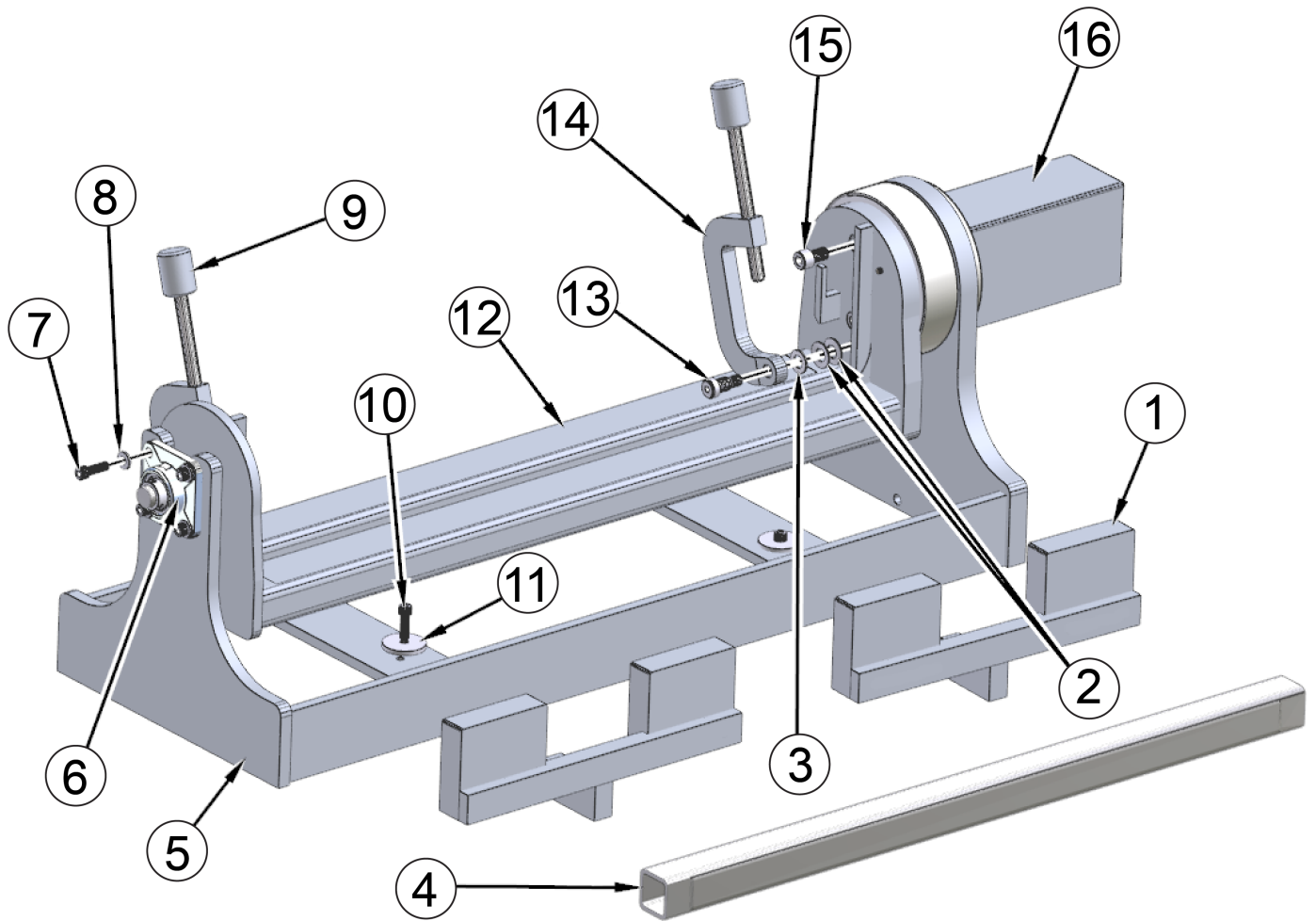
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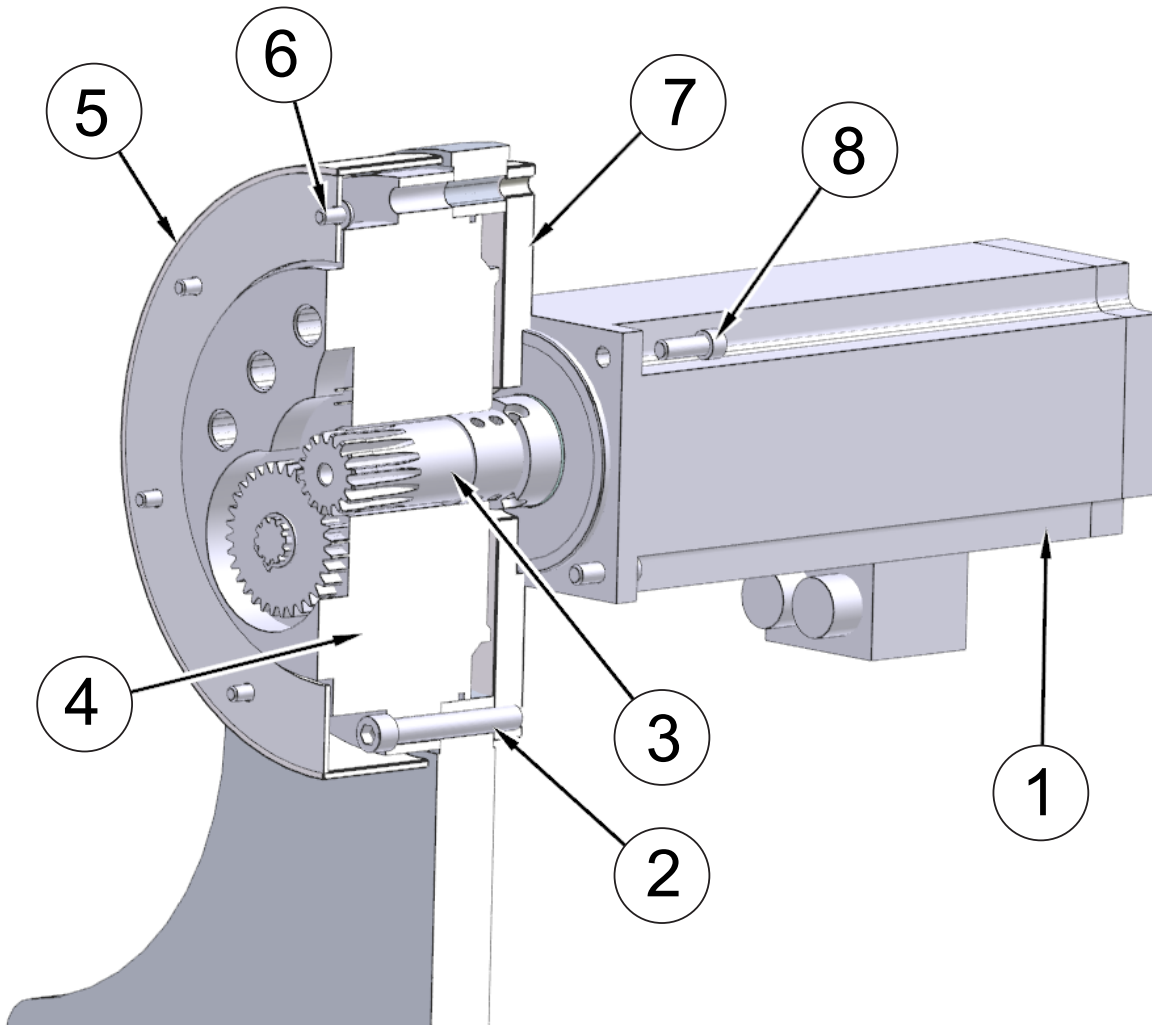
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Optional Fixturing

514-14-60 Automatic Programmable Roll Over Fixture Parts

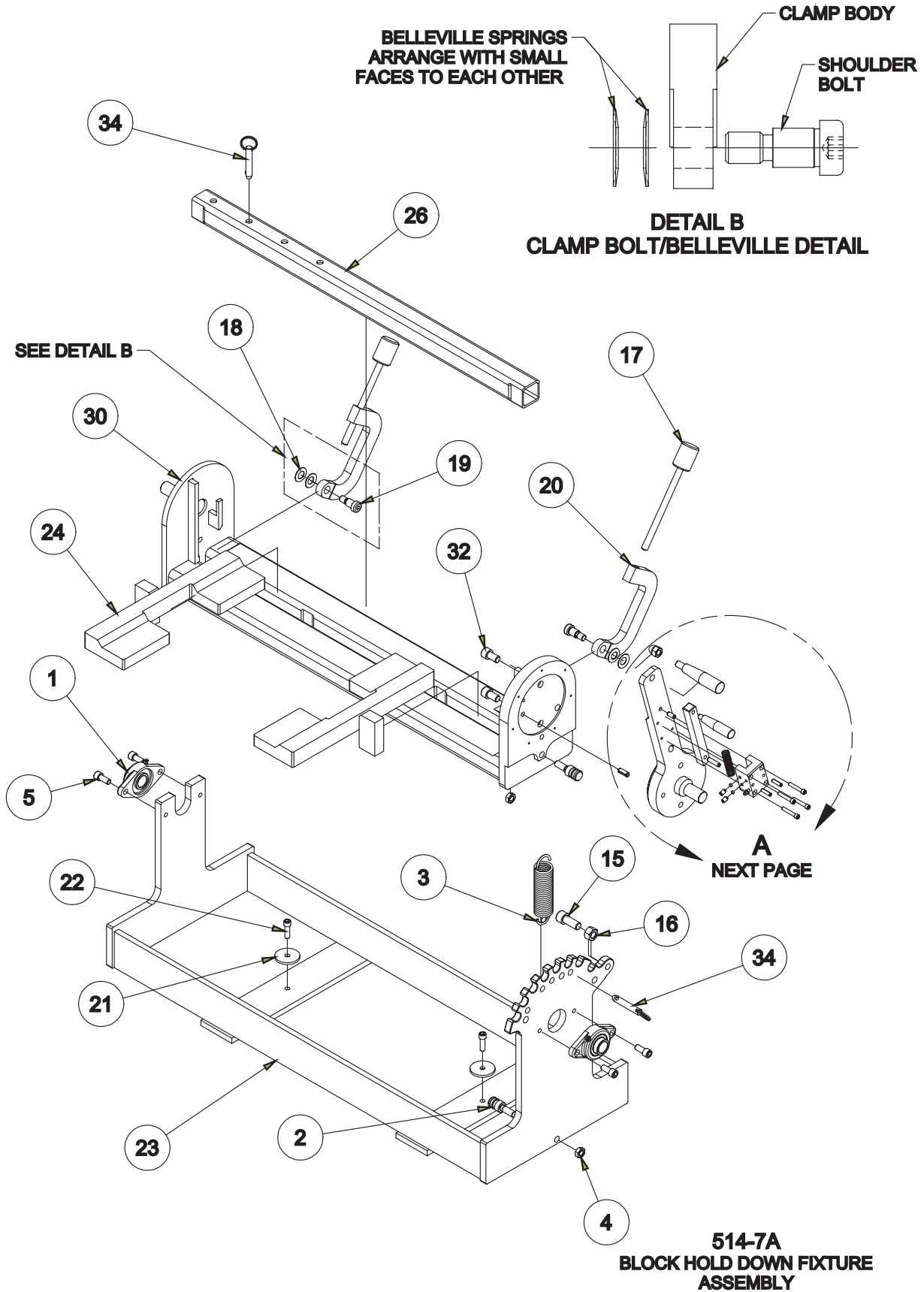


ITEM	PART #	DESCRIPTION
1	514-7-15	SUPPORT, BLOCK
2	514-7-21	WASHER, BELLEVILLE
3	514-7-20	WASHER, THRUST
4	514-7-14B	BAR, CLAMP
5	514-13-14A	BASE
6	514-13-14L	BEARING, END
7	MF-32	SOCKET HEAD CAP SCREW 3/8-16 X 1 1/4"
8	MF-179A	FLAT WASHERS 3/8"
9	7223	KNOB ASSY
10	MF-32	SOCKET HEAD CAP SCREW 3/8-16 X 1 1/4"
11	514-7-1C	WASHER, HOLD DOWN
12	514-7-14C	LOCATOR BAR, SMALL
13	MF-155	SHOULDER SCREW 3/8 X 3/4"
14	514-7-10A	ARM, CLAMP
15		M14X2 X 25 SOCKET HEAD CAP SCREW
16	514-13-14M	COVER, MOTOR



ITEM	PART #	DESCRIPTION
1	650-3-93B	SERVO MOTOR WITH BRAKE
2	MF-27C	SOCKET HEAD CAP SCREW 5/16-18 X 2 1/4"
3	5506D	INPUT SHAFT
4	5506C	GEARBOX ASSEMBLY
5	514-13-14K	COVER, GEAR BOX
6	MF-88	SOCKET BUTTON HEAD SCREW 10-24 X 3/8"
7	514-13-14J	ADAPTOR, MOTOR GEAR BOX
8	MF-14	SOCKET HEAD CAP SCREW 1/4-20 X 3/4"

514-7A Manual Indexable Roll Over Fixture Parts

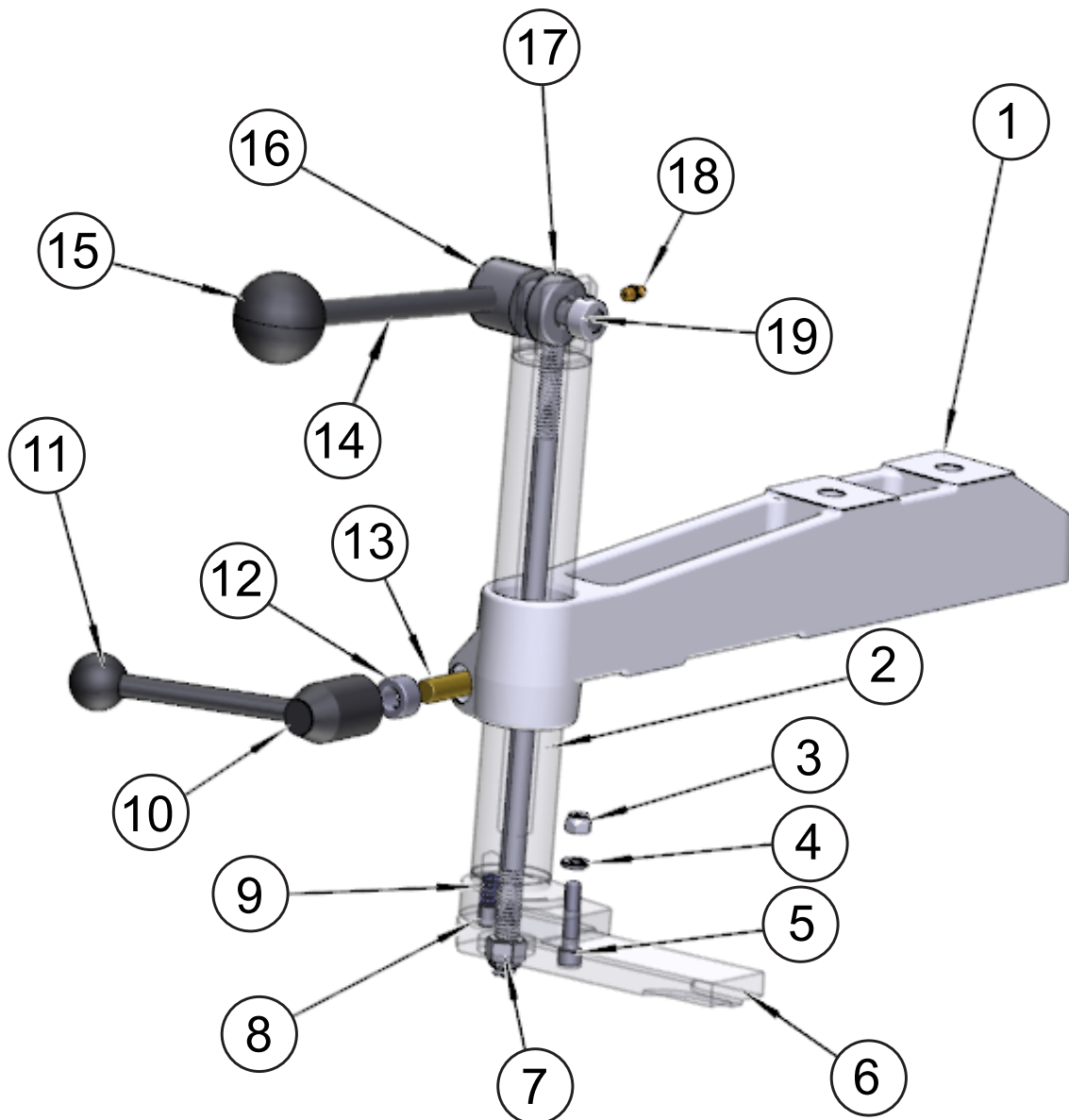


514-7A BLOCK HOLD DOWN FIXTURE ASSEMBLY - HONE			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	514-7-13	BLOCK, FLANGE, BLOCK HOLDDOWN FIXTURE
2	2	514-3-72A	PIN, SPRING RETAINER, BLOCK HOLD DOWN FIXTURE
3	1	514-3-34A	SPRING, EXTENSION - BLOCK HOLD DOWN FIXTURE
4	2	MF-165	1/2-13UNC HEX NUT
5	4	MF-39	7/16-14UNC x 1" LG. S.H.C.S.
6	1	514-3-56A	INDEX PIN SUPPORT - BLOCK HOLD DOWN FIXTURE HONE
7	1	514-7-9B	INDEX PIN - BLOCK HOLD DOWN FIXTURE - HONE
8	1	MF-227A	5/16" x 1-1/4" LG. ROLL PIN
9	1	MF-227B	5/16" x 3/4" LG. ROLL PIN
10	1	514-3-58A	HANDLE, INDEX - BLOCK HOLD DOWN FIXTURE - HONE
11	1	514-3-59B	HANDLE, PIVOT ARM - BLOCK HOLD DOWN FIXTURE & V6/V8 AIR FIXTURE
12	1	514-3-70	SPRING, HANDLE RETURN
13	4	MF-17	1/4-20UNC x 1-1/2" LG. S.H.C.S.
14	2	MF-226	1/4" x 1" LG. ROLL PIN
15	1	MF-46A	5/8-11UNC x 1-1/2" LG. S.H.C.S.
16	1	MF-166	5/8-11UNC HEX NUT
17	2	7223	CLAMP ASSEMBLY - MANUAL V6/V8 COMB. FIXTURE
18	4	514-7-21	Bellville Spring
19	2	514-7-22A	5/8 x 3/4" LG. SOCKET SHOULDER SCREW
20	2	514-7-10A	CLAMP ARM (MACHINING), BLOCK HOLD DOWN FIXTURE - HONE
21	2	514-7-1C	WASHER, HOLDDOWN - BLOCK HOLDDOWN FIXTURE - HONE
22	2	MF-32	S.H.C.S.3/8 - 16 UNC - 1 1/4
23	1	514-7-1E	MAIN FRAME REDESIGN (MACHINING)
24	2	514-7-15	SUPPORT, BLOCK - BLOCK HOLD DOWN FIXTURE
25	1	514-3-59C	1/2-13UNC ACORN NUT
26	1	514-7-14B	BAR, CLAMP - HOLD DOWN FIXTURE
27	2	514-3-56B	TERCITE PAD
28	1	MF-189	STRAIGHT GREASE FITTING
29	1	514-7-3D	MANUAL CRADLE HANDLE (MACHINING), HONE
30	1	514-13-14C	H70 - FIXTURE CRADLE MACHINING
31	1	MF-229B	3/8" x 1" LG. ROLL PIN
32	2	650-4-49	M14x2 x 25
33	2	7212C	5/16-18UNC x .50" LG. SOCKET HALF DOG SET SCREW
34	2	7210C	PIN, GUIDE ROTTLER LEVELING TABLE

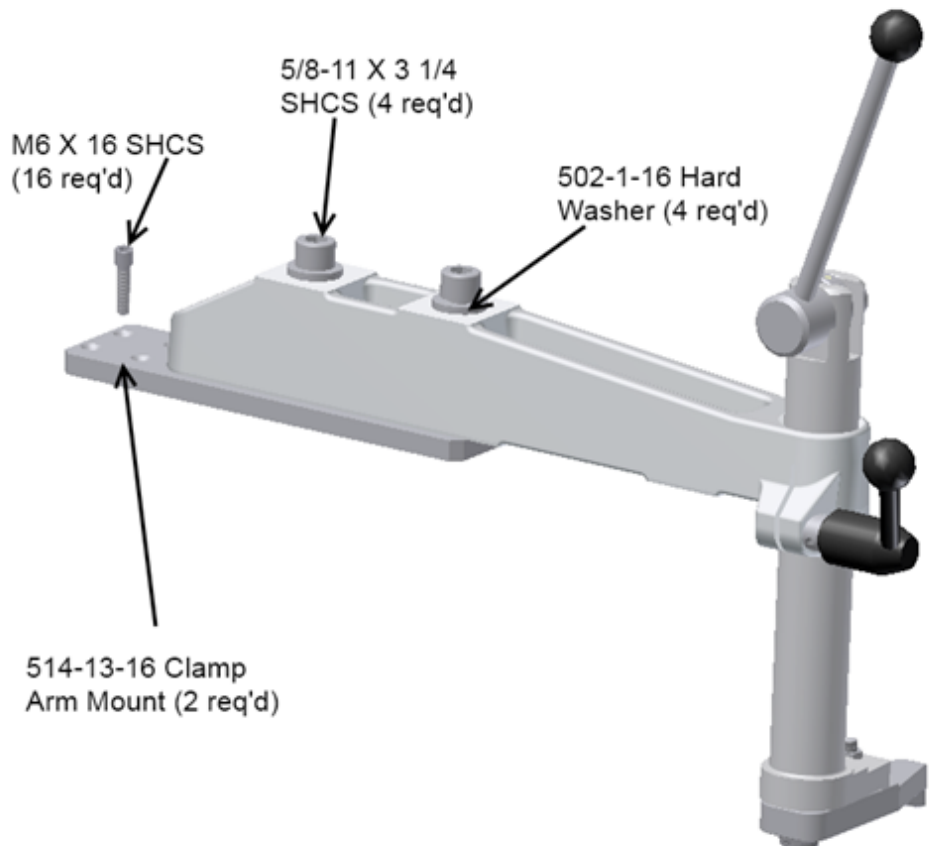
514-7-14E 2" (50.8mm) Small Diameter Main Line Tube



502-1-30H Clamp Arm Assembly Parts

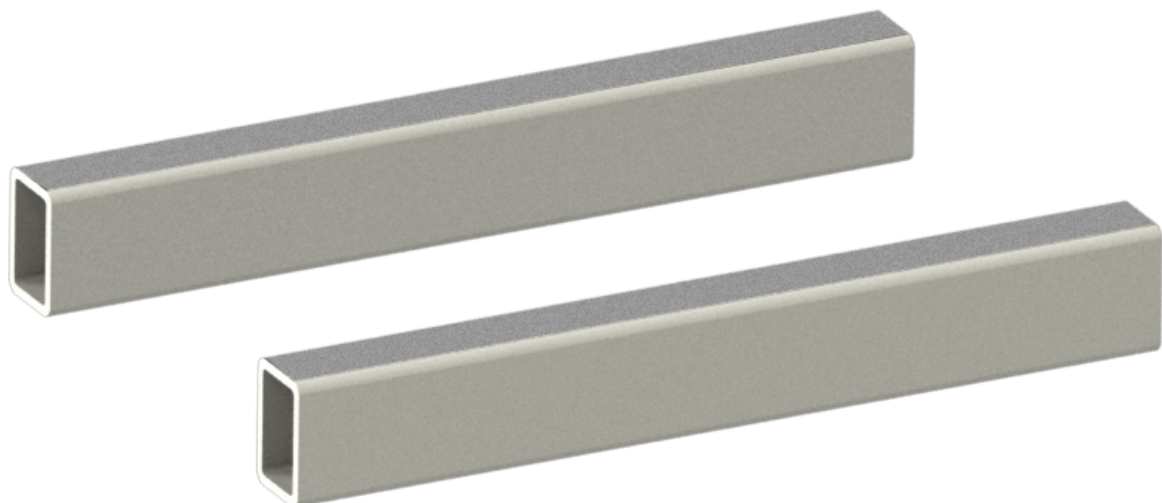


ITEM	PART #	DESCRIPTION
1	502-1-22G 502-1-22H	CLAMP ARM-LEFT CLAMP ARM-RIGHT
2	502-1-31C	LEG, CLAMP-14 1/2" LONG
3	MF-187	NYLOCK NUTS 5/16-18 NC
4	MF-184	LOCK WASHERS 5/16"
5	MF-25	SOCKET HEAD CAP SCREW 5/16-18 X 1 1/2"
6	502-1-24G	SHOE, CLAMP - HEAVY DUTY
7	502-1-25B	LOCKNUT, EYE BOLT 1/2-13NC
8	MF-211	DOWEL PIN 3/8 X 1/2"
9	500-33	SPRING, CLAMP LEG
10	514-2-39C	HANDLE,ADJUSTABLE-CLAMP STOP
11	514-2-39E	HANDLE, ADJUSTABLE CLAMP
12	7209J	COLLAR, 1/2" SHAFT
13	514-4-5B	STUD-CLAMP HANDLE
14	502-1-27	ARM, HANDLE - BLOCK CLAMP
15	502-1-28	KNOB, PLASTIC BALL - BLOCK CLAMP
16	502-1-26L 502-1-26R	CAM BODY LEFT HAND ONLY CAM BODY RIGHT HAND ONLY
17	502-1-25A	EYE BOLT ASSEMBLY
18	MF-189	1/4-28 STRAIGHT LUBE GREASE FITTING
19	502-1-29A	COLLAR (15/32 ID),CLAMP LEG

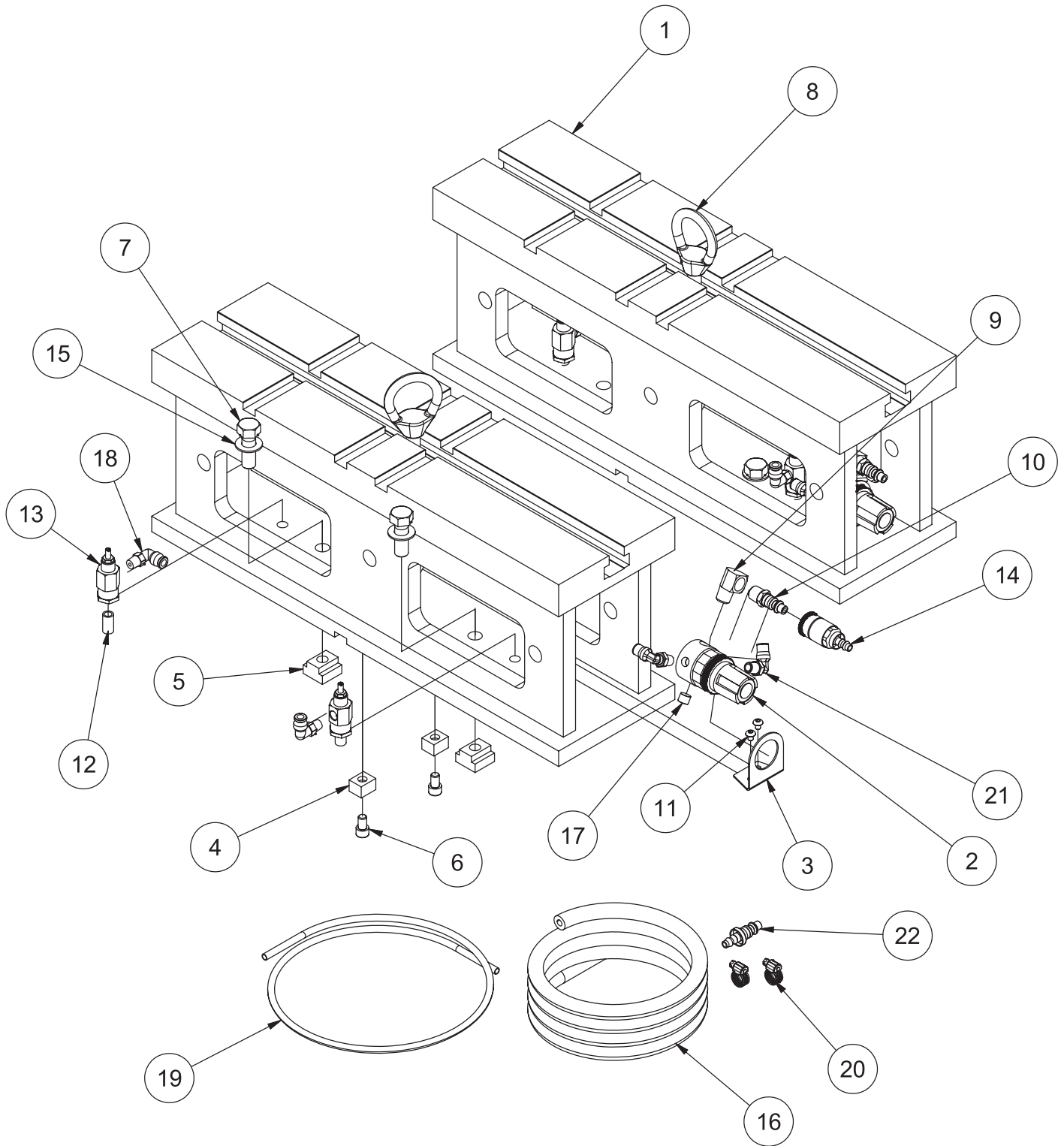


11115 2" (50mm) X 3" (75mm) Parallels

Sold only as complete assembly.



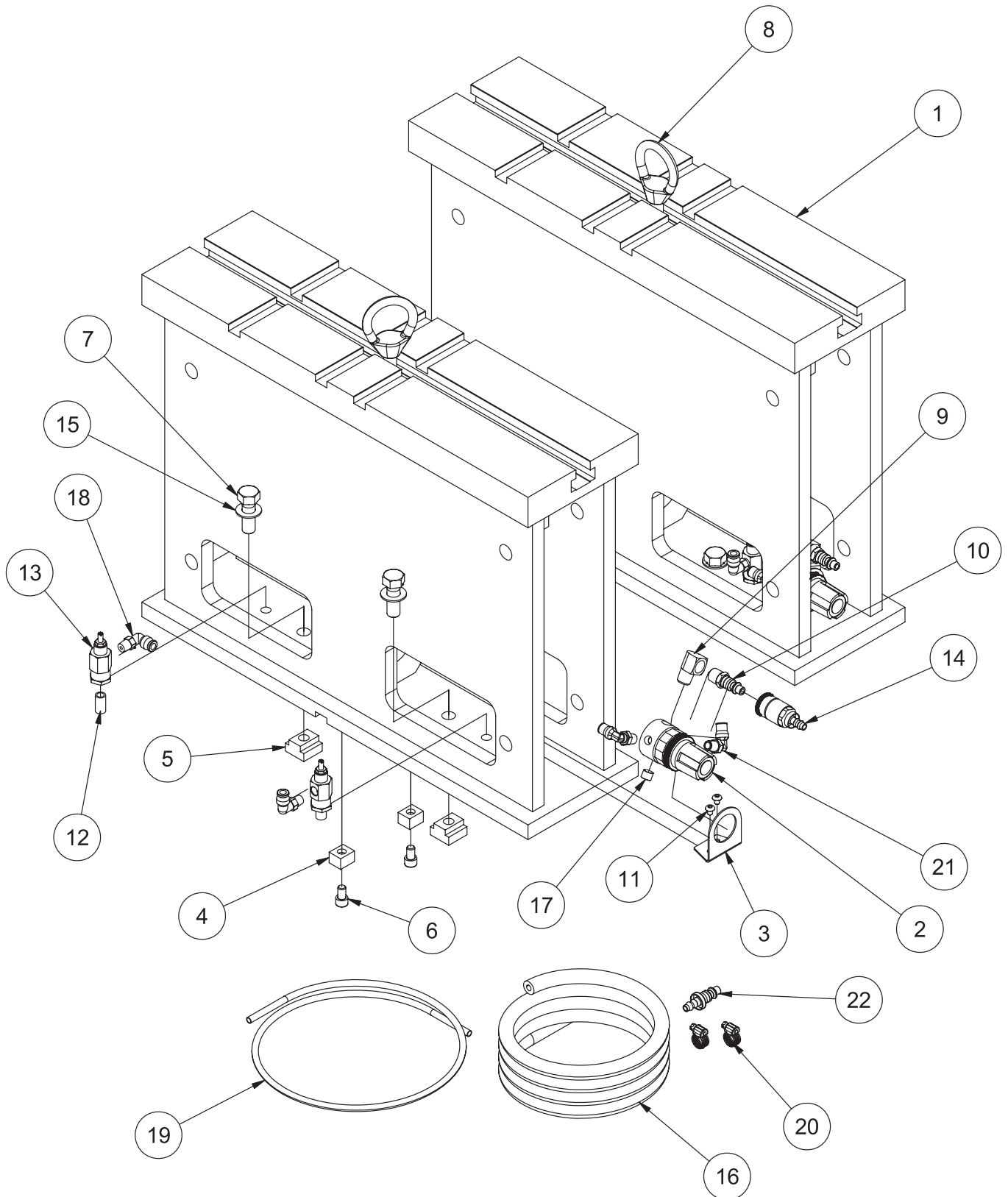
11112C Universal 8" (203mm) Heavy Duty T-Slot Parallels Parts



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	CONNECTOR, MALE THREAD 1/4 NPTF V6/V8 FIXTURE
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	4	MF-180	1/2" FLAT WASHER
16	15 FT.	502-1-98	1/4" AIR HOSE
17	2	MF-234	Countersunk Hex-Head Plug 1/8
18	4	514-4-17E	ELBOW, 90 DEGREE MALE - 1/4" POLY X 1/8" NPT
19	4 FT.	502-11-15	TUBING, BLACK POLYFLO 1/4" O.D.
20	2	502-1-97	CLAMP, 1/4" I.D. HOSE
21	4	514-4-17V	FITTING 1/8 NPT X 1/4 POLY-90 DEGREE
22	1	502-11-16Y	CONNECTOR, MALE AIR 1/4 NPTF

11114C Universal 16" (405mm) Heavy Duty T-Slot Parallels Parts

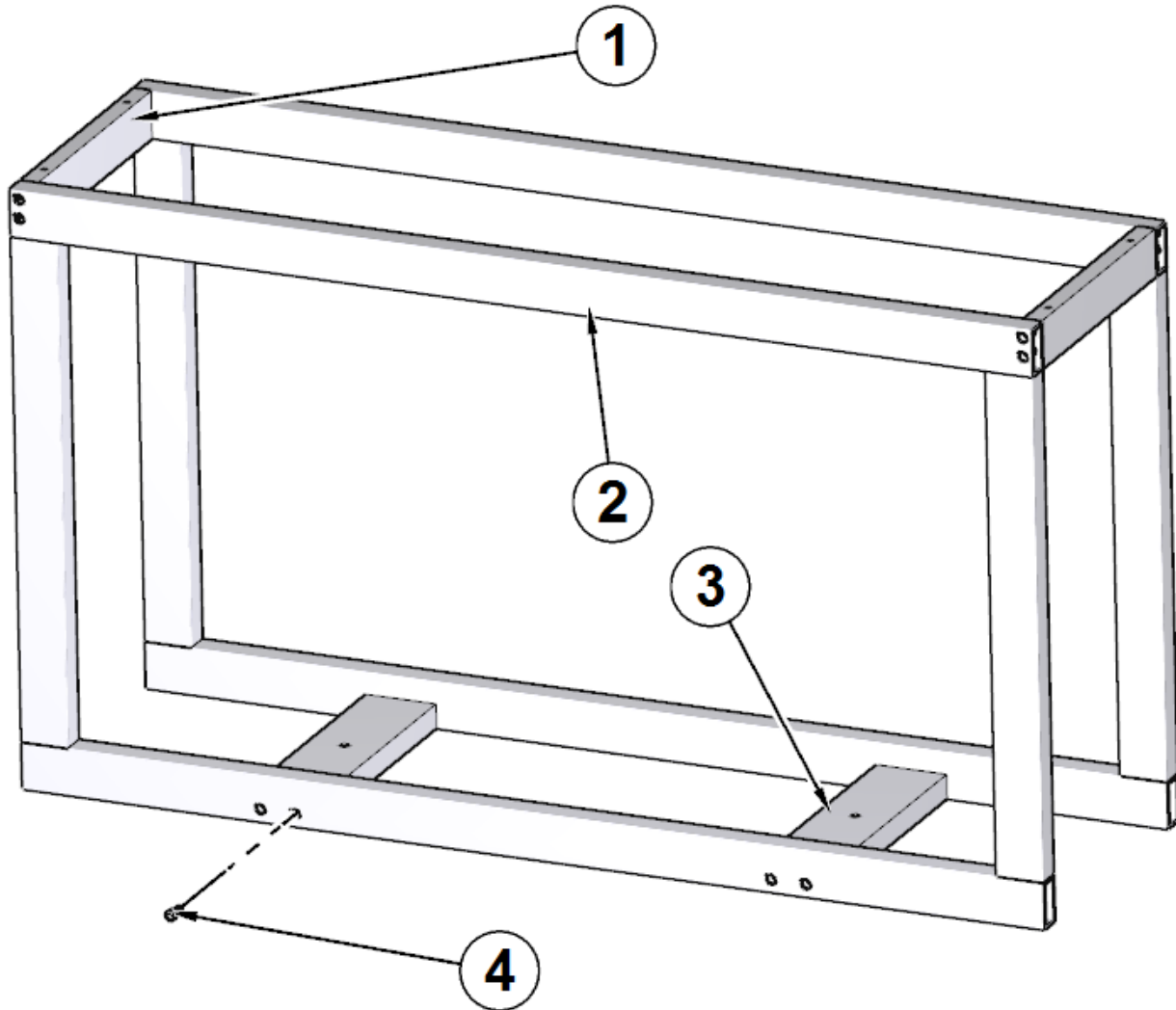


11114
16" SUPPORT PARALLEL ASSEMBLY
F70

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	CONNECTOR, MALE THREAD 1/4 NPTF V6/V8 FIXTURE
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	4	MF-180	1/2" FLAT WASHER
16	15 FT.	502-1-98	1/4" AIR HOSE
17	2	MF-234	Countersunk Hex-Head Plug 1/8
18	4	514-4-17E	ELBOW, 90 DEGREE MALE - 1/4" POLY X 1/8" NPT
19	4 FT.	502-11-15	TUBING, BLACK POLYFLO 1/4" O.D.
20	2	502-1-97	CLAMP, 1/4" I.D. HOSE
21	4	514-4-17V	FITTING 1/8 NPT X 1/4 POLY-90 DEGREE
22	1	502-11-16Y	CONNECTOR, MALE AIR 1/4 NPTF

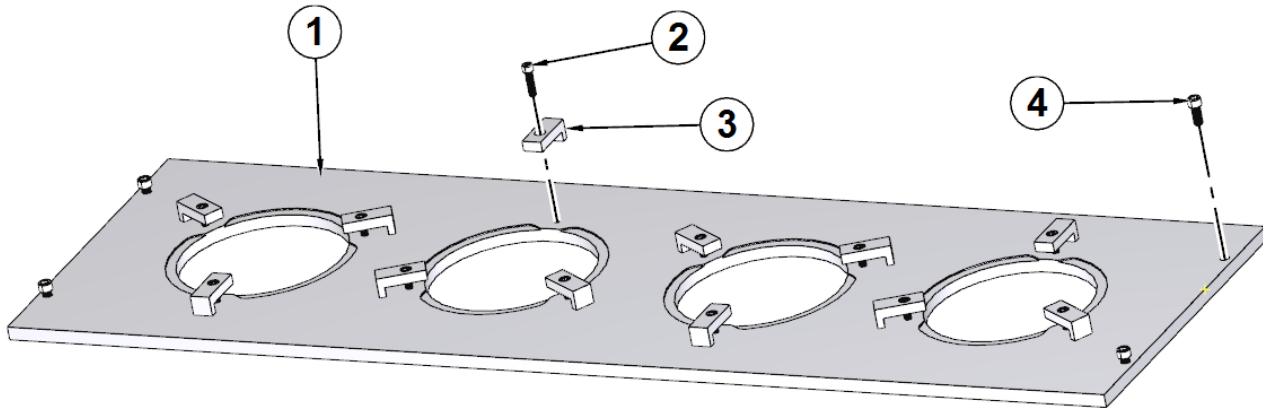
Fixture for Honing Multiple Cylinder Liners (4 Liners)

514-11-5 Cylinder Liner Honing Fixture Parts



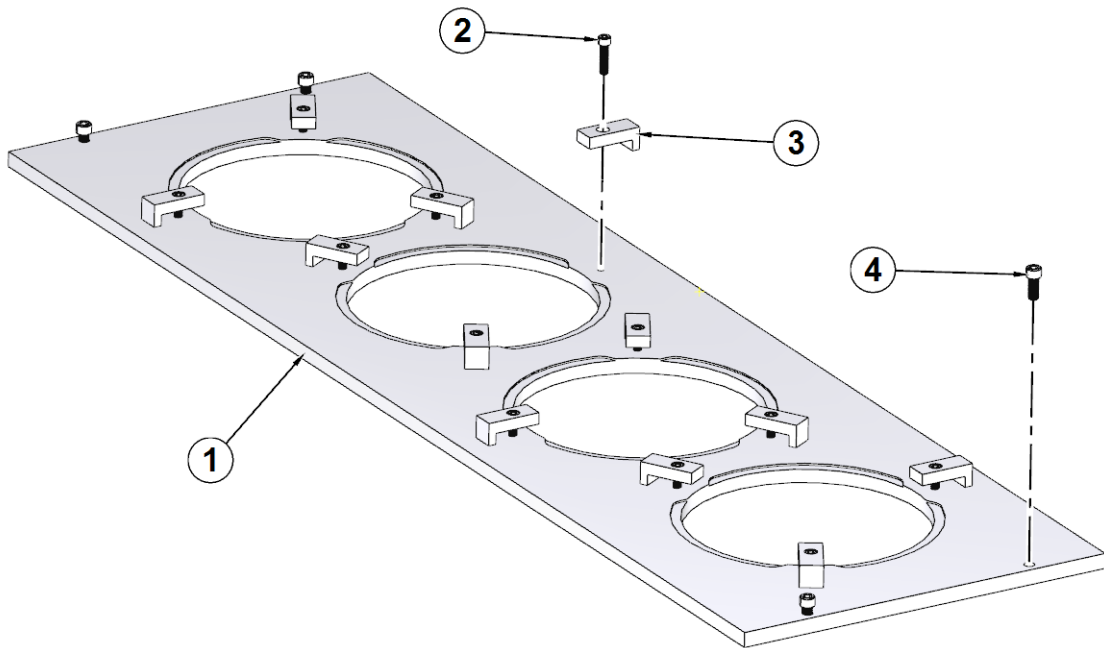
ITEM	PART #	DESCRIPTION
1	514-11-1D	UPPER CROSS BAR
2	514-11-5B	SIDE, SLEEVE FIXTURE
3	514-11-1E	LOWER CROSS BAR
4	MF-21	SOCKET HEAD CAP SCREW 5/16-18 X 5/8"

514-11-6 Fixture Plate Parts



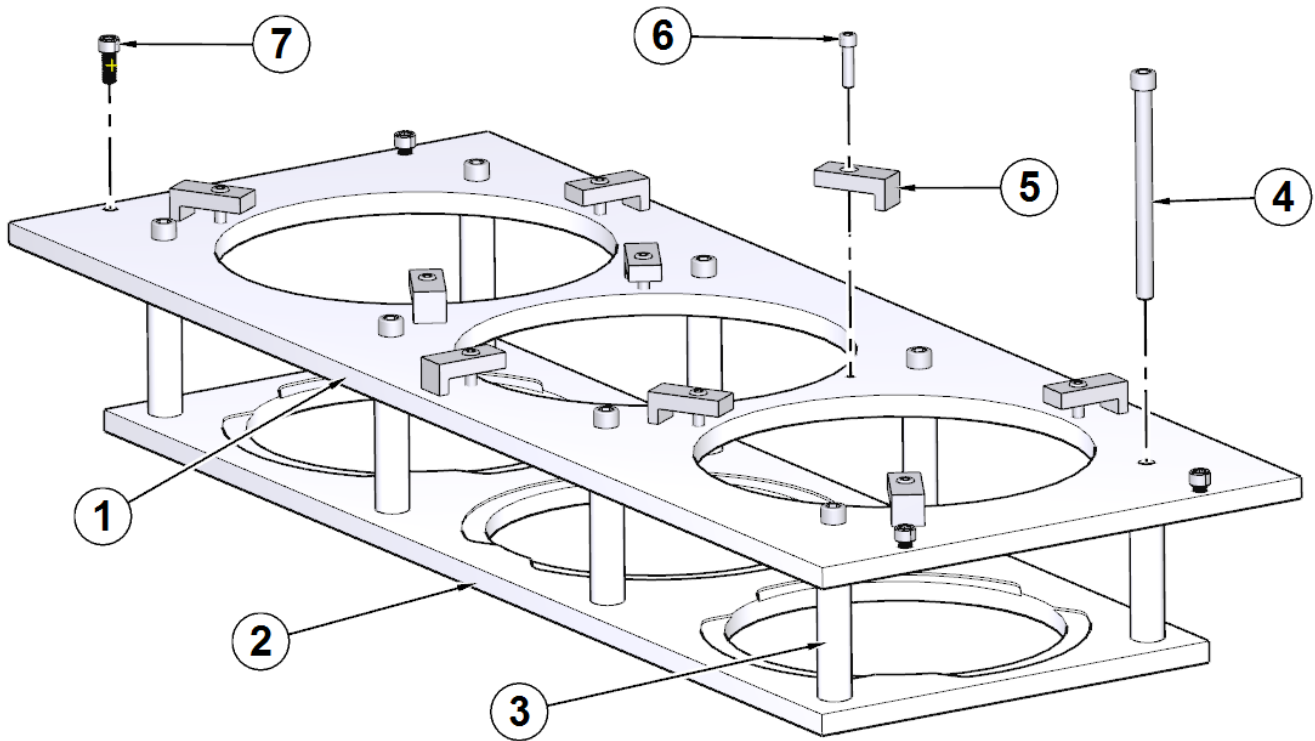
ITEM	PART #	DESCRIPTION
1	514-11-6B	PLATE, CAT 3400 SLEEVE FIXTURE
2	MF-15	SOCKET HEAD CAP SCREW 1/4-20 X 1"
3	514-11-2C	CLAMP, FIXTURE PLATE
4	MF-22	SOCKET HEAD CAP SCREW 5/16-18 X 3/4"

514-11-7 Fixture Plate Parts



ITEM	PART #	DESCRIPTION
1	514-11-7B	PLATE, CAT 3500 SLEEVE FIXTURE
2	MF-15	SOCKET HEAD CAP SCREW 1/4-20 X 1"
3	514-11-2C	CLAMP, FIXTURE PLATE
4	MF-22	SOCKET HEAD CAP SCREW 5/16-18 X 3/4"

514-11-4 Fixture Plate Parts



ITEM	PART #	DESCRIPTION
1	514-11-4A	UPPER FIXTURE PLATE
2	514-11-4C	LOWER FIXTURE PLATE
3	514-11-4E	SPACER,CAT C175 FIXTURE PLATE ASSEMBLY
4	MF-38	SOCKET HEAD CAP SCREW 3/8-16 X 5"
5	514-11-2C	CLAMP, FIXTURE PLATE
6	MF-15	SOCKET HEAD CAP SCREW 1/4-20 X 1"
7	MF-22	SOCKET HEAD CAP SCREW 5/16-18 X 3/4"

Optional Coolant and Filter Equipment

514-4-71C Synthetic Coolant

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



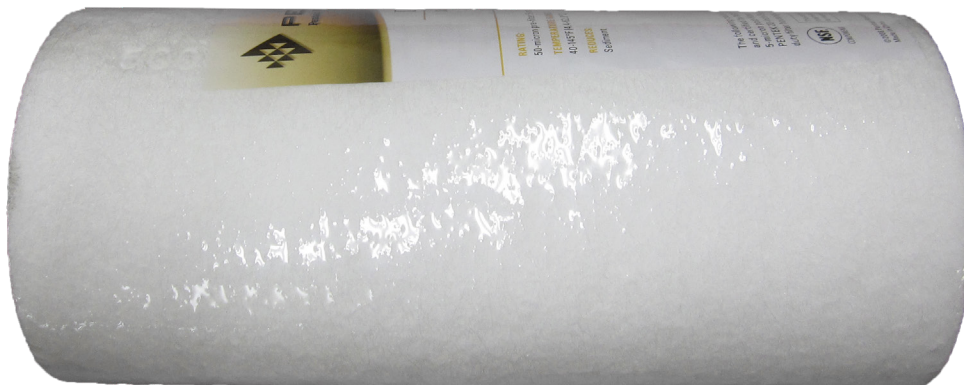
514-4-71D Coolant Refractor

Sold as complete kit only.



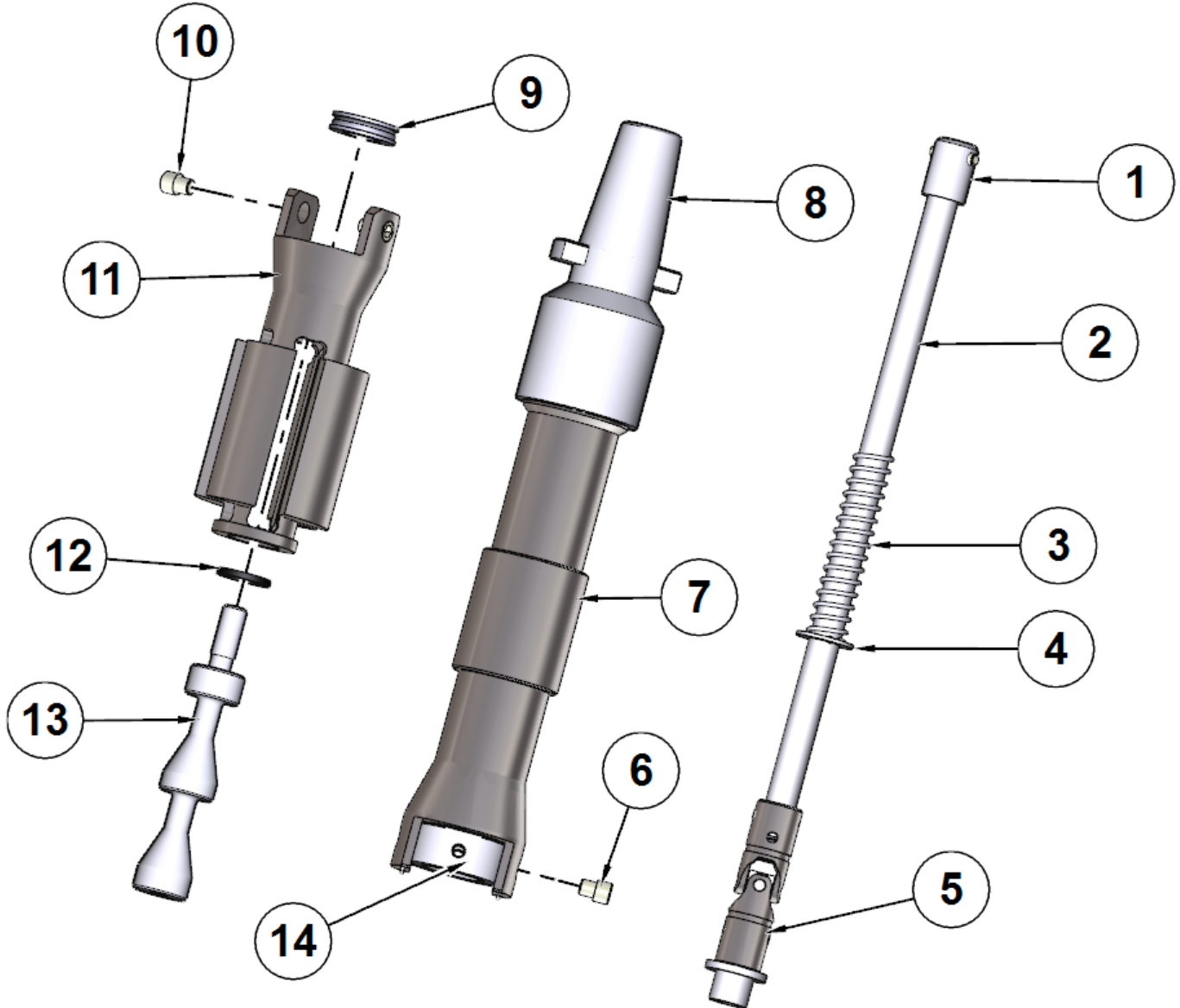
514-2-42C Dual Gradient 50-5 Micron Replacement Filter Cartridge

For standard filter system



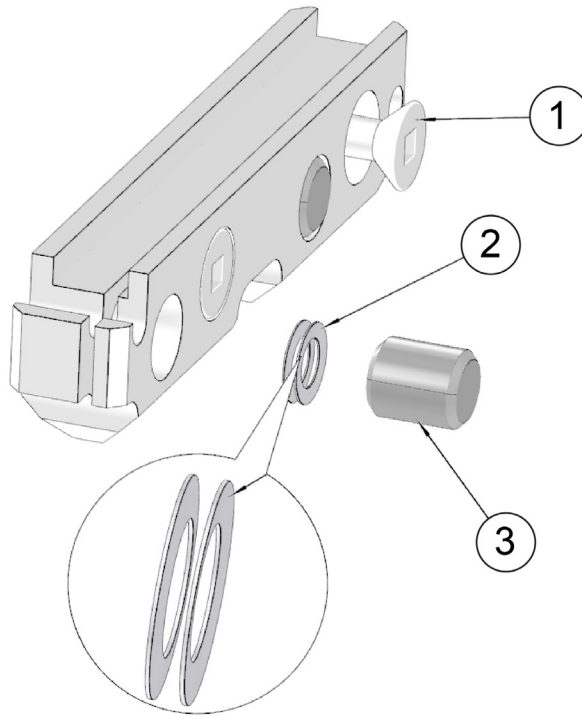
Optional Rottler Precision Hone Heads, Sleeves and Stone Holders

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



ITEM	PART #	DESCRIPTION
1	514-6-44	COUPLING, DRIVEN
2	514-10-20B	SHAFT, ADJUSTING
3	514-5-72A	SPRING, COMPRESSION
4	100-19	WASHER, THRUST
5	514-10-5A	JOINT, UNIVERSAL ASSY
6	514-10-10	SCREW, PIVOT
7	514-10-20A	YOKE
8	514-13-49	ADAPTER, KWIK SWITCH
9	514-7-82F	BEARING, THRUST
10	514-10-10	SCREW, PIVOT
11	514-10-1A	BODY
12	7209H	BUMPER
13	514-10-2A	CONE ROD
14	514-10-6	BLOCK, PIVOT

514-10-13 Series Stone Holder Parts



ITEM	PART #	DESCRIPTION
1	514-7-81J	SCREW, FLAT HEAD SQUARE DRIVE
2	514-10-11D	SPRING, BELLEVILLE
3	514-10-11C	PIN, DAMPENING

Medium Hone Head Stone Size Charts

Diameter (New Stones)

	0.312 Stones		0.200 Stones	
	Min	Max	Min	Max
514-10-13A	2.34	2.45	2.20	2.23
514-10-13F	2.44	2.55	2.22	2.33
514-10-13B	2.54	2.65	2.32	2.43
514-10-13G	2.64	2.75	2.42	2.53
514-10-13C	2.74	2.85	2.52	2.63
514-10-13H	2.84	2.95	2.62	2.73
514-10-13D	2.94	3.05	2.72	2.83

Diameter (New Stones) (Metric)

	7.925 Stones		5.08 Stones	
	Min	Max	Min	Max
514-10-13A	59.44	62.23	53.75	56.54
514-10-13F	61.98	64.77	56.29	59.08
514-10-13B	64.52	67.31	58.83	61.62
514-10-13G	67.06	69.85	61.37	64.16
514-10-13C	69.60	72.39	63.91	66.70
514-10-13H	72.14	74.93	66.45	69.24
514-10-13D	74.68	77.47	68.99	71.78

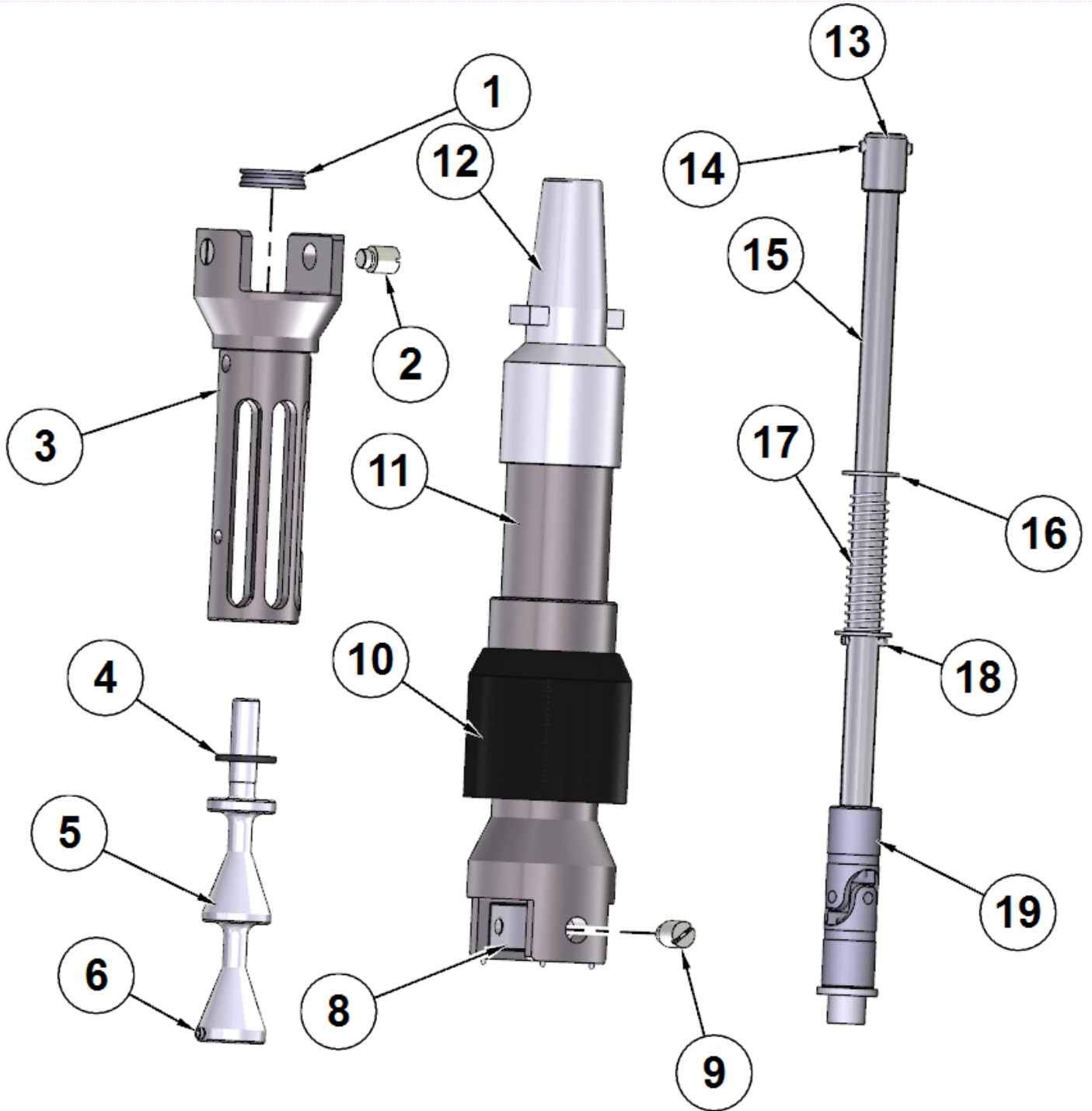
Diameter (New Brushes)

	0.550 Brushes		0.395 Brushes	
	Min	Max	Min	Max
514-10-13A	2.82	2.93	2.51	2.62
514-10-13F	2.92	3.03	2.61	2.72
514-10-13B	3.02	3.13	2.71	2.82
514-10-13G	3.12	3.23	2.81	2.92
514-10-13C	3.22	3.33	2.91	3.02
514-10-13H	3.32	3.43	3.01	3.12
514-10-13D	3.42	3.53	3.11	3.22

Diameter (New Brushes) (Metric)

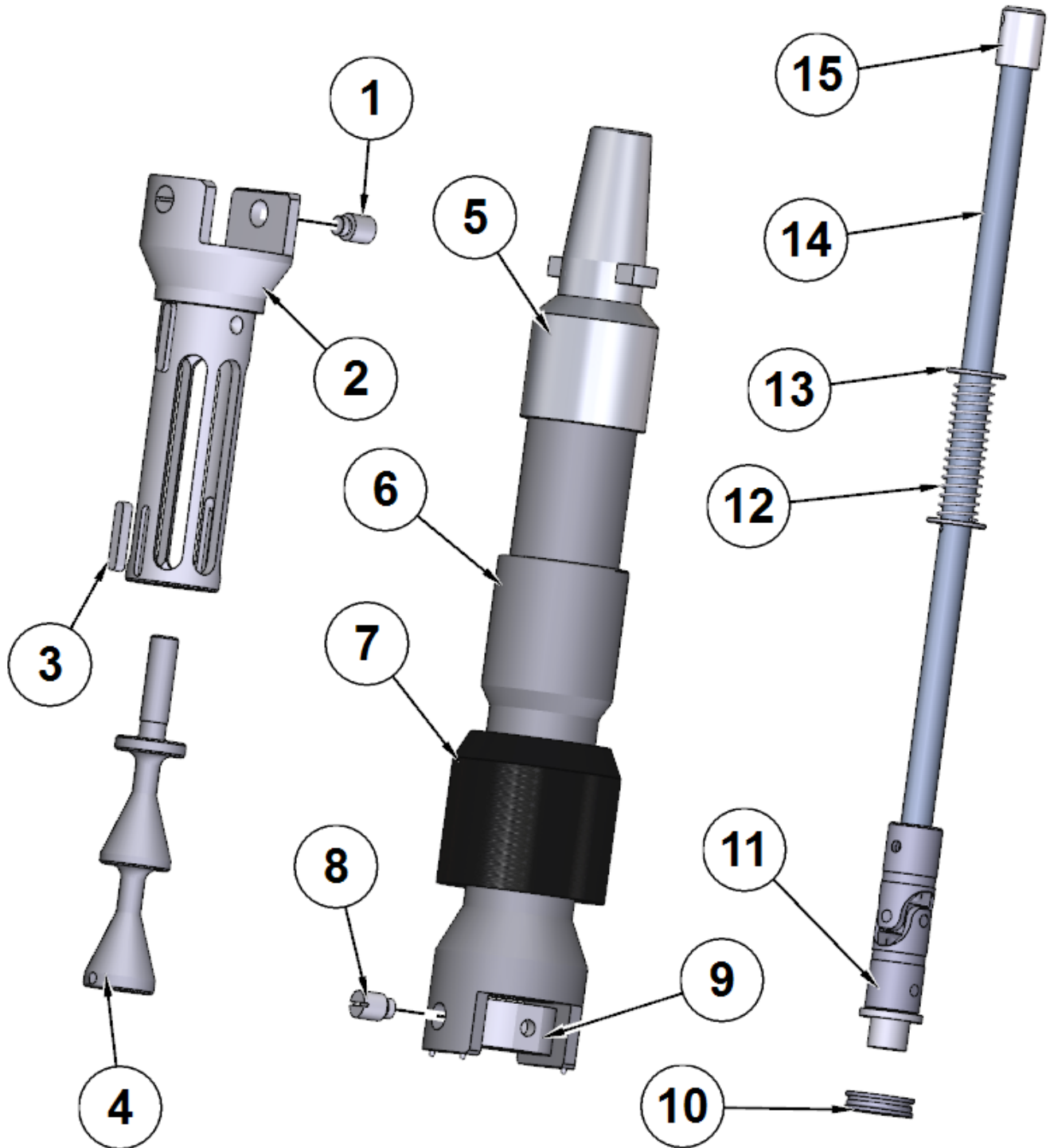
	13.970 Brushes		10.033 Brushes	
	Min	Max	Min	Max
514-10-13A	71.53	74.32	63.65	66.45
514-10-13F	74.07	76.86	66.19	68.99
514-10-13B	76.61	79.40	68.73	71.53
514-10-13G	79.15	81.94	71.27	74.07
514-10-13C	81.69	84.48	73.81	76.61
514-10-13H	84.23	87.02	76.35	79.15
514-10-13D	86.77	89.56	78.89	81.69

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

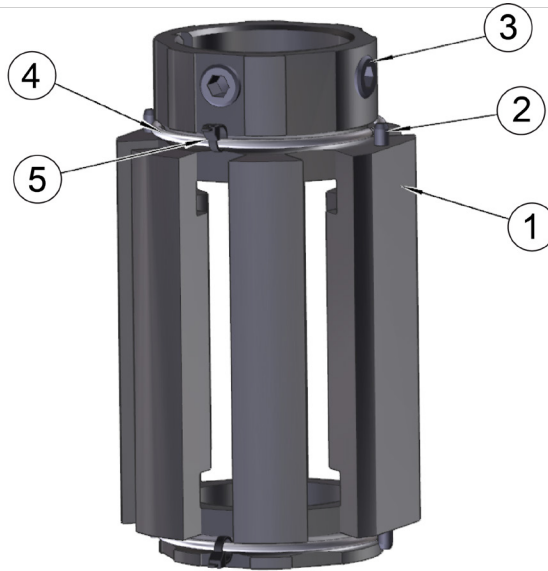


ITEM	PART #	DESCRIPTION
1	514-7-82F	BEARING, THRUST
2	514-5-66G	PIN, THREADED
3	514-9-10D	BODY, LARGE HEAVY DUTY HONE HEAD
4	514-7-82G	RING, SQUARE CROSS SECTION
5	514-9-7A	CONE ROD
6	MF-223C	ROLL PIN 3/16 X 5/8"
8	514-7-81S	PIVOT BLOCK
9	514-5-66G	PIN, THREADED
10	514-9-10G	COVER, HONE HEAD U-JOINT
11	514-7-81T	YOKE, DRIVE SHAFT
12	514-13-49	ADAPTER, KWIK SWITCH
13	514-6-44	COUPLING, DRIVEN
14	MF-198A	DOWEL PINS 3/16 X 7/8"
15	514-7-81U	SHAFT, ADJUSTING HONE HEAD
16	100-19	WASHER, THRUST
17	514-5-72A	SPRING, COMPRESSION
18	MF-219	ROLL PIN 1/8 X 3/4"
19	514-9-8A	JOINT, UNIVERSAL ASSY

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

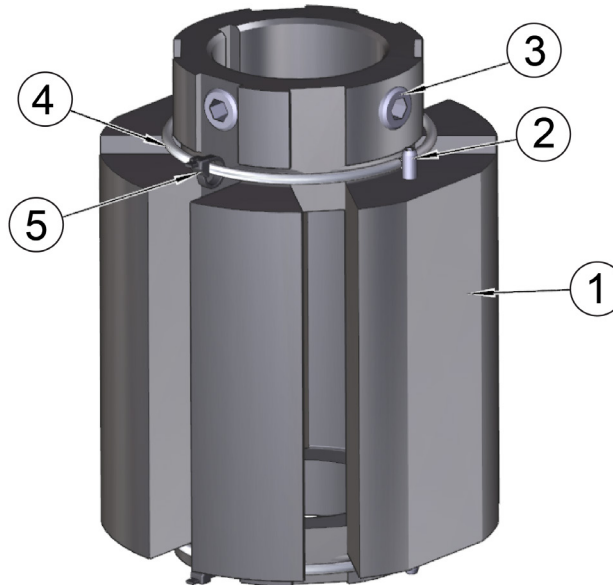


ITEM	PART #	DESCRIPTION
1	514-5-66G	PIN, THREADED
2	514-9-10D	BODY, LARGE HEAVY DUTY HONE HEAD
3	514-7-83C	KEY,SLEEVE
4	514-9-7A	CONE ROD
5	514-13-49	ADAPTER, KWIK SWITCH
6	514-7-81R	YOKE, DRIVE SHAFT
7	514-9-10G	COVER, HONE HEAD U-JOINT
8	514-5-66G	PIN, THREADED
9	514-7-81S	PIVOT BLOCK
10	514-7-82F	BEARING, THRUST
11	514-9-8A	JOINT, UNIVERSAL ASSY
12	514-5-72A	SPRING, COMPRESSION
13	100-19	WASHER, THRUST
14	514-7-81B	SHAFT, ADJUSTING HONE HEAD
15	514-6-44	COUPLING, DRIVEN



514-9-4E Sleeve Assembly Parts

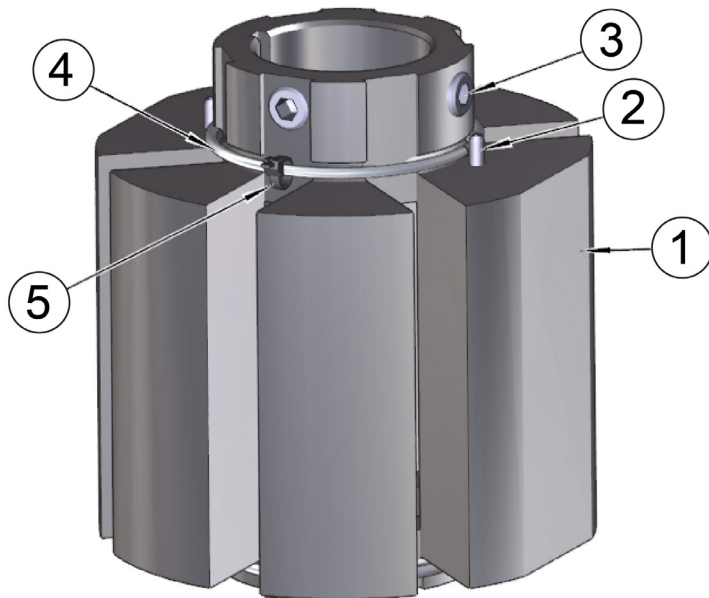
ITEM	PART #	DESCRIPTION
1	514-9-3E	SLEEVE ONLY (6 STONE) 2.77 TO 3.88" DIAMETER
2	MF-217	ROLL PIN 1/8 X 1/2"
3	514-7-83D	SCREW, SOCKET SET CONE POINT
4	514-7-83K	SPRING,GARTER
5	6147D	TYRAP



514-9-4F Sleeve Assembly Parts

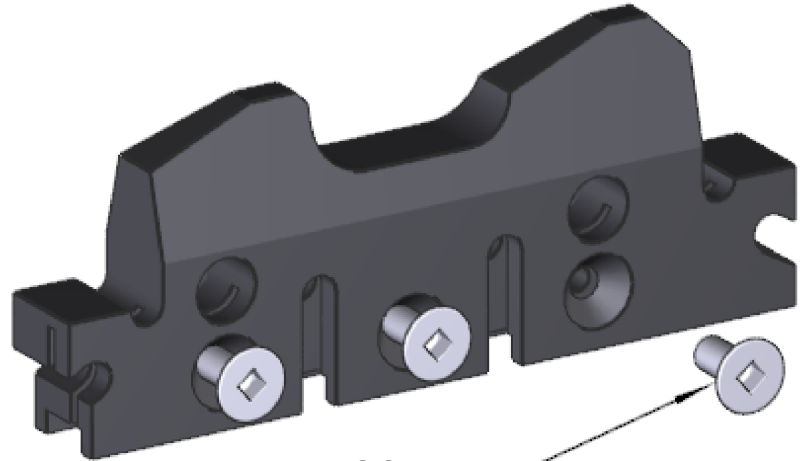
ITEM	PART #	DESCRIPTION
1	514-9-3F	SLEEVE ONLY (6 STONE) 3.67 TO 4.63" DIAMETER
2	MF-217	ROLL PIN 1/8 X 1/2"
3	514-7-83D	SCREW, SOCKET SET CONE POINT
4	514-7-83K	SPRING,GARTER
5	6147D	TYRAP

514-9-4G Sleeve Assembly Parts



ITEM	PART #	DESCRIPTION
1	514-9-3G	SLEEVE ONLY (6 STONE) 4.42 TO 7.38" DIAMETER
2	MF-217	ROLL PIN 1/8 X 1/2"
3	514-7-83D	SCREW, SOCKET SET CONE POINT
4	514-7-83K	SPRING,GARTER
5	6147D	TYRAP

514-9-31 Series Stone Holder Parts



**514-7-81J SCREW
FLAT HEAD SQUARE DRIVE**

Six Stone Hone Head Stone Size Chart

	Diameter (New Stones)			
	0.312 Stones		0.200 Stones	
	Min	Max	Min	Max
514-9-31J	2.99	3.45	2.77	3.23
514-9-31A	3.17	3.63	2.94	3.41
514-9-31B	3.42	3.88	3.19	3.66
514-9-31C	3.67	4.13	3.44	3.91
514-9-31D	3.92	4.38	3.69	4.16
514-9-31E	4.17	4.63	3.94	4.41
514-9-31F	4.42	4.88	4.19	4.66
514-9-31G	4.67	5.13	4.44	4.91
514-9-31H	4.92	5.38	4.69	5.16
514-9-31K	5.17	5.63	4.94	5.41
514-9-31L	5.42	5.88	5.19	5.66
514-9-31M	5.67	6.13	5.44	5.91
514-9-31N	5.92	6.38	5.69	6.16
514-9-31P	6.17	6.63	5.94	6.41
514-9-31Q	6.42	6.88	6.19	6.66
514-9-31R	6.67	7.13	6.44	6.91
514-9-31S	6.92	7.38	6.69	7.16

Diameter (New Stones) (Metric)				
	7.9248 Stones		5.08 Stones	
	Min	Max	Min	Max
514-9-31J	75.92	87.73	70.23	82.04
514-9-31A	80.39	92.20	74.70	86.51
514-9-31B	86.74	98.55	81.05	92.86
514-9-31C	93.09	104.90	87.40	99.21
514-9-31D	99.44	111.25	93.75	105.56
514-9-31E	105.79	117.60	100.10	111.91
514-9-31F	112.14	123.95	106.45	118.26
514-9-31G	118.49	130.30	112.80	124.61
514-9-31H	124.84	136.65	119.15	130.96
514-9-31K	131.19	143.00	125.50	137.31
514-9-31L	137.54	149.35	131.85	143.66
514-9-31M	143.89	155.70	138.20	150.01
514-9-31N	150.24	162.05	144.55	156.36
514-9-31P	156.59	168.40	150.90	162.71
514-9-31Q	162.94	174.75	157.25	169.06
514-9-31R	169.29	181.10	163.60	175.41
514-9-31S	175.64	187.45	169.95	181.76

Diameter (New Brushes)				
	0.550 Brushes		0.395 Brushes	
	Min	Max	Min	Max
514-9-31J	3.47	3.93	3.16	3.62
514-9-31A	3.64	4.11	3.33	3.80
514-9-31B	3.89	4.36	3.58	4.05
514-9-31C	4.14	4.61	3.83	4.30
514-9-31D	4.39	4.86	4.08	4.55
514-9-31E	4.64	5.11	4.33	4.80
514-9-31F	4.89	5.36	4.58	5.05
514-9-31G	5.14	5.61	4.83	5.30
514-9-31H	5.39	5.86	5.08	5.55
514-9-31K	5.64	6.11	5.33	5.80
514-9-31L	5.89	6.36	5.58	6.05
514-9-31M	6.14	6.61	5.83	6.30
514-9-31N	6.39	6.86	6.08	6.55
514-9-31P	6.64	7.11	6.33	6.80
514-9-31Q	6.89	7.36	6.58	7.05
514-9-31R	7.14	7.61	6.83	7.30
514-9-31S	7.39	7.86	7.08	7.55



Diameter (New Brushes) (Metric)				
	13.97 Brushes		10.033 Brushes	
	Min	Max	Min	Max
514-9-31J	88.01	99.82	80.14	91.95
514-9-31A	92.48	104.29	84.61	96.42
514-9-31B	98.83	110.64	90.96	102.77
514-9-31C	105.18	116.99	97.31	109.12
514-9-31D	111.53	123.34	103.66	115.47
514-9-31E	117.88	129.69	110.01	121.82
514-9-31F	124.23	136.04	116.36	128.17
514-9-31G	130.58	142.39	122.71	134.52
514-9-31H	136.93	148.74	129.06	140.87
514-9-31K	143.28	155.09	135.41	147.22
514-9-31L	149.63	161.44	141.76	153.57
514-9-31M	155.98	167.79	148.11	159.92
514-9-31N	162.33	174.14	154.46	166.27
514-9-31P	168.68	180.49	160.81	172.62
514-9-31Q	175.03	186.84	167.16	178.97
514-9-31R	181.38	193.19	173.51	185.32
514-9-31S	187.73	199.54	179.86	191.67

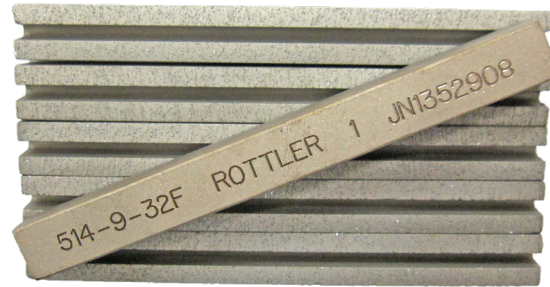
Diamond Abrasives for Rottler Precision 6 Stone Holder Hone Heads

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), Set of 6

514-9-32F Diamond Stones, 80 grit

3" (76mm) long set of 6, 90 Ra, (2.25um)



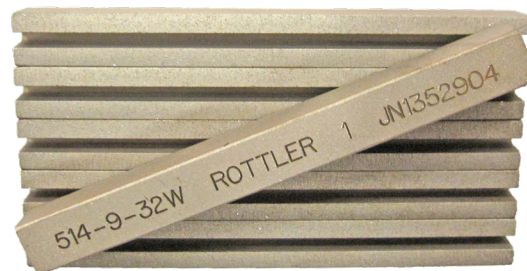
514-9-32R Diamond Stones 80 grit

3.5" (89mm) long set of 6, 90 Ra, (2.25um)



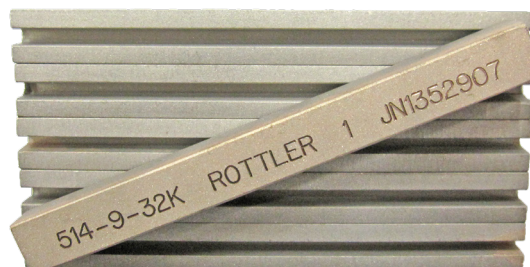
514-9-32W Diamond Stones, 140/170 grit

3" (76mm) long set of 6, 50-75 Ra, (1.25 - 1.875um)

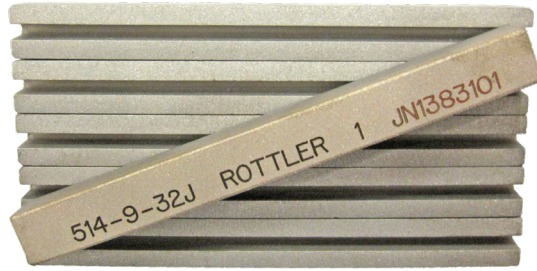


514-9-32K Diamond Stones, 170/200 grit

3" (76mm) long set of 6, 45-60 Ra, (1.125 - 1.5um)



514-9-32J Diamond Stones, 270/325 grit
3" (76mm) long set of 6, 35-45 Ra, (.875 - 1.125um)



514-9-32E Diamond Stones, 325/400 grit
3" (76mm) long set of 6, 24-30 Ra, (.6 - .75um)



514-9-32C Diamond Stones, 500 grit
3" (76mm) long set of 6, 18-22 Ra, (.45 - .55um)



514-9-32L Diamond Stones, 550 grit
3" (76mm) long set of 6, 15-19 Ra, (.375 - .475)



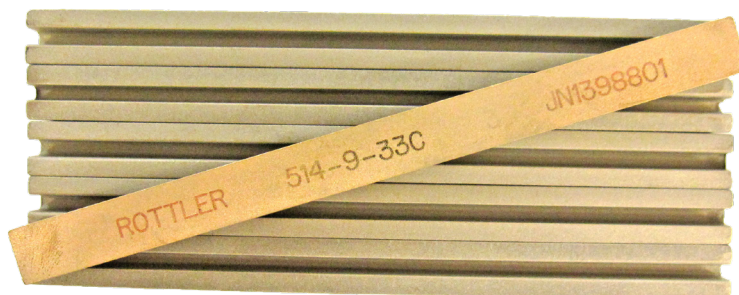
514-9-32G Diamond Stones, 600 grit
3" (76mm) long set of 6, 8-12 Ra, (.2 - .3um)



514-9-33 Diamond Stones, 800 grit
3" (76mm) long set of 6



514-9-33C Diamond Stones, 800 grit
4" (102mm) long set of 6



514-9-33J Diamond Stones, 1200 grit
3" (76mm) long set of 6



Diamond Stones, .200 (5.08MM), Set of 6

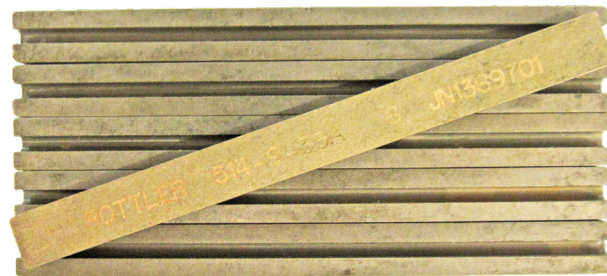
514-9-33B Diamond Stones, 270/325 grit
3.5" (89mm) long set of 6, 35-45 Ra,



514-9-32D Diamond Stones, 325/400 grit
3" (76mm) long set of 6, 18-22 Ra, 2.795 bore



514-9-33A Diamond Stones, 800 grit
3.5" (89mm) long set of 6



CBN Stones for Super Finishing with Rottler Precision 4 and 6 Stone Holder Hone Heads

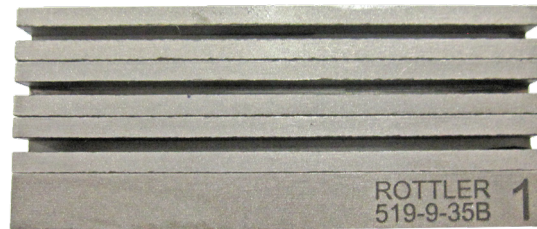
514-9-35C CBN Stones, 320 grit
3" (76mm) long set of 4, for super finishing



514-9-35D CBN Stones, 400 grit
3" (76mm) long set of 4, for super finishing



514-9-35B CBN Stones, 600 grit
3" (76mm) long set of 4, for super finishing



Brushes for Plateau Finishing with Rottler Precision 4 and 6 Stone Holder Hone Heads

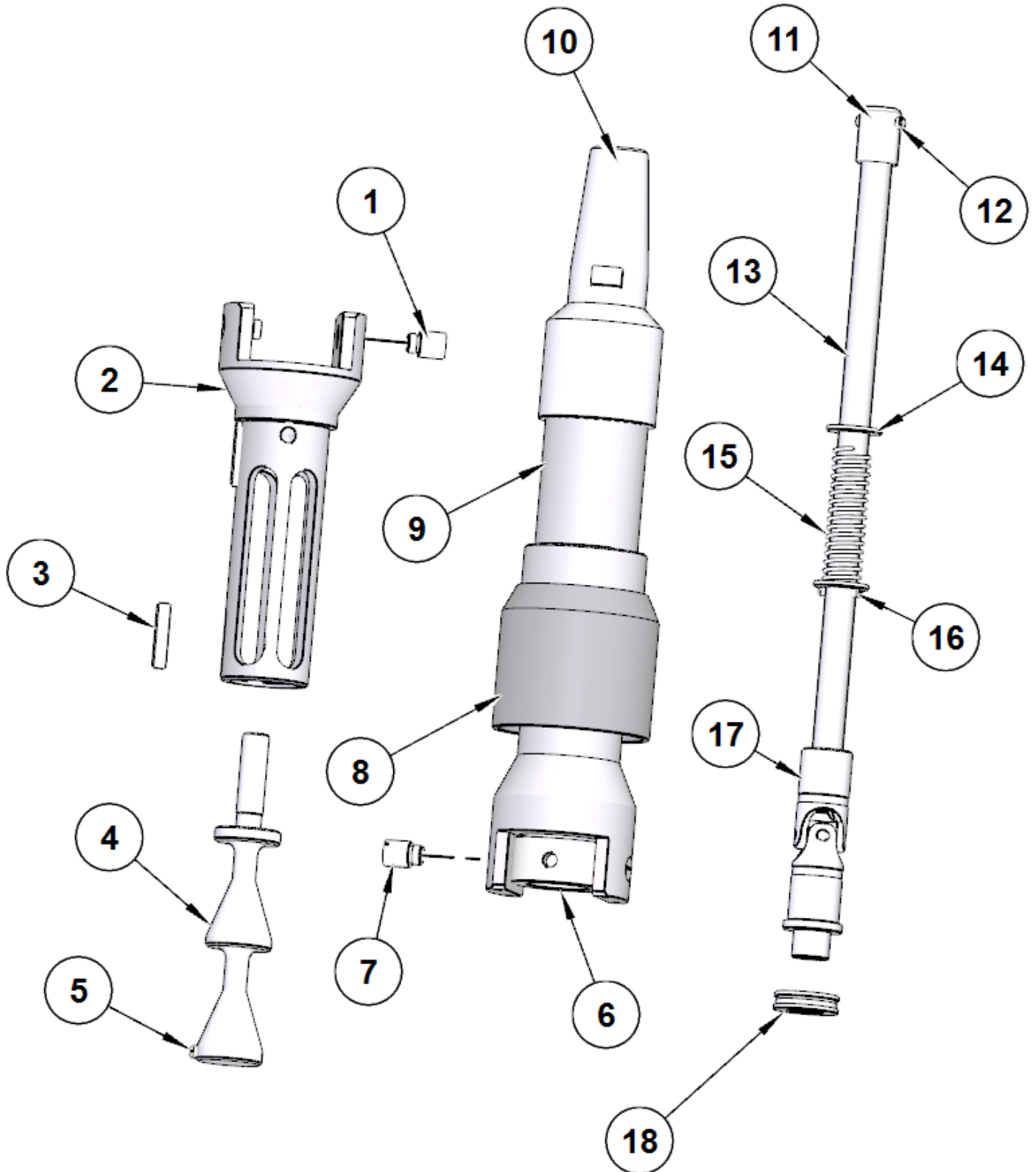
514-9-14H Brushes, for Plateau Finishing
.550" (14mm) height, 3 1/2" (89mm) long, requires one or two size smaller stone holder compared to .312" (7.90mm) height diamond stone. Set of 4



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. Set of 4

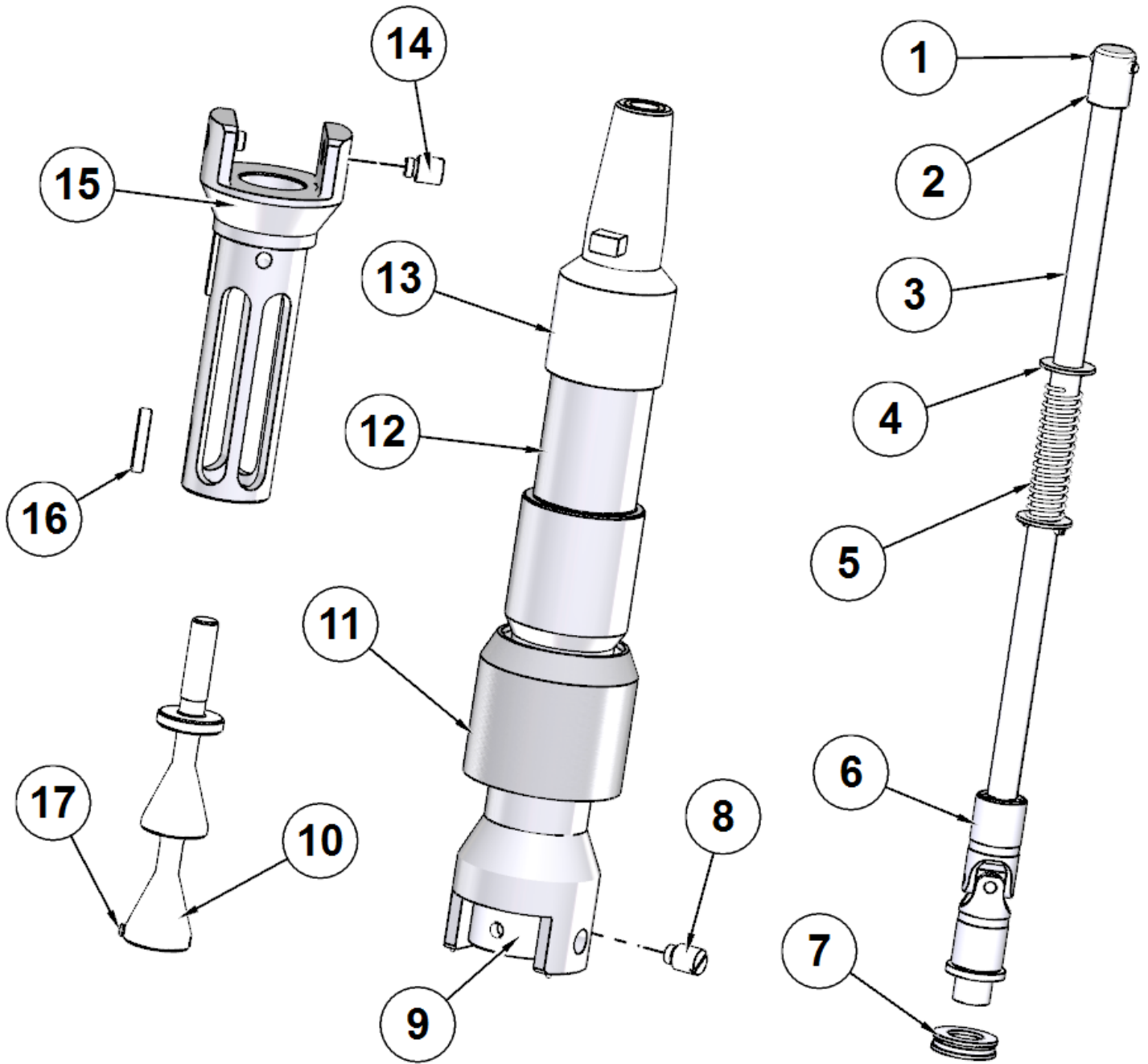


514-9P Large Rottler Precision Heavy Duty 4 Stone Holder Hone Head Assembly Parts



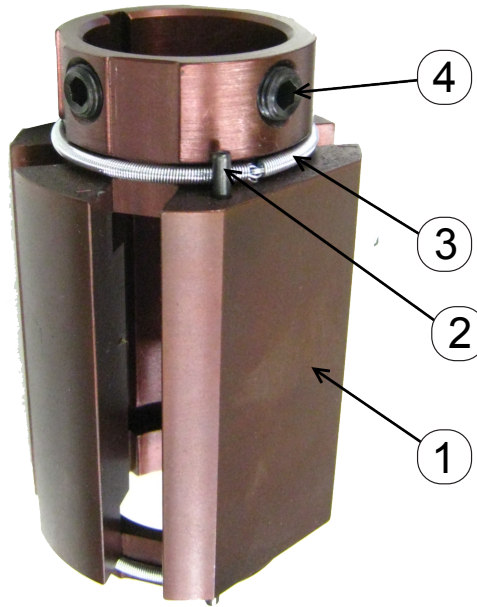
ITEM	PART #	DESCRIPTION
1	514-5-66G	PIN, THREADED
2	514-9-10E	BODY, LARGE HEAVY DUTY HONE HEAD
3	514-7-83C	KEY,SLEEVE
4	514-9-7A	CONE ROD
5	MF-223C	ROLL PIN 3/16 X 5/8"
6	514-7-81S	PIVOT BLOCK
7	514-5-66G	PIN, THREADED
8	514-9-10G	COVER, HONE HEAD U-JOINT
9	514-7-81T	YOKE, DRIVE SHAFT
10	514-13-49	ADAPTER, KWIK SWITCH
11	514-6-44	COUPLING, DRIVEN
12	MF-198A	DOWEL PIN 3/16 X 7/8"
13	514-7-81U	SHAFT, ADJUSTING HONE HEAD
14	100-19	WASHER, THRUST
15	514-5-72A	SPRING, COMPRESSION
16	MF-219	ROLL PIN 1/8 X 3/4"
17	514-9-8A	JOINT,UNIVERSAL ASSY
18	514-7-82F	BEARING,THRUST

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



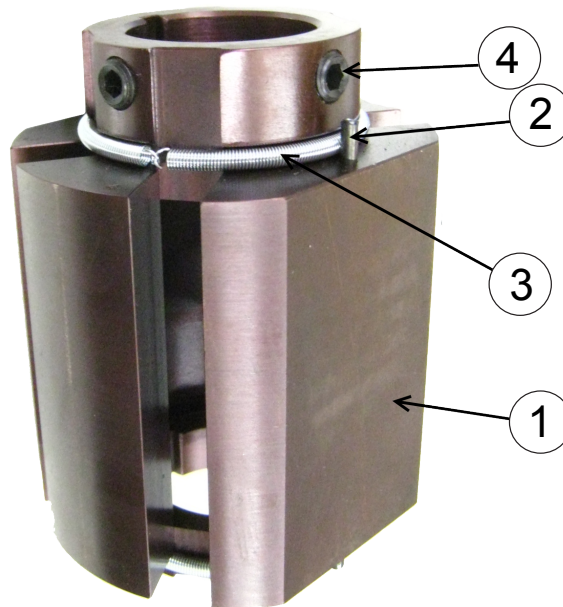
ITEM	PART #	DESCRIPTION
1	MF-198A	DOWEL PIN 3/16 X 7/8"
2	514-6-44	COUPLING, DRIVEN
3	514-7-81B	SHAFT, ADJUSTING HONE HEAD
4	100-19	WASHER, THRUST
5	514-5-72A	SPRING, COMPRESSION
6	514-9-8A	JOINT, UNIVERSAL ASSY
7	514-7-82F	BEARING, THRUST
8	514-5-66G	PIN, THREADED
9	514-7-81S	PIVOT BLOCK
10	514-9-7A	CONE ROD
11	514-9-10G	COVER, HONE HEAD U-JOINT
12	514-7-81R	YOKE, DRIVE SHAFT
13	514-13-49	ADAPTER, KWIK SWITCH
14	514-5-66G	PIN, THREADED
15	514-9-10E	BODY, LARGE HEAVY DUTY HONE HEAD
16	514-7-83C	KEY, SLEEVE
17	MF-223C	ROLL PIN 3/16 X 5/8"

514-9-4A Sleeve Assembly Parts



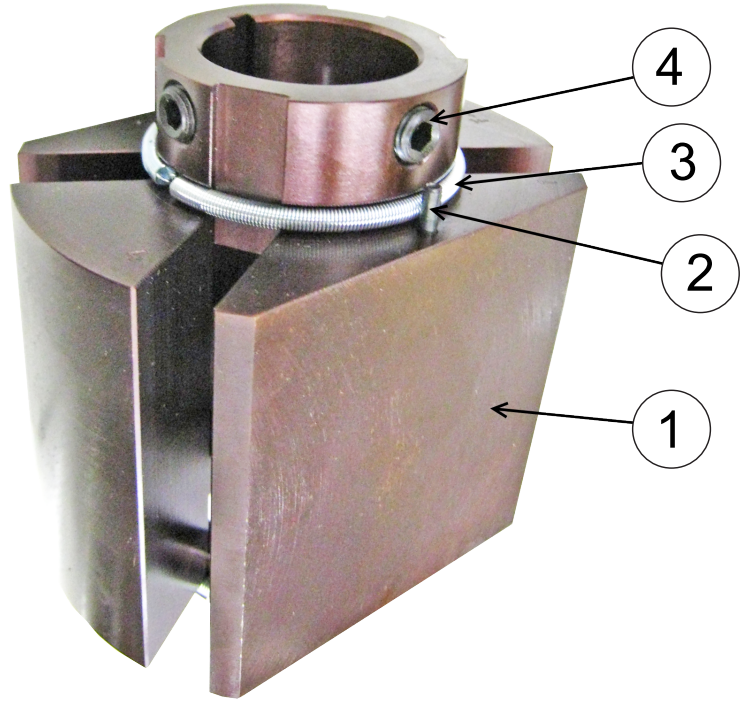
ITEM	PART #	DESCRIPTION
1	514-9-3A	SLEEVE 2.75 TO 3.56" DIA.
2	MF-217	ROLL PIN 1/8 X 1/2"
3	514-7-83K	SPRING,GARTER
4	514-7-83D	SCREW, SOCKET SET CONE POINT

514-9B Sleeve Assembly Parts



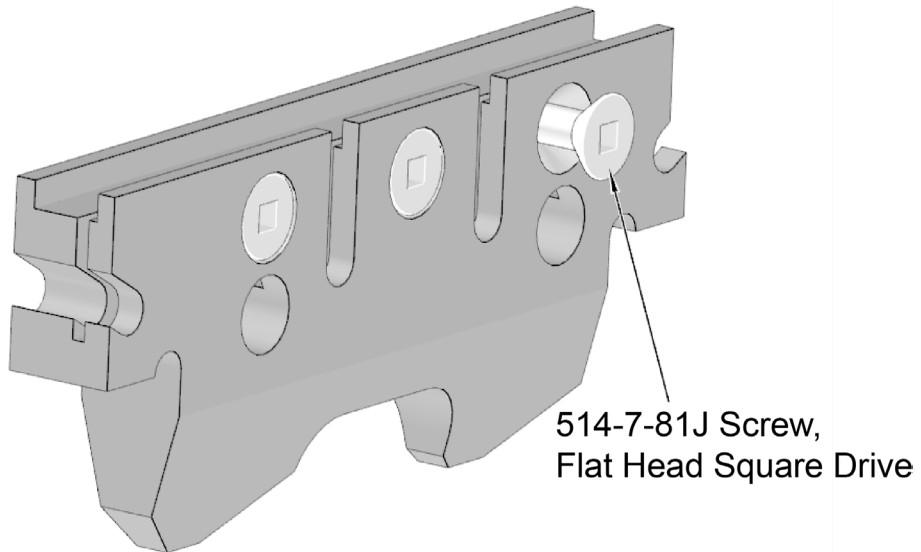
ITEM	PART #	DESCRIPTION
1	514-9-3B	SLEEVE ONLY 3.50-4.32" DIAMETER
2	MF-217	ROLL PIN 1/8 X 1/2"
3	514-7-83K	SPRING,GARTER
4	514-7-83D	SCREW, SOCKET SET CONE POINT

514-9-4C Sleeve Assembly Parts



ITEM	PART #	DESCRIPTION
1	514-9-3C	SLEEVE 4.25 TO 5.06" DIAMETER
2	MF-217	ROLL PIN 1/8 X 1/2"
3	514-7-83K	SPRING, GARTER
4	514-7-83D	SCREW, SOCKET SET CONE POINT

514-9-6 Series Stone Holder Parts



Large Hone Head Stone Size Chart

Diameter (New Stones)

	0.312 Stones		0.200 Stones	
	Min	Max	Min	Max
514-9-6J	2.99	3.45	2.77	3.23
514-9-6A	3.17	3.63	2.94	3.41
514-9-6B	3.42	3.88	3.19	3.66
514-9-6C	3.67	4.13	3.44	3.91
514-9-6D	3.92	4.38	3.69	4.16
514-9-6E	4.17	4.63	3.94	4.41
514-9-6F	4.42	4.88	4.19	4.66
514-9-6G	4.67	5.13	4.44	4.91
514-9-6H	4.92	5.38	4.69	5.16
514-9-6K	5.17	5.63	4.94	5.41
514-9-6L	5.42	5.88	5.19	5.66
514-9-6M	5.67	6.13	5.44	5.91
514-9-6N	5.92	6.38	5.69	6.16
514-9-6P	6.17	6.63	5.94	6.41
514-9-6Q	6.42	6.88	6.19	6.66
514-9-6R	6.67	7.13	6.44	6.91
514-9-6S	6.92	7.38	6.69	7.16

Diameter (New Stones) (Metric)

	7.925 Stones		5.08 Stones	
	Min	Max	Min	Max
514-9-6J	75.92	87.73	70.23	82.04
514-9-6A	80.39	92.20	74.70	86.51
514-9-6B	86.74	98.55	81.05	92.86
514-9-6C	93.09	104.90	87.40	99.21
514-9-6D	99.44	111.25	93.75	105.56
514-9-6E	105.79	117.60	100.10	111.91
514-9-6F	112.14	123.95	106.45	118.26
514-9-6G	118.49	130.30	112.80	124.61
514-9-6H	124.84	136.65	119.15	130.96
514-9-6K	131.19	143.00	125.50	137.31
514-9-6L	137.54	149.35	131.85	143.66
514-9-6M	143.89	155.70	138.20	150.01
514-9-6N	150.24	162.05	144.55	156.36
514-9-6P	156.59	168.40	150.90	162.71
514-9-6Q	162.94	174.75	157.25	169.06
514-9-6R	169.29	181.10	163.60	175.41
514-9-6S	175.64	187.45	169.95	181.76

Diameter (New Brushes)

	0.550 Brushes		0.395 Brushes	
	Min	Max	Min	Max
514-9-6J	3.47	3.93	3.16	3.62
514-9-6A	3.64	4.11	3.33	3.80
514-9-6B	3.89	4.36	3.58	4.05
514-9-6C	4.14	4.61	3.83	4.30
514-9-6D	4.39	4.86	4.08	4.55
514-9-6E	4.64	5.11	4.33	4.80
514-9-6F	4.89	5.36	4.58	5.05
514-9-6G	5.14	5.61	4.83	5.30
514-9-6H	5.39	5.86	5.08	5.55
514-9-6K	5.64	6.11	5.33	5.80
514-9-6L	5.89	6.36	5.58	6.05
514-9-6M	6.14	6.61	5.83	6.30
514-9-6N	6.39	6.86	6.08	6.55
514-9-6P	6.64	7.11	6.33	6.80
514-9-6Q	6.89	7.36	6.58	7.05
514-9-6R	7.14	7.61	6.83	7.30
514-9-6S	7.39	7.86	7.08	7.55

Diameter (New Brushes) (Metric)

	13.970 Brushes		10.033 Brushes	
	Min	Max	Min	Max
514-9-6J	88.01	99.82	80.14	91.95
514-9-6A	92.48	104.29	84.61	96.42
514-9-6B	98.83	110.64	90.96	102.77
514-9-6C	105.18	116.99	97.31	109.12
514-9-6D	111.53	123.34	103.66	115.47
514-9-6E	117.88	129.69	110.01	121.82
514-9-6F	124.23	136.04	116.36	128.17
514-9-6G	130.58	142.39	122.71	134.52
514-9-6H	136.93	148.74	129.06	140.87
514-9-6K	143.28	155.09	135.41	147.22
514-9-6L	149.63	161.44	141.76	153.57
514-9-6M	155.98	167.79	148.11	159.92
514-9-6N	162.33	174.14	154.46	166.27
514-9-6P	168.68	180.49	160.81	172.62
514-9-6Q	175.03	186.84	167.16	178.97
514-9-6R	181.38	193.19	173.51	185.32
514-9-6S	187.73	199.54	179.86	191.67

Diamond Stones, .312" (7.90mm) Height, Set of 4

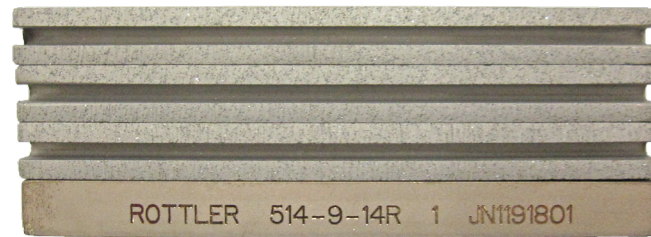
514-9-14F Diamond Stones, 80 grit

3" (76mm) long set of 4, 90Ra (2.25um), stock removal .004-.007/min.



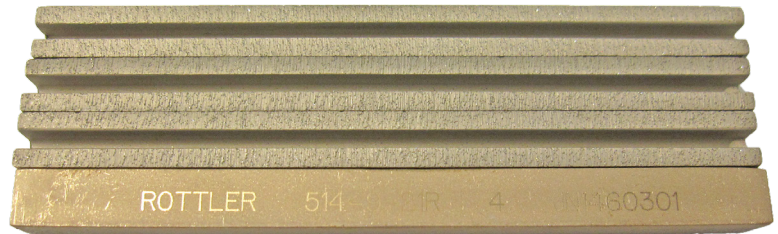
514-9-14R Diamond Stones, 80 grit

3 1/2" (89mm) long set of 4, 90Ra (2.25um), stock removal .004-.007/min. (.102 - .178mm)



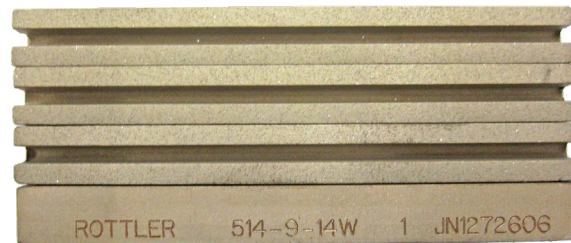
514-9-21R Diamond Stones, 80 grit

4" (102mm) long set of 4, 90 Ra, (2.25um)



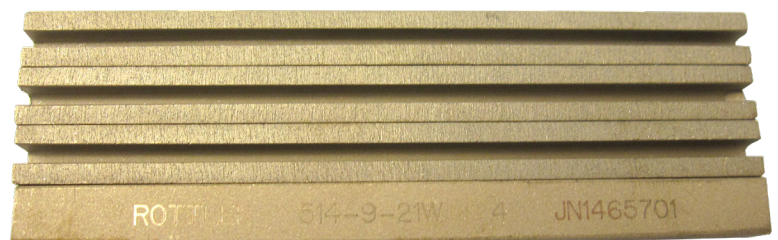
514-9-14W Diamond Stones, 140/170 grit

3" (76mm) long set of 4, 50-75Ra (1.25 - 1.875um)



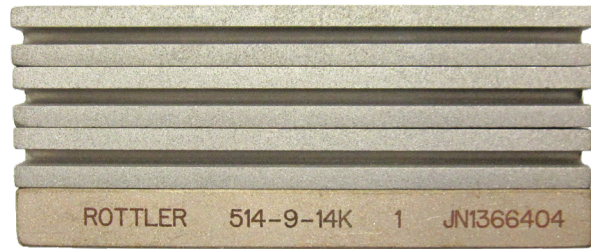
514-9-21W Diamond Stones, 140/170 grit

4" (102mm) long set of 4, 50-75 Ra, (1.25 - 1.875um)



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

3 (76mm) long set of 4, 45-60Ra (1.125 - 1.5um)



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

3 1/2" (89mm) long set of 4, 45-60Ra (1.125 - 1.5um)



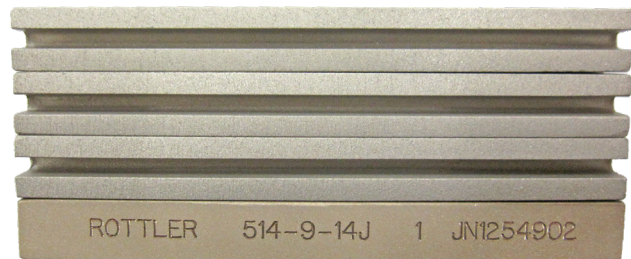
514-9-21M Diamond stones, 170/200 grit

4" (102mm) long set of 4, 45-60 Ra, (1.125 - 1.5um)



514-9-14J Diamond Stones, 270/325 grit

3" (76mm) long set of 4, 35-45Ra (.875 - 1.125um)



514-9-14T Diamond Stones, 270/325 grit

3 1/2" (89mm) long set of 4, 35-45Ra (.875 - 1.125um)



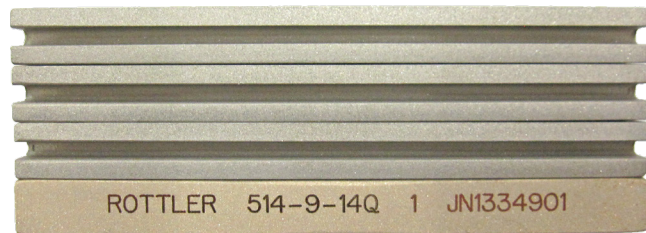
514-9-14Z Diamond Stones, 270/325 grit
4" (102mm) long set of 4, 35-45Ra (.875 - 1.125um)



514-9-14E Diamond Stones, 325/400 grit
3" (76mm) long set of 4, 24-30Ra (.6 - .75um)



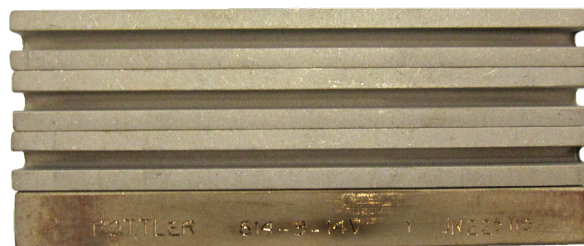
514-9-14Q Diamond Stones, 325/400 grit
3 1/2" (89mm) long set of 4, 24-30Ra (.6 - .75um)



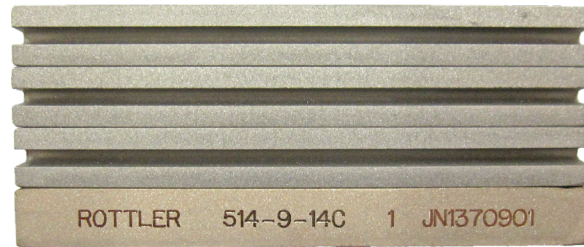
514-9-14X Diamond Stones, 325/400 grit
4" (102mm) long set of 4, 24-30Ra (.6 - .75um)



514-9-14V Diamond Stones, 500 grit
3" (76mm) long set of 4, 15-19Ra (.375 - .475um)



514-9-14C Diamond Stones, 325/400 grit
3" (76mm) long set of 4, 18-22Ra (.45 - .55um)



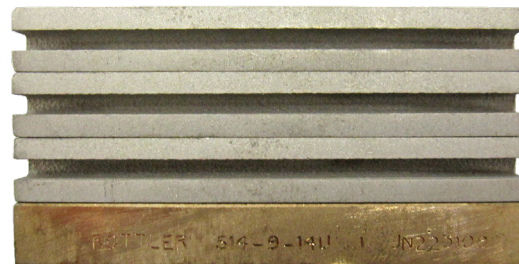
514-9-14P Diamond Stones, 500 grit
3-1/2" (89mm) long set of 4, 18-22Ra (.45 - .55um)



514-9-14D Diamond Stones, 325/400 grit
3" (76mm) long set of 4, 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 set of 4, 18-22Ra (.45 - .55um)



514-9-14L Diamond Stones, 550 grit
3" (76mm) long set of 4, 15-19Ra (.375 - .475um)



514-9-14N Diamond Stones, 550 grit
3 1/2" (89mm) long set of 4, 15-19Ra (.375 - .475um)



514-9-14G Diamond Stones, 600 grit
3" (76mm) long set of 4, 8-12Ra (.2 - .3um)



514-9-14S Diamond Stones, 600 grit
3 1/2" (89mm) long set of 4, 8-12Ra (.2 - .3um)



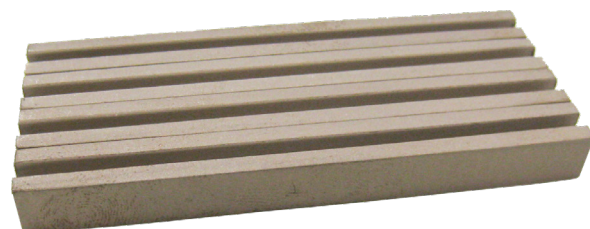
514-9-21G Diamond Stones, 800 grit
3" (76mm) long set of 4



514-9-21H Diamond Stones, 1000 grit
3" (76mm) long set of 4



514-9-21J Diamond Stones, 1200 grit
3" (76mm) long set of 4



CBN Stones for Super Finishing with Rottler Precision 4 and 6 Stone Holder Hone Heads

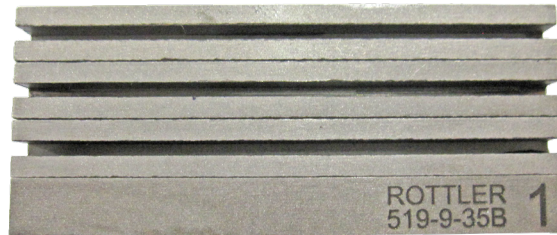
514-9-35C CBN Stones, 320 grit
3" (76mm) long set of 4, for super finishing



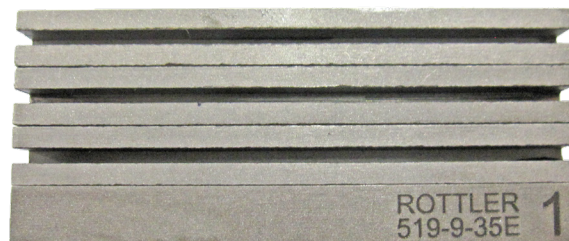
514-9-35D CBN Stones, 400 grit
3" (76mm) long set of 4, for super finishing



514-9-35B CBN Stones, 600 grit
3" (76mm) long set of 4, for super finishing



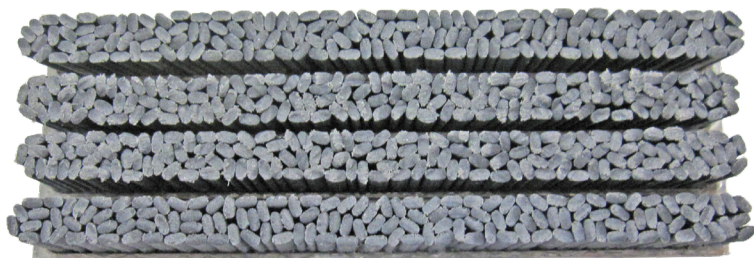
514-9-35E CBN Stones, 500 grit
3" (76mm) long set of 4, for super finishing



Brushes for Plateau Finishing with Rottler Precision 4 and 6 Stone Holder Hone Heads**514-9-14H Brushes, for Plateau Finishing**

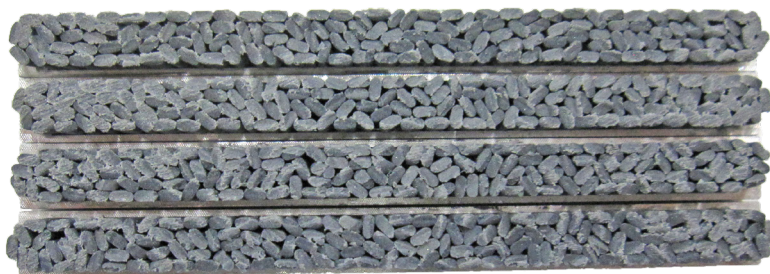
.550" (14mm) height, 3 1/2" (89mm) long. Set of 4

Requires one or two size smaller stone holder compared to .312" (7.90mm) height diamond stone.

**514-9-14Y Brushes, for Plateau Finishing**

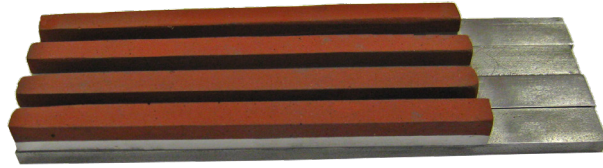
.395" (10mm) height, 3 1/2" (89mm) long. Set of 4

Requires same or one size smaller stone holder compared to .312" (7.90mm) height diamond stone.



Special Stones for Finishing Aluminum Silicone Cylinders
(Refer to bulletin No. 284) Requires Rottler Precision 4 or 6 Stone Holder 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



Special Hone Head Dual Stage

514-9M Hone Head, Dual Stage Parts

Assembly Image and Parts List are unavailable at this time.

Please visit the service tab of our web page at Send a Service Request www.rottlermfg.com or contact the Rottler Factory Service at service@rottlermfg.com for assistance and your service request.

You may also call Rottler at 1-800-452-0534 or 1-253-872-7050

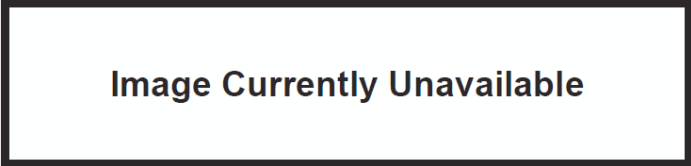
Please ensure you have the Machine Model and Serial Number available when contacting Rottler for Service

Special Hone Head 514-9M Dual Stage, Diamond Stones, Set of 6

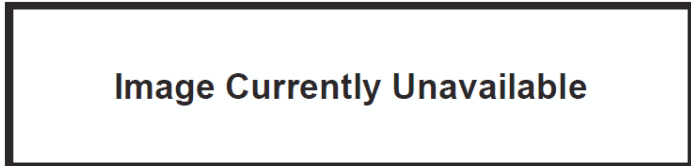
110-162R Dual Stage Diamond Stones
.0781" Tall (19.83MM), (325/400 Grit) Set of 6



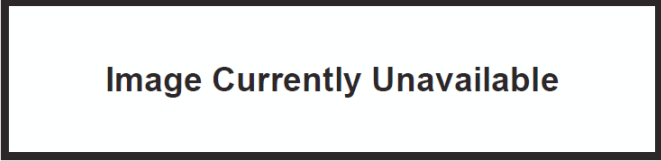
110-163R Dual Stage Diamond Stones
.859" Tall (22.73MM), (325/400 Grit) Set of 6



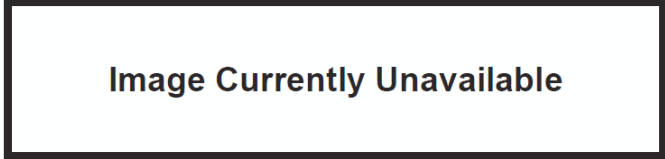
110-163R-01 Dual Stage Diamond Stones
.859" Tall (22.73MM), (140/170 Grit)
3.865" Bore, Set of 6



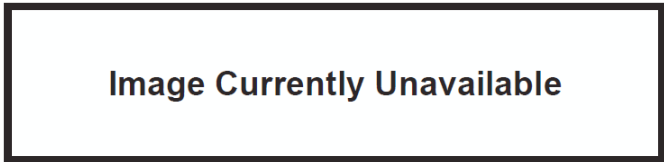
110-163R-03 Dual Stage Diamond Stones
.859" Tall (22.73MM), 600 Grit
3.865" Bore, Set of 6



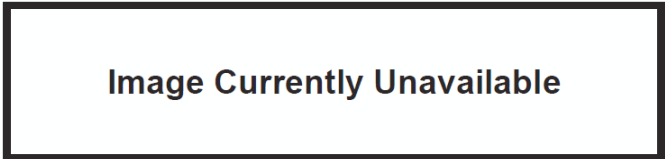
110-164R Dual Stage Diamond Stones
.937" Tall (23.80MM), (325/400 Grit) Set of 6



110-164R-01 Dual Stage Diamond Stones
.937" Tall (23.80MM), (140/170 Grit)
4.110" Bore, Set of 6

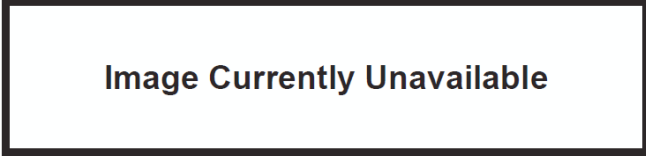


110-164R-03 Dual Stage Diamond Stones
.937" Tall (23.80MM), 60 Grit
4.110" Bore, Set of 6

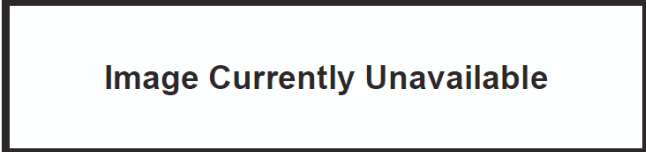


Special Dual Stage Hone Head Brush Sets

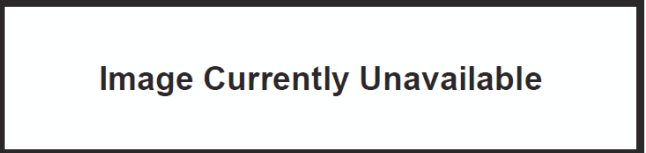
124-24 Brush Set, Dual Stage Hone Head
.781 Tall (19.84MM) Set of 4



124-25 Brush Set, Dual Stage Hone Head
.859 Tall (21.82MM) Set of 4



124-26 Brush Set, Dual Stage Hone Head
.937 Tall (23.80MM) Set of 4



Special Hone Head Single Stage, 12 Stone**514-9N Hone Head, Single Stage Parts**

Assembly Image and Parts List are unavailable at this time.

Please visit the service tab of our web page at [Send a Service Request www.rottlermfg.com](http://www.rottlermfg.com) or contact the Rottler Factory Service at service@rottlermfg.com for assistance and your service request.

You may also call Rottler at 1-800-452-0534 or 1-253-872-7050

Please ensure you have the Machine Model and Serial Number available when contacting Rottler for Service

110-171-01 Single Stage Diamond Stones

.0781" Tall (19.83MM), 600 Grit Set of 12



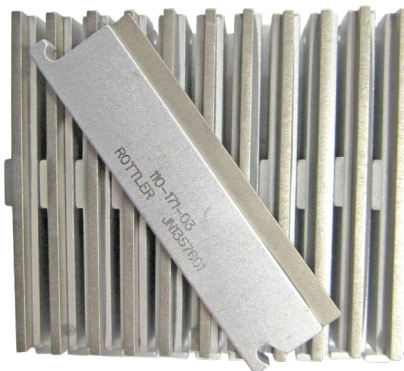
110-171-02 Single Stage Diamond Stones

.0781" Tall (19.83MM), 1200 Grit, Set of 12



110-171-03 Single Stage Diamond Stones

.0781" Tall (19.83MM), (325/400 Grit) - Set of 12



Optional Measuring Equipment

201 Mitutoyo Surface Tester Surftest 201

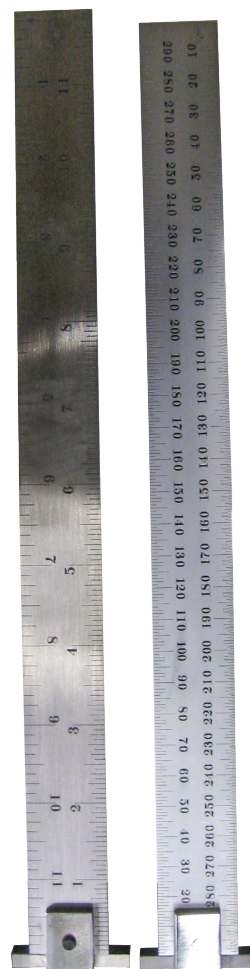
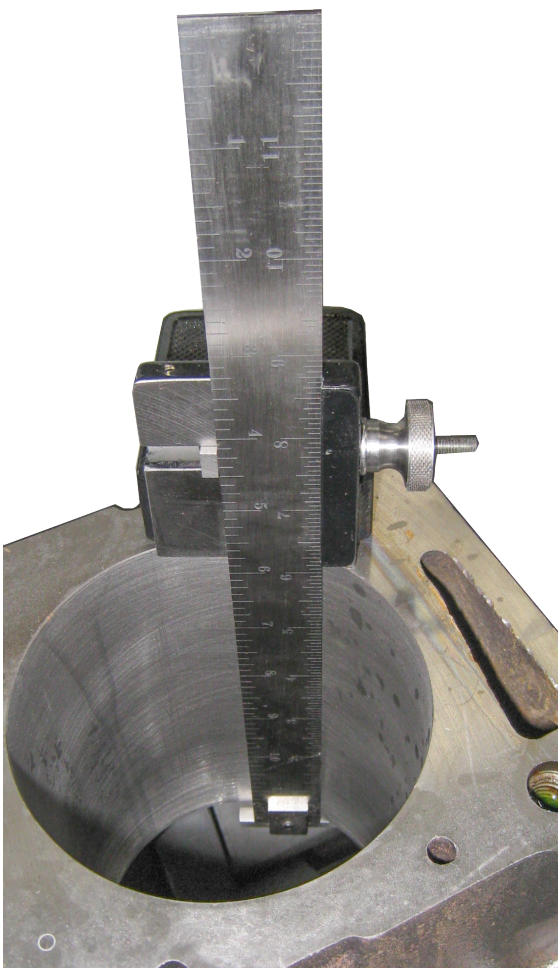
Sold as complete unit only.



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

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

Both items sold as complete assemblies only.

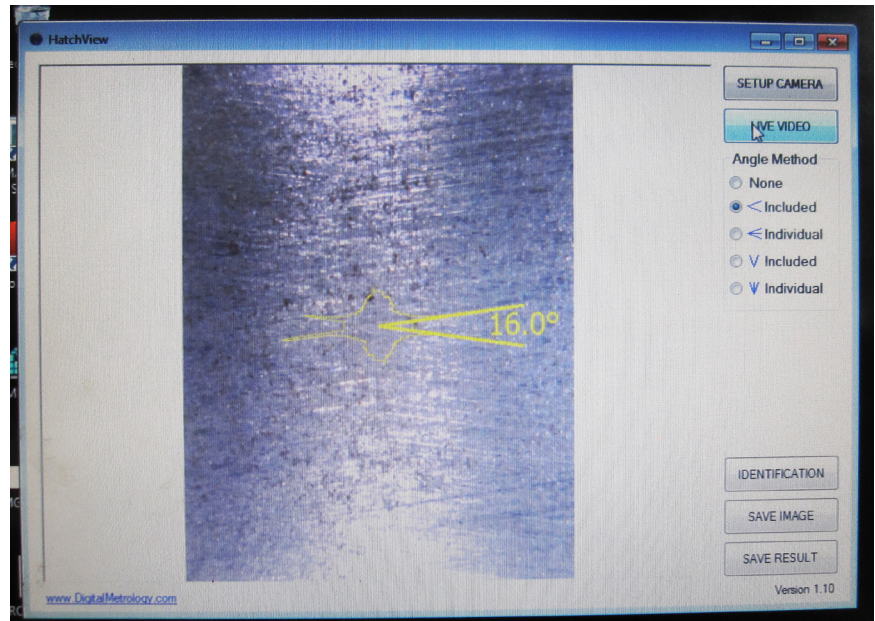


Camera & Software To View Cross Hatch Angle

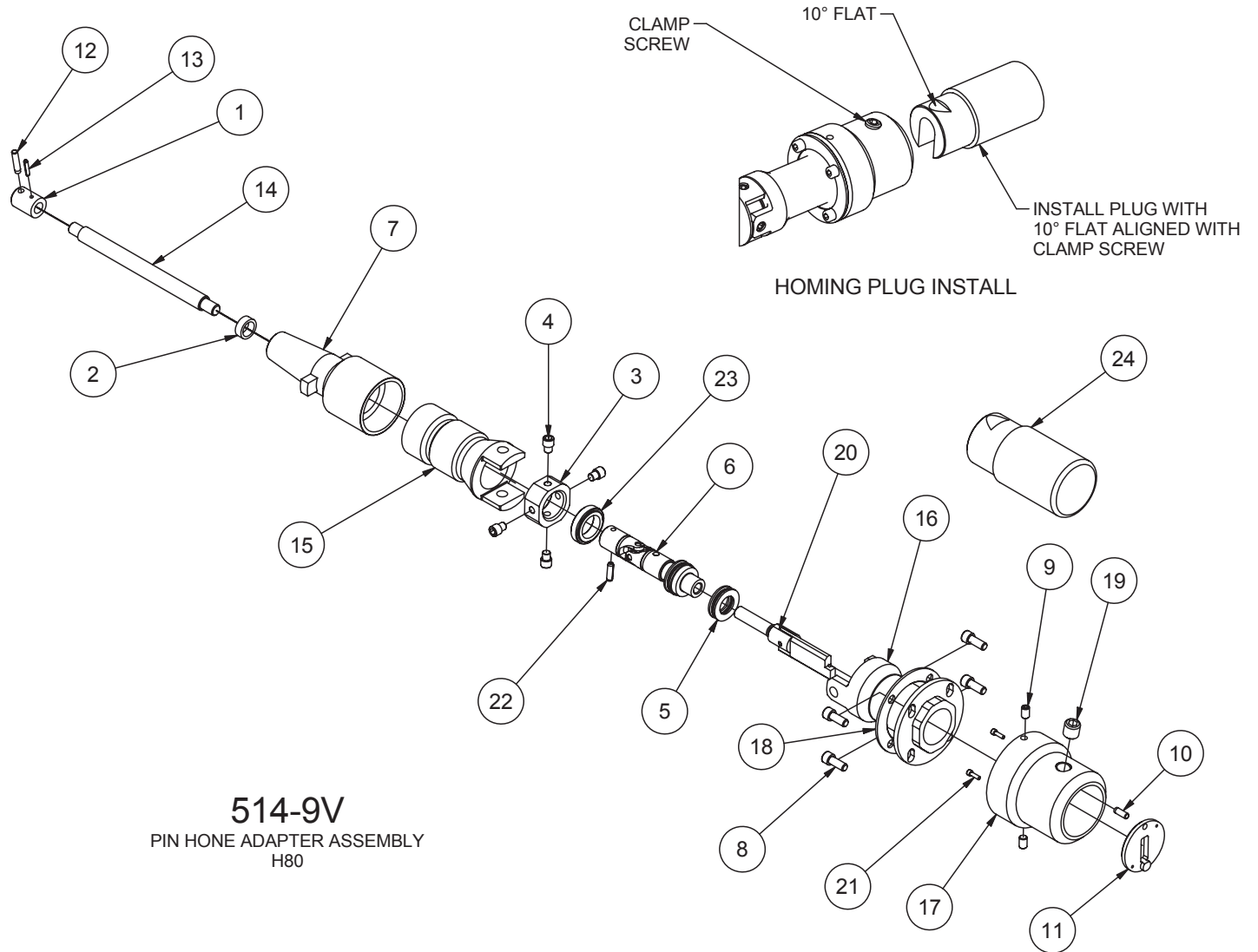
514-14-29A Camera



514-14-29B Software Package



514-9V Pin Hone Adapter Parts



514-9V
PIN HONE ADAPTER ASSEMBLY
H80

514-9V PIN HONE ADAPTER ASSEMBLY - H80			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-6-44	DRIVEN COUPLING - HONE #2
2	1	514-7-80T	OIL LITE BUSHING
3	1	514-10-6	PIVOT BLOCK UNIVERSAL JUNIOR PERCISION HONE HEAD
4	4	514-10-10	PIVOT SCREW
5	1	514-7-82F	THRUST WASHER
6	1	514-10-5B	U-JOINT ASSEMBLY - PIN HONE ADAPTER - H80
7	1	514-13-49	KWIK SWITCH TAPER
8	4	MF-13	S.H.C.S. 1/4 - 20 UNC - 5/8
9	2	514-10-1E	1/4-28UNF x 3/8" LONG SOCKET FLAT POINT SET SCREW
10	1	MF-196	3/16" x 1/2" LG. DOWEL PIN
11	1	514-10-3D	BACKING PLATE, PIN HONE ADAPTER ASSEMBLY
12	1	MF-198A	3/16 x 7/8 Dowel Pin
13	1	MF-218	1/8 x 5/8 Roll Pin
14	1	514-10-20C	ADJUSTING SHAFT - PIN HONE ADAPTER ASSEMBLY
15	1	514-10-20D	YOKE DRIVE TUBE, PIN HONE ADAPTER - H75
16	1	514-10-1B	UPPER BODY, PIN HONE ADAPTER ASSEMBLY - H80
17	1	514-10-1C	LOWER BODY, PIN HONE ADAPTER ASSEMBLY - H80
18	1	514-10-1D	CLAMP PLATE, PIN HONE ADAPTER ASSEMBLY - H80
19	1	6855P	1/2-13UNC x 1/2" LONG SOCKET FLAT POINT SET SCREW
20	1	514-10-3E	ACTUATOR ASSEMBLY, PIN HONE ADAPTER ASSEMBLY - H80
21	2	MF-84D	4-40UNC x 3/8" LG. S.H.C.S.
22	1	MF-223C	3/16" X 5/8" LG. ROLL PIN
23	1	514-10-1F	NUT, THRUST BEARING - PIN HONE ADAPTER - H80
24	1	514-10-1G	HOMING PLUG, PIN HONE ADAPTER - H85

Safety Shut Down Protection System

514-14-99 Laser Light Curtain

Sold only as complete assembly.

