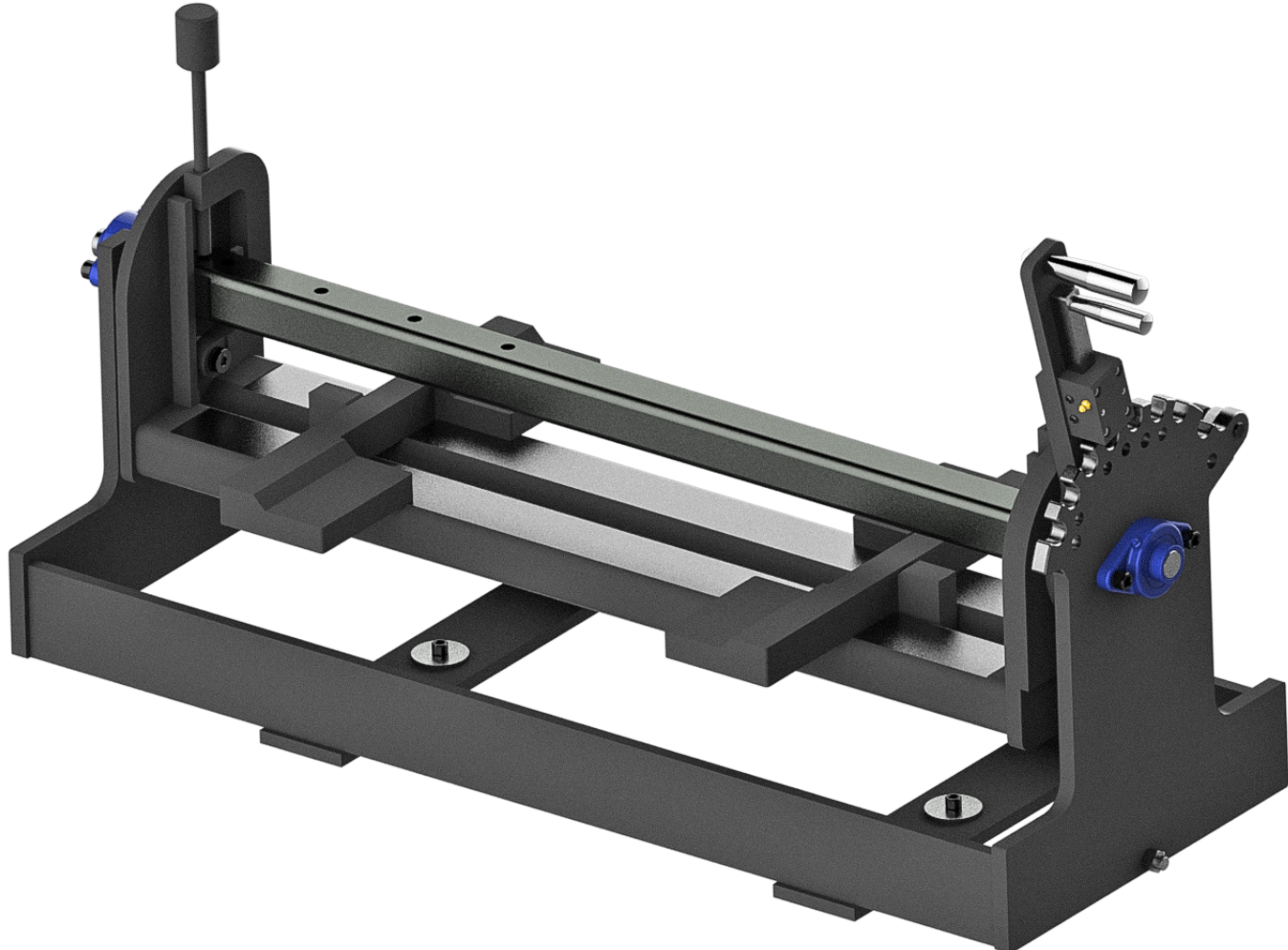




# 514-7A MANUAL BLOCK FIXTURE

OPERATION AND MAINTENANCE 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 specialist.

Have the following information handy to expedite the ordering process:

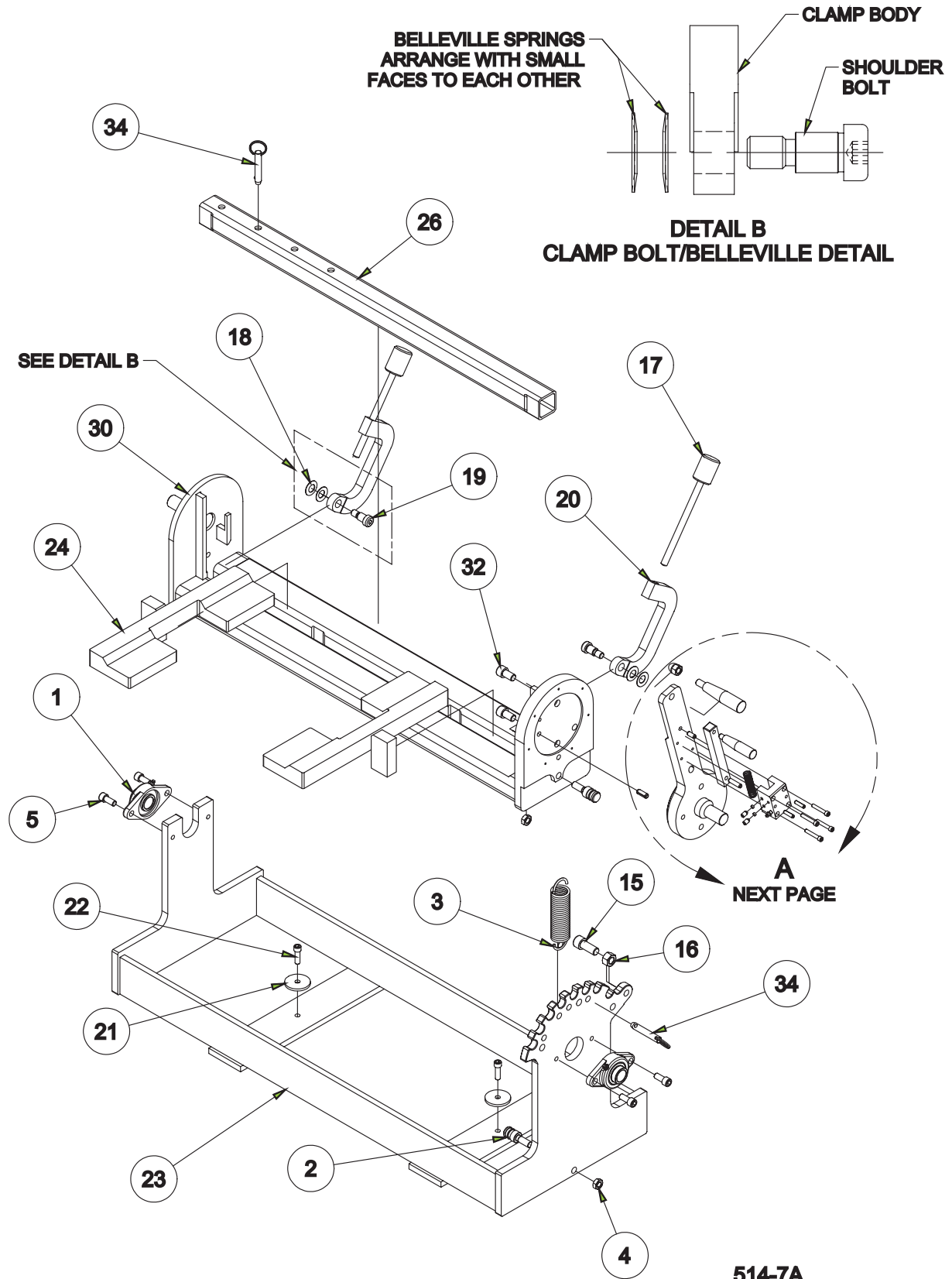
1. Your name, business name, and contact number
2. Customer number
3. If you don't have a customer number, your billing address
4. Shipping address if different from billing address
5. Machine model and serial number
6. Part number and description of what you want to order
7. Preferred method of shipment
8. You may also contact us via e-mail with the above information. Send e-mail requests to:  
[parts@rottlermfg.com](mailto: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**





**514-7A  
BLOCK HOLD DOWN FIXTURE  
ASSEMBLY**



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