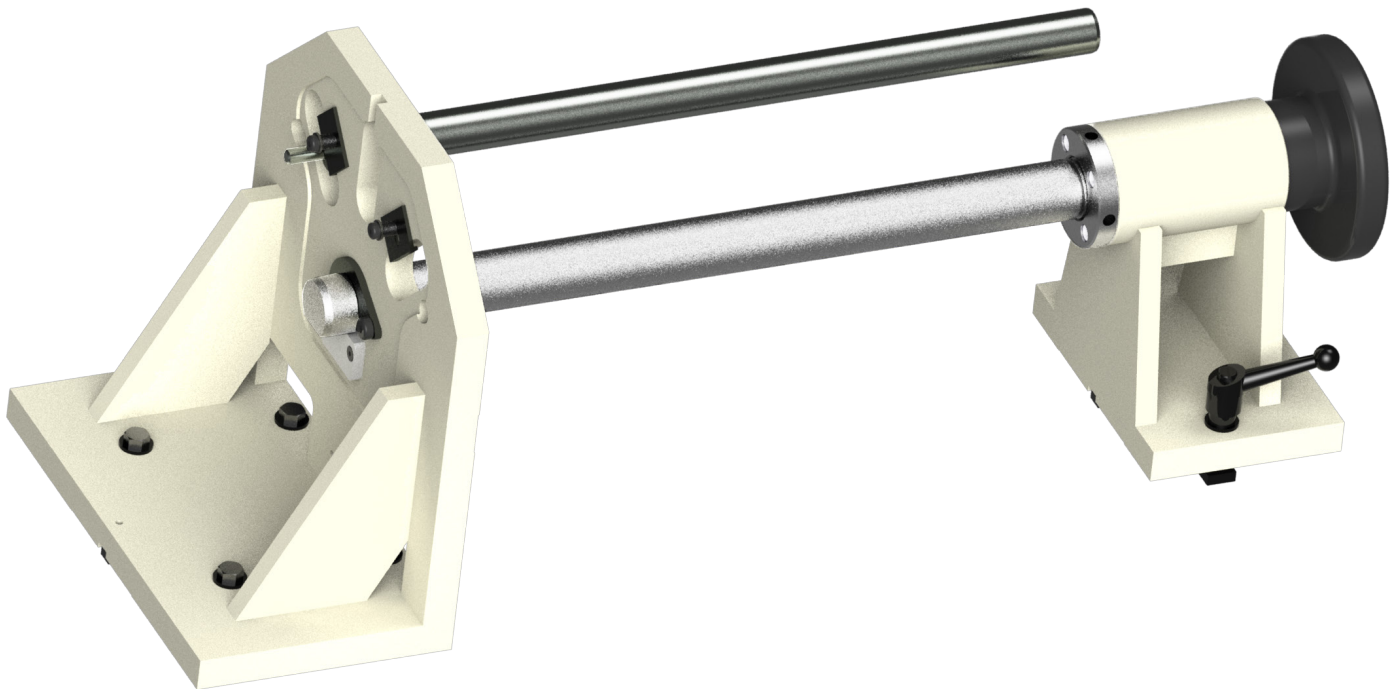


ROTTLER

650-3-1 PERFORMANCE 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

You may also contact us via e-mail with the above information. Send e-mail requests to:
parts@rottermfg.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

Contents

Performance Fixture Setup for Cylinder Boring..... 1

Performance Fixture Setup for Lifter Boring 4

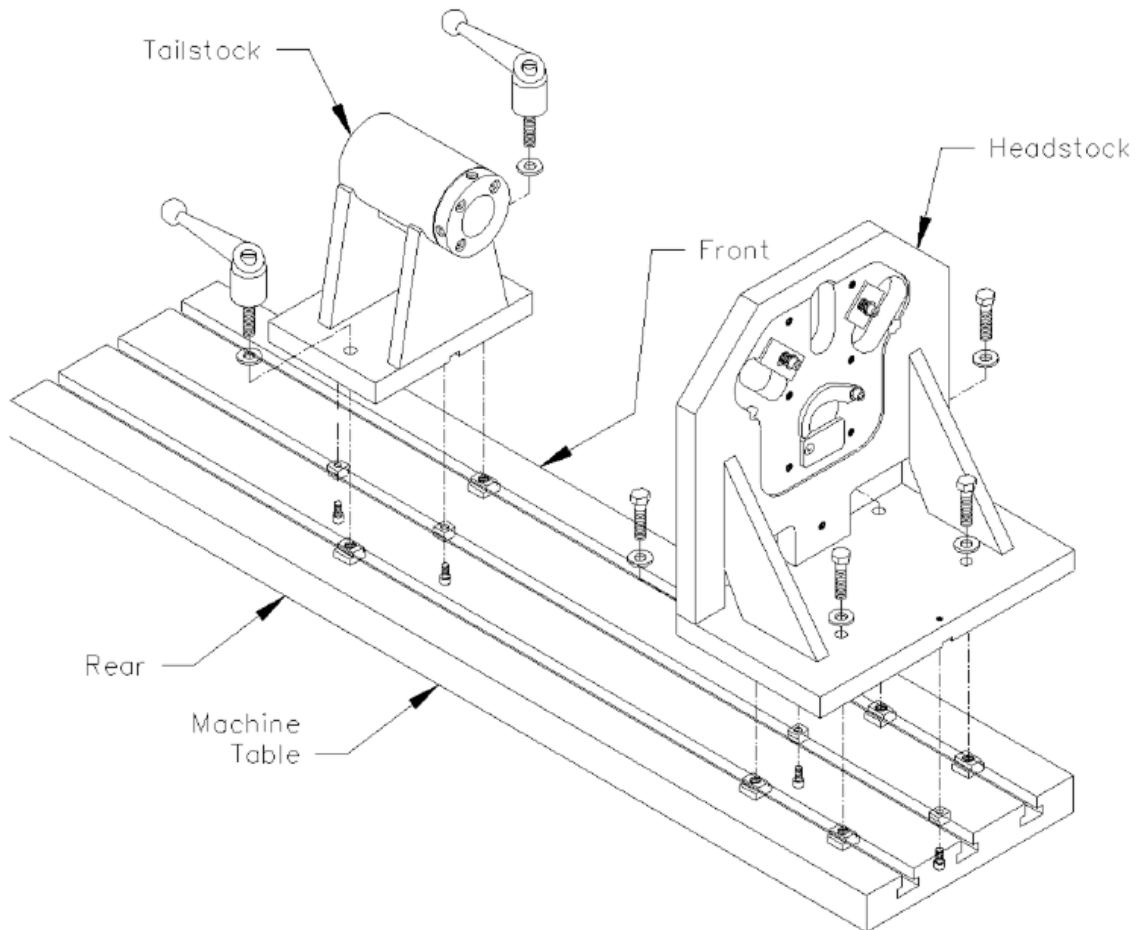
Performance Fixture Parts..... 5

Headstock Parts 5

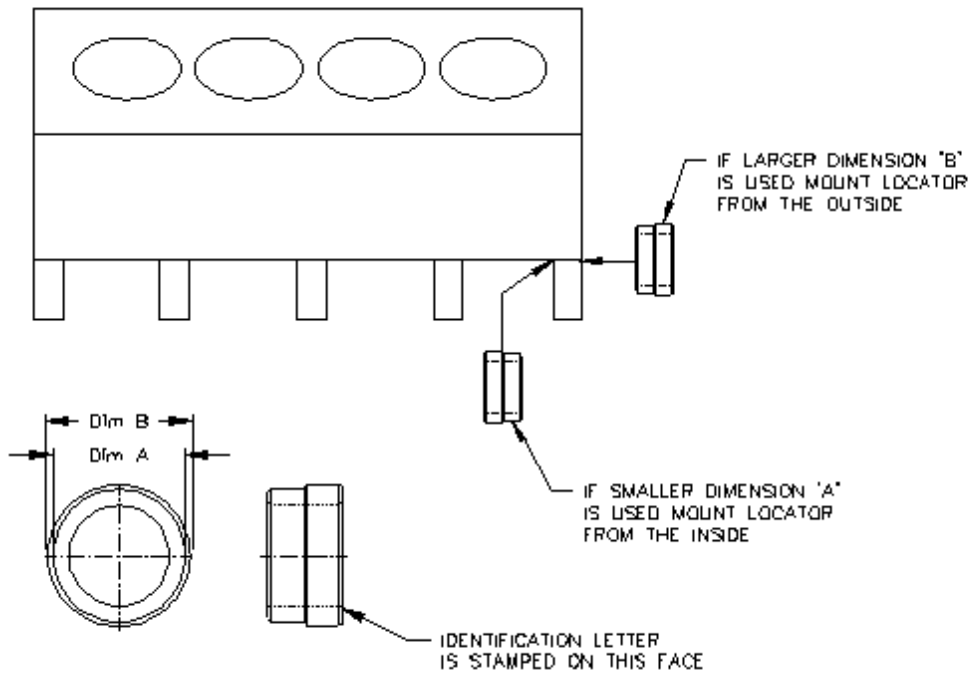
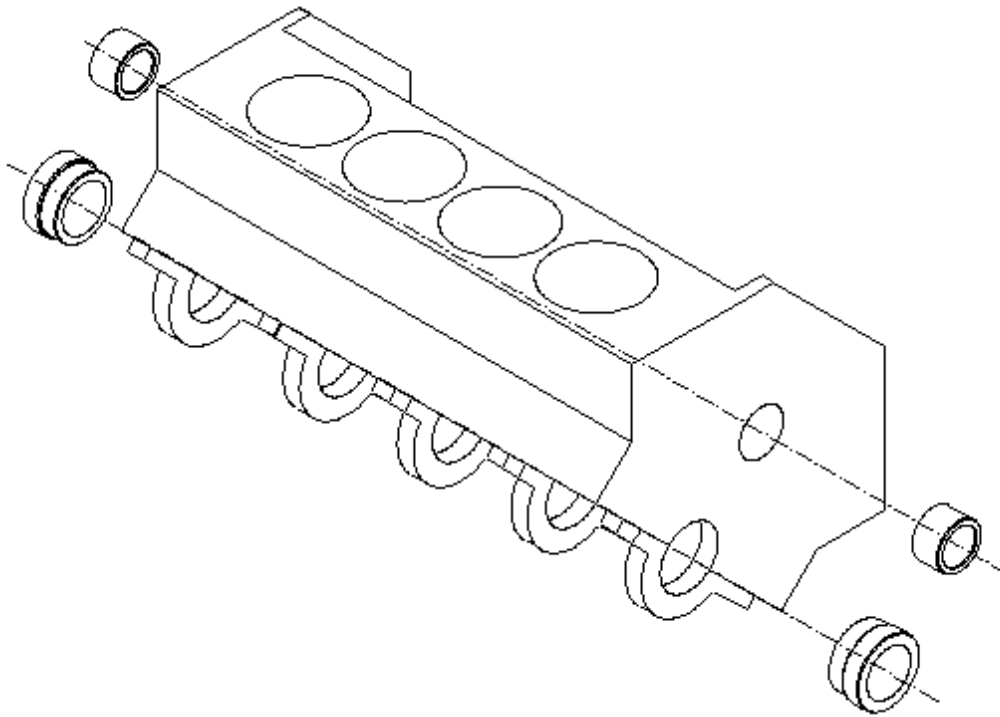
Tailstock Parts 6

Performance Fixture Setup for Cylinder Boring

Install and align the performance fixture head stock on the left hand side of the table as shown below. Follow the alignment procedures for the Performance fixture in the Maintenance section of this manual. Tighten the Head Stock to the table securely using the four Hex bolts and T-Nuts. Install the Tail Stock onto the right hand side of the table but do not tighten down.



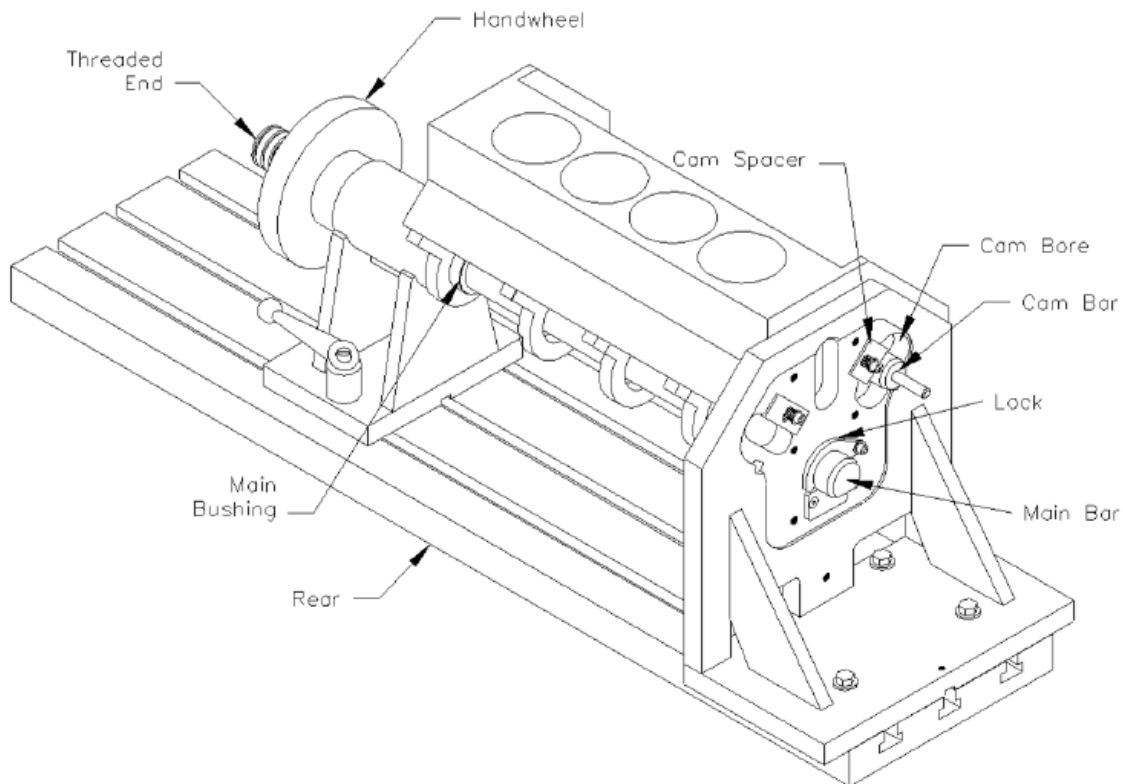
Select the correct Main and Cam bushing for the block you are going to be using from the tables in the Options section of this manual. Place bushings in block as shown below.



Note: Each locator covers two bearing diameters ('A' and 'B'). The unused diameter MUST be placed INSIDE the block to prevent interference with the Index plates.

1. Using a slow travel hoist, position the block between the Head stock and Tail stock with the Bell housing end of the block towards the Head stock.
2. Slide the unthreaded end of the Main Bar through the Tail stock, both Main bushings and into the Head stock with the flat facing down. The threaded end of the Main Bar should be on the Tail stock side of the table. Slide the Lock into the groove on the Main Bar.
3. Rotate the block until the bank you want to bore is facing up. Make sure the cam spacer is not in the cam Bore area at this time. Slide the Cam Bar through the two Cam bushings and into the Head stock with the reduced diameter at the Head stock.
4. Snap the Cam spacer into place.
5. Push the Tail stock up to the block. Tighten the Handwheel with a quick snapping motion.
6. Tighten the two handles on the Tail stock.

The block and fixture are now locked in place and ready for machining.

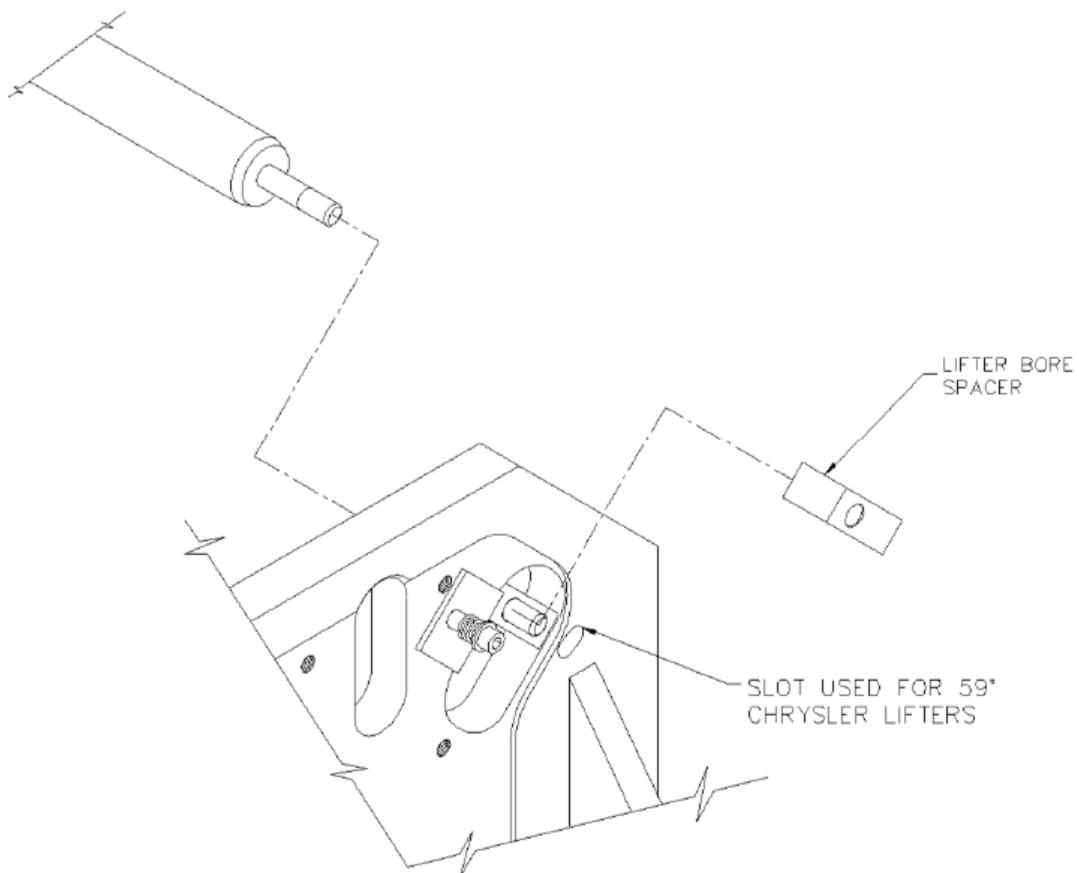


Performance Fixture Setup for Lifter Boring

The same procedure for loading a block in Lifter boring as was used in Cylinder Boring with an exception in the Cam Bar area.

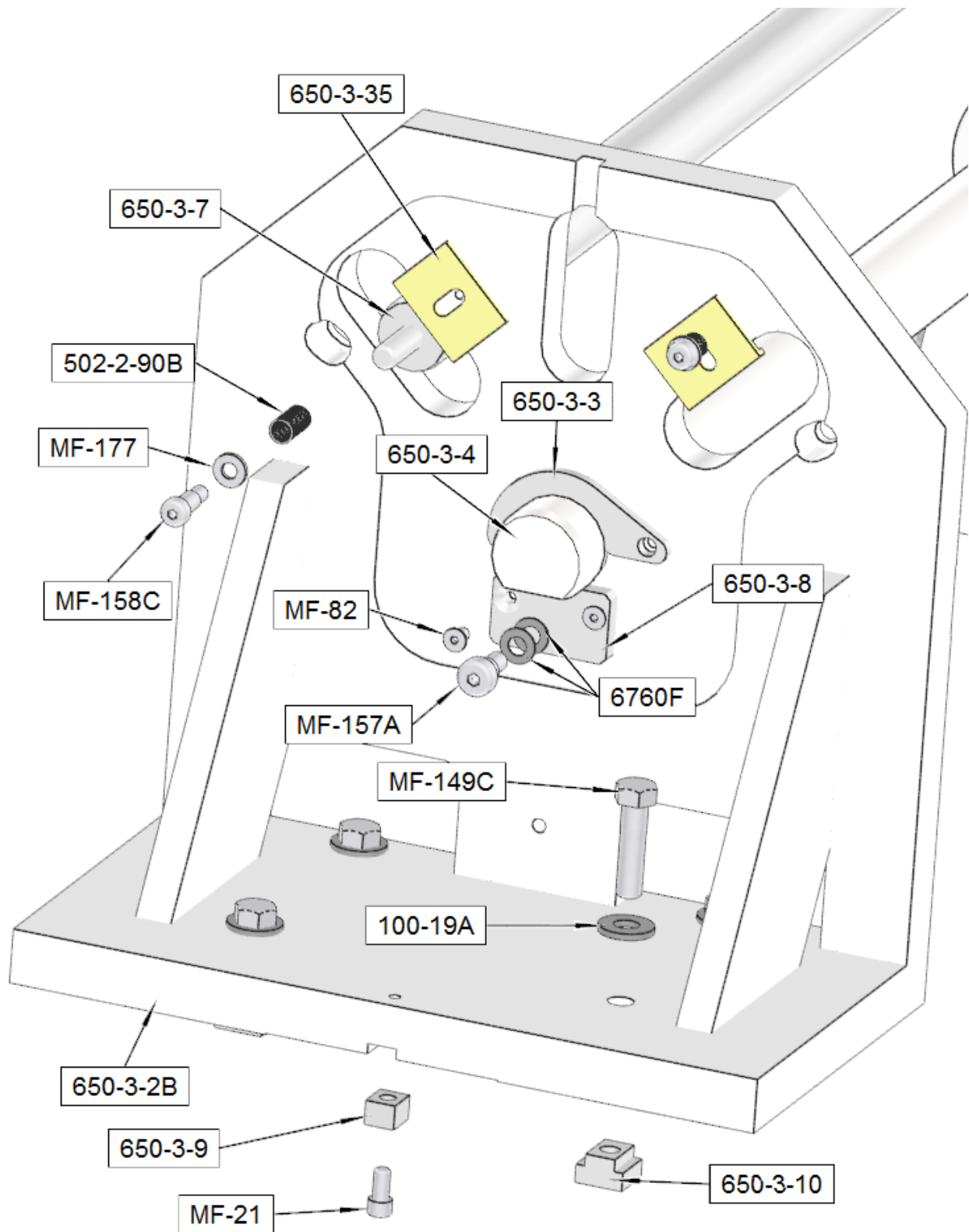
1. Instead of the Cam Bar being slid through the Cam Bore to its full Diameter, the small shaft on the end of the Cam Bar is used in conjunction with spacer Blocks.
2. Select the correct Spacer from the Chart in the Options section of this manual for the angle of the Lifter Bores.
3. The Cam Spacer must be out of the Cam Bore.

See illustration below for spacer installation.



Performance Fixture Parts

Headstock Parts



Tailstock Parts

