



# 650-3-91 Rock n Roll 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

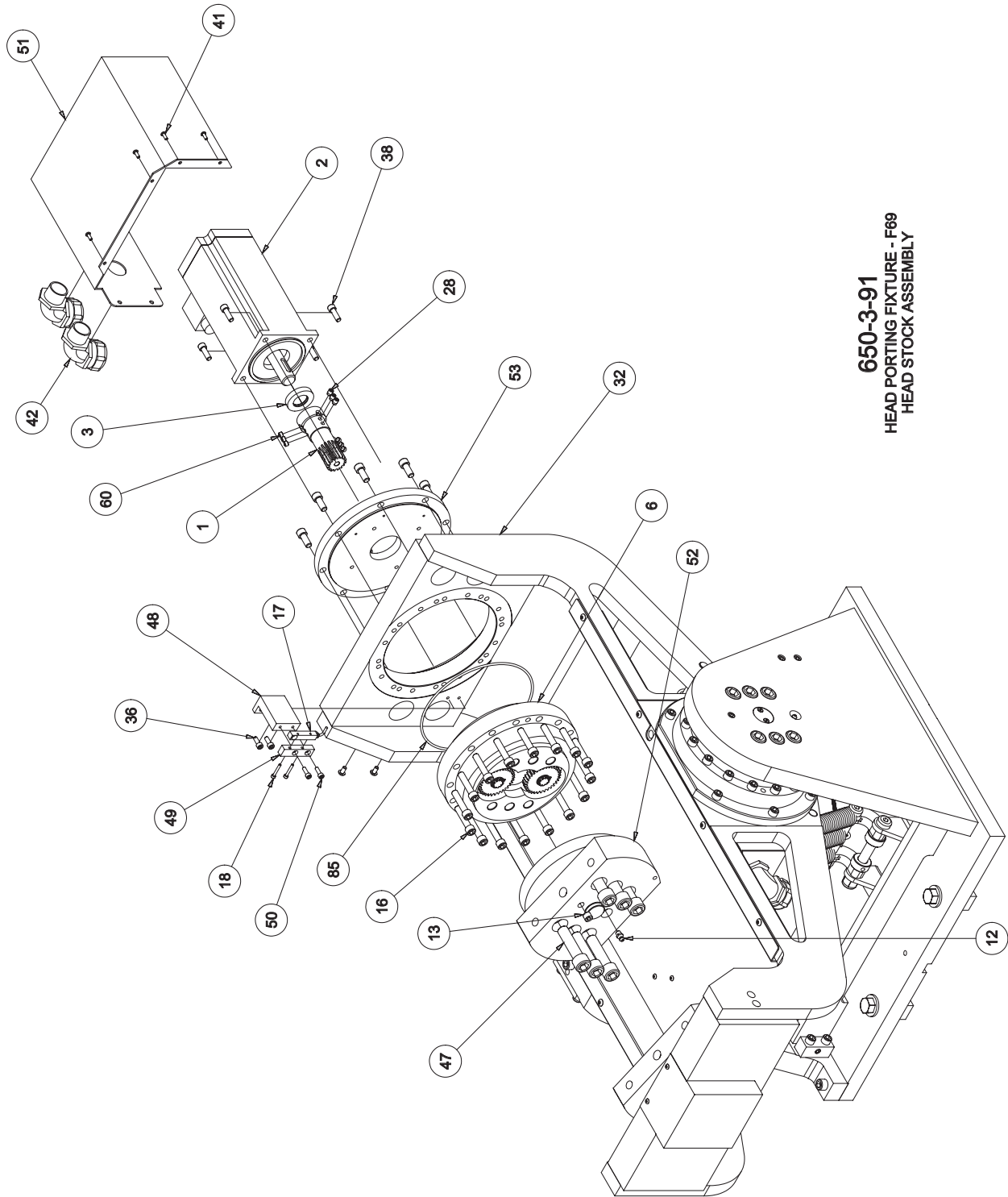
You may also contact us via e-mail with the above information. Send e-mail requests to: [parts@rottermfg.com](mailto:parts@rottermfg.com) or [intlpart@rottermfg.com](mailto:intlpart@rottermfg.com)

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.

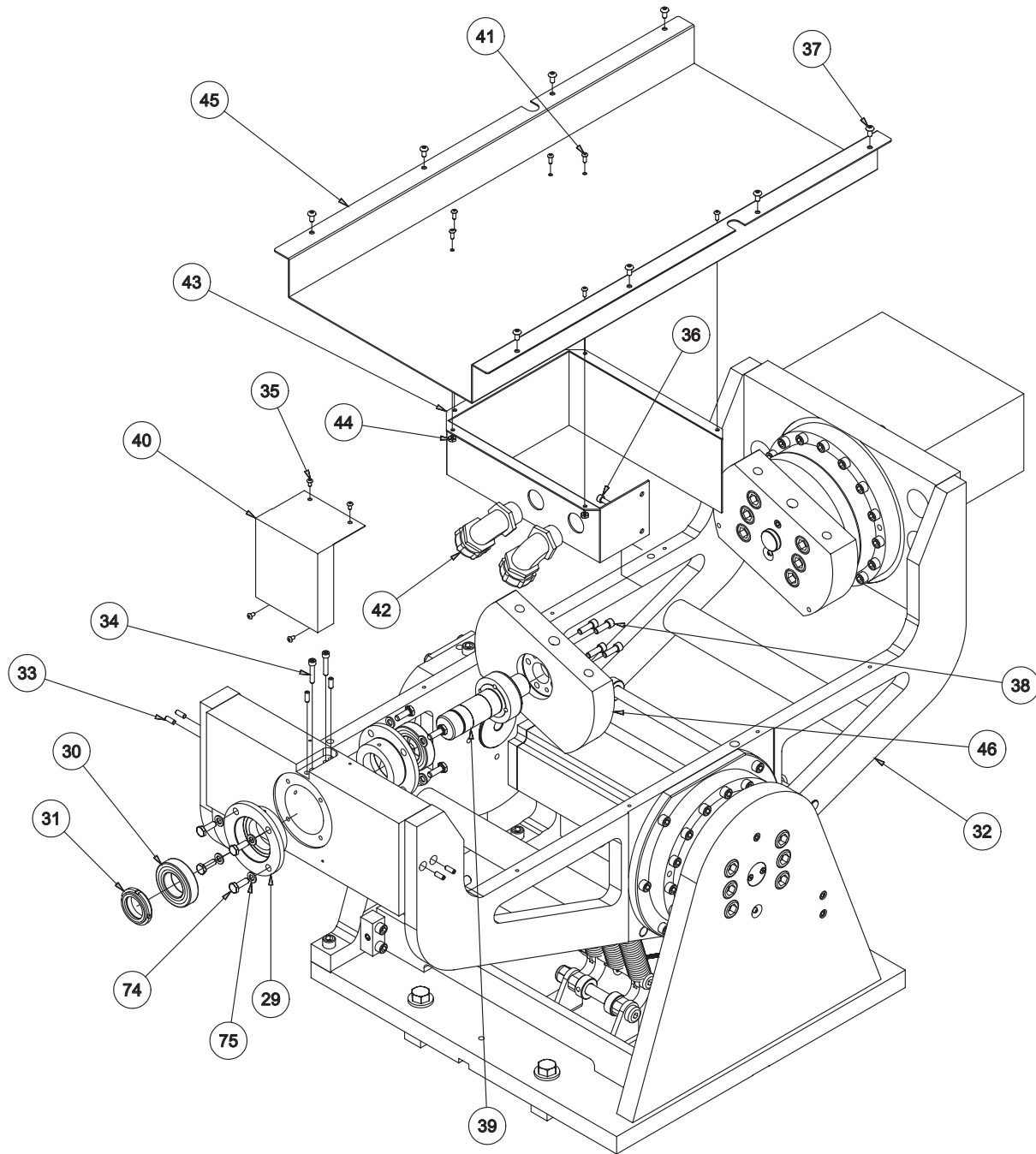
If you are unsure which part you need to order, contact our service department and ask to speak to one of our service consultants. They will assist you in determining which part you require.

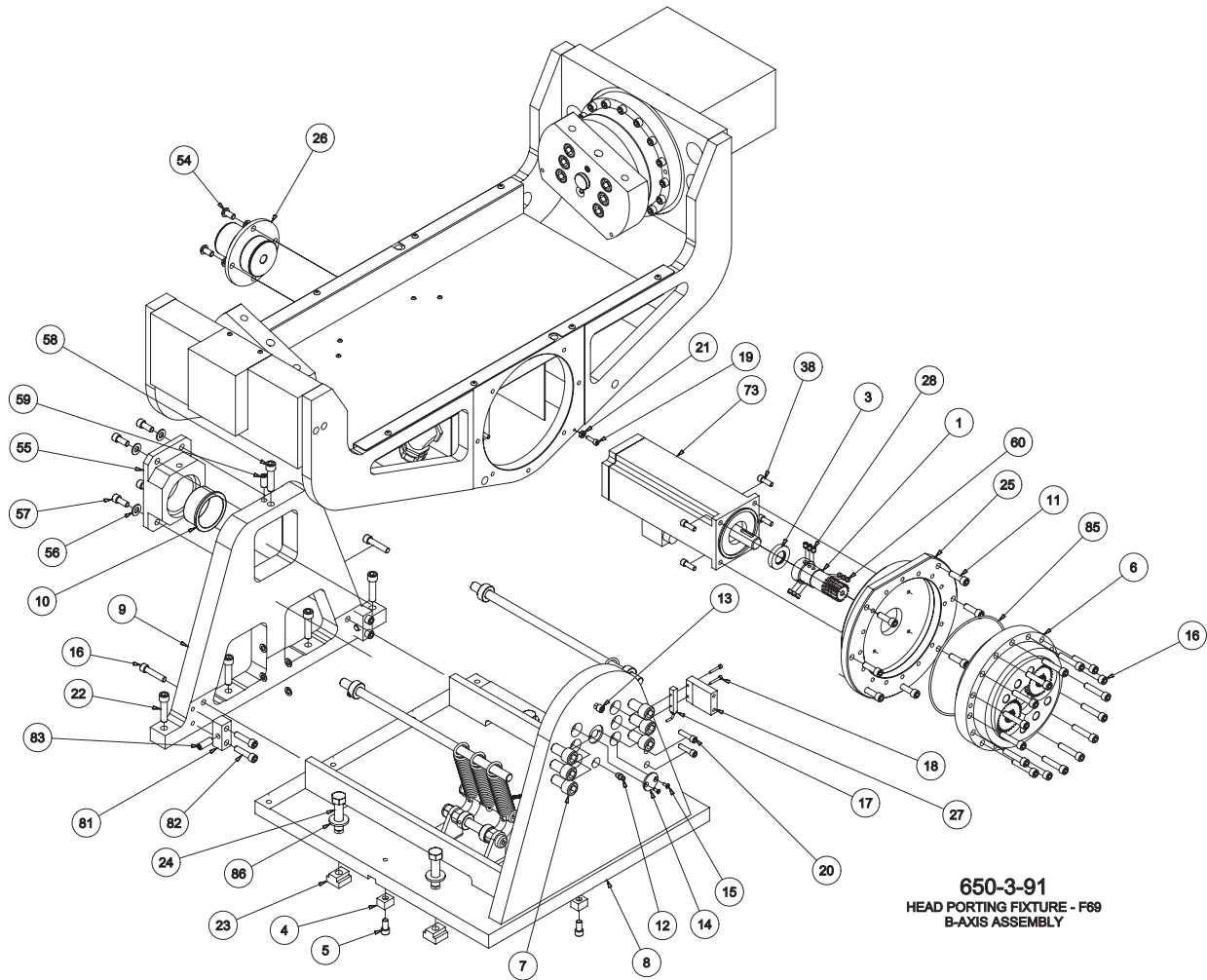
**THERE IS A MINIMUM ORDER OF \$25.00**

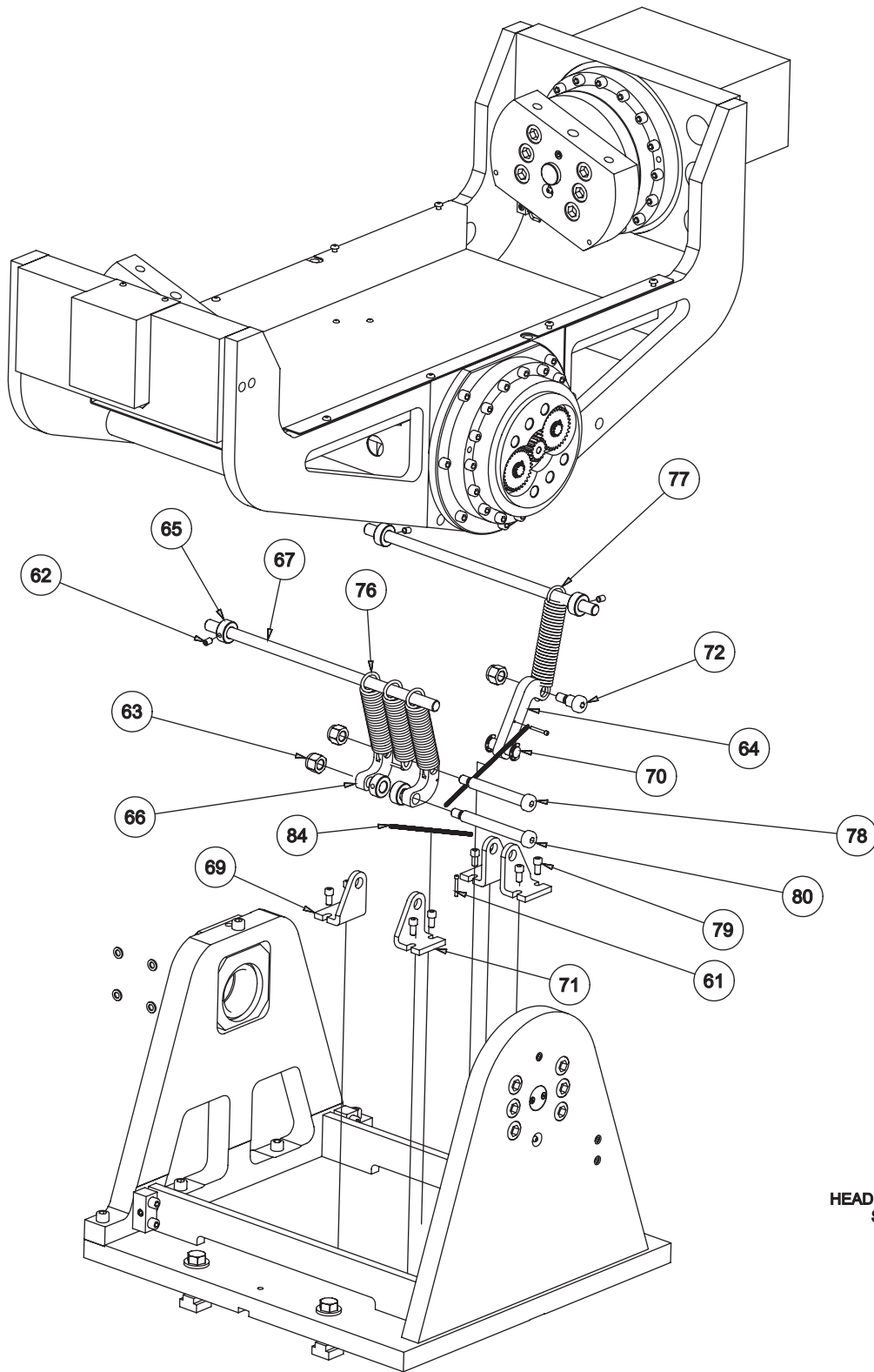




**650-3-91**  
HEAD PORTING FIXTURE - F69  
HEAD STOCK ASSEMBLY







**650-3-91**  
**HEAD PORTING FIXTURE - F69**  
**SPRING ASSEMBLY**



650-3-91 HEAD PORTING FIXTURE ASSEMBLY - F69			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	5506D	INPUT GEAR (REWORK) - REDUCTION GEARBOX - P69
2	1	9020B	SERVO MOTOR
3	2	650-3-61N	OIL SEAL
4	2	650-3-9	Key
5	2	MF-21	S.H.C.S. 5/16 - 18 UNC - 5/8
6	2	5506C	REDUCTION GEARBOX - P69
7	6	650-4-49	M14x2 x 65mm LONG S.H.C.S.
8	1	650-3-91A	BASE, MACHINING - HEAD PORTING FIXTURE F69
9	1	650-3-91C	SIDE PLATE (MACHINING), BASE - HEAD PORTING FIXTURE - F69
10	1	650-3-91P	BEARING, FRAME PIVOT, HEAD PORTING FIXTURE - F69
11	7	MF-23	S.H.C.S.5/16 - 18 UNC - 1
12	2	MF-189	STRAIGHT GREASE FITTING
13	2	MF-233	Countersunk Hex-Head Plug 1/8
14	1	5506E	COVER, TOOLING HOLE, MOTOR MOUNT - P69
15	2	MF-121A	6-32UNC x 3/8" LONG SOCKET FLAT HEAD SCREW
16	34	MF-25	S.H.C.S. 5/16 - 18 UNC - 1 1/2
17	2	514-2-65C	Proximity Switch
18	4	514-2-65E	M3x.5 x 20mm S.H.C.S.
19	2	MF-9	S.H.C.S. 10-32 UNF - 0.625
20	2	MF-15	Hexagon Socket Head Cap Screw
21	1	MF-161	10-32UNF HEX NUT
22	4	MF-33	Hexagon Socket Head Cap Screw
23	4	650-3-10	TN-5 T-Nut
24	4	MF-149C	Hex Bolt 1/2-13 x 2
25	1	650-3-91N	ADAPTER, GEAR REDUCTION, HEAD PORTING FIXTURE - F69
26	1	650-3-91R	REAR PIVOT
27	1	650-3-91S	MOUNT BLOCK, HOME POSITION SENSOR (B AXIS) - HEAD PORTING FIXTURE - P69
28	6	5506G	SET SCREW REWORK 1/4-20
29	2	5510F	REAR BEARING CUP, TAILSTOCK - P65
30	2	502-9-72B	BALL BEARING
31	1	6777B	LOCKNUT BH-06
32	1	650-3-91E	TILT FRAME MACHINING
33	6	MF-56B	SOCKET FLAT POINT SET SCREW 10-32UNF x 1/2" LG.
34	2	MF-6A	S.H.C.S. 10 - 24 UNC - 1
35	4	650-1-2C	6-32UNC x 1/4" LG. SOCKET BUTTONHEAD SCREW
36	4	MF-5A	S.H.C.S. 10 - 24 UNC - 1/2
37	10	MF-88	Hexagon Socket Button Head Cap Screw
38	12	MF-14	S.H.C.S. 1/4 - 20 UNC - 3/4
39	1	650-3-91Q	CENTER SHAFT, TAILSTOCK F69 HEAD PORTING FIXTURE
40	1	650-3-91J	COVER, TAILSTOCK, HEAD PORTING FIXTURE - F69
41	10	MF-88B	6-32UNC x 3/8" LG. SOCKET BUTTONHEAD SCREW
42	4	502-6-8	3/4 pipe fitting 90 deg. elbow
43	1	650-3-91T	COVER, B-AXIS MOTOR, HEAD PORTING FIXTURE - F69

650-3-91 HEAD PORTING FIXTURE ASSEMBLY - F69			
ITEM	QTY	PART NUMBER	DESCRIPTION
44	6	MF-159	6-32UNC HEX NUT
45	1	650-3-91M	COVER, FRAME, HEAD PORTING FIXTURE - F69
46	1	5510D	MOUNTING BLOCK, FIXTURE - TAILSTOCK F65
47	6	650-4-50	M14x2 x 25mm LG. S.H.C.S.
48	1	5509E	MOUNT BLOCK, LIMIT SWITCH - INDEXER HEAD STOCK - P69
49	1	514-4-61N	Prox Sensor Mount
50	2	MF-2	S.H.C.S. 8 - 32 UNC - 1/2
51	1	650-3-91L	COVER, HEADSTOCK, HEAD PORTING FIXTURE - F69
52	1	5509D	MOUNT BLOCK, HEAD STOCK END
53	1	650-3-92F	MOTOR MOUNT PLATE, HEAD PORTING FIXTURE - F69
54	4	MF-93	Hexagon Socket Button Head Cap Screw
55	1	650-3-92E	REAR BEARING SUPPORT
56	4	MF-177	5/16" SAE FLAT WASHER
57	12	MF-22	S.H.C.S. 5/16 - 18 UNC - 3/4
58	1	650-3-92Y	3/8-24UNF x 1-1/2" LG. S.H.C.S.
59	1	650-3-92Z	3/8-24UNF x 3/4" LG. FLAT POINT SOCKET SET SCREW
60	12	5506Q	1/4-20UNC x 3/16" LG. SOCKET FLAT POINT SET SCREW
61	4	MF-84B	4-40UNC x 7/8" LG. S.H.C.S.
62	3	MF-59	Flat Point 1/4-20 UNC x 0.38
63	3	514-3-59D	1/2-13UNC NYLOCK NUT
64	1	650-3-91X	RETURN SPRING LINK, HEADSTOCK (MACHINING)
65	5	650-3-91W	SHAFT COLLAR, RETURN SPRING
66	2	650-3-91Z	RETURN SPRING LINK, TAILSTOCK (MACHINING)
67	2	650-3-92A	RETURN SPRING UPPER MOUNT BAR - HEAD PORTING FIXTURE - F69
68	2	650-3-45H e-Clip	e-Clip
69	2	650-3-45H LEFT	Pivot Bracket, left, Bimba D-13512-A
70	1	650-3-45H Pin	PIN, PIVOT BRACKET, Bimba D-13512-A
71	2	650-3-45H RIGHT	Pivot Bracket, Right, Bimba D-13512-A
72	1	502-9-83	.500" DIA. x .51" LONG SOCKET SHOULDER SCREW
73	1	650-3-92G	SERVO MOTOR, TILT - HEAD PORTING FIXTURE - F60
74	8	MF-134A	1/4-20UNC x 3/4" LONG HEX HEAD CAP SCREW
75	8	MF-176	1/4" SAE FLAT WASHER
76	3	650-3-91U	RETURN SPRING, TAIL STOCK
77	1	650-3-91V	RETURN SPRING, HEAD STOCK
78	1	650-3-92C	.50" DIA. x 3-1/4" LONG SOCKET SHOULDER SCREW
79	8	MF-12	S.H.C.S. 1/4 - 20 UNC - 1/2
80	1	650-3-92B	.50" DIA. x 3-3/4" LONG SOCKET SHOULDER SCREW
81	2	6451Q	Block, Adjusting Belt, Servo Motor
82	4	MF-24	S.H.C.S. 5/16 - 18 UNC - 1 1/4
83	2	MF-70	Hexagon Socket Set Screw - Flat Point
84	2	514-7-83E	SPRING, GARTER
85	2	5506U	O-RING, GEARBOX
86	4	100-19A	Hardened washer 17/32 I.D.