

ROTTLER

FA & FX BORING MACHINE 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 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. For customers within the U.S. send emails to parts@rottermfg.com, for customers outside of the U.S. use intlparts@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

FA & FX OPTIONAL EQUIPMENT PARTS MANUAL

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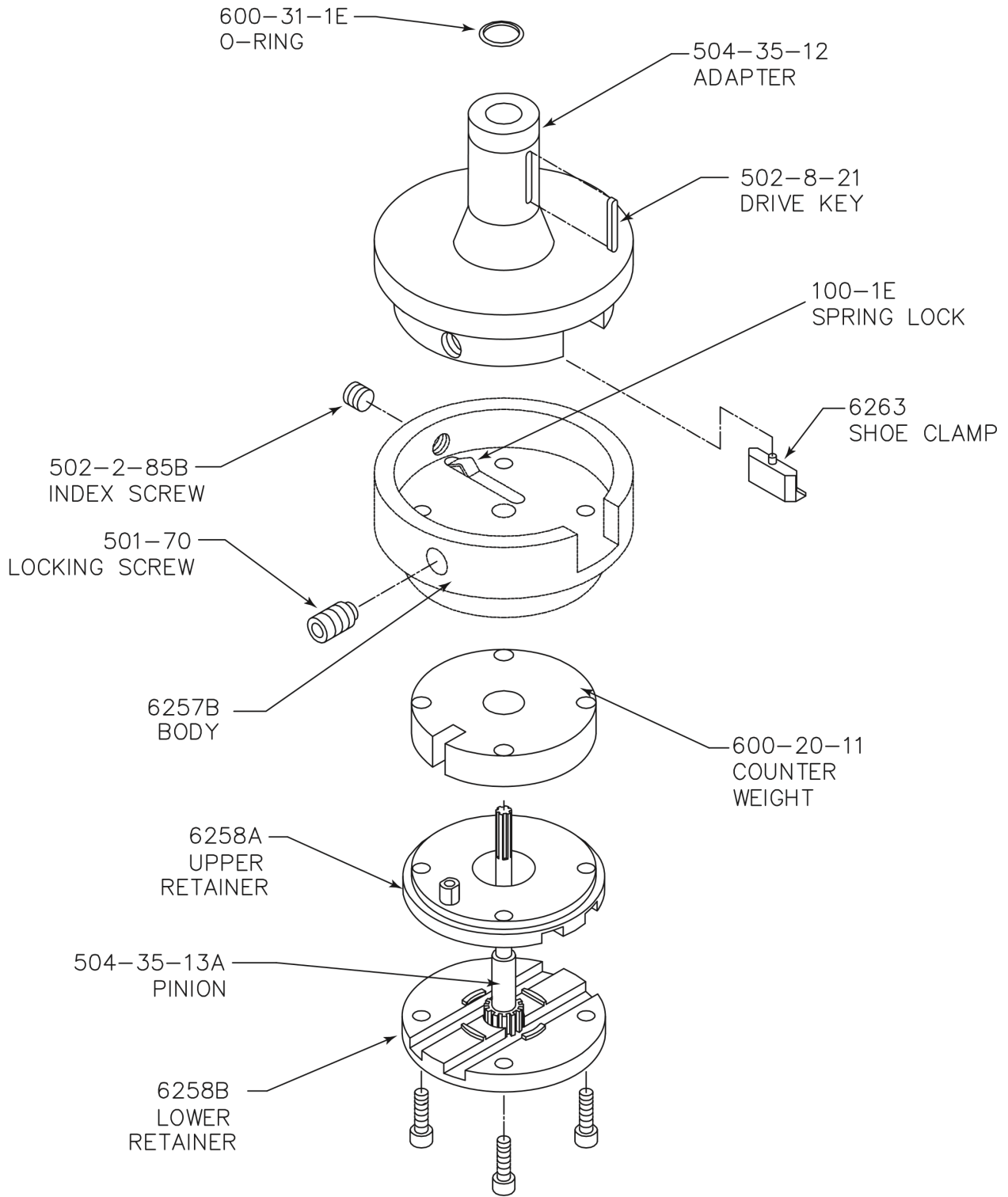
502-12-4 Magnetic Holding Block Assembly 32

Cutting Tools

Boring Tools

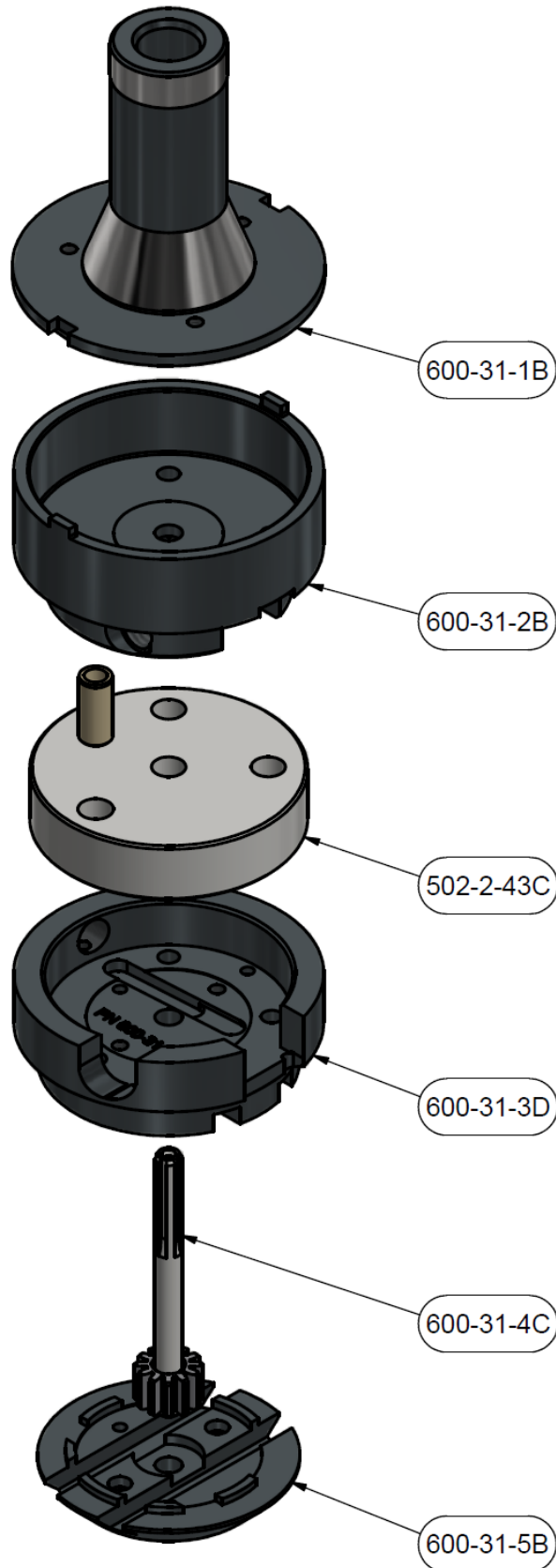
504-35-12A Cutterhead Kit, 4.5-9" Diameter





600-8-4L Cutterhead Kit, 2.875-5.0" Dia



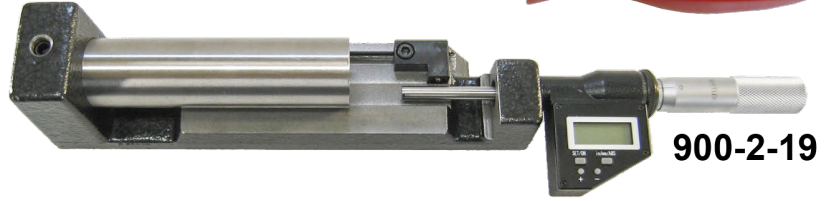


502-13U Cutterhead Kit, 2.68-5.0" Dia.

502-13T

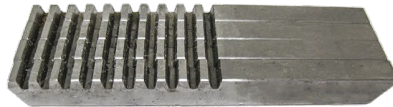


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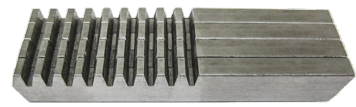


900-2-19

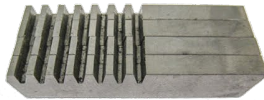
200-11



200-10-1



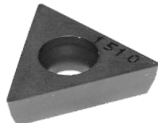
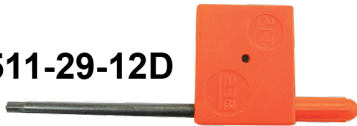
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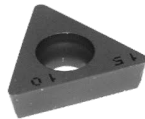
511-29-32B



511-29-12D



RT321



RT322

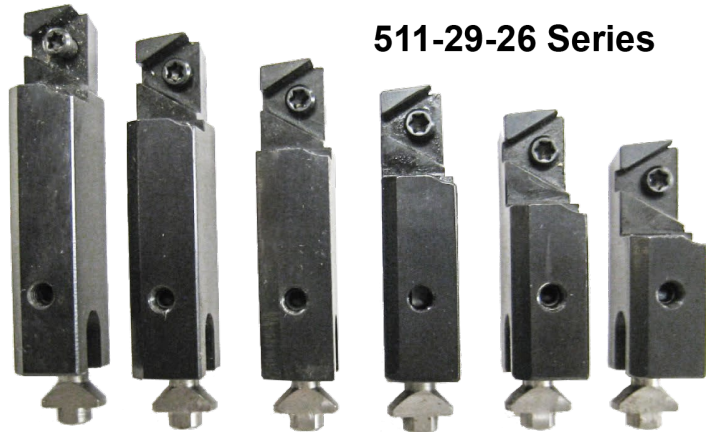


RT211



RT212

511-29-26 Series



26P

26N

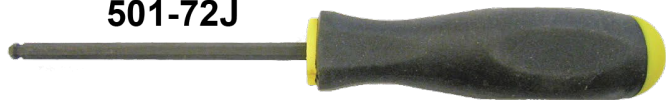
26M

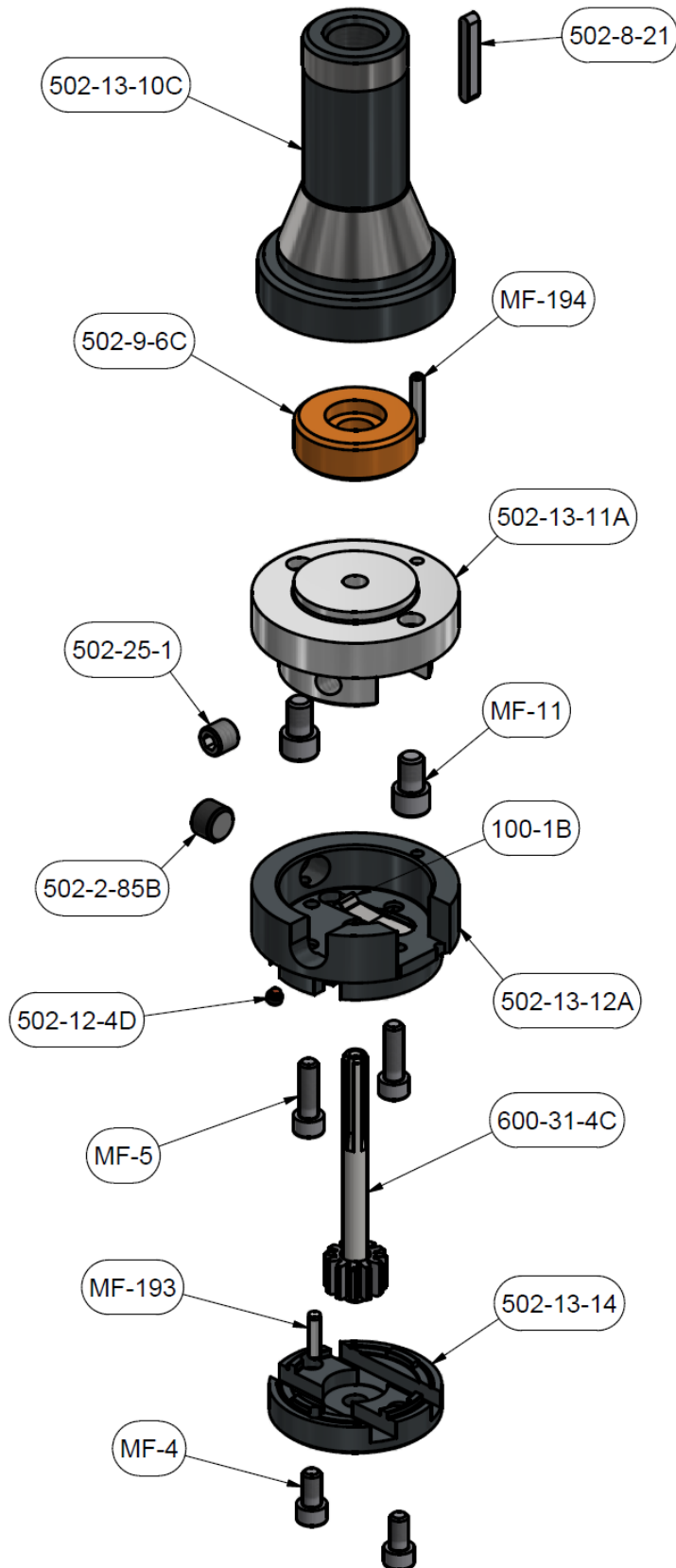
26L

26K

26J

501-72J



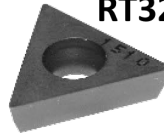


502-13M Stub Bar Cutterhead, 2.19-4.1" Dia. X 6" Long

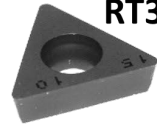
502-13N



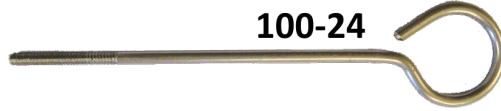
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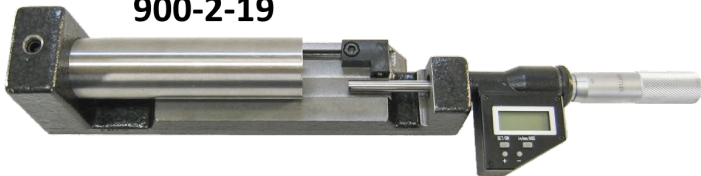
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100-24



900-2-19



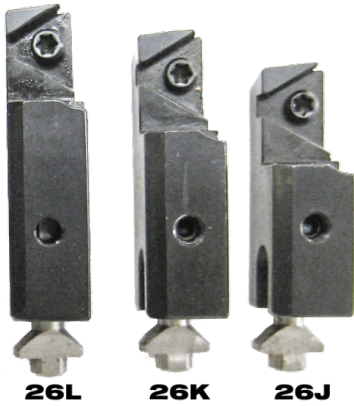
RT211



RT212



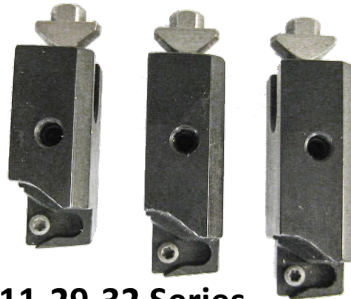
511-29-26 Series



32

32A

32B



511-29-12D



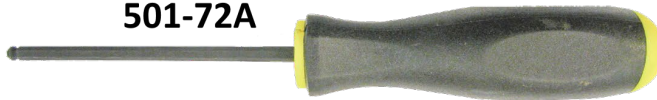
511-29-12F



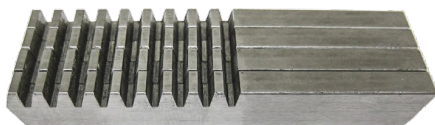
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501-72A

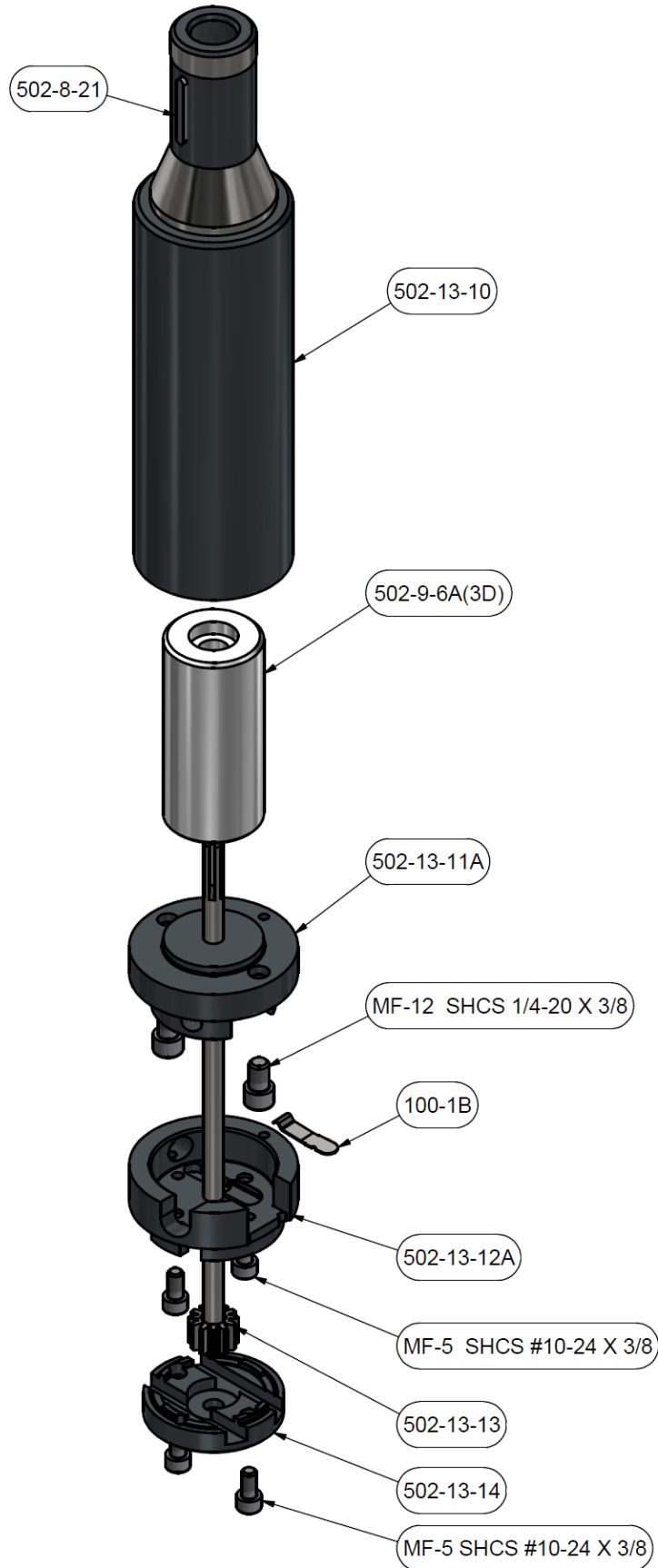


200-10-1



T8D



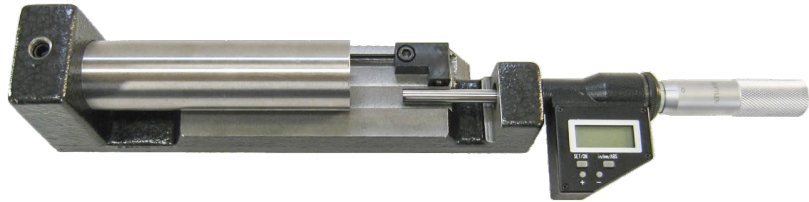


600-8-5 Blind Hole Cutterhead Kit, 2.6-5.0" Dia.

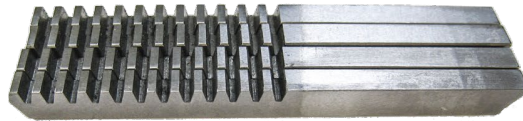
600-8-5A



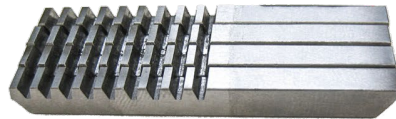
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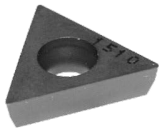
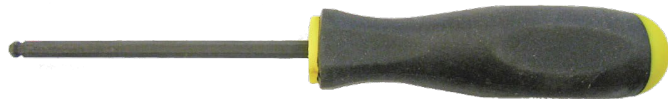
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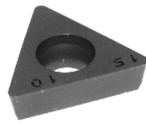
200-21-3



501-72J



RT321



RT322



511-29-12D

F



G



H



J



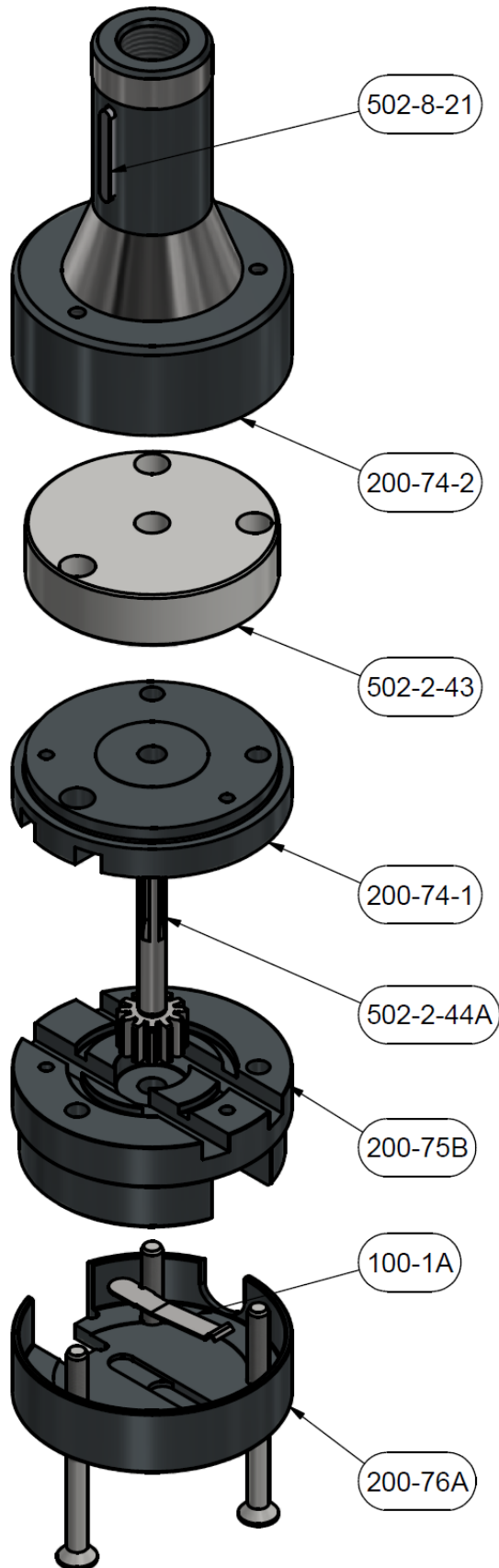
K



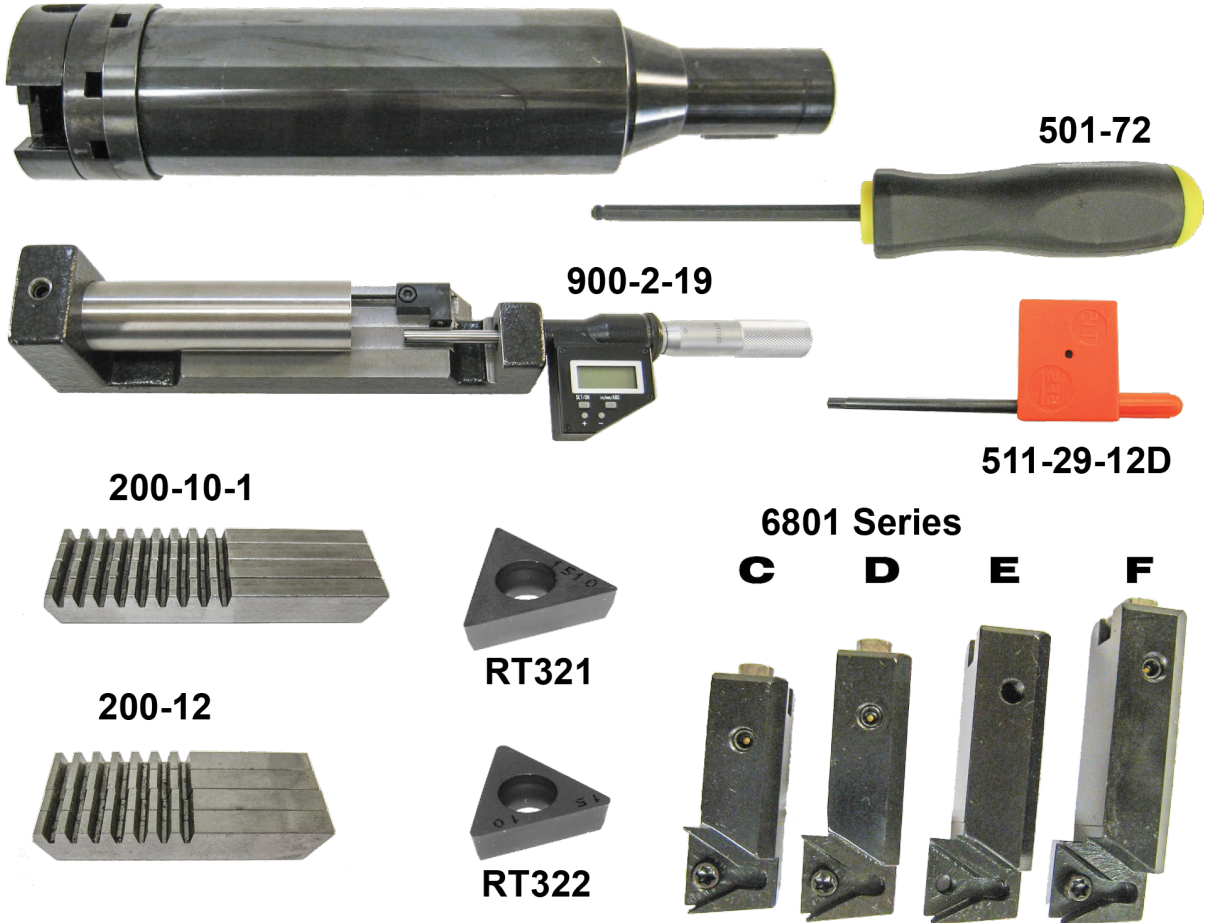
L

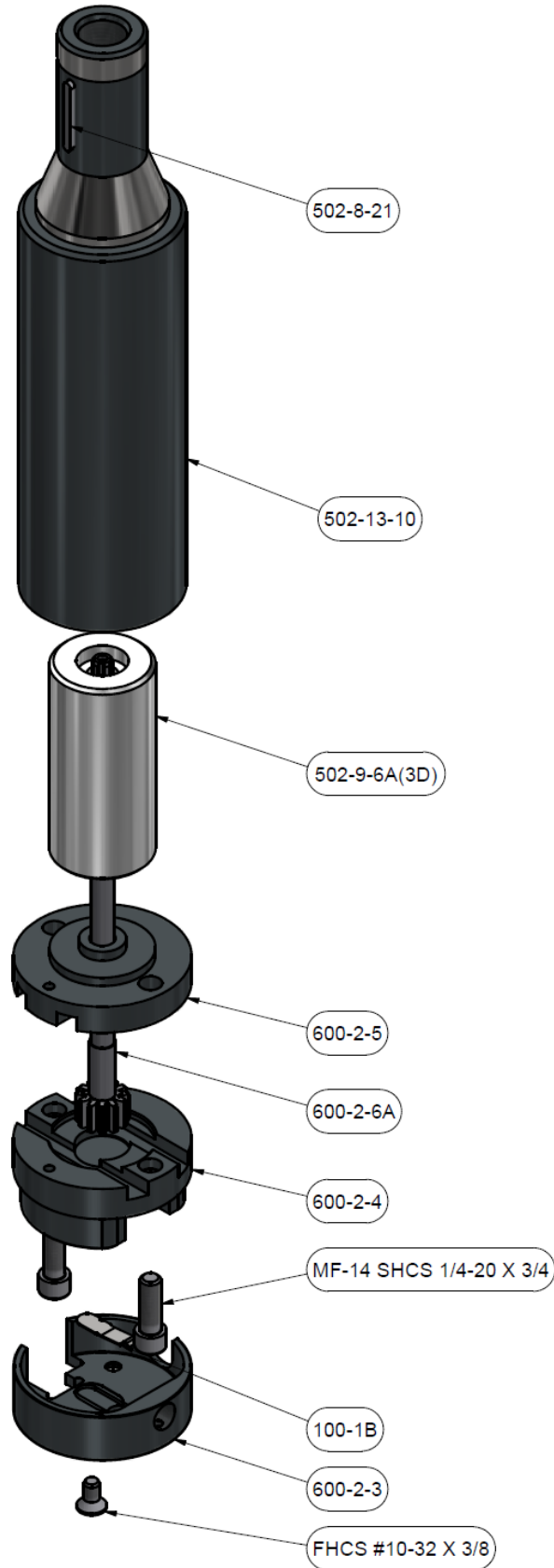


6801 Series



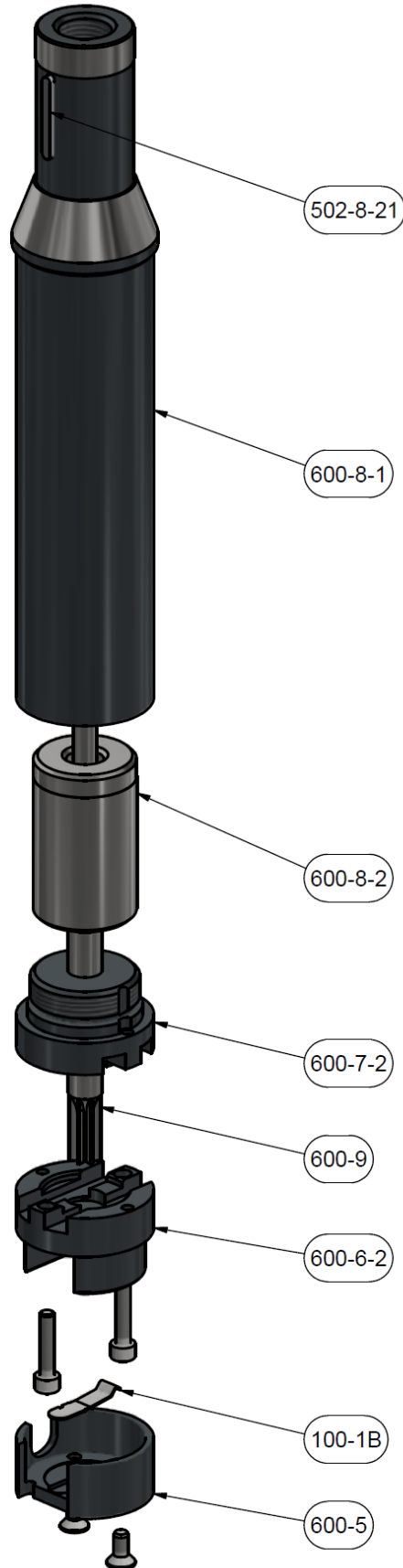
600-2-2 Blind Hole Stub Bar Kit, 2.2-4.0" Dia. X 6.375" Long 600-2-2A





600-2 Blind Hole Stub Cutterhead, 1.5-4.1" Dia. X 6.5" Long



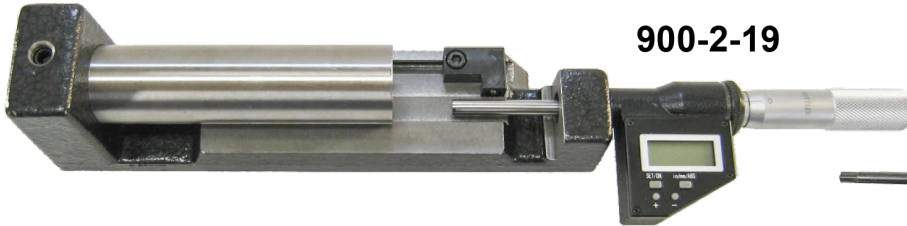


600-8-3A Blind Hole Stub Cutterhead, 1.5-4.1" Dia. X 5.25" Long

600-8-3B



501-72A

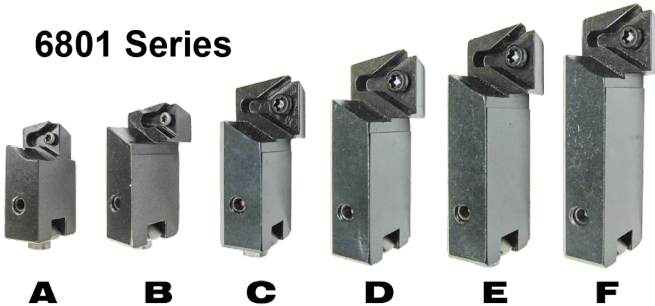


900-2-19



511-29-12D

6801 Series

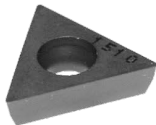


A B C D E F

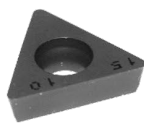
200-26-1



200-26-2



RT321



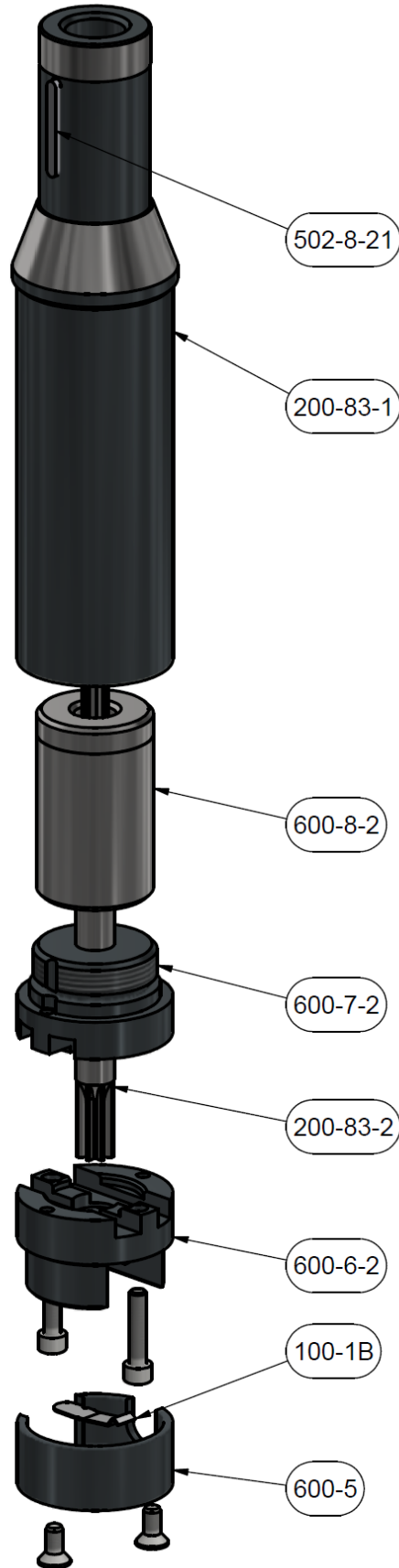
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RT212



600-8-8A Blind Hole Stub Cutterhead, 1.5-4.1" Dia. X 3" Long

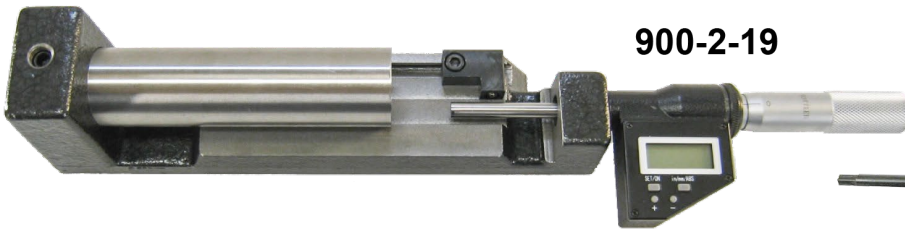
600-8-8B



501-72A



T8D

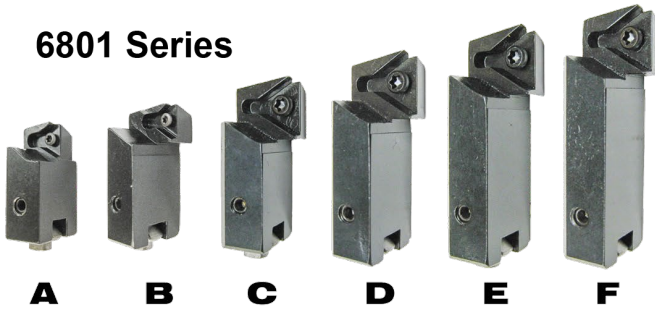


900-2-19



511-29-12D

6801 Series



A

B

C

D

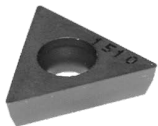
E

F

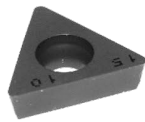
200-26-1



200-26-2



RT321



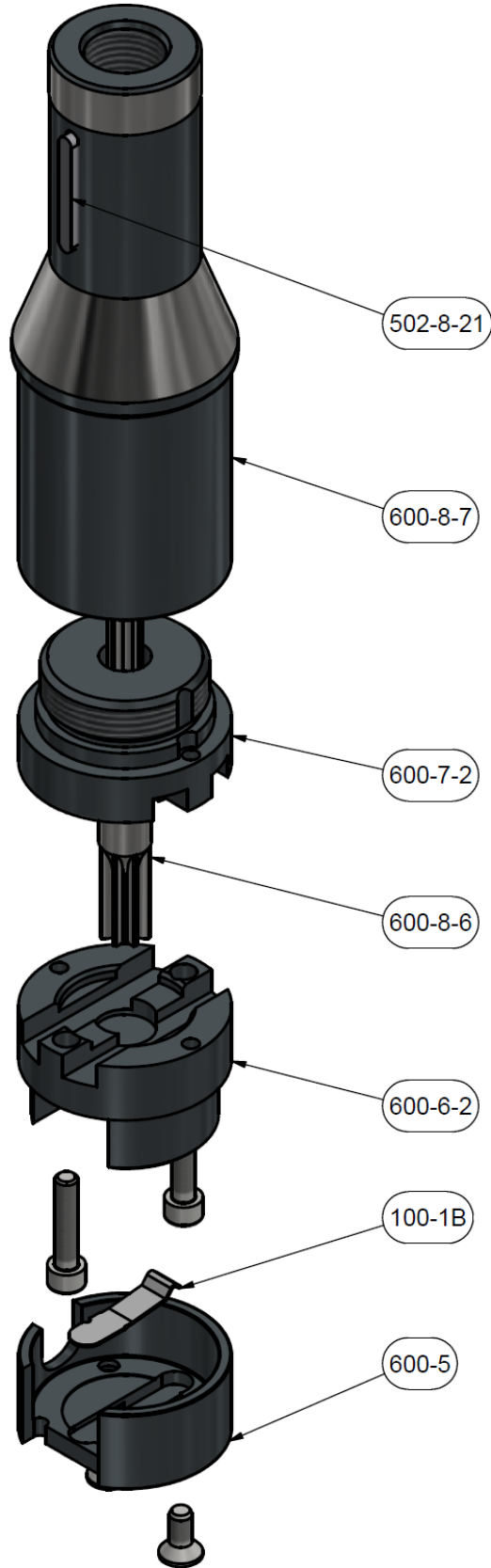
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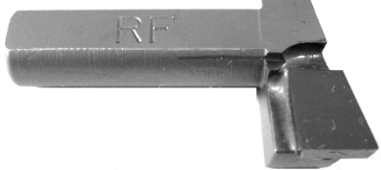
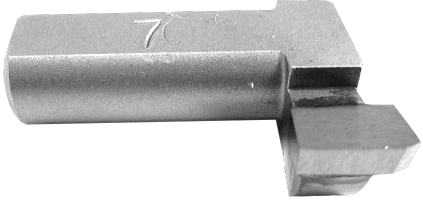
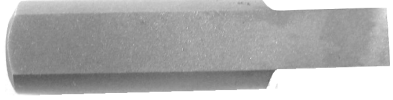
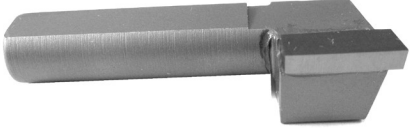


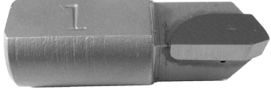
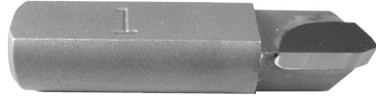
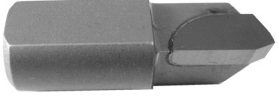
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RT212



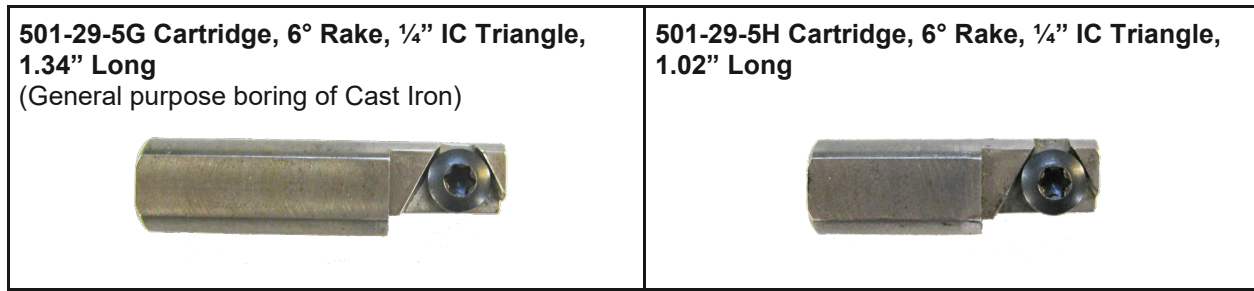
Insert Holders
Brazed Carbide Tools

<p>100-29 Offset Tool Bit for Blind Holes</p> 	<p>100-29-6 Offset FR Tool Bit (Mercury outboard blind hole sleeves)</p> 
<p>100-29-7 Offset GM Tool Bit (GM 60° V6)</p> 	<p>100-74 VW Thrust Facing Tool Bit</p> 
<p>100-76 Offset Tool Bit ½" (12.7mm) Wide, VW Cylinder Head Facing</p> 	<p>501-28 Steel Cutting Tool Bit w/ Chip Curler</p> 
<p>501-29A FR Facing and Counterboring Tool Bit (For Cast Iron blocks, sleeve cutoff)</p> 	<p>501-30-1 R1 Carbide Tool Bit 1" (25.4mm) Hi-speed Finishing, non-interrupted cuts</p> 
<p>501-30-2 R1 Carbide Tool Bit 1 ⅜" (34.9mm)</p> 	<p>501-31-1 R8 Carbide Tool Bit 1" (25.4mm) General Purpose & Heavy cuts on cast iron, recommended for interrupted cuts</p> 

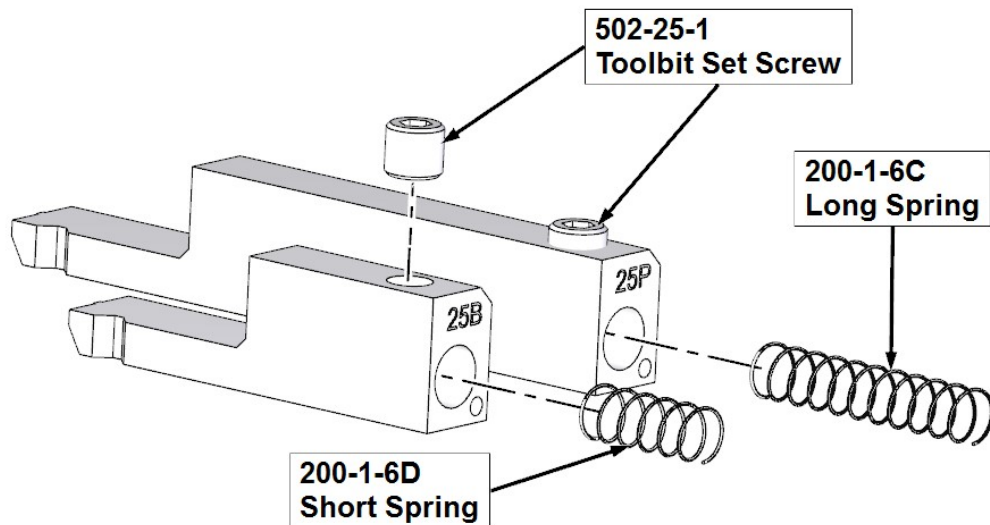
<p>501-31-2 R8 Carbide Tool Bit 1 3/8" (34.9mm)</p> 	<p>501-31-1A R8 Carbide Tool Bit 11/16" (17.5mm)</p> 
<p>501-31A Cummins Counterbore Tool Bit</p> 	<p>501-32-1 Special Grooving Tool Bit, 048 (O-Ring Tool)</p> 
<p>501-32-2 Special Grooving Tool Bit, 072</p> 	<p>501-32-3 Special Grooving Tool Bit, 037</p> 
<p>501-32-4 Special Grooving Tool Bit, 152</p> 	<p>501-32-6 Special Grooving Tool Bit, 039</p> 
<p>501-33B Chamfer Tool Bit, 15° (For chamfering Cummins Blocks)</p> 	<p>501-33D Chamfer Tool Bit, 30° (For general Cast Iron)</p> 

501-33E Chamfer Tool Bit, 45°**501-33-1 R8 Carbide, 12° Hi-Rake Tool Bit**
(For roughing cuts)**501-33-2 R1 Carbide, 12° Hi-Rake Tool Bit**
(For Aluminum – Vega)

Indexable Insert Cartridge Tool Bits



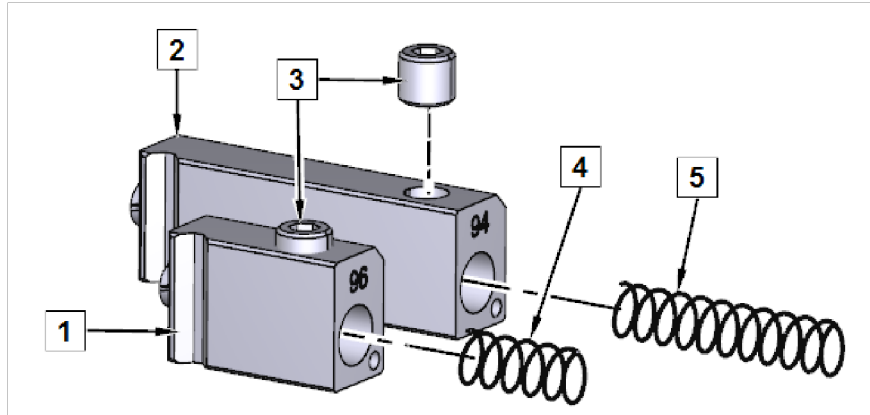
502-25 Series, "F" Type Tool Holders for Brazed Bits



502-25 Series Tool Holder Bore Range Chart		
Tool Holder Number	Cartridge Length Used	Bore Range
502-25A	Long	3 7/8 – 5" (98.4-127.0mm)
502-25B	Short	3 1/8 - 4 1/8" (79.38-104.78mm)
502-25C	Long	2 7/8 – 3 5/8" (2.88-92.08mm)
502-25D	Long	4 3/4-6" (120.65-152.4mm)
502-25E	Long	5 5/8-7 1/8" (142.88-180.98mm)
502-25F	Long	7 1/8-8 1/8" (180.98-206.38mm)
502-25G	Long	3 3/8-4 3/8" (85.7-111.13mm)
502-25H	Short	2 1/4-3" (57.15-76.2mm)
502-25I	Short	2 3/8-3 3/8" (60.33-85.73mm)
502-25J	Short	2 7/8-3 7/8" (73.03-98.43mm)
502-25K	Short	3 5/8-4 5/8" (92.08-117.48mm)

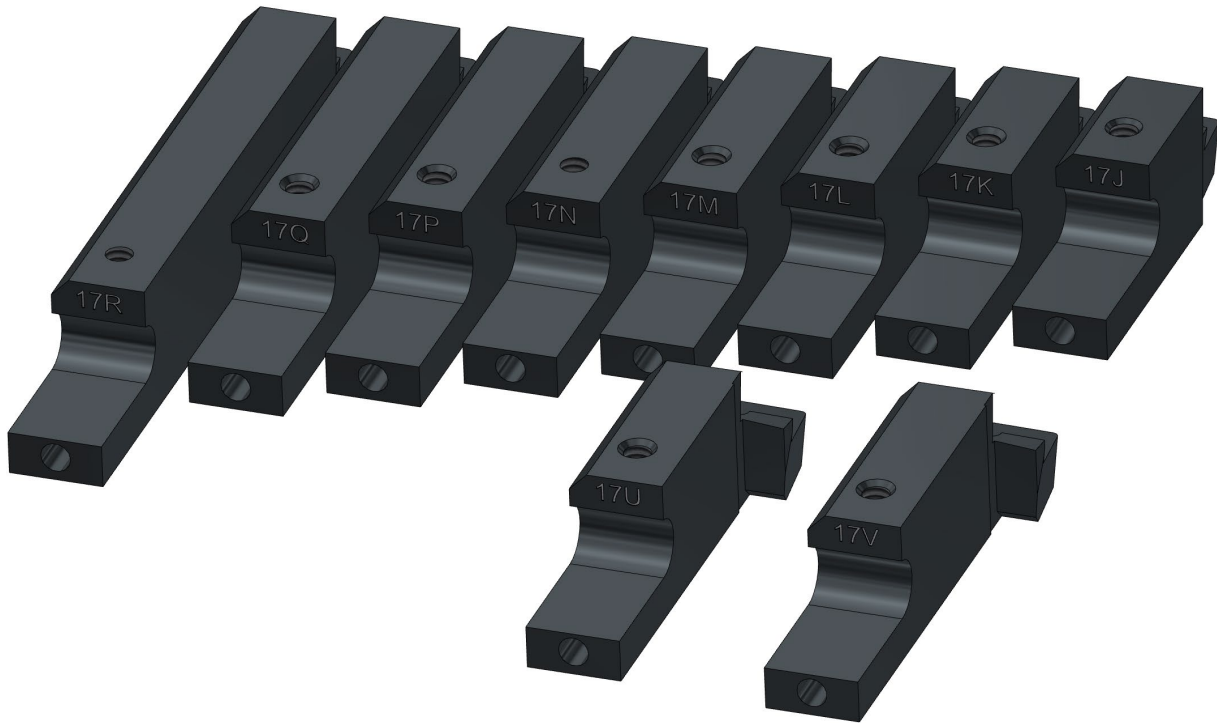
“D” Type Tool Holders for Brazed Tool Bits

199 Series Tool Holders



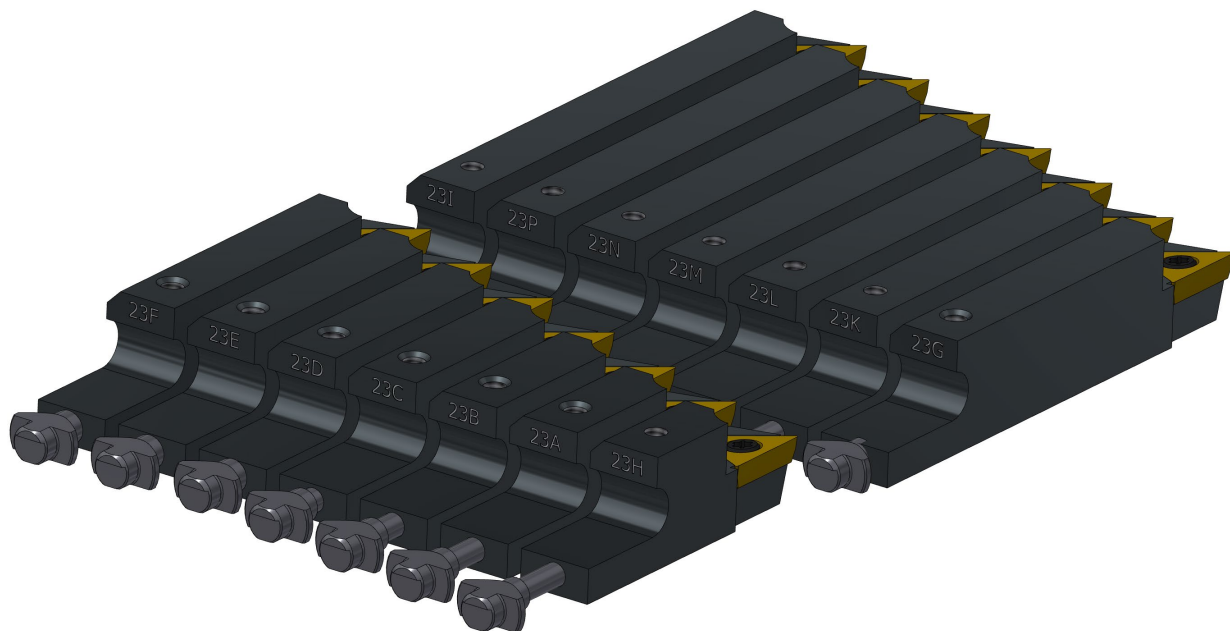
ITEM	PART #	DESCRIPTION
1	199-96	HOLDER, TOOL 1 1/4"
2	199-94	HOLDER, TOOL 2 1/4"
3	502-25-1	SCREW, SOCKET SET 5/16-18 X 5/16" LG
4	200-1-6D	SPRING, TOOL BIT 3/4"
5	200-1-6C	SPRING, TOOL BIT 1 7/16"

Tool Holder	Holder Length	Tool Bit Grooving	Tool Bit Chamfer	Degree or Width	Bore Range
199-96	1.25"		501-33B	15°	2.15-2.80"
			501-33C	20°	
			501-33D	30°	
		501-31-3		.037"	
		501-31-1		.048"	
199-89	1.50"		501-33B	15°	2.80-3.45"
			501-33C	20°	
			501-33D	30°	
		501-31-3		.037"	
		501-31-1		.048"	
199-90	1.75"		501-33B	15°	3.45-4.10"
			501-33C	20°	
			501-33D	30°	
		501-31-3		.037"	
		501-31-1		.048"	
199-94	2.25"		501-33B	15°	4.10-4.75"
			501-33C	20°	
			501-33D	30°	
		501-31-3		.037"	
		501-31-1		.048"	

511-29-17 Series Indexable Cartridges, Negative Rake, $\frac{3}{8}$ " IC Square


Tool Holder Assembly Number	Tool Holder Length	Bore Range
511-29-17J	1.95"	2.90-3.12"
511-29-17K	2.15"	3.12-3.52"
511-29-17L	2.35"	3.52-3.92"
511-29-17M	2.55"	3.92-4.32"
511-29-17N	2.75"	4.32-4.72"
511-29-17P	2.95"	4.72-5.12"
511-29-17Q	3.15"	5.12-5.52"
511-29-17R	3.98"	6.17-7.17"
Offset Tool Holders for 600-8-4L Production Cutterhead Only		
511-29-17U	2.33"	3.48-3.88"
511-29-17V	2.53"	3.88-4.28"

511-29-23 Series Indexable Cartridges, $\frac{3}{8}$ IC Triangle



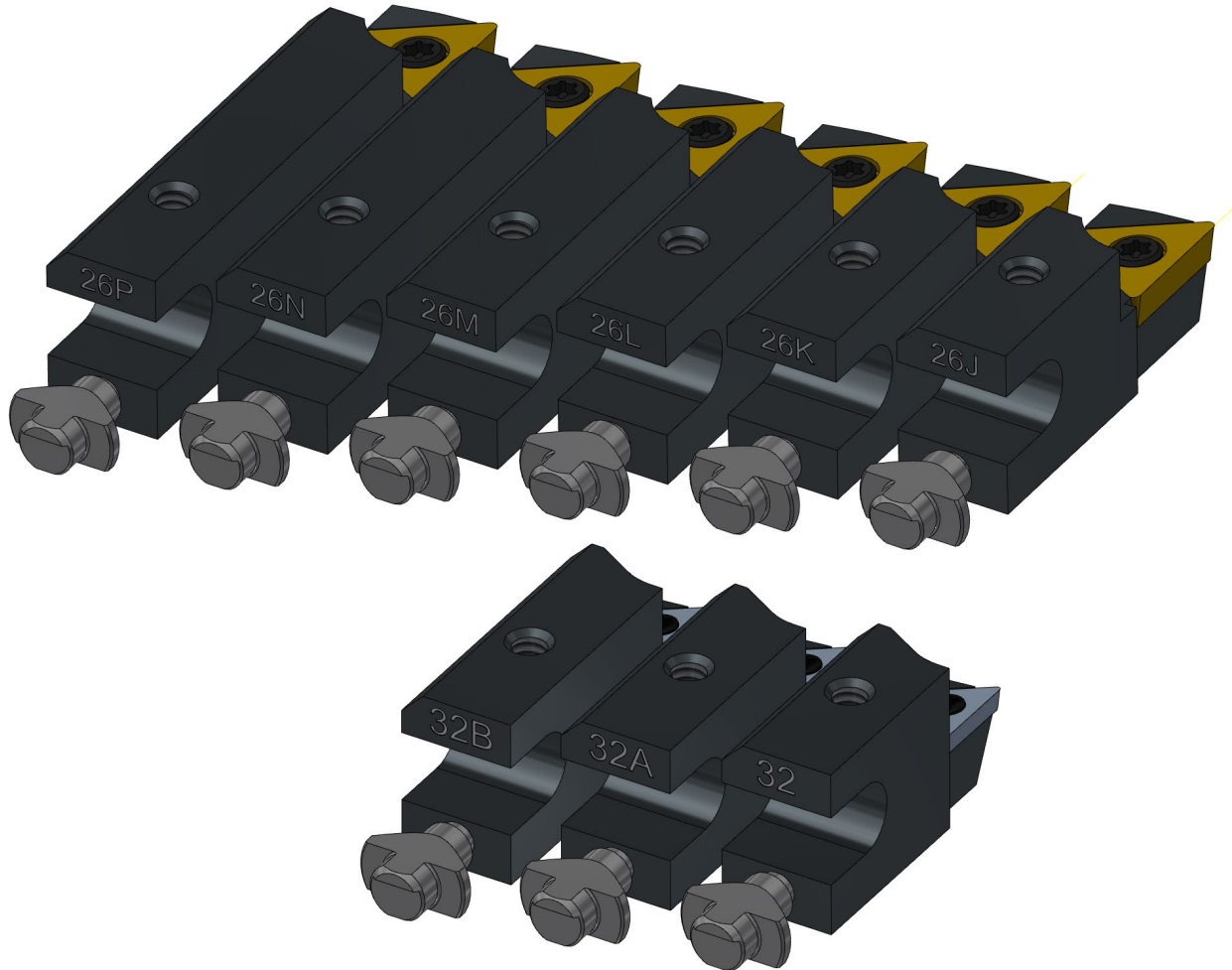
Tool Holder Assembly Number	Tool Holder Length	Bore Range
511-29-23H	2.13"	3.10-3.50"
511-29-23A	2.33"	3.50-3.88"
511-29-23B	2.53"	3.88-4.28"
511-29-23C	2.73"	4.28-4.68"
511-29-23D	2.93"	4.68-5.08"
511-29-23E	3.13"	5.08-5.48"
511-29-23F	3.33"	5.48-5.88"
511-29-23G	3.53"	5.88-6.28"
511-29-23K	3.75"	6.28-6.68"
511-29-23L	4.00"	6.68-7.08"
511-29-23M	4.19"	7.08-7.48"
511-29-23N	4.38"	7.48-7.88"
511-29-23P	4.56"	7.88-8.28"
511-29-23I	4.75"	8.28-8.68"

511-29-24 Series Indexable Cartridges, Negative Rake, $\frac{3}{8}$ " IC Square



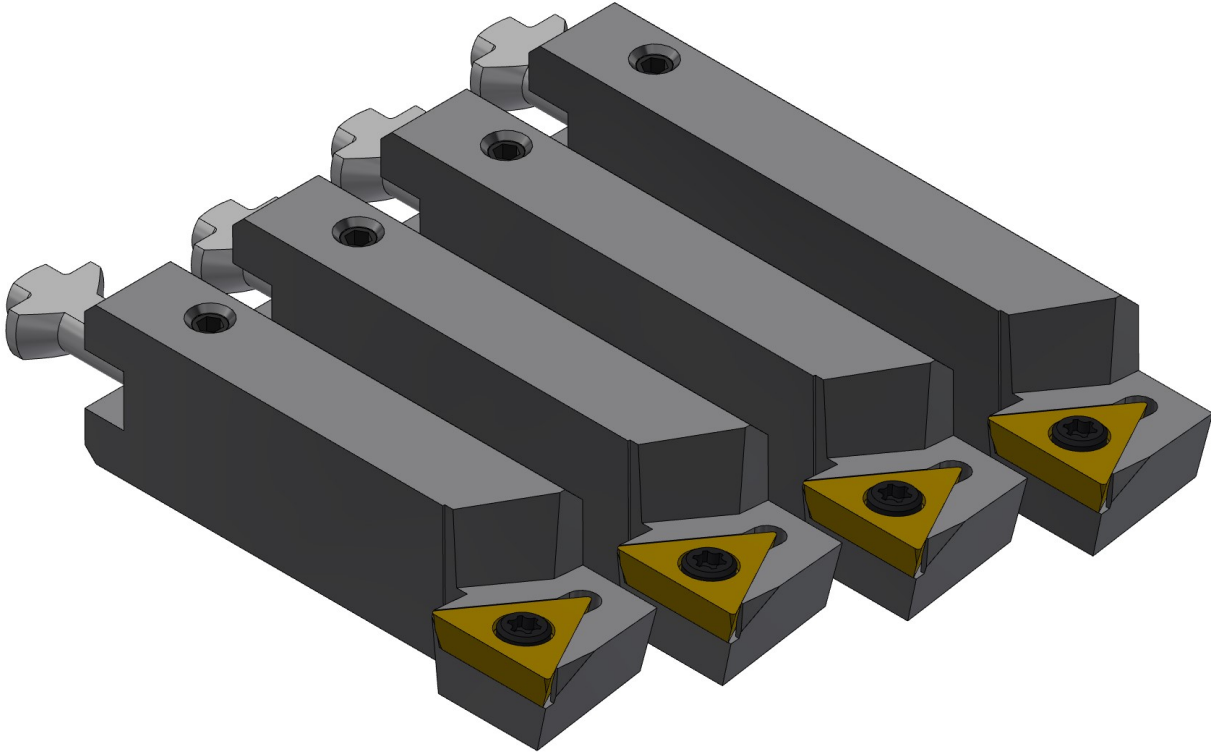
Tool Holder Assembly Number	Tool Holder Length	Bore Range
511-29-24G	1.31"	2.19-2.44"
511-29-24H	1.43"	2.44-2.69"
511-29-24J	1.56"	2.69-2.94"
511-29-24K	1.68"	2.94-3.34"
511-29-24L	1.88"	3.34-3.74"
511-29-24M	2.08"	3.74-4.14"
511-29-24N	2.26"	4.14-4.54"
511-29-24P	2.46"	4.54-5.00"

**511-29-32 Series Indexable Cartridges, Positive Rake, 1/4" IC Triangle and
511-29-26 Series Indexable Cartridges, Positive Rake, 3/8" IC Triangle**




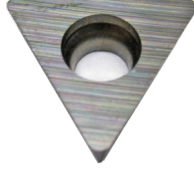


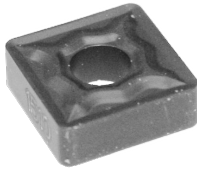
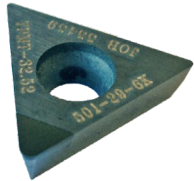




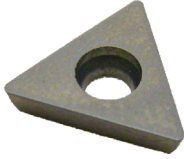
Tool Holder Assembly Number	Bore Range
511-29-32	2.11-2.44"
511-29-32A	2.36-2.69"
511-29-32B	2.62-2.94"
511-2-26J	2.74-3.30"
511-2-26K	3.14-3.70"
511-2-26L	3.54-4.10"
511-2-26M	3.94-4.50"
511-2-26N	4.34-4.90"
511-2-26P	4.74-5.30"




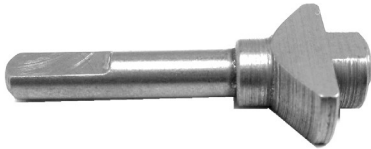
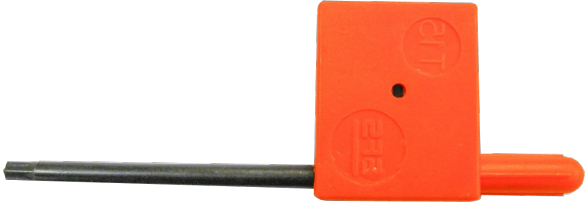



6801 Series Offset Indexable Cartridge, Positive Rake Insert Holders









Tool Holder Assembly Number	Tool Holder Length
6801A	1.23" (31.242mm)
6801B	1.44" (36.576mm)
6801C	1.65" (41.91mm)
6801D	1.85" (46.99mm)
6801E	2.05" (52.07mm)
6801F	2.25" (57.15mm)
6801G	2.55" (64.77mm)
6801H	2.75" (69.85mm)
6801J	2.95" (74.93mm)
6801K	3.15" (80.01mm)
6801L	3.35" (85.09mm)

Inserts and Hardware for Tool Cartridges/holders

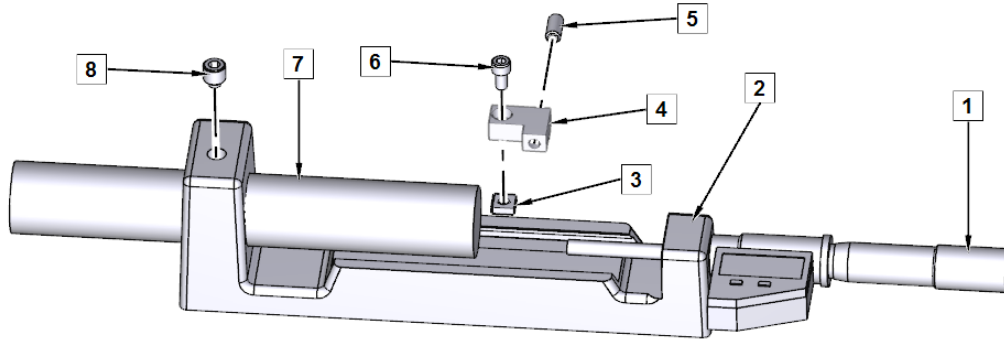
<p>RT321F 1/64" (397mm) radius, 3/8" (9525mm) IC Precision counterboring</p> 	<p>RT322F, 1/32" (787mm) radius, 3/8" (9525mm) IC Precision counterboring</p> 	<p>RT321, 1/64" (397mm) radius, 3/8" (9525mm) IC general purpose and sleeving</p> 
<p>RT322 1/32" (787mm) radius, 3/8" (9525mm) IC General purpose and sleeving</p> 	<p>RS322 1/32" (787mm) radius, 3/8" (9525mm) IC Black ceramic coated for high speed oversize thru boring</p> 	<p>501-29-6K 1/32 radius, diamond tipped carbide, 3/8" (9525mm) IC Aluminum boring</p> 
<p>511-29-20E 1/32" (787mm) radius, positive rake, 3/8" (9525mm) IC For cutting steel & ductile iron</p> 	<p>RT212 1/32" (787mm) radius, 1/4" (635mm) IC General purpose and sleeving</p> 	<p>RT212F 1/32" (787mm) radius, 1/4" (635mm) IC Precision counterboring</p> 
<p>RT211 1/64" (397mm) radius, 1/4" (635mm) IC General purpose and sleeving</p> 	<p>RT211F 1/64" (397mm) radius, 1/4" (635mm) IC Precision counterboring</p> 	

<p>511-29-17 Adjusting pin (511-29-17 series & 511-29-23 series)</p> 	<p>100-82-3 Adjusting pin (511-29-5 series)</p> 	<p>511-29-17W Adjusting pin (511-29-24K - M)</p> 
<p>511-29-17X Adjusting pin (511-29-24G - J)</p> 		
<p>511-29-12D Torx wrench for 3/8" (9.525mm) triangular insert cartridge tool holders</p> 		
<p>100-82-2A Set screw brass tipped for indexable insert tool holder assemblies. (10-24NC x 3/8) (511-29-17, 511-29-23, 511-29-24 series)</p> 	<p>511-29-12C M4 x 7 x 10mm, torx screw (to hold triangular inserts)</p> 	<p>511-29-12 6/32 x 7/16" (4775 x 11125mm) long SHCS (to hold square inserts)</p> 

<p>100-82-2 Set screw brass tipped for square cartridge/tool holder assemblies. (10-24NC x 3/16) (51129-5 series)"</p> 	<p>511-29-12B Washer precision, insert holding square cartridge tool holder assembly</p> 	<p>100-82-1 Adjusting pin spring, short (for 511-29-5J)</p> 
<p>100-82-4 Adjusting pin spring, long (for 511-29-5A-S)</p> 	<p>100-82-5 Adjusting pin spring, short (for 511-29-17J & K and 511-29-23H)</p> 	<p>100-82-5A Adjusting pin spring, long (for 511-29-17L -R & 511-29-23A - G)</p> 

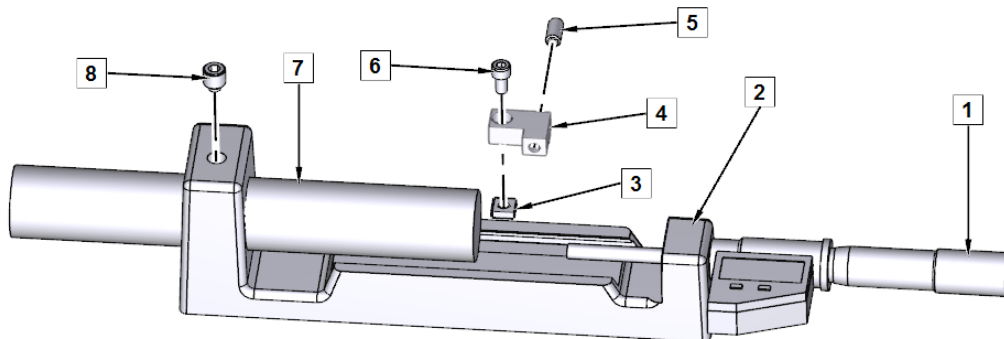
Micrometers:

900-2-19 Tool Setting Micrometer, 1/2" Tooling



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	501-34-2R	HEAD, MICROMETER, UNIVERSAL MIC HEAD DIGITAL READING INCH/METRIC
2	1	502-30-10B	FRAME, MICROMETER
3	1	502-30-10J	SQUARE NUT - #10-24 MICROMETER FRAME
4	1	502-30-10M	CLAMP, MICROMETER
5	1	502-30-10K	BALL PLUNGER, 1/4-20 MICROMETER FRAME
6	1	MF-9A	SOCKET HEAD CAPSCREW #10-32 X 3/8"
7	1	502-30-10A	ANVIL, MICROMETER 7/8" DIA X 5 5/8" LG
8	1	502-30-10L	SET SCREW, BRASS TIPPED 3/8-24 X 3/8"

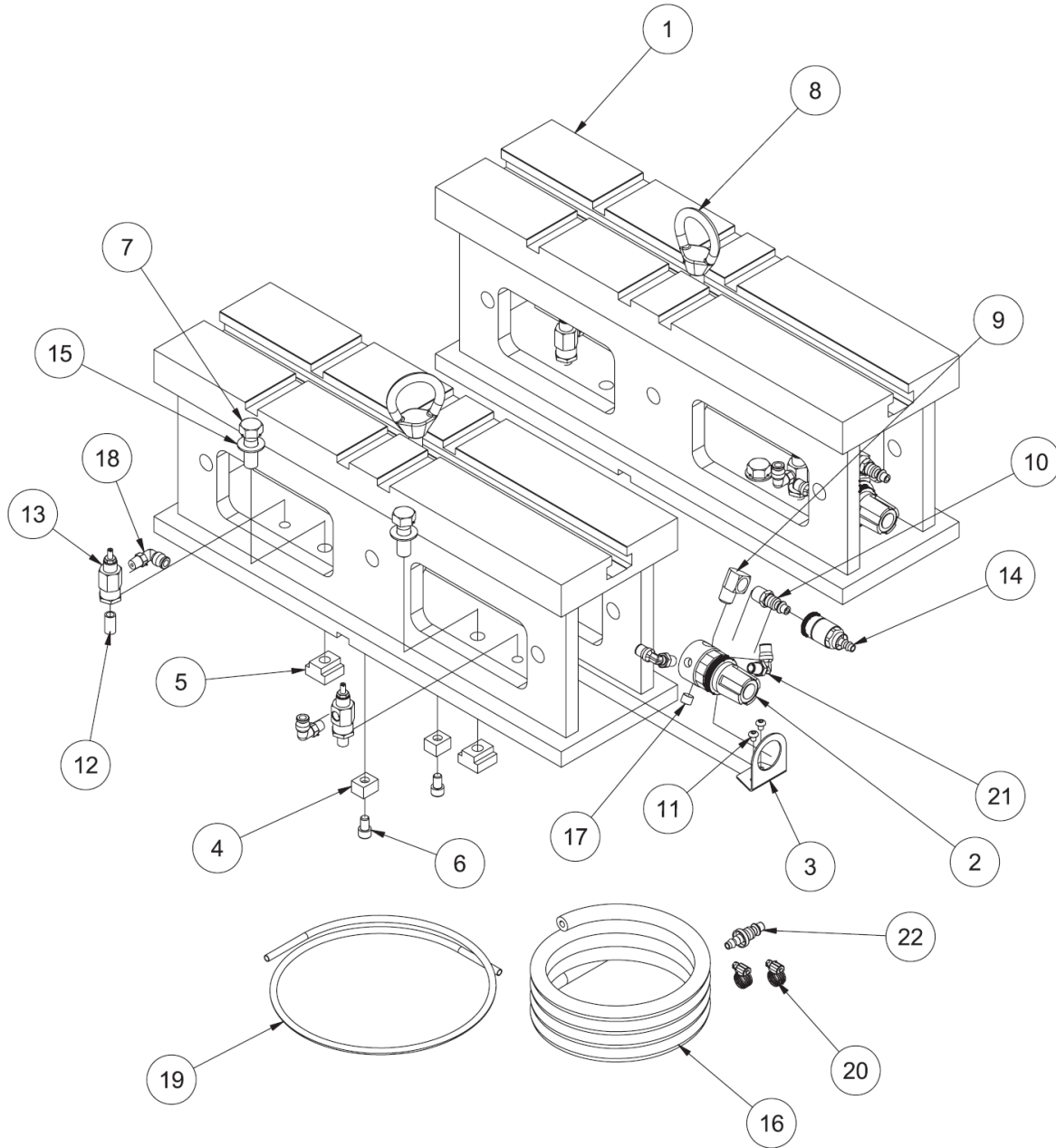
900-2-20 Tool Setting Micrometer, 3/4" Tooling



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	501-34-2R	HEAD, MICROMETER, UNIVERSAL MIC HEAD DIGITAL READING INCH/METRIC
2	1	502-30-10C	FRAME, MICROMETER
3	1	502-30-10J	SQUARE NUT - #10-24 MICROMETER FRAME
4	1	502-30-10M	CLAMP, MICROMETER
5	1	502-30-10K	BALL PLUNGER, 1/4-20 MICROMETER FRAME
6	1	MF-9A	SOCKET HEAD CAPSCREW #10-32 X 3/8"
7	1	502-30-10A	ANVIL, MICROMETER 7/8" DIA X 5 5/8" LG
8	1	502-30-10L	SET SCREW, BRASS TIPPED 3/8-24 X 3/8"

**Fixturing
Parallels**

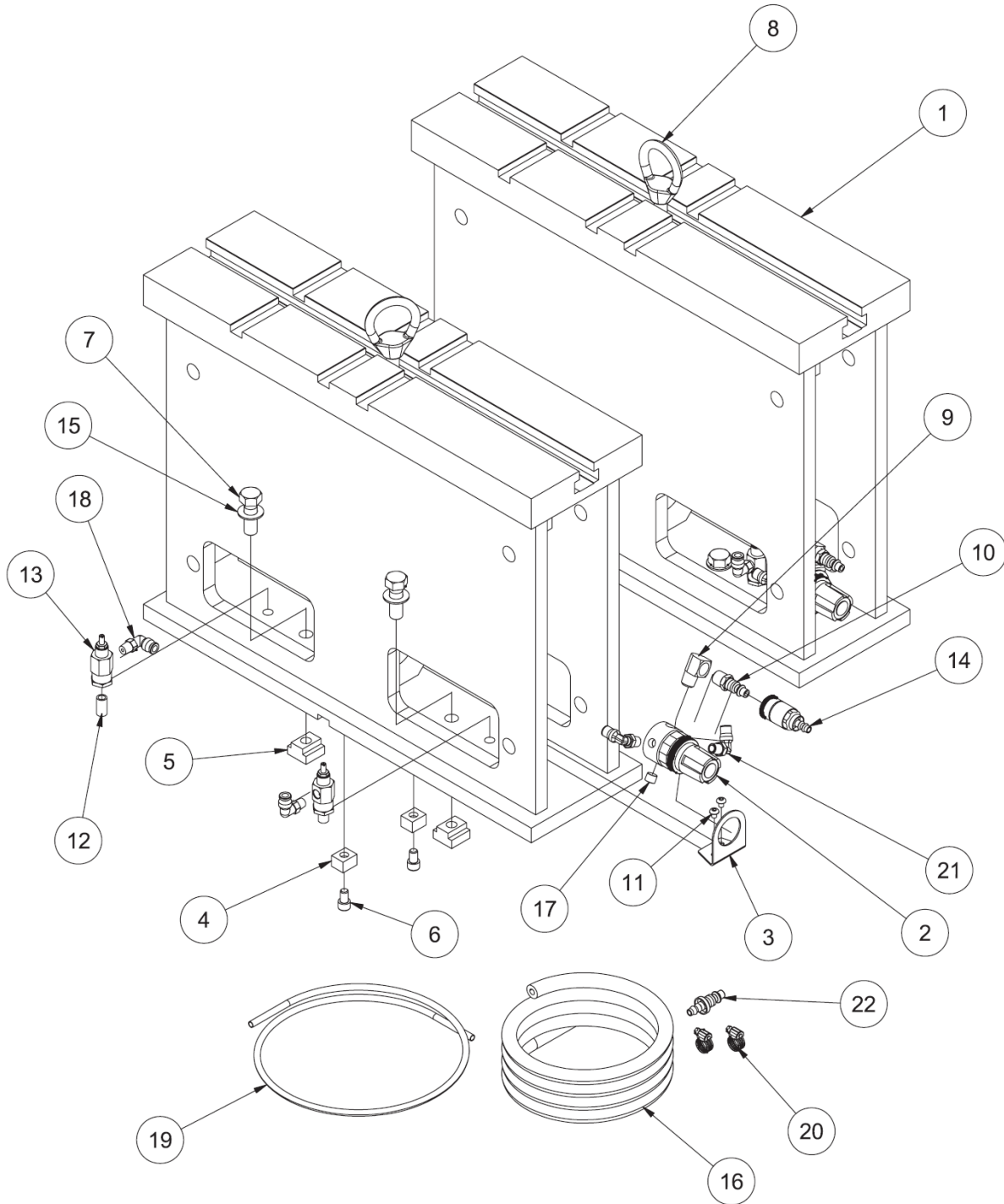
11112 Universal 8" (203mm) Heavy Duty T-Slot Parallels Parts



11112
8" SUPPORT PARALLEL ASSEMBLY
F70

11112 PARALLEL, 8", ASSEMBLY			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	11112A	SUPPORT PARALLEL 8" (MACHINING)
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	SOCKET HEAD CAPSCREW 5/16-18 X 1/2"
7	4	MF-137A	HEX HEAD CAPSCREW 1/2-13 X 1 1/2"
8	2	502-3-13	LIFT EYE
9	2	502-11-17S	STREET ELL, 1/4"
10	2	502-1116X	CONNECTOR, MALE, 1/4 NPT
11	4	MF-87	SOCKET BUTTON HEAD SCREW #10-24 X 1/4"
12	4	502-11-17J	NIPPLE, CLOSE, 1/8" NPT
13	4	502-11-35A	FLOW CONTROL
14	1	502-11-16W	QUICK CONNECT AIR FITTING, FEMALE
15	4	MF-180	FLAT WASHER 1/2"
16	15 FT	502-1-98	AIR HOSE, 1/4"
17	2	MF-234	HEX SOCKET PLUG 1/8" NPT
18	4	514-4-17E	ELBOW, 90 DEG MALE, 1/4" POLY X 1/8" NPT
19	4 FT	502-11-15	TUBING, BLACK POLYFLO, 1/4"
20	2	502-1-97	CLAMP, 1/4" HOSE
21	4	514-4-17V	FITTING, 90 DEG, 1/8 NPT X 1/4 POLY
22	1	502-11-16Y	CONNECTOR, MALE, AIR 1/4 NPT

11114 Universal 16" (406mm) Heavy Duty T-Slot Parallels

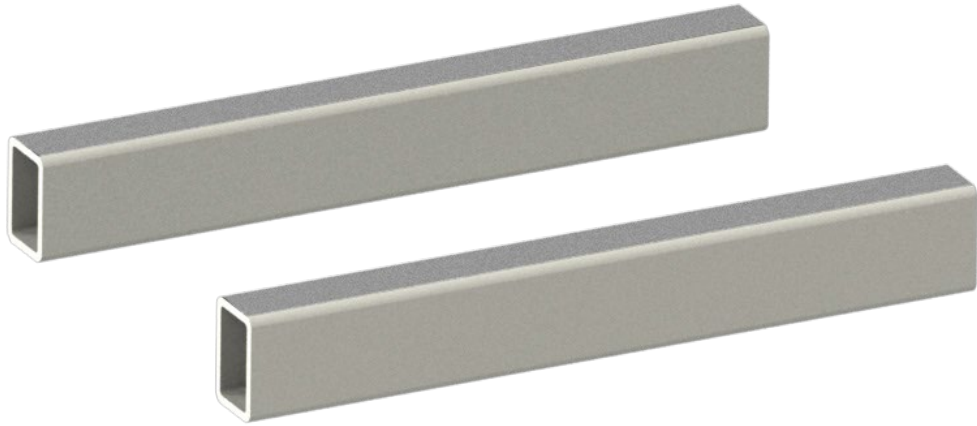
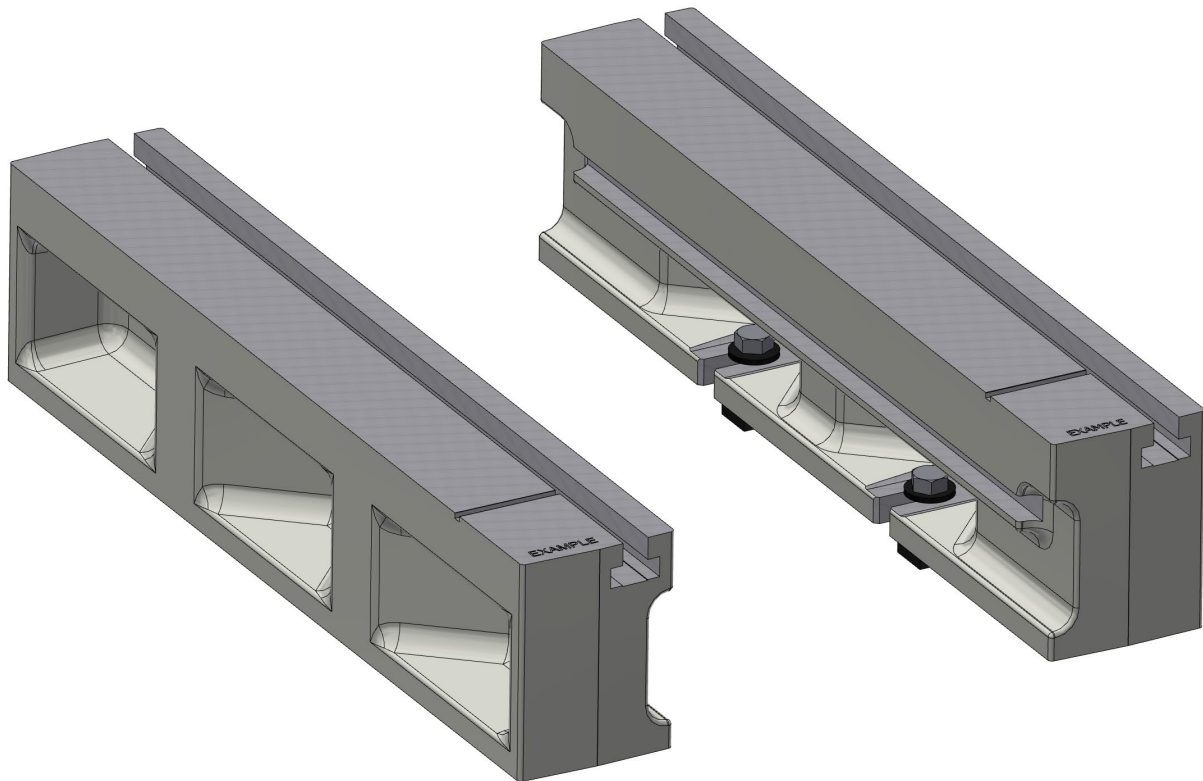


11114
16" SUPPORT PARALLEL ASSEMBLY
F70

11114 PARALLEL, 16", ASSEMBLY			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	11114A	SUPPORT PARALLEL 16" (MACHINING)
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	SOCKET HEAD CAPSCREW 5/16-18 X 1/2"
7	4	MF-137A	HEX HEAD CAPSCREW 1/2-13 X 1 1/2"
8	2	502-3-13	LIFT EYE
9	2	502-11-17S	STREET ELL, 1/4"
10	2	502-1116X	CONNECTOR, MALE, 1/4 NPT
11	4	MF-87	SOCKET BUTTON HEAD SCREW #10-24 X 1/4"
12	4	502-11-17J	NIPPLE, CLOSE, 1/8" NPT
13	4	502-11-35A	FLOW CONTROL
14	1	502-11-16W	QUICK CONNECT AIR FITTING, FEMALE
15	4	MF-180	FLAT WASHER 1/2"
16	15 FT	502-1-98	AIR HOSE, 1/4"
17	2	MF-234	HEX SOCKET PLUG 1/8" NPT
18	4	514-4-17E	ELBOW, 90 DEG MALE, 1/4" POLY X 1/8" NPT
19	4 FT	502-11-15	TUBING, BLACK POLYFLO, 1/4"
20	2	502-1-97	CLAMP, 1/4" HOSE
21	4	514-4-17V	FITTING, 90 DEG, 1/8" NPT X 1/4" POLY
22	1	502-11-16Y	CONNECTOR, MALE, AIR 1/4 NPT

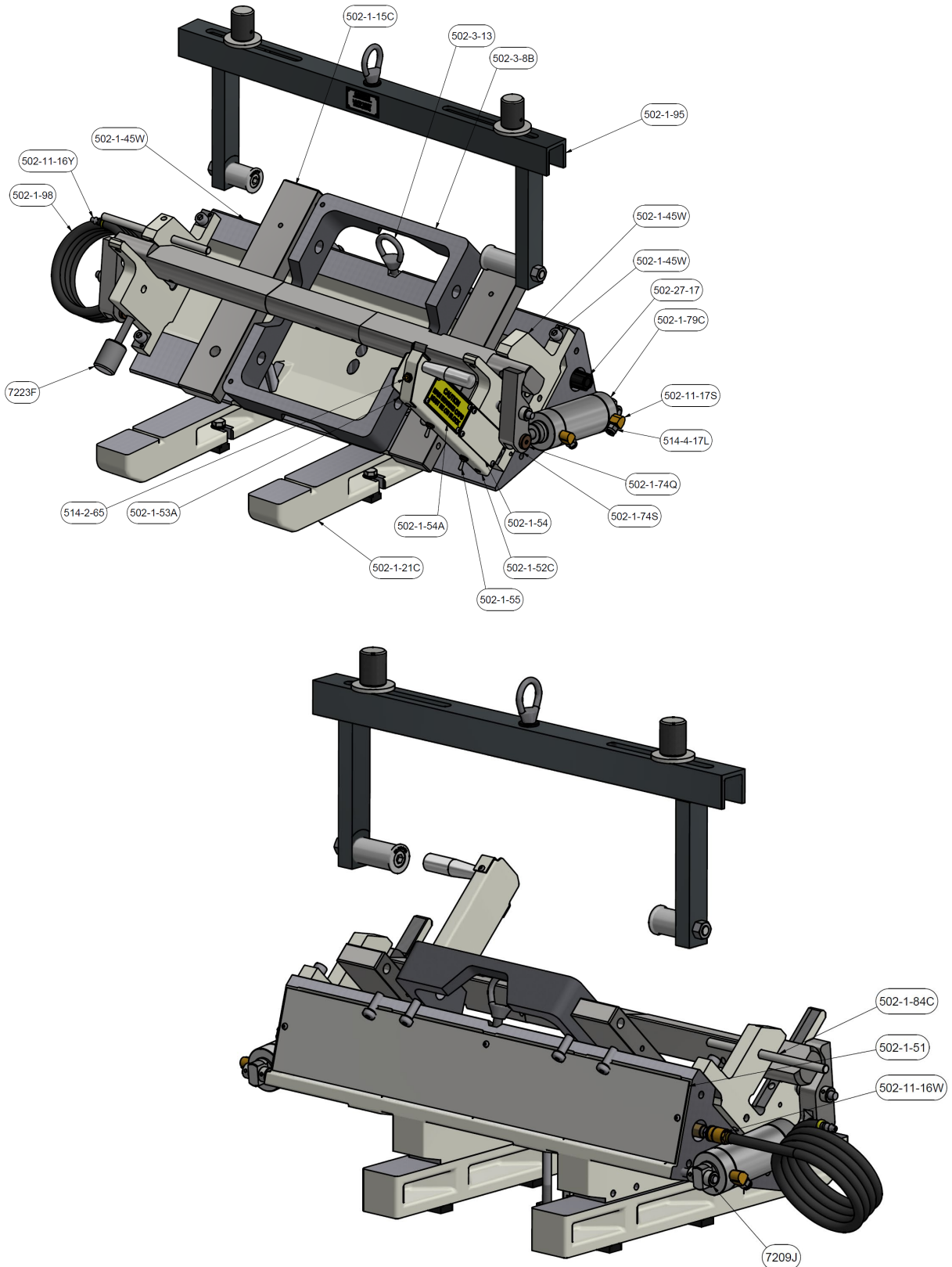
11115 2" (50mm) X 3" (75mm) Parallels

Sold as complete set.

**7219W Universal 5.2" (132mm) Parallels**

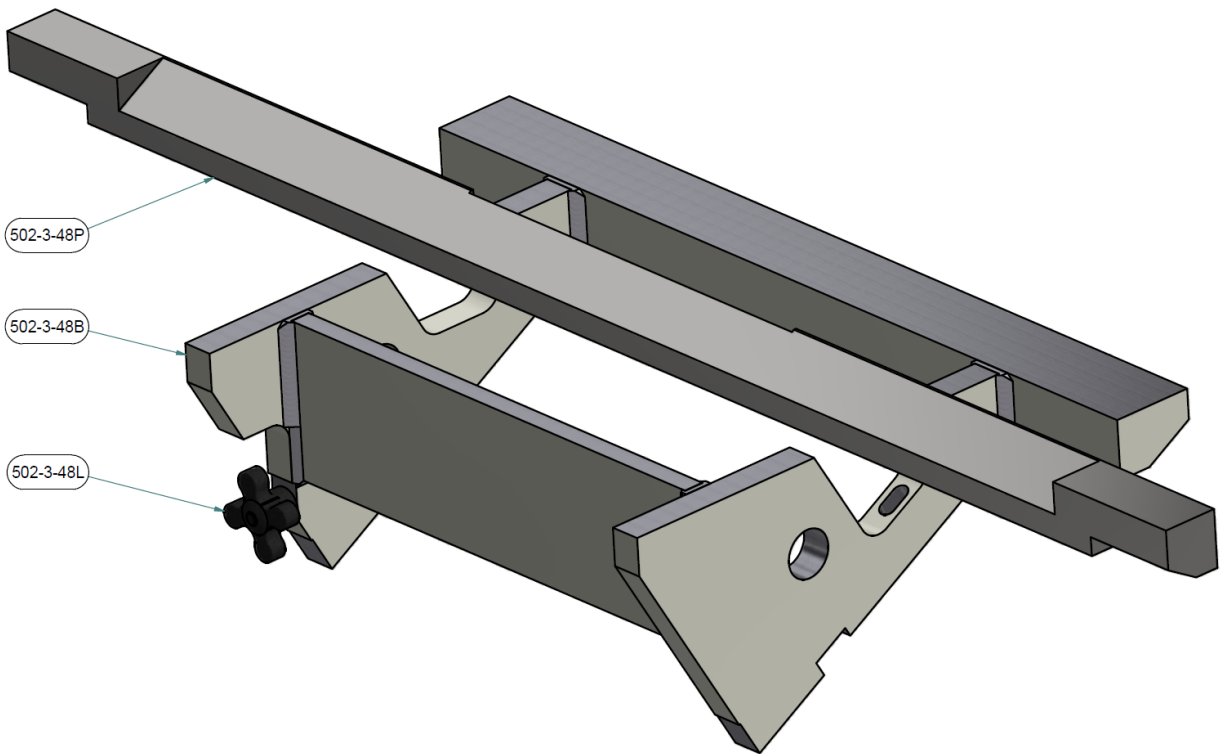
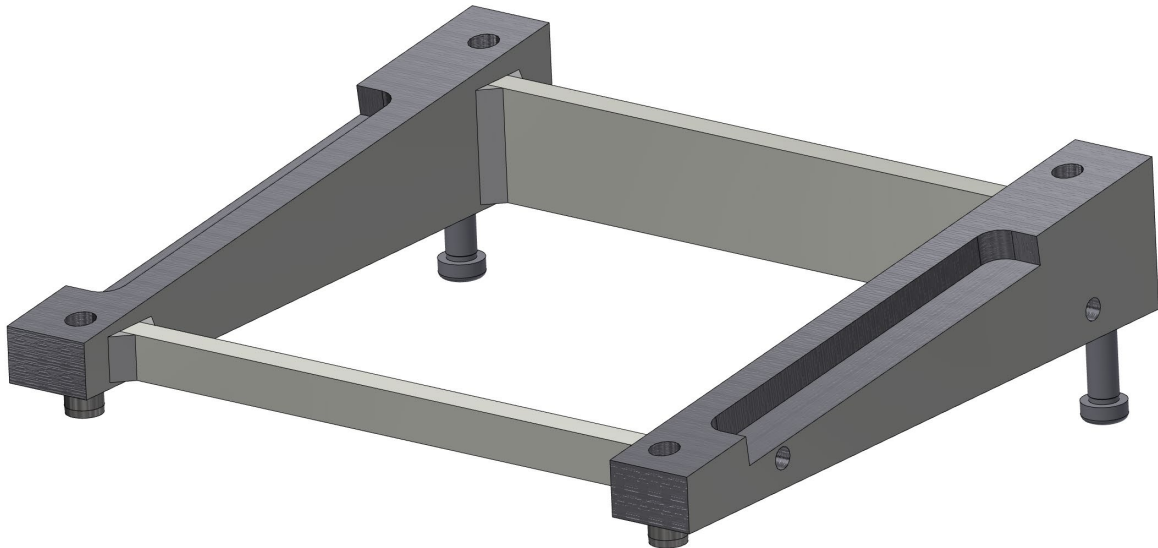
Block Locating Fixtures

502-1-72F V-Block Fixtures

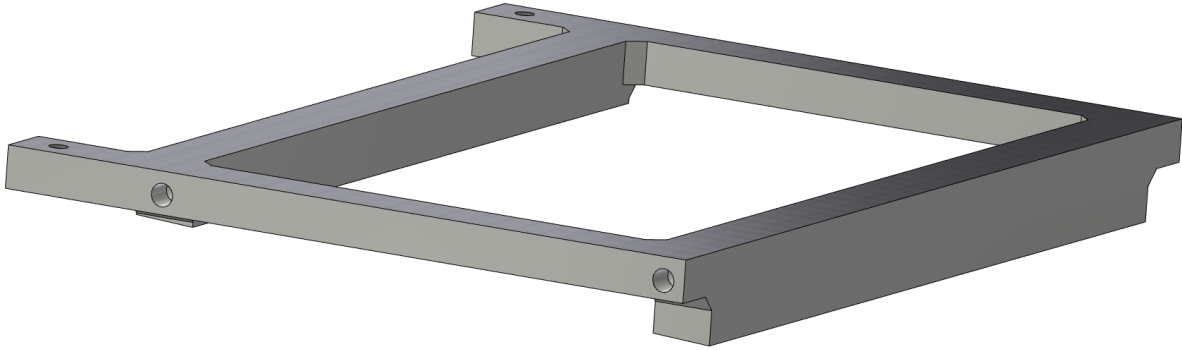


502-3-48Q In-Line Block Frame

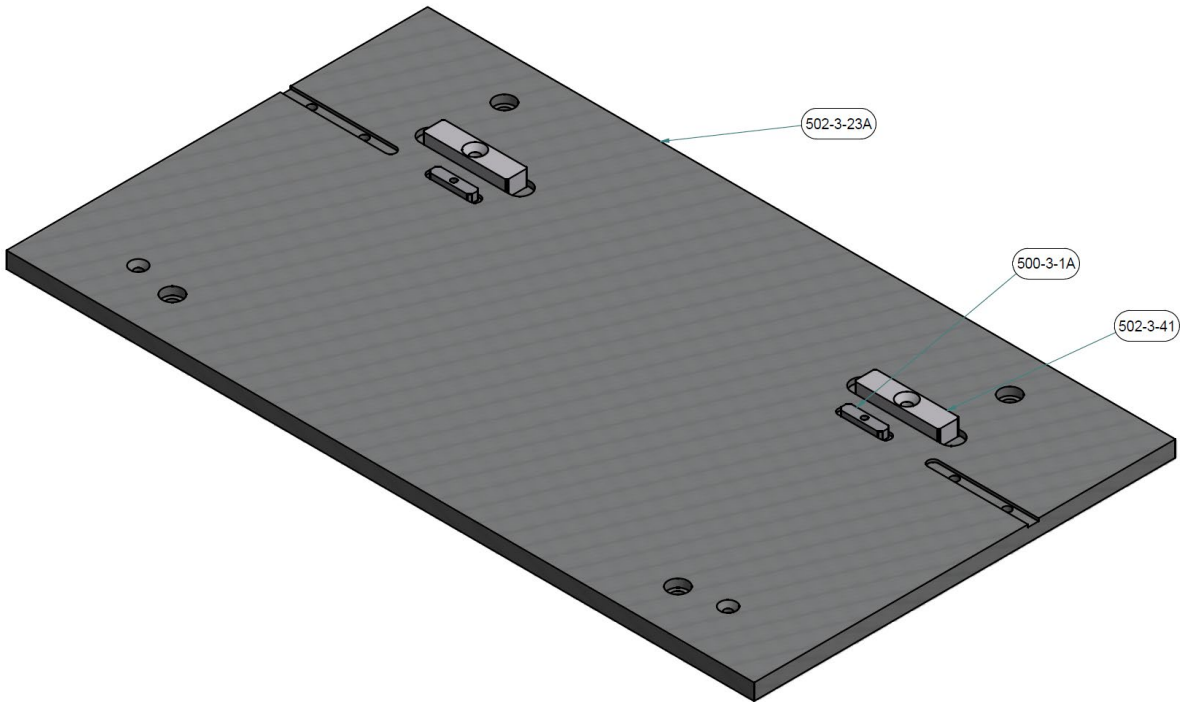
Mounts onto 502-1-72F V-Block Frame

**502-3-49 VW 15° / Ford, Mazda, Isuzu 75° V-Block Fixture**

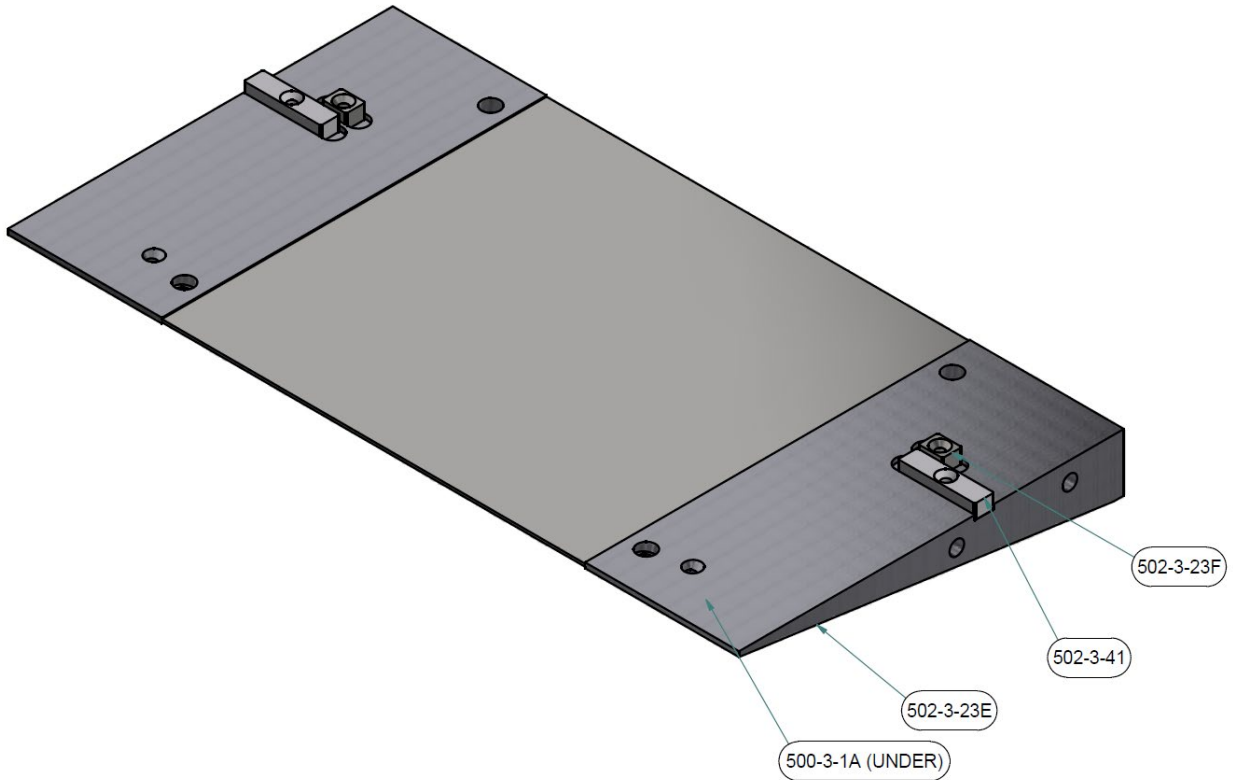
502-3-52 Cadillac Catera V6 Fixture



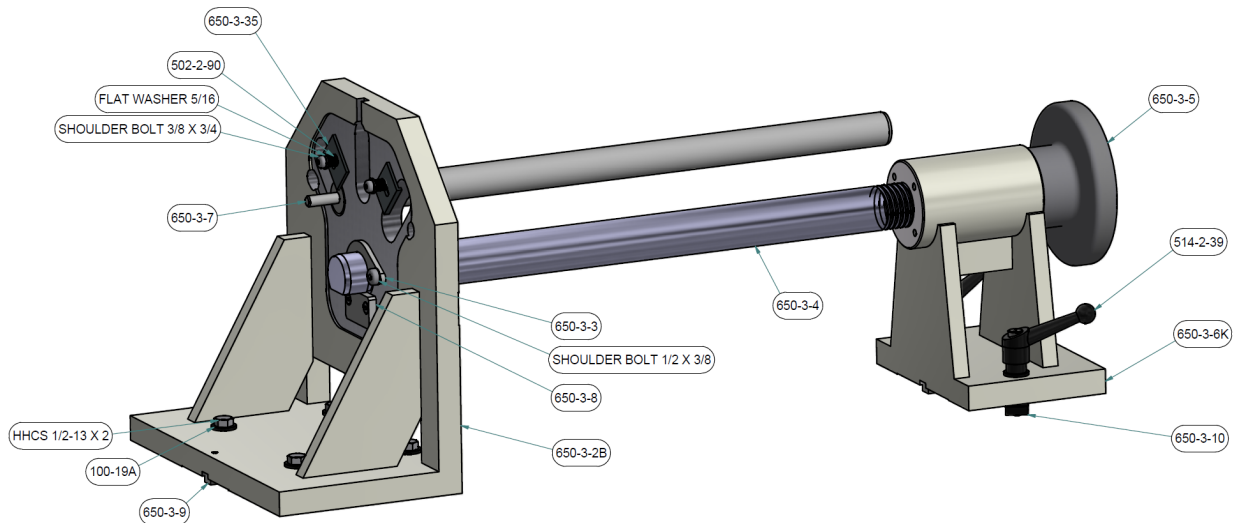
502-3-23 Marine Outboard Fixture



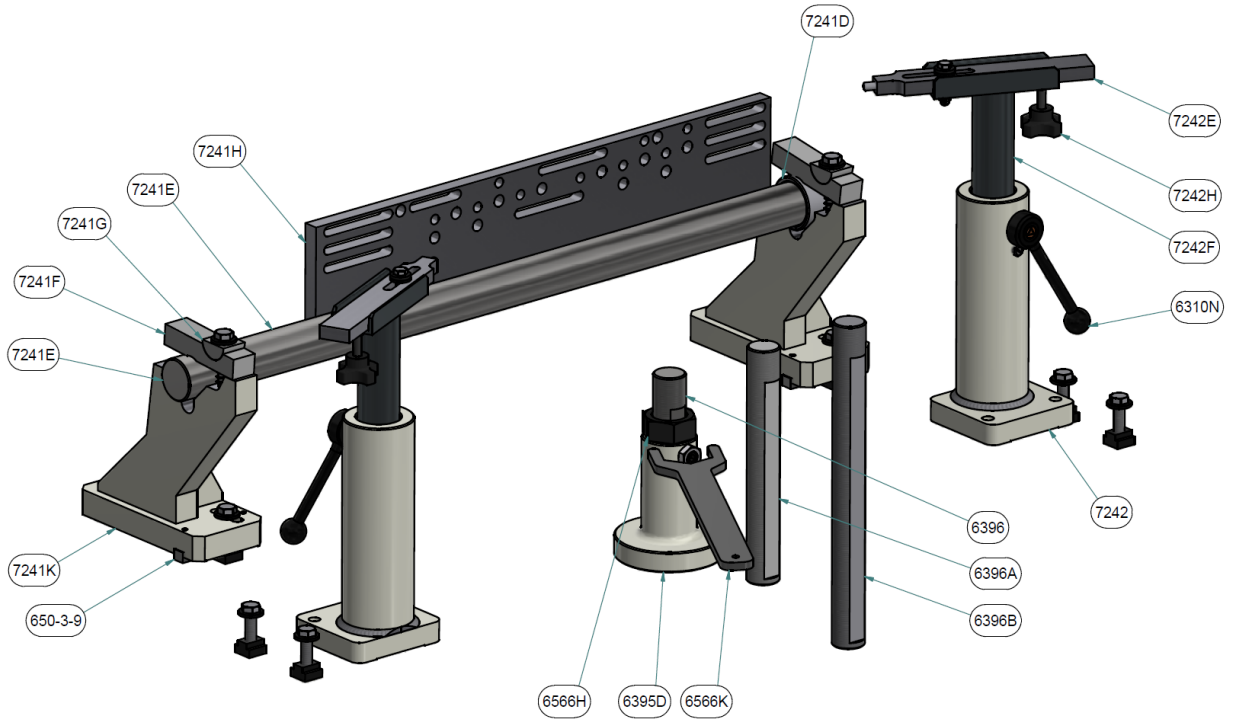
502-3-23C Marine Outboard Fixture



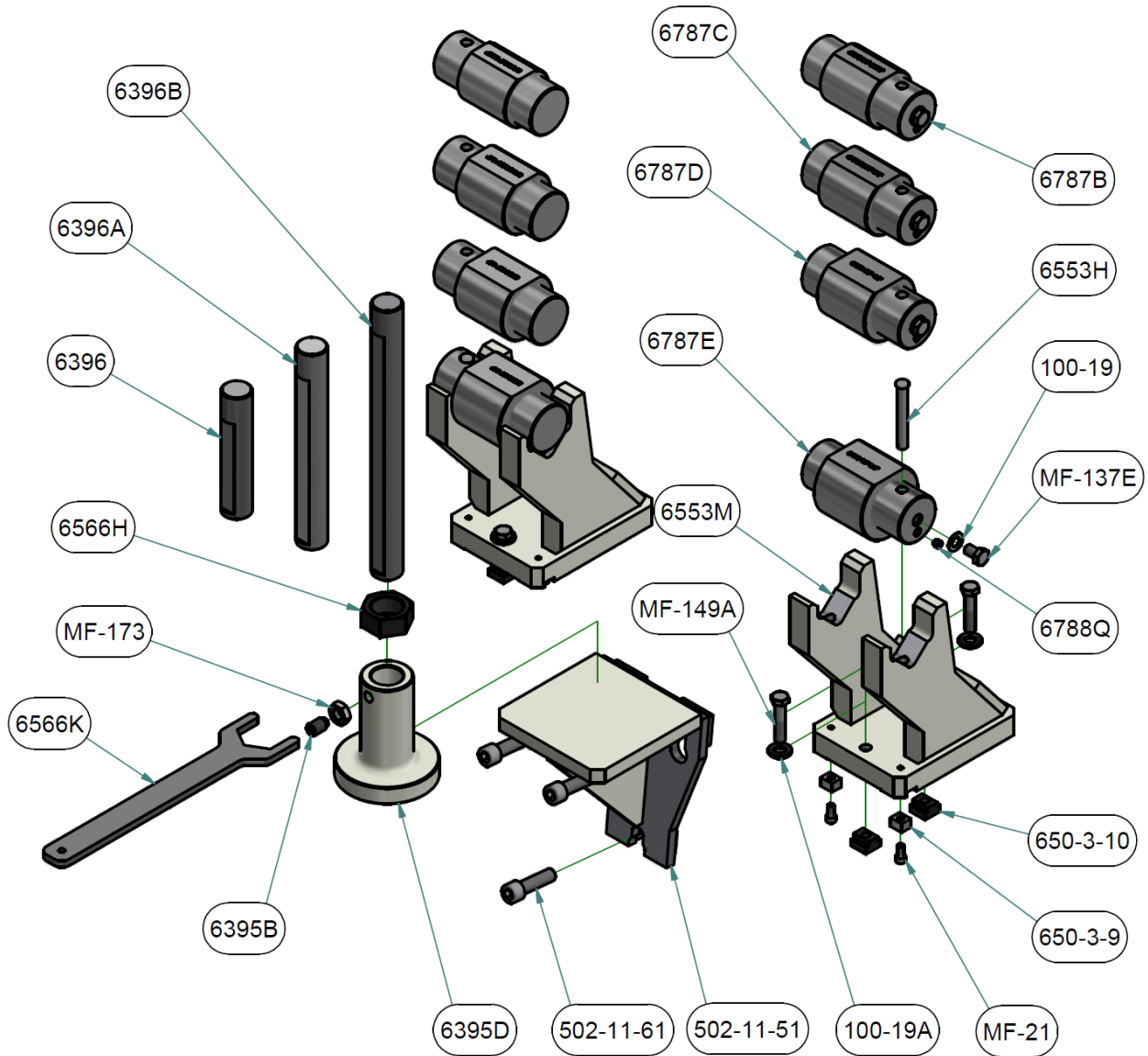
650-3-1 Performance Fixture



7241 Universal Economy Automotive Block Fixture

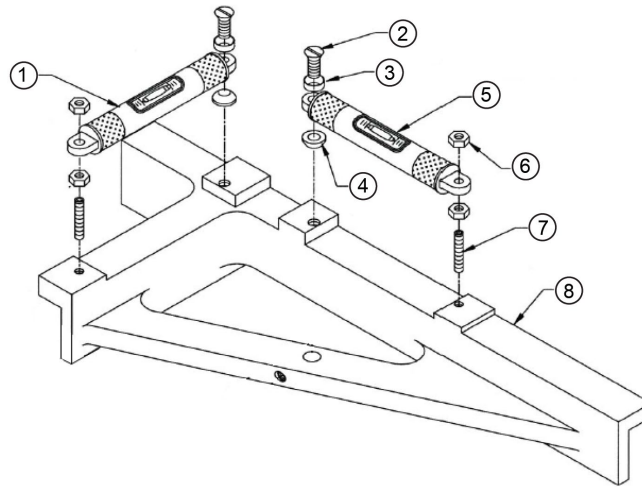


7243 Mid-size Diesel Block Fixture



Auxiliary Equipment



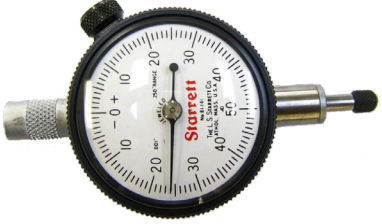

7152A Dual Axis Level



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	7152	VIAL ONLY, LEVEL SF
2	2	7153G	SCREW, FLAT HEAD, #12-24, SURFACING LEVEL
3	2	7153Z	WASHER, LEVEL MOUNTING (COUNTERSUNK HEAD)
4	2	7153V	WASHER, LEVEL MOUNTING (RADIUS HEAD)
5	1	7152C	COMPLETED VIAL, LONGITUDINAL SF LEVEL ASS'Y
6	4	7153H	NUT, #12-24, HEAD SURFACING LEVEL
7	2	7153J	SCREW, SOCKET SET #12-24 X 1" SURFACING LEVEL
8	1	7153S	BASE, HEAD SURFACE LEVEL

201 Mitutoyo Surface Tester



<p>502-9-9A Mechanical Run-out Indicator</p>  <p>A mechanical run-out indicator with a circular dial featuring a yellow-to-red color gradient. The dial has markings from 0 to 100. The instrument has a black metal body with a knurled adjustment knob on top and a probe arm extending to the right.</p>	<p>503-14-11A Depth Indicator (Inch)</p>  <p>A depth indicator with a circular dial ranging from 0 to 100 in increments of 10. The dial is white with black markings. The instrument has a black metal body and a long, thin stainless steel probe extending to the left.</p>
<p>7038Y Flatness Probe Dial Indicator for Level Assembly</p>  <p>A flatness probe dial indicator with a circular dial ranging from 0 to 40 in increments of 10. The dial is white with black markings. The instrument has a black metal body with a knurled adjustment knob on the left and a probe arm extending to the right.</p>	<p>503-14-12A Depth Indicator (Metric)</p>  <p>A depth indicator with a circular dial ranging from 0 to 100 in increments of 10. The dial is white with black markings. The instrument has a black metal body and a long, thin stainless steel probe extending to the left.</p>

502-12-4 General Purpose Magnetic Indicator Holder

