

ROTTLER

THE CUTTING EDGE

F107AH & F109AH

OPTIONAL

EQUIPMENT CATALOG



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

Optional Equipment 1

6761 Transformer..... 1

9203Q Hold Down Anchor Kit for F109 Machine Installation. 1

Conversational Touch Screen Software Packages 1

9040 Boring and Sleeving Software..... 1

9041 Surfacing Software..... 1

9042 Line Boring Software 1

9046 Lifter Bore Machining Software 1

9044 Connecting Rod Boring Software 1

CAM (Computer Aided Manufacturing) Software 1

9043 Rottler CAM Software Package 1

Training..... 2

RCAM-IH-INTRO..... 2

Automatic Tool Changing System 2

10360 Automatic Tool Changing System 2

Optional Equipment for Boring and Surfacing 3

Automatic Power Roll Over Block Fixture 3

9300 Computer Controlled Automatic 4Th Axis Block Roll Over Fixture 3

Fixturing for Extra Large In-Line and V Blocks 4

10100 Fixture.....4

10100A Fixture5

10100D Fixture6

Main Bearing Bore Locator Sets 7

10102A Main Line Locators 7

10102C Main Line Locators 7



10102E Main Line Locators 8

10102L Main Line Locators..... 8

10102N Main Line Locators 9

10102R Main Line Locators 9

10102G Main Line Locators 10

6309P Clamping System 11

10355 Set of Parallels with Air Float 11

Fixturing for Mid Range to Large In-Line and V Blocks..... 12

6405F Large V Block Fixture 12

Main Bearing Bore Locator Sets 12

6407A Locator Assembly 12

6407C Locator Assembly 13

6407E Locator Assembly 13

6407G Locator Assembly 14

6407J Locator Assembly 14

6407L Locator Assembly 15

6407N Locator Assembly 15

6407Q Locator Assembly 16

6407S Locator Assembly 16

6407U Locator Assembly 17

6407W Locator Assembly 17

7152A Dual Axis Level Assembly 18

6370Z Set Of Parallels with Air Float 18

6370C Set Of Parallels with Air Float..... 19

7219W Heavy Duty T-Slot Universal Parallels..... 19

6725 Mid-Range In-Line and V Block Fixture..... 20

6511 3/4" (19.05mm) Clamp Kit 21

Fixturing for Surfacing Cylinder Heads and Manifolds 22

7209M Leveling Table With Air Float..... 22

7209N 2-Piece Vise	22
Boring and Sleeving Tooling for HSK80A Spindle Taper.....	23
10118 Blind Hole Stub Cutterhead Package	23
10108B Blind Hole Stub Cutterhead Package.....	24
10117A Blind Hole Cutterhead	25
10116 Extended Spindle Blind Hole Cutterhead Package	26
10107B Blind Hole Cutterhead Package.....	27
10104B Blind Hole Cutterhead Package.....	28
10105B Blind Hole Cutterhead Package.....	29
6593S Cartridge Assembly	29
Surfacing Tooling for HSK80A Spindle Taper	30
10119 10" (250mm) Diameter Surfacing Cutterhead Assembly	30
10106C 14" (360mm) Diameter Surfacing Cutterhead Assembly	30
10115 18" (460mm) Diameter Surfacing Cutterhead Assembly	31
10106B 22" (560mm) Diameter Surfacing Cutterhead Assembly	31
6301J CBN Insert.....	31
6303V CBN Insert.....	31
Special Surfacing Tooling for Milling Metal Sprayed Head Gasket Decks.....	32
10109B Special 18" (420mm) Diameter Multi Tooth Milling Head.....	32
10120 Special 12" (300mm) Diameter Multi Tooth Milling Head.....	33
6864E Replacement Insert.....	33
6864D Replacement Cartridge.....	33
General Purpose Accessories.....	34
502-12-7B Digital Runout Probe and Readout.....	34
General Purpose Tooling	34
10121 Caterpillar 3400 Series Tappet Bore Repair Tooling Package.....	34
10122 Small Precision Adjustable Boring Head	35
10123 Large Heavy Duty Adjustable Boring/Facing Head	36

10124 Collet Kit.....	36
650-2-45G Solid Carbide End Mill	37
650-2-43F Four Fluted End Mill	37
Spindle Adapters for Mounting Universal Tooling	37
10113 1" (25.4mm) Spindle Adapter.....	37
10125 Blank Adapter	38
10126 #40 Taper Adapter.....	38
10127 R8 Taper Adaptor.....	38
10128 #5 Morse Taper Adapter	39
Main Line Bore Equipment	39
6898 Extra Heavy Duty 90 Degree Right Angle Drive.....	39
10114 Heavy Duty Offset 90 Degree Right Angle Drive	40
6779A Heavy Duty Line Bore Cutterhead Assembly	41
6519V Heavy Duty Line Bore Cutterhead Assembly	42
6519P Heavy Duty Line Bore Cutterhead Assembly	43
6519M Heavy Duty Line Bore Cutterhead Assembly	44
6519N Heavy Duty Line Bore Cutterhead Assembly.....	45
Line Bore Fixturing for Extra Large Blocks	46
10200 Adjustable Universal Line Boring Fixture	46
10200 Boring Fixture Adaptor Packages.....	46
10201 Adapter Package and Support Cradle for CAT 3600 V blocks	46
10202 Adapter Package and Support Cradle for Waukesha AT V Blocks	47
10203 Adapter Package and Support Cradle for Superior 2400 V Blocks	47
10204 Adapter Package for CAT 3600 In-Line Blocks.....	48
10205 Adapter Package and Support Cradle for GE EVO V Blocks	48
10206 Adapter Package and Support Cradle for EMD 645 & 710 V Blocks	49
10207 Adapter Package and Support Cradle for MTU 1163 V Blocks	49
10208 Adapter Package and Support Cradle for MTU 8000 V Blocks	50
Line Bore Fixturing for Large Blocks	50
6810 Waukesha 7042, 9390 and CAT 379, 398, 399 Line Boring Fixture	50
6815 White Superior 8G825 Line Boring Fixture - Requires Fixture 6821.....	51

6846 White Superior 12 & 16 G825 Line Boring Fixture - Requires Fixture 6821	51
Line Bore Fixturing for Large Blocks	52
6821 Adjustable Universal Line Boring Parallel Assembly	52
6823B 120 Degree V Block Supports for Large 120 Degree V Blocks.....	53
6823E 90 Degree V Block Supports for Large 90 Degree V Blocks	53
Line Bore Tooling for Small to Large Blocks and Heads.....	54
10133 Straight 90 Degree Right Angle Drive Assembly	54
650-2-39B Cutterhead Assembly Line Boring.....	55
650-2-39C Cutterhead Assembly Line Boring.....	56
650-2-39A Cutterhead Assembly Line Boring.....	57
Line Bore Fixturing for Small to Large Blocks and Heads	58
650-3-56 Line Bore Pivot Table Fixture.....	58
6821 Adjustable Universal Line Boring Fixture Assembly	58
6843 90 Degree V Block Supports	59
6823E 90 Degree V Block Supports	59
6789L 113 Degree V Block Supports	60
6789N 116 Degree V Block Supports	60
6789E 115 Degree V Block Supports	61
6823B 120 Degree V Block Supports.....	61
6789K 130 Degree V Block Supports.....	62
6789Q 140 Degree V Block Supports.....	62
Line Bore Set Up and Alignment Equipment	63
6889B Adapter	63
502-12-7B Digital Runout Probe and Readout.....	63
502-12-4 General Purpose Magnetic Indicator Holder	64
502-12-4A Magnetic Indicator Holder	64
502-9-9A Mechanical Run Out Indicator.....	64
502-9-9J Mechanical Run Out Indicator	64

Equipment for Preparing Blocks for Line Boring.....	65
7209N 2-Piece Vise	65
7209M Leveling Table With Air Float.....	65
10129 Shell Mill	66
10130 Shell Mill	66
10109C Shell Mill	67
6514T Insert.....	68
6514Y Insert	68
Equipment for Facing Thrust Bearing Surfaces for Main Line	68
6855C Thrust Facing Tooling Package.....	68
6855G Thrust facing tooling package.....	69
Special Tooling for Block End Machining	69
6779H Adaptor for 40 Taper Tooling	69
6779L 10" (250mm) Diameter Surfacing Cutterhead Assembly	70
6779M 14" (360mm) Diameter Surfacing Cutterhead Assembly	70
6779N Crossfeed Head Assembly.....	71
Connecting Rod Boring and Surfacing Equipment.....	72
650-3-44R Rottler Precision Connecting Rod Fixturing System.....	72
Fixturing & Tooling for Machining Large Engine & Compressor Connecting Rods.....	73
650-3-64 Rottler Precision Connecting Rod Fixturing System	73
650-3-66 Rottler Precision Compressor Conrod Cap Surfacing Fixture	74
6870 Rottler Precision Connecting Rod Boring Fixturing System	75
Tooling for Connecting Rod Boring.....	76
10118 Blind Hole Cutterhead Assembly	76
10131 Blind Hole Cutterhead Assembly.....	77
Tool Changing and Storage System for Heavy Tooling.....	78
6875A Tool Changing and Storage System.....	78

Optional Equipment

F100 machines require 205-250V, 60A, 50/60hZ, 3 phase power supply. If the voltage at place of installation is above or below this range, a transformer is required.

6761 Transformer

For Supply Voltage 380V, 415V, 440V. For supply voltage above or below this range, special transformer will be quoted.

Suggested Hold Down Anchor System

9203Q Hold Down Anchor Kit for F109 Machine Installation.

Conversational Touch Screen Software Packages

For Programmable Automated Engine Rebuilding Machine Work
Contact your Rottler representative or the factory concerning this option.

9040 Boring and Sleaving Software

Including: (1) Circular Interpolation Counterbore Finishing for Corner Radius Undercut and Facing Very Wide Counterbores (2) Lower Offset for Boring Larger Diameters Commonly Found When Resleeving Lower Seal Areas of Wet Liner

Contact your Rottler representative or the factory concerning this option.

9041 Surfacing Software

Including Multiple Pass Programmable Depth of Cuts Including Different Settings for Rough and Finish Milling/Surfacing
Contact your Rottler representative or the factory concerning this option.

9042 Line Boring Software

Including Circular Interpolation for Thrust Facing
Contact your Rottler representative or the factory concerning this option.

9046 Lifter Bore Machining Software

Contact your Rottler representative or the factory concerning this option.

9044 Connecting Rod Boring Software

Contact your Rottler representative or the factory concerning this option.

CAM (Computer Aided Manufacturing) Software

9043 Rottler CAM Software Package

When Rottler CAM #9043 is purchased together with a new machine, one day of introductory training is available for purchase on the CAM software. Additional training on Rottler CAM is provided through instructional videos at www.RottlerTube.com

Training

RCAM-IH-INTRO

Three days introductory training for one person on Rottler CAM software at Rottler factory in a group class setting. Customers must have purchased #9043 Rottler CAM Software package before attending this training course. Customer must supply own Windows laptop. Full details of costs and conditions is available from the Rottler Sales Department.

Automatic Tool Changing System

10360 Automatic Tool Changing System

For up to 20 HSK80A tools. Large diameter tools may occupy more than one tool pocket.



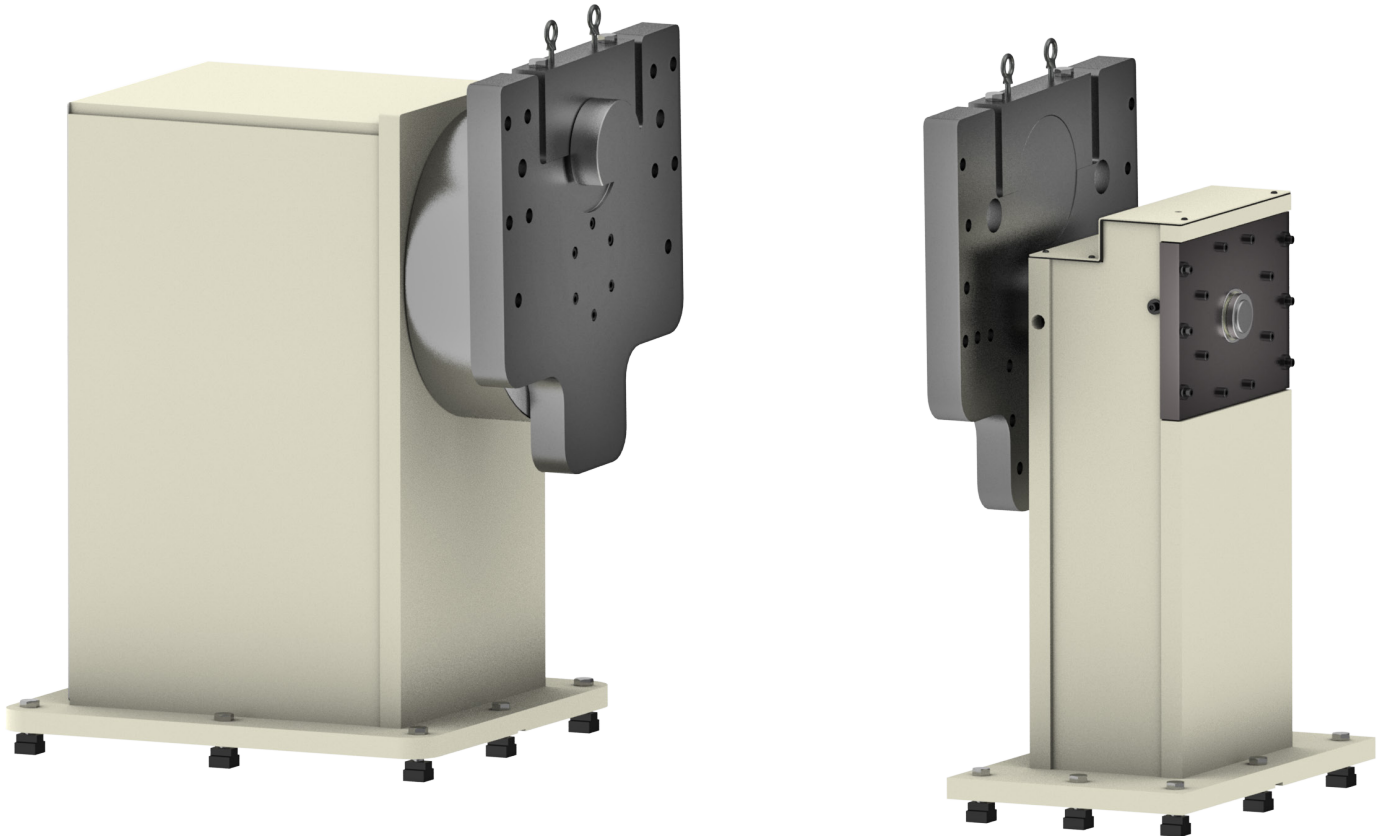
Optional Equipment for Boring and Surfacing

Automatic Power Roll Over Block Fixture

9300 Computer Controlled Automatic 4Th Axis Block Roll Over Fixture

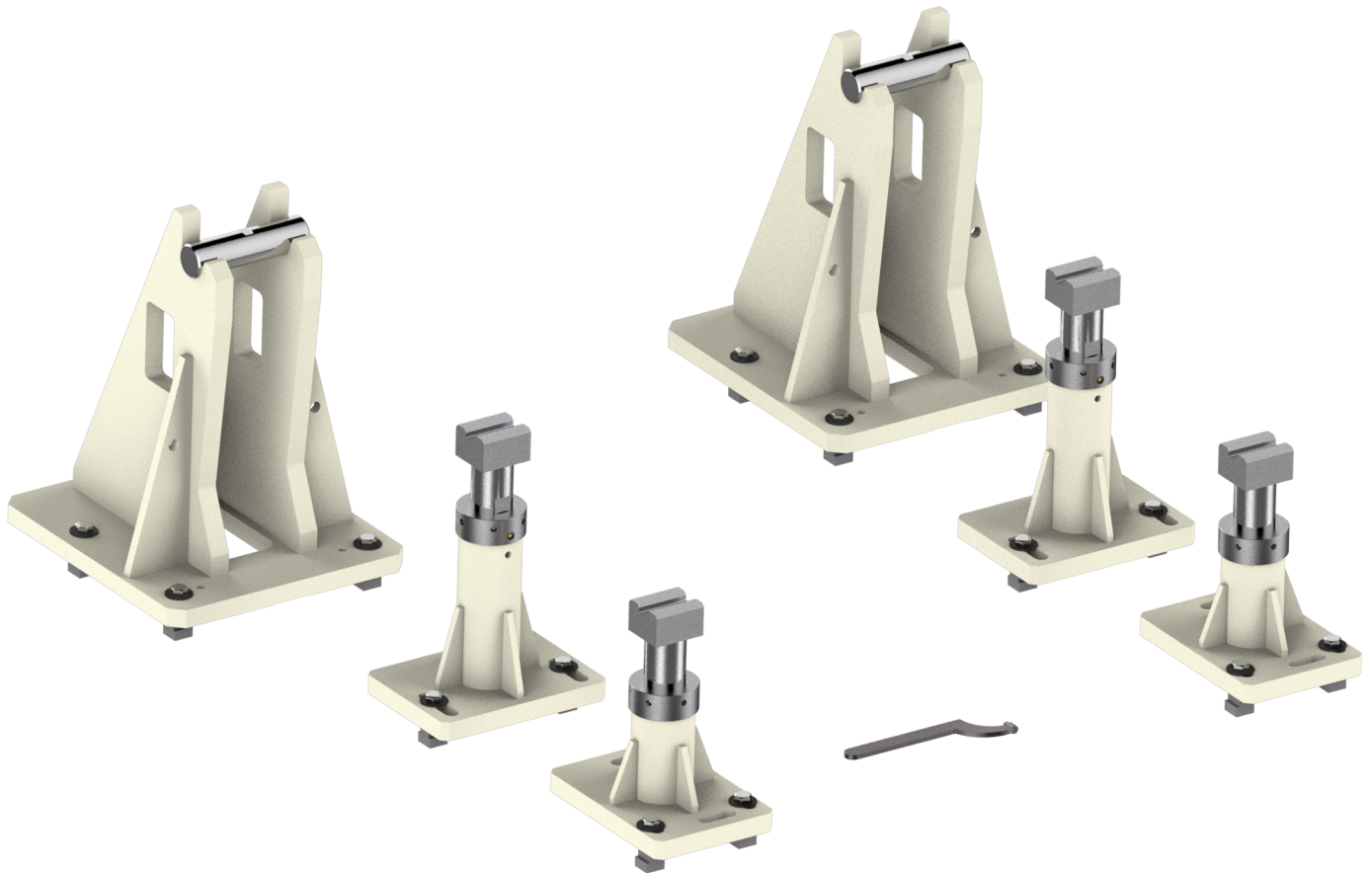
Engine blocks require mounting system to suit each block. Set up could be designed to use locating dowel pins or crankshaft main bore centerline. Price for mounting system for each block is quoted on application.

Note: Price includes factory install of 4th Axis Fixture when ordered together with new machine. Field retrofit will require additional service charges.



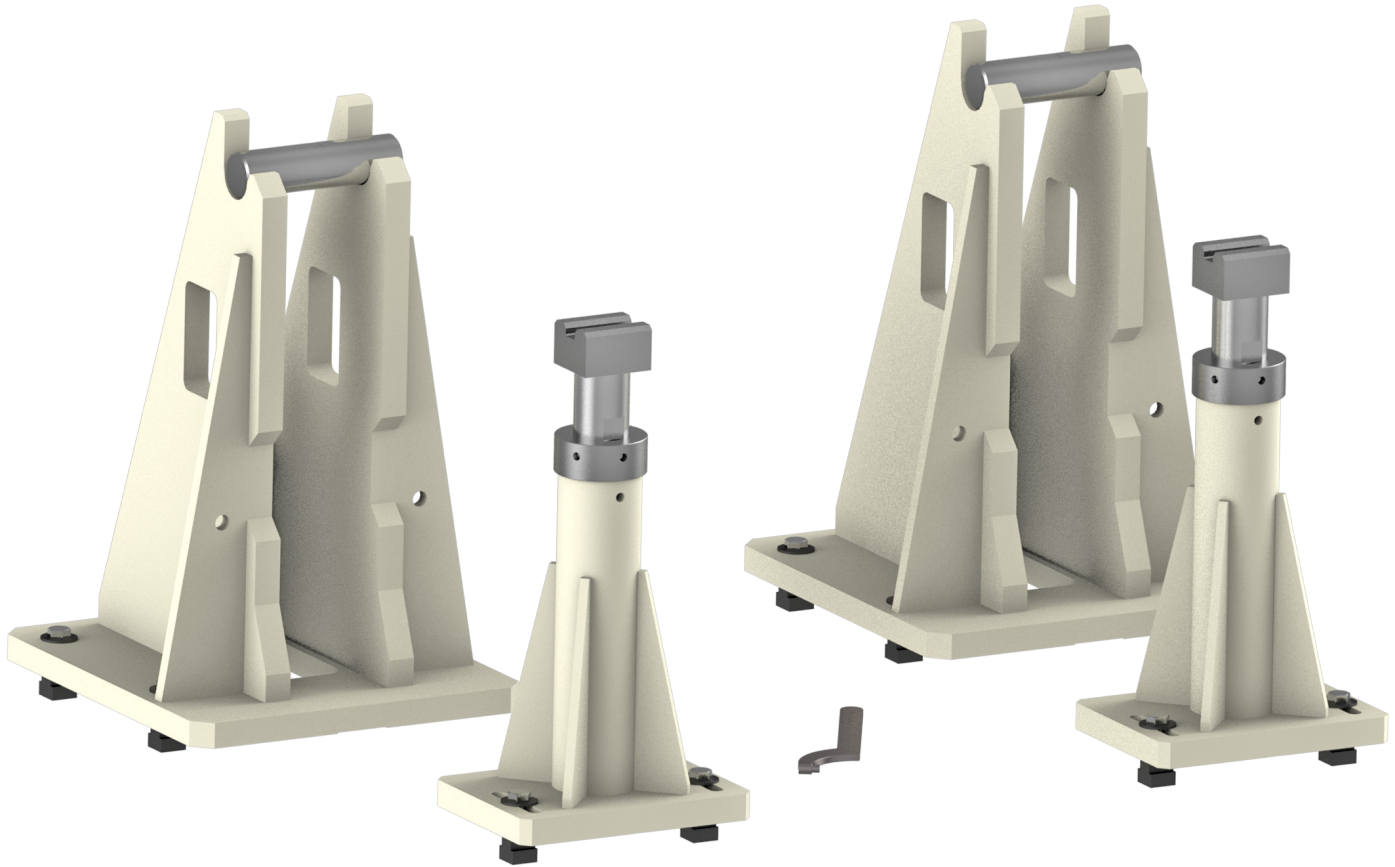
Fixturing for Extra Large In-Line and V Blocks**10100 Fixture**

For Upper End Machining - Boring and Surfacing of V blocks such as CAT 3600 and Superior 2400. Centerline to deck dimension is 24.65" (626mm) Saddle pin diameter is 2.5" (63.5mm) Main Line Locators must be ordered separately



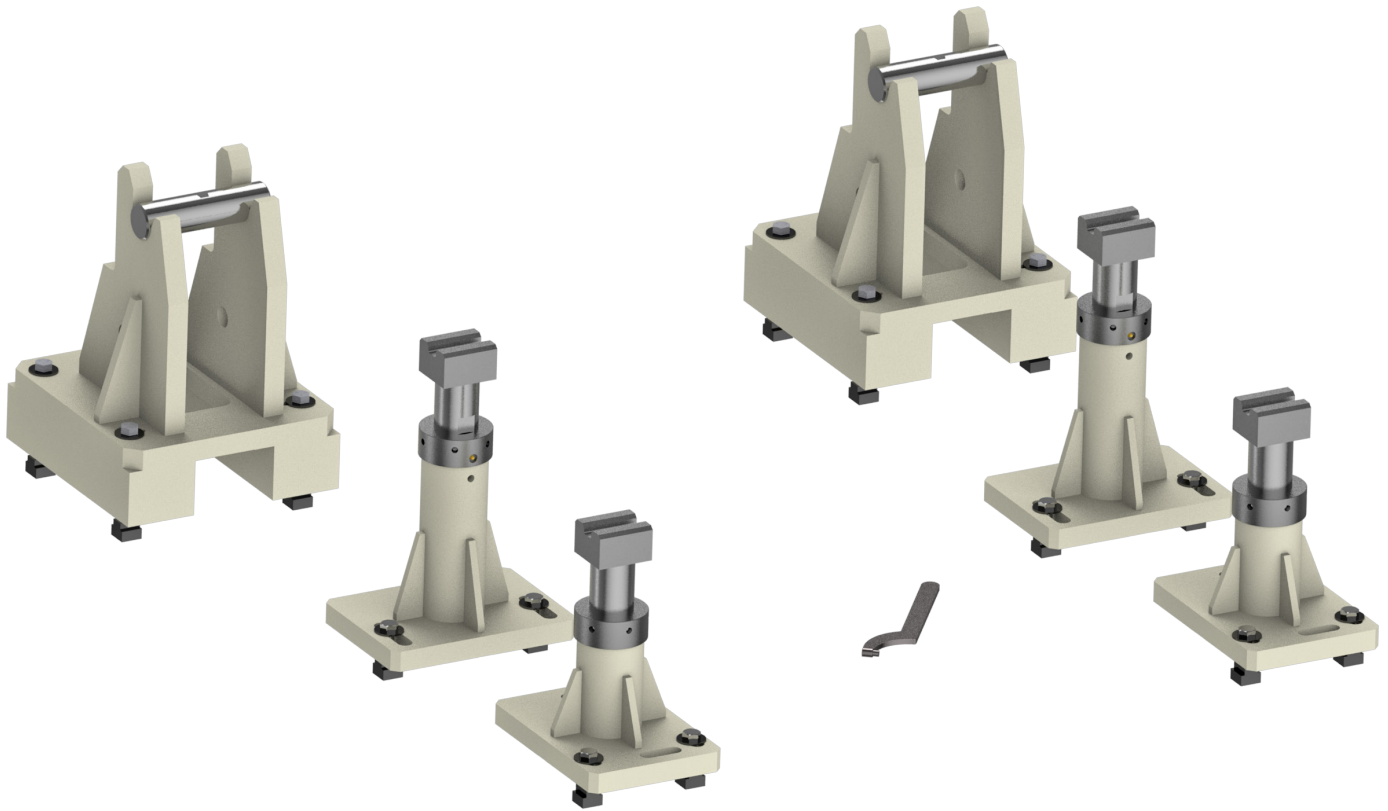
10100A Fixture

For Upper End Machining - Boring and Surfacing of V blocks such as Waukesha AT. Centerline to deck dimension is 29.28" (743.7mm) Saddle pin diameter is 2.5" (63.5mm) Main Line Locators must be ordered separately. Centerline to base 29.28"



10100D Fixture

For Upper End Machining - Boring and Surfacing of V Blocks such as EMD 645 & 710. Main Line Locators must be ordered separately.

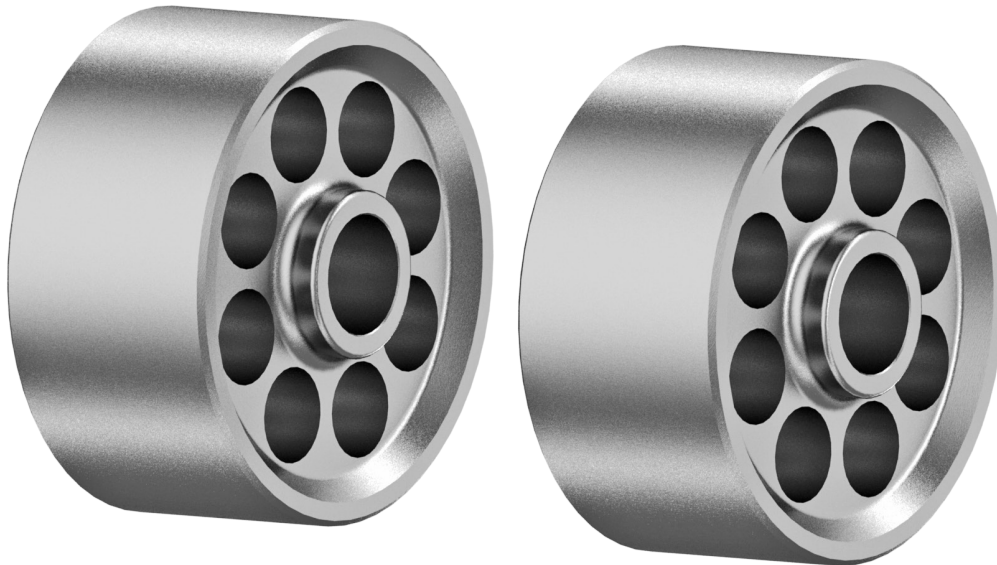


Main Bearing Bore Locator Sets

For 10100 & 10100A Block Fixture. (If Customer Requires Size Other than Available from Stock, Rottler will Manufacture the Required Size.) Customer Must Provide the Size, Including Tolerance of the Main Bearing Bore.

10102A Main Line Locators

For CAT 3600



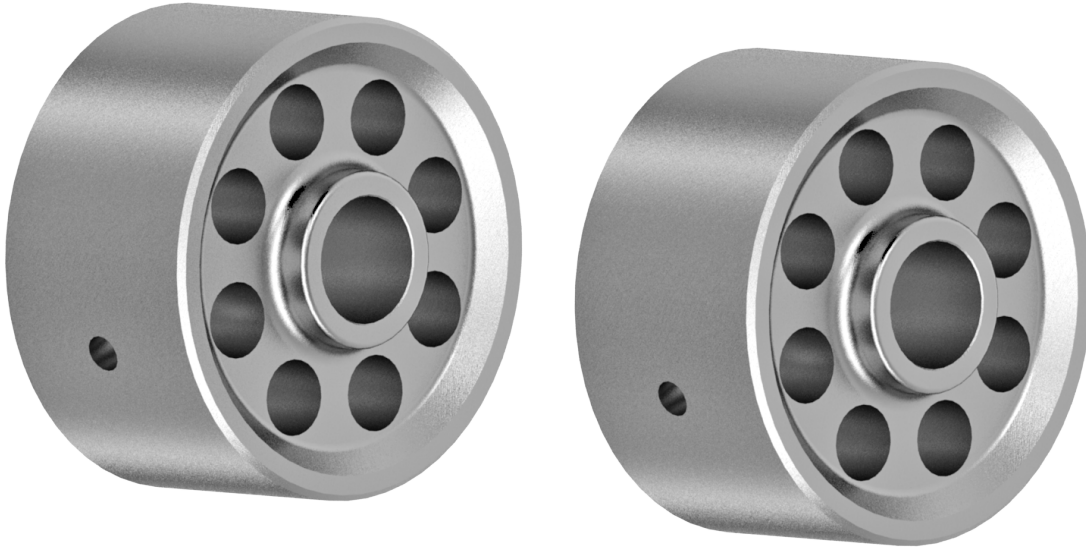
10102C Main Line Locators

For Superior 2400



10102E Main Line Locators

For Waukesha AT



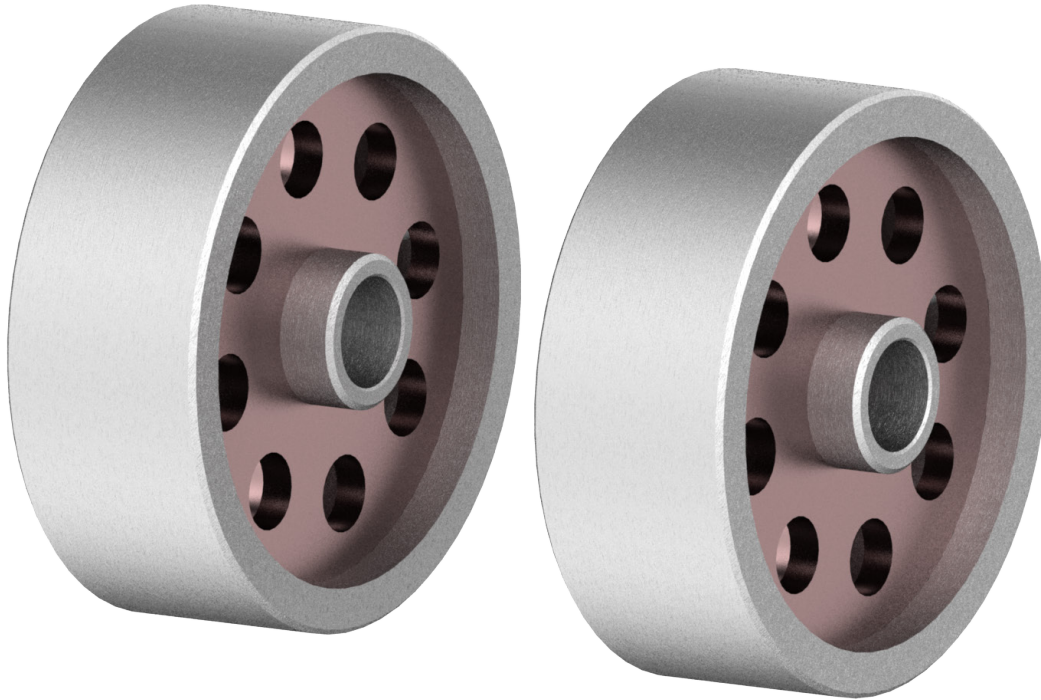
10102L Main Line Locators

For MTU 1163



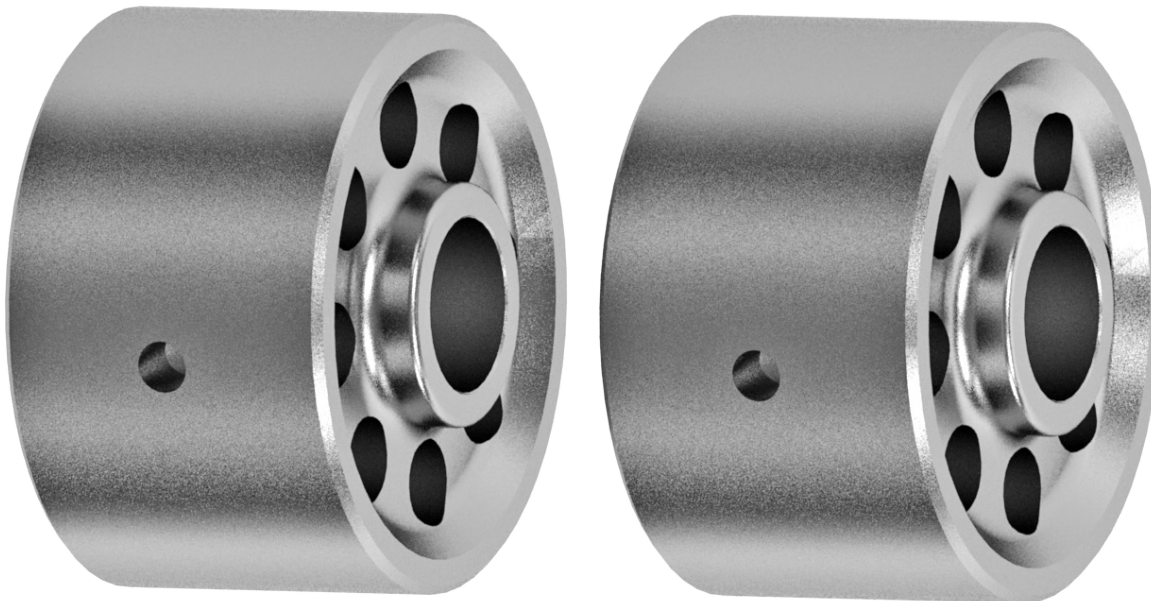
10102N Main Line Locators

For MTU 8000



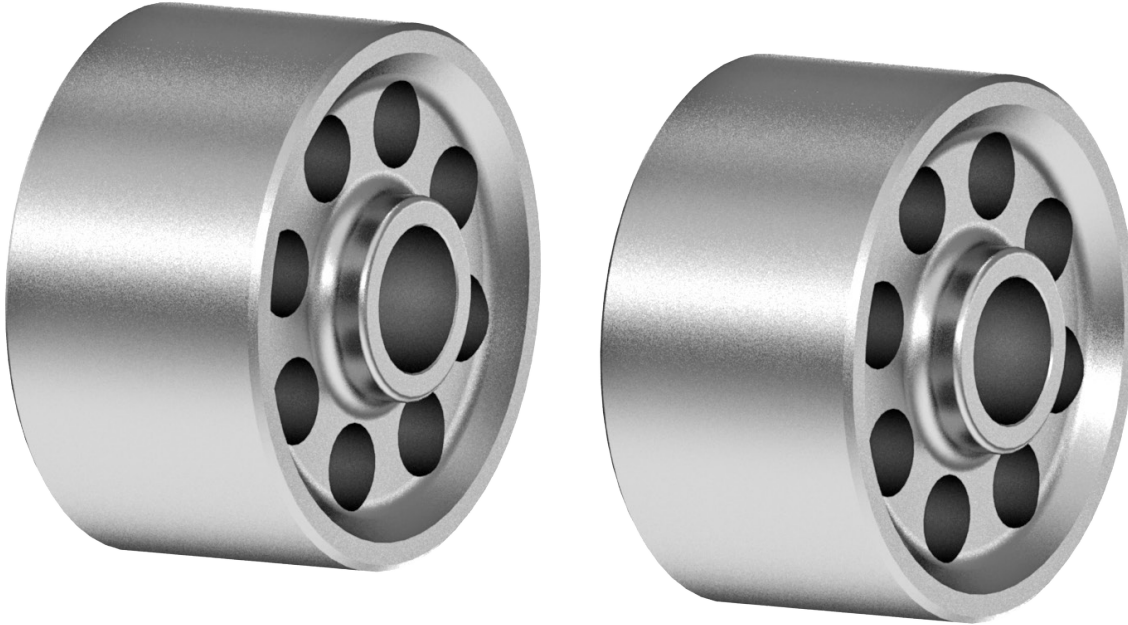
10102R Main Line Locators

For Locomotive EMD 645 (8.242")



10102G Main Line Locators

For Locomotive EMD 710 (9.242")

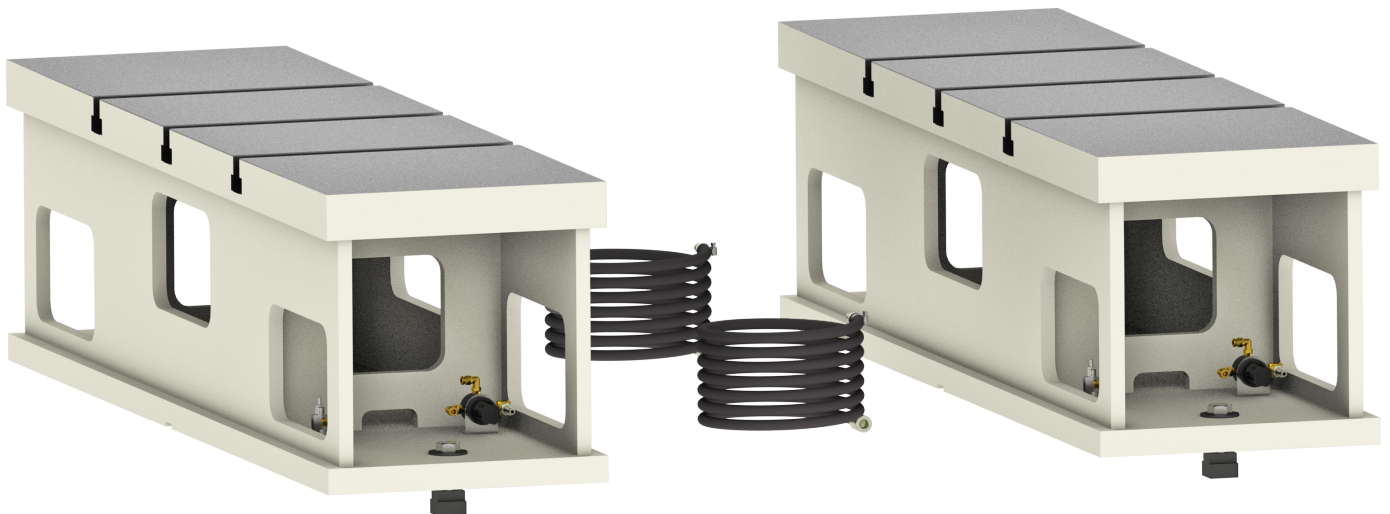


6309P Clamping System
For Fixtures 10100 & 10100A



10355 Set of Parallels with Air Float

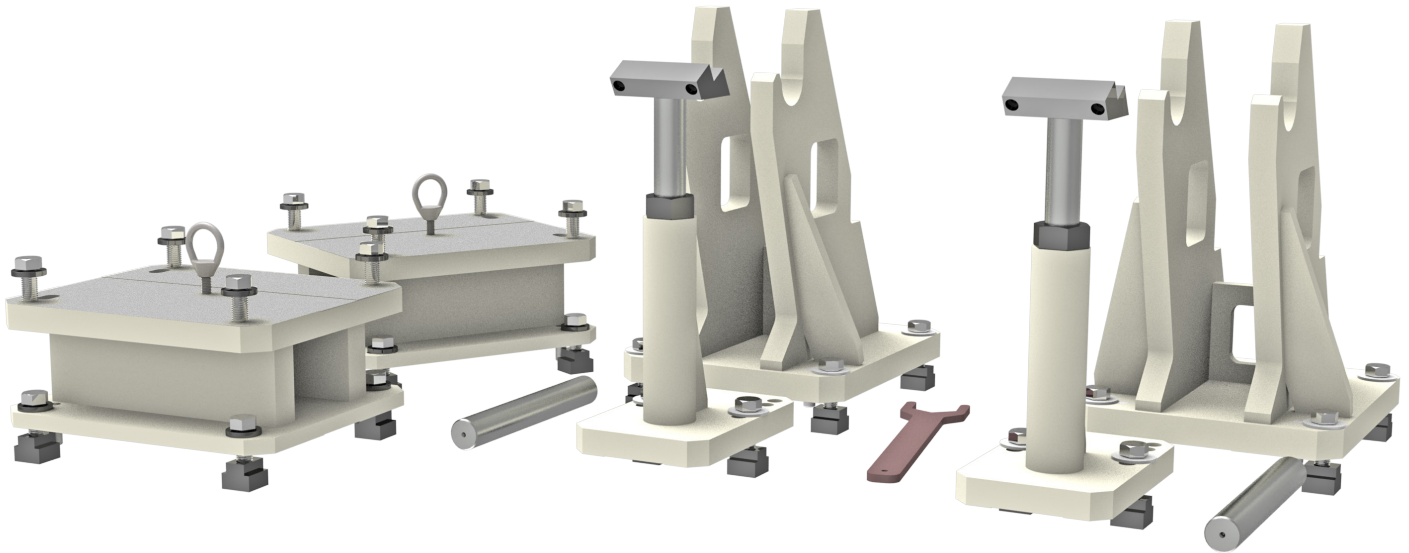
15 1/2" (394mm) - 55" (1400mm) long. Required when using Large Block Fixtures 6405F and 6821.



Fixturing for Mid Range to Large In-Line and V Blocks

6405F Large V Block Fixture

For Blocks such as CAT 3500/399, Cummins K and QSK, MTU 4000, Waukesha 7042, etc. Centerline to deck dimension is 16.28" (413.5mm) Saddle pin diameter is 2.5" (63.5mm) Requires Locators as listed.

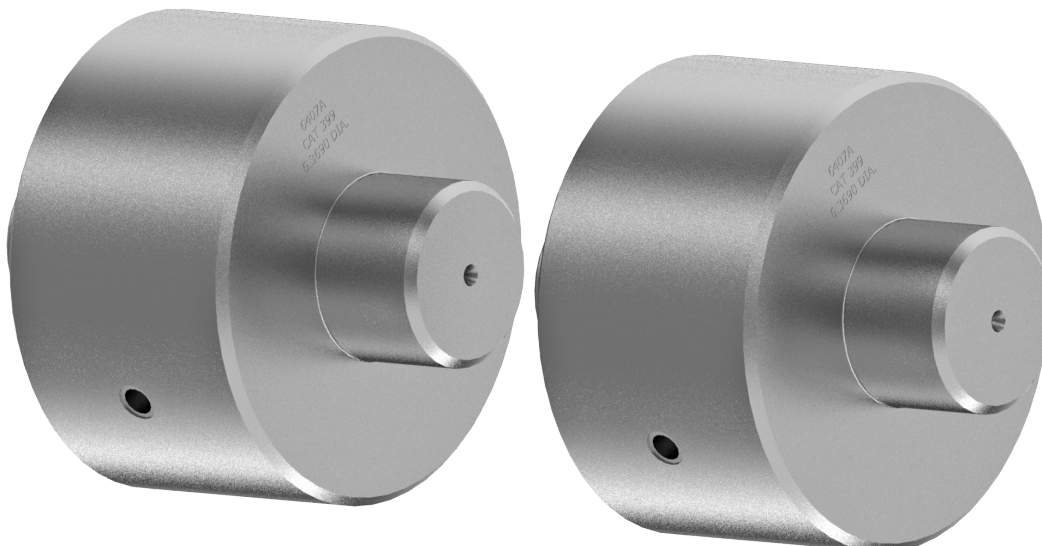


Main Bearing Bore Locator Sets

For 6405F Block Fixture. (If Customer Requires Size Other than Available from Stock, Rottler will Manufacture the Required Size.) Customer Must Provide the Size, Including Tolerance of the Main Bearing Bore.

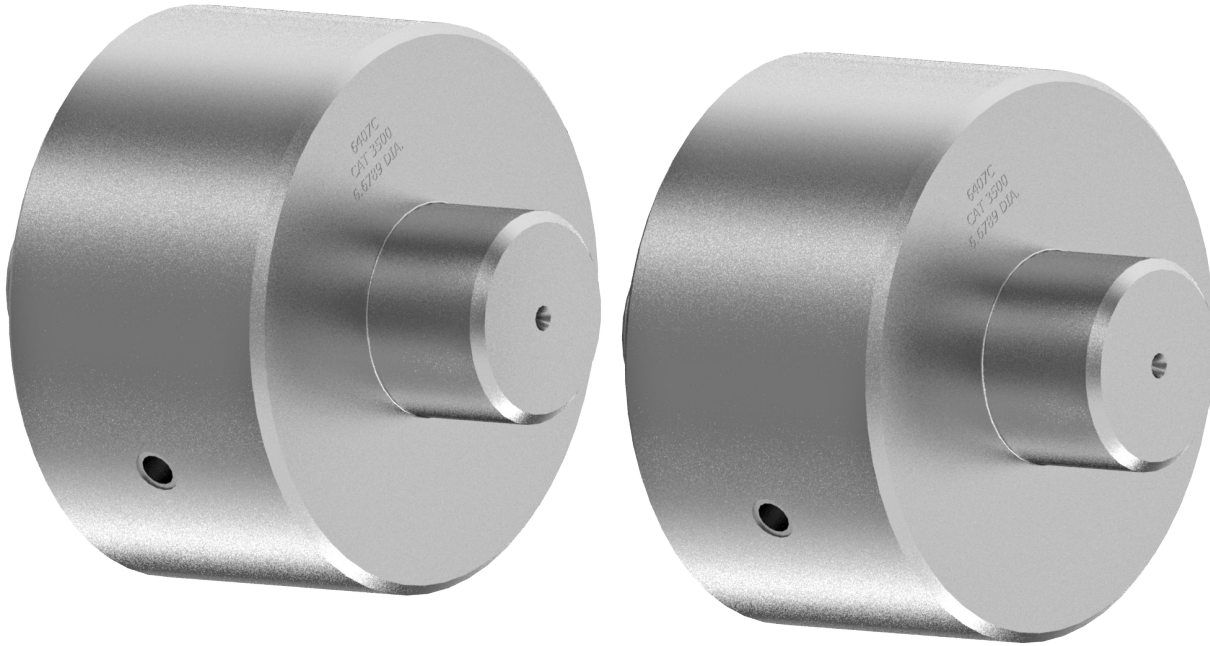
6407A Locator Assembly

Main, CAT 399 / Large V-Block Fixture (Matched Pair)



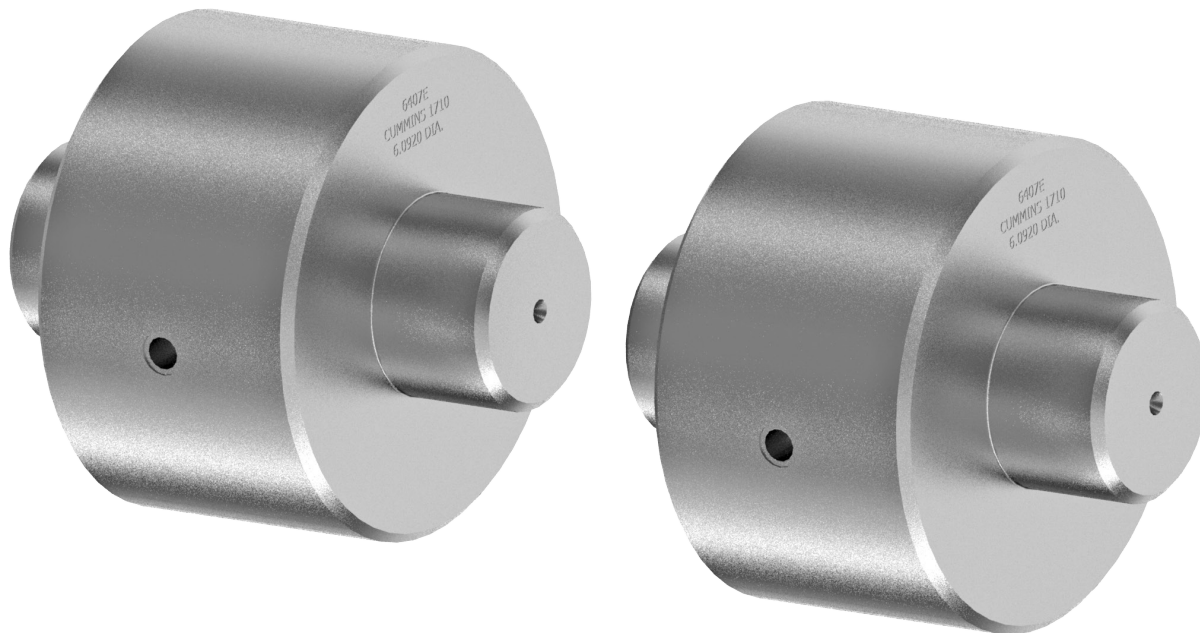
6407C Locator Assembly

Main, CAT 3500 / Large V-Block Fixture (Matched Pair)



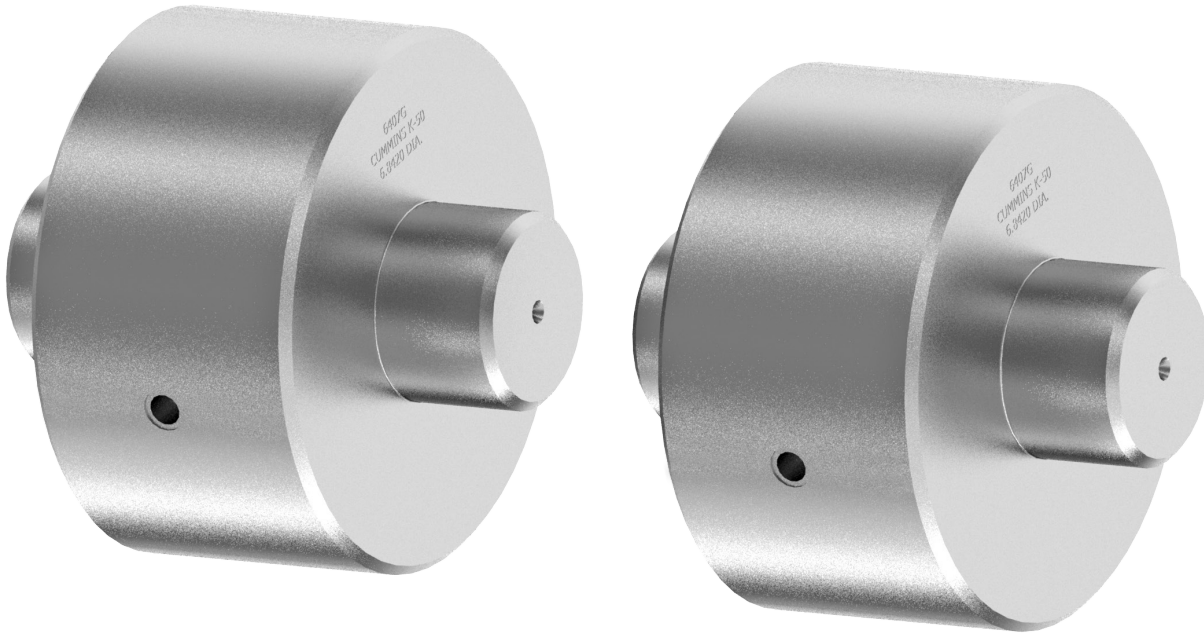
6407E Locator Assembly

Main, Cummins 1710 / Large V-Block Fixture (Matched Pair)



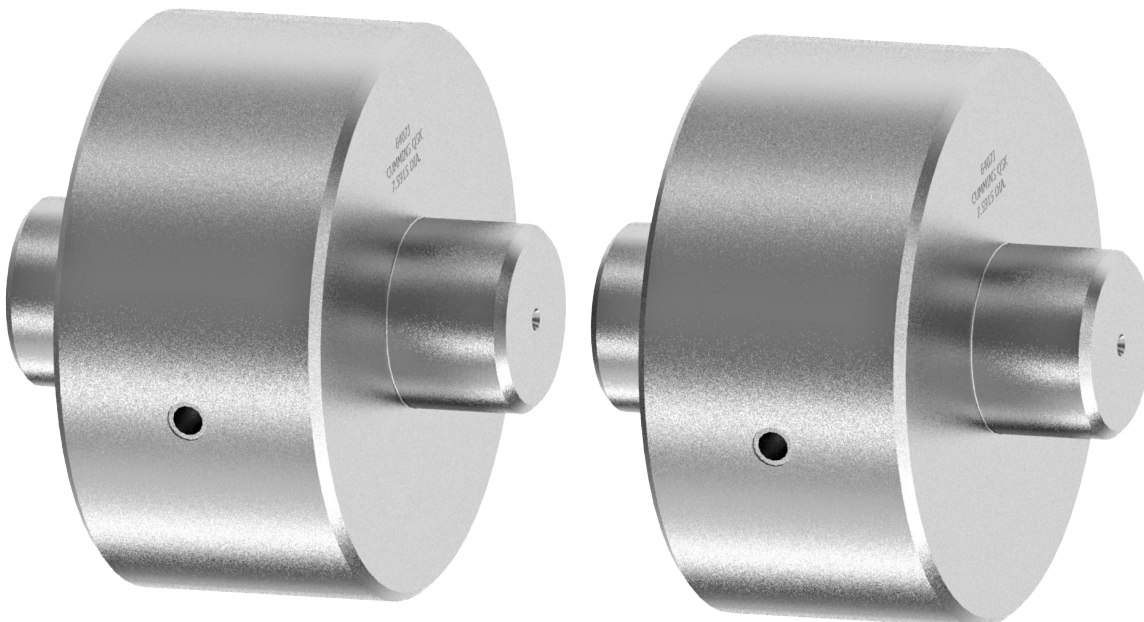
6407G Locator Assembly

Main, Cummins K50 / Large V-Block Fixture (Matched Pair)



6407J Locator Assembly

Main, Cummins QSK / Large V-Block Fixture (Matched Pair)



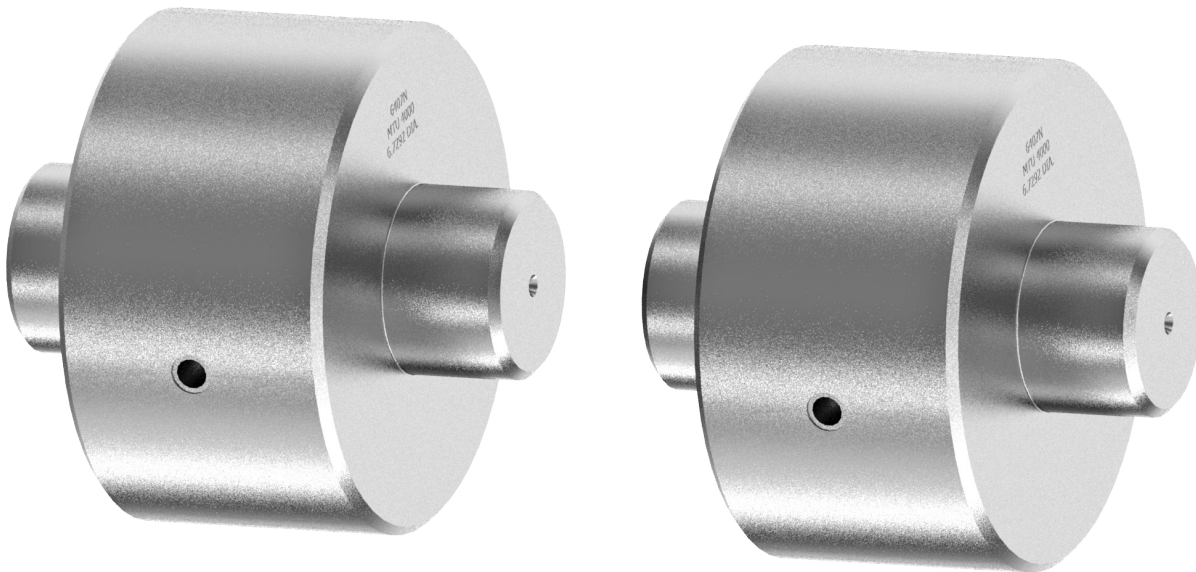
6407L Locator Assembly

Main, Waukesha 7042 / Large V-Block Fixture (Matched Pair)



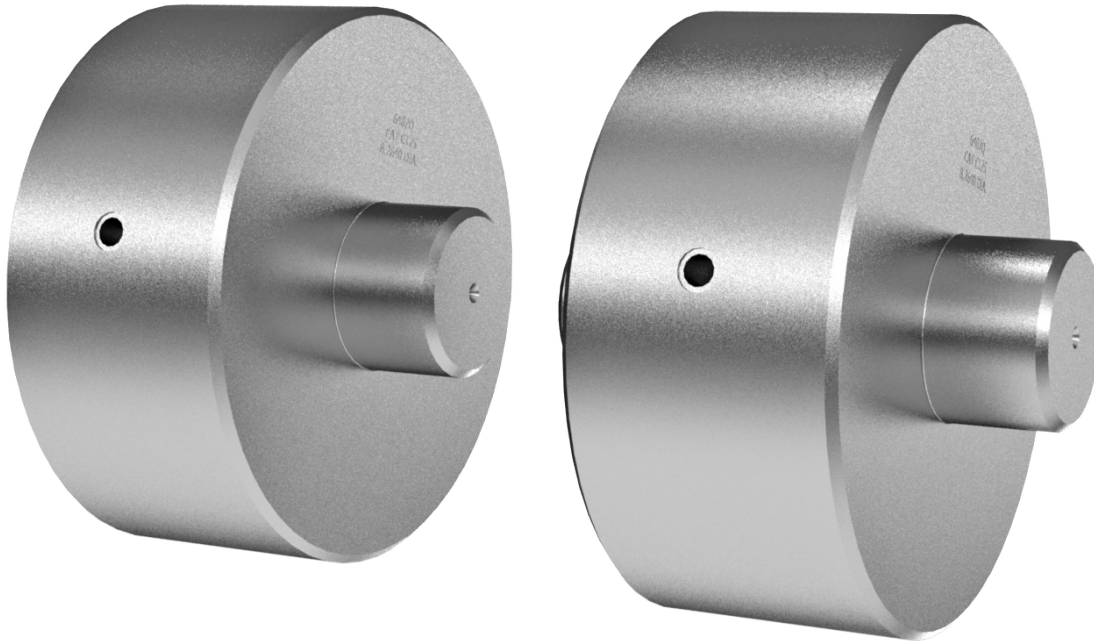
6407N Locator Assembly

Main, MTU 4000 / Large V-Block Fixture (Matched Pair)



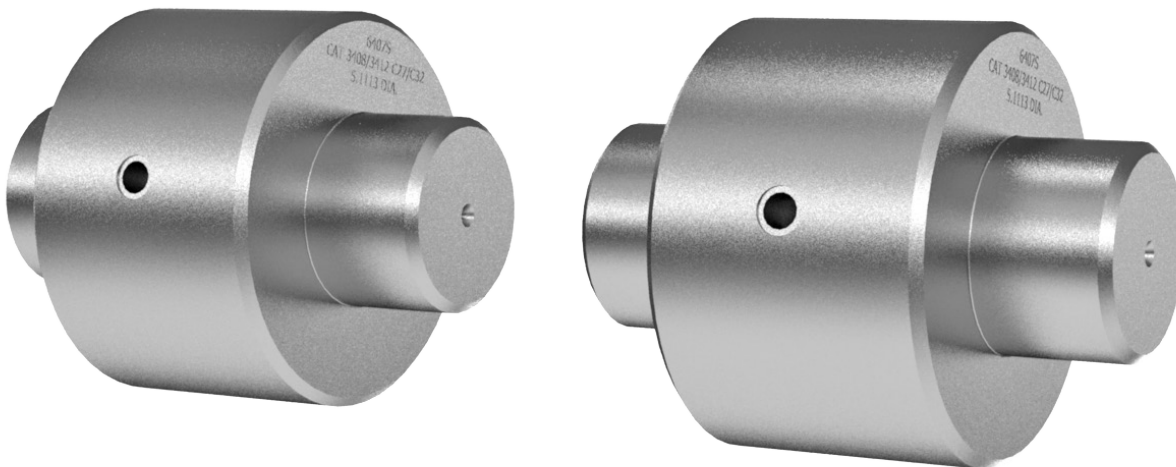
6407Q Locator Assembly

Main, CAT C175 / Large V-Block Fixture (Matched Pair)



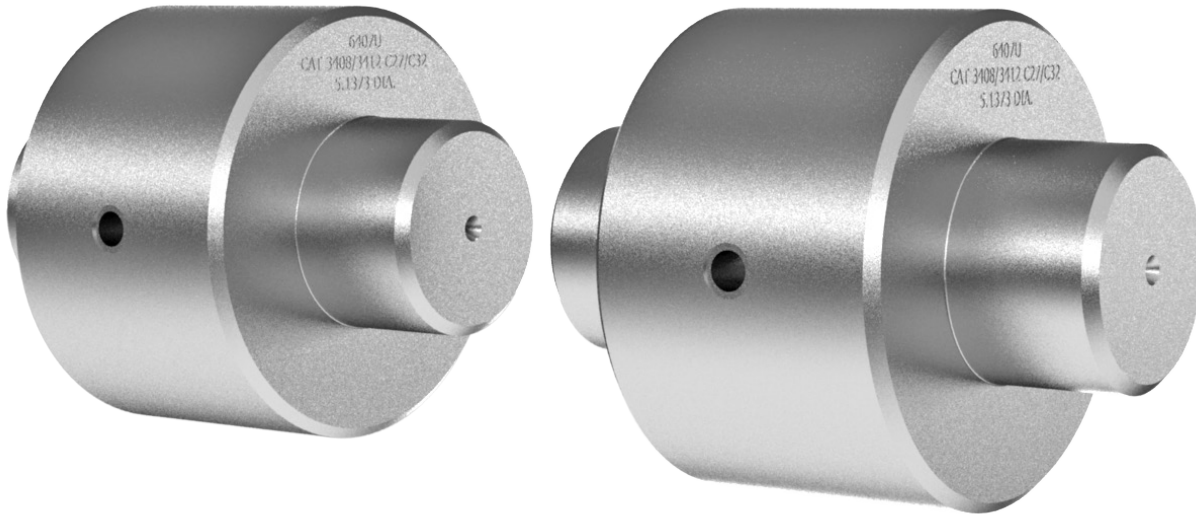
6407S Locator Assembly

Main, 5.1143 diameter bore (Matched Pair)



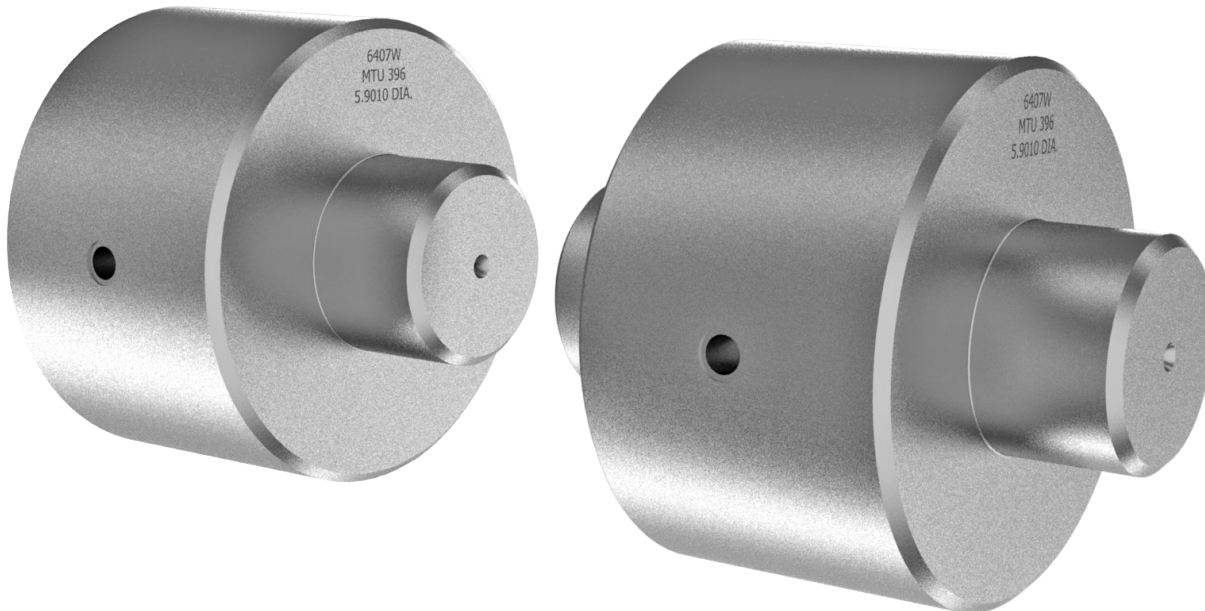
6407U Locator Assembly

Main, 5.1393 diameter bore (Matched Pair)



6407W Locator Assembly

Main, MTU 396

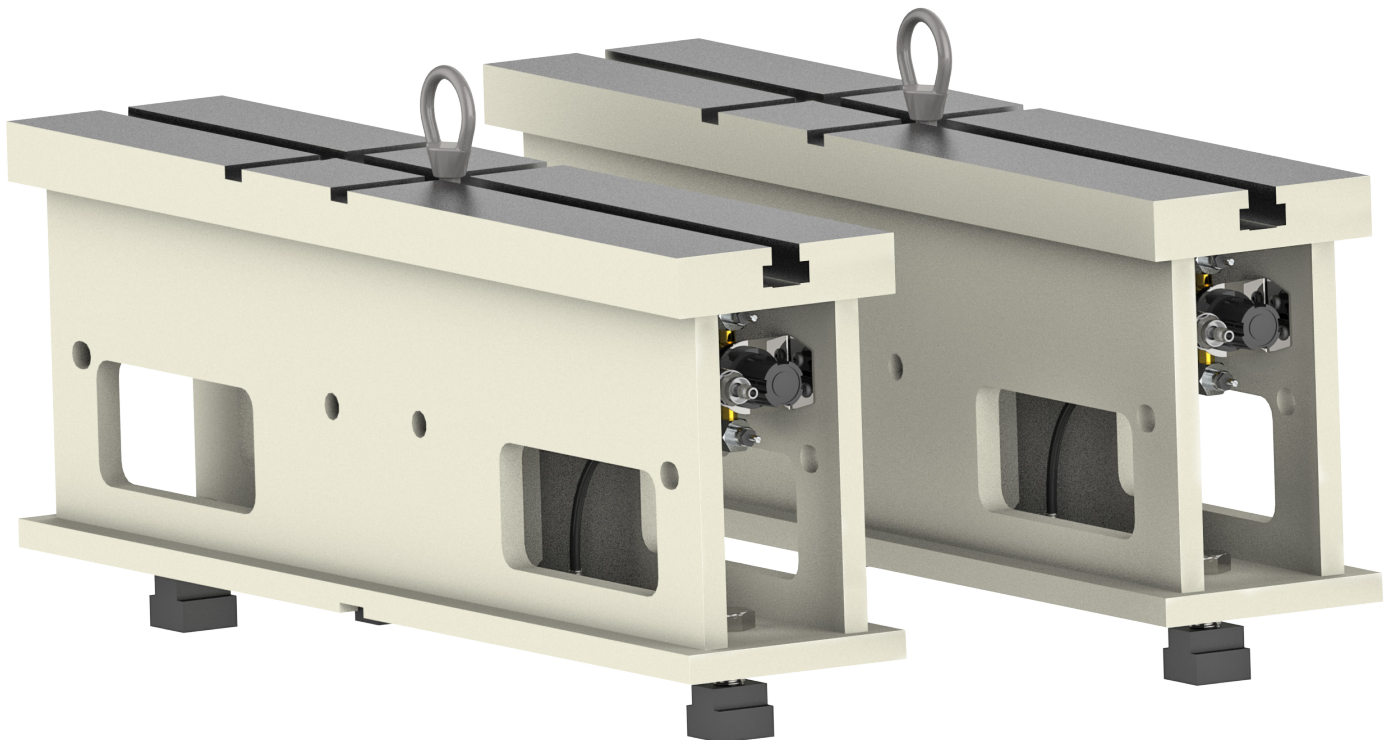


7152A Dual Axis Level Assembly



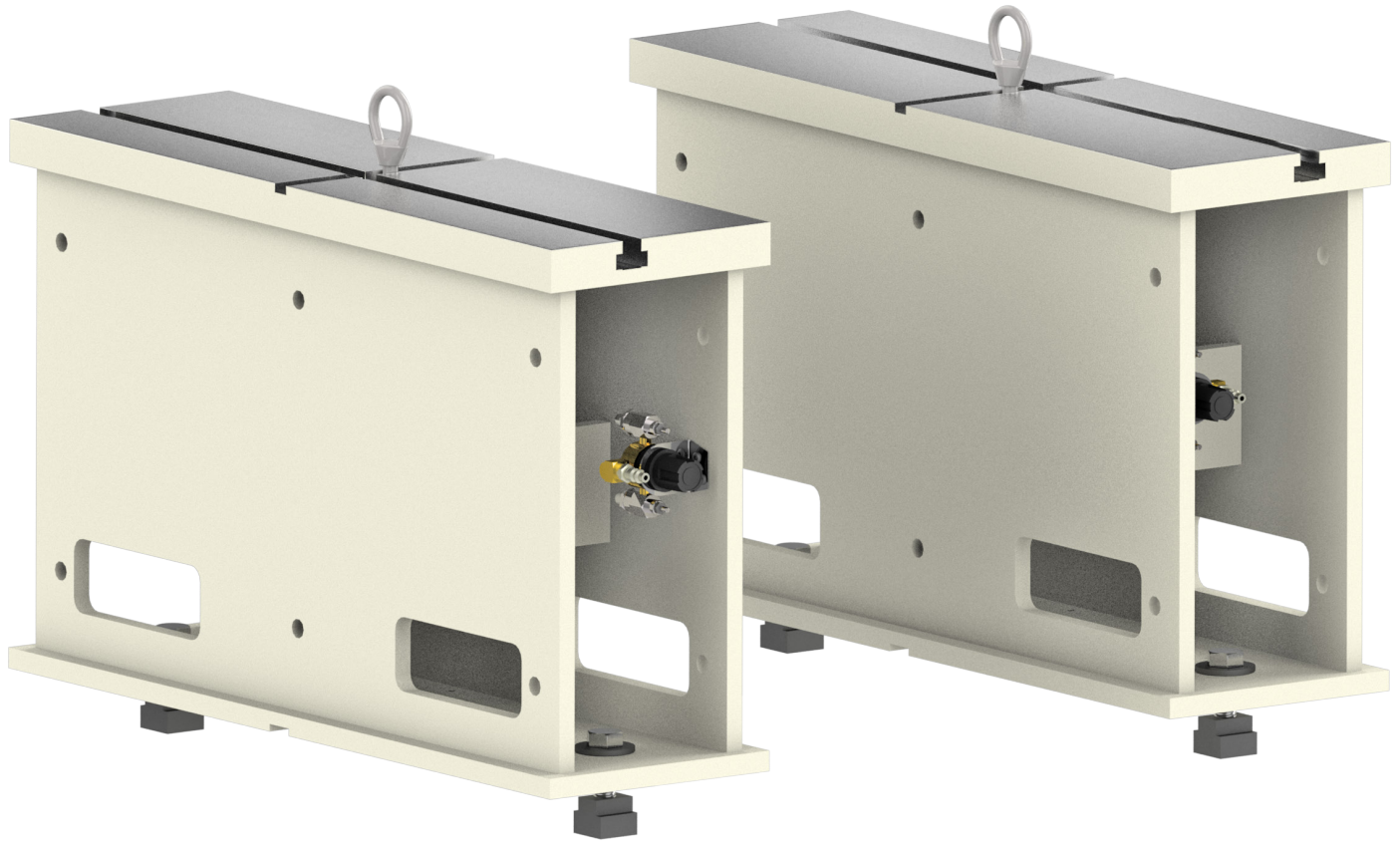
6370Z Set Of Parallels with Air Float

10" (254mm) - 3 T Slots



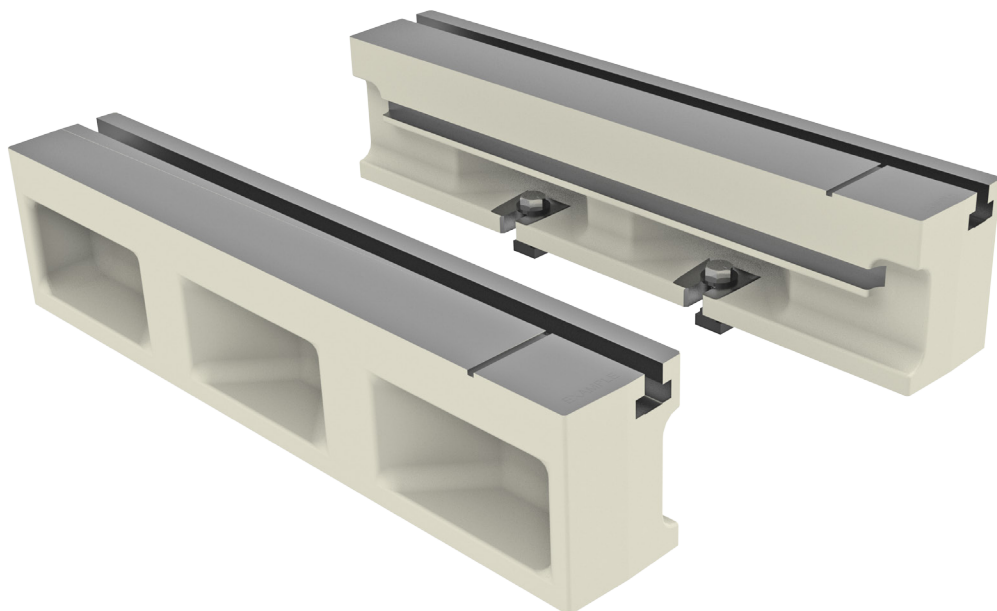
6370C Set Of Parallels with Air Float

18" (457mm) - 3 T Slots



7219W Heavy Duty T-Slot Universal Parallels

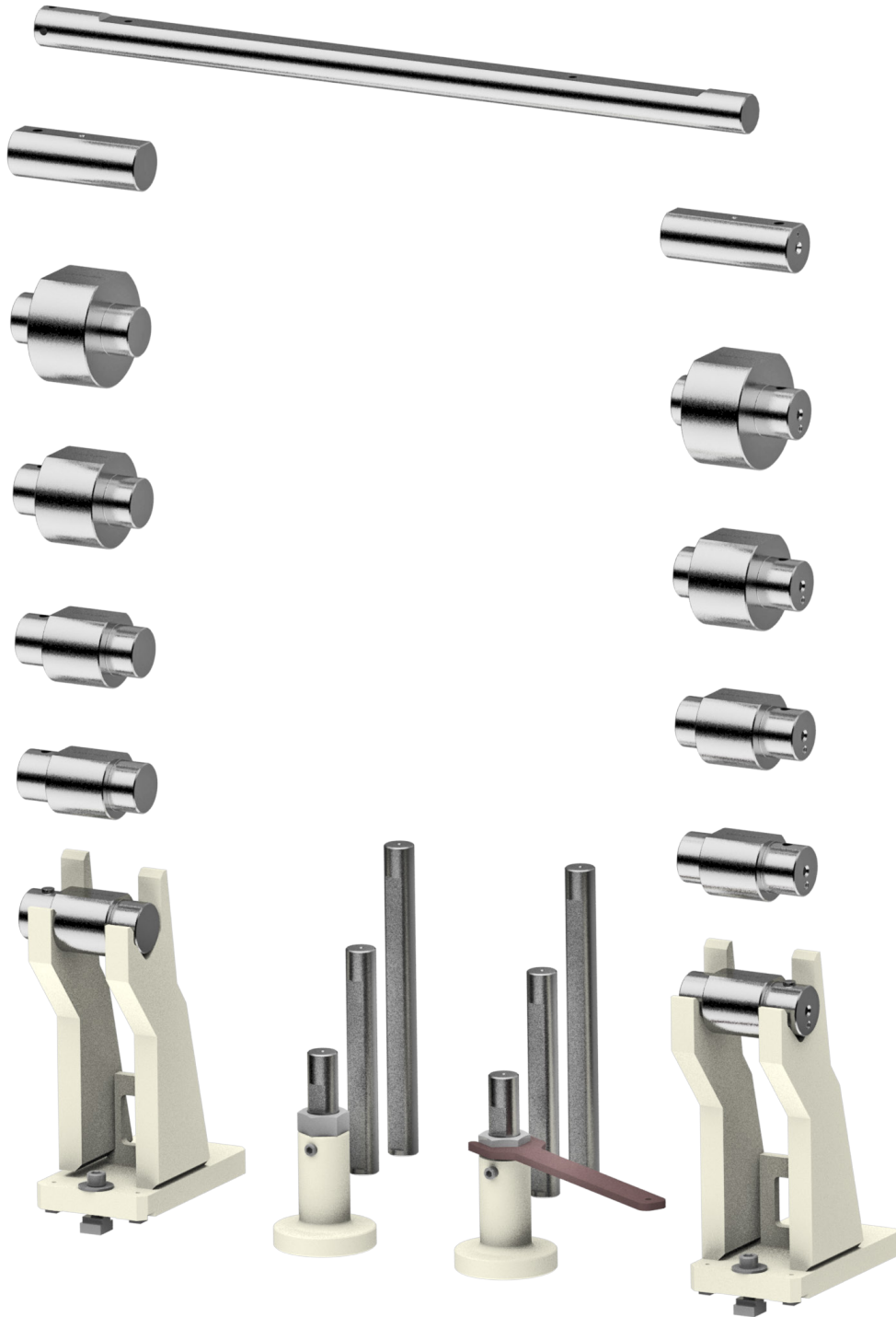
5.2" (132mm) Required when Machining Small In-Line Blocks on their Pan Rails.



6725 Mid-Range In-Line and V Block Fixture

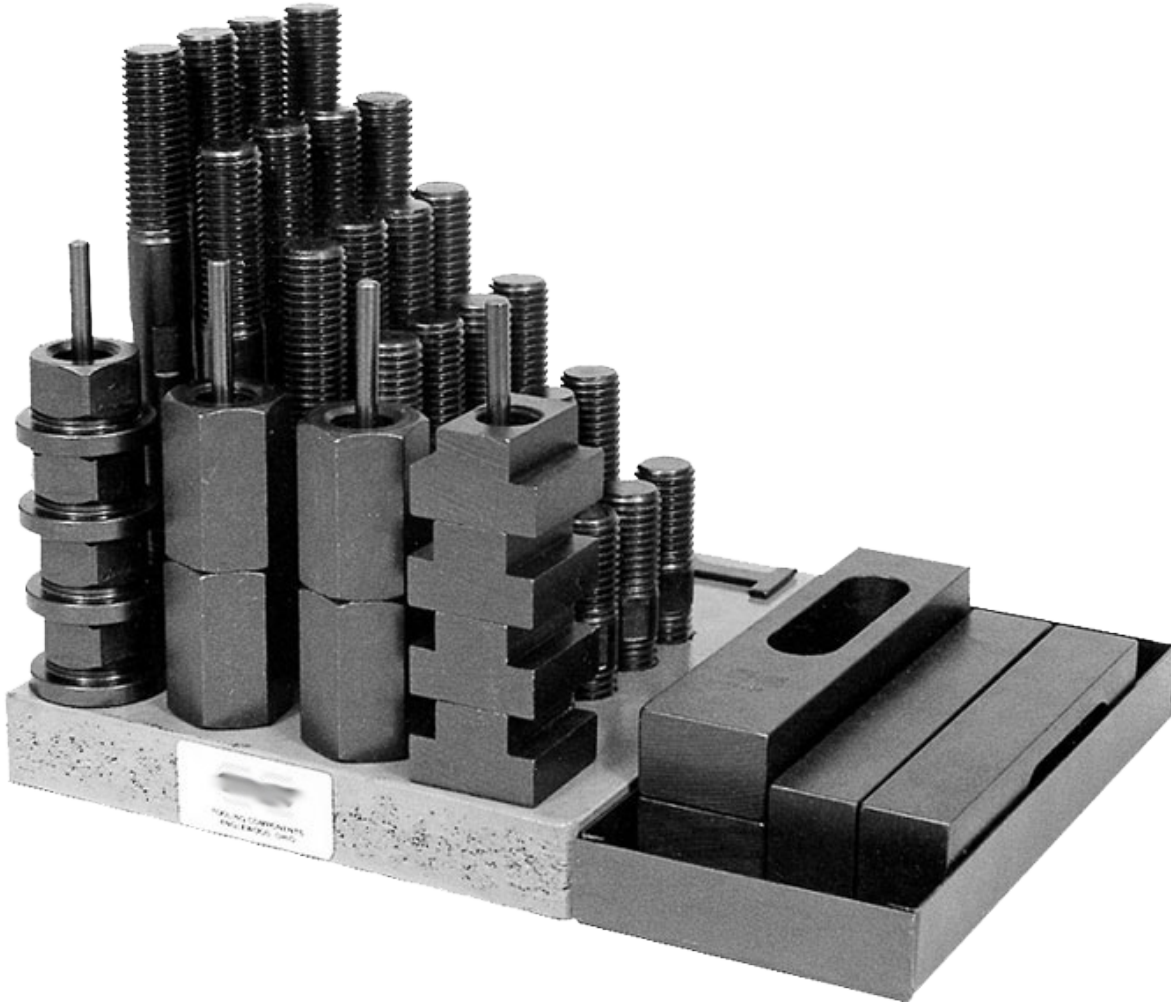
For Blocks Up to V12 Such as CAT C27, Cummins Nv12, Etc. Fixture Includes Five Pair Locators to Cover 2.5 - 6.0" (63.5 - 152mm) Main Line Diameter Range. Package includes 2" (50.8mm) bar to support small in-line and V-blocks, selection of locators available for most common blocks.

Note: 6725 requires 6370Z 10" (254mm) parallels.



6511 3/4" (19.05mm) Clamp Kit

T-Nuts, Bolts, Strap Clamps, Etc.

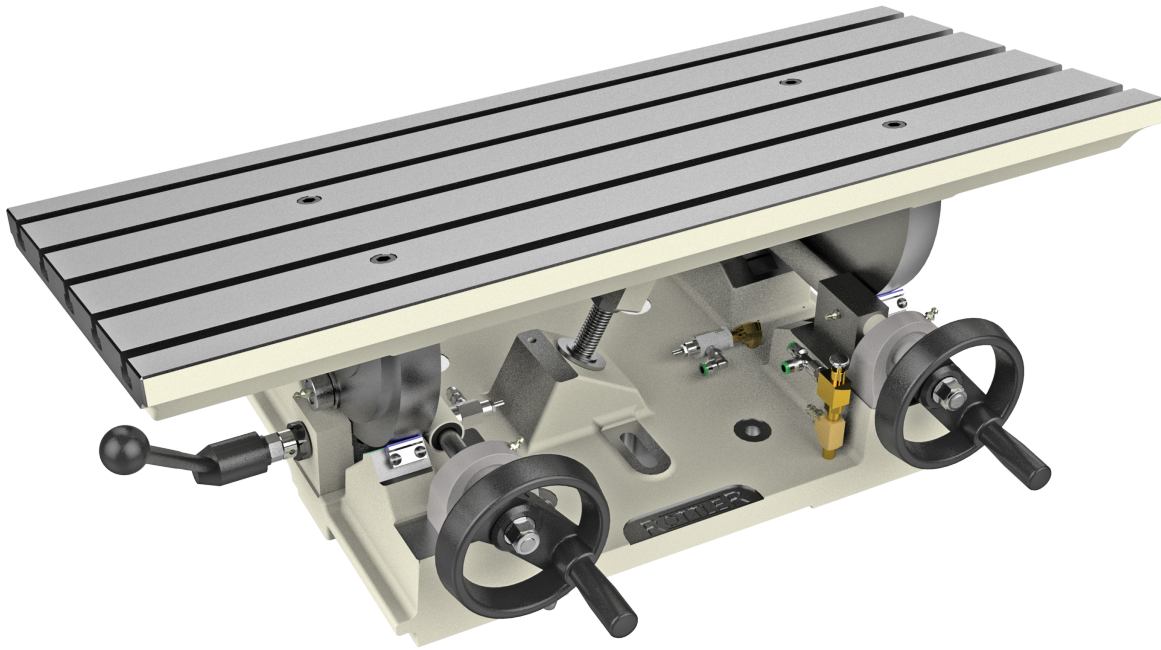


Fixturing for Surfacing Cylinder Heads and Manifolds

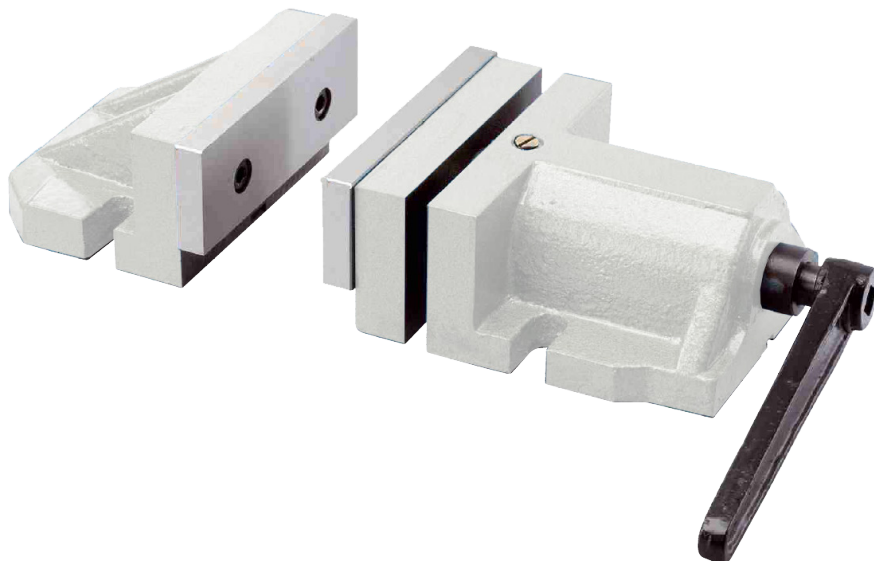
Requires Parallels 10355

7209M Leveling Table With Air Float

Complete With Universal Work Holding System for Surfacing Cylinder Heads and Manifolds. Requires One Set of 6370C Parallels

**7209N 2-Piece Vise**

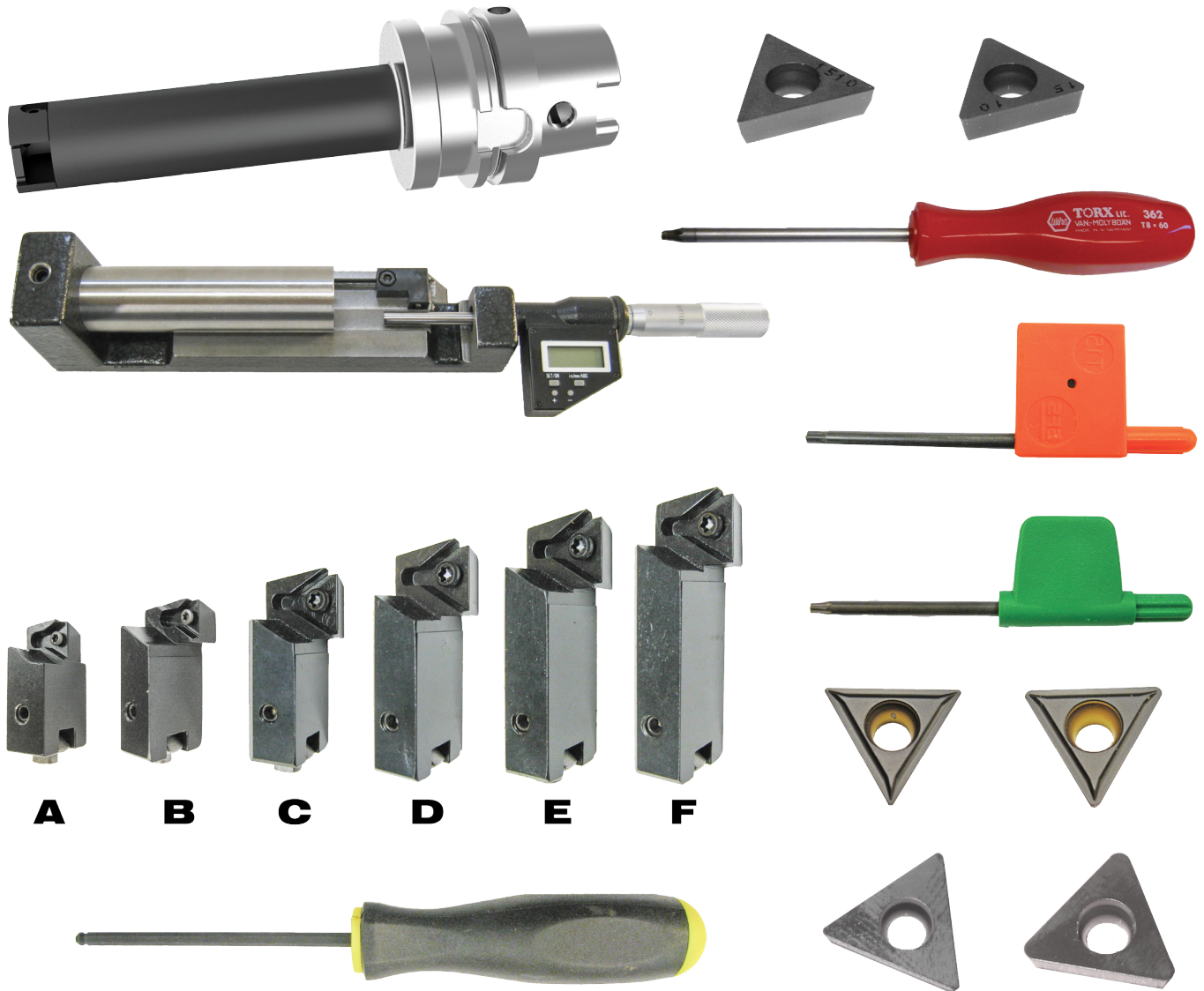
For Holding Exhaust Manifolds for Surfacing. Also Used for Surfacing Main Bearing Housing Caps In Preparation for Main Line Boring. Requires 7209M Leveling Table.



Boring and Sleeving Tooling for HSK80A Spindle Taper

10118 Blind Hole Stub Cutterhead Package

1.5 - 4.2" (38 - 107mm) diameter x 6.5" (165mm) length complete with tooling and Digital Micrometer



10108B Blind Hole Stub Cutterhead Package

2.9 - 5.0" (74 - 152mm) diameter X 9.7" (246mm) length Complete With Tooling and Digital Micrometer



10117A Blind Hole Cutterhead

4.5 - 9.0" (114 - 229mm) diameter complete with tooling and Digital Micrometer suitable for boring diameters larger than spindle diameter 6" (152.5mm)



10116 Extended Spindle Blind Hole Cutterhead Package

4.5 - 9.0" (114 - 228mm) diameter x 12.5" (318mm) length complete with tooling and Digital Micrometer



10107B Blind Hole Cutterhead Package

8.0 - 14.0" (203 - 360mm) diameter complete with tooling and Digital Micrometer



10104B Blind Hole Cutterhead Package

11.75 - 16" (298 - 406mm) diameter - Complete with tooling and Digital Micrometer



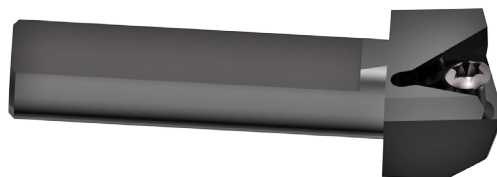
10105B Blind Hole Cutterhead Package

14.0 - 20.0" (356 - 508mm) diameter complete with tooling and Digital Micrometer



6593S Cartridge Assembly

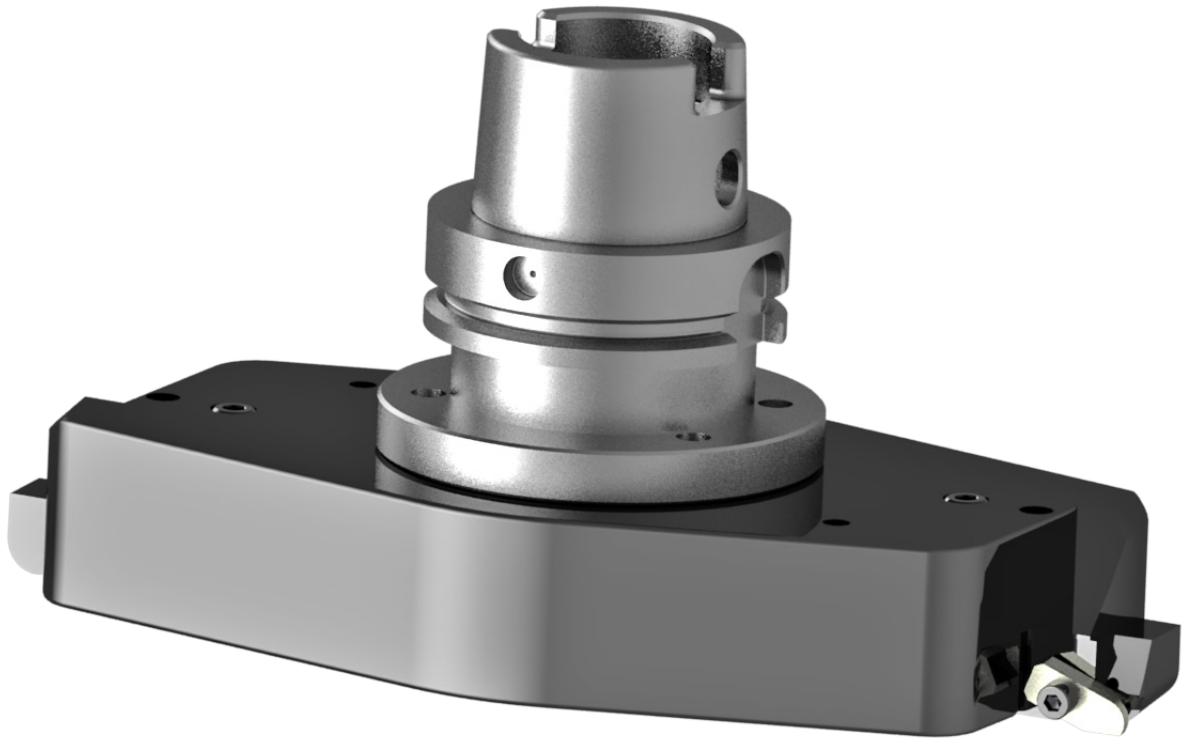
Circular Interpolation Counterbore Facing



Surfacing Tooling for HSK80A Spindle Taper

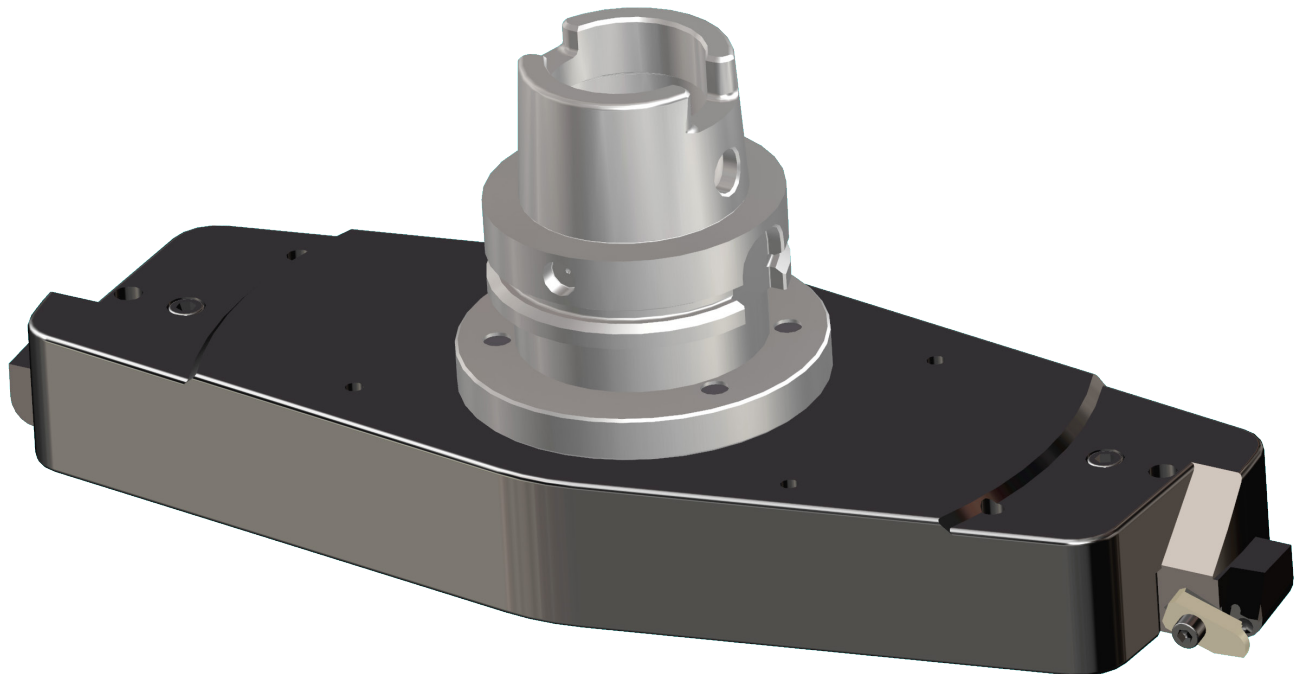
10119 10" (250mm) Diameter Surfacing Cutterhead Assembly

Complete With Tooling



10106C 14" (360mm) Diameter Surfacing Cutterhead Assembly

Complete With Tooling



10115 18" (460mm) Diameter Surfacing Cutterhead Assembly

Complete With Tooling



10106B 22" (560mm) Diameter Surfacing Cutterhead Assembly

Complete With Tooling



6301J CBN Insert

1/16 Radius, for Surfacing Large Blocks (15% Discount on orders of 10 or more)



6303V CBN Insert

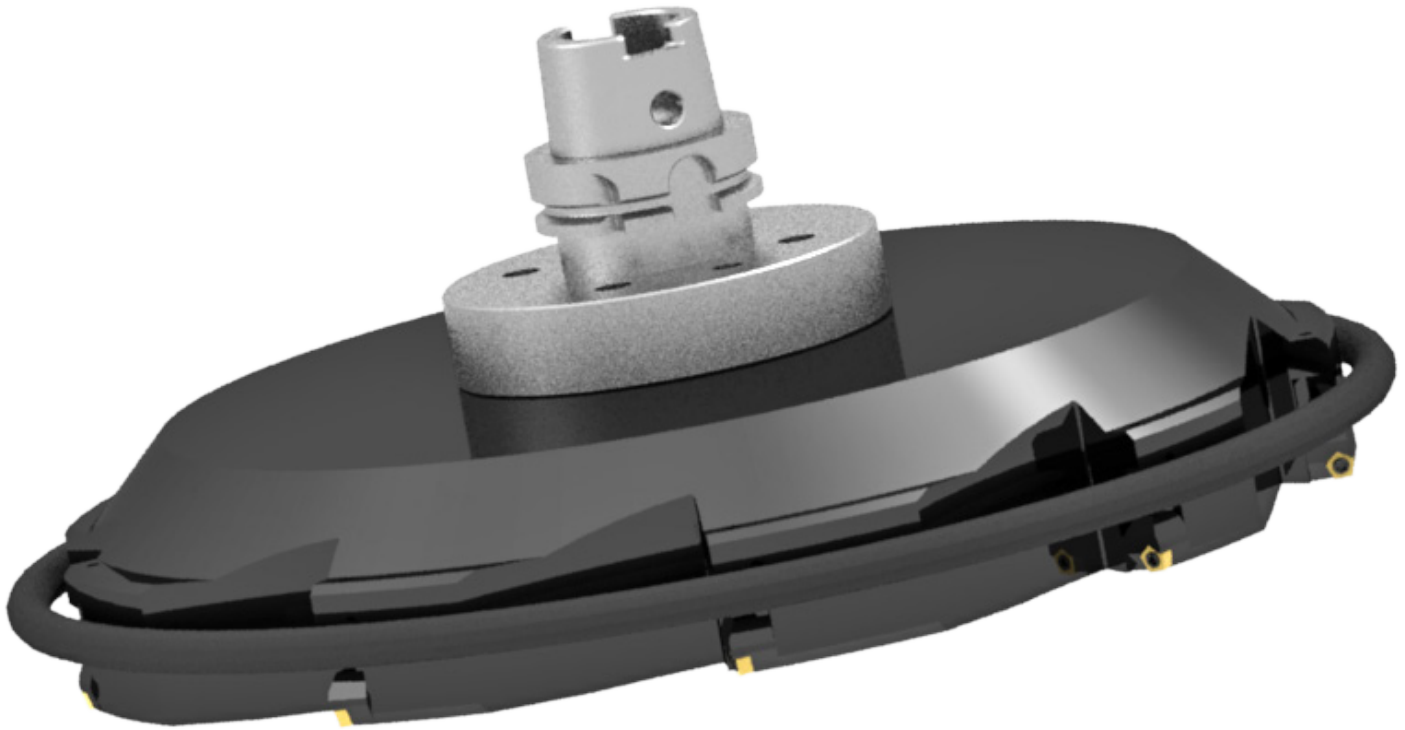
Octagonal (16-Cutting Corners) for surfacing large diesel blocks (15% Discount on orders of 10 or more)



Special Surfacing Tooling for Milling Metal Sprayed Head Gasket Decks

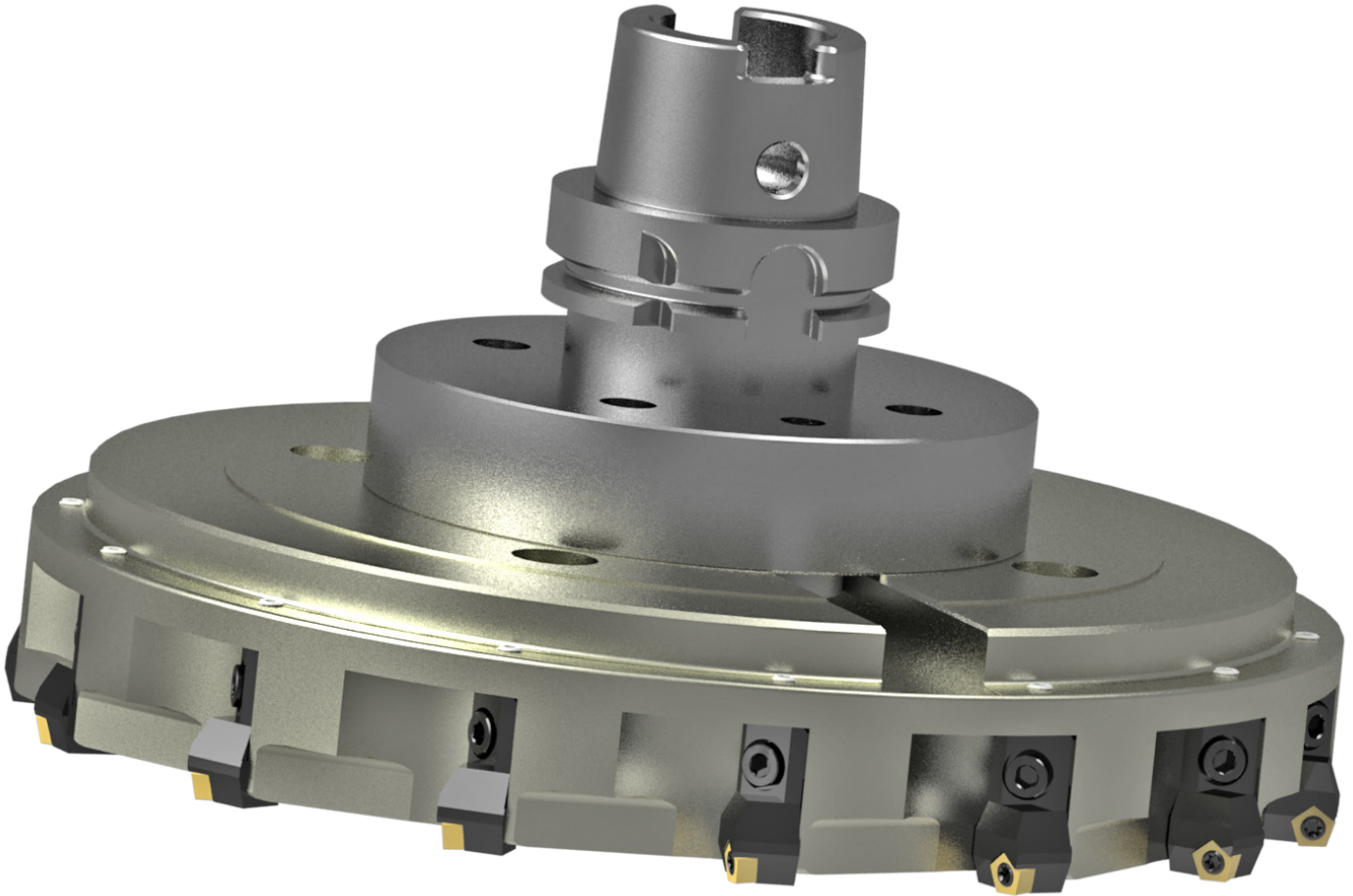
10109B Special 18" (420mm) Diameter Multi Tooth Milling Head

Including 9 Cartridges with 10 cutting edges per insert: Cutting inserts must be ordered separately



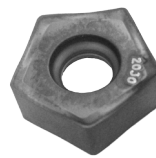
10120 Special 12" (300mm) Diameter Multi Tooth Milling Head

Including 14 Cartridges with 10 cutting edges per insert: Cutting inserts must be ordered separately



6864E Replacement Insert

(10 cutting edges per insert) for 10109B and 10120 Milling Head



6864D Replacement Cartridge

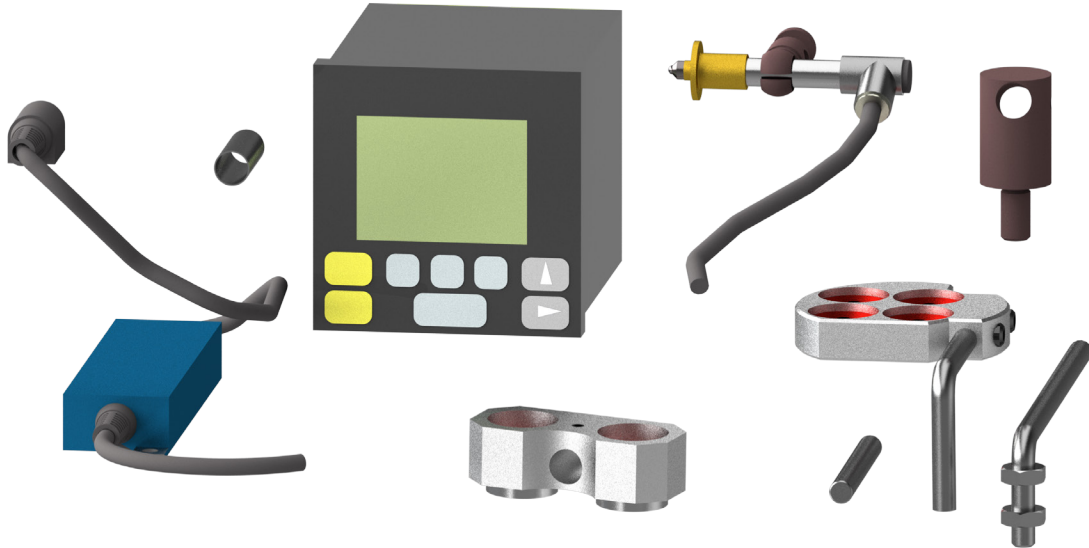
For 10120 Milling Head



General Purpose Accessories

502-12-7B Digital Runout Probe and Readout

Including Magnetic Holder for Block Set Up and Manual Centering of Cylinder Bores and Main Line Bores



General Purpose Tooling

10121 Caterpillar 3400 Series Tappet Bore Repair Tooling Package

Including Digital Indicator and 1" Spindle Adaptor



10122 Small Precision Adjustable Boring Head

Including Spindle Adapter and Digital Indicator for General Purpose Boring and Facing Work, Boring Range 3/4 - 3" (20 - 75mm) and Facing Range 4.9 - 7" (125 - 180mm)



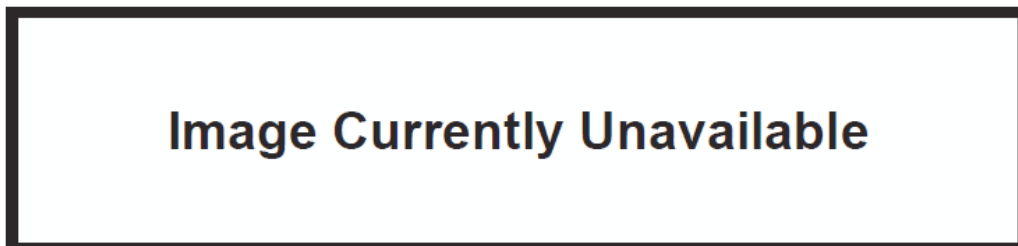
10123 Large Heavy Duty Adjustable Boring/Facing Head

Including Spindle Adapter for General Purpose Boring and Facing Work, and Cutting Wide Chamfers



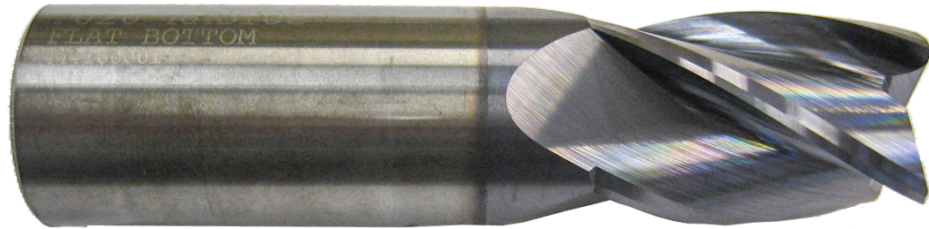
10124 Collet Kit

1/8 - 1" (3 - 26mm) 23 Collets Including Storage Box and Wrench. Requires 6170J #40 Spindle Adapter



650-2-45G Solid Carbide End Mill

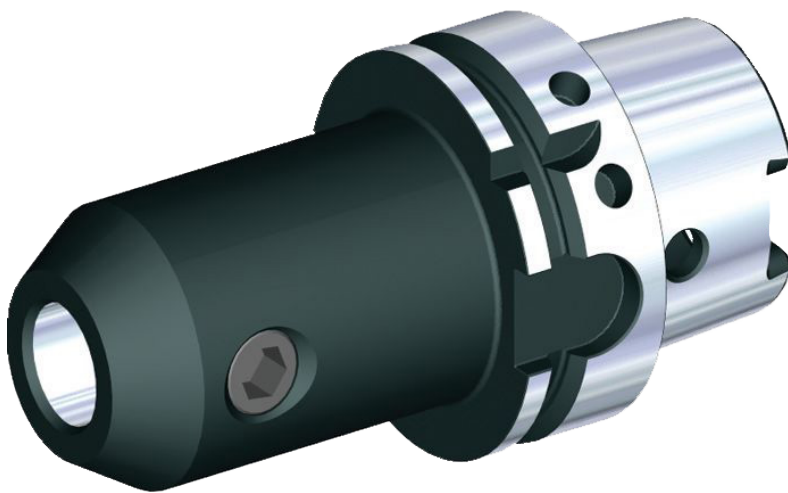
1" (25.4mm) Diameter x 4.00" (101.4mm) overall length. Used for machining head gasket fire deck surface for water hole corrosion repairs.

**650-2-43F Four Fluted End Mill**

3/4" (19.05mm) X 4" (101.4mm) Overall length (.020" corner radius, flat bottom, no dish) Used for Machining Head Gasket Fire Deck Surface for Water Hold Corrosion Repairs

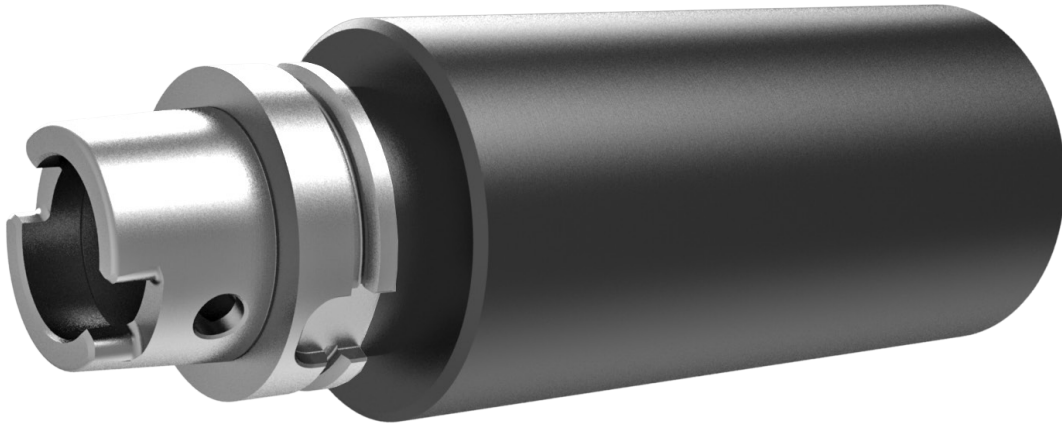
**Spindle Adapters for Mounting Universal Tooling****10113 1" (25.4mm) Spindle Adapter**

For Driving 1" (25.4mm) Diameter Shank Tooling

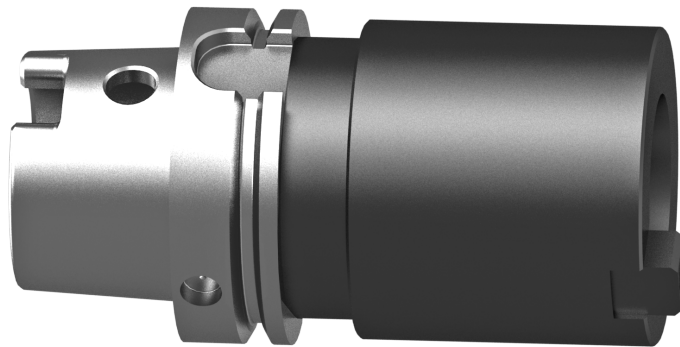


10125 Blank Adapter

Can be Machined by Customer to Suit Special Requirements



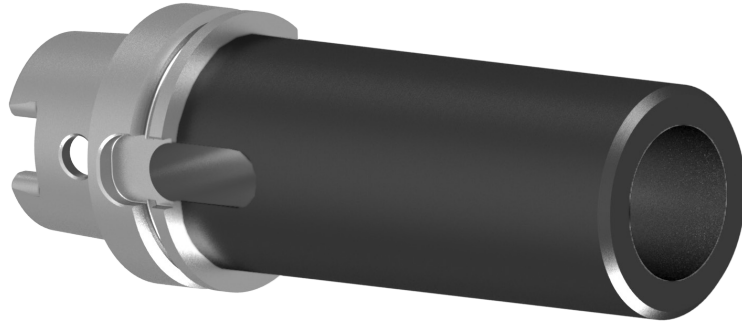
10126 #40 Taper Adapter



10127 R8 Taper Adaptor



10128 #5 Morse Taper Adapter



Main Line Bore Equipment

Line Bore Tooling for Extra Large Blocks Such as CAT 3600, 3500 & 399, Waukesha AT, 7042 and 9390, White Superior 2400 and 825

6898 Extra Heavy Duty 90 Degree Right Angle Drive

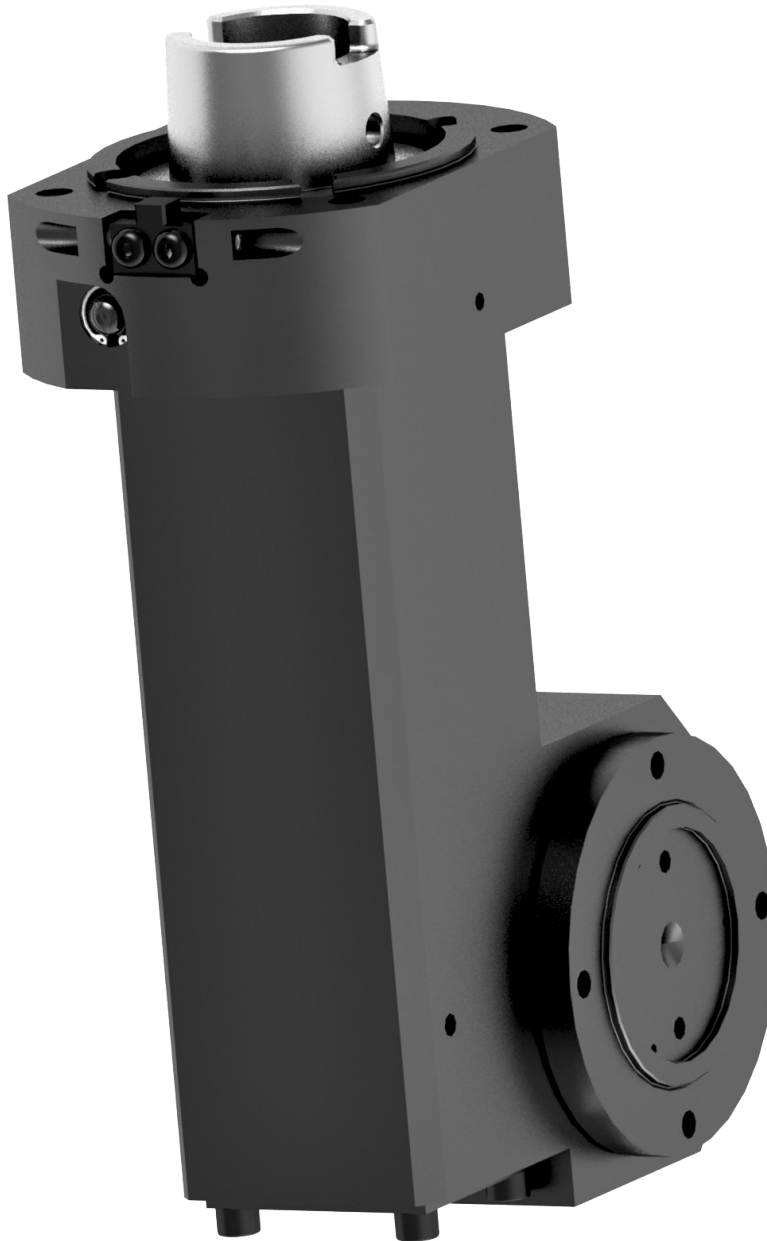
Double Sided for machining in left and right directions



10114 Heavy Duty Offset 90 Degree Right Angle Drive

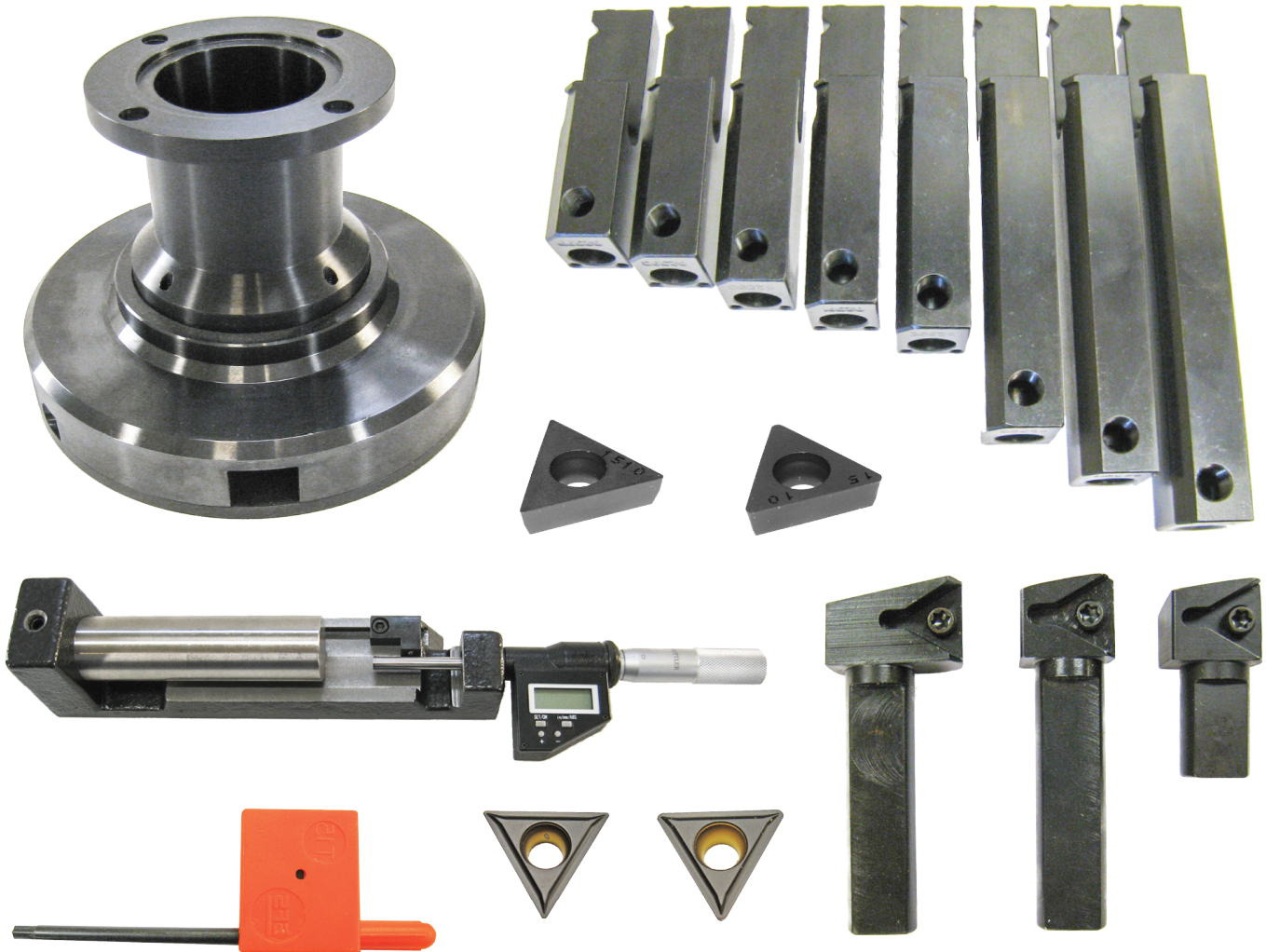
Single Sided

Note: Cutterheads are Not Included With Right Angle Drive and Must be Ordered Separately



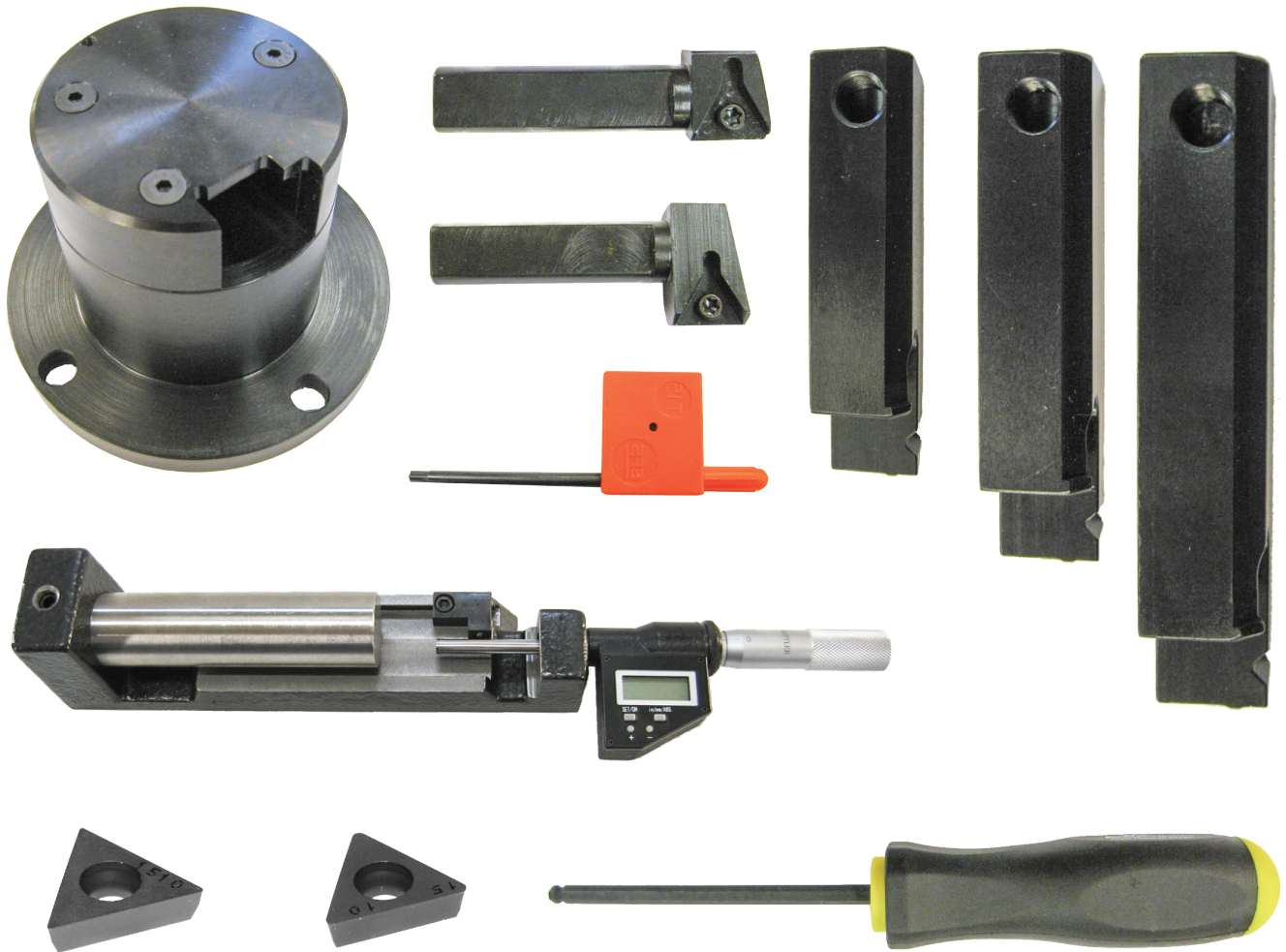
6779A Heavy Duty Line Bore Cutterhead Assembly

8 - 14" (203 - 356mm) Diameter Complete with Tooling and Digital Micrometer



6519V Heavy Duty Line Bore Cutterhead Assembly

6.0 - 8.50" (152.40 - 215.90mm) Diameter X 3" (76mm) Length Complete with Tooling and Digital Micrometer. Minimum Distance Between Bearing Housings 7.94" (102mm)



6519P Heavy Duty Line Bore Cutterhead Assembly

6.0 - 8.50" (152.40-215.90mm) Diameter X 4.25" (108mm) Length Complete with Tooling and Digital Micrometer. Minimum Distance Between Bearing Housings 8.94" (227mm)



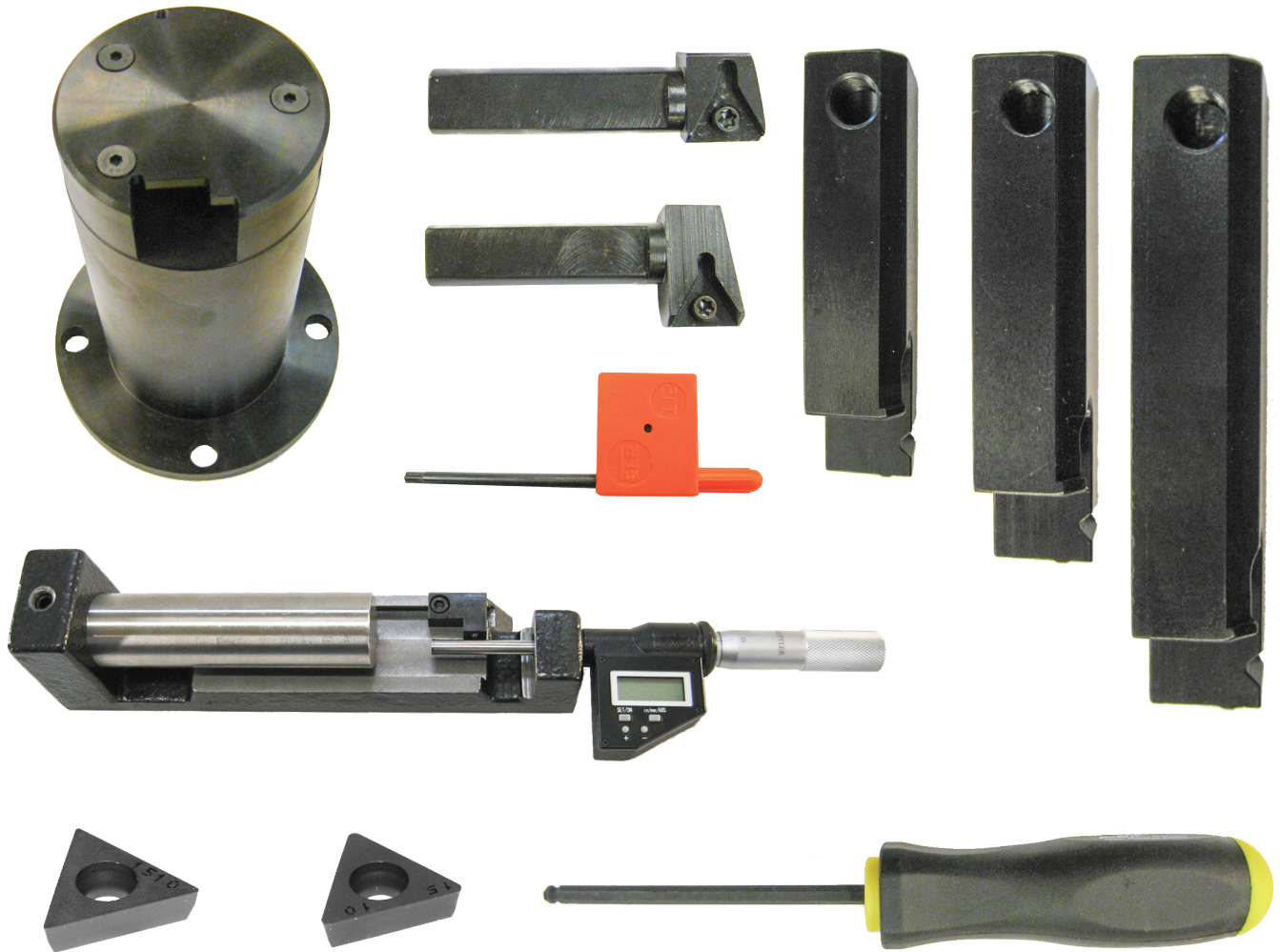
6519M Heavy Duty Line Bore Cutterhead Assembly

6.0 - 8.50" (152.40 - 215.90mm) Diameter X 5.10" (130mm) Length Complete with Tooling and Digital Micrometer.
Minimum Distance Between Bearing Housings 10.04" (255mm)



6519N Heavy Duty Line Bore Cutterhead Assembly

6.0 - 8.50" (152.40 - 215.90mm) Diameter X 6.0" (152mm) Length Complete with Tooling and Digital Micrometer. Minimum Distance Between Bearing Housings 10.94" (278mm)

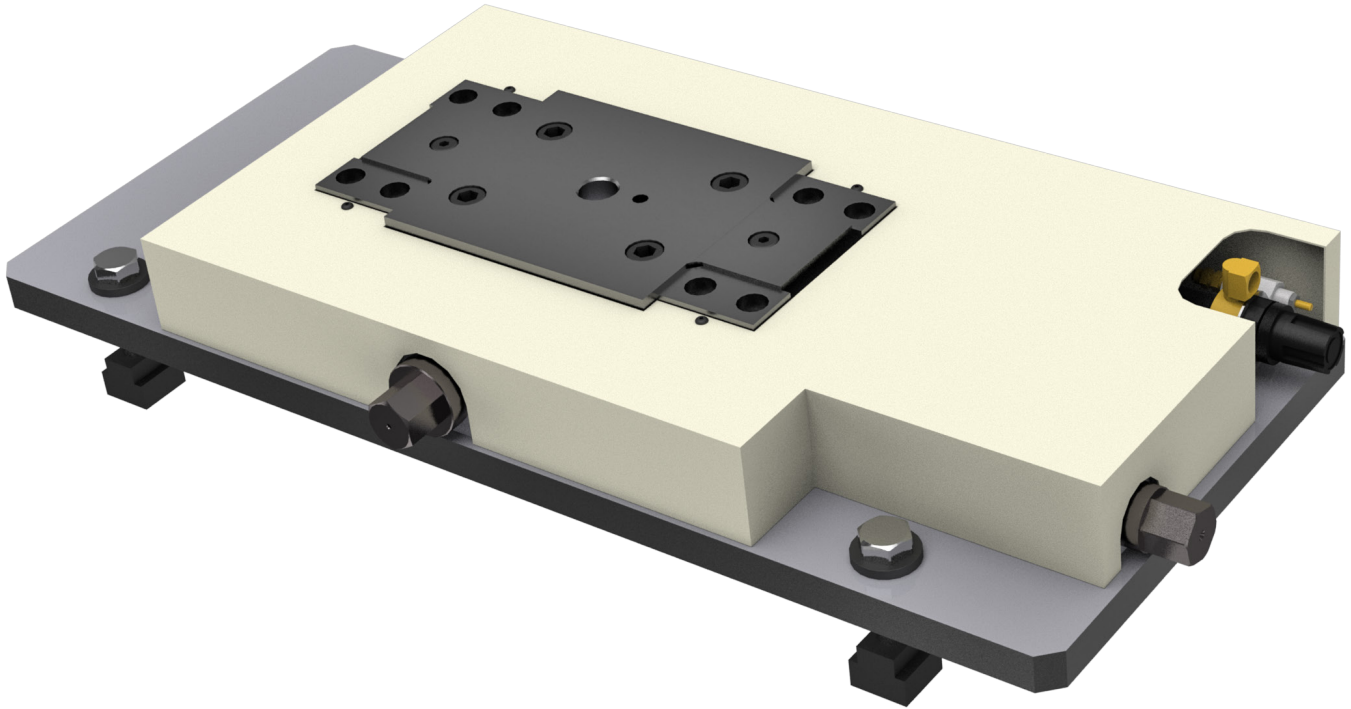


Line Bore Fixturing for Extra Large Blocks

Such as CAT 3600, Waukesha AT, Locomotive EMD and GE Frames, MTU 1163 & 8000

10200 Adjustable Universal Line Boring Fixture

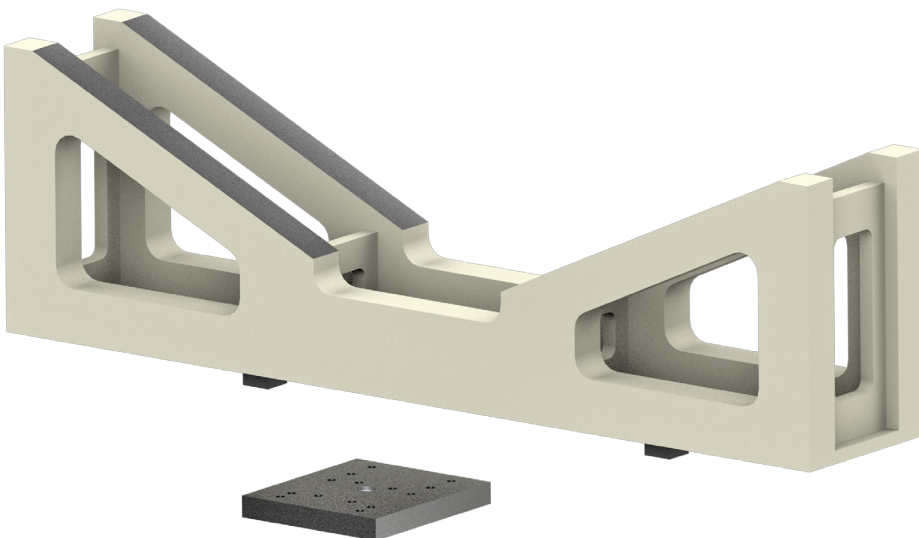
Adapter Package and Support Cradle must be Ordered Separately.



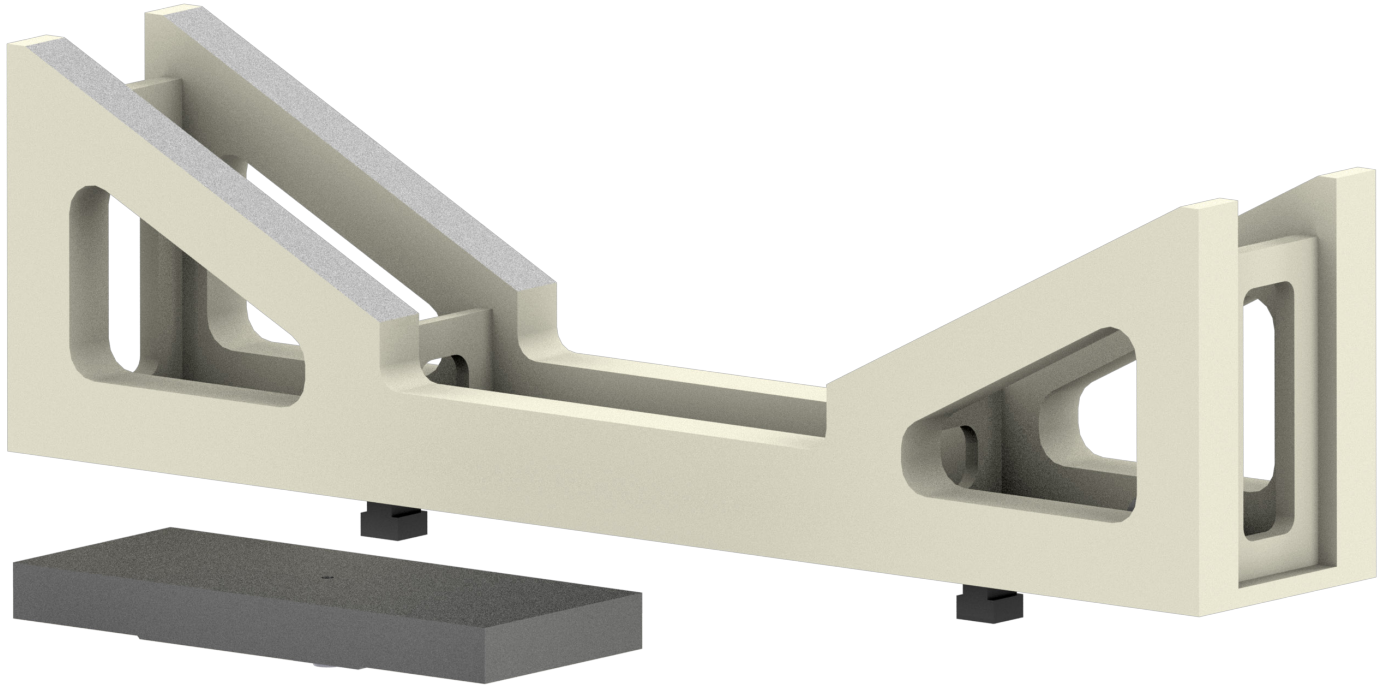
10200 Boring Fixture Adaptor Packages

Note: 10200 series fixture packages fit only the 10200 Line Boring Fixture

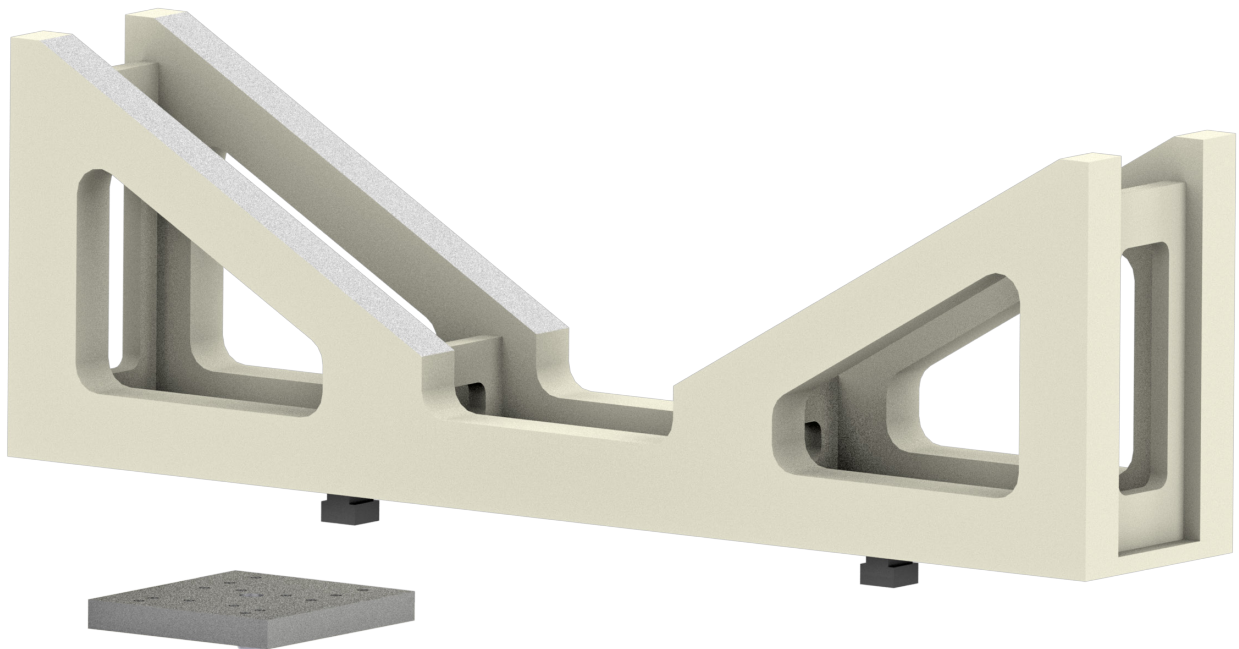
10201 Adapter Package and Support Cradle for CAT 3600 V blocks



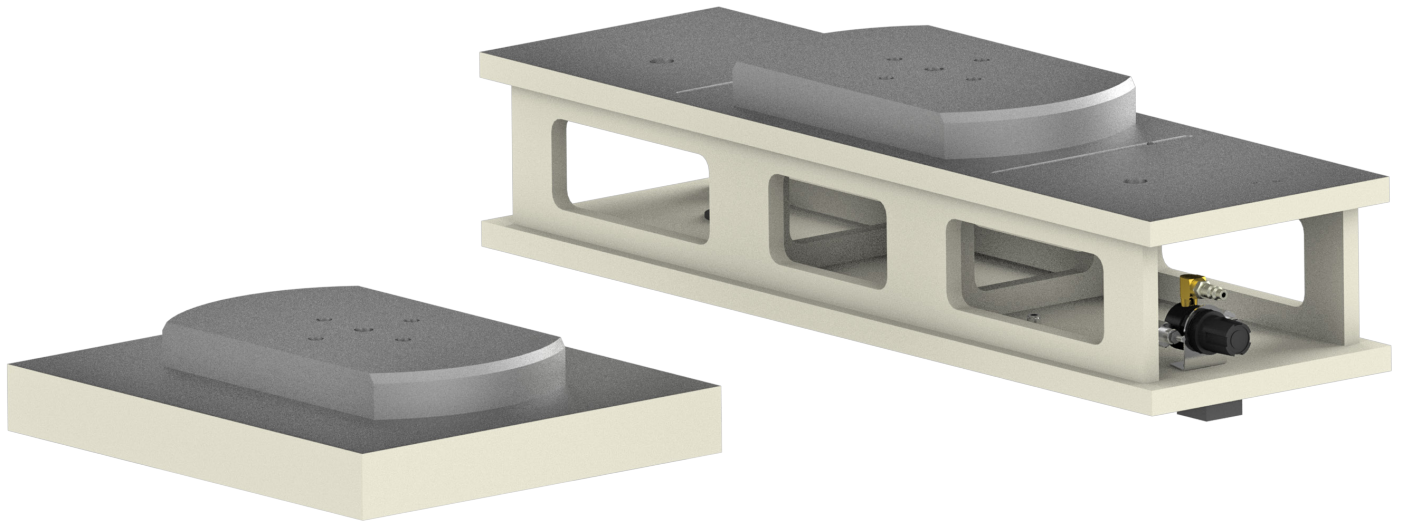
10202 Adapter Package and Support Cradle for Waukesha AT V Blocks



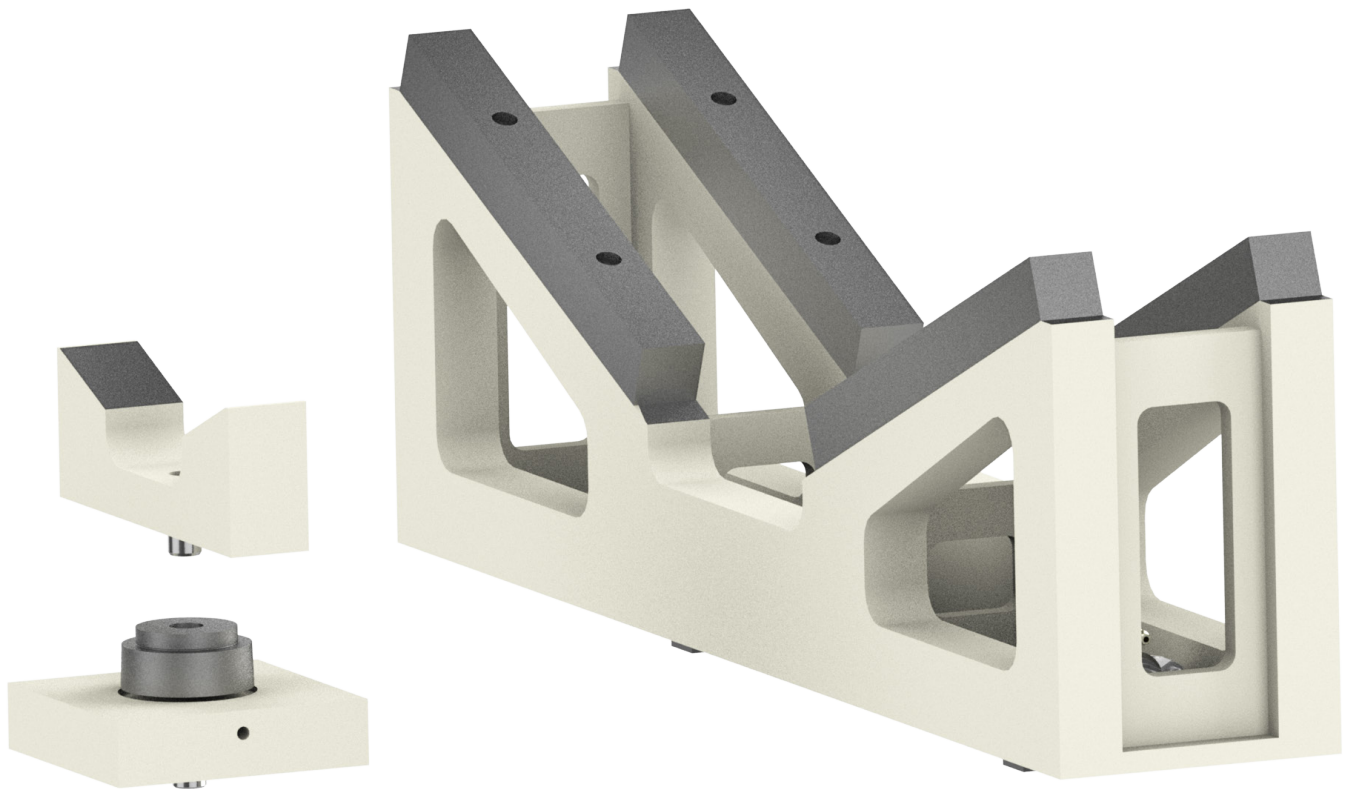
10203 Adapter Package and Support Cradle for Superior 2400 V Blocks



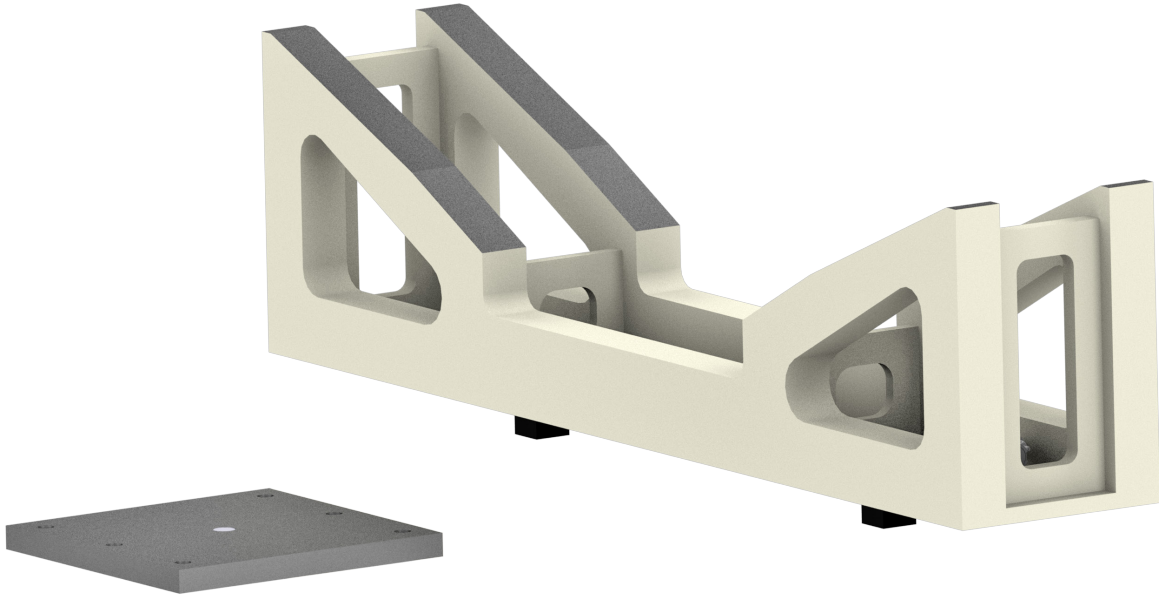
10204 Adapter Package for CAT 3600 In-Line Blocks



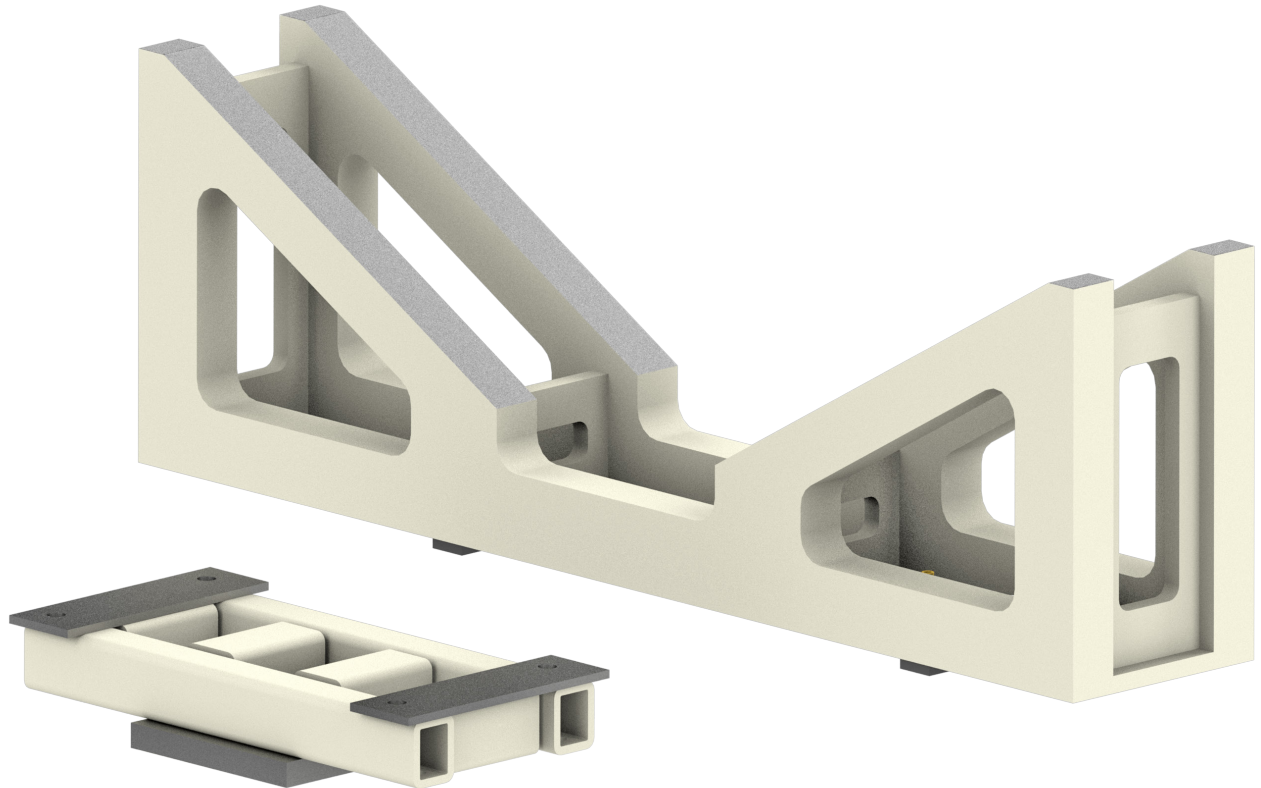
10205 Adapter Package and Support Cradle for GE EVO V Blocks



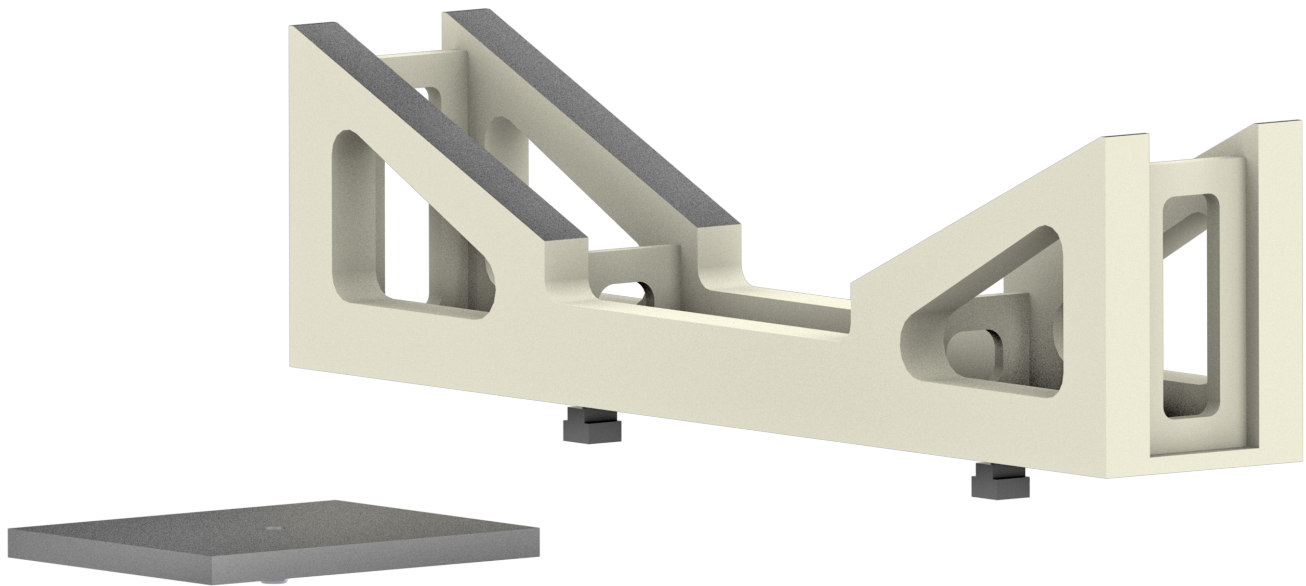
10206 Adapter Package and Support Cradle for EMD 645 & 710 V Blocks



10207 Adapter Package and Support Cradle for MTU 1163 V Blocks



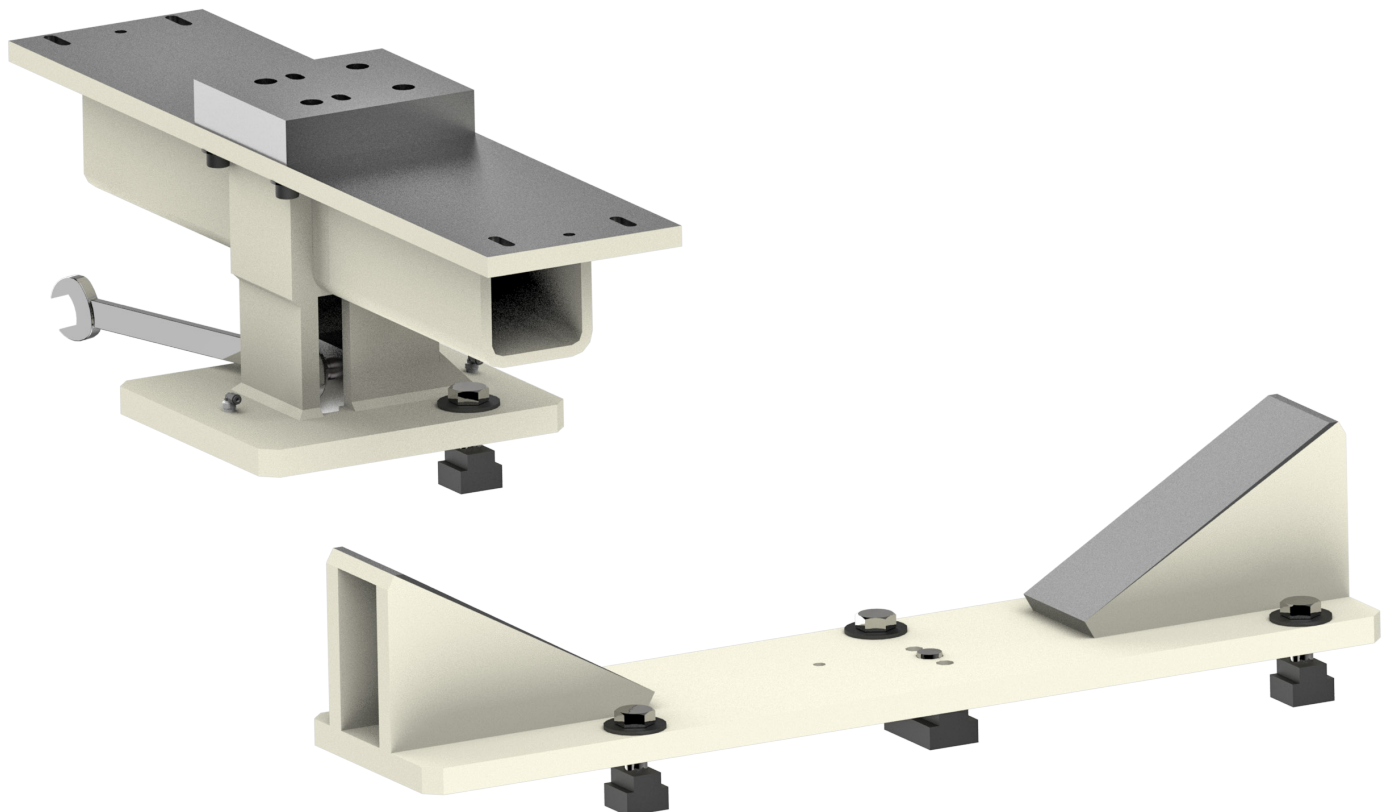
10208 Adapter Package and Support Cradle for MTU 8000 V Blocks



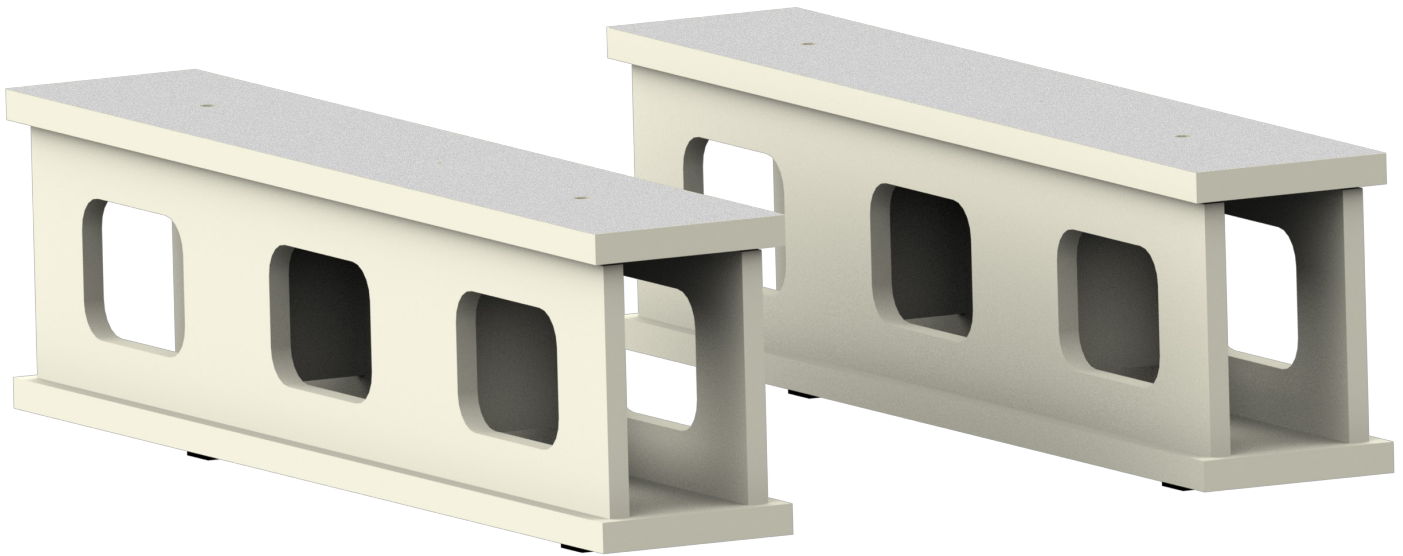
Line Bore Fixturing for Large Blocks

Such as Waukesha 7042, 9390 and White Superior 825 - Requires Parallels 10355

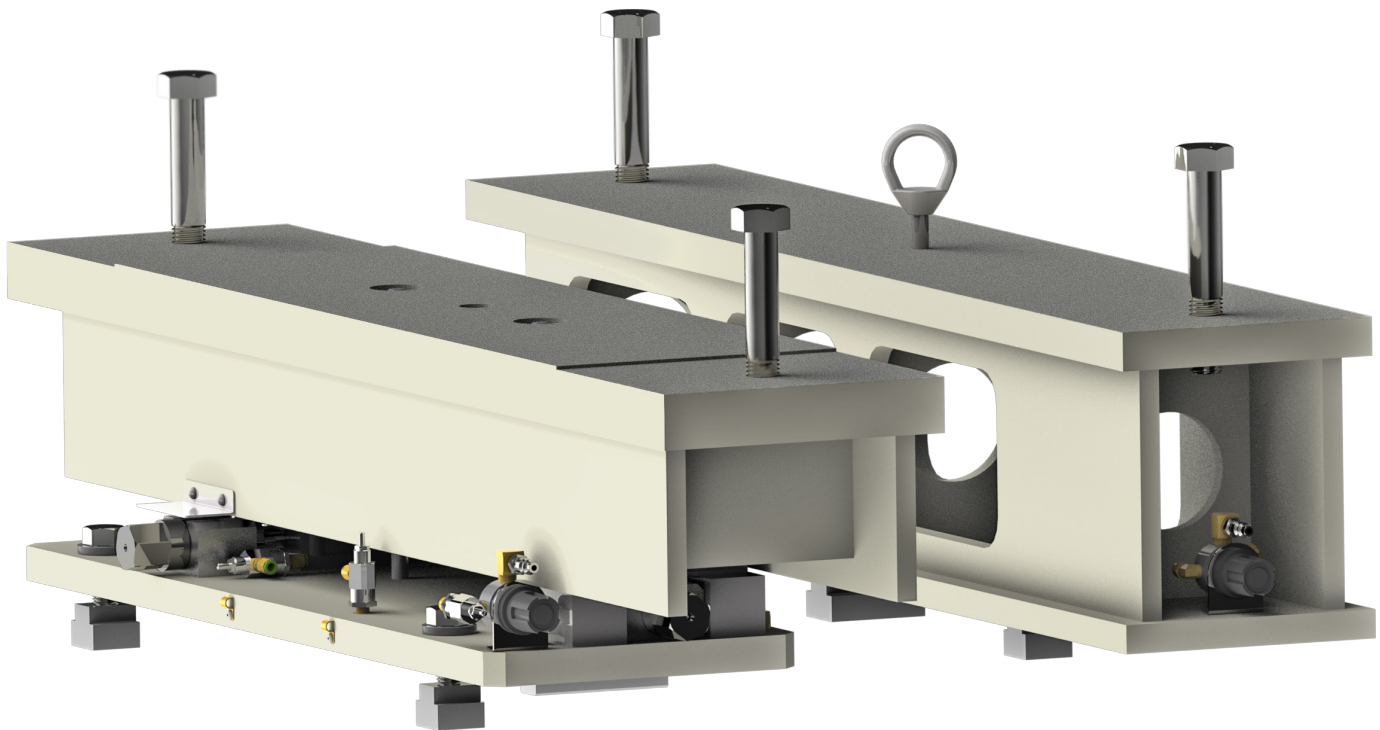
6810 Waukesha 7042, 9390 and CAT 379, 398, 399 Line Boring Fixture



6815 White Superior 8G825 Line Boring Fixture - Requires Fixture 6821



6846 White Superior 12 & 16 G825 Line Boring Fixture - Requires Fixture 6821



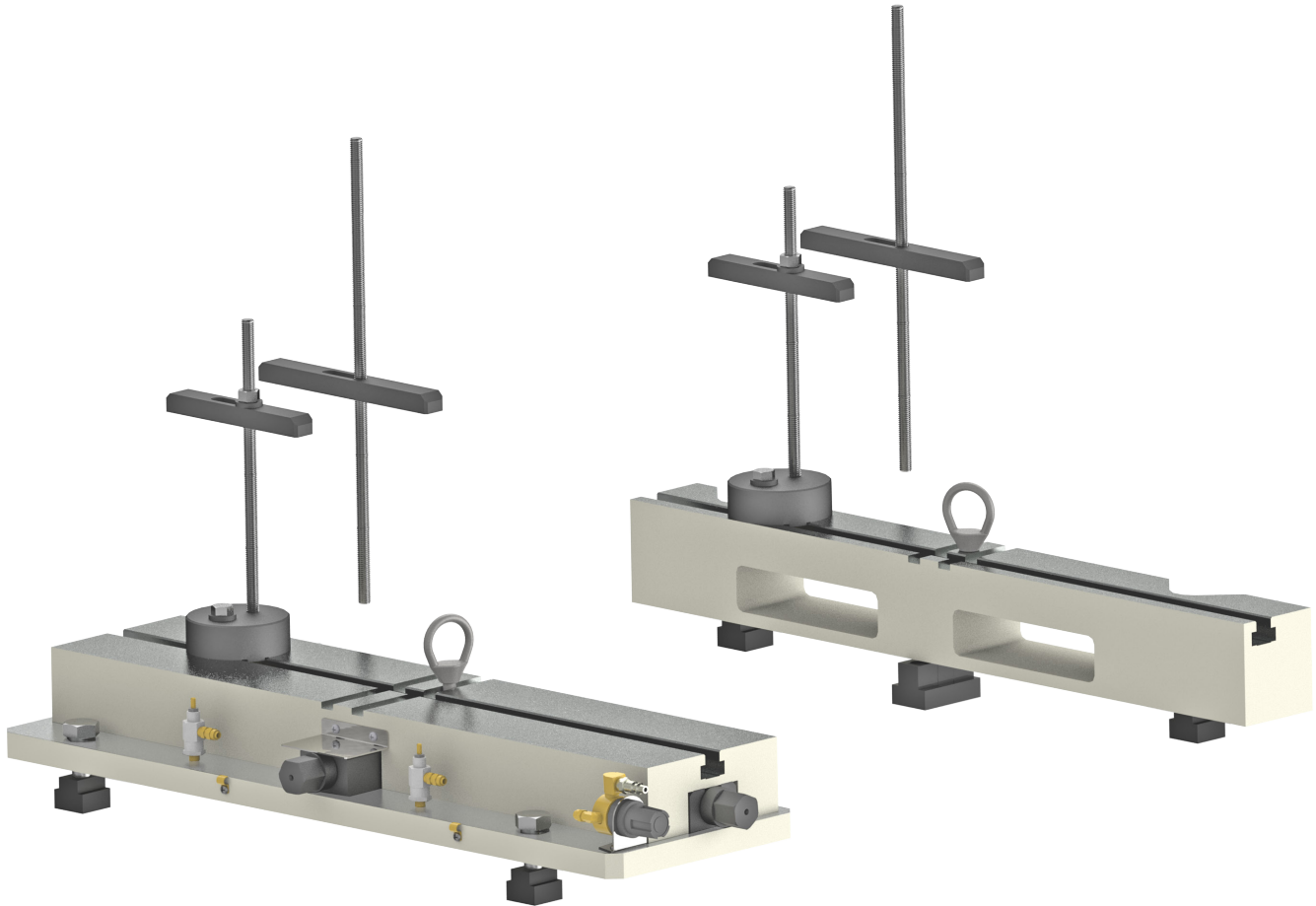
Line Bore Fixturing for Large Blocks

Such as CAT 3500, MTU 4000, Cummins QSK

6821 Adjustable Universal Line Boring Parallel Assembly

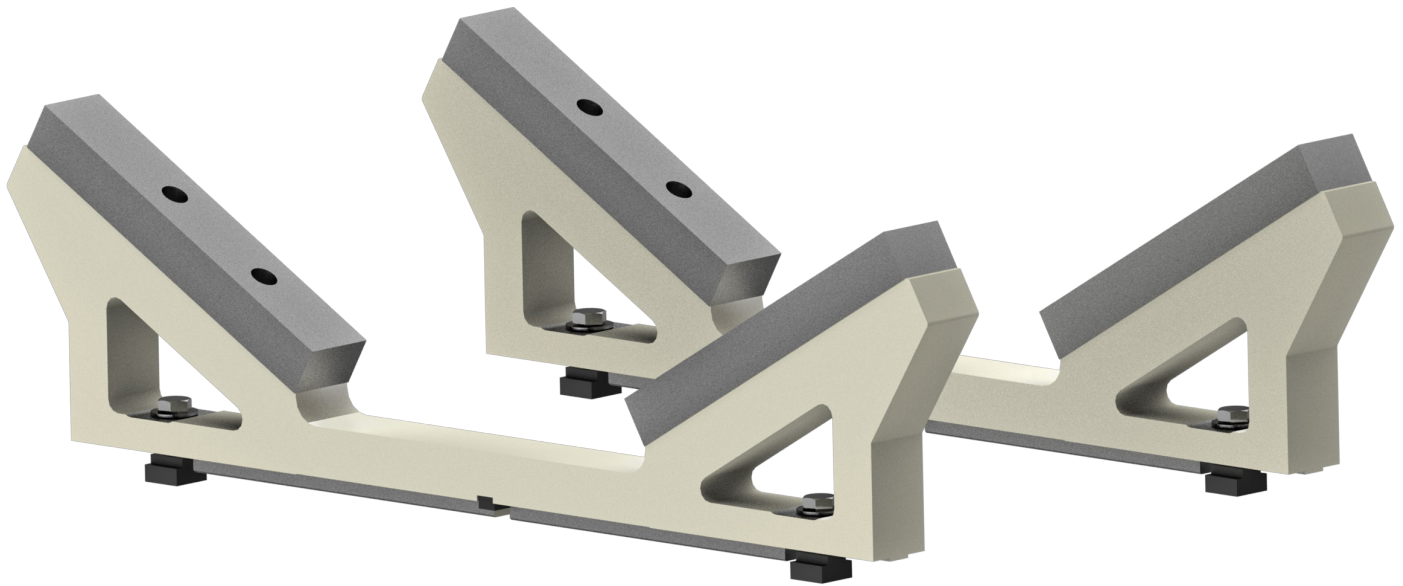
Includes Locators for Mid Range In-Line Blocks.

Supports for V Blocks Must Be Ordered Separately.



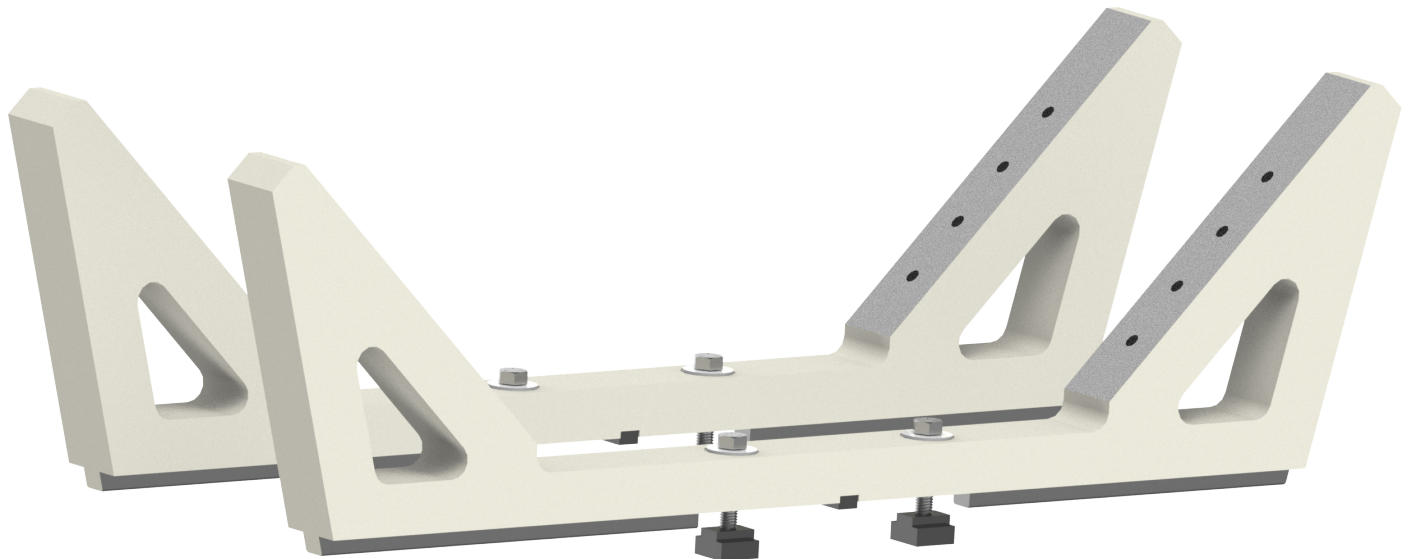
6823B 120 Degree V Block Supports for Large 120 Degree V Blocks

Such as CAT 3500, Komatsu 170 for use on Adjustable Parallels 6821



6823E 90 Degree V Block Supports for Large 90 Degree V Blocks

Such as MTU4000 for use on Adjustable Parallels 6821



Line Bore Tooling for Small to Large Blocks and Heads

10133 Straight 90 Degree Right Angle Drive Assembly

For Medium to Large Blocks. Includes a .41" (10.41mm), .700" (17.78mm), 1.05" (25.725mm), 1.215" (30.86mm) and 1.50" (38.10mm) spacer

Note: Cutterheads are Not Included with Right Angle Drive and Must be Ordered Separately

A large rectangular box with a thick black border, containing the text "Image Currently Unavailable" in a bold, black, sans-serif font.

Image Currently Unavailable

650-2-39B Cutterhead Assembly Line Boring

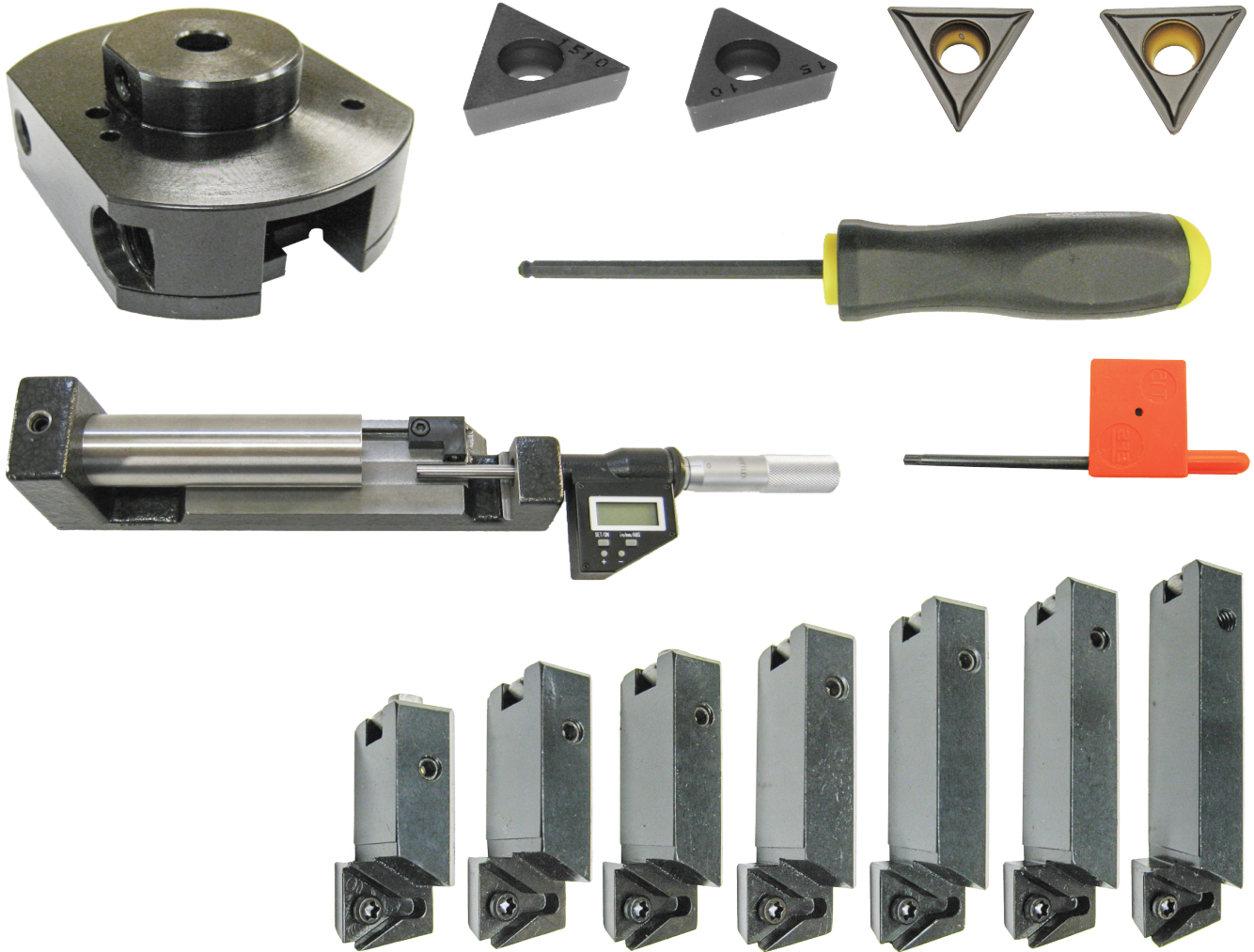
1.9 - 4.0" (48.26 - 101.60mm) diameter complete with tooling and Digital Micrometer (When used with 6753J Drive, minimum distance between bearing housings 3.29") (83.6mm)



650-2-39C Cutterhead Assembly Line Boring

2.9 - 5.6" (73.66 - 142.24mm) diameter complete with tooling and Digital Micrometer. When used with 6753J Drive, minimum distance between bearing housings 4.18" (106.2mm)

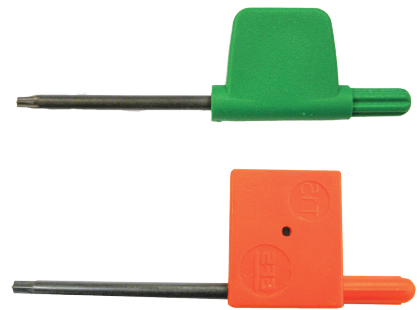
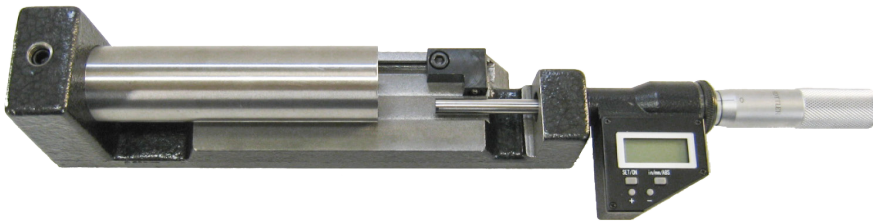
Note: Cutterheads are not included with Right Angle Drive and must be ordered separately



650-2-39A Cutterhead Assembly Line Boring

5.4 - 8.1" (137 - 206mm) diameter complete with tooling and Digital Micrometer. When used with 6753J Drive, minimum distance between bearing housings 4.19" (106.4mm)

Note: Length of Bores can be Increased with Extension Spacers. The Addition of Extension Spacers will Increase the Minimum Distance Between Bearing Housings by the Length of the Spacer. Allow for Some Clearance Either Side of the Assembly for Safety



B C D E F G H

Line Bore Fixturing for Small to Large Blocks and Heads

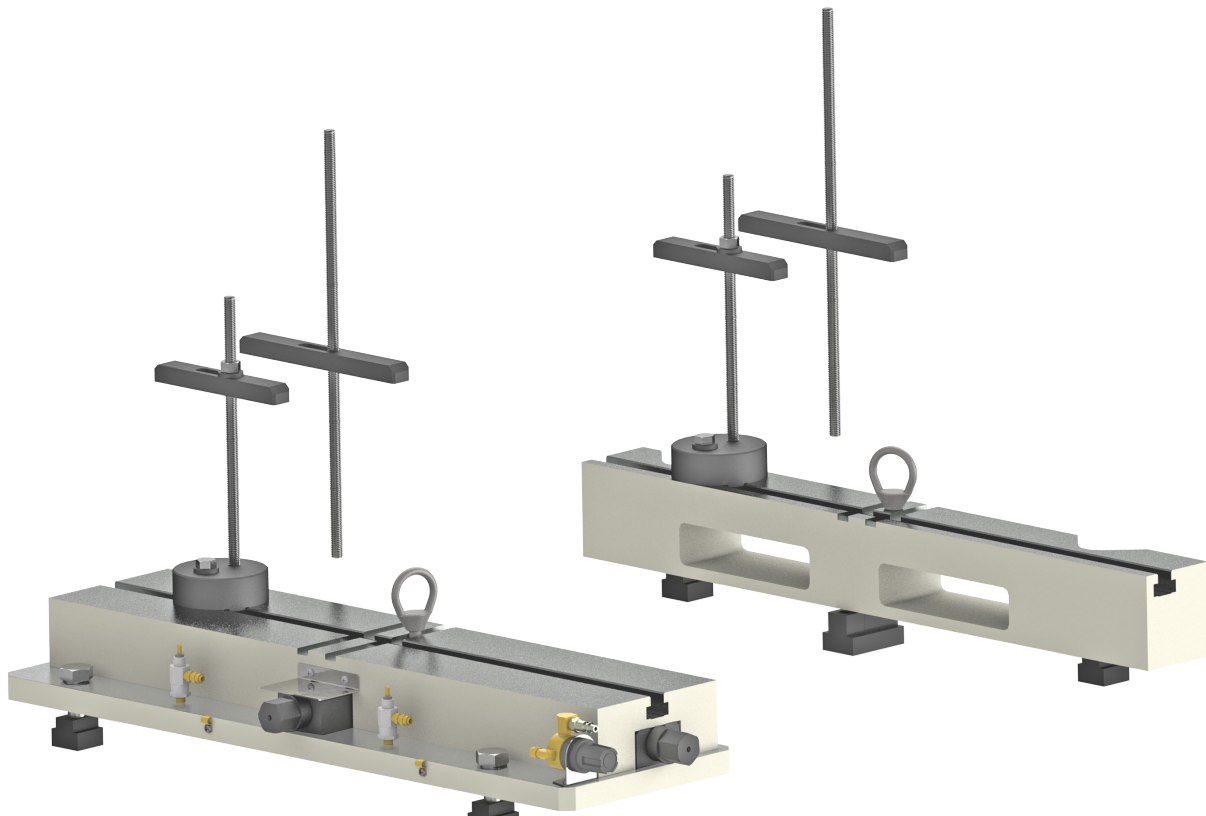
650-3-56 Line Bore Pivot Table Fixture

Complete with Universal Work Holding System for Small In Line and 90 Degree V Blocks, Includes 6843 90 Degree V Block Supports. Also Used for Setting Up Cylinder Heads Such as CAT3406E and Detroit 50/60 Series for Camshaft Line Boring.



6821 Adjustable Universal Line Boring Fixture Assembly

Includes Locators for In-Line Blocks, Supports for V Blocks Must Be Ordered Separately, Listed Below.



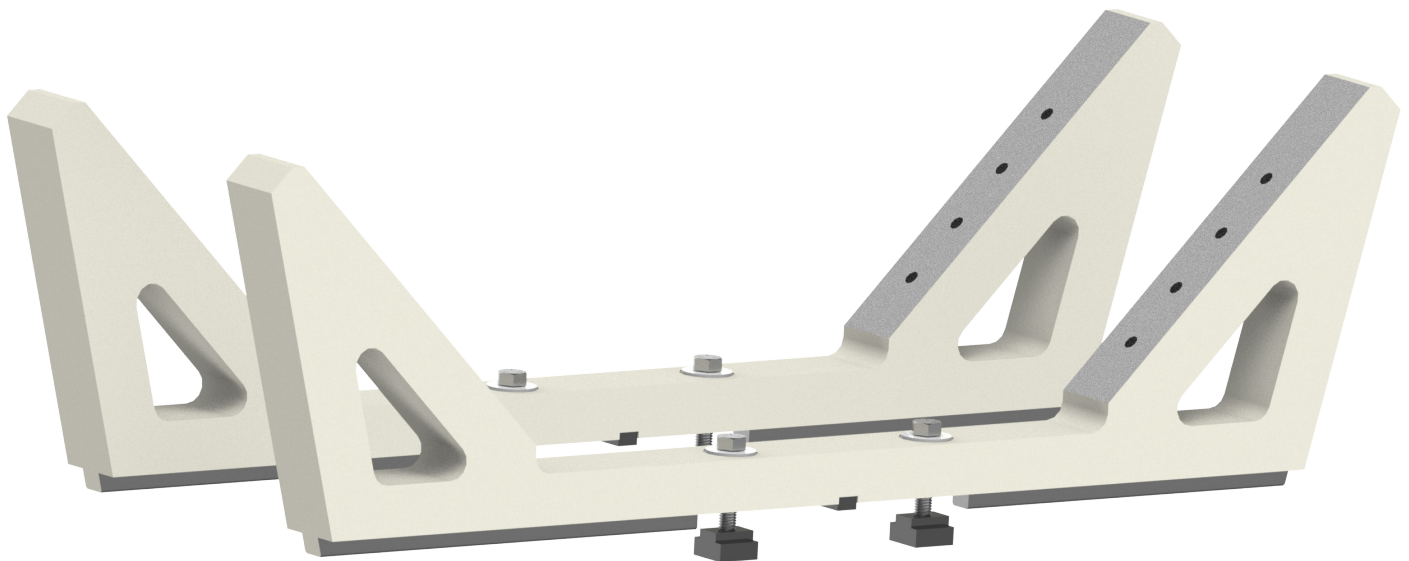
6843 90 Degree V Block Supports

For Small To Mid-Size 90 Degree V Blocks for use on Line Bore Fixtures 6821 and 11113



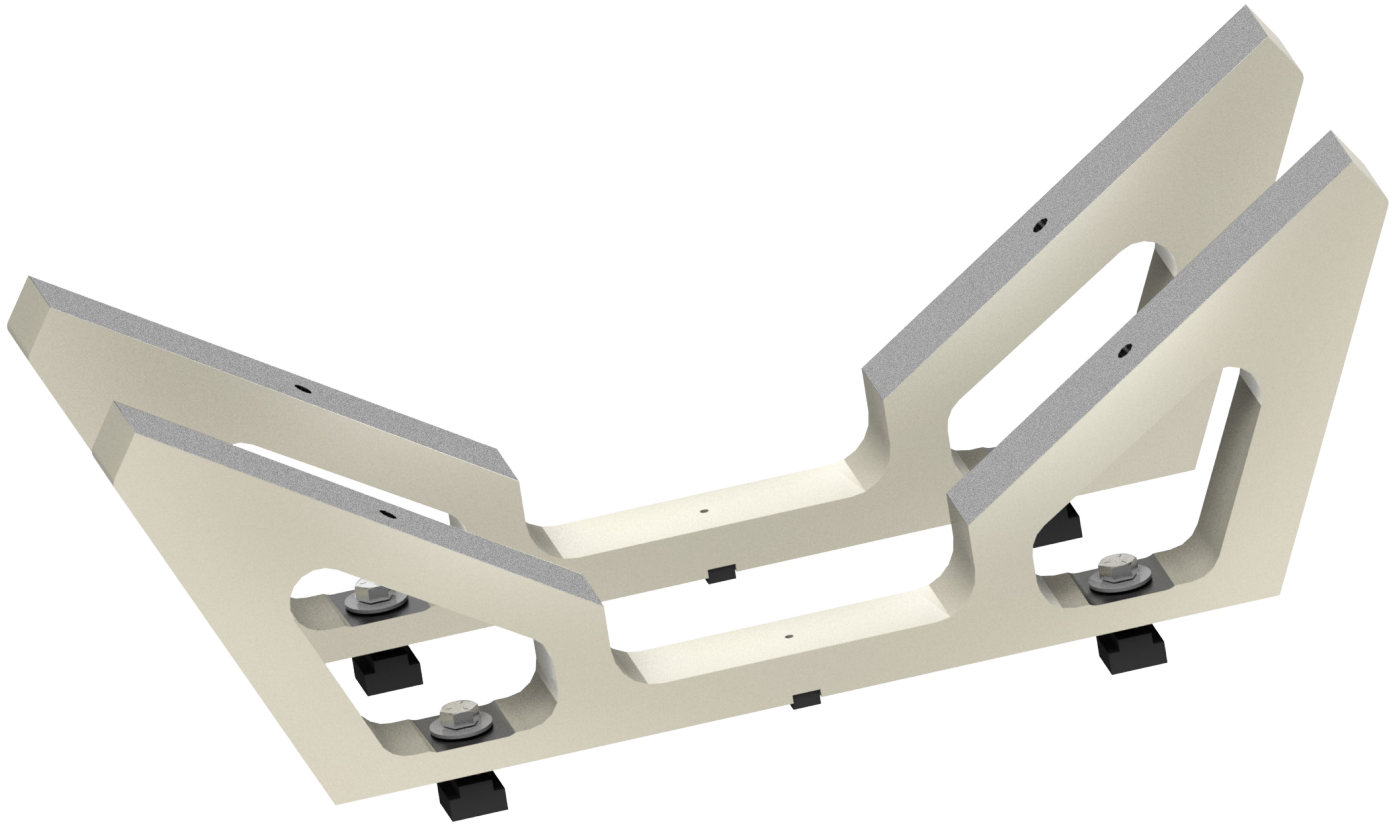
6823E 90 Degree V Block Supports

For Large 90 Degree V Blocks Such as MTU4000 for use on Line Bore Fixture 6821



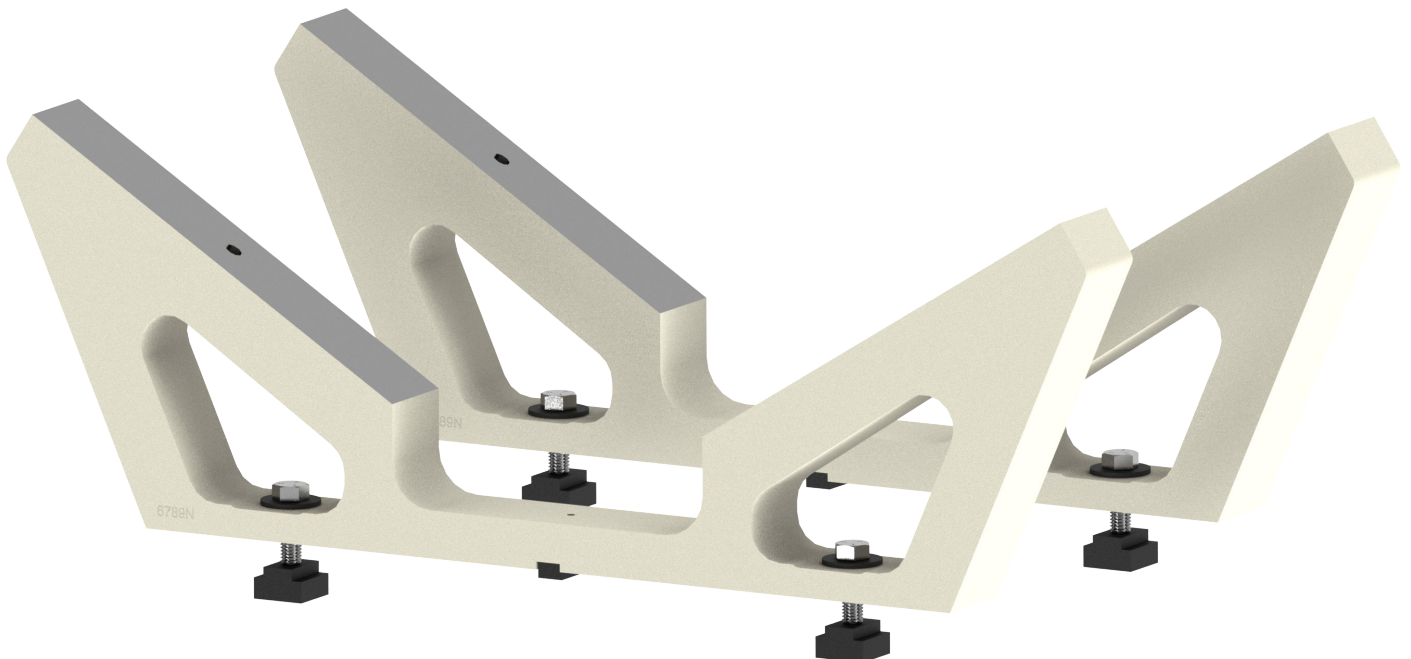
6789L 113 Degree V Block Supports

For Detroit Diesel V53 for use on Line Bore Fixture 6821 and 11113



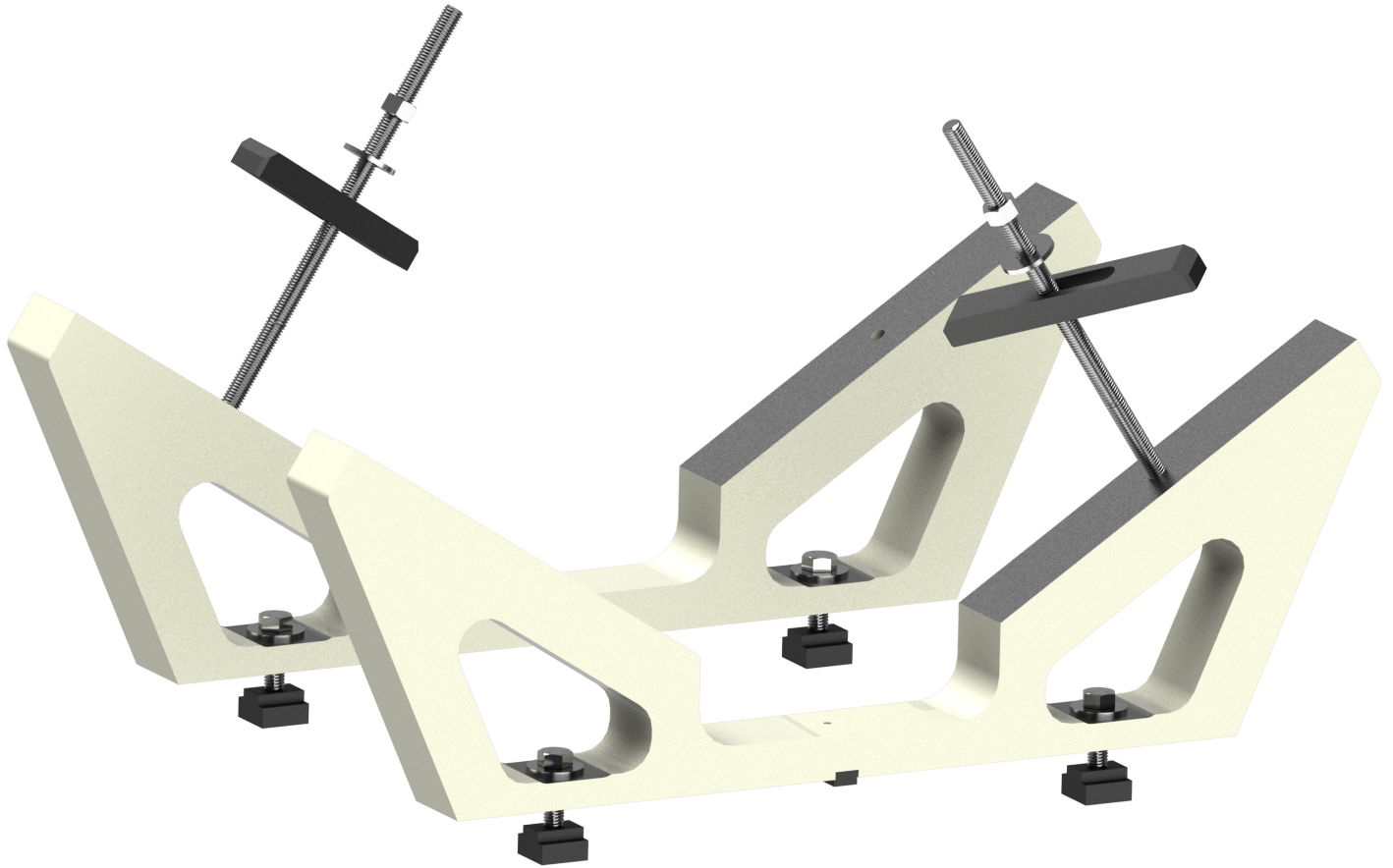
6789N 116 Degree V Block Supports

For Detroit Diesel V71 & V92 for use on Line Bore Fixture 6821 and 11113



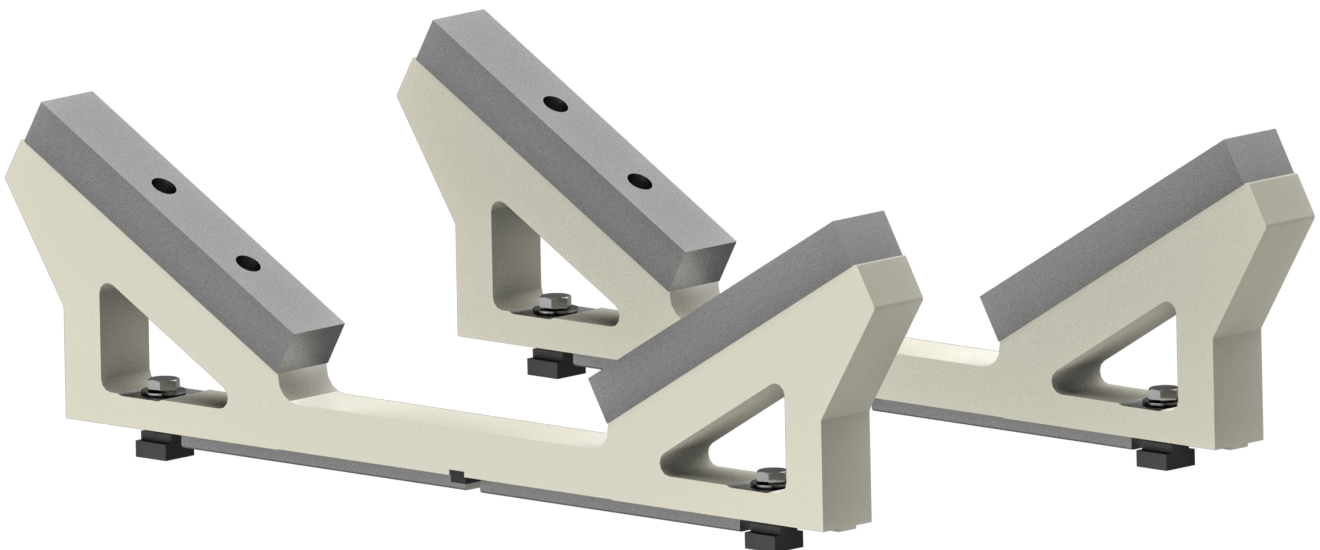
6789E 115 Degree V Block Supports

For CAT 3400 for use on Line Bore Fixture 6821 and 11113



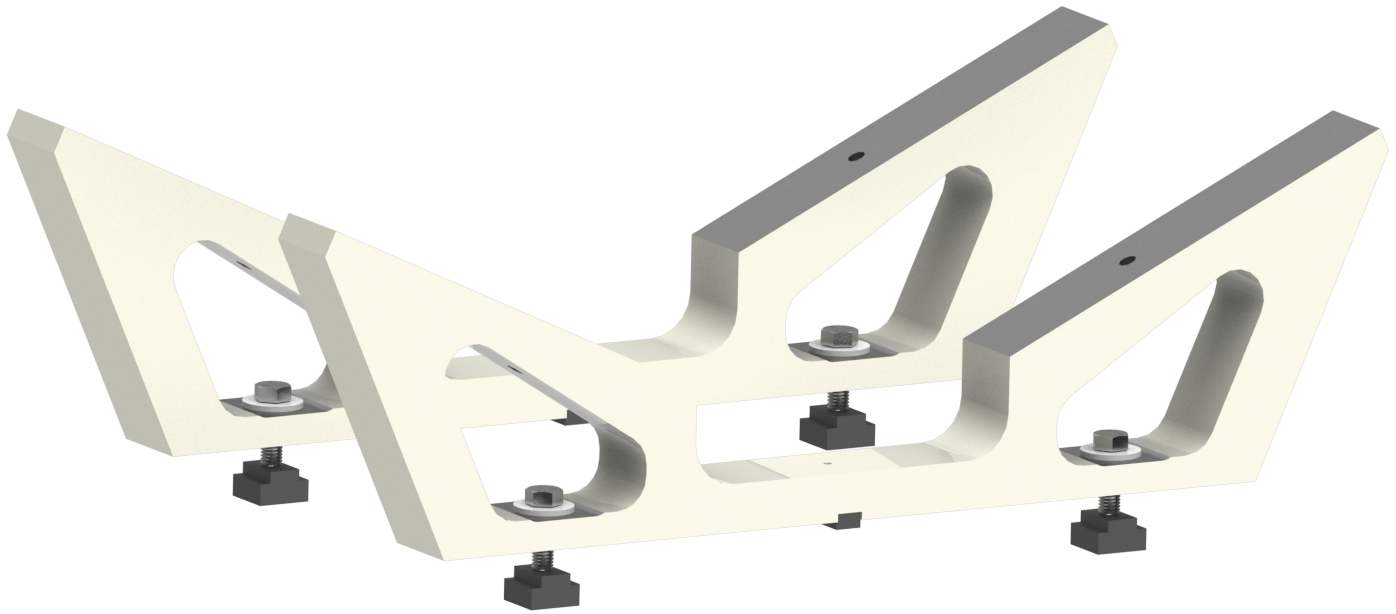
6823B 120 Degree V Block Supports

For Large 120 Degree V Blocks such as CAT 3500, Cummins K & QSK, Komatsu 170 for use on Line Bore Fixture 6821



6789K 130 Degree V Block Supports

For Komatsu 140 for use on Line Bore Fixture 6821



6789Q 140 Degree V Block Supports

For Cummins 1710 for use on Line Bore Fixture 6821



Line Bore Set Up and Alignment Equipment

6889B Adapter

Including Radio Probe and Stylus to check main line alignment , requires Software Package 10200A and Radio Probe 650-3-59X.
 Note: Main Line probing is only available for very large blocks such as EMD and GE locomotives.

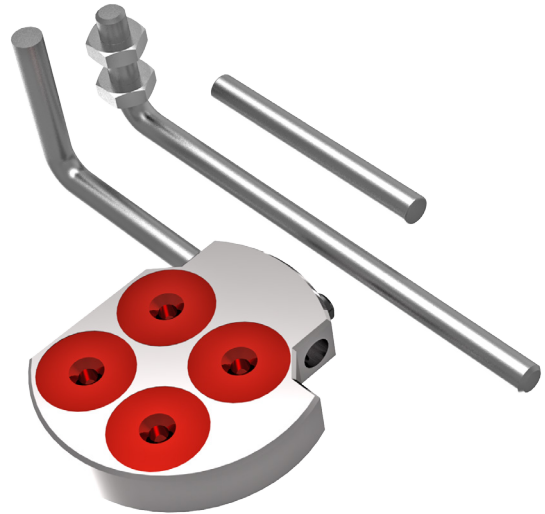


502-12-7B Digital Runout Probe and Readout

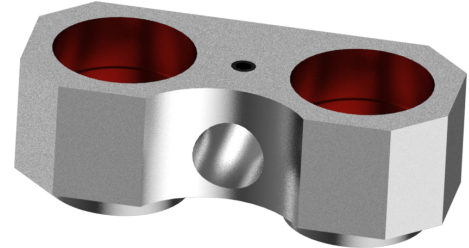
Including Magnetic Holder for Block Set Up and Manual Centering of Cylinder Bores and Main Line Bores



502-12-4 General Purpose Magnetic Indicator Holder
(Requires #502-9-9A or J Indicator)



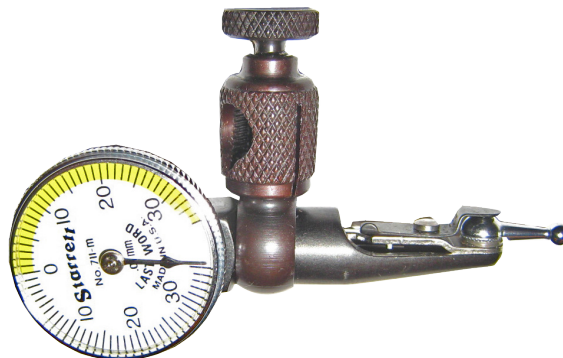
502-12-4A Magnetic Indicator Holder
For 2 - 3" (50 - 75mm) Diameter (Requires 502-9-9A Or J Indicator)



502-9-9A Mechanical Run Out Indicator
General Purpose (.001" Inch Resolution)



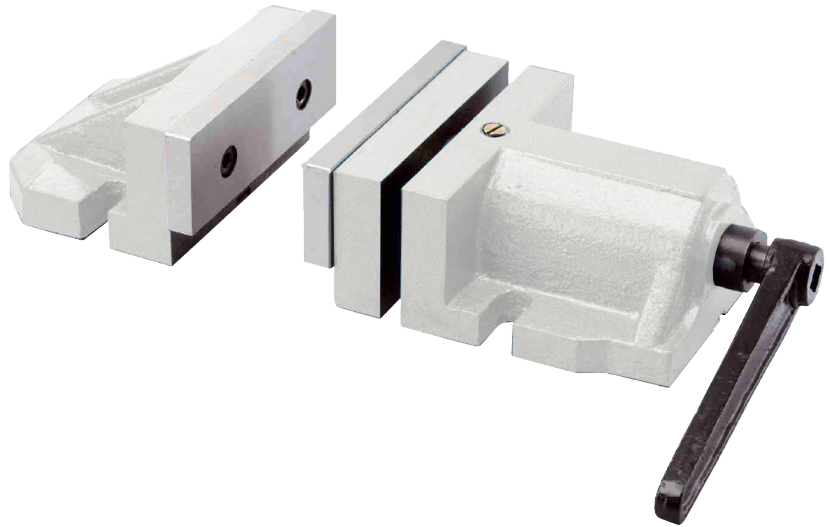
502-9-9J Mechanical Run Out Indicator
General Purpose (.01mm Metric Resolution)



Equipment for Preparing Blocks for Line Boring

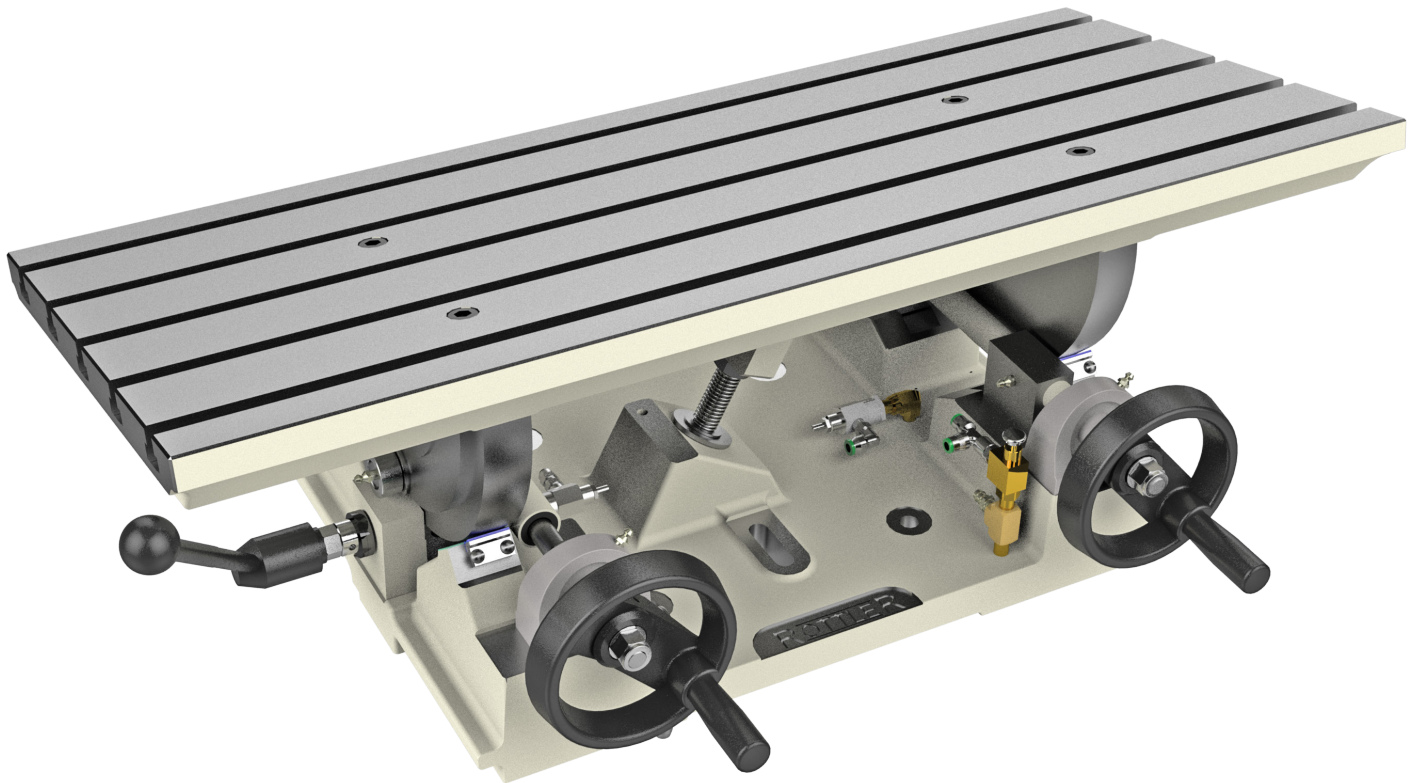
7209N 2-Piece Vise

For Surfacing Main Bearing Housing Caps in Preparation for Main Line Boring. also used for Holding Exhaust Manifolds for Surfacing. Requires 7209M Leveling Table.



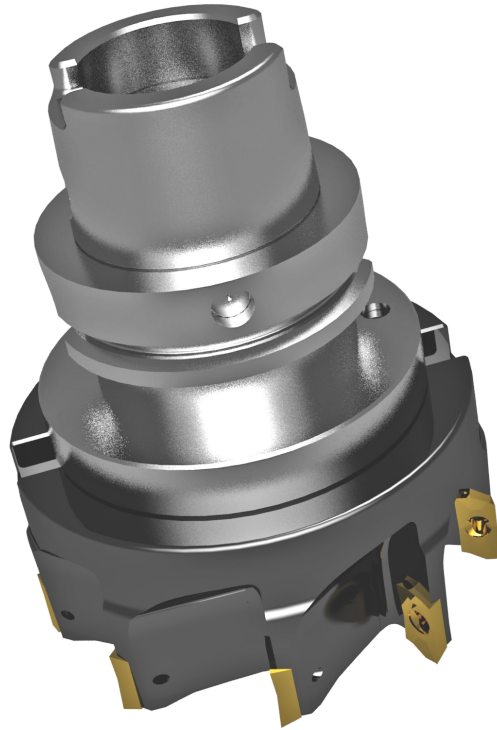
7209M Leveling Table With Air Float

Complete with Universal Work Holding System for Surfacing Cylinder Heads and Manifolds. Requires One Set of 6370C Parallels



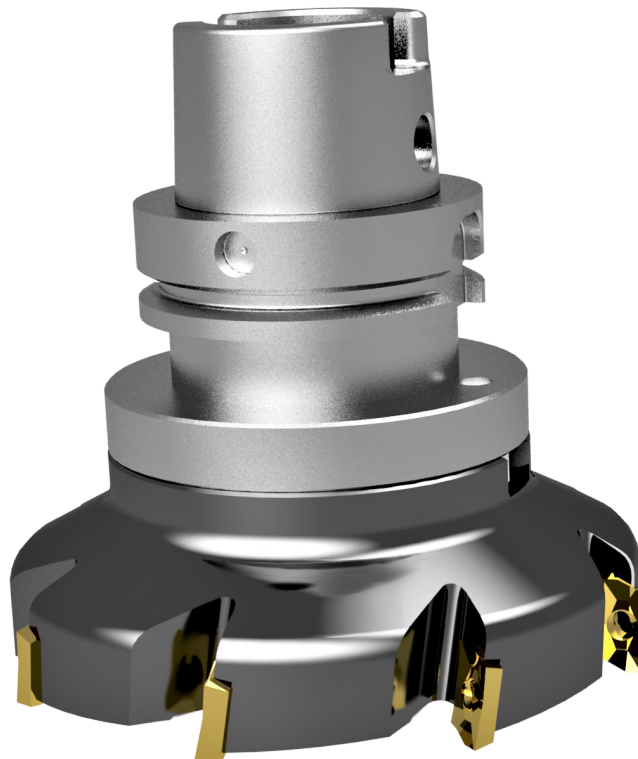
10129 Shell Mill

5" (127mm) Diameter for Surfacing Main Bearing Cap Register Face in Blocks in Preparation for Main Line Boring



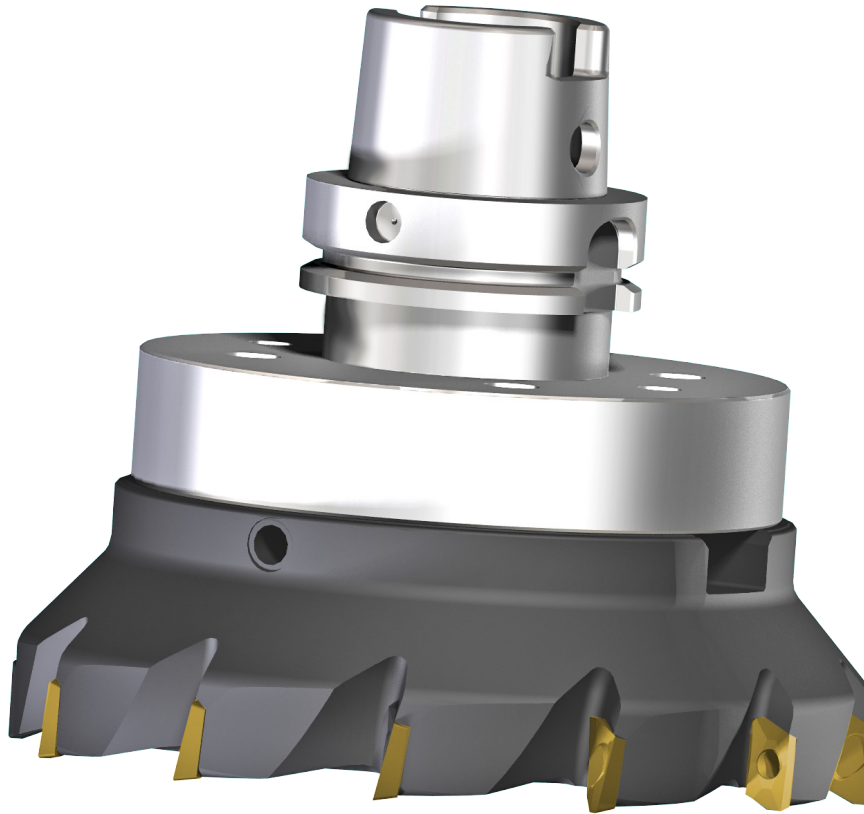
10130 Shell Mill

6" (152mm) Diameter for surfacing main bearing cap register face in blocks in preparation for main line boring



10109C Shell Mill

8" (203mm) Diameter for surfacing main bearing cap register face in blocks in preparation for main line boring



6514T Insert

For 6514L & 6514V Shell Mills, .030" (0.8mm) Corner Radius, different radius available on request



6514Y Insert

For 6514L, 6514V & 6514W Shell Mills, .125" (3.2mm) Corner Radius, different radius available on request



Equipment for Facing Thrust Bearing Surfaces for Main Line

6855C Thrust Facing Tooling Package

For main line bore for small to large blocks

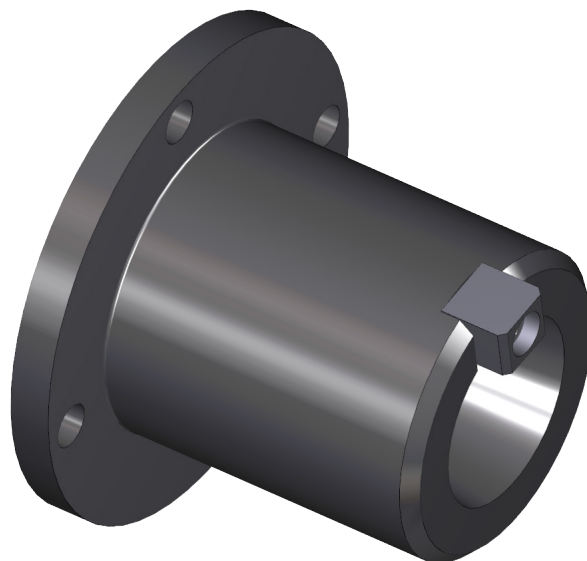


6855G Thrust facing tooling package
For main line bore for extra large blocks



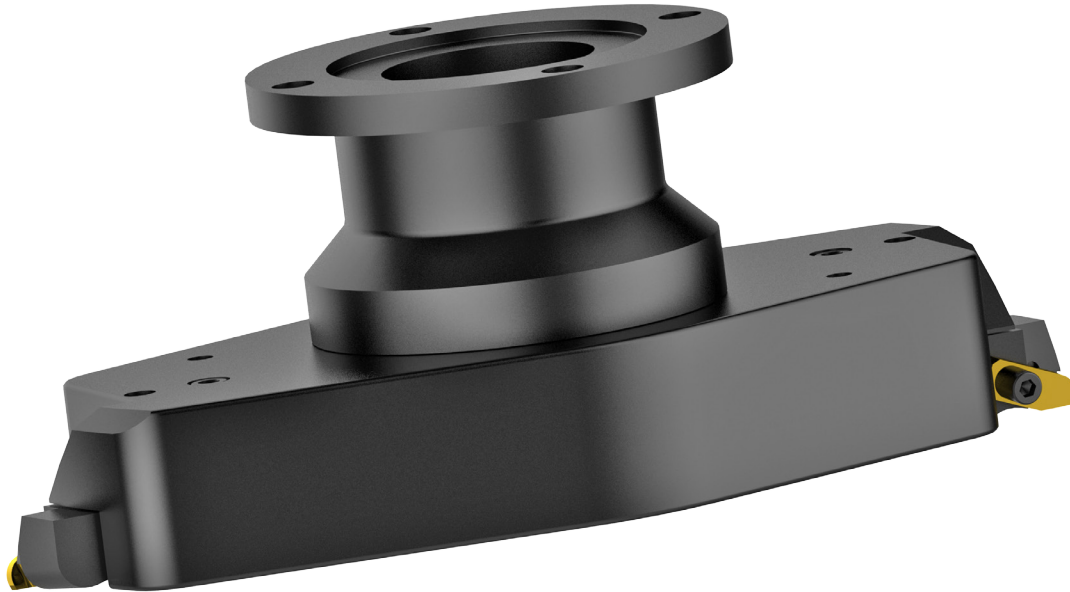
Special Tooling for Block End Machining
Requires Heavy Duty Right Angle Drive 6773F or 6779K

6779H Adaptor for 40 Taper Tooling
Such as 6648K Collet Kit



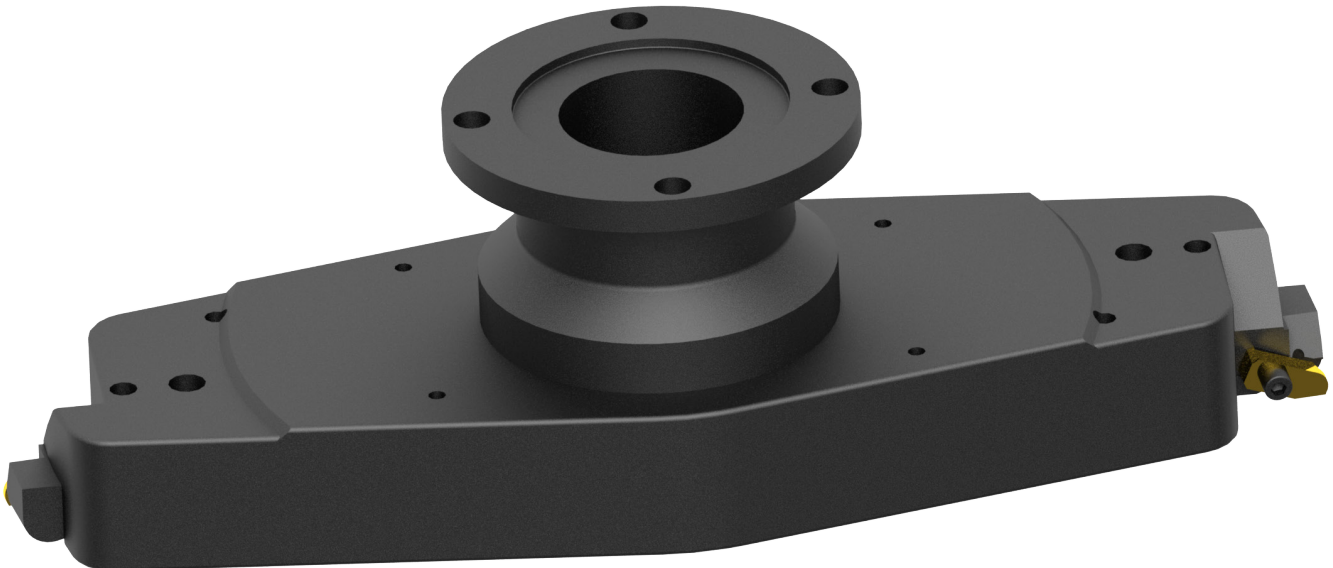
6779L 10" (250mm) Diameter Surfacing Cutterhead Assembly

Complete with Tool holders for .375" (9.52mm) round or square inserts for Block End Surfacing



6779M 14" (360mm) Diameter Surfacing Cutterhead Assembly

Complete with Tool holders for .375" (9.52mm) round or square inserts for Block End Surfacing



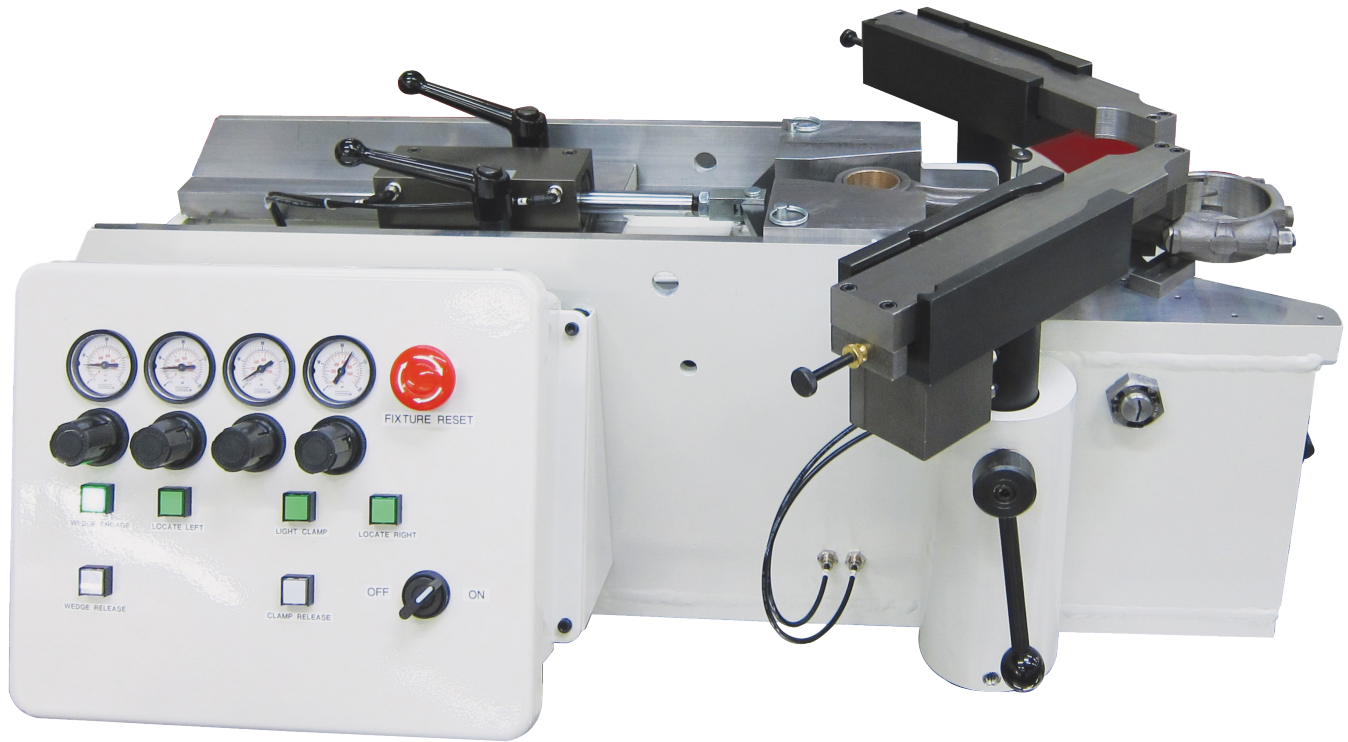
6779N Crossfeed Head Assembly
Heavy Duty Offset 90 degree right angle drive



Connecting Rod Boring and Surfacing Equipment

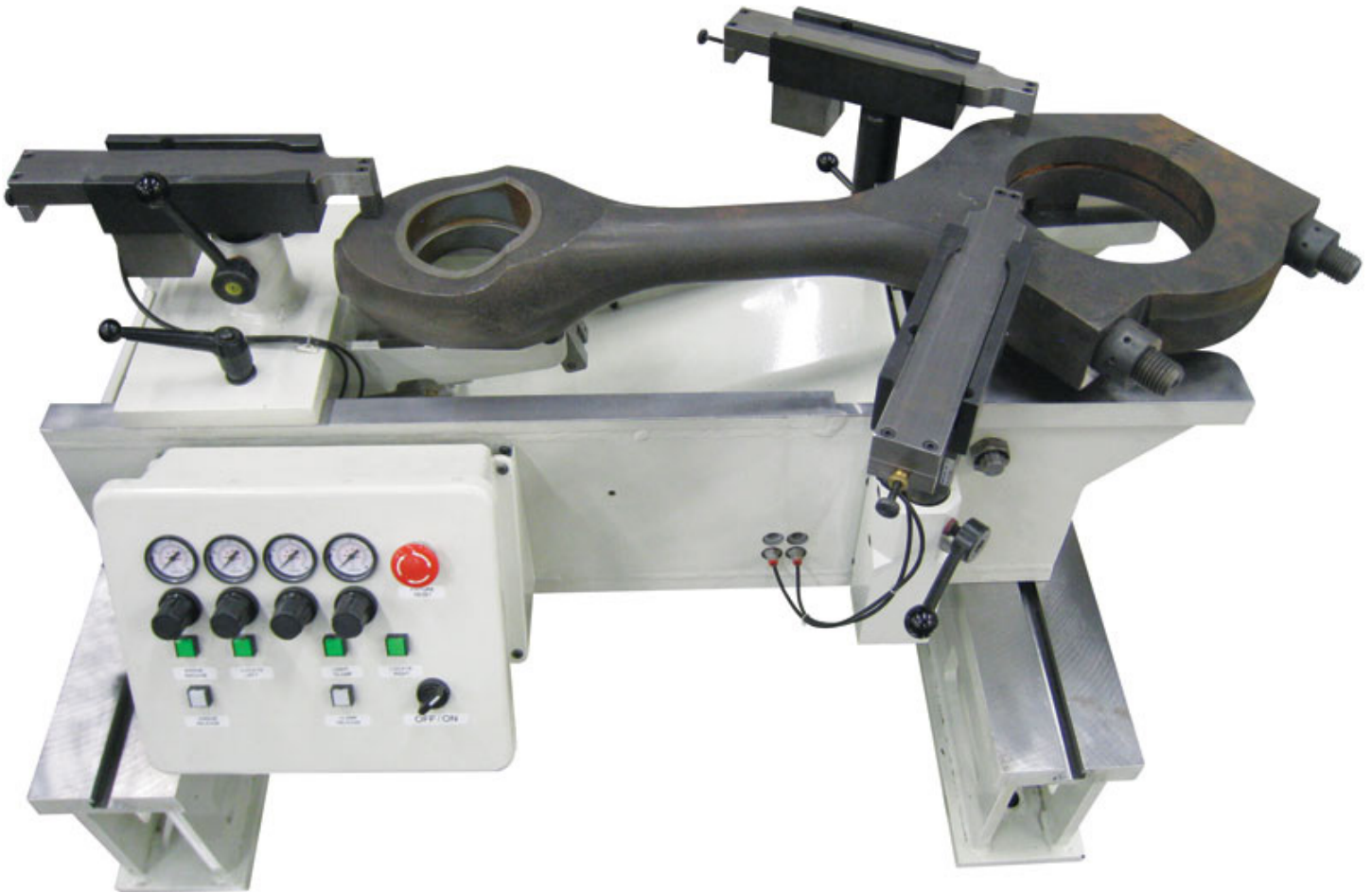
650-3-44R Rottler Precision Connecting Rod Fixturing System

For Connecting Rods Approx 8 - 24" (200 - 600mm) Center to Center Distance - Requires (1) Set of 6370C Parallels

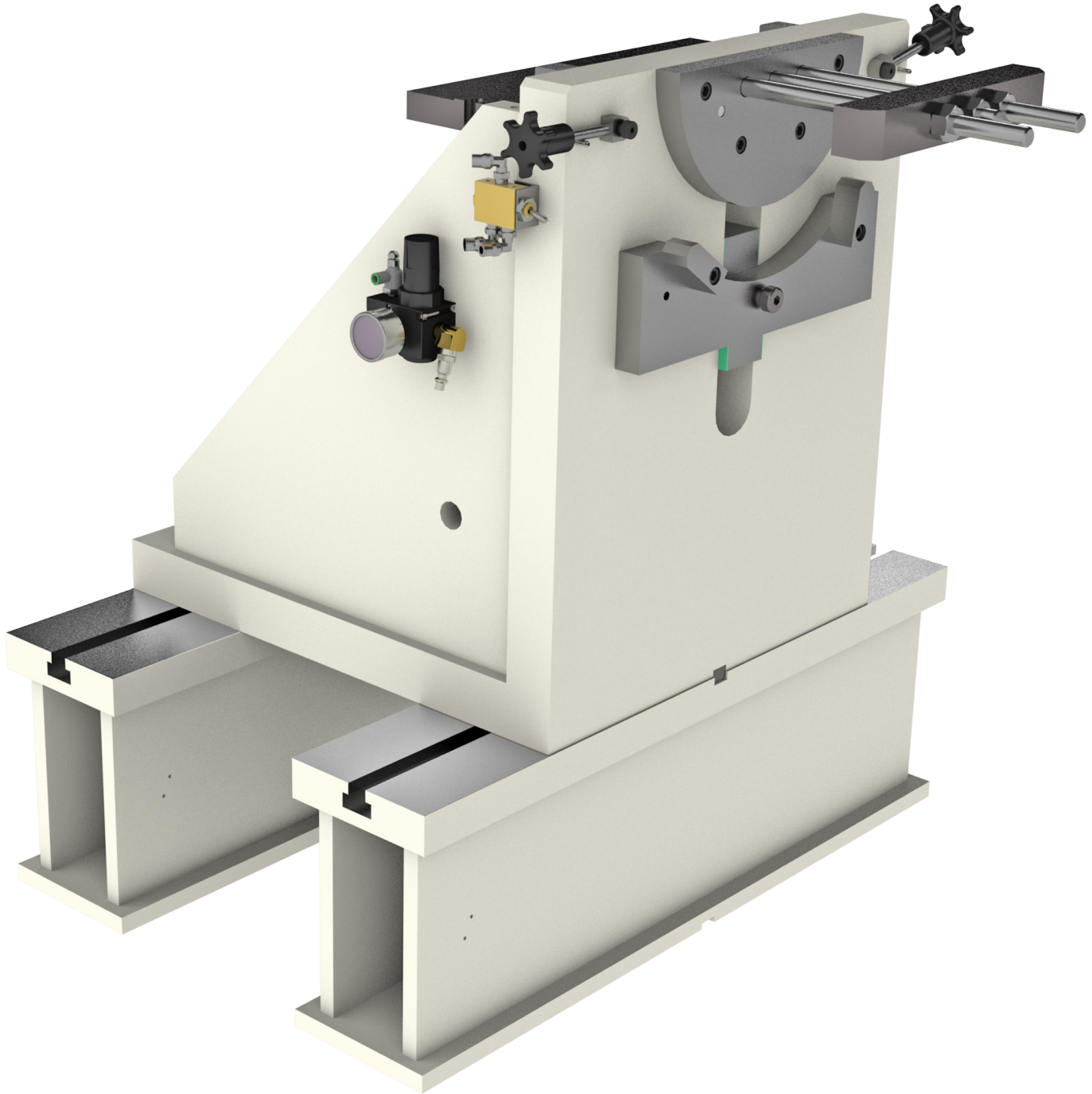


Fixturing & Tooling for Machining Large Engine & Compressor Connecting Rods**650-3-64 Rottler Precision Connecting Rod Fixturing System**

Special Version to Handle Natural Gas Compressor Connecting Rods and Large Engine Connecting Rods Such as Waukesha 7042 and White Superior 825 - Requires (1) Set of 6370C Parallels

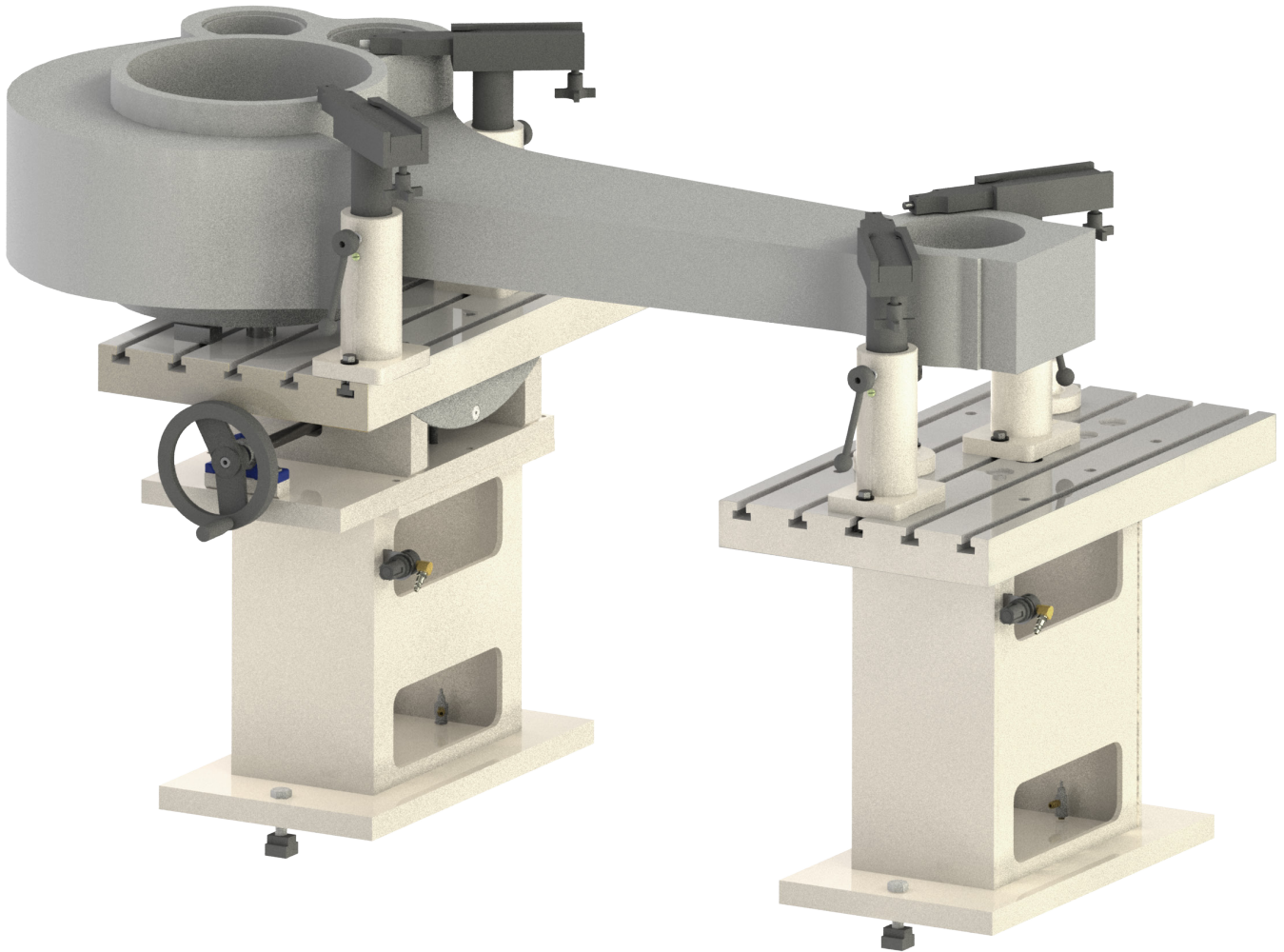


650-3-66 Rottler Precision Compressor Conrod Cap Surfacing Fixture
Requires (1) Set 6370Z Parallels



6870 Rottler Precision Connecting Rod Boring Fixturing System

For extra large and heavy connecting rods such as Ajax integral engine-compressors. Fixture consists of 2 parts mounted on air float supports.



Tooling for Connecting Rod Boring

10118 Blind Hole Cutterhead Assembly

1.5 - 4.2" (38 - 107mm) Diameter X 6.5" (165mm) Length Complete With Tooling and Digital Micrometer



10131 Blind Hole Cutterhead Assembly

2.9 - 8.0" (74 - 203mm) Diameter X 9.3" (236mm) Length Complete With Tooling and Digital Micrometer



Tool Changing and Storage System for Heavy Tooling

6875A Tool Changing and Storage System

For heavy tooling such as Milling Heads, Flycutters and Right Angle Drives

