

# ROTTLER

## SA SERIES 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 specialists.

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

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**



# S7A /S8A OPTIONAL EQUIPMENT CATALOG

## Contents

|   |           |
|---|-----------|
| <b>Safety Equipment</b> .....   | <b>1</b>  |
| 7036Y Full Steel Enclosure with Folding Door .....                            | 1         |
| <b>Fixtures and Parallels</b> .....   | <b>2</b>  |
| Universal Quick Leveling Cylinder Head Fixture.....                           | 2         |
| 7209M Leveling Table.....   | 2         |
| 7152A Dual Axis Level Assembly.....   | 2         |
| <b>Fixed Angle Fixtures for Blocks</b> .....                                  | <b>3</b>  |
| 502-1-72F V Block Fixture with Air Float and Air Clamping .....               | 3         |
| 502-3-48Q In-line Block Frame .....   | 4         |
| 502-3-49 VW 15-degree, Ford Mazda & Isuzu 75-degree V Block Fixture .....     | 4         |
| 502-3-52 Cadillac Catera 54-degree V Block Fixture .....                      | 5         |
| 502-3-23 Marine Outboard Fixture, V4 & V6 Evinrude/ Johnson, V6 Mercury ..... | 5         |
| 502-3-23C Marine Outboard Fixture, Yamaha 76 degree .....                     | 6         |
| <b>Adjustable Angle Fixtures for Blocks</b> .....                             | <b>7</b>  |
| 650-3-1 Performance Fixture Assembly .....                                    | 7         |
| 7241 Universal Economy Automotive Head & Block Fixture .....                  | 8         |
| 7243 Mid-size Diesel Block Fixture .....                                      | 9         |
| <b>Accessories for Fixtures</b> .....   | <b>10</b> |
| 502-1-95 Block Handler for Lifting Camshaft Type V Blocks .....               | 10        |
| 502-1-46T Precision 2" (50.8mm) Locator Bar for 502-1-72F & H Fixtures .....  | 10        |
| 550-5-10 (1) pair of Main bearing bushings for Detroit 8.2 liter diesel ..... | 11        |
| 7242M Clamp Tower Assembly .....  | 11        |
| <b>Parallels</b> .....  | <b>12</b> |
| 11115 2" (50mm) X 3" (75mm) Parallels.....                                    | 12        |
| 11112 Universal 8" (203mm) Heavy Duty T-Slot Parallels with Air Float .....   | 12        |
| 11114 Universal 16" (405mm) Heavy Duty T-Slot Parallels with Air Float .....  | 13        |
| 7219W 5.2" (132mm) Heavy Duty T-Slot Universal Parallels for 7209M .....      | 13        |
| <b>Optional Tooling</b> .....   | <b>14</b> |
| 7225F 10" (254mm) Multi-tooth Face Mill Assembly .....                        | 14        |
| 7224 Shell Mill Assembly 2 1/2" (63.50mm) diameter .....                      | 14        |

|  |           |
|--|-----------|
| <b>7225Y Shell Mill Assembly 4" (102mm) Diameter</b> .....             | <b>15</b> |
| <b>7224G Shell Mill Assembly 6" (152.4mm) Diameter</b> .....           | <b>15</b> |
| <b>7038Y Flatness Probe Dial Indicator for Level Assembly</b> .....    | <b>16</b> |
| <b>7209N 2-Piece Vise</b> .....  | <b>16</b> |
| <b>7226G Exhaust/Intake Manifold Surfacing Fixture</b> .....           | <b>17</b> |
| <b>650-3-38 Machinist Level for Intake and Exhaust Manifolds</b> ..... | <b>18</b> |
| <b>502-1-95 V-Block Handler Assembly</b> .....                         | <b>18</b> |
| <b>201 Mitutoyo Surface Tester</b> .....                               | <b>18</b> |
| <b>7202V Holder Assembly</b> .....                                     | <b>19</b> |
| <b>7202U Holder Assembly</b> .....                                     | <b>19</b> |
| <b>7202X Tool Holder Assembly</b> .....                                | <b>19</b> |
| <b>Cutting Inserts</b> .....   | <b>20</b> |
| <b>6514T Inserts</b> .....   | <b>20</b> |
| <b>7224B Triangle Inserts</b> .....                                    | <b>20</b> |
| <b>6301I Ceramic Composite Insert</b> .....                            | <b>20</b> |
| <b>6301V Ceramic Composite Insert</b> .....                            | <b>20</b> |
| <b>6303K Coated Carbide Insert</b> .....                               | <b>20</b> |
| <b>6303M PCD Round Insert</b> .....                                    | <b>20</b> |
| <b>6303B CBN Round Insert</b> .....                                    | <b>20</b> |
| <b>6303R CBN Round Insert</b> .....                                    | <b>20</b> |
| <b>6303S CBN Round Insert</b> .....                                    | <b>20</b> |
| <b>6301J CBN Square Insert</b> .....                                   | <b>20</b> |
| <b>6303Q CBN Round Insert</b> .....                                    | <b>21</b> |
| <b>6303P PCD Round Insert</b> .....                                    | <b>21</b> |
| <b>6303U CBN Round Insert</b> .....                                    | <b>21</b> |
| <b>6303V CBN Insert</b> .....  | <b>21</b> |
| <b>RS322 Insert</b> .....  | <b>21</b> |
| <b>7202Z Round Insert</b> .....  | <b>21</b> |
| <b>Transformer</b> .....   | <b>21</b> |
| <b>650-5-25 Buck-Boost Transformer</b> .....                           | <b>21</b> |

## Safety Equipment

### 7036Y Full Steel Enclosure with Folding Door

Includes chip collector to guide chips into a removable container for easy disposal



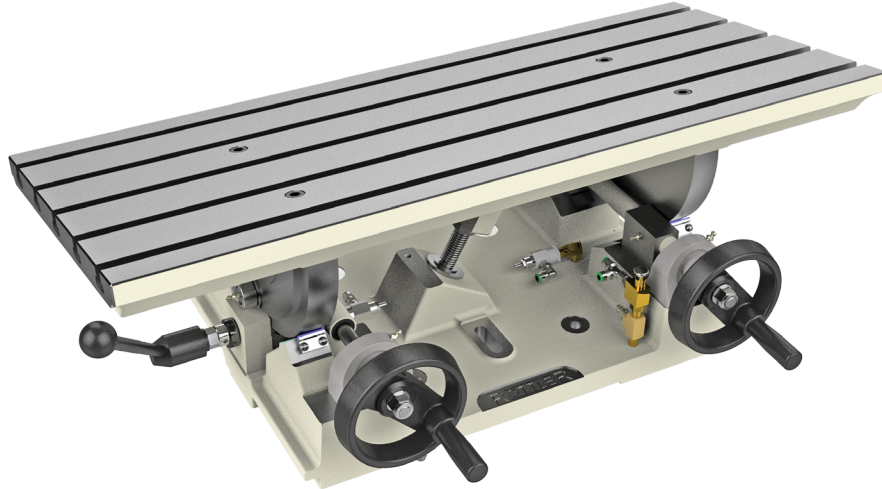


## Fixtures and Parallels

### Universal Quick Leveling Cylinder Head Fixture

#### 7209M Leveling Table

Complete with universal work holding system for cylinder heads and small in-line blocks (requires 7219W Parallels)



#### 7152A Dual Axis Level Assembly

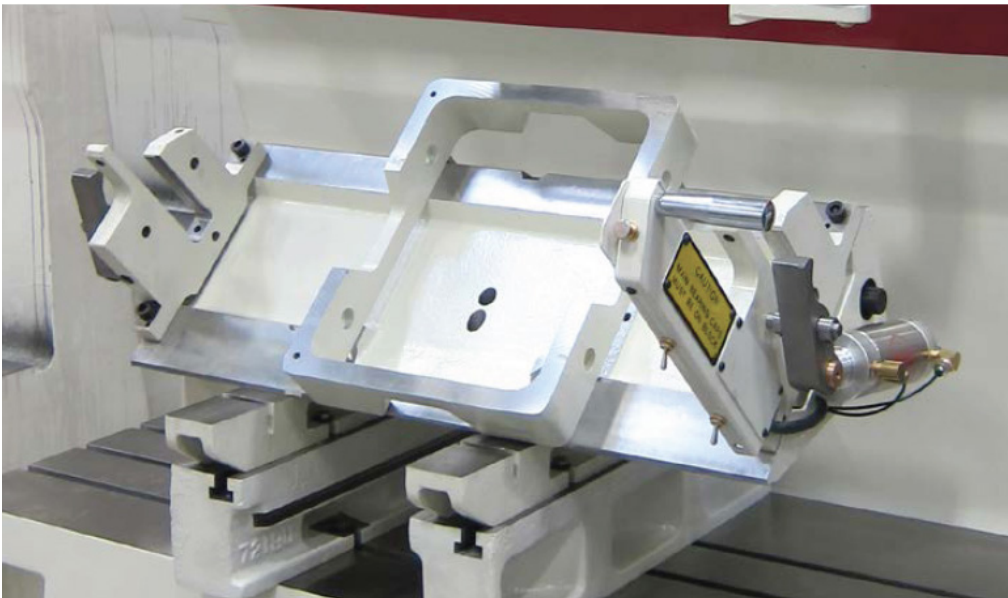
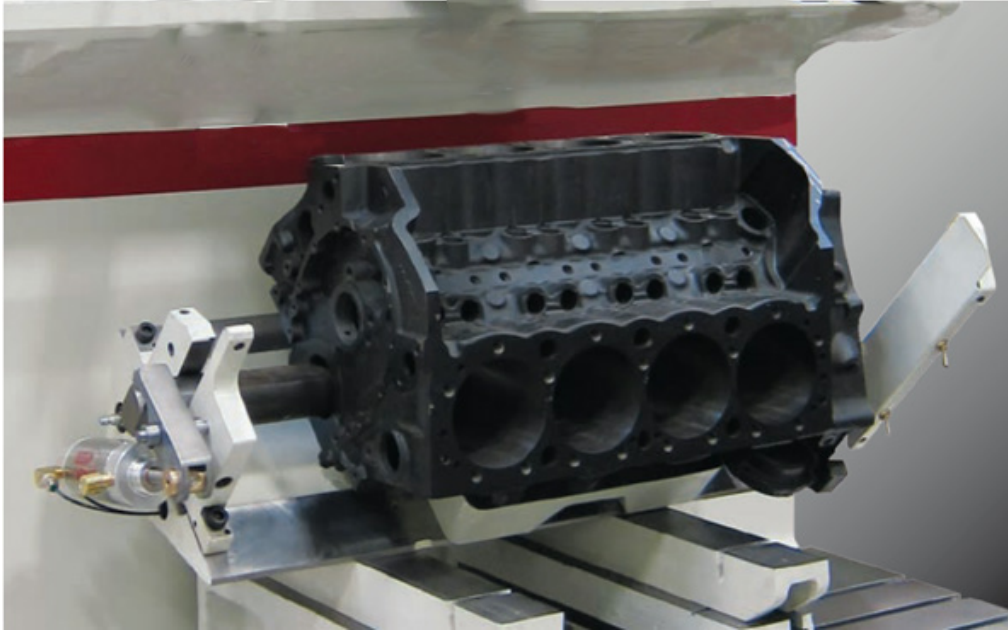




## Fixed Angle Fixtures for Blocks

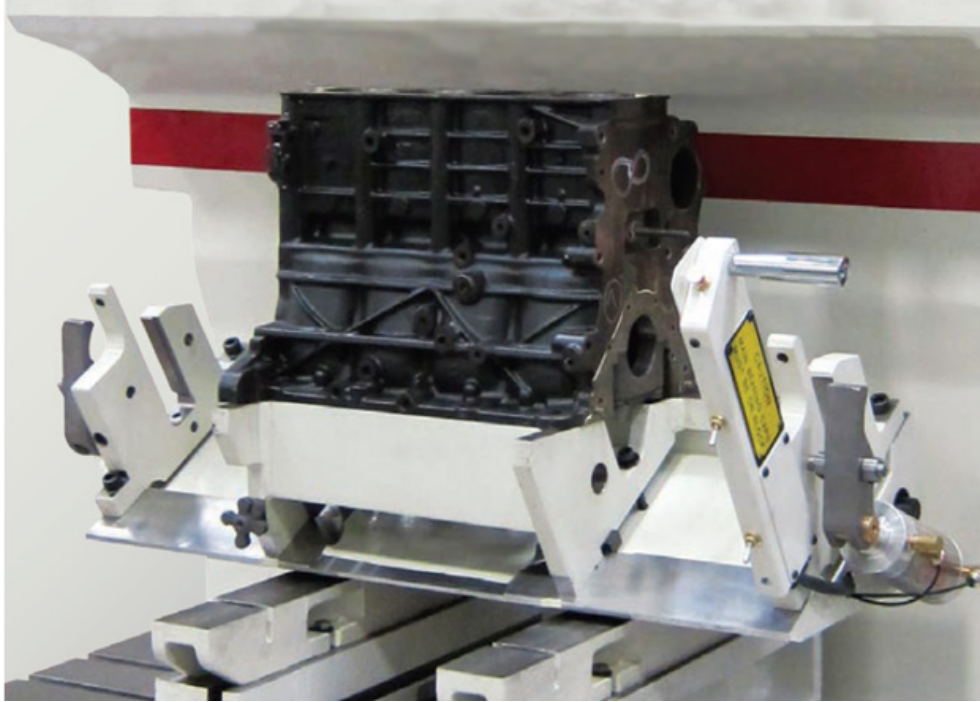
### 502-1-72F V Block Fixture with Air Float and Air Clamping

(Includes: Parallels 502-1-15C, Block Handler 502-1-95 & 502-1-21C Wear Pads) (Requires: 7219W Parallels)



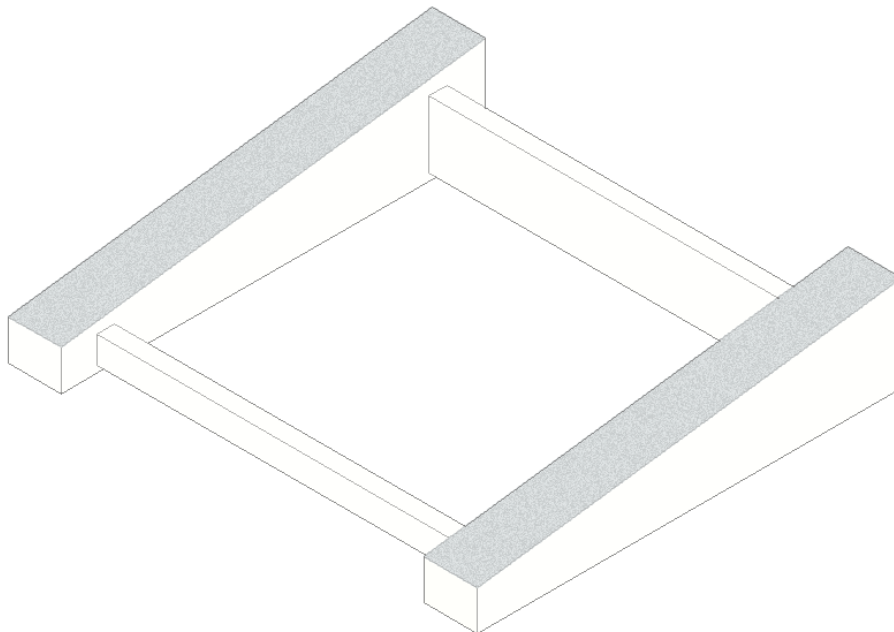
**502-3-48Q In-line Block Frame**

For V Block Fixture 502-1-72F

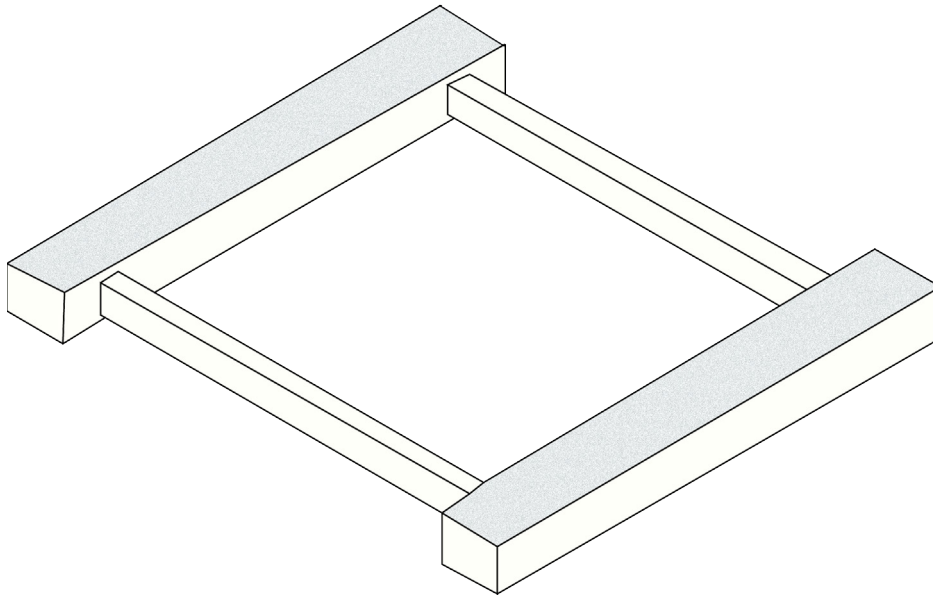


**502-3-49 VW 15-degree, Ford Mazda & Isuzu 75-degree V Block Fixture**

(requires 502-1-72F Fixture)



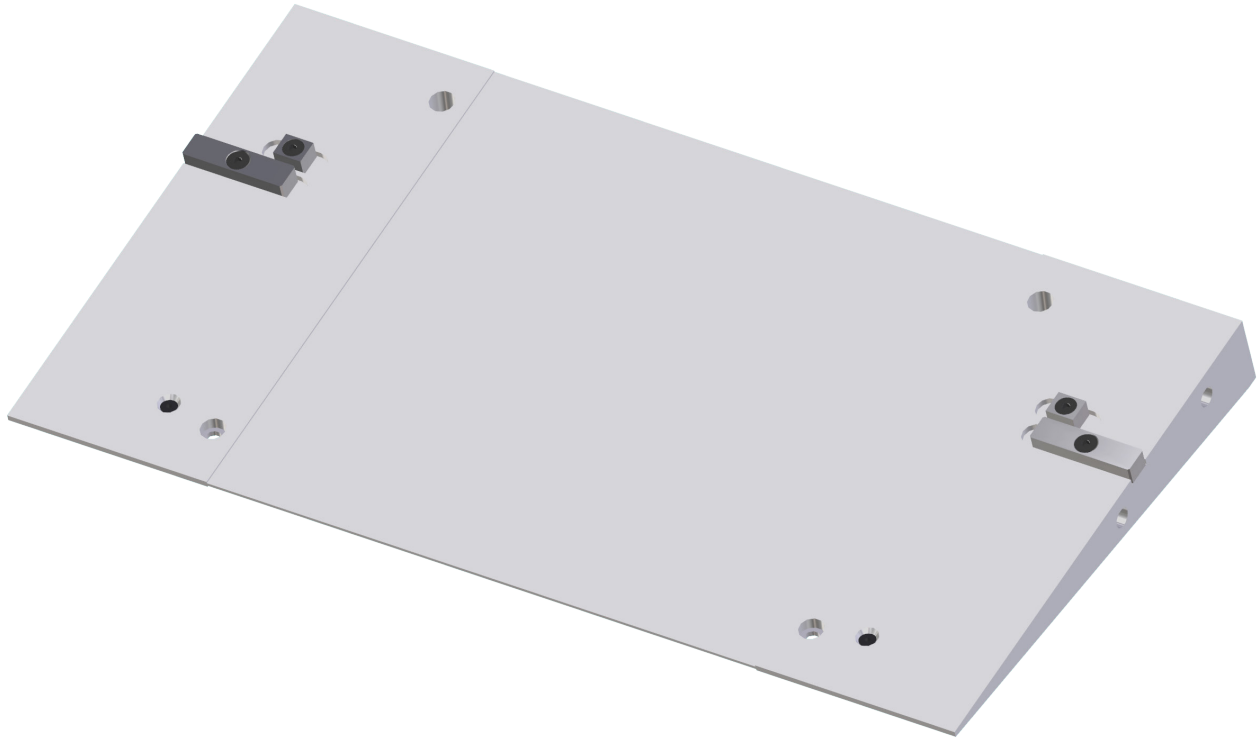
**502-3-52 Cadillac Catera 54-degree V Block Fixture**  
(requires 502-1-72F Fixture)



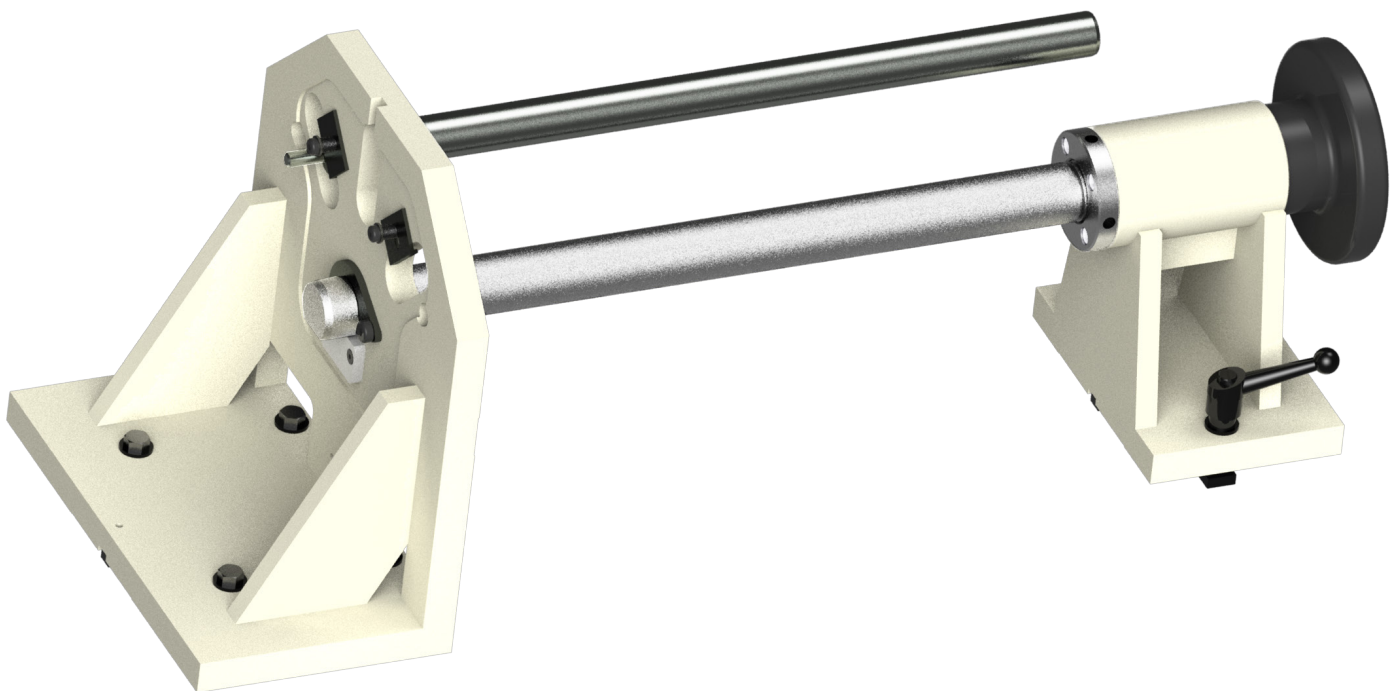
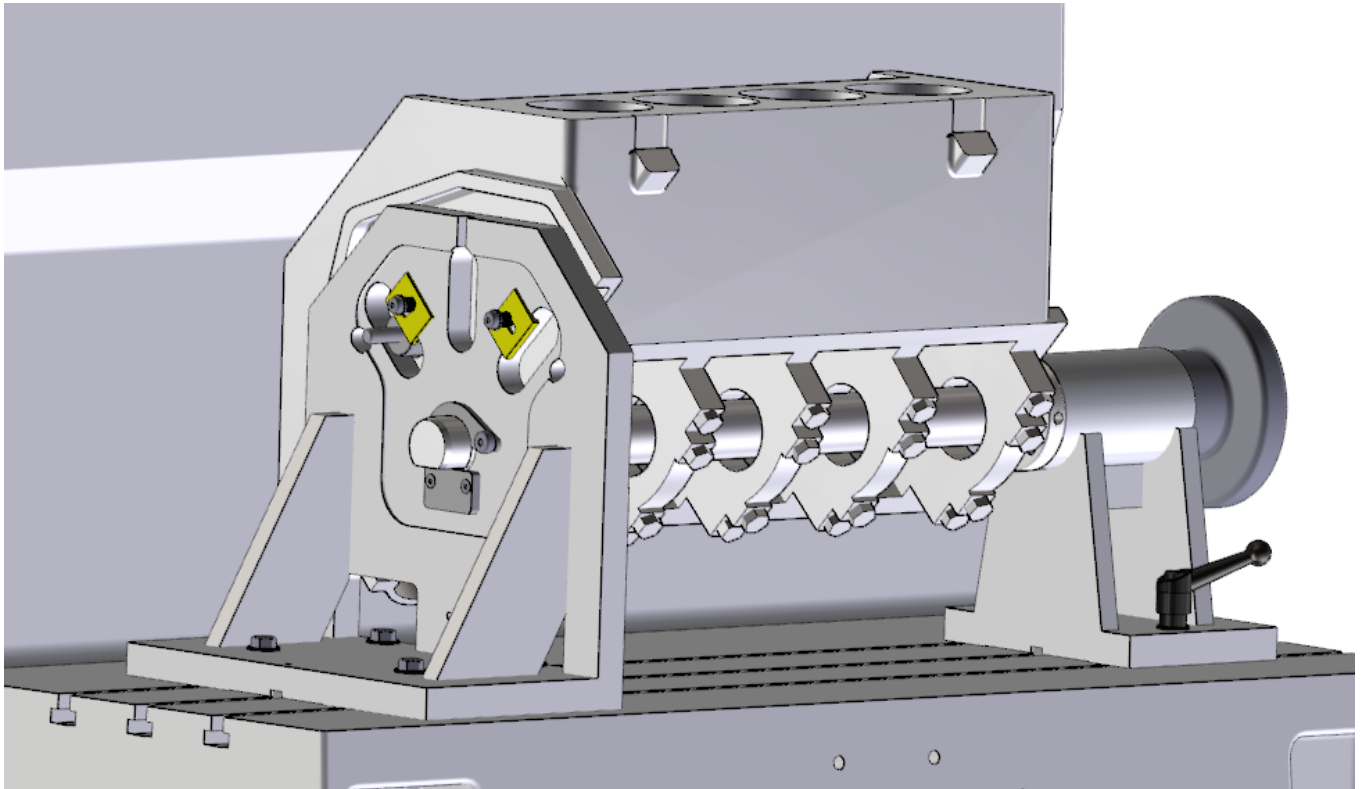
**502-3-23 Marine Outboard Fixture, V4 & V6 Evinrude/ Johnson, V6 Mercury**  
(requires 502-1-72F Fixture)



**502-3-23C Marine Outboard Fixture, Yamaha 76 degree**  
(requires 502-1-72F Fixture)

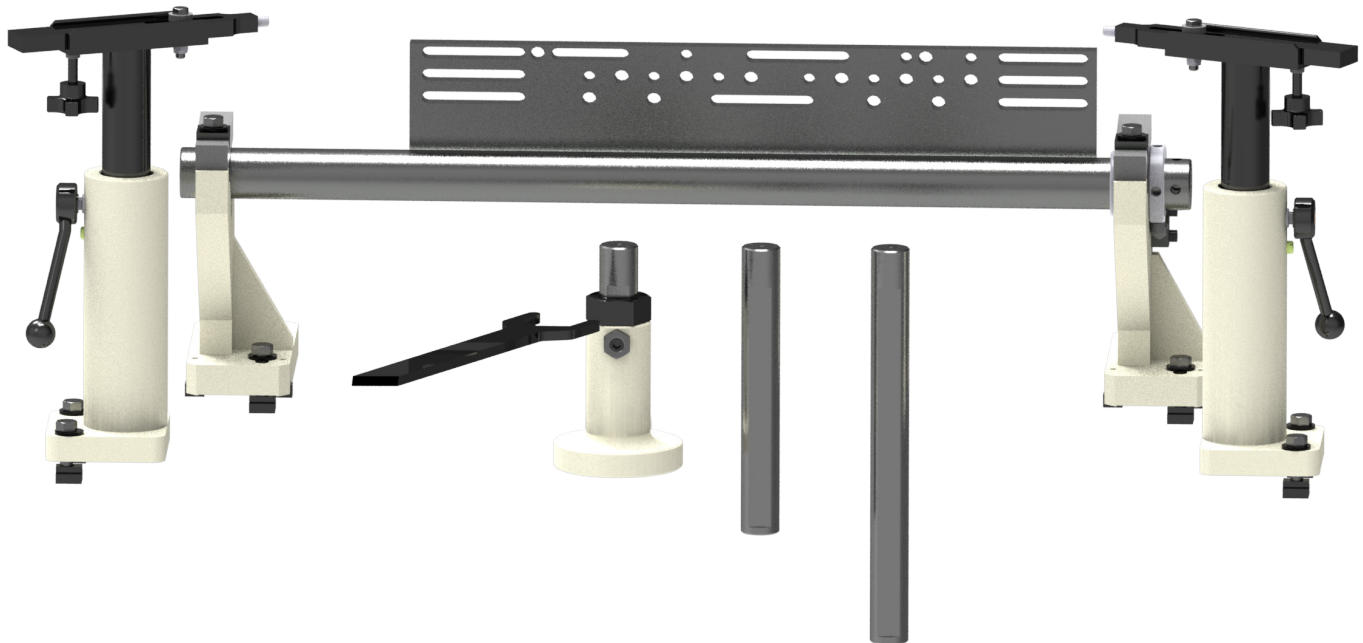
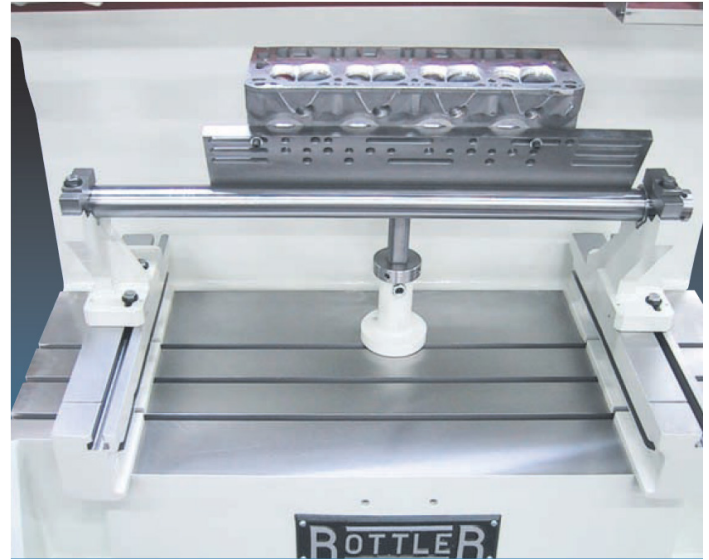
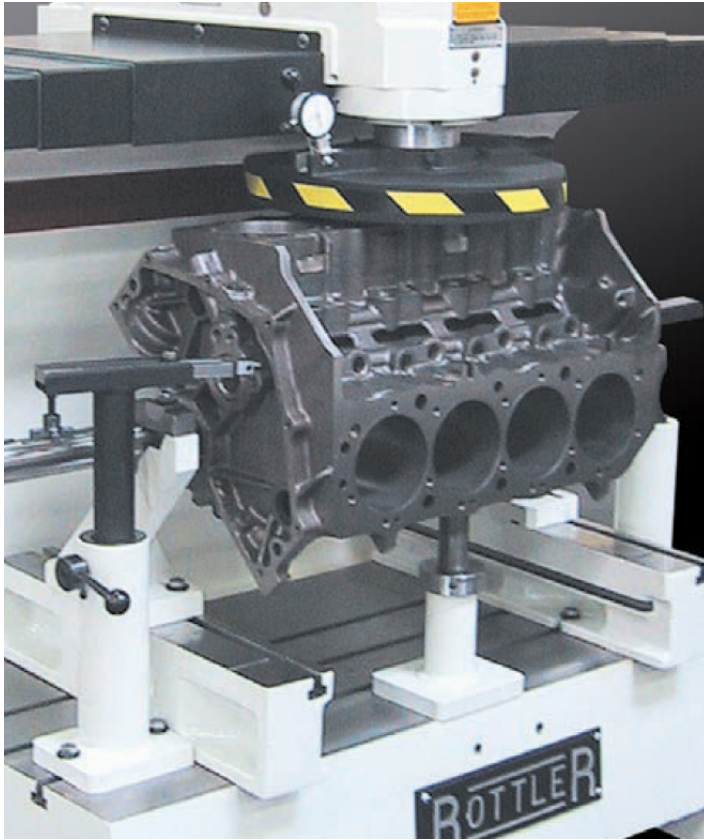


**Adjustable Angle Fixtures for Blocks**  
**650-3-1 Performance Fixture Assembly**





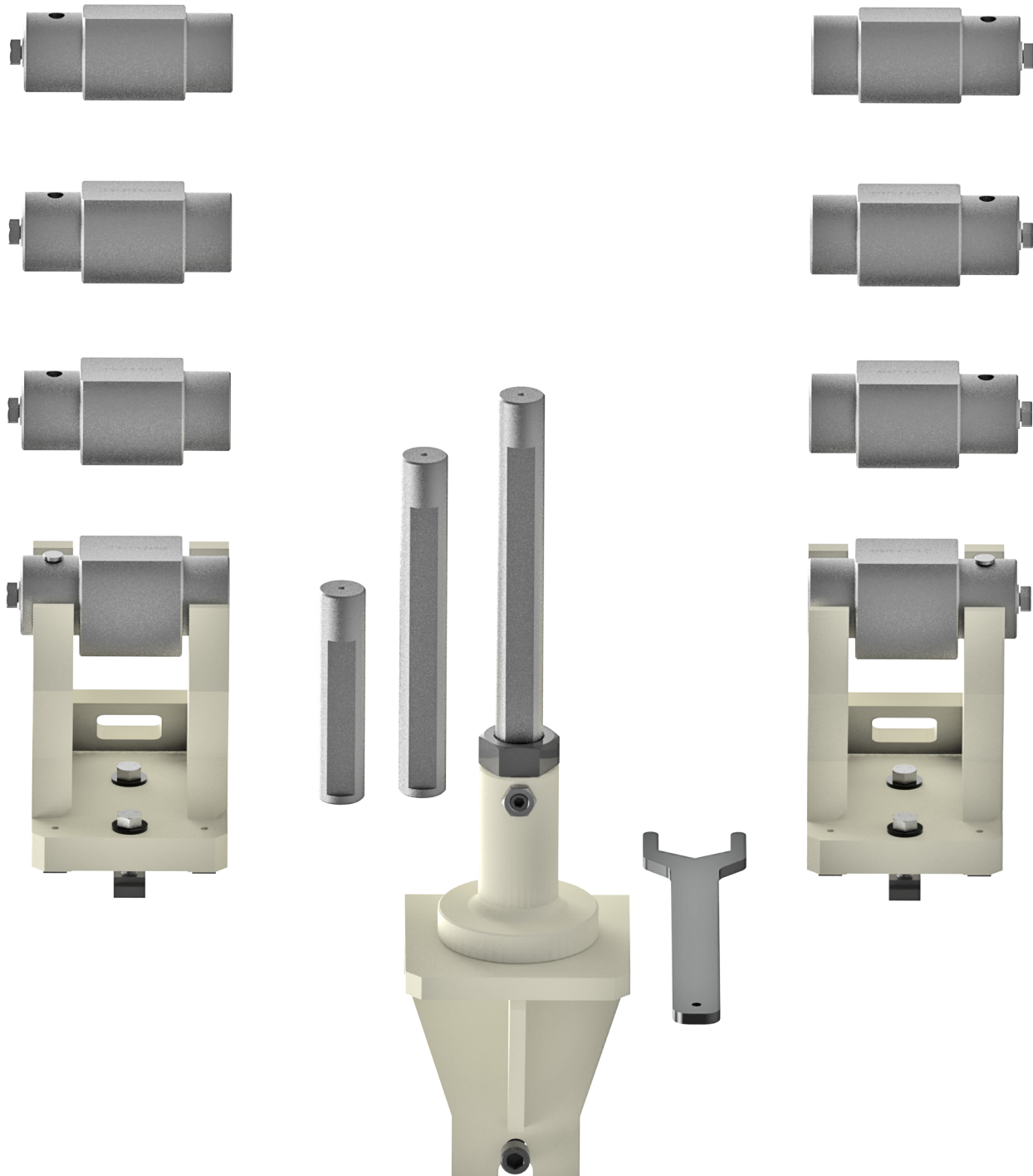
## 7241 Universal Economy Automotive Head & Block Fixture (requires 7219W Parallels) (Includes Clamp Towers - 7242M)





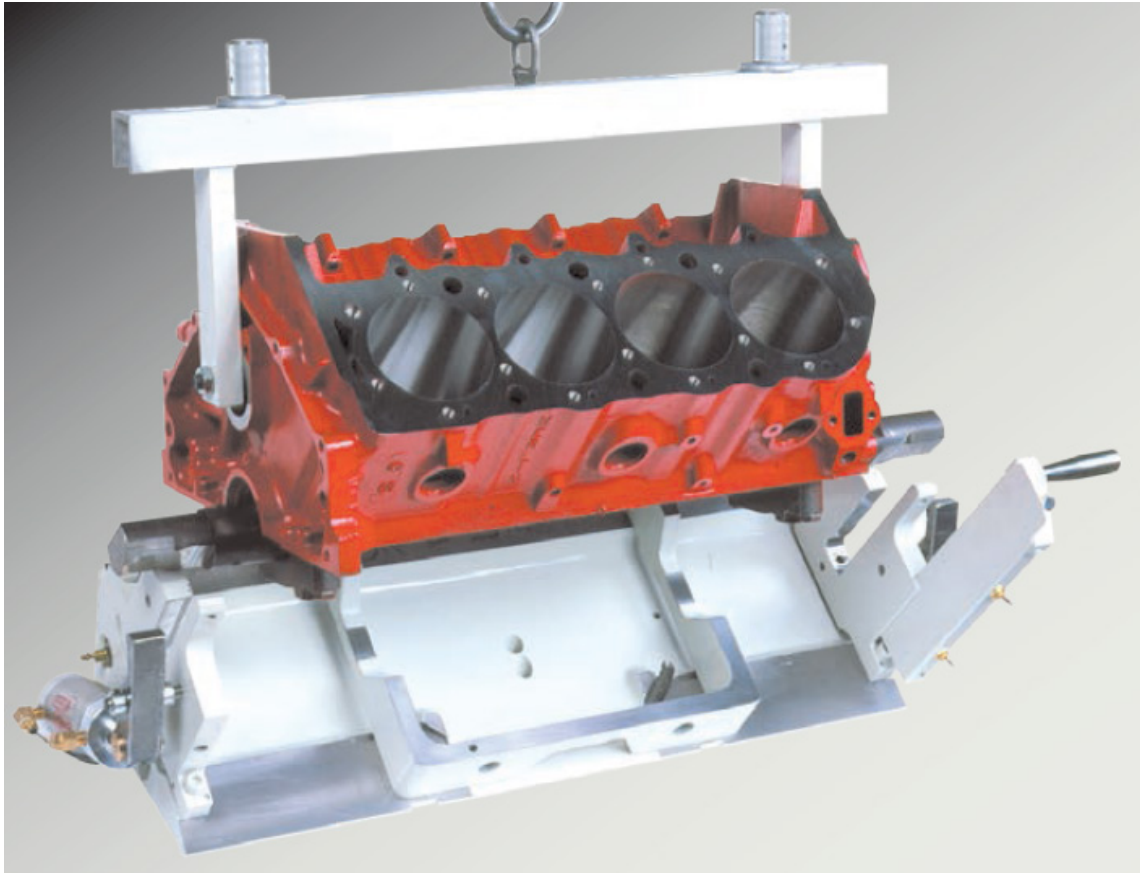
**7243 Mid-size Diesel Block Fixture**

Includes four pair main bearing locators to cover 3 - 5" (76.2 - 127mm) main line diameter range. When used on surfacing machines, requires one pair 7242M Clamp Towers to use.



## Accessories for Fixtures

### 502-1-95 Block Handler for Lifting Camshaft Type V Blocks



### 502-1-46T Precision 2" (50.8mm) Locator Bar for 502-1-72F & H Fixtures (main bearing locators required)



**550-5-10 (1) pair of Main bearing bushings for Detroit 8.2 liter diesel**  
(requires 502-1-72F Fixture with special hole location machined on 502-1-15C parallels)



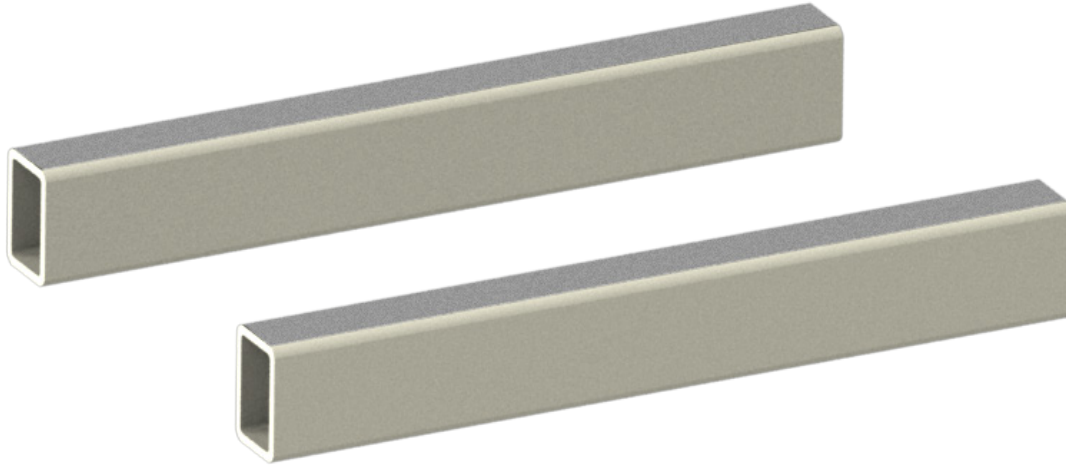
**7242M Clamp Tower Assembly**  
(1 pair)



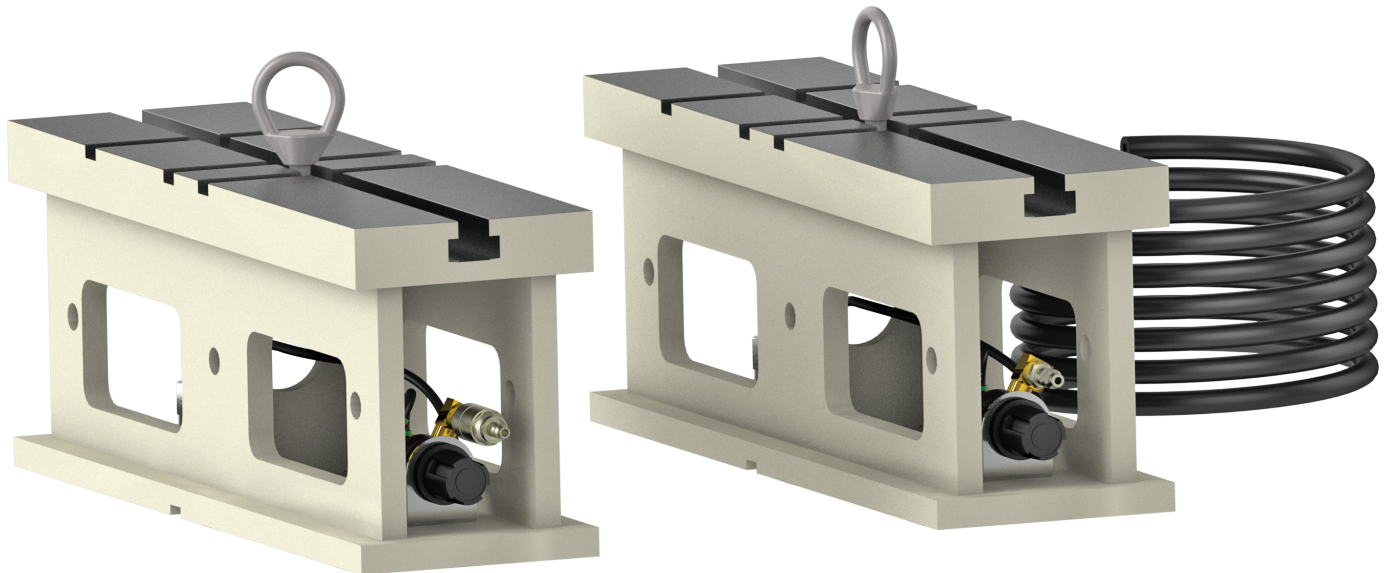
## Parallels

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

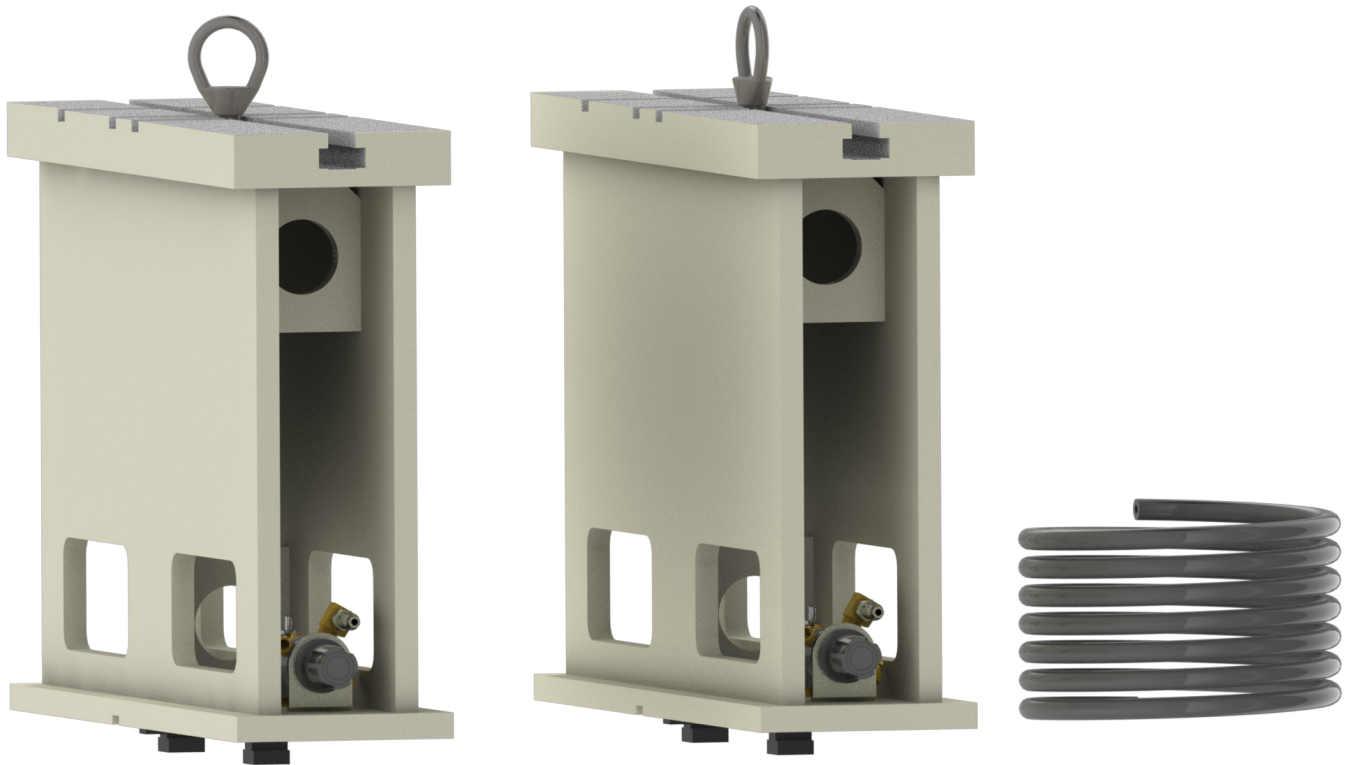
For general purpose machine work such as setting up in-line blocks on the pan or small single cylinders.



### 11112 Universal 8" (203mm) Heavy Duty T-Slot Parallels with Air Float



**11114 Universal 16" (405mm) Heavy Duty T-Slot Parallels with Air Float**



**7219W 5.2" (132mm) Heavy Duty T-Slot Universal Parallels for 7209M**



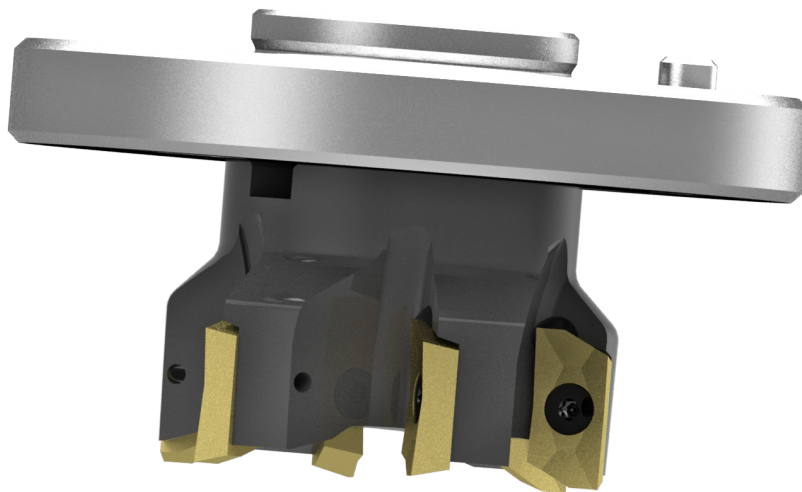


**Optional Tooling**

**7225F 10" (254mm) Multi-tooth Face Mill Assembly**

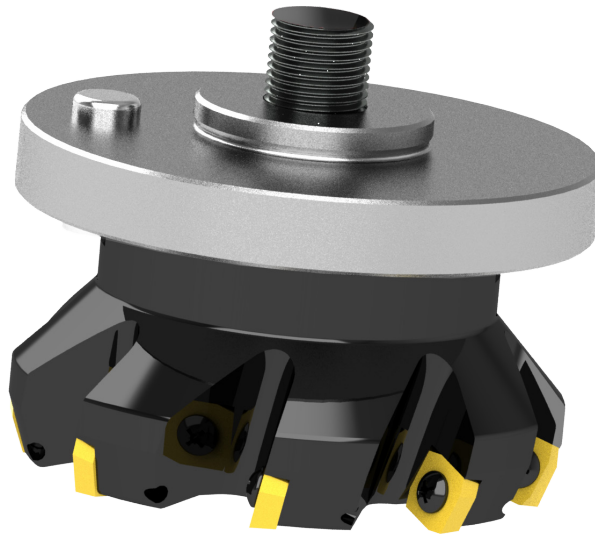


**7224 Shell Mill Assembly 2 1/2" (63.50mm) diameter**

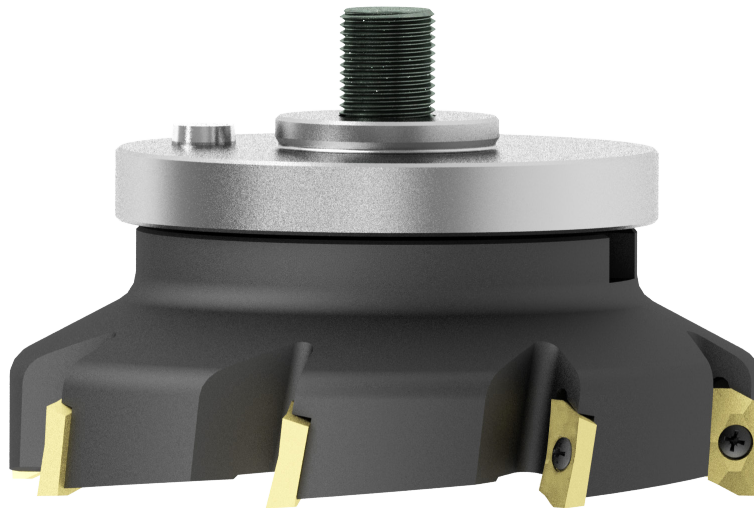




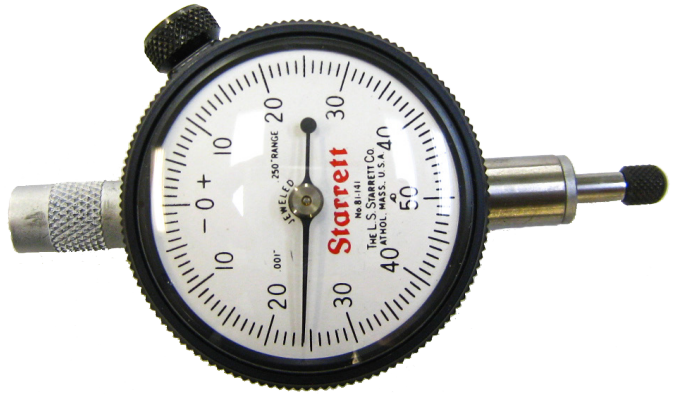
**7225Y Shell Mill Assembly 4" (102mm) Diameter**



**7224G Shell Mill Assembly 6" (152.4mm) Diameter**

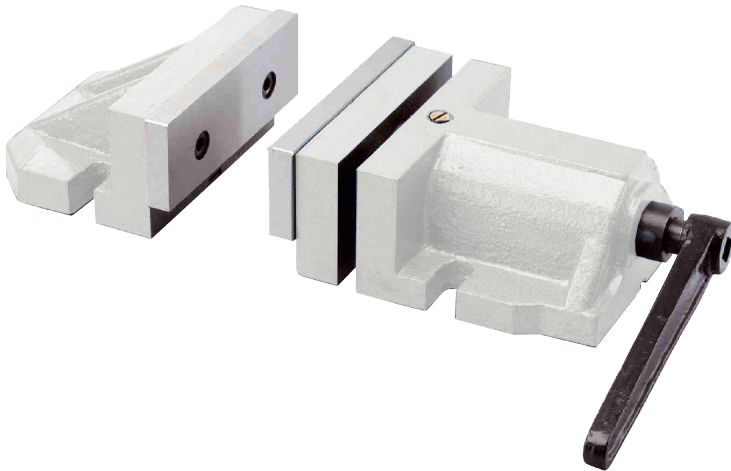


### 7038Y Flatness Probe Dial Indicator for Level Assembly

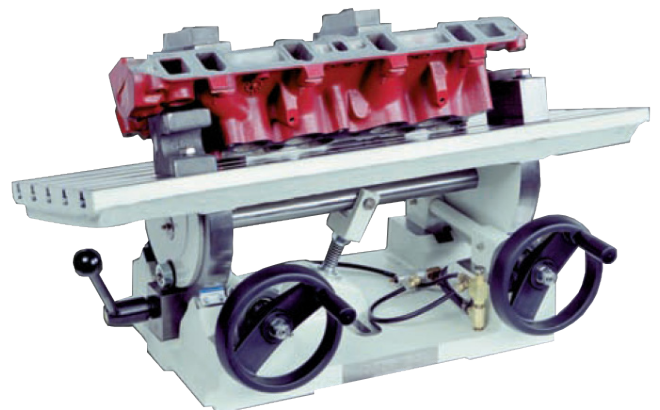
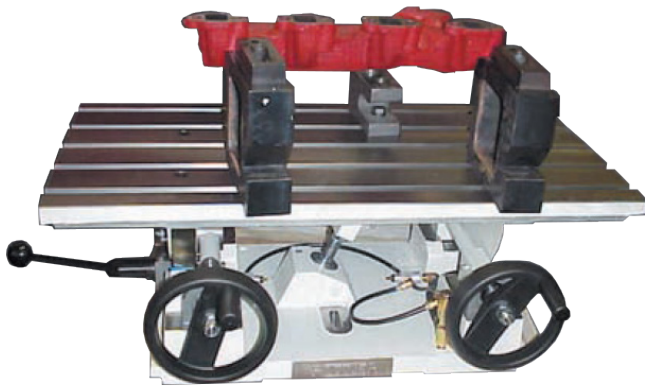
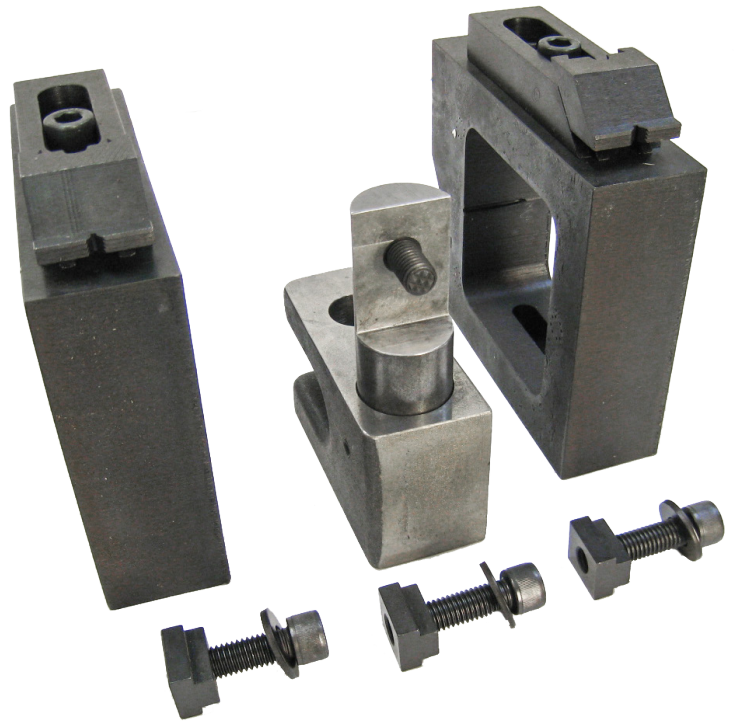


### 7209N 2-Piece Vise

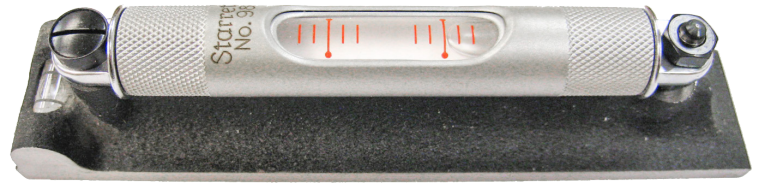
For surfacing main caps in preparation for main line boring. Also used for holding exhaust manifolds for surfacing. Requires 7209M Leveling Table.



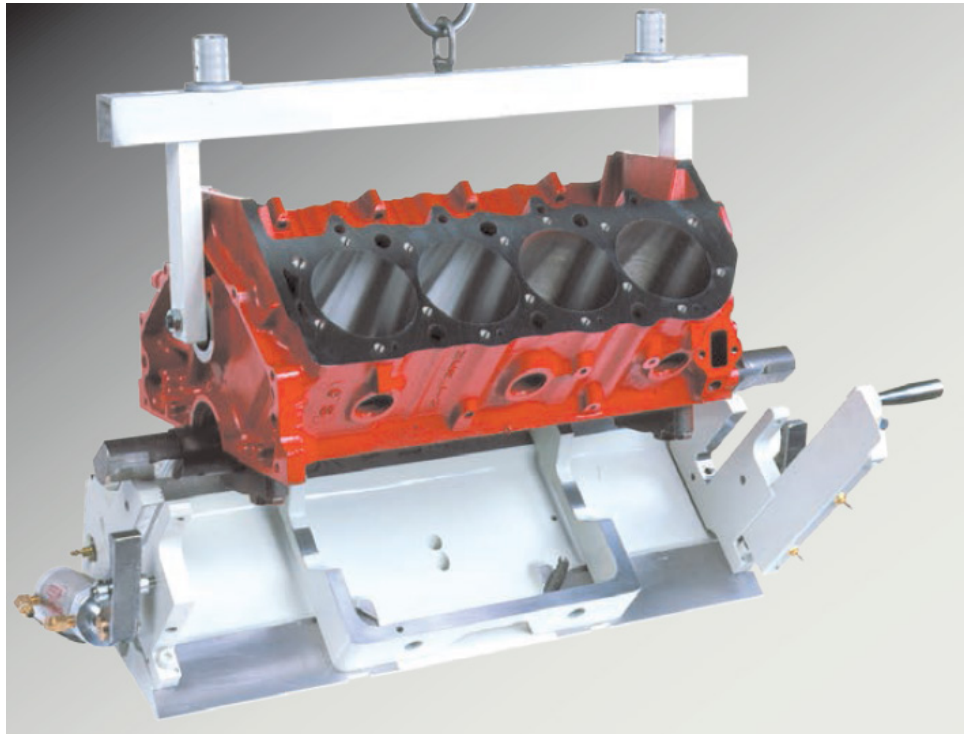
**7226G Exhaust/Intake Manifold  
Surfacing Fixture**



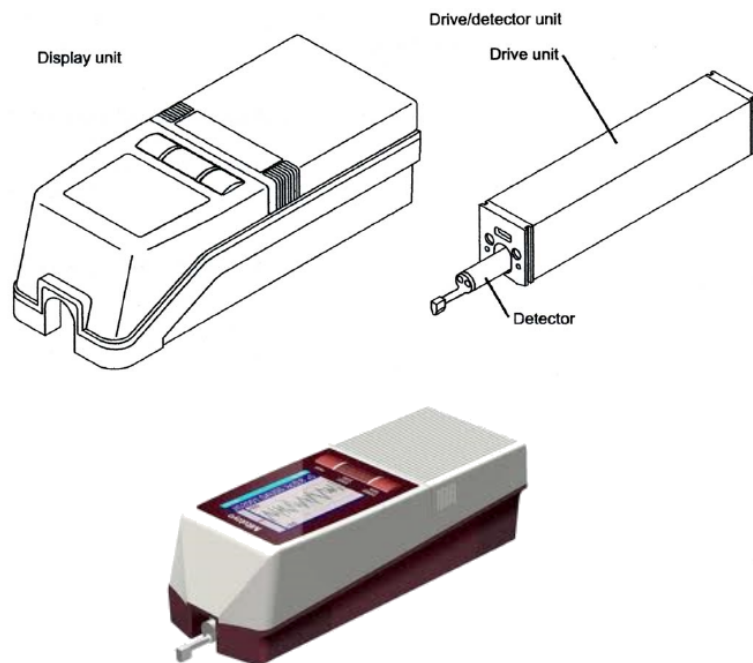
**650-3-38 Machinist Level for Intake and Exhaust Manifolds**



**502-1-95 V-Block Handler Assembly**  
(Standard w/ 502-1-72F V6/V8 Fixture)

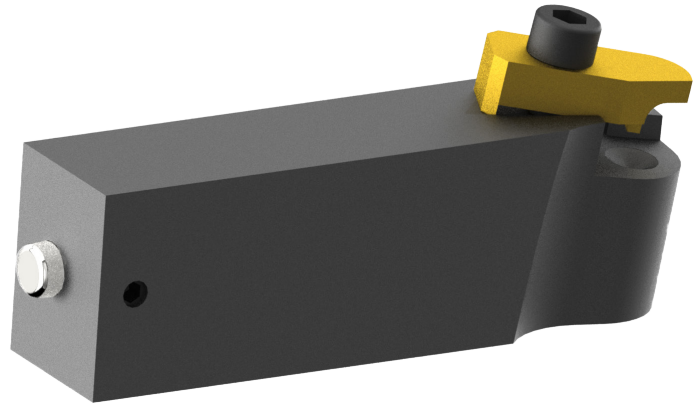


**201 Mitutoyo Surface Tester**



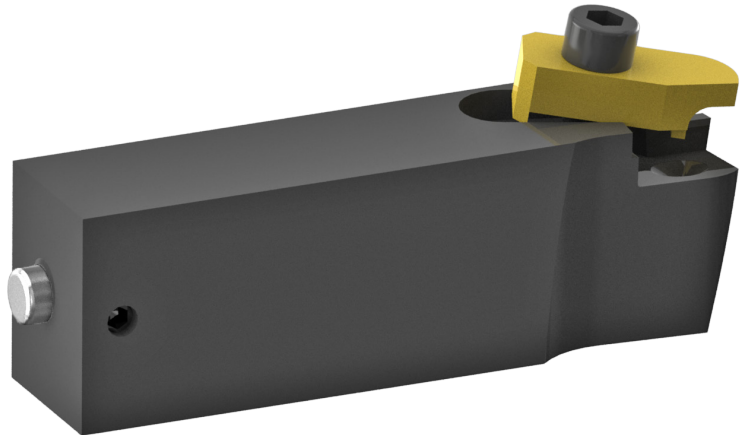
### 7202V Holder Assembly

Fly Cutter Tool 1/2" (12.70mm) IC Negative Rake



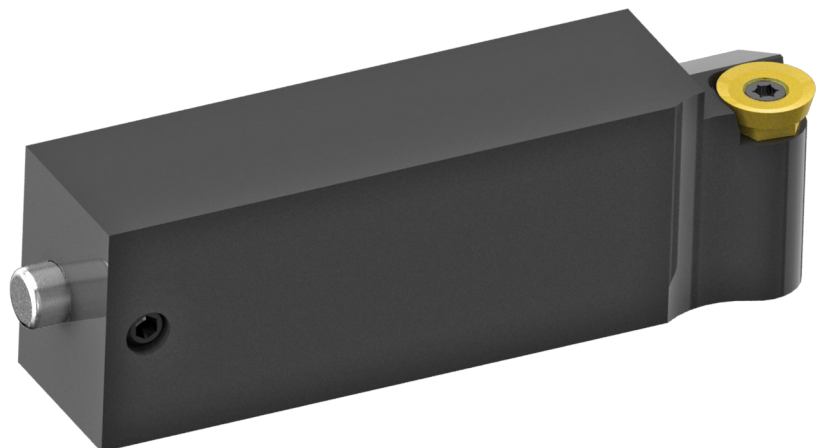
### 7202U Holder Assembly

Fly Cutter Tool 1/2" (12.70mm) IC-11 Degree Positive Rake




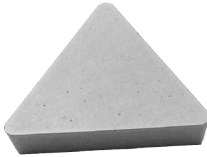
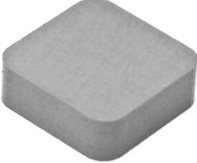







### 7202X Tool Holder Assembly

Fly Cutting (for use with special gold coated round insert 7202Z for surfacing aluminum heads with pre chambers and cast iron heads with soft pre chambers)




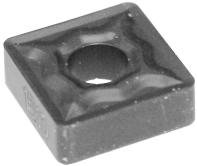




## Cutting Inserts

|  |   |
|--|---|
| <p><b>6514T Inserts</b><br/>For Shell Mills (7225Y, 7224G, and 7224 - Requires 8 Inserts)</p>                                       | <p><b>7224B Triangle Inserts</b><br/>For 2-1/2" (63.50mm) Shell Mill 3/8" IC</p>   |
| <p><b>6301I Ceramic Composite Insert</b><br/>For cutting precombustion chambers, square negative rake 3/8" IC</p>                   | <p><b>6301V Ceramic Composite Insert</b><br/>For cutting precombustion chambers, round negative rake 3/8" IC</p>         |
| <p><b>6303K Coated Carbide Insert</b><br/>3/8" IC, for aluminum and cast iron</p>   | <p><b>6303M PCD Round Insert</b><br/>3/8" IC, for super finishing aluminum (15% Discount on orders of 10 or more)</p>  |
| <p><b>6303B CBN Round Insert</b><br/>Double Sided, 3/8" IC, for cast iron (15% Discount on orders of 10 or more)</p>              | <p><b>6303R CBN Round Insert</b><br/>3/8" IC, for cast iron heads with steel pre-cups</p>                              |
| <p><b>6303S CBN Round Insert</b><br/>3/8" IC, for cutting aluminum heads with steel pre-cups and aluminum blocks with liners</p>  | <p><b>6301J CBN Square Insert</b><br/>Double Sided, 3/8" IC, 1/16" Radius, for heavy stock removal</p>                 |



|   |  |
|---|--|
| <p><b>6303Q CBN Round Insert</b><br/>Double Sided, 1/2" IC, for general cast iron surfacing</p>  | <p><b>6303P PCD Round Insert</b><br/>1/2" IC, for super finishing aluminum</p>    |
| <p><b>6303U CBN Round Insert</b><br/>Single Sided, 3/8" IC. For hard cast iron</p>               | <p><b>6303V CBN Insert</b><br/>Octagonal (16-Cutting Corners) for surfacing large diesel blocks</p>   |
| <p><b>RS322 Insert</b><br/>Square negative rake, 1/32" radius for roughing</p>                 | <p><b>7202Z Round Insert</b><br/>3/8" gold coated for aluminum cylinder head precup cutting, also for soft cast iron precups like Land Rover. Use with 7202X tool holder only.</p>  |

**Transformer**

**650-5-25 Buck-Boost Transformer**

(Required for All Machine Installations where Power Supply higher than 240 Volts or lower than 208 volts)

