

ROTTLER

H85A/X/Y CNC HONE 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. 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





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Fixturing

Block Holding Fixtures

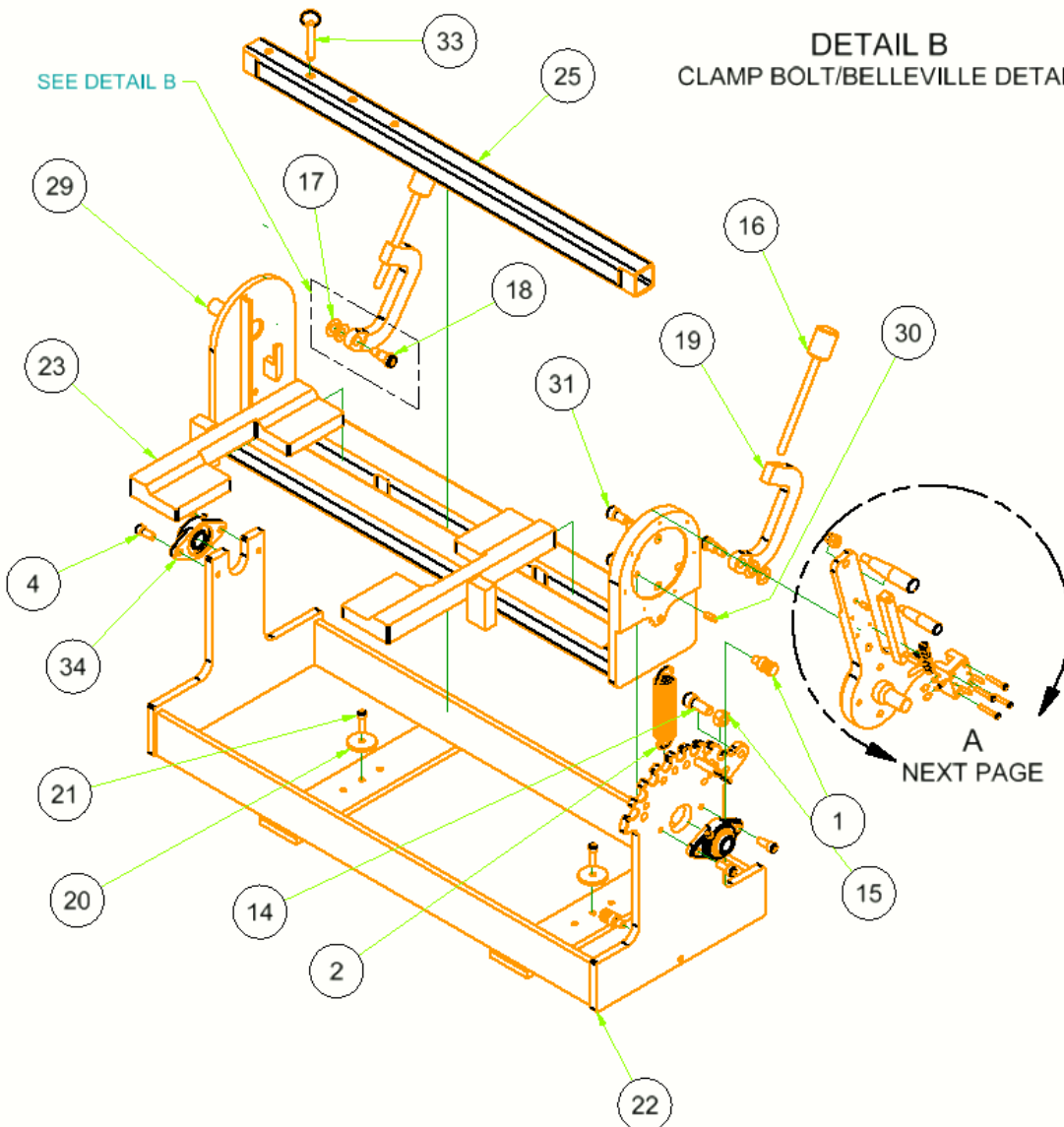
514-7E Manual Indexable Roll-over Fixture

BELLEVILLE SPRINGS
ARRANGE WITH SMALL
FACES TO EACH OTHER

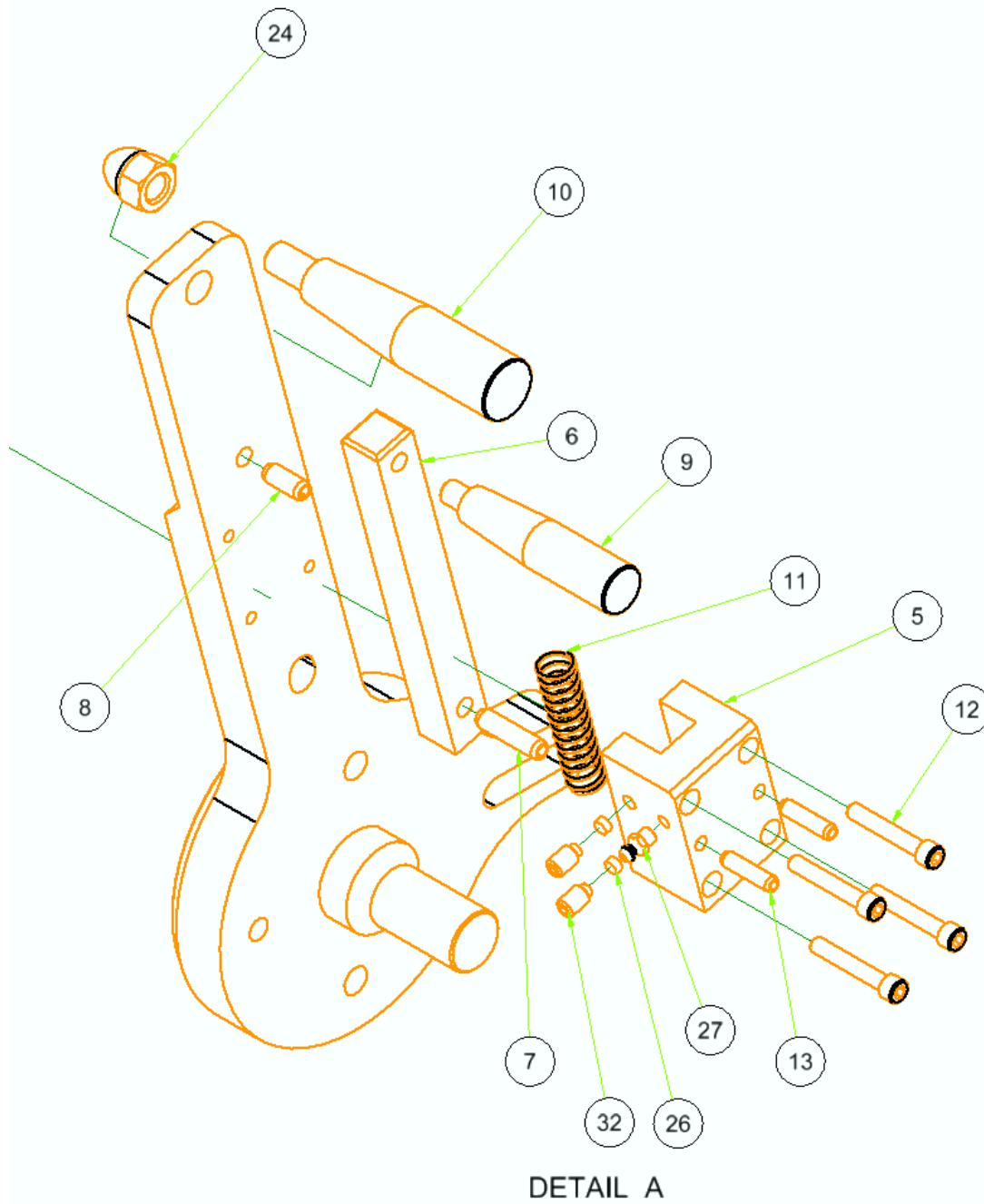
CLAMP BODY

SHOULDER BOLT

DETAIL B
CLAMP BOLT/BELLEVILLE DETAIL



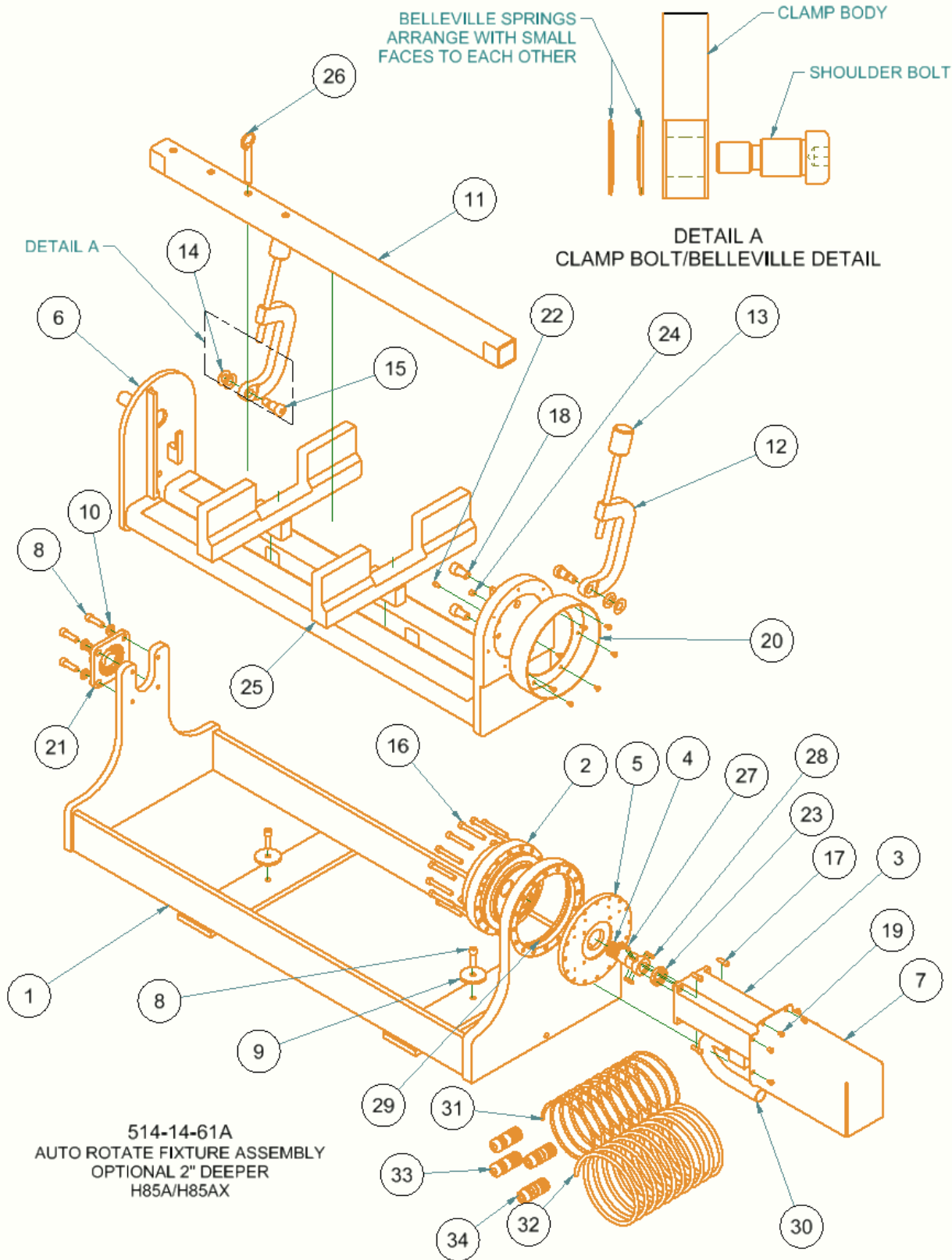
514-7E
BLOCK HOLD DOWN FIXTURE
ASSEMBLY
OPTIONAL 2" DEEPER





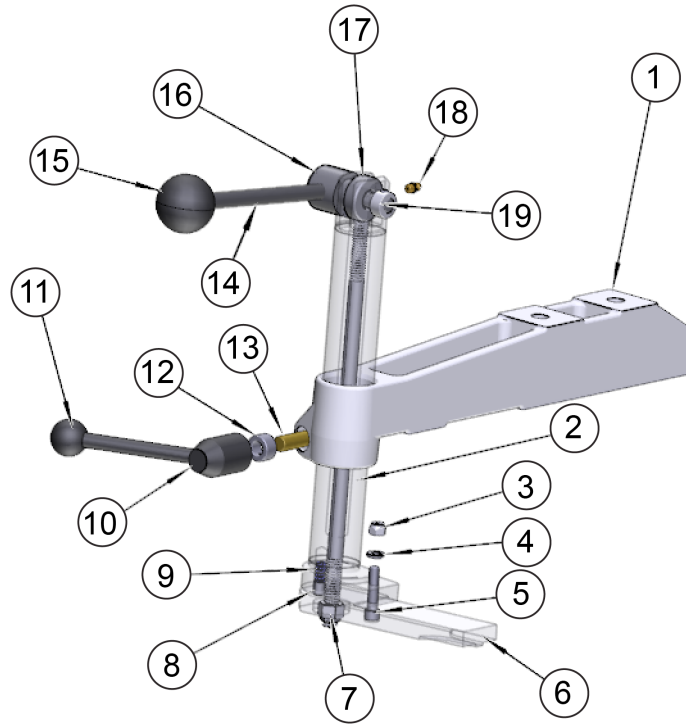
514-7E BLOCK HOLD DOWN FIXTURE ASSEMBLY (OPT. 2" DEEPER) - HONE			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	514-3-72A	PIN, SPRING RETAINER, BLOCK HOLD DOWN FIXTURE
2	1	514-3-34A	SPRING, EXTENSION - BLOCK HOLD DOWN FIXTURE
4	4	MF-39	7/16-14UNC x 1" LG. S.H.C.S.
5	1	514-3-56A	INDEX PIN SUPPORT - BLOCK HOLD DOWN FIXTURE HONE
6	1	514-7-9B	INDEX PIN - BLOCK HOLD DOWN FIXTURE - HONE
7	1	MF-227A	5/16" x 1-1/4" LG. ROLL PIN
8	1	MF-227B	5/16" x 3/4" LG. ROLL PIN
9	1	514-3-58A	HANDLE, INDEX - BLOCK HOLD DOWN FIXTURE - HONE
10	1	514-3-59B	HANDLE, PIVOT ARM - BLOCK HOLD DOWN FIXTURE & V6/V8 AIR FIXTURE
11	1	514-3-70	SPRING, HANDLE RETURN
12	4	MF-17	1/4-20UNC x 1-1/2" LG. S.H.C.S.
13	2	MF-226	1/4" x 1" LG. ROLL PIN
14	1	MF-46A	5/8-11UNC x 1-1/2" LG. S.H.C.S.
15	1	MF-166	5/8-11UNC HEX NUT
16	2	7223	CLAMP ASSEMBLY - MANUAL V6/V8 COMB. FIXTURE
17	4	514-7-21	Bellville Spring
18	2	514-7-22A	5/8 x 3/4" LG. SOCKET SHOULDER SCREW
19	2	514-7-10A	CLAMP ARM (MACHINING), BLOCK HOLD DOWN FIXTURE - HONE
20	2	514-7-1C	WASHER, HOLDDOWN - BLOCK HOLDDOWN FIXTURE - HONE
21	2	MF-32	S.H.C.S.3/8 - 16 UNC - 1 1/4
22	1	514-7-1E	MAIN FRAME REDESIGN (MACHINING)
23	2	514-7-15	SUPPORT, BLOCK - BLOCK HOLD DOWN FIXTURE
24	1	514-3-59C	1/2-13UNC ACORN NUT
25	1	514-7-14B	BAR, CLAMP - HOLD DOWN FIXTURE
26	2	514-3-56B	TERCITE PAD
27	1	MF-189	1/4-28 STRAIGHT LUBE GREASE FITTINGS
28	1	514-7-3D	MANUAL CRADLE HANDLE (MACHINING), HONE
29	1	514-13-14R	H70 - FIXTURE CRADLE MACHINING - SPECIAL 2" DEEPER
30	1	MF-229B	3/8" x 1" LG. ROLL PIN
31	2	650-4-49	M14x2 x 25
32	2	7212C	5/16-18UNC x .50" LG. SOCKET HALF DOG SET SCREW
33	2	7210C	PIN, GUIDE ROTTLER LEVELING TABLE
34	2	514-7-13	BLOCK, FLANGE, BLOCK HOLDDOWN FIXTURE

514-14-61A Automatic Programmable Roll Over Fixture Parts



514-14-61A - AUTO ROTATE FIXTURE ASSEMBLY - OPT. 2" DEEPER - H85A/H85AX			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-13-14A	H75 - AUTOMATIC FIXTURE BASE - MACHINING
2	1	5506C	REDUCTION GEARBOX - P69
3	1	650-3-93B	SERVO MOTOR, TILT - HEAD PORTING FIXTURE - F60
4	1	5506D	INPUT GEAR (REWORK) - REDUCTION GEARBOX - P69
5	1	514-13-14J	MOTOR GEAR BOX ADAPTOR
6	1	514-13-14R	H70 - FIXTURE CRADLE MACHINING - SPECIAL 2" DEEPER
7	1	514-13-14M	MOTOR COVER
8	6	MF-32	S.H.C.S.3/8 - 16 UNC - 1 1/4
9	2	514-7-1C	WASHER, HOLDDOWN - BLOCK HOLDDOWN FIXTURE - HONE
10	4	MF-179A	3/8" FLAT WASHER
11	1	514-7-14B	BAR, CLAMP - HOLD DOWN FIXTURE
12	2	514-7-10A	CLAMP ARM (MACHINING), BLOCK HOLD DOWN FIXTURE - HONE
13	2	7223	CLAMP ASSEMBLY - MANUAL V6/V8 COMB. FIXTURE
14	4	514-7-21	Bellville Spring
15	2	514-7-22A	5/8" x 3/4" HEX SOCKET SHOULDER SCREW
16	16	MF-38B	S.H.C.S.5/16 - 18 UNC - 2 1/4
17	4	MF-14	S.H.C.S.1/4 - 20 UNC - 3/4
18	2	650-4-49	M14x2 x 25mm S.H.C.S.
19	13	MF-88	Socket Button Head10 - 24 x 3/8
20	1	514-13-14K	GEAR BOX COVER
21	1	514-13-14L	MOUNTED BEARING
22	1	MF-189	1/4-28 STRAIGHT LUBE GREASE FITTINGS
23	1	650-3-61N	OIL SEAL
24	1	MF-233	Countersunk Hex-Head Plug 1/8
25	2	514-7-15	SUPPORT, BLOCK - BLOCK HOLD DOWN FIXTURE
26	1	514-14-60A	STOP HITCH PIN
27	3	5506G	SET SCREW REWORK 1/4-20
28	6	5506Q	1/4-20UNC x 3/16" LG. SOCKET FLAT POINT SET SCREW
29	1	5506U	O-RING, GEARBOX
30	8 FT.	502-11-13C	TUBING, BLACK VINYL 1"
31	27 FT.	9020U	COMMUNICATION (ENCODER) CABLE
32	25 FT.	9020X	SMALL POWER CABLE
33	2	9020V	CONNECTOR, 12 PIN BISS ENCODER
34	2	9020W	CONNECTOR, POWER

502-1-30H Clamp Arm Assembly
 Sold as a pair



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	502-1-22G 502-1-22H	CLAMP ARM – LEFT CLAMP ARM – RIGHT
2	1	502-1-31C	LEG, CLAMP – 14 1/2" LONG
3	1	MF-187	NYLOCK NUT, 5/16-18
4	1	MF-184	LOCK WASHER, 5/16"
5	1	MF-25	S.H.C.S. 5/16-18 X 1 1/2"
6	1	502-1-24G	SHOE, CLAMP – HEAVY DUTY
7	1	502-1-25B	LOCKNUT, EYE BOLT, 1/2-13
8	1	MF-211	DOWEL PIN, 3/8 X 1/2"
9	1	500-33	SPRING, CLAMP LEG
10	1	514-2-39C	HANDLE, ADJUSTABLE CLAMP, STOP
11	1	514-2-39E	HANDLE, ADJUSTABLE CLAMP
12	1	7209J	COLLAR, 1/2" SHAFT
13	1	514-4-5B	STUD – CLAMP HANDLE
14	1	502-1-27	ARM, HANDLE – BLOCK CLAMP
15	1	502-1-28	KNOB, PLASTIC BALL – BLOCK CLAMP
16	1	502-1-29L 502-1-29R	CAM BODY, LEFT HAND CAM BODY, RIGHT HAND
17	1	502-1-25A	EYE BOLT ASSEMBLY
18	1	MF-189	STRAIGHT LUBE GREASE FITTING, 1/4-28
19	1	502-1-29A	COLLAR (15/32 ID), CLAMP LEG

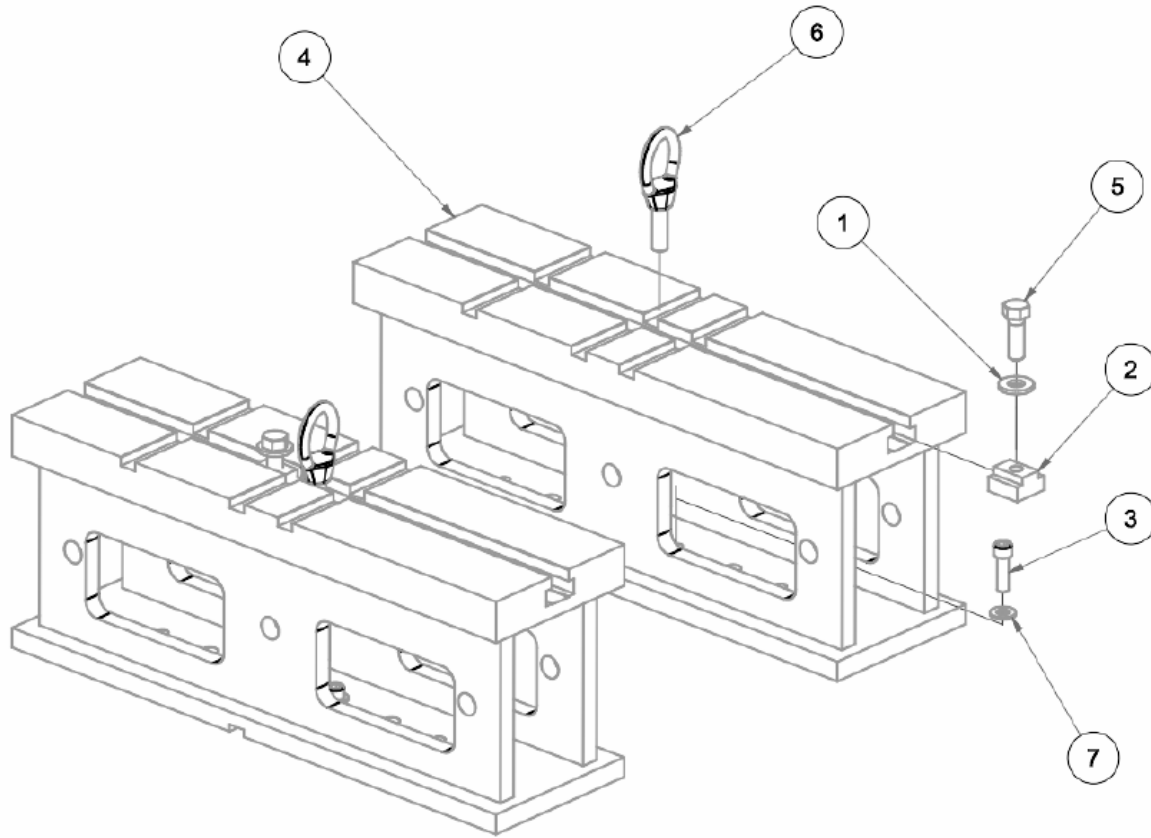
514-7-14E Small Diameter, 2" (508mm), Main Line Bar



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

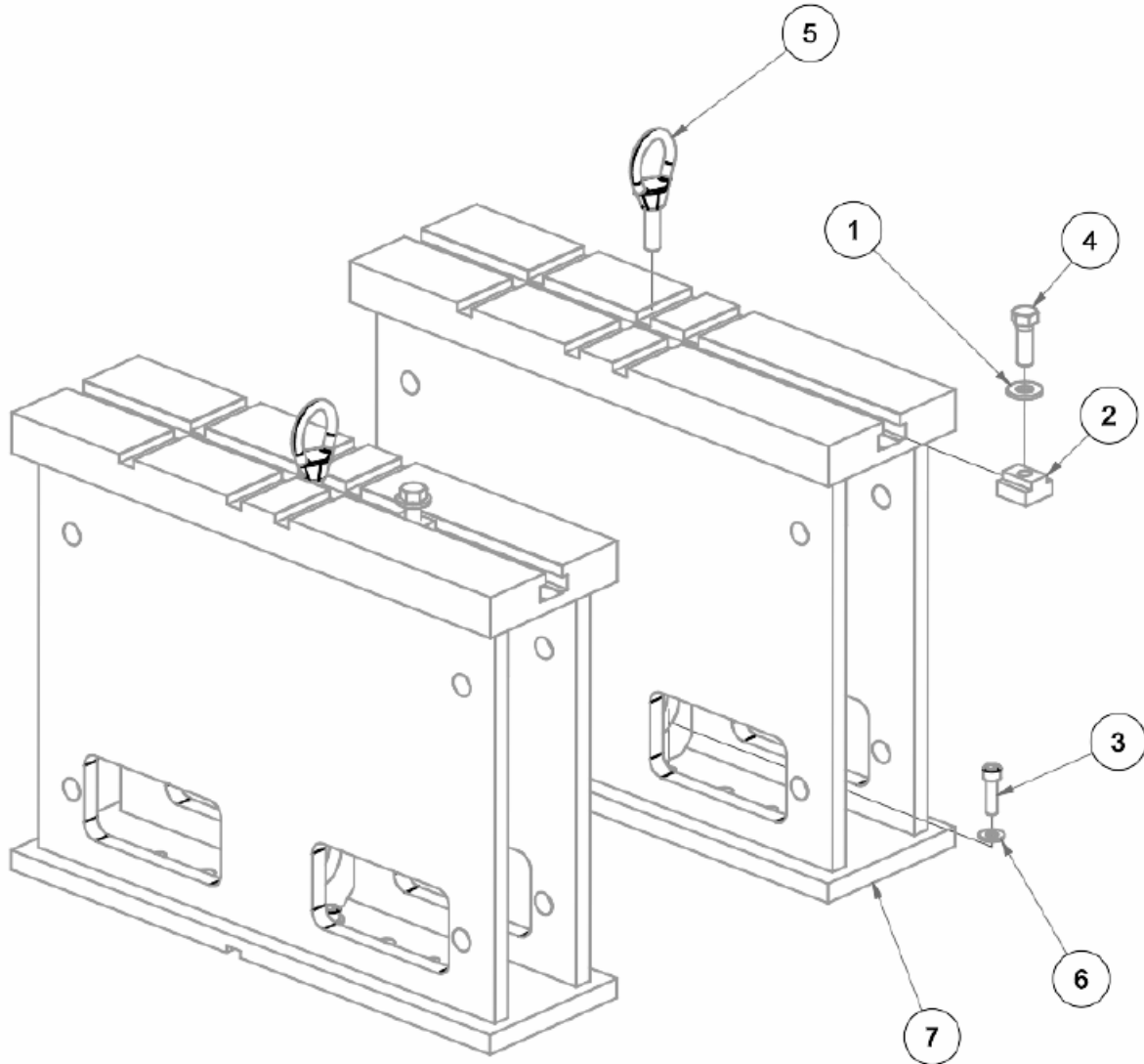


11112C Universal 8" (203mm) Heavy Duty T-Slot Parallels Parts



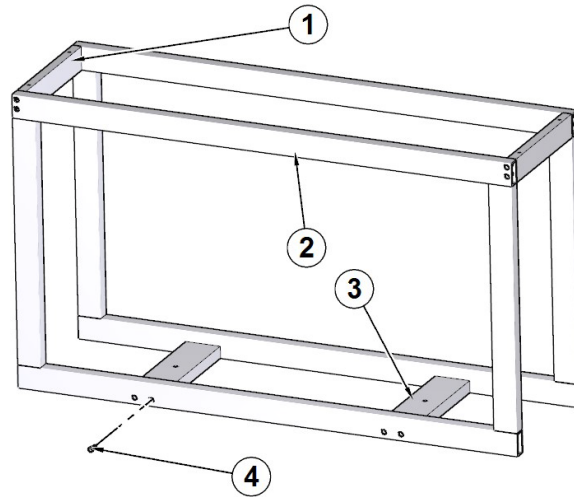
11112C 8" PARALLEL ASSEMBLY - HONE			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	100-19A	Hardened washer 17/32 I.D.
2	2	502-1-11B	T-Nut 3/4"
3	2	MF-33	3/8-16UNC x 1-1/4" LG. S.H.C.S.
4	2	11112D	8" SUPPORT PARALLEL REWORK - HONES
5	2	MF-150A	1/2-13UNC x 1-1/2" LG. HEX BOLT
6	2	502-3-13	Lift Eye
7	2	MF-178	SAE 3/8" FLAT WASHER

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



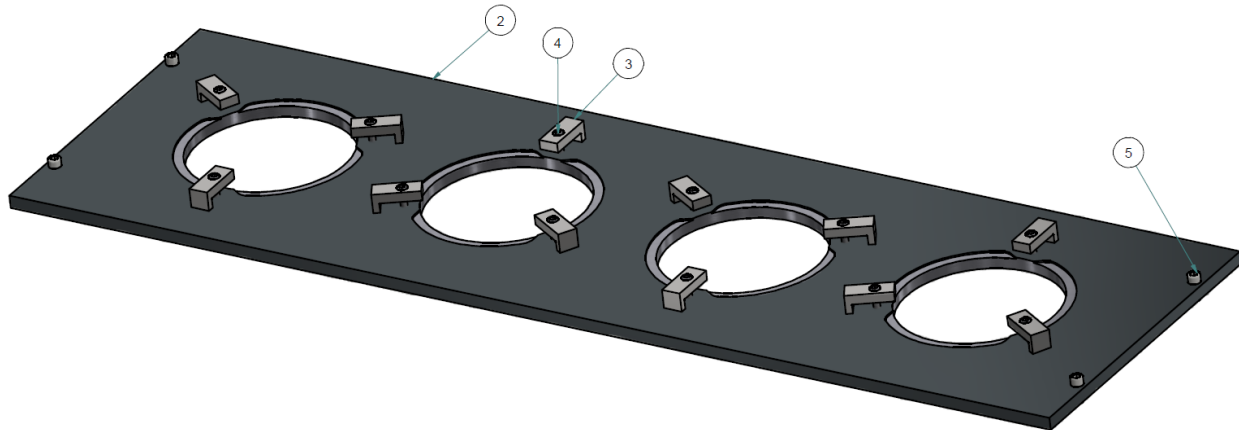
11114C 16" PARALLEL ASSEMBLY - HONE			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	100-19A	Hardened washer 17/32 I.D.
2	2	502-1-11B	T-Nut 3/4"
3	2	MF-33	3/8-16UNC x 1-1/4" LG. S.H.C.S.
4	2	MF-150A	1/2-13UNC x 1-1/2" LG. HEX BOLT
5	2	502-3-13	Lift Eye
6	2	MF-178	SAE 3/8" FLAT WASHER
7	2	11114D	16" SUPPORT PARALLEL REWORK - HONES

Cylinder Sleeve Fixtures
514-11-5 Cylinder Liner Honing Fixture



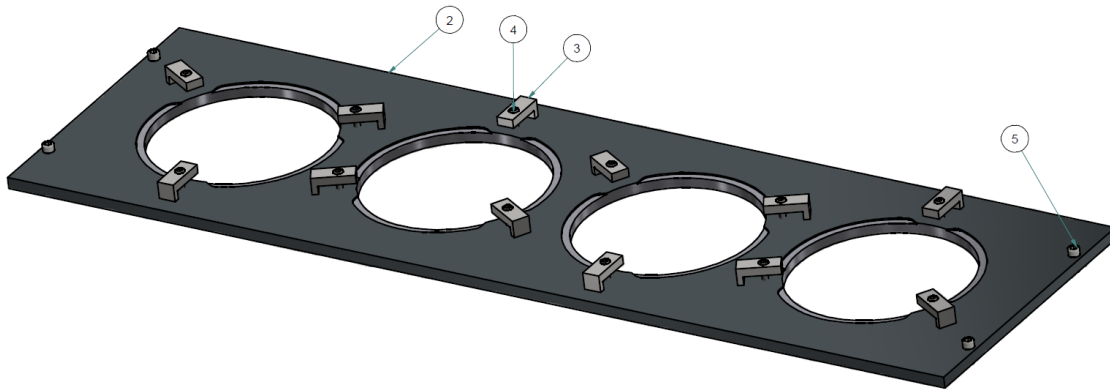
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	514-11-1D	UPPER CROSS BAR
2	2	514-11-5B	SIDE, SLEEVE FIXTURE
3	2	514-11-1E	LOWER CROSS BAR
4	8	MF-21	S.H.C.S. 5/16-18 X 5/8"

514-11-6 Fixture Plate, CAT 3400 Cylinder Sleeve



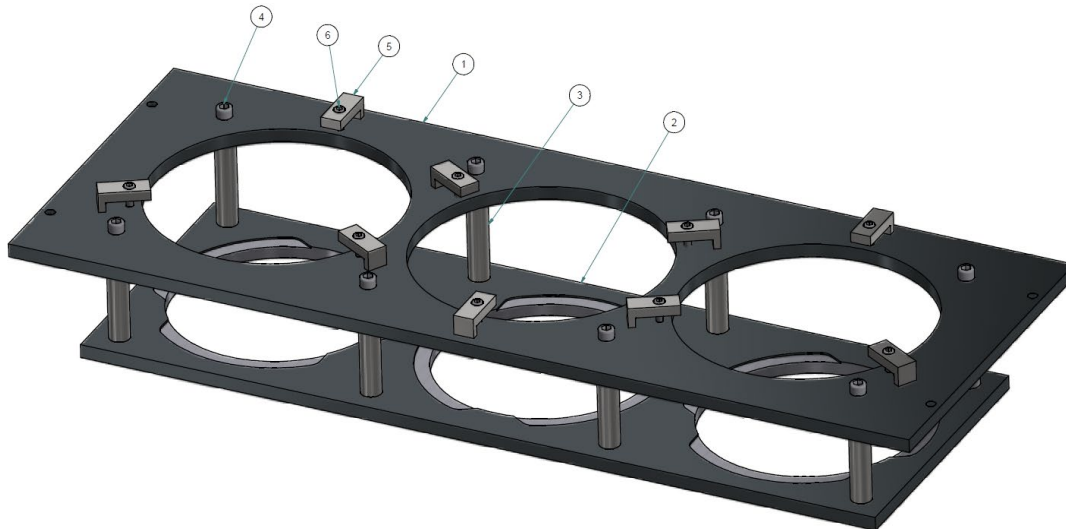
ITEM	QTY	PART NUMBER	DESCRIPTION
2	1	514-11-6B	PLATE, CAT 3400 SLEEVE FIXTURE
3	12	514-11-2C	CLAMP, FIXTURE PLATE
4	12	MF-15	S.H.C.S. 1/4-20 X 1"
5	4	MF-22	S.H.C.S. 5/16-18 X 3/4"

514-11-7 Fixture Plate, CAT 3500 Cylinder Sleeve



ITEM	QTY	PART NUMBER	DESCRIPTION
2	1	514-11-7A	3400 SLEEVE TOP PLATE FIXTURE
3	12	514-11-2C	CLAMP, FIXTURE PLATE
4	12	MF-15	S.H.C.S. 1/4-20 X 1"
5	4	MF-22	S.H.C.S. 5/16-18 X 3/4"

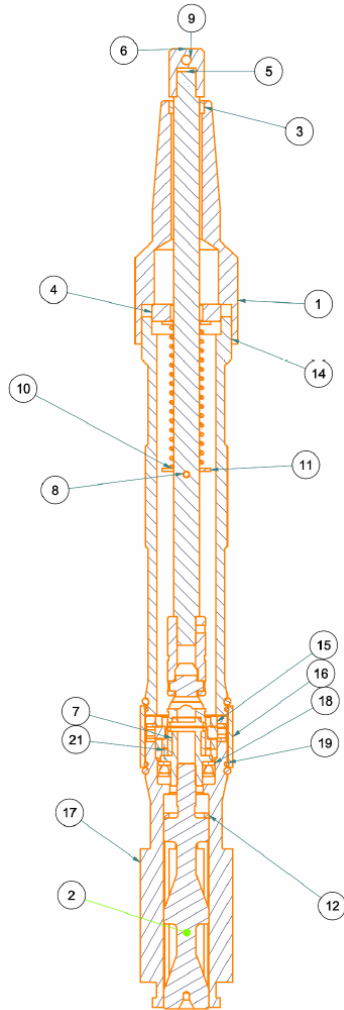
514-11-4 Fixture Plate, CAT C175 Cylinder Sleeve



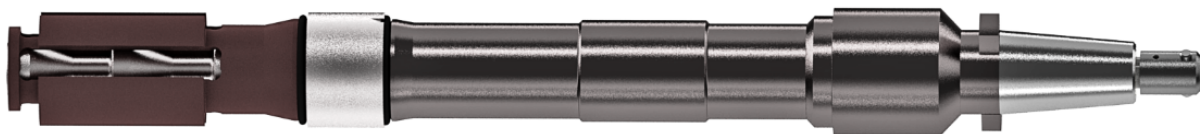
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-11-4A	FIXTURE PLATE TOP – CAT C175 SLEEVE
2	1	514-11-4C	UPPER PLATE, CAT C175 FIXTURE
3	8	514-11-4E	SPACER, CAT C175 SLEEVE FIXTURE
4	8	MF-38	S.H.C.S. 3/8-16 X 5"
5	9	514-11-2C	CLAMP, FIXTURE PLATE
6	9	MF-15	S.H.C.S. 1/4-20 X 1"

Hone Heads

514-11-10 Small Precision 4-Stone Hone Head



ITEM	QTY	PARTNUMBER	DESCRIPTION
1	1	514-13-49	KWIK SWITCH TAPER
2	1	514-10-2A	Cone Rod, Junior Head
3	1	514-7-80T	OIL UTE BUSHING
4	1	514-7-82L	DRIVE CONNECTOR - DRIVE TUBE - H75
5	1	514-10-20B	
6	1	514-6-44	DRIVEN COUPLING - HONE#2
7	1	514-10-SA	U-JOINT ASSEMBLY - JUNIOR PRECISION HONE HEAD
8	2	MF-218	
9	1	MF-198A	
10	1	514-5-72A	SPRING COMPRESSION LARGE HONE HEAD
11	2	100-19	Washer
12	1	514-10-9	
13	1	MF-217	Pin - Slotted Spring
14	1	514-11-108	
15	1	514-11-10C	PIVOT BLOCK UNIVERSAL SMALL PRECISION HONE HEAD
16	1	514-11-10D	HONE SLEEVE
17	1	514-11-10A	SMALL PRECISION HONE HEAD
18	1	514-7-82F	THRUST WASHER
19	2	514-11-10F	
20	2	514-11-10E	
21	4	514-11-10G	PIVOTSCREW

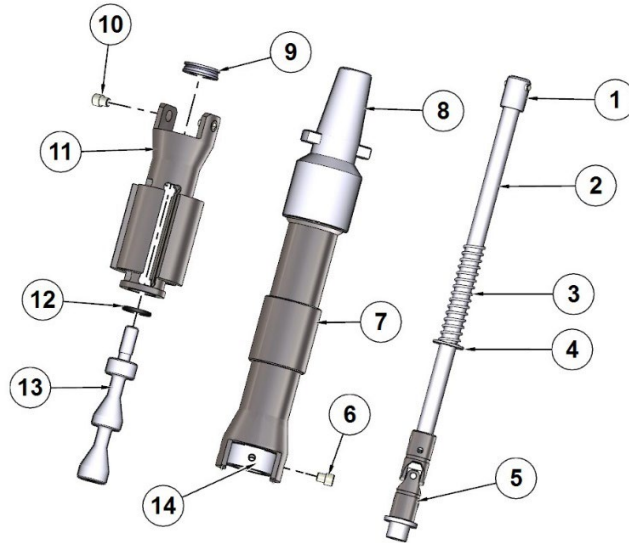


*** Measurements are absolute maximums and minimums when using new stones. Rottler recommends having a minimum of 0.010" clearance for entering/exiting the bore when manually operating the machine, and a minimum of 0.150" clearance when operating the machine in an automatic hole-to-hole cycle.**

Holder PN	0.200" Stones		0.312" Stones	
	Min Dia in (mm)	Max Dia in (mm)	Min Dia in (mm)	Max Dia in (mm)
514-10-13A	1.964 (49.89)	2.226 (56.54)	2.188 (55.58)	2.450 (62.23)
514-10-13K	1.930 (49.02)	2.192 (55.67)	2.154 (54.71)	2.416 (61.36)
514-10-13J	1.896 (48.16)	2.158 (54.81)	2.120 (53.85)	2.382 (60.50)

514-9J Medium Precision 4-Stone Hone Head

18.5" (470mm) Overall Length



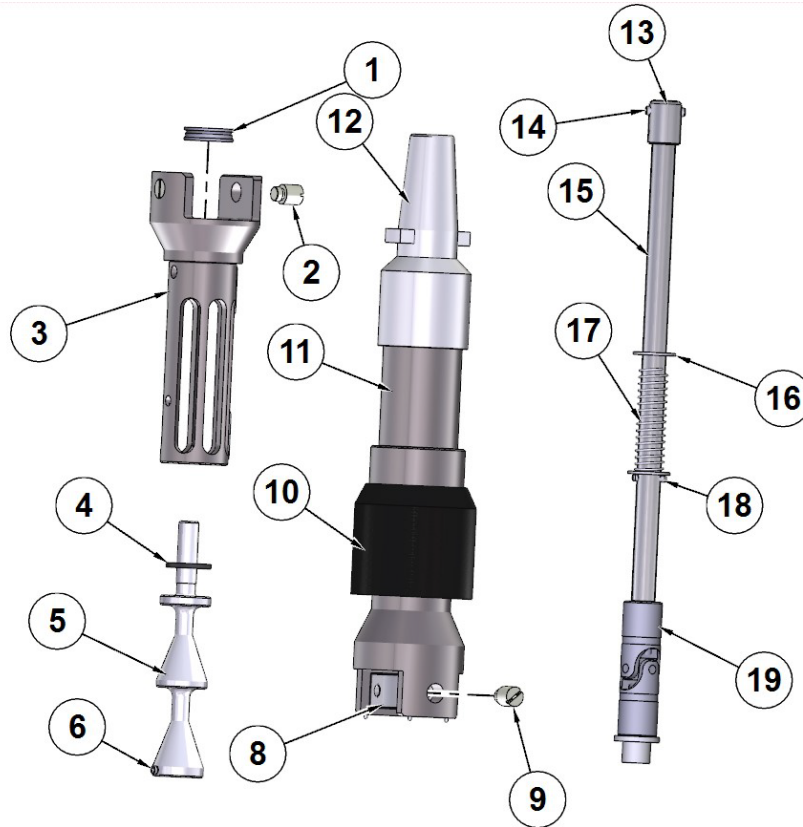
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-6-44	COUPLING, DRIVEN
2	1	514-10-20B	SHAFT, ADJUSTING
3	1	514-5-72A	SPRING, COMPRESSION
4	1	100-19	WASHER, THRUST
5	1	514-10-5A	JOINT, UNIVERSAL ASSY
6	2	514-10-10	SCREW, PIVOT
7	1	514-10-20A	YOKE
8	1	514-13-49	ADAPTER, KWIK SWITCH
9	1	514-7-82F	BEARING, THRUST
10	2	514-10-10	SCREW, PIVOT
11	1	514-10-1A	BODY
12	1	7209H	BUMPER
13	1	514-10-2A	CONE ROD
14	1	514-10-6	BLOCK, PIVOT

514-9N Single Stage, 12-Stone Hone Head



514-9Q Large Precision 6-Stone Hone Head

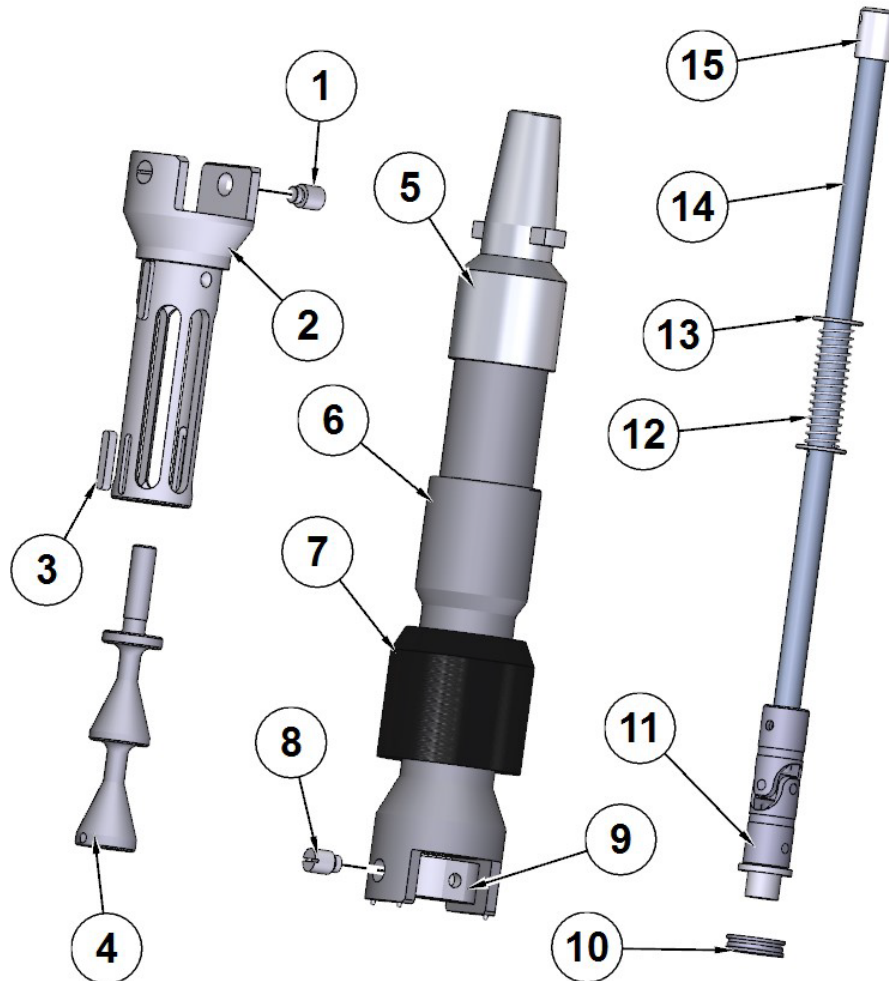
19.5" (496mm) Overall Length



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-7-82F	BEARING, THRUST
2	2	514-5-66G	PIN, THREADED
3	1	514-9-10D	BODY, LARGE HEAVY DUTY HONE HEAD
4	1	514-7-82G	RING, SQUARE CROSS SECTION
5	1	514-9-7A	CONE ROD
6	1	MF-223C	ROLL PIN, 3/16 X 5/8"
8	1	514-7-81S	PIVOT BLOCK
9	2	514-5-66G	PIN, THREADED
10	1	514-9-10G	COVER, HONE HEAD U-JOINT
11	1	514-7-81T	YOKE, DRIVE SHAFT
12	1	514-13-49	ADAPTER, KWIK SWITCH
13	1	514-6-44	COUPLING, DRIVEN
14	1	MF-198A	DOWEL PIN, 3/16 X 7/8"
15	1	514-7-81U	SHAFT, ADJUSTING HONE HEAD
16	2	100-19	WASHER, THRUST
17	1	514-5-72A	SPRING, COMPRESSION
18	1	MF-219	ROLL PIN, 1/8 X 3/4"
19	1	514-9-8A	JOINT, UNIVERSAL ASSY

514-9S Large Precision 6-Stone Hone Head

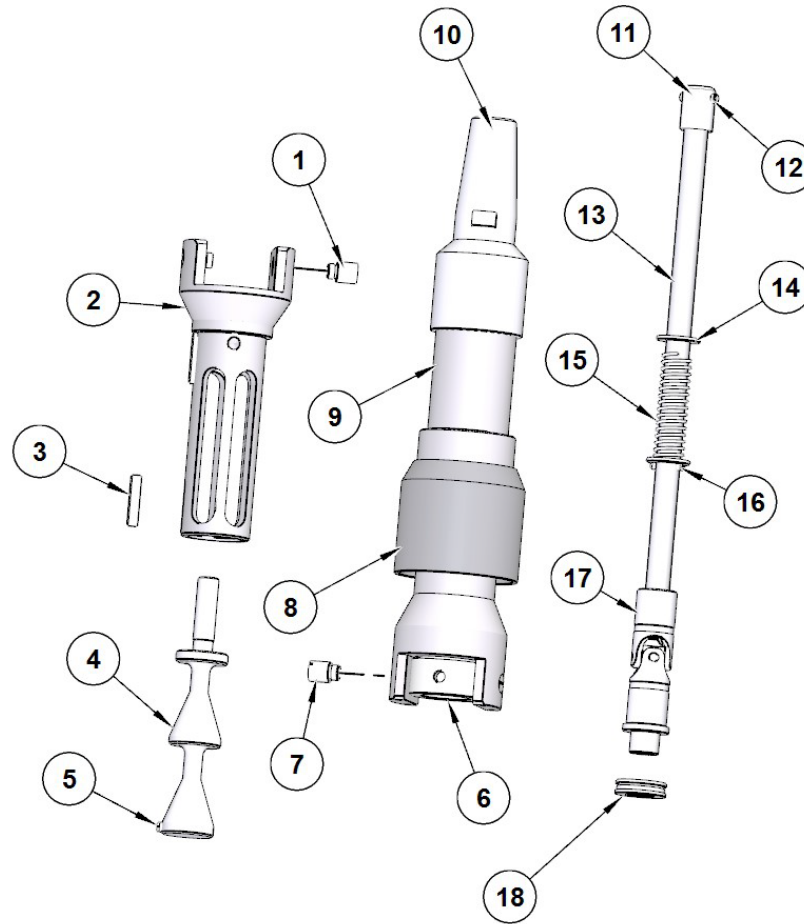
21.5" (547mm) Overall Length



ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	514-5-66G	PIN, THREADED
2	1	514-9-10D	BODY, LARGE HEAVY DUTY HONE HEAD
3	1	514-7-83C	KEY, SLEEVE
4	1	514-9-7A	CONE ROD
5	1	514-13-49	ADAPTER, KWIK SWITCH
6	1	514-7-81R	YOKE, DRIVE SHAFT
7	1	514-9-10G	COVER, HONE HEAD U-JOINT
8	2	514-5-66G	PIN, THREADED
9	1	514-7-81S	PIVOT BLOCK
10	1	514-7-82F	BEARING, THRUST
11	1	514-9-8A	JOINT, UNIVERSAL ASSY
12	1	514-5-72A	SPRING, COMPRESSION
13	2	100-19	WASHER, THRUST
14	1	514-7-81B	SHAFT, ADJUSTING HONE HEAD
15	1	514-6-44	COUPLING, DRIVEN

514-9P Large Precision 4-Stone Hone Head

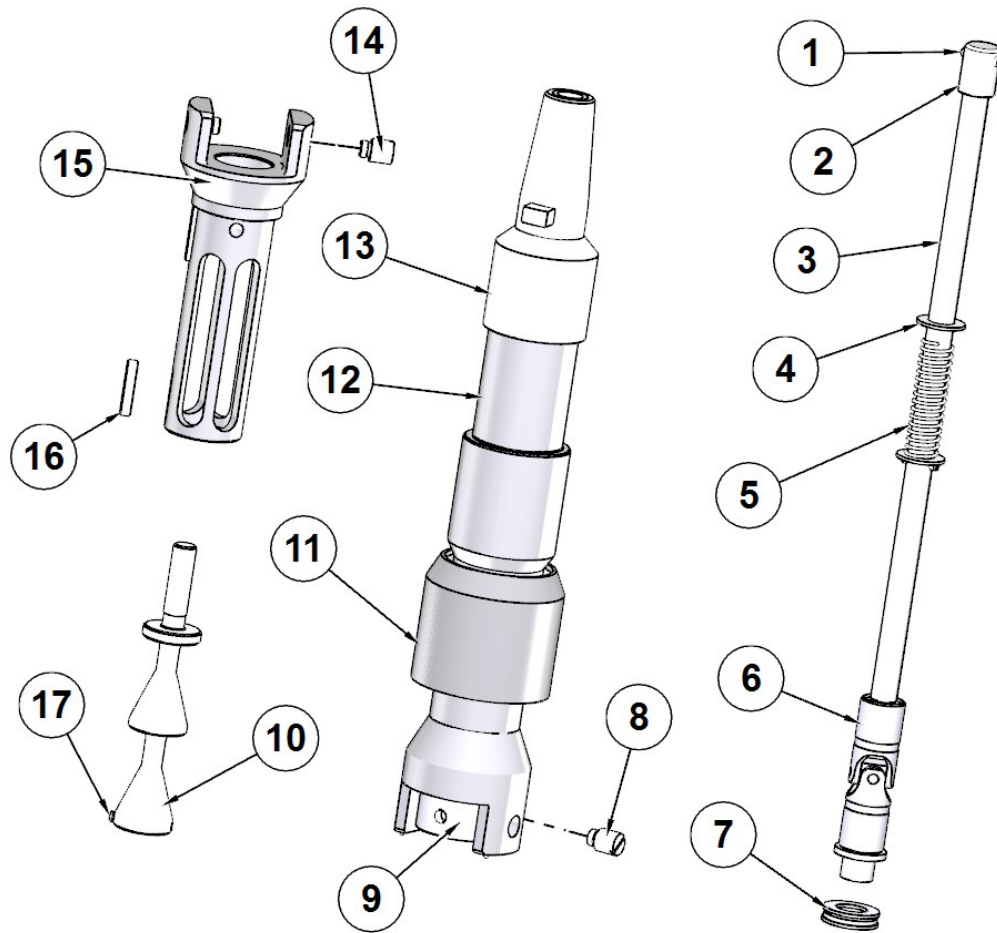
19.5" (496mm) Overall Length



ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	514-5-66G	PIN, THREADED
2	1	514-9-10E	BODY, LARGE HEAVY DUTY HONE HEAD
3	1	514-7-83C	KEY, SLEEVE
4	1	514-9-7A	CONE ROD
5	1	MF-223C	ROLL PIN 3/16 X 5/8"
6	2	514-7-81S	PIVOT BLOCK
7	1	514-7-66G	PIN, THREADED
8	1	514-9-10G	COVER, HONE HEAD U-JOINT
9	1	514-7-81T	YOKE, DRIVE SHAFT
10	1	514-13-49	ADAPTER, KWIK SWITCH
11	1	514-6-44	COUPLING, DRIVEN
12	1	MF-198A	DOWEL PIN 3/16 X 7/8"
13	1	514-7-81U	SHAFT, ADJUSTING HONE HEAD
14	2	100-19	WASHER, THRUST
15	1	514-5-72A	SPRING, COMPRESSION
16	1	MF-219	ROLL PIN 1/8 X 3/4"
17	1	514-9-8A	JOINT, UNIVERSAL ASSY
18	1	514-7-82F	BEARING, THRUST

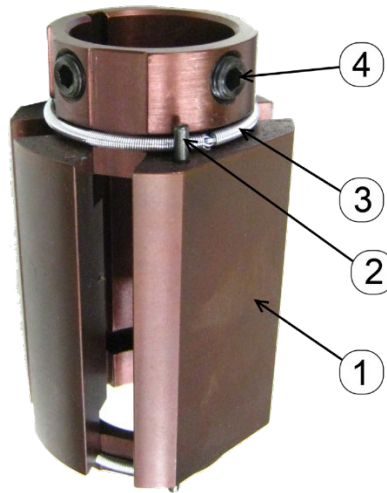
514-9R Large Precision 4-Stone Hone Head

21.5" (547mm) Overall Length



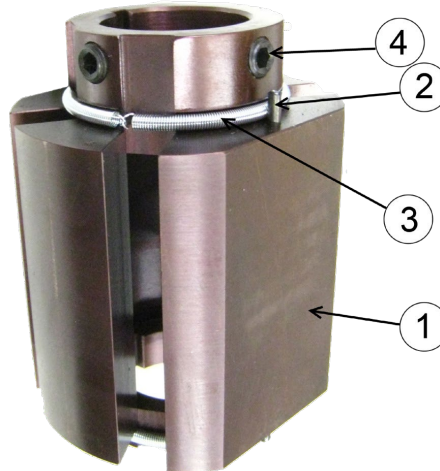
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	MF-198A	DOWEL PIN, 3/16 X 7/8"
2	1	514-6-44	COUPLING, DRIVEN
3	1	514-7-81B	SHAFT, ADJUSTING HONE HEAD
4	2	100-19	WASHER, THRUST
5	1	514-5-72A	SPRING, COMPRESSION
6	1	514-9-8A	JOINT, UNIVERSAL ASSY
7	1	514-7-82F	BEARING, THRUST
8	2	514-5-66G	PIN, THREADED
9	1	514-7-81S	PIVOT BLOCK
10	1	514-9-7A	CONE ROD
11	1	514-9-10G	COVER, HONE HEAD U-JOINT
12	1	514-7-81R	YOKE, DRIVE SHAFT
13	1	514-13-49	ADAPTER, KWIK SWITCH
14	2	514-5-66G	PIN, THREADED
15	1	514-9-10E	BODY, LARGE HEAVY DUTY HONE HEAD
16	1	514-7-83C	KEY, SLEEVE
17	1	MF-223C	ROLL PIN 3/16 X 5/8"

514-9-4A Sleeve Assembly, 4-Stone, 2.75-3.88" Dia.



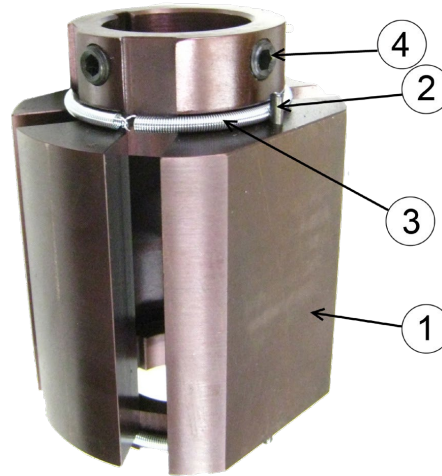
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-9-3A	SLEEVE, 2.75-3.56" DIA
2	1	MF-217	ROLL PIN, 1/8 X 1/2"
3	2	514-7-83K	SPRING, GARTER
4	2	514-7-83D	SOCKET SET SCREW, CONE POINT

514-9-4B Sleeve Assembly, 4-Stone, 3.50-4.67" Dia.



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-9-3B	SLEEVE, 3.50-4.32" DIA
2	1	MF-217	ROLL PIN, 1/8 X 1/2"
3	2	514-7-83K	SPRING, GARTER
4	2	514-7-83D	SOCKET SET SCREW, CONE POINT

514-9-4C Sleeve Assembly, 4-Stone, 4.25-5.00” Dia.



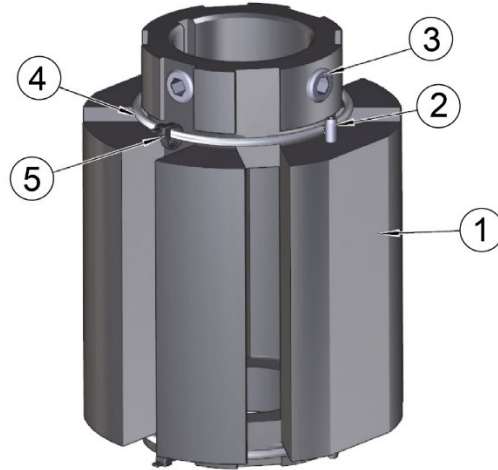
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-9-3C	SLEEVE, 4.25-5.00” DIA
2	1	MF-217	ROLL PIN, 1/8 X 1/2”
3	2	514-7-83E	SPRING, GARTER
4	2	514-7-83D	SOCKET SET SCREW, CONE POINT

514-9-4E Sleeve Assembly, 6-Stone, 2.77-3.88” Dia.



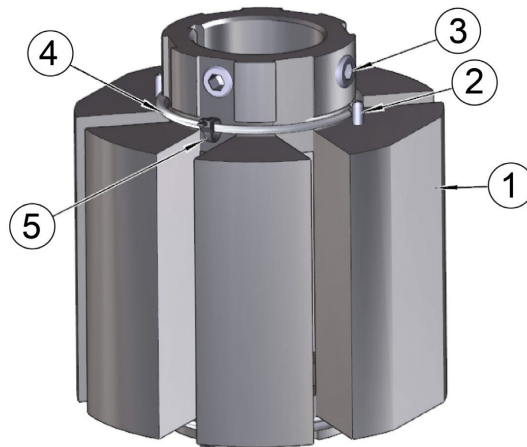
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-9-3E	SLEEVE, 3.50-4.32” DIA
2	1	MF-217	ROLL PIN, 1/8 X 1/2”
3	2	514-7-83D	SOCKET SET SCREW, CONE POINT
4	2	514-7-83K	SPRING, GARTER
5	4	6147D	TYRAP

514-9-4F Sleeve Assembly, 6-Stone, 3.67-4.36" Dia.



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-9-3F	SLEEVE, 3.50-4.32" DIA
2	1	MF-217	ROLL PIN, 1/8 X 1/2"
3	2	514-7-83D	SOCKET SET SCREW, CONE POINT
4	2	514-7-83K	SPRING, GARTER
5	4	6147D	TYRAP

514-9-4G Sleeve Assembly, 6-Stone, 4.42-7.38" Dia.



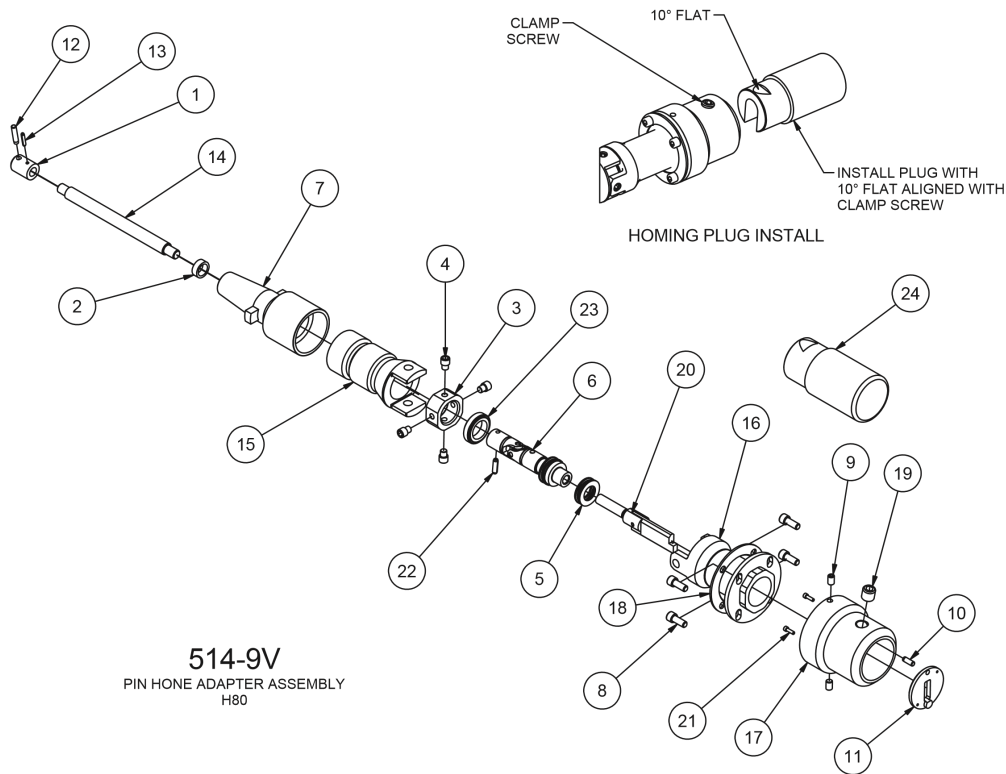
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-9-3G	SLEEVE, 3.50-4.32" DIA
2	1	MF-217	ROLL PIN, 1/8 X 1/2"
3	2	514-7-83D	SOCKET SET SCREW, CONE POINT
4	2	514-7-83K	SPRING, GARTER
5	4	6147D	TYRAP

514-14-87 Lifter Honing Mandrel Kit



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-9L	MANDREL, 0.827-1.062"
2	1	514-12-5	ABRASIVE STONES .827-.945"
3	1	514-12-6	ABRASIVE STONES .945-1.062"
4	1	514-12-3	SMALL LIFTER BORE HONING SLEEVE - 0.950"
5	1	514-12-4	SMALL LIFTER BORE HONING SLEEVE - 1.065"

514-9V Pin Hone Adapter



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-6-44	DRIVEN COUPLING – HONE #2
2	1	514-7-80T	OILITE BUSHING
3	1	514-10-6	PIVOT BLOCK, UNIVERSAL, JUNIOR PREC. HONE HEAD
4	4	514-10-10	PIVOT SCREW
5	1	514-7-82F	THRUST WASHER
6	1	514-10-5B	U-JOINT ASSEMBLY – PIN HONE ADAPTER
7	1	514-13-49	KWIK SWITCH TAPER
8	4	MF-13	S.H.C.S. ¼-20 X 5/8"
9	2	514-10-1E	SOCKET SET SCREW, FLAT POINT, ¼-28 X 3/8"
10	1	MF-196	DOWEL PIN 3/16 X 1/2"
11	1	514-10-3D	BACKING PLATE, PIN HONE ADAPTER ASSY
12	1	MF-198A	DOWEL PIN 3/16 X 7/8"
13	1	MF-218	ROLL PIN 1/8 X 5/8"
14	1	514-10-20C	ADJUSTING SHAFT – PIN HONE ADAPTER ASSY
15	1	514-10-20D	YOKE DRIVE TUBE, PIN HONE ADAPTER
16	1	514-10-1B	UPPER BODY, PIN HONE ADAPTER ASSY
17	1	514-10-1C	LOWER BODY, PIN HONE ADAPTER ASSY
18	1	514-10-1D	CLAMP PLATE, PIN HONE ADAPTER ASSY
19	1	6855P	SOCKET SET SCREW, FLAT POINT, 1/2-13 X 1/2"
20	1	514-10-3E	ACTUATOR ASSEMBLY, PIN HONE ADAPTER ASSY
21	2	MF-84D	S.H.C.S. #4-40 X 3/8"
22	1	MF-223C	ROLL PIN 3/16 X 5/8"
23	1	514-10-1F	NUT, THRUST BEARING – PIN HONE ADAPTER
24	1	514-10-1G	HOMING PLUG, PIN HONE ADAPTER

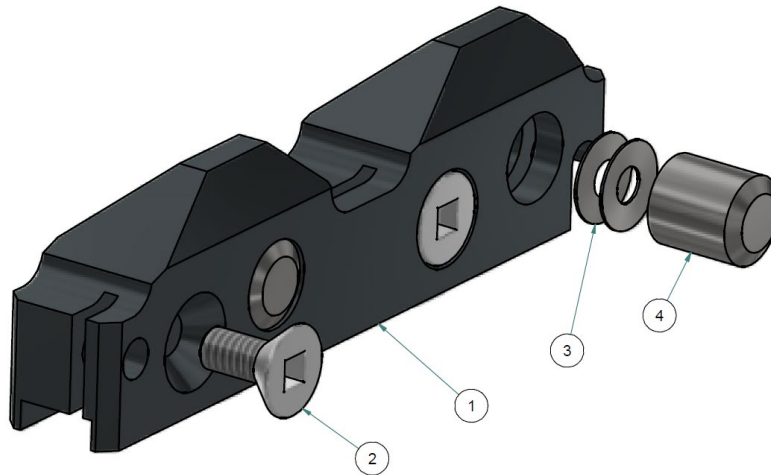


Stone Holders

Stone Holder Size Chart

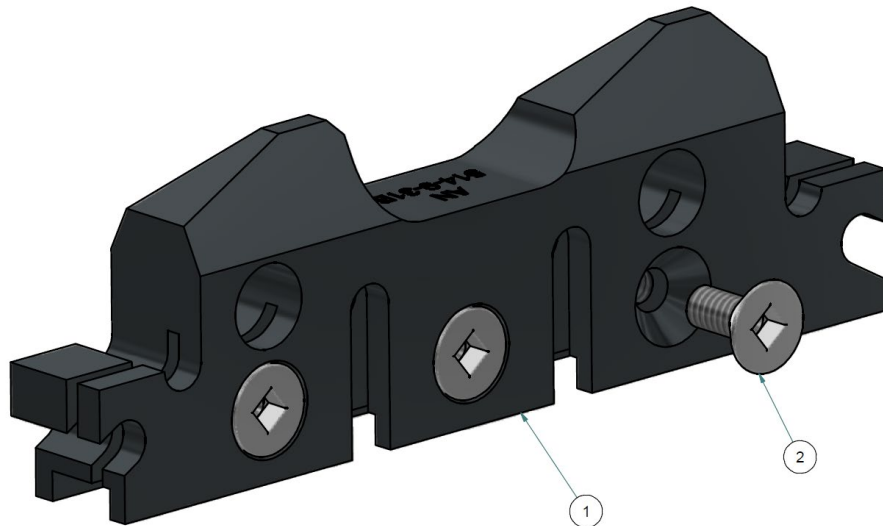
Holder PN	0.200" Stones		0.312" Stones		0.395" Brushes		0.550" Brushes	
	Min Dia in (mm)	Max Dia in (mm)	Min Dia in (mm)	Max Dia in (mm)	Min Dia in (mm)	Max Dia in (mm)	Min Dia in (mm)	Max Dia in (mm)
514-10-13 (4-Stone) Medium Series								
514-10-13A	2.12 (53.75)	2.23 (56.54)	2.34 (59.44)	2.45 (62.23)	2.51 (63.65)	2.62 (66.45)	2.82 (71.53)	2.93 (74.32)
514-10-13F	2.22 (56.29)	2.33 (59.08)	2.44 (61.98)	2.55 (64.77)	2.61 (66.19)	2.72 (68.99)	2.92 (74.07)	3.03 (76.86)
514-10-13B	2.32 (58.83)	2.43 (61.62)	2.54 (64.52)	2.65 (67.31)	2.71 (68.73)	2.82 (71.53)	3.02 (76.61)	3.13 (79.40)
514-10-13G	2.42 (61.37)	2.53 (64.16)	2.64 (67.06)	2.75 (68.85)	2.81 (71.27)	2.92 (74.07)	3.12 (79.15)	3.23 (81.94)
514-10-13C	2.52 (63.91)	2.63 (66.70)	2.74 (69.60)	2.85 (72.39)	2.91 (73.81)	3.02 (76.61)	3.22 (81.69)	3.33 (84.48)
514-10-13H	2.62 (66.45)	2.73 (69.24)	2.84 (72.14)	2.95 (74.93)	3.01 (76.35)	3.12 (79.15)	3.32 (84.23)	3.43 (87.02)
514-10-13D	2.72 (68.99)	2.83 (71.78)	2.94 (74.68)	3.05 (77.47)	3.11 (78.89)	3.22 (81.69)	3.42 (86.77)	3.53 (89.56)
514-9-31 (6-Stone) & 514-9-6 (4-Stone) Large Series								
514-9-31J 514-9-6J	2.77 (70.23)	3.23 (82.04)	2.99 (75.92)	3.45 (87.73)	3.16 (80.14)	3.62 (91.95)	3.47 (88.01)	3.93 (99.82)
514-9-31A 514-9-6A	2.94 (74.70)	3.41 (86.51)	3.17 (80.39)	3.63 (92.20)	3.33 (84.61)	3.80 (96.42)	3.64 (92.48)	4.11 (104.29)
514-9-31B 514-9-6B	3.19 (81.05)	3.66 (92.86)	3.42 (86.74)	3.88 (98.55)	3.58 (90.96)	4.05 (102.77)	3.89 (98.83)	4.36 (110.64)
514-9-31C 514-9-6C	3.44 (87.40)	3.91 (99.21)	3.67 (93.09)	4.13 (104.90)	3.83 (97.31)	4.30 (109.12)	4.14 (105.18)	4.61 (116.99)
514-9-31D 514-9-6D	3.69 (93.75)	4.16 (105.56)	3.92 (99.44)	4.38 (111.25)	4.08 (103.66)	4.55 (115.47)	4.39 (111.53)	4.86 (123.34)
514-9-31E 514-9-6E	3.94 (100.10)	4.41 (111.91)	4.17 (105.79)	4.63 (117.60)	4.33 (110.01)	4.80 (121.82)	4.64 (117.88)	5.11 (129.69)
514-9-31F 514-9-6F	4.19 (106.45)	4.66 (118.26)	4.42 (112.14)	4.88 (123.95)	4.58 (116.36)	5.05 (128.17)	4.89 (124.23)	5.36 (136.04)
514-9-31G 514-9-6G	4.44 (112.80)	4.91 (124.61)	4.67 (118.49)	5.13 (130.30)	4.83 (122.71)	5.30 (134.52)	5.14 (130.58)	5.61 (142.39)
514-9-31H 514-9-6H	4.69 (119.15)	5.16 (130.96)	4.92 (124.84)	5.38 (136.65)	5.08 (129.06)	5.55 (140.87)	5.39 (136.93)	5.86 (148.74)
514-9-31K 514-9-6K	4.94 (125.50)	5.41 (137.31)	5.17 (131.19)	5.63 (143.00)	5.33 (135.41)	5.80 (147.22)	5.64 (143.28)	6.11 (155.09)
514-9-31L 514-9-6L	5.19 (131.85)	5.66 (143.66)	5.42 (137.54)	5.88 (149.35)	5.58 (141.76)	6.05 (153.57)	5.89 (149.63)	6.36 (161.44)
514-9-31M 514-9-6M	5.44 (138.20)	5.91 (150.01)	5.67 (143.89)	6.13 (155.70)	5.83 (148.11)	6.30 (159.92)	6.14 (155.98)	6.61 (167.79)
514-9-31N 514-9-6N	5.69 (144.55)	6.16 (156.36)	5.92 (150.24)	6.38 (162.05)	6.08 (154.46)	6.55 (166.27)	6.39 (162.33)	6.86 (174.14)
514-9-31P 514-9-6P	5.94 (150.90)	6.41 (162.71)	6.17 (156.59)	6.63 (168.40)	6.33 (160.81)	6.80 (172.62)	6.64 (168.68)	7.11 (180.49)
514-9-31Q 514-9-6Q	6.19 (157.25)	6.66 (169.06)	6.42 (162.94)	6.88 (174.75)	6.58 (167.16)	7.05 (178.97)	6.89 (175.03)	7.36 (186.84)
514-9-31R 514-9-6R	6.44 (163.60)	6.91 (175.41)	6.67 (169.29)	7.13 (181.10)	6.83 (173.51)	7.30 (185.32)	7.14 (181.38)	7.61 (193.19)
514-9-31S 514-9-6S	6.69 (169.95)	7.16 (181.76)	6.92 (175.64)	7.38 (187.45)	7.08 (179.86)	7.55 (191.67)	7.39 (187.73)	7.86 (199.54)

514-10-13 Series Stone Holders
 Sold in sets of 4



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	-	STONE HOLDER BODY (ONLY SOLD AS ASSY)
2	2	514-7-81J	SCREW, FLAT HEAD, SQUARE DRIVE
3	4	514-10-11D	SPRING, BELLEVILLE (optional for H85 – required for HP series)
4	2	514-10-11C	PIN, DAMPENING

514-9-31 (Set of 6) & 514-9-6 (Set of 4) Series Stone Holders



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	-	STONE HOLDER BODY (ONLY SOLD AS ASSY)
2	2	514-7-81J	SCREW, FLAT HEAD, SQUARE DRIVE

Stone Sets

Contact Rottler Applications Engineering for assistance with stone selection.

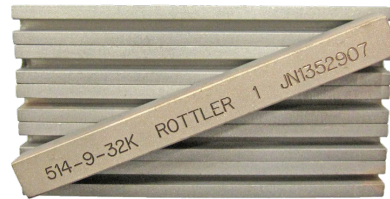
Stones are available in a wide variety of materials, sizes, grits, and lengths.

Below are some examples:

4 Stone Sets:



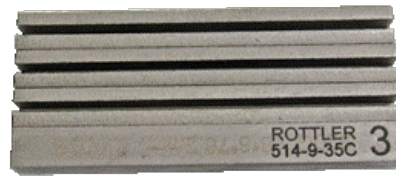
6 Stone Sets:



Diamond Stones:



CBN Stones:



Slotted Style (dual Stick):

End Profile:



T-Style (single stick):

End Profile:



Diamond Stones							
Slotted Style							
4 Stone				6 Stone			
Part No	Grit	Height (in)	Length (in)	Part No	Grit	Height (in)	Length (in)
514-9-14A	200/230	0.312	3	514-9-32A	40	0.312	3
514-9-14C	450	0.312	3	514-9-32B	60	0.312	3
514-9-14E	325/400	0.312	3	514-9-32C	450	0.312	3
514-9-14F	80	0.312	3	514-9-32E	325/400	0.312	3
514-9-14G	600	0.312	3	514-9-32F	80	0.312	3
514-9-14J	270/325	0.312	3	514-9-32G	600	0.312	3
514-9-14K	170	0.312	3	514-9-32J	270/325	0.312	3
514-9-14L	500	0.312	3	514-9-32K	170	0.312	3
514-9-14W	140	0.312	3	514-9-32M	200/230	0.312	3
514-9-21G	800	0.312	3	514-9-32Q	100	0.312	3
514-9-21H	1000	0.312	3	514-9-32T	120	0.312	3
514-9-21J	1200	0.312	3	514-9-32W	140	0.312	3
514-9-21P	60	0.312	3	514-9-33	800	0.312	3
514-9-21Q	100	0.312	3	514-9-33J	1200	0.312	3
514-9-21T	120	0.312	3	514-9-34E	400	0.312	3
514-9-14D	325/400	0.200	3	514-9-34F	80	0.312	3
514-9-21S	80	0.200	3	514-9-34J	270/325	0.312	3
514-9-29F	100	0.200	3	514-9-34K	170/200	0.312	3
514-9-38C	170	0.200	3	514-9-34W	140/170	0.312	3
514-9-14U	450	0.312	2.5	514-9-32D	325/400	0.200	3
514-9-14B	140	0.312	3.5	514-9-33S	80	0.200	3
514-9-14M	170	0.312	3.5	514-9-39J	270/325	0.200	3
514-9-14N	600	0.312	3.5	514-9-39K	170	0.200	3
514-9-14P	500	0.312	3.5	514-9-32R	80	0.312	3.5
514-9-14Q	325/400	0.312	3.5	514-9-33A	800	0.200	3.5
514-9-14R	80	0.312	3.5	514-9-33B	270/325	0.200	3.5
514-9-14T	270/325	0.312	3.5				
514-9-14X	325/400	0.312	4				
514-9-14Z	270/325	0.312	4				
514-9-21M	170	0.312	4				
514-9-21R	80	0.312	4				
514-9-21W	140	0.312	4				
514-9-21X	80	0.200	4				

Diamond Stones							
T Style							
4 Stone				6 Stone			
Part No	Grit	Height (in)	Length (in)	Part No	Grit	Height (in)	Length (in)
514-9-44Q	100	0.312	3	514-9-43Q	100	0.312	3
514-9-44T	120	0.312	3	514-9-43T	120	0.312	3
514-9-44W	140	0.312	3	514-9-43W	140	0.312	3
514-9-44X	140	0.200	3	514-9-43K	170	0.312	3
514-9-44K	170	0.312	3	514-9-43P	60	0.312	3
514-9-44P	60	0.312	3	514-9-43F	80	0.312	3
514-9-44R	80	0.312	3	514-9-43R	80	0.312	3

CBN Stones							
Slotted Style							
4 Stone				6 Stone			
Part No	Grit	Height (in)	Length (in)	Part No	Grit	Height (in)	Length (in)
514-9-35C	320	0.312	3	514-9-35F		0.312	4
514-9-35D	400	0.312	3				
514-9-41B	600	0.200	3				
514-9-35B	600	0.312	3				

CBN Stones							
T Style							
4 Stone				6 Stone			
Part No	Grit	Height (in)	Length (in)	Part No	Grit	Height (in)	Length (in)
514-9-38H	1000	0.312	3	514-9-40H	1000	0.312	3
514-9-38D	400	0.312	3	514-9-42K	220	0.312	3
514-9-38E	500	0.312	3	514-9-40C	320	0.312	3
514-9-38A	600	0.200	3	514-9-40E	500	0.312	3
514-9-38B	600	0.312	3	514-9-40F	600	0.312	3
				514-9-40G	600	0.200	3
				514-9-40A	80	0.312	3

Brushes and Miscellaneous Finishing		
<p>514-9-14 Brushes For Plateau Finishing 0.395" (10mm) High x 3" (76.2mm) Long. Set of 4</p> 	<p>514-9-14H Brushes For Plateau Finishing 0.550" (14mm) High x 3 1/2" (89mm) Long. Set of 4</p> 	<p>514-9-14Y Brushes For Plateau Finishing 0.395" (10mm) High x 3 1/2" (89mm) Long. Set of 4</p> 
<p>514-9-18P Special Red Finish Diamonds For final sizing. Set of 4.</p> 	<p>514-9-18N Silicone Abrasive Exposing Stones For removing aluminum. Set of 4.</p> 	<p>514-9-21 Polishing Felt Pads For use with 514-9-21F Paste. Set of 4.</p> 
<p>514-9-21F Silicone Paste For final sizing. Set of 4.</p> 		
Single Stage Diamond Stone Sets (For use with 514-9N Hone Head), Sets of 12		
<p>110-171-01, 600 Grit 0.781" (19.83mm) Height</p> 	<p>110-171-02, 1200 Grit 0.781" (19.83mm) Height</p> 	<p>110-171-03, 325/400 Grit 0.781" (19.83mm) Height</p> 

Coolant and Filter Equipment

514-4-71C Synthetic Coolant

For use with Diamond stones. 5 gal (20L). Mix with water 20:1

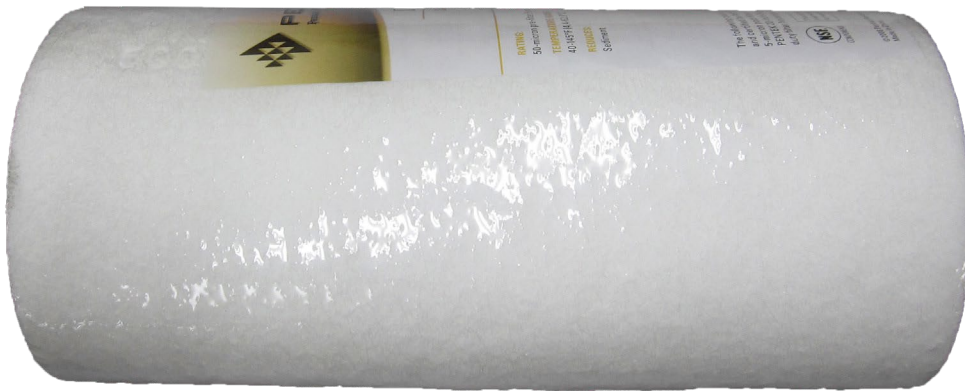


514-4-71D Coolant Refractor



514-2-42C Dual Gradient 50-5 Micron Replacement Filter Cartridge

For standard filter system



514-2-42A Cannister Magnetic Filter System

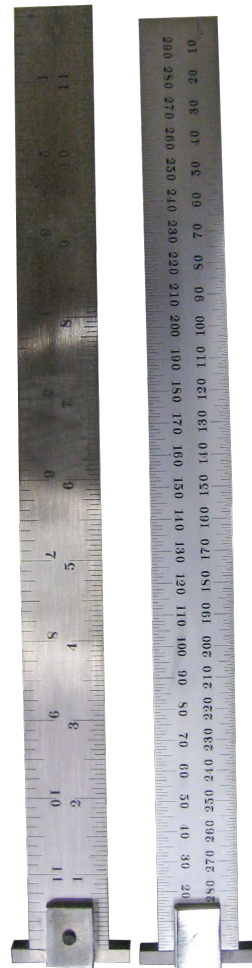
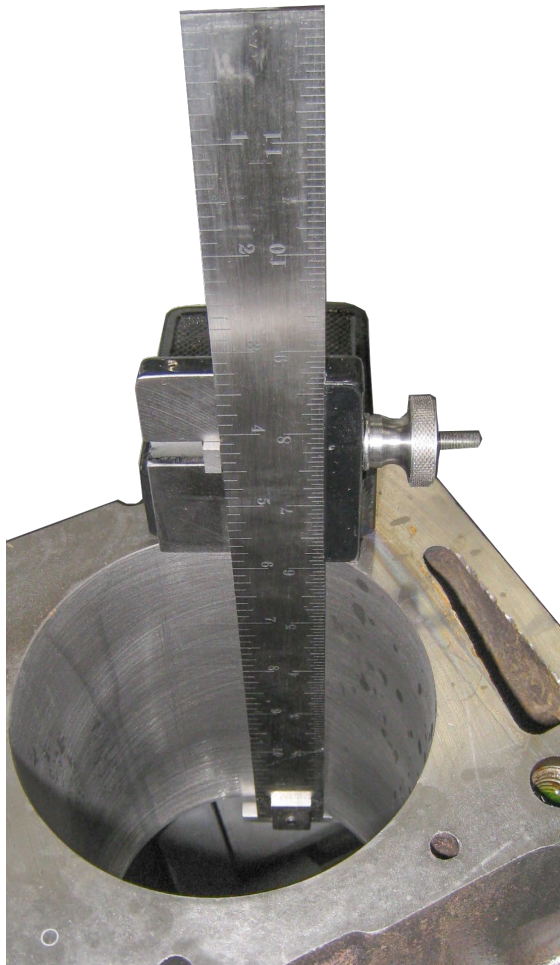
Replacement parts: 514-2-42M O-Ring, 514-2-42P Bowl Spanner, 514-2-42Q Bowl



Measuring Equipment
SJ-220 Mitutoyo Surface Tester



514-8-27 Stone Depth Scale and Holder, Inch
514-8-27F Stone depth Scale and Holder, Metric



514-14-29A Crosshatch Inspection Camera



514-14-29D Honing Inspection Software

If you have one of these...

you NEED this.

The screenshot displays the TraceBoss software interface with the following data:

Surface Texture Data
Demonstration Data
23/09/2022 09:49:08
Digital Metrology Solutions, Inc.

Roughness Profile

Material Ratio

Reference Geometry: Line
Filtering: Spline 0.0025 - Robust 0.800 mm

Ra	0.265 μm	Rk	0.611 μm	Rpq	0.200 μm
Rz	3.754 μm	Rpk	0.163 μm	Rvq	1.130 μm
R3.0	0.508 μm	Rvk	0.993 μm	Rmq	04.628 %
R1.0	91.694 %	Rmr1	7.781 %		
		Rmr2	81.865 %		
		Rvo	0.083 μm		

MEASURE

TraceBoss Surface Gage Software

Safety Shut Down Protection System

514-14-99 Laser Light Curtain

Sold only as complete assembly. H85AX & AXY Only

