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@rottlermfg.com or intlparts@rottlermfg.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
EM103/4/5 H SERIES OPTIONAL EQUIPMENT CATALOG

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Machine Installation Accessories

Suggested Hold Down Anchor System

9203T Hold Down Anchor Kit For EM103/4/5 Machine Installation
Conversational Touch Screen Software Packages
For Programmable Automated Engine Rebuilding Machine Work

9040 Boring and Sleeving 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

9041 Surfacing Software
Including Multiple Pass Programmable Depth of Cuts Including Different Settings for Rough and Finish Milling/Surfacing.
Note: Software allows surfaces wider than flycutter to be machined.

9042 Line Boring Software
Including Circular Interpolation for Thrust Facing

9046 Lifter Bore Machining Software

9044 Connecting Rod Boring Software

9053 Software Package For Machining Lower Chamfers And Facing Counter Bores
Requires radial feeding adjustable cutterhead such as 6835 or 6757Z.

Rottler Path & 4C Software Options

RPATH
Rottler Path allows users to quickly and easily produce CNC toolpath programs for producing custom parts and fixtures. Maximized for performance on Rottler EM series machines with 32” (810mm) touch screen controls. Intuitive Conversational programming with no G-code knowledge necessary.

When Rottler Path is purchased together with a new machine, there are 2 versions of introductory training available.

1. One Day introductory software tutorial at place of machine installation during the installation process.
2. Three Day introductory training course at Rottler factory.

Additional training on Rottler Path after the above training is provided through instructional videos at www.RottlerTube.com or by internet and/or telephone support, hourly charges apply.

RPATH-RL-INTRO
One day introduction tutorial on Rottler PATH software at place of machine installation during the installation process. Customers must have purchased #RPATH Rottler Path Software package before undergoing this tutorial. Full details of costs and conditions is available from the Rottler Service Department. service@rottlermfg.com
Automatic Tool Changer

9116 Automatic Rotary Tool Changer for HSK80A Tooling - 16 Tool Positions
NOTE: ATC mounts directly to the floor adjacent to the machine table.
Wireless Probing System for Automatic Centering and Measuring

10110 Renishaw Wireless Radio Probing System
Including a selection of (6) probes/stylus and Software for (1) Automatic Centering in Cylinder Bores (2) Measuring Cylinder Bore Diameters.

Price Includes Factory Installation During Machine Manufacture, Extra Charge Applies for Field Fitment.
Optional Equipment for Boring and Surfacing

Fixturing for In-Line and V Blocks

6309N Tower Type Block Hold Down Clamps
Set Of 2
6405F Large V Block Fixture
For Blocks such as CAT 3500/399, Cummins K and QSK, MTU 4000, Waukesha 7042, etc. Requires locators.

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.
| 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

6419 Locator, Assembly, Main, Jenbacher 3,4.2095” (106.92mm) (Matched Pair)

7152A Dual Axis Level Assembly

6370Z 10” (254mm) Parallels With Air Float
**6725, Cummins NV12, Komatsu 170, 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.
6370C 18” (457mm) Parallels With Air Float

7219W 5.2” (132mm) Heavy Duty T-Slot Universal Parallels
Required when Machining Small In-Line Blocks on their Pan Rails.
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.

6511 3/4” (19.05mm) Clamp Kit
Fixturing for Surfacing Cylinder Heads and Manifolds

**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.

**Adaptor for F60 Model Fixtures**

**9111A T-Slot Plate**  
Allows use of EM69 Performance Fixture, Pivot Table and Block End Truing Fixtures on EM79 & EM100 model machines.
Boring and Slewing Tooling

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
10117 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" (1152.5mm)
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
Surfacing Tooling

10119 10” (250mm) Diameter Surfacing Cutterhead Package
10106C 14” (360mm) Diameter Surfacing Cutterhead Package

10115 18” (460mm) Diameter Surfacing Cutterhead Package
10106B 22” (560mm) Diameter Surfacing Cutterhead Package

6301J CBN Insert, 1/16 Radius
for surfacing large blocks

6303V CBN Insert, Octagonal (16-Cutting Corners)
for surfacing large blocks
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

6515C Replacement Square Carbide Insert
Heavy Duty Coated for Weld-Cutting.

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6515D Replacement Square Carbide Insert

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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

10121A 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)
6900B Cross Feeding Head Assembly
For Wide Counterbores and Chamfers including HSK spindle adaptor Inch Reading
10124 Collet kit 1/8 - 1” (3 - 26mm)
23 collets including storage box and wrench.
Requires 6170J #40 Spindle Adapter

650-2-45G 1” (25.4mm) Diameter Solid Carbide End Mill x 4.00” (101.4mm) Length
Used for machining head gasket fire deck surface for water hole corrosion repairs
REQUIRED FOR CAT 3500 WATERHOLE REPAIR

650-2-43F 3/4” (19.05mm) Four Fluted End Mill X 4” (101.4mm) Length
(.020” corner radius, flat bottom, no dish) Used for Machining Head Gasket Fire Deck Surface for Water Hold Corrosion Repairs
REQUIRED FOR CAT 3500 WATERHOLE REPAIR
Spindle Adapters for Mounting Universal Tooling

10113 1” (25.4mm) Spindle Adapter for Driving 1” (25.4mm) Diameter Shank Tooling
Tooling REQUIRED FOR CAT 3500 WATERHOLE REPAIR

10113A .750” (19.05mm) Spindle Adapter for Driving .750” (19.05mm) Diameter Shank Tooling
REQUIRED FOR CAT 3500 WATERHOLE REPAIR

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10125 Adapter, Blank
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 Small to Large Blocks and Heads
Note: Cutterheads are not included with Right Angle Drive and Must be Ordered Separately

13001 Straight 90 Degree Right Angle Drive Assembly
For Small to Medium Blocks and Heads.
13002 Straight 90 Degree Right Angle Drive Assembly
For Medium to Large Blocks.
**13003 Special Belt Drive 90 Degree Right Angle Drive Assembly**

For Limited Clearance Between Bearing Caps.

Note: The Belt Drive Right Angle Drive is Designed for Limited Clearance Between Bearing Caps and it’s Cutting Performance will Deteriorate as Larger Diameters are Bored and Extension Spacers are Used.
13004 Special Right Angle Drive Assembly
Complete With Narrow Cutterhead complete with Tooling and Micrometer for Line Boring 1.9” To 2.4” Diameter HSK80
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
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.
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

6789T 110 Degree V Block Supports for Jenbacher 3
For use on Line Bore Fixture 6821
Line Bore Tooling for Extra Large Blocks
Such as CAT C175, 3500 & 399, Waukesha 7042, White Superior 8G825

13000 Heavy Duty Offset 90 Degree Right Angle Drive Assembly Without Tooling
Note: Cutterheads are Not Included with Right Angle Drive and Must be Ordered Separately
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

6810 Waukesha 7042, 9390 and CAT 379, 398, 399 Line Boring Fixture
6846 White Superior 12 & 16 G825 Line Boring Fixture

Line Bore Set Up and Alignment Equipment

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)

502-9-9S Indicator Mount
Angled for small diameter main line bores
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 and general purpose milling work

10130 Shell Mill
6" (152mm) Diameter for surfacing main bearing cap register face in blocks in preparation for main line boring and general purpose milling work
10109C Shell Mill
8" (203mm) Diameter for surfacing main bearing cap register face in blocks in preparation for main line boring and general purpose milling work

6514T Insert
For 6514L, 6514V & 6514W 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
Main Line Thrust Facing Utilizing Circular Interpolation

6855C Thrust Facing Tooling Package
For main line bore

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

6779H Adaptor for 40 Taper Tooling
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 Fixturing and Tooling

650-3-44R Rottler Precision Connecting Rod Fixturing System
Approximately 8 - 24" (203 - 610mm) center distance - requires (1) pair of 6370C
Fixturing & Tooling for Large Engine & Compressor Connecting Rods

650-3-64 Rottler Precision Connecting Rod Boring 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 Stub Cutterhead
2.9 - 8.0" (74 - 203mm) Diameter X 9.3" (236mm) Length Complete with Tooling and Digital Micrometer
9234 Enclosure
Optional full enclosure with sliding doors and large viewing windows.
When enclosure supplied with new machine, standard chip guard is not included
Note: Enclosure is free standing and supplied as a kit. Mounting holes in foundation are required for installation.
Installation is customer responsibility.