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

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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**6761 Factory Supplied Transformer Package**
For Voltage Above or Below 208-240 Volts - Customer to Specify Electrical Supply When Placing Order
Contact your Rottler representative or the factory concerning this option.

**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 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
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.

**CAD/CAM (Computer Aided Design and Manufacturing) Software**

**9043 Rottler Direct Motion CAD/CAM Software Package.**
Contact your Rottler representative or the factory concerning this option.
Wireless Probing System for Automatic Centering and Measuring

650-3-59X 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.
Suggested Hold Down Anchor System

9203G Hold Down Anchor Kit
For F100 Machine Installation. Includes injection adhesive system for threaded rod applications in concrete, adhesive dispenser, mixer, anchor rods, and blow out pump.
Note: Hammer Drill Bit and Hammer Drill are not included
Optional Equipment for Boring and Surfacing

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
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

10102G Main Line Locator Assembly
For Locomotive EMD Block
10102L Main Line Locator Assembly
For MTU 1163
10102N  Main Line Locators
For MTU 8000
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
Requires Parallels 10355

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 below.
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.
6511 3/4" (19.05mm) Clamp Kit
T-Nuts, Bolts, Strap Clamps, Etc.
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. See F60/F70 Locator price sheet for listing of available locators.
Note: 6725 requires 6370Z 10" (254mm) parallels.
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 Sleeveing Tooling

6516H Blind Hole Stub Cutterhead
1.5 - 4.2" (38 - 107mm) diameter x 6.5" (165mm) length complete with tooling and Digital Micrometer
6519Z Blind Hole Stub Cutterhead
2.9 - 5.0" (74 - 152mm) diameter X 9.7" (246mm) length Complete With Tooling and Digital Micrometer
6256A Blind Hole Spindle/Cutterhead
4.5 - 9.0" (114 - 228mm) Diameter X 12" (254mm) Length Complete with Tooling and Digital Micrometer
6464J Blind Hole Cutterhead
8.0 - 14.0" (203 - 360mm) diameter complete with tooling and Digital Micrometer
6588 Blind Hole Cutterhead
11.75 - 16” (298 - 406mm) diameter - Complete with tooling and Digital Micrometer
6587 Blind Hole Cutterhead
14.0 - 20.0" (356 - 508mm) diameter complete with tooling and Digital Micrometer
10103 Extended Spindle Blind Hole Cutterhead
4.5” – 9.0” (114mm – 228mm) Diameter /x 12.5” (318mm) Long.
Complete with Tooling and Digital Micrometer
6593S Cartridge Assembly
Circular Interpolation Counterbore Facing
Surfacing Tooling

6294V Surfacing Cutterhead Assembly
10" (250mm) Diameter Complete With Tooling
6294U Surfacing Cutterhead Assembly
14" (360mm) Diameter Complete With Tooling
6294T Surfacing Cutterhead Assembly
18" (460mm) Diameter Complete With Tooling
6294W Surfacing Cutterhead Assembly
22" (560mm) Diameter Complete With Tooling

6301J CBN Insert
1/16 Radius, for Surfacing Large Blocks

6303V CBN Insert
Octagonal (16-Cutting Corners) for surfacing large diesel blocks
Special Surfacing Tooling for Milling Metal Sprayed Head Gasket Decks

6864 Special Multi Tooth Milling Head
18" (420mm) Diameter Including 9 Cartridges with 10 cutting edges per insert
6865 Special Multi Tooth Milling Head
12" (300mm) Diameter Including 14 Cartridges with 10 cutting edges per insert

6864E Replacement Insert
(10 cutting edges per insert) for 6864 and 6865 Milling Head

6864D Replacement Cartridge
For 6864 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

6648 Caterpillar 3400 Series Tappet Bore Repair Tooling Package
Including Digital Indicator
6835 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)
6757Z Large Heavy Duty Adjustable Boring/Facing Head
Including Spindle Adapter for General Purpose Boring and Facing Work, and Cutting Wide Chamfers
6648K 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

**6648M Spindle Adapter**
1” (25.4mm) for Driving 1” (25.4mm) Diameter Shank Tooling

**6170C Adapter**
Blank, Can be Machined by Customer to Suit Special Requirements

**6170J #40 Taper Adapter**
6170K R8 Taper Adaptor

6514Q #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

6779K Heavy Duty Offset 90 Degree Right Angle Drive
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 Superior 2400

10200 Adjustable Universal Line Boring Parallel Assembly
Supports for V Blocks must be Ordered Separately, Listed Below.

10201 Support Cradle for CAT 3600 V blocks
10204 Support Cradle for CAT 3600 In-Line Blocks

10202 Support Cradle for Waukesha AT
10203 Support Cradle for Superior 2400 V Blocks

10355 PARALLELS
15 1/2" (394 MM) HEIGHT X 55" (1397MM) LONG WITH AIRFLOAT
Line Bore Fixturing for Large Blocks
Such as Waukesha 7042, 9390 and White Superior 825 - Requires Parallels 10355

6810 Line Boring Fixture
Waukesha 7042, 9360 and CAT 379, 398, 399

6815 White Superior 8G825 Line Boring Fixture
Requires Fixture 6821
6846 White Superior 12 & 16 G825 Line Boring Fixture
Requires Fixture 6821

Replace this box with correct illustration when available
Line Bore Fixturing for Large Blocks
Such as CAT 3500, MTU 4000, Cummins QSK

6821 Adjustable Universal Line Boring Parallel Assembly
Includes Locators for Mir Range In-Line Blocks, Supports for V Blocks Must Be Ordered Separately, Listed Below.
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

6780 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
650-2-39B Line Boring Cutterhead Assembly
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 Line Boring Cutterhead Assembly
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 Line Boring Cutterhead Assembly
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, 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

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
6514L Shell Mill
5" (127mm) Diameter for Surfacing Main Bearing Cap Register Face in Blocks in Preparation for Main Line Boring

6514V Shell Mill
6" (152mm) diameter for surfacing main bearing cap register face in blocks in preparation for main line boring
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

www.rottlermfg.co
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 Surfacing Cutterhead Assembly
10” (250mm) Diameter Complete with Toolholders for .375” (9.52mm) round or square inserts for Block End Surfacing
6779M Surfacing Cutterhead Assembly
14" (360mm) Diameter Complete with Toolholders 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 Con Rod Cap Surfacing Fixture
Requires (1) Set 6370Z Parallels
Tooling for Connecting Rod Boring

6516H Blind Hole Cutterhead Assembly
1.5 - 4.2" (38 - 107mm) Diameter X 6.5" (165mm) Length Complete With Tooling and Digital Micrometer
6519Z 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

Replace this box with correct illustration when available