

ROTTLER

EM79 CNC MACHINING CENTER 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@rottlermfg.com, for customers outside of the U.S. use 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

EM79 OPTIONAL EQUIPMENT PARTS MANUAL

Contents

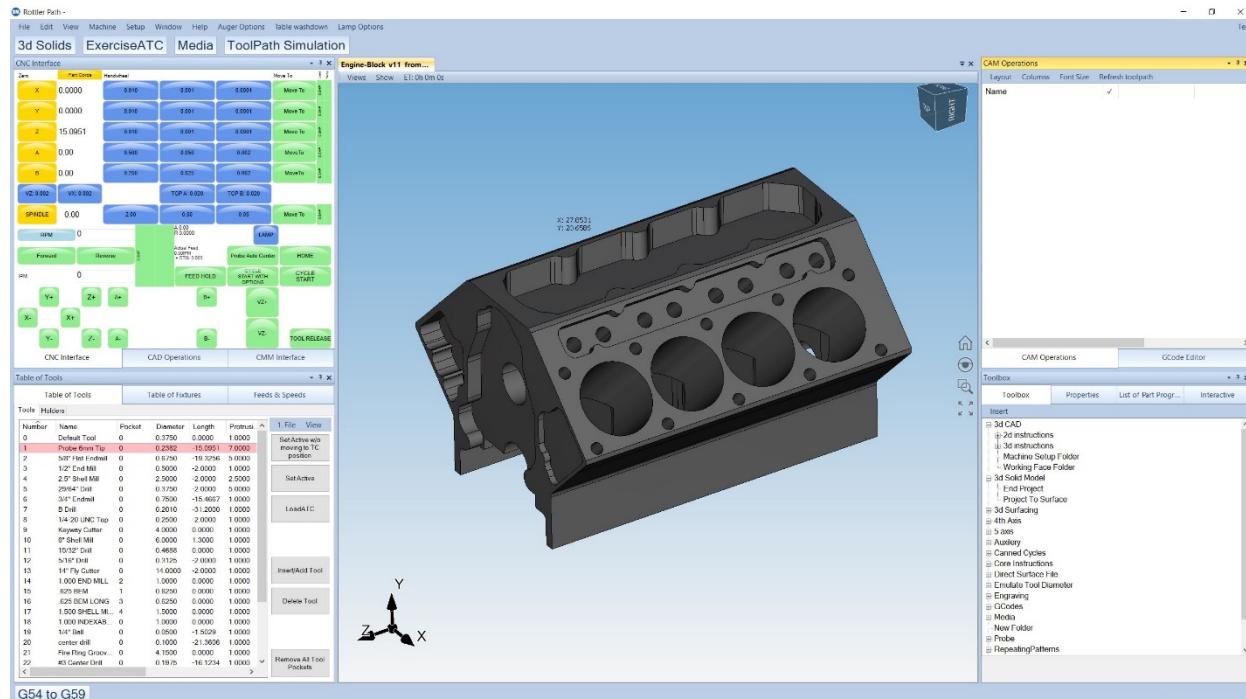
RPATH-4C Software Package	1
Cutting Tools	1
Boring Tools	1
650-2-1D Blind Hole Cutterhead Kit, 2.0-4.0" (51-102mm) x 7" (176mm).....	1
650-2-3T Blind Hole Cutterhead Kit, 2.0-4.0" (51-102mm) x 4.0" (102mm).....	2
11100 Blind Hole Cutterhead Kit, 3.8-5.0" (96.5-127mm)	3
650-2-15F Blind Hole Cutterhead Kit, 2.9-8.0" (73.5-203mm) x 4.0" (102mm)	4
650-2-14B Blind Hole Cutterhead Kit, 2.9-5.0" (74-127mm) x 7" (176mm).....	5
11101 HD Cutterhead Kit, 4.5-7.0" (115-178mm).....	6
Surfacing Tools	7
650-2-8E Surfacing Flycutter Kit, 10" (254mm) Dia.....	7
650-2-8F Surfacing Flycutter Kit, 14" (356mm) Dia	8
650-2-44N Shell Mill, 2.5" (63.5mm) Dia.....	9
650-2-44P Shell Mill, 4" (102mm) Dia.....	10
Right Angle Drives	11
11103 Right Angle Drive	11
11103E Right Angle Drive, 2" Extended	12
11104 Special Belt Driven Right Angle Drive	13
11105A Narrow Right Angle Drive	14
Right Angle Drive Accessories.....	15
650-2-39B Line Boring Cutterhead Kit, 1.94-4.11" (49.28-104.39mm) Dia	15
650-2-39C Line Boring Cutterhead Kit, 2.82-5.52" (71.63-140.21mm) Dia	16
6855Q Thrust Facing Tool Package	17
Main Bore Chamfering Tools	18
Insert Holders	19
Miscellaneous Insert Holders and Tooling	20
6598 Insert Cartridge	22
6260L Insert Cartridge	23
6598R Series Insert Holder.....	23

6598M Series Insert Holder	23
6260W Series Insert Holder	23
6593 Series Insert Cartridge	24
6520 Series Insert Cartridge	24
6801 Series Insert Cartridge	25
6801M Tool Holder Package	26
6801P Tool Holder Package	27
Micrometers	28
900-2-19 Micrometer	28
900-2-20 Micrometer	28
General Purpose Tooling	29
6648W Caterpillar 3400 Tappet Bore Repair Kit	29
650-2-53 Splayed 4-Bolt Main Cap Tooling Package	30
650-2-44M Drill Chuck Kit	31
10124 CAT 40 Collet Kit	31
11116 Cross Feed Head Assembly	32
650-2-3S Cutterhead Kit	32
650-2-11K Tap Driver	33
650-2-44A Endmill Adapter, 1" (25.4mm) Tooling	33
650-2-45H Endmill, 1" (25.4mm) x 8.5" (216mm) OL, Roughing	33
650-2-60B Lifter Bore Tooling Kit	33
Fixturing	34
Parallels	34
11115 Parallels, 2" x 3" (51mm x 76mm)	34
11113L Parallels, 4" (102mm)	35
11112 Parallels, 8" (203mm)	35
11114 Parallels, 16" (406mm)	36
Block Locating Fixtures	37
11121 Small to Mid-Range Main Bore Fixture Kit	37
650-3-56 Line Bore Pivot Table Fixture Kit	38
11113 Adjustable Line Bore Parallel Kit	39
6843 90° V-Block Support Kit	40
6789L 113° V-Block Support Kit	40
6789E 115° V-Block Support Kit	41
6789N 116° V-Block Support Kit	41
6866 Wedge Kit, Cummins 5.9L Camshaft Bore	42
Miscellaneous Fixtures/Accessories	43
650-3-37 ½" (12.7mm) Clamp Kit	43

7209M Dual Axis Leveling Table	43
7209N 2-Piece Vice	43
11111 Tower Type Hold Down Clamp Kit.....	44
7152A Dual Axis Level.....	44
9111A T-Slot Plate for F60 Fixtures.....	45
650-2-60N Setting Fixture, Lifter Tooling	45
Auxiliary Equipment.....	46
650-3-59Y Renishaw Wireless Probe Kit.....	46
502-12-7B Digital Runout Probe and Readout Kit.....	47
502-12-4 General Purpose Magnetic Indicator Holder	48
502-12-4A Magnetic Indicator Holder	49
502-9-9S Indicator Mount	49
502-9-9A Mechanical Runout Indicator, Inch.....	49
502-9-9J Mechanical Runout Indicator, Metric	49
650-3-44S Precision Connecting Rod Fixture System	50
650-3-64 HD Precision Connecting Rod Fixture System.....	50
690-3-70 Automatic 4 th Axis Fixture.....	51
650-3-84 Block Fixture Plates, Overhead Cam	52
11038 Optional Machine Enclosure	56
11042 Automatic Rotary Tool Changer.....	57

RPATH-4C Software Package

Next Generation Toolpath Software powered by 4C allows users to quickly and easily produce CNC toolpath programs for producing custom parts and fixtures. Intuitive Conversational programming with no G-code knowledge necessary for 2+1 axis machining.

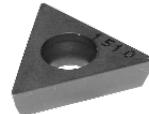


Cutting Tools
Boring Tools
650-2-1D Cutterhead Package Components

650-2-1E



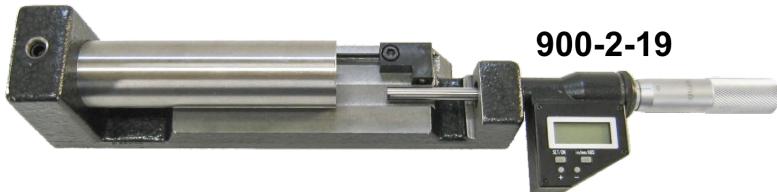
RT321



RT322



900-2-19



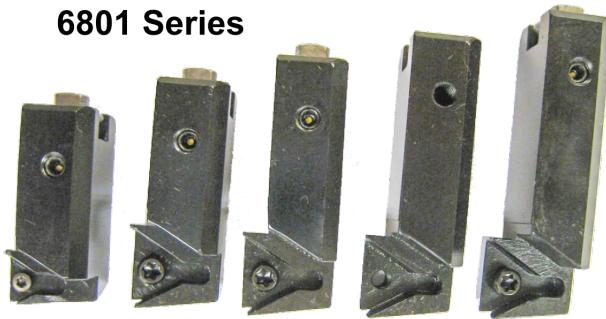
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RT212



6801 Series



511-29-12D



511-29-12F



501-72

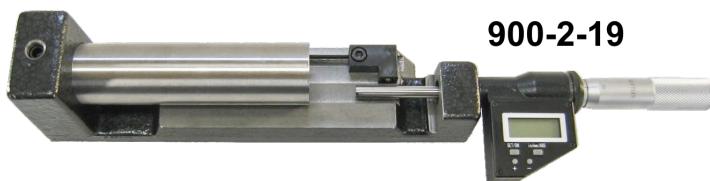
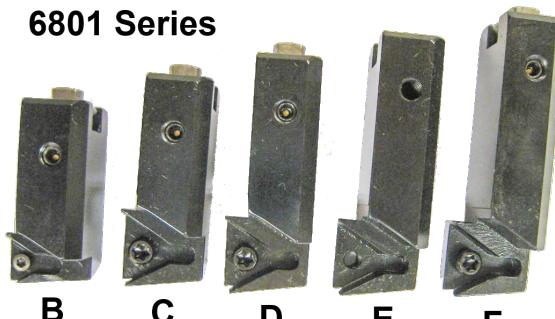
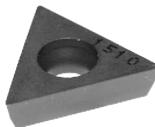


T8D

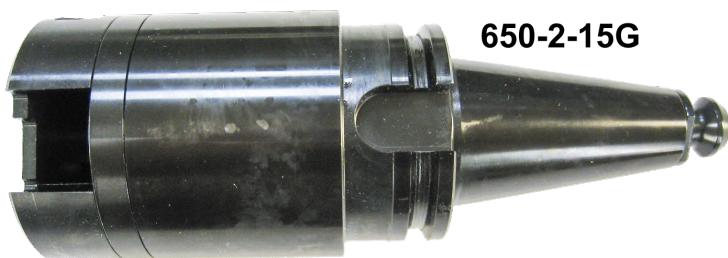


501-72J



650-2-3T Cutterhead Package Components**650-2-3U****511-29-12D****T8D****900-2-19****511-29-12F****501-72****6801 Series****B****C****D****E****F****RT321****RT322****RT211****RT212****RTCR321**

11100 Cutterhead Package Components

650-2-15F Cutterhead Package Components

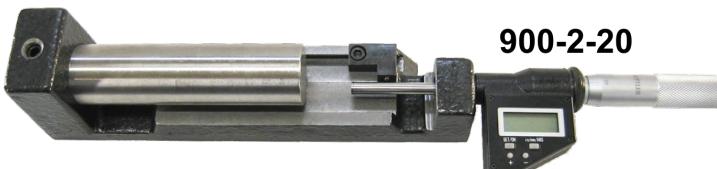
650-2-15G



RT321

RT322

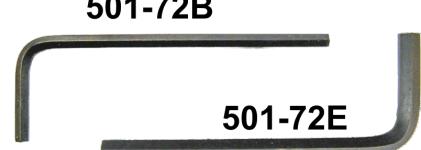
6593 Series



900-2-20



6598K



501-72B

501-72E



6260W



511-29-12D



6260L



6598M



RS322

RTCR321



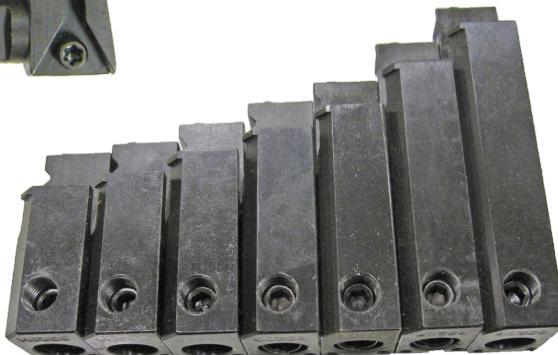
100-24



501-72



501-72J

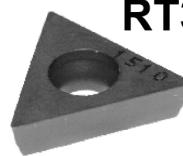


6520 Series

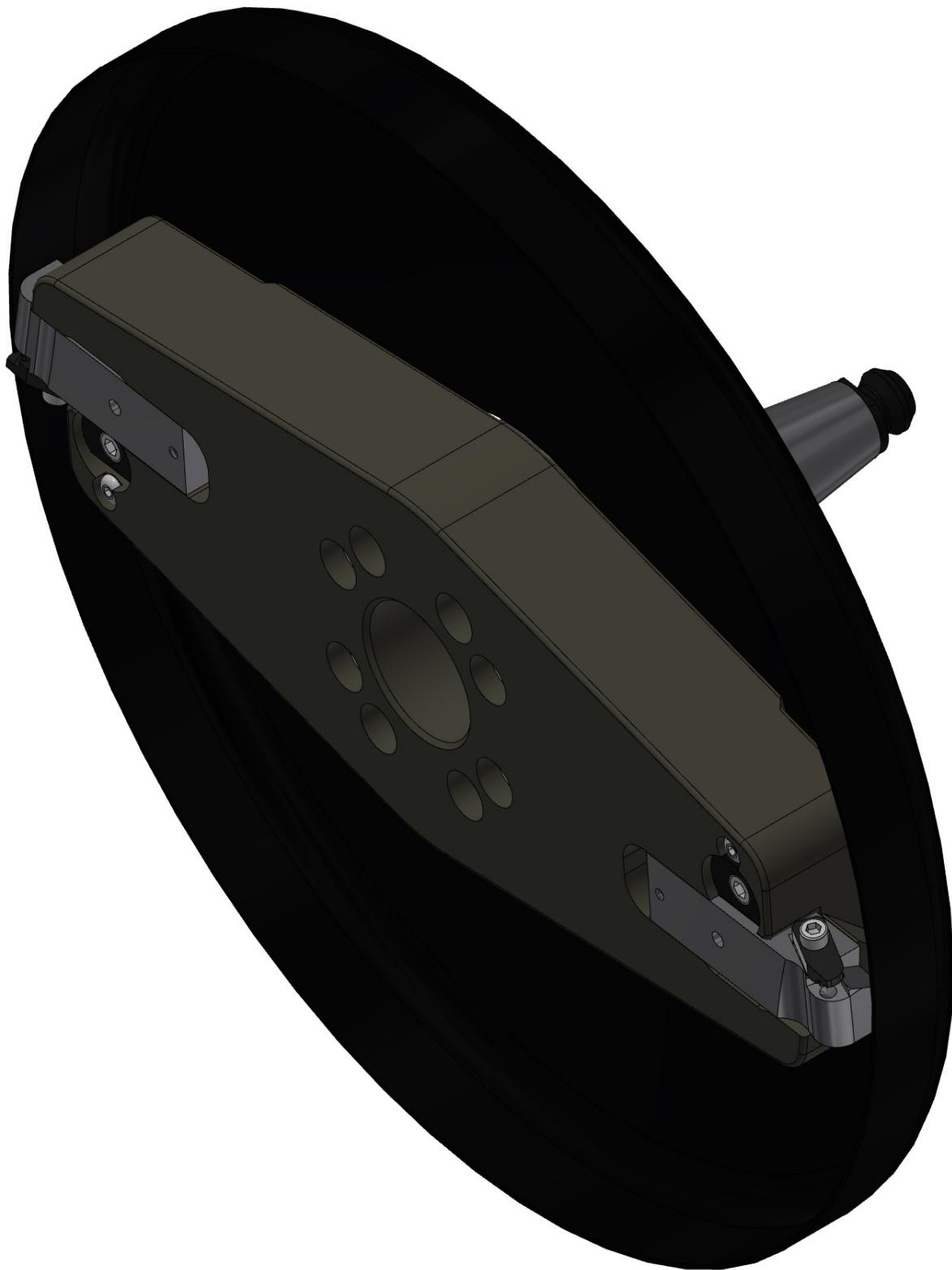
650-2-14B Cutterhead Package Components**650-2-16D 1400" (355mm) Spacer (Extension)**

For use with 650-2-14B Cutterhead Sold only as complete assembly.



11101 Heavy Duty Cutter Head Package Components**11101A****RT321****RT322****900-2-20****511-29-12D****6598K****6259 Series****501-72****6598R****6598M**

Surfacing Tools**650-2-8E Surfacing Cutterhead, 10" (254mm Diameter Parts)**

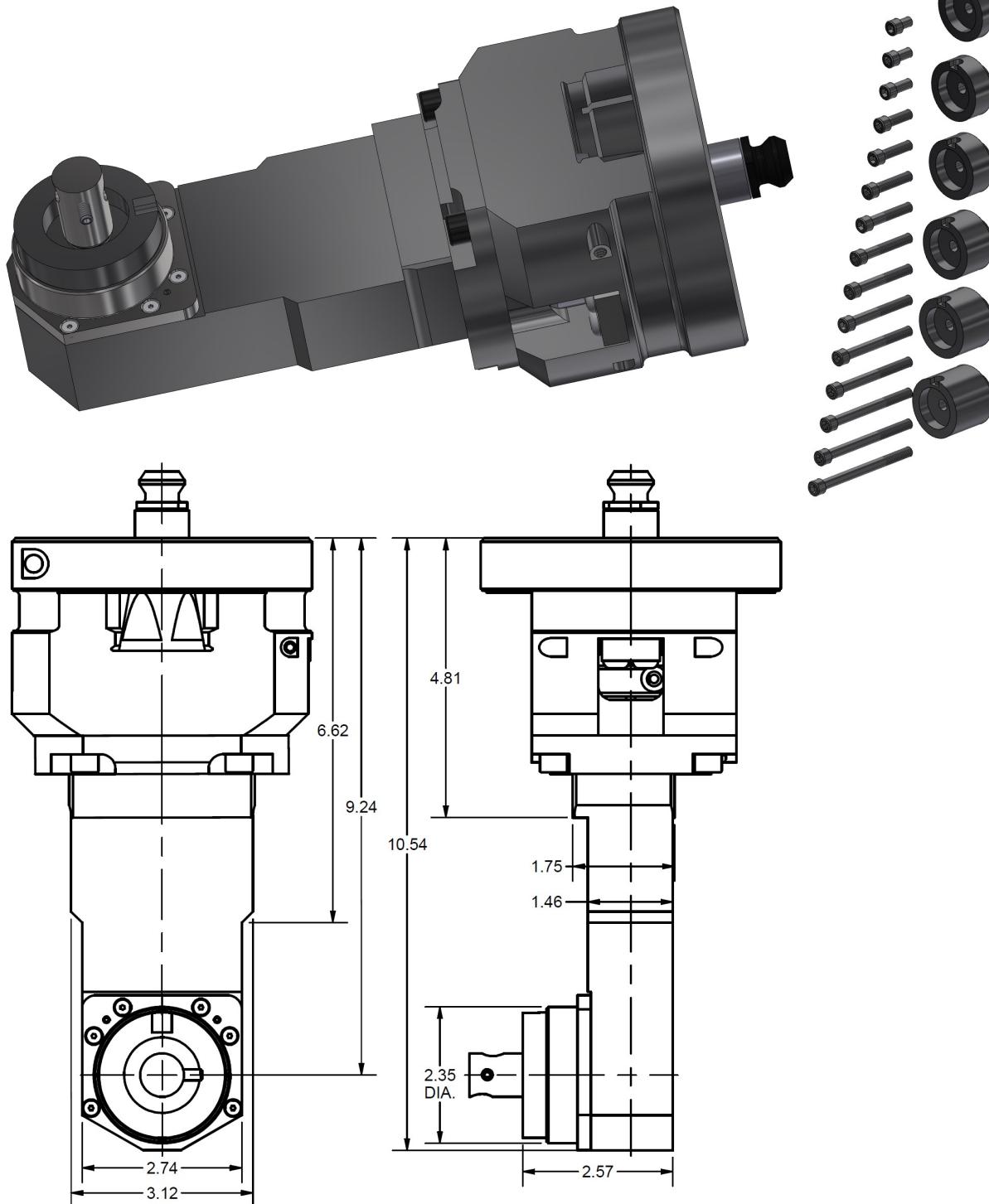
650-2-8F Surfacing Cutterhead, 14" (356mm) Diameter Parts

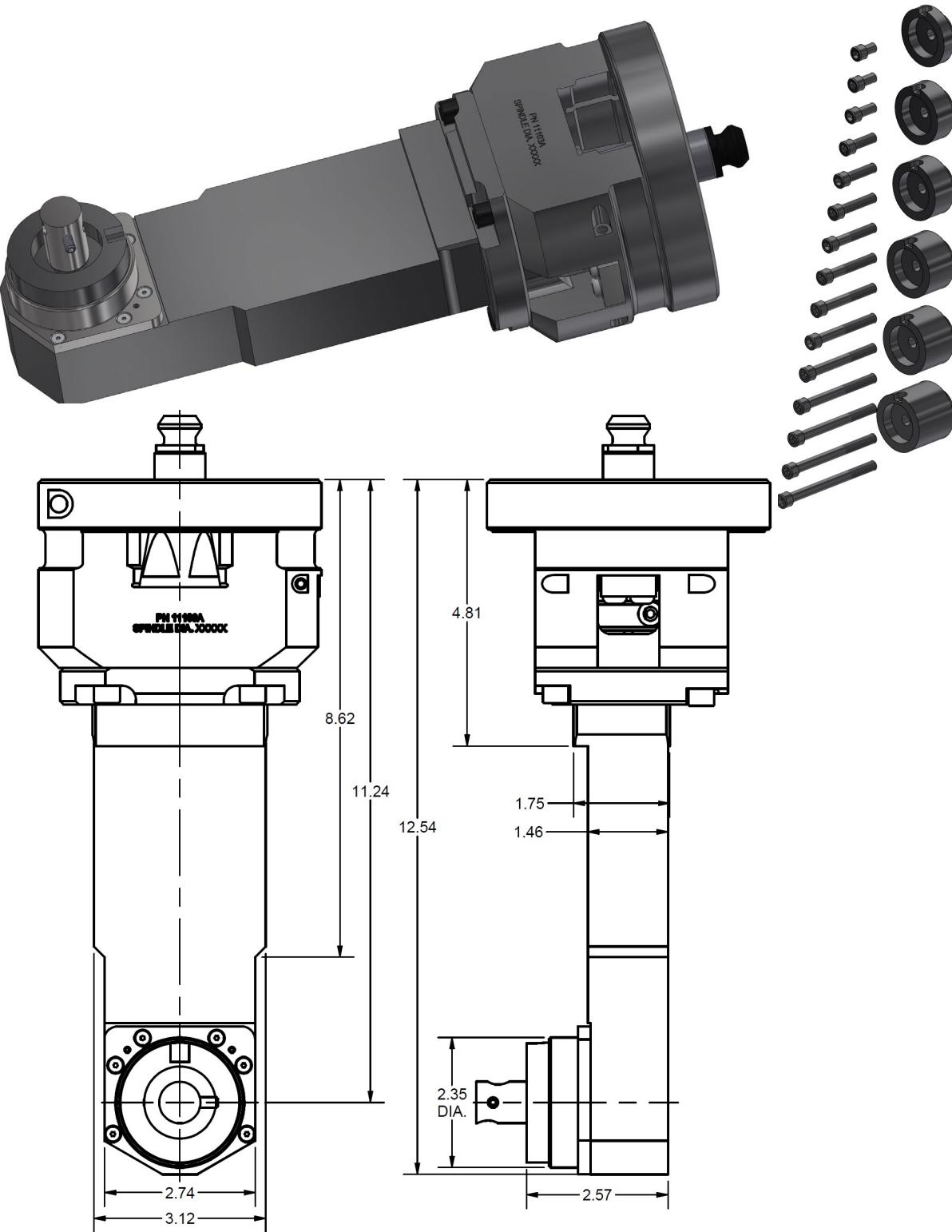
650-2-44N Shell Mill, 2" (50.8mm)

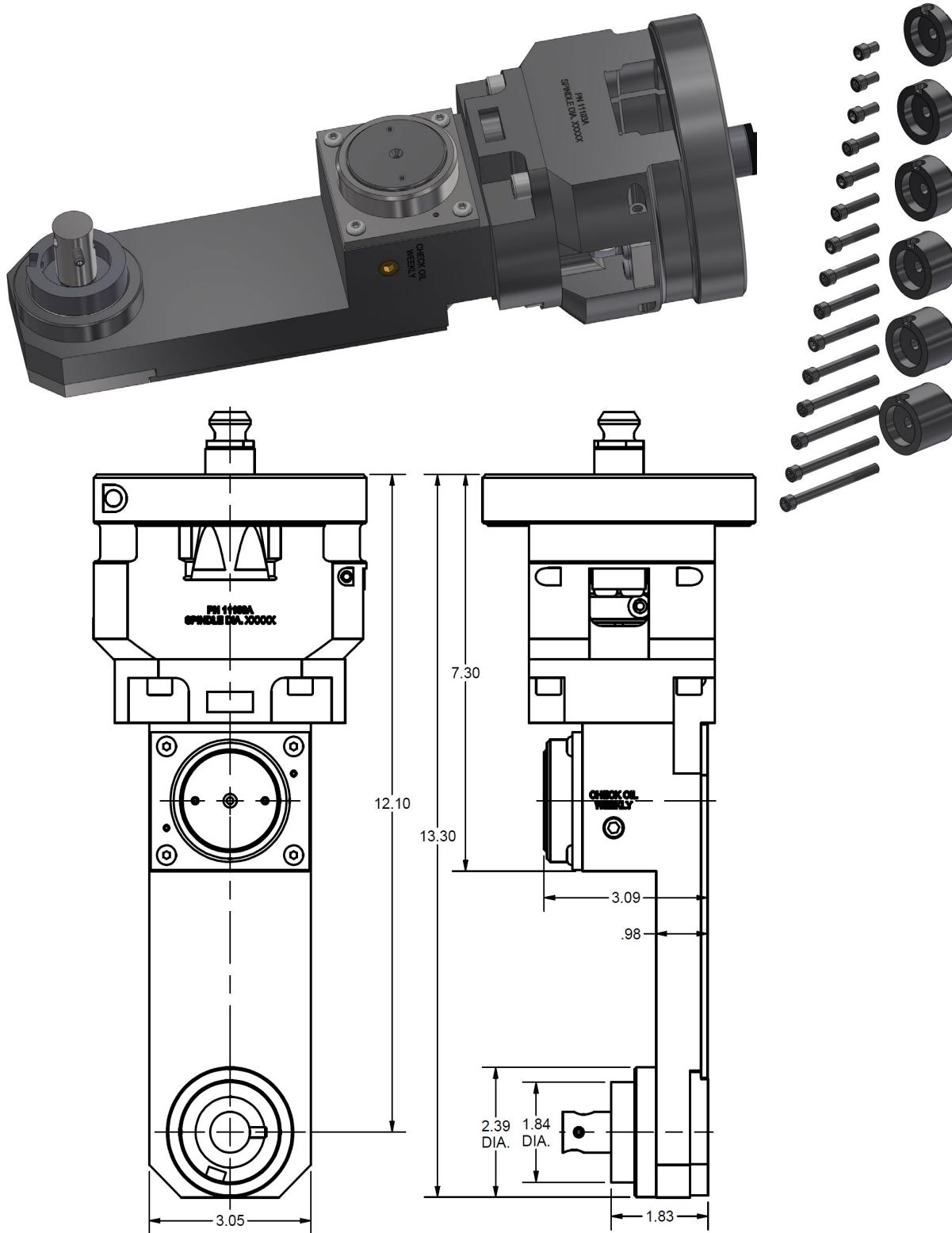
650-2-44P Shell Mill, 4" (10160mm)

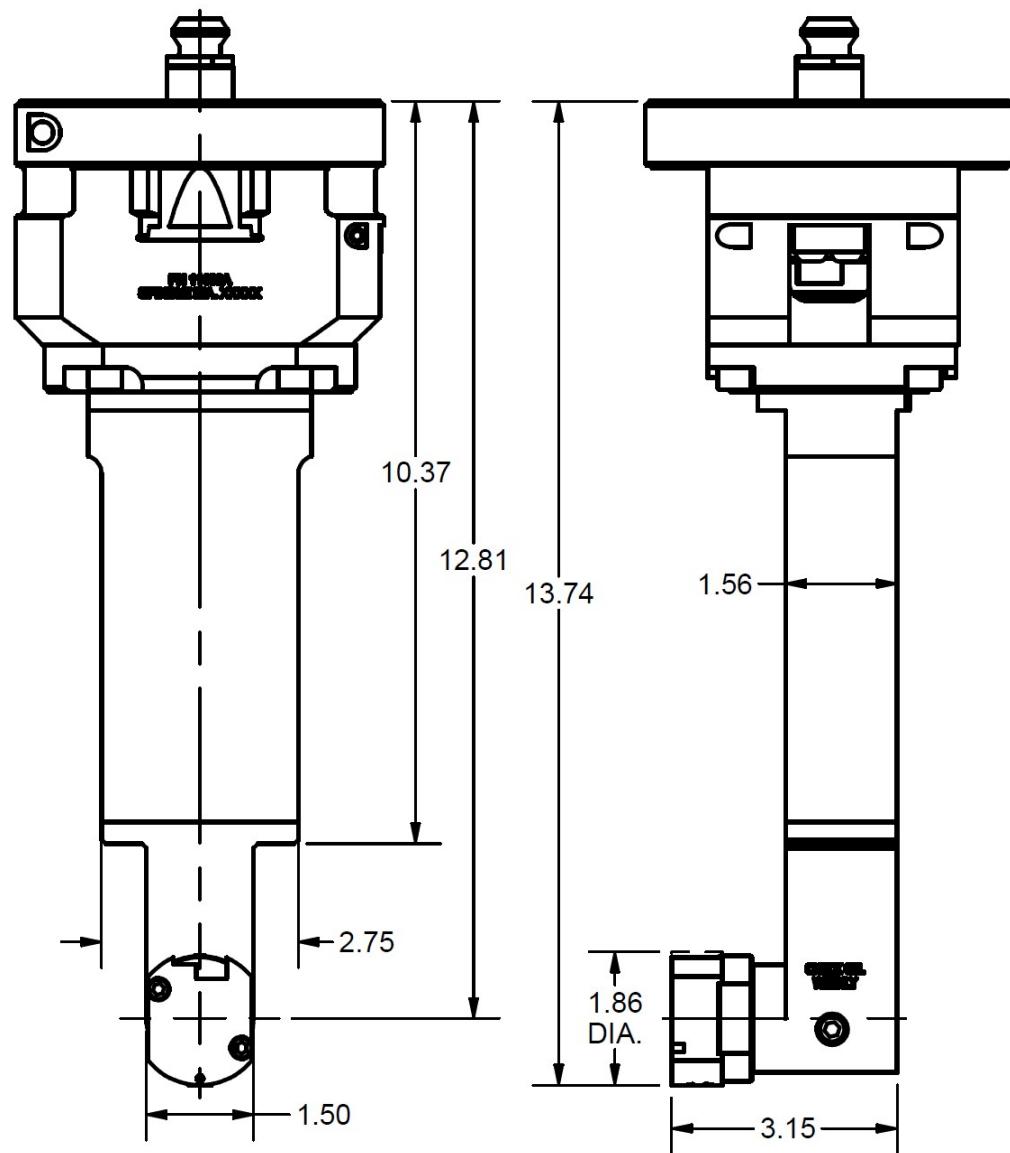
Right Angle Drives

11103Main Line Bore 90 Degree Right Angle Drive



11103E Main Line Bore 90 Degree Right Angle Drive, 2" Extended

11104 Special Belt Drive 90 Degree Right Angle Drive

11105 Narrow Right Angle Drive

Right Angle Drive Accessories

650-2-39B Line Boring Cutterhead Package Components

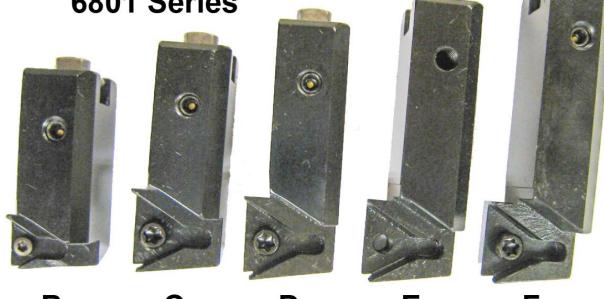


650-2-39F

RT321F



6801 Series



B C D E F



900-2-19

511-29-12D



501-72



T7D



RT322F



511-29-12F



RT211



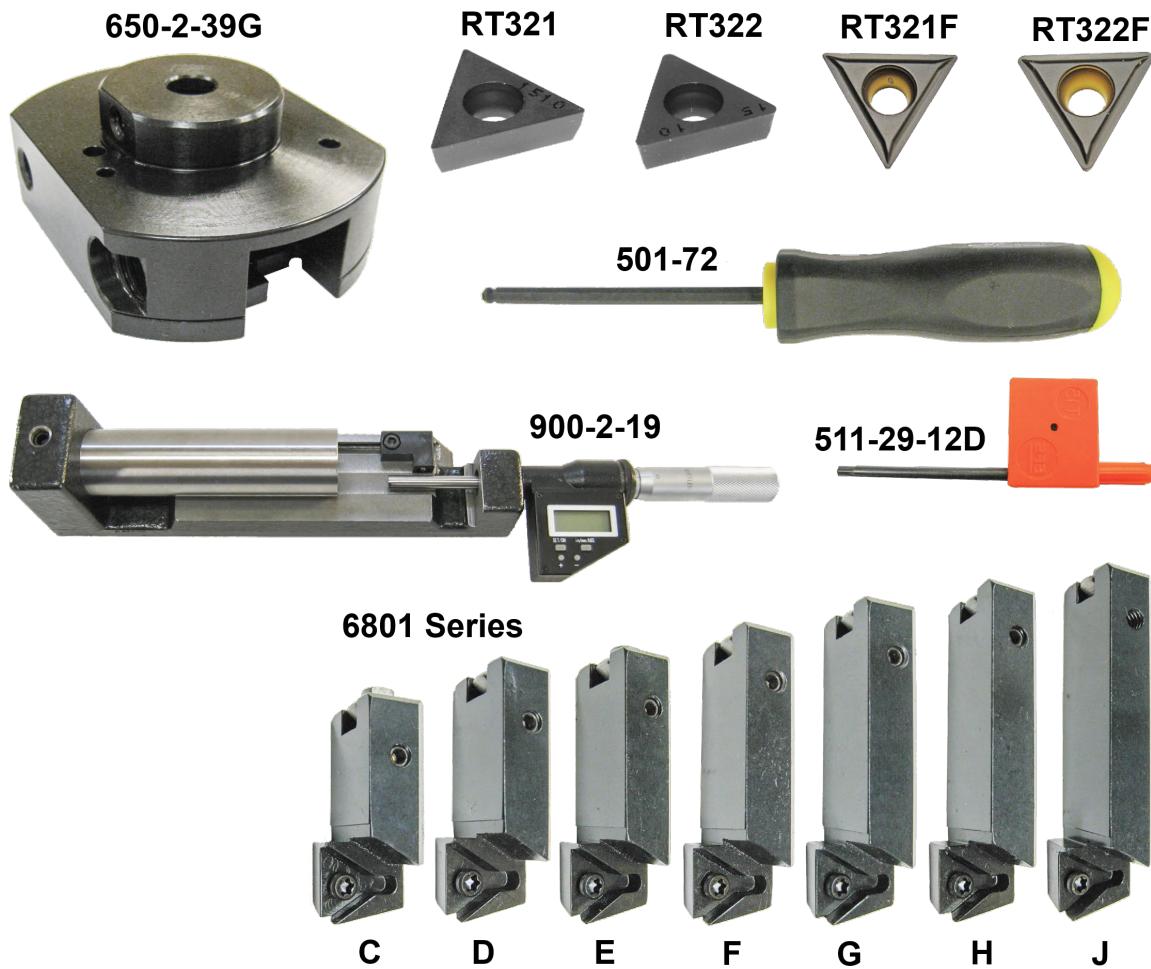
RT212



RT321



RT322

650-2-39C Line Boring Cutterhead Package Components

**6855Q Thrust Facing Tooling Package Components****6855****6855D****6855J****6855A****6855E**

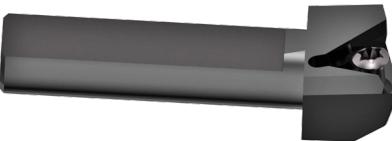
Special Main Line Boring Chamfering Tools**199-90 Tool Holder, 2 - 3"**
(5080 - 7620mm)**199-96 Tool holder, 3 - 4"**
(7620 - 10160mm)**501-33E Tool Bit, 45-Degree Chamfer**

Insert Holders

Tool Holder Diameter Ranges by Cutterhead Size

Cutterhead Diam	Centerline Offset	Tool Holder	CAT40	650-2-76A	-	-	-
			ROTTLER	6516C / G / Q / T	-	-	-
			HSK80	10118A	-	-	-
			RAD	-	650-2-39G	650-2-39E	
			OL	(1.5")	(2.82")	(5.4")	
1.5"	-0.655"	6801A	1.23	1.5	2.02	-	-
2.82"	-0.500"	6801B	1.44	1.93	2.53	-	5.4
2.88"	-1.080"	6801C	1.56	2.3	2.9	2.82	5.46
4.5"	-1.762"	6801D	1.85	-	-	2.99	6.06
5.4"	0.960"	6801E	2.05	-	-	3.4	6.45
7.75"	-0.280"	6801F	2.25	-	-	3.8	6.86
12"	1.570"	6801G	2.45	-	-	4.2	7.26
14"	3.000"	6801H	2.56	-	-	4.63	7.66

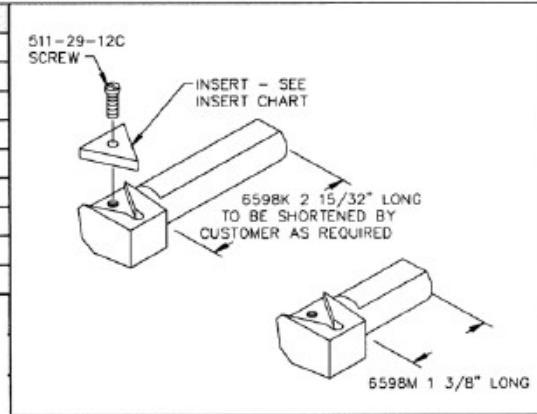
Tool Holder	OL W/O Tool Bit	CAT40	650-2-14A / C / G / J	11101A	-	-	-	-
		ROTTLER	6519Y	6256P	6464H	6588A	6587D	
		HSK80	10108 / 10131A	10103A / 10116A / 10117A	10107	10104	10105B	
		RAD	6519U / S / Q / R	-	6779F	-	-	
		Tool Bit	(2.88")	(4.5")	(7.75")	(12")	(14")	
6593C	2.75	-	2.92	3.35	-	-	-	-
6593D	2.97	-	3.36	3.79	-	-	-	-
6520H	2.25	6598M	3.48	3.88	-	-	-	-
6520A	2.38	6598M	3.74	4.24	-	-	-	-
6520B	2.63	6598K	5.57	6.74	-	-	-	14
6520C	2.88	6598K	-	-	-	-	-	15.84
6520D	3.13	6598K	-	-	-	-	-	16.25
6520E	3.38	6598K	-	-	4.55	5.85	7.75	14
6520F	3.63	6598K	-	-	5.05	6.35	8	15.13
6520G	4.13	6598K	-	-	6.05	7.35	9	15.3
6259P	3.13	6598K	-	-	5.63	6.64	8.58	12.1
6259C	3.38	6598K	-	-	5.73	7.14	8.68	13.11
6259D	3.63	6598K	-	-	5.63	7.64	8.58	15.08
6259I	3.88	6598K	-	-	5.63	8.05	8.58	17.09
6259E	4.13	6598K	-	-	6.04	7.34	8.99	14.11
6259F	4.63	6598K	-	-	7.04	8.34	9.99	15.08
6259G	5.13	6598K	-	-	-	-	10.99	17.5
6259H	5.63	6598K	-	-	-	-	-	18.49
6259J	6.13	6598K	-	-	-	-	-	19.49
6529M	7.63	6598K	-	-	-	-	-	20.79
					-	-	-	22.49
					-	-	-	23.79

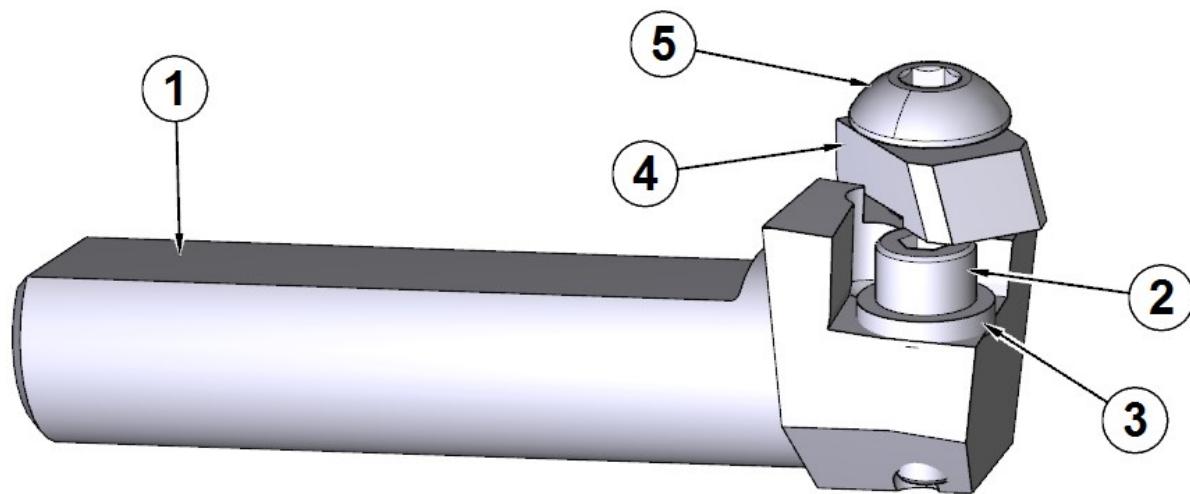
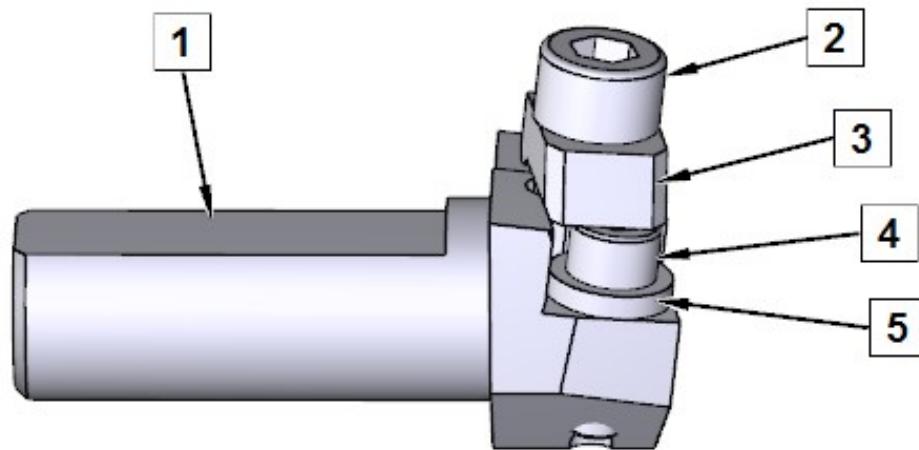
<p>6593S Cartridge, Triangular For Circular Interpolation Counterbore Facing</p> 	<p>6598M Cartridge, Triangular, 13/16" (20mm) length For Counterboring</p> 
<p>6598K Cartridge, Triangular, 1-7/8" (48mm) length For Counterboring</p> 	<p>6598R Cartridge, Triangular Offset 250 (64mm) For Blind Holes</p> 
<p>6513J Tool bit, Brazed Carbide - 037" (940mm) Wide O Ring Grooving</p> 	<p>6513L Tool bit, Brazed Carbide - 039" (991mm) Wide O Ring Grooving</p> 
<p>6513N Tool bit, Brazed Carbide - 060" (1524mm) Wide O Ring Grooving</p> 	<p>6513Q Tool bit, Brazed Carbide - 120" (3048mm) Wide O Ring Grooving</p> 
<p>6513P Tool bit, Brazed Carbide - 085" (2159mm) Wide O Ring Grooving</p> 	<p>6747K Cartridge, Triangular - 5 Degree Chamfer</p> 

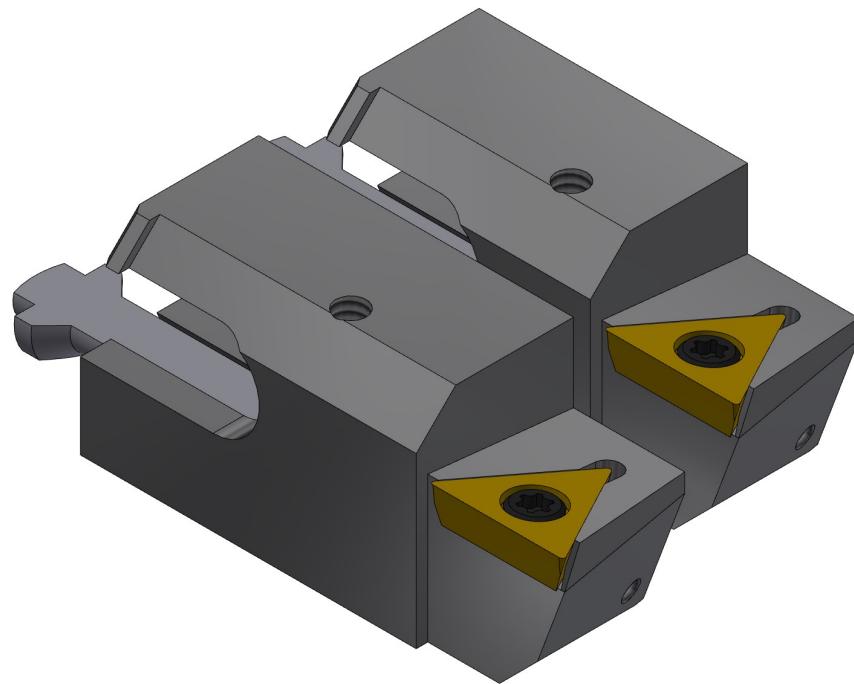
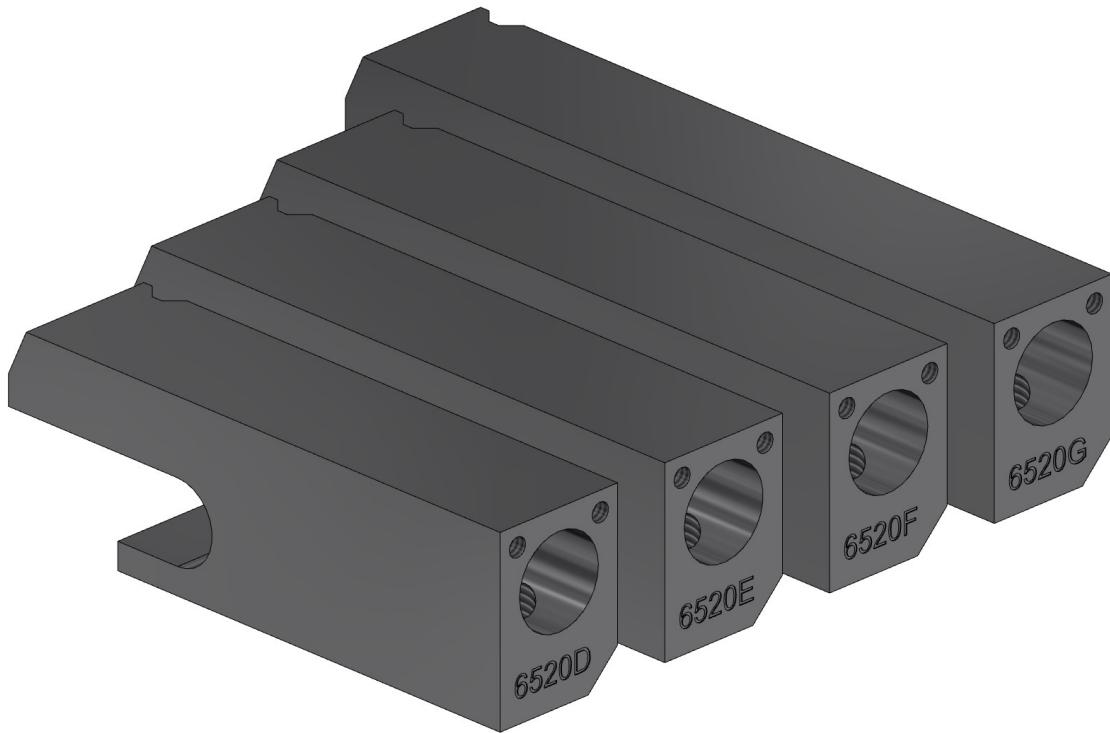
6747P Cartridge, Triangular - 10 Degree Chamfer	6747G Cartridge, Triangular - 15 Degree Chamfer
	
6747F Cartridge, Triangular- 20 Degree Chamfer	6747M Cartridge, Triangular - 20 Degree Chamfer (Special Application Only)
	
6747H Cartridge, Triangular - 30 Degree Chamfer	
	

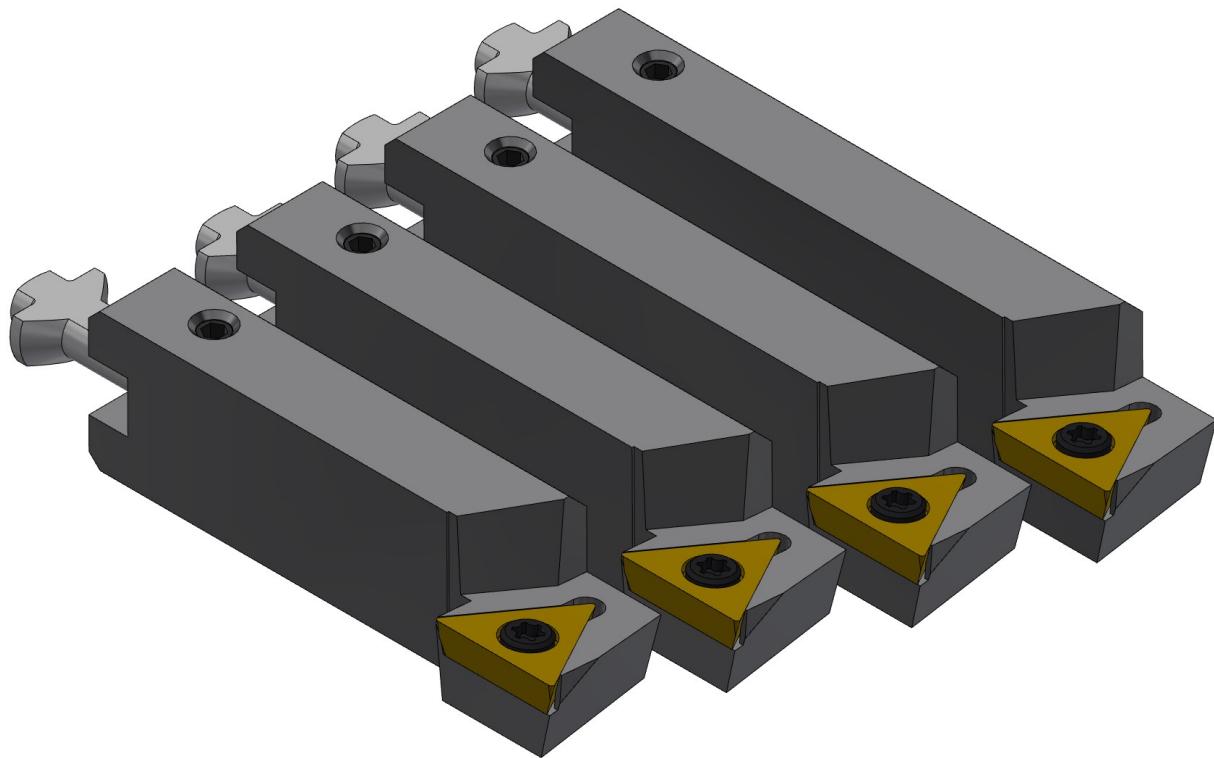
6598 Series Insert Cartridge Parts and Size Chart

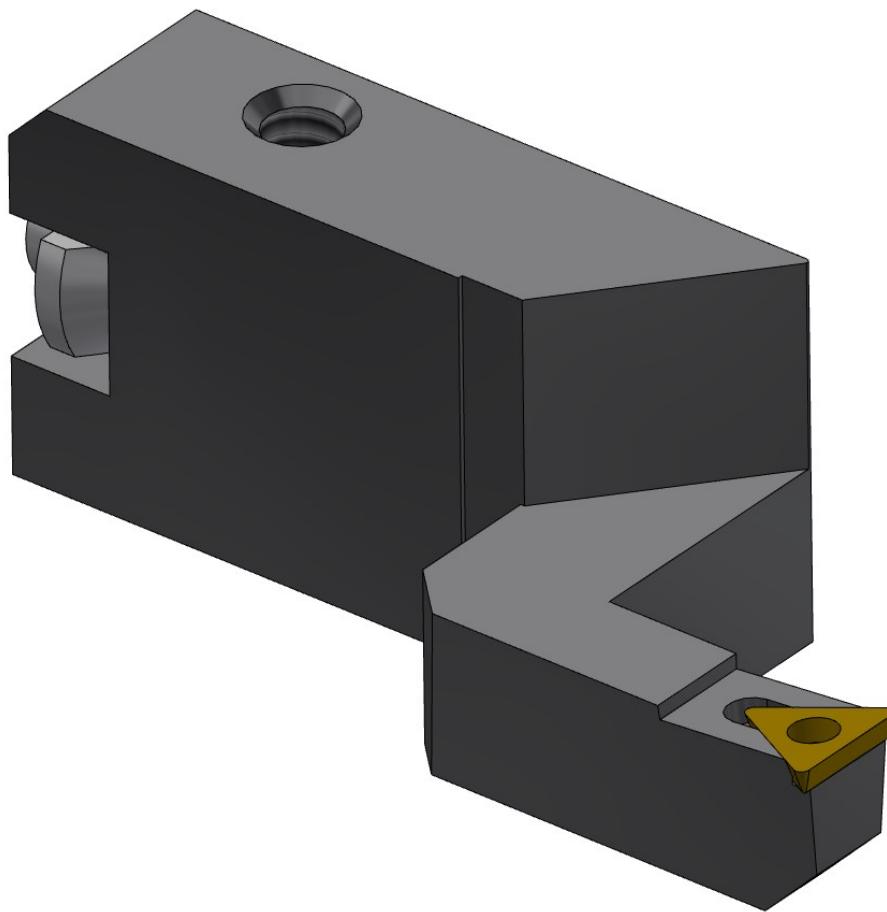
6598 Series Tool Bit when used with 6520 Holders		
Tool Bit	Tool Holder	Bore Range
6598M	6520H	3.75" – 4.00"
6598M	6520A	4.00" – 4.50"
6598K	6520B	4.50" – 5.00"
6598K	6520C	5.00" – 5.50"
6598K	6520D	5.50" – 6.00"
6598K	6520E	6.00" – 6.50"
6598K	6520F	6.50" – 7.00"
6598K	6520G	7.00" – 8.00"



6260L Insert Cartridge Parts**6260W Insert Cartridge Parts**

6593 Series Insert Holder Parts**6520 Series Toolholders**

6801 Series Insert Holders

6801M Tool Holder Package

501-29-6G INSERT, TRIANGLE-.160" IC 1/64 RADIUS



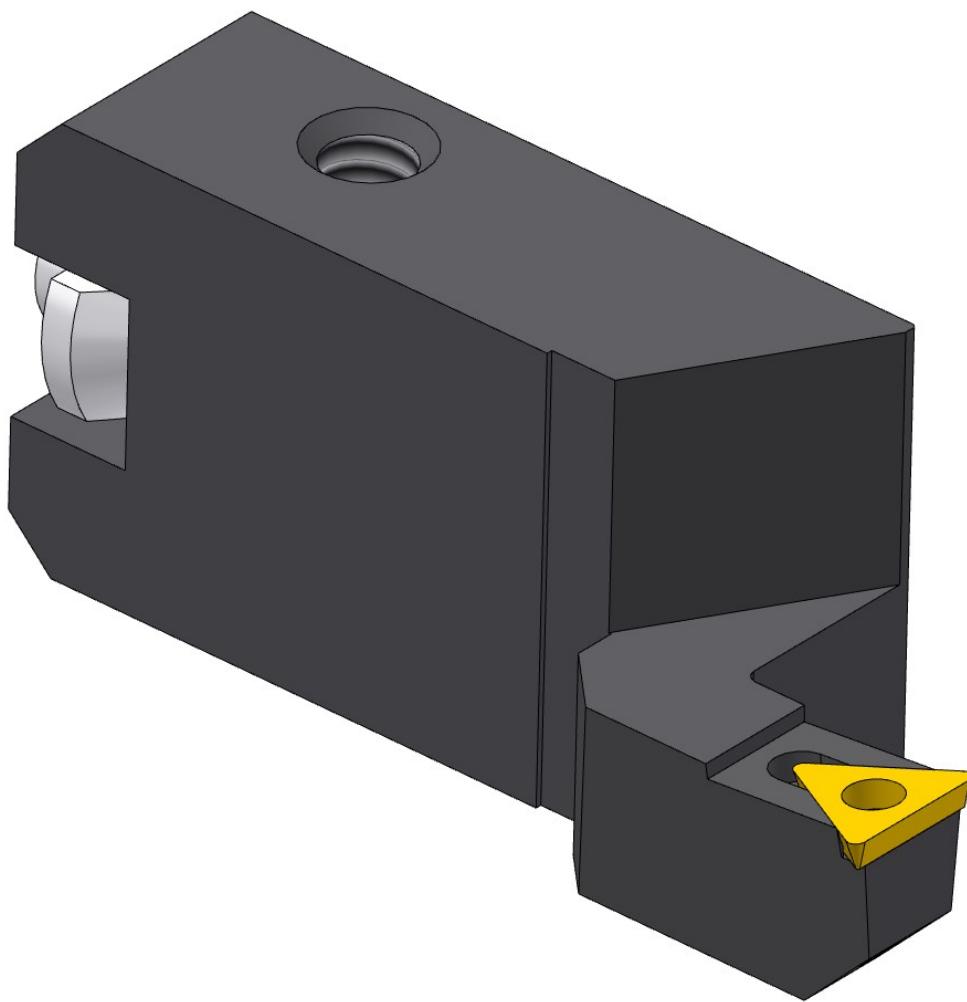
501-29-6H SCREW, INSERT THRUST FACING
TOOLBIT-.160" IC TRIANGLE



T7D T7 TORX TIP HOLDING SCREW DRIVER



T8D T8 TORX TIP HOLDING SCREW DRIVER

6801P Tool Holder Package

501-29-6G INSERT, TRIANGLE-.160" IC 1/64 RADIUS



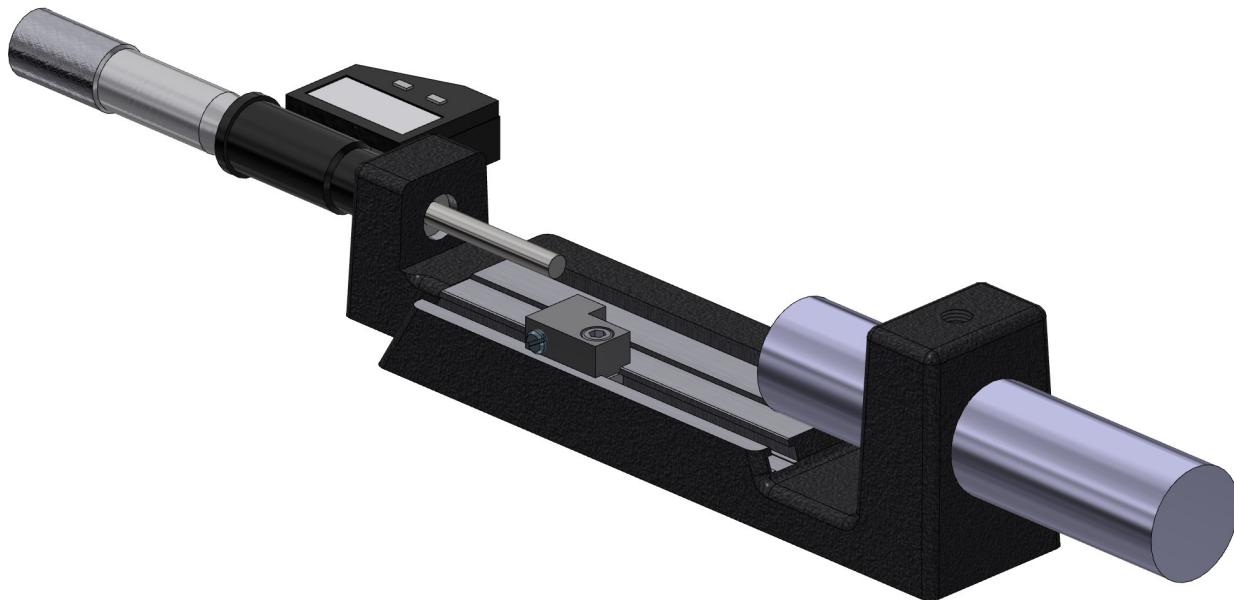
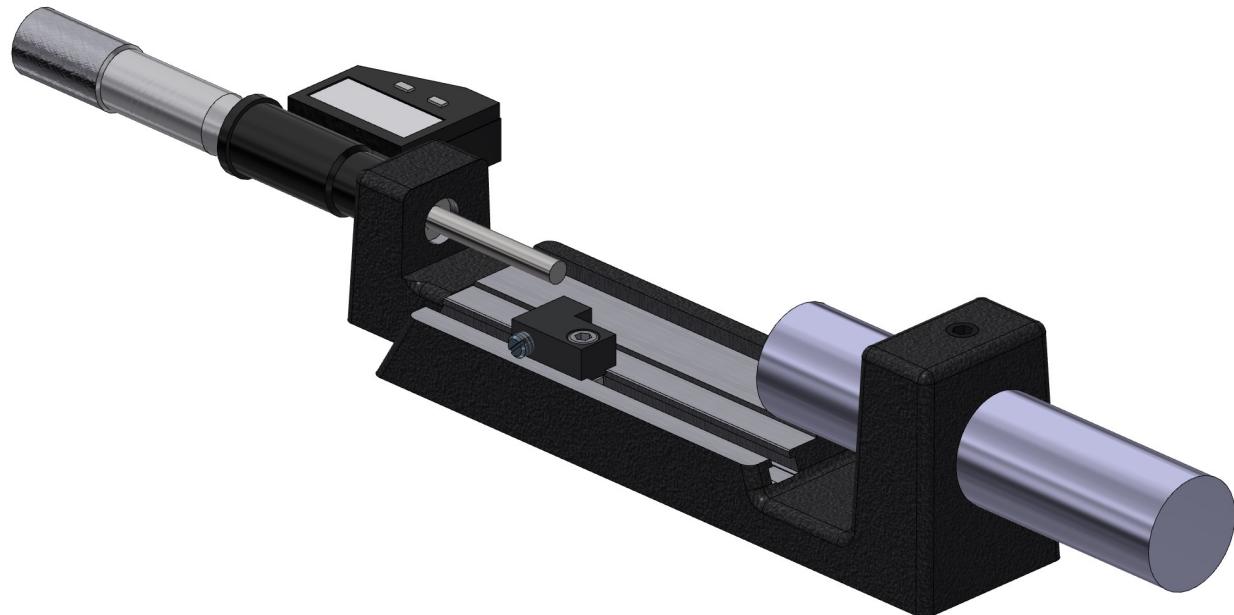
501-29-6J INSERT, TRIANGLE-.160" IC 1/32 RADIUS

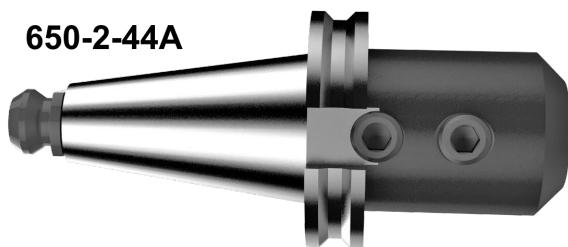
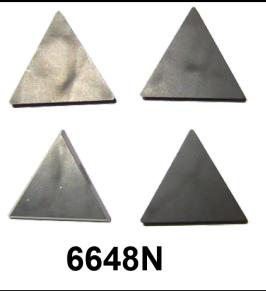


511-29-12F WRENCH, TORX



T8D T8 TORX TIP HOLDING SCREW DRIVER

Micrometers:**900-2-19 Tool Setting Micrometer, 1/2"****Tooling** 6801 Series Tool Holders**900-2-20 Tool Setting Micrometer, 3/4"****Tooling** 6593, 6520, and 6259 Series Tool Holders

General Purpose Tooling**6648W Cat 3400 Series Tappet Bore Repair Tooling Package Components****650-2-44A****6648D****6648C****6648B****6648F****6648N****502-11-39F****MF-71D****650-2-34D**

650-2-53 Splayed 4 Bolt Main Cap Machining Tooling Package Components

650-2-44J



650-2-11F



650-2-53B



650-2-11K



650-2-44M



650-2-44N



650-2-53C

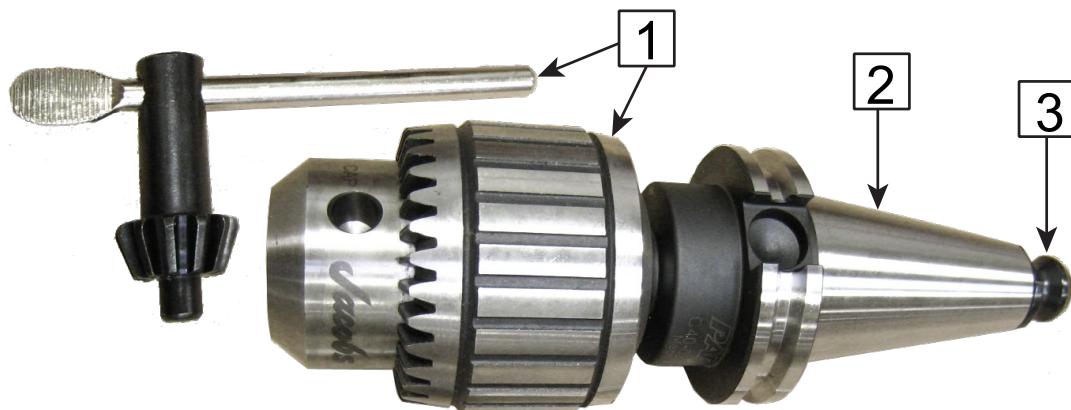


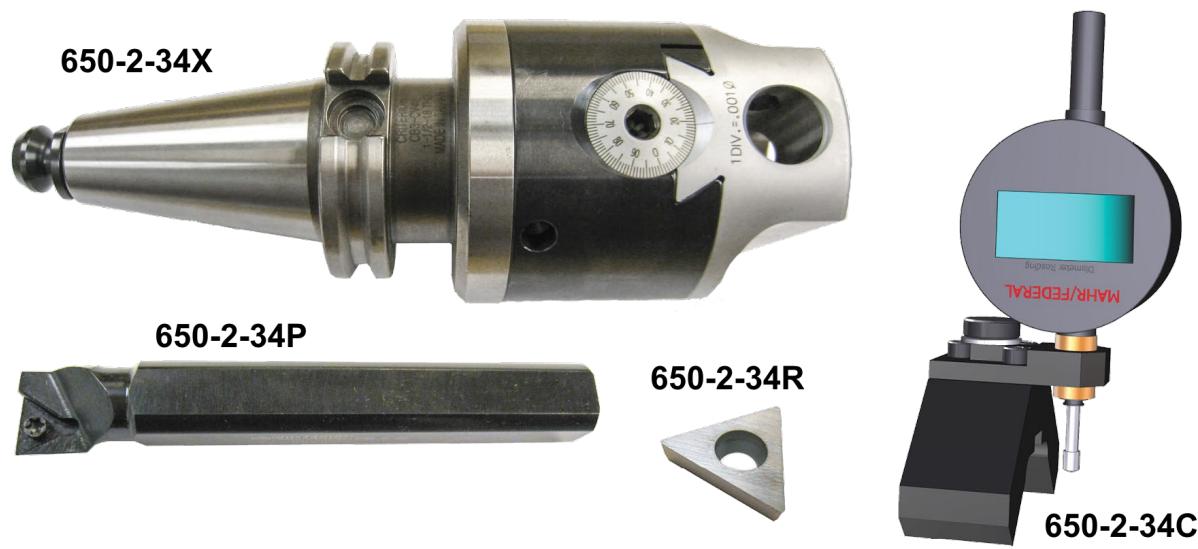
650-2-53A



650-2-53D



650-2-44M Drill Chuck Kit**10124 Collet Kit**

11116 Cross Feed Head Assembly**650-2-3S Cutterhead Package Components**

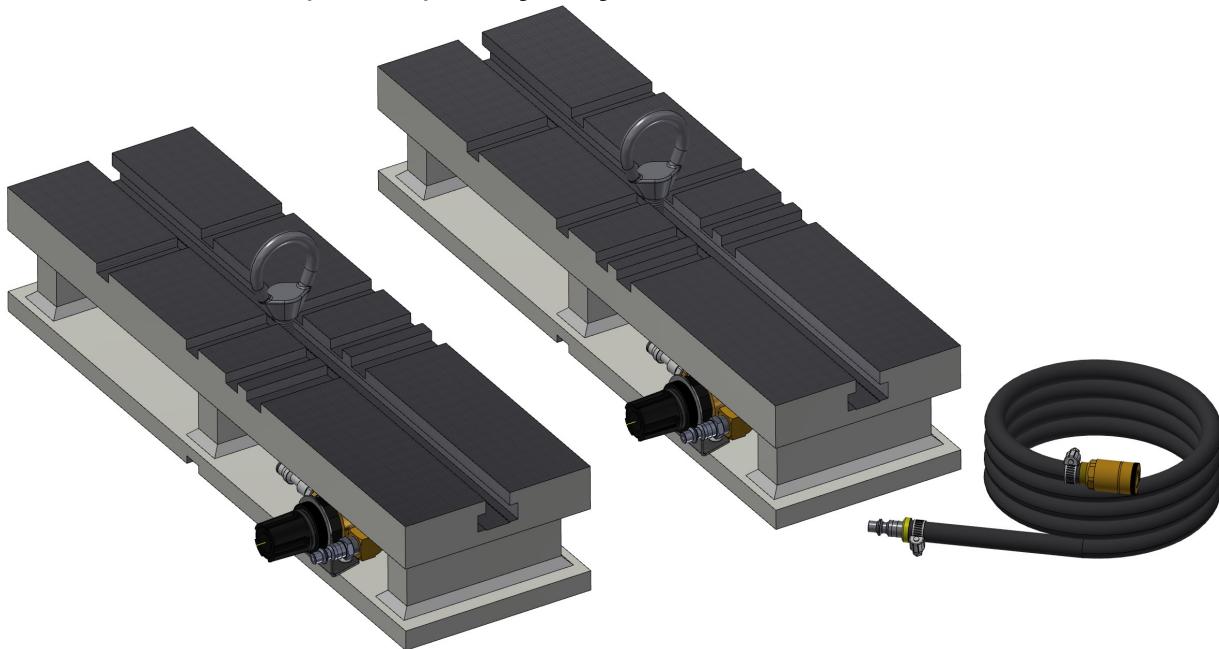
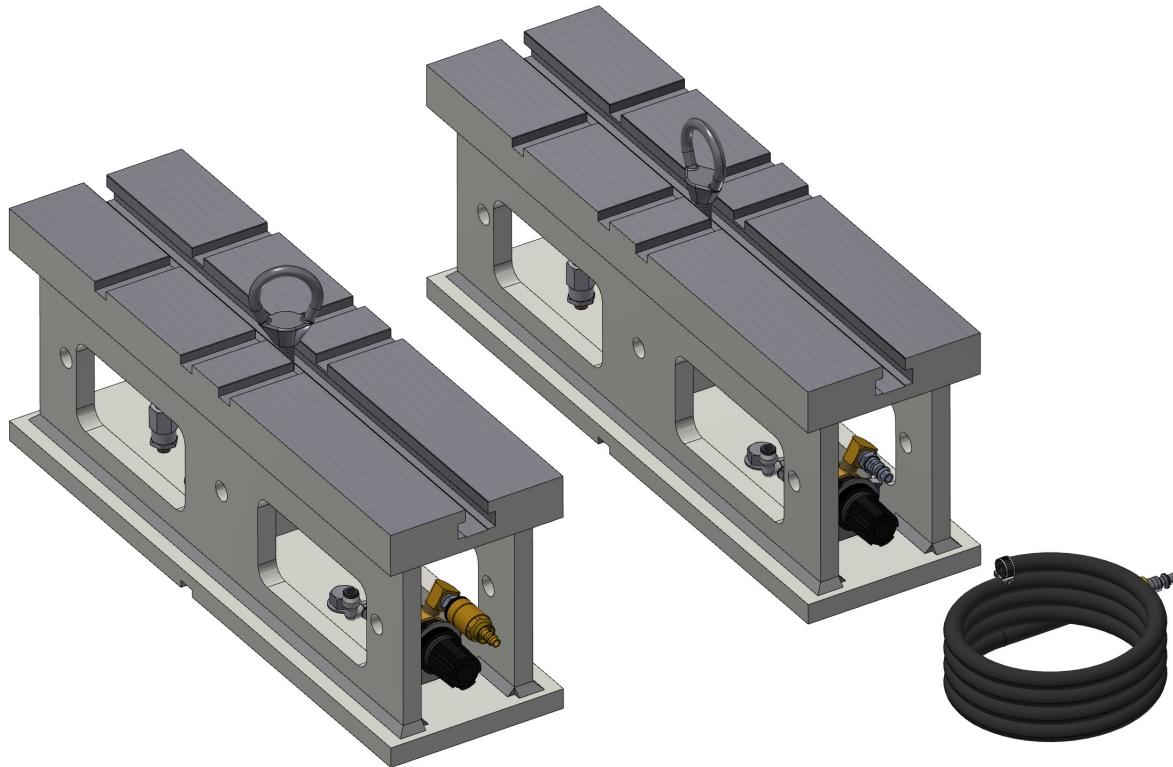
650-2-11K Tap Driver**650-2-44A Endmill Adapter, 1" (25.4mm) Shank Tooling****650-2-45H Endmill, 1" (25.4mm) x 8.5" (216mm) OL Roughing**

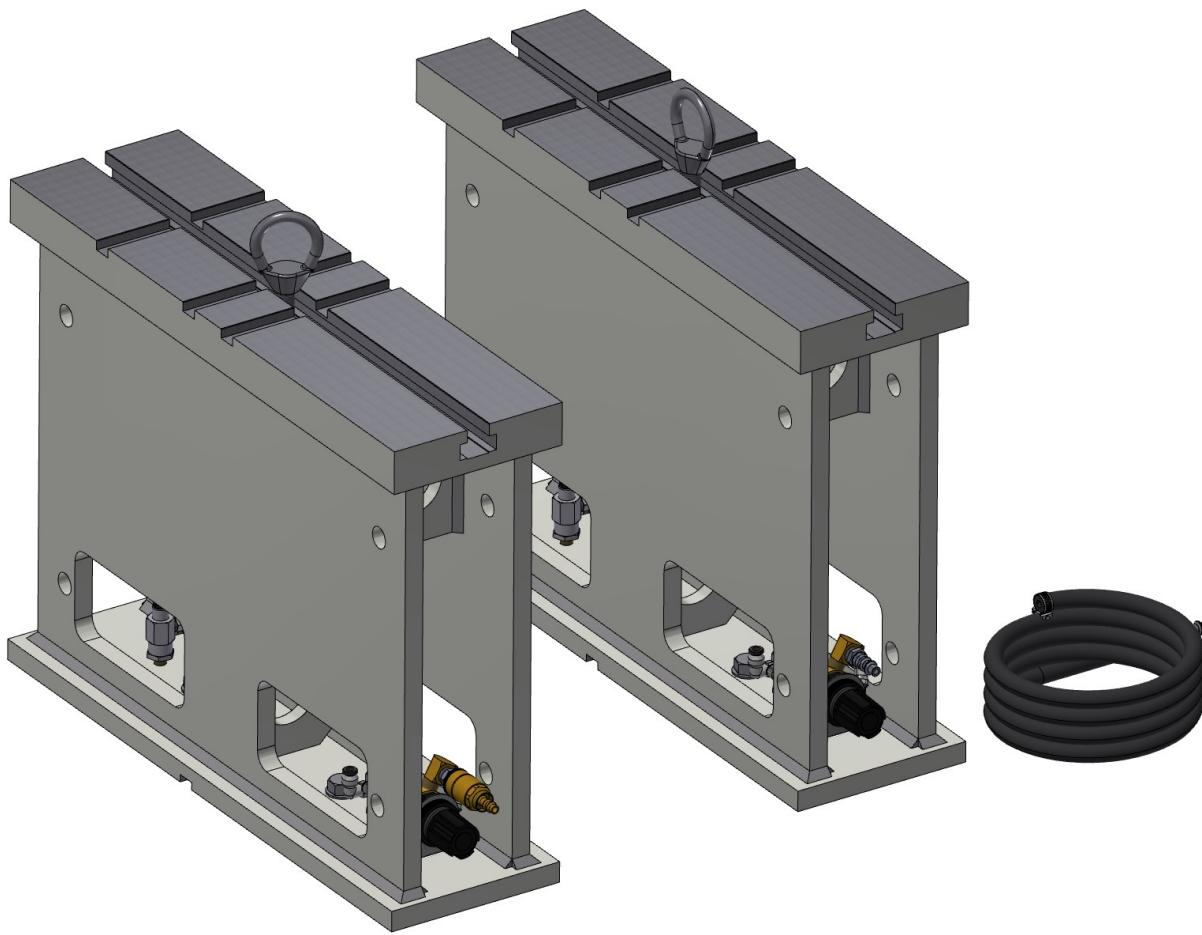
650-2-60B Lifter Bore Tooling Kit**650-2-60C****650-2-60E****650-2-60D****650-2-60F****650-2-60K****650-2-60J****650-2-60H****650-2-60G****650-2-20C****650-2-20L****650-2-32J****650-2-60L****650-2-44A****511-29-12F****650-2-32U**

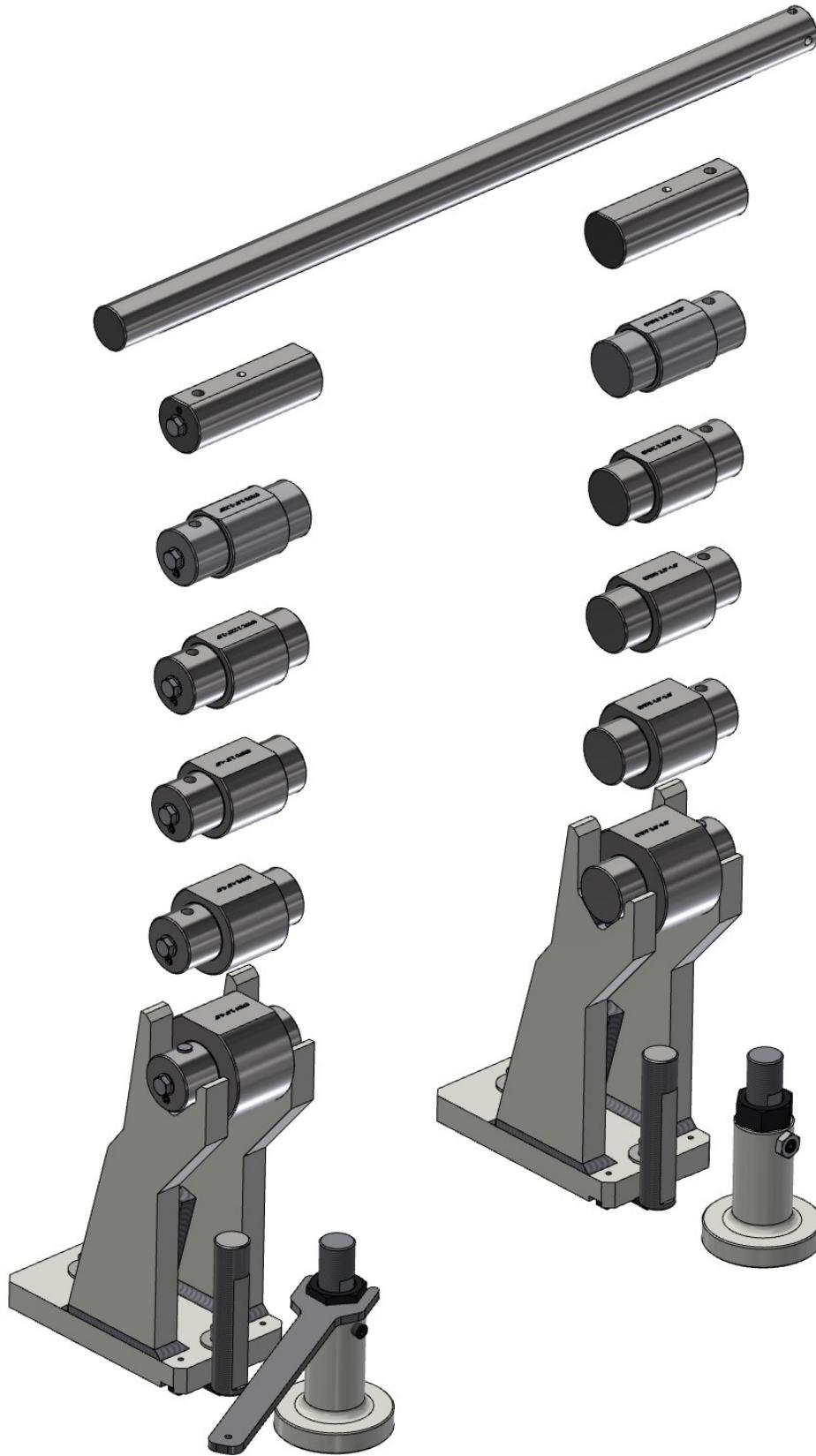
Fixtures: Parallels**11115 2" (50mm) X 3" (75mm) Parallels**

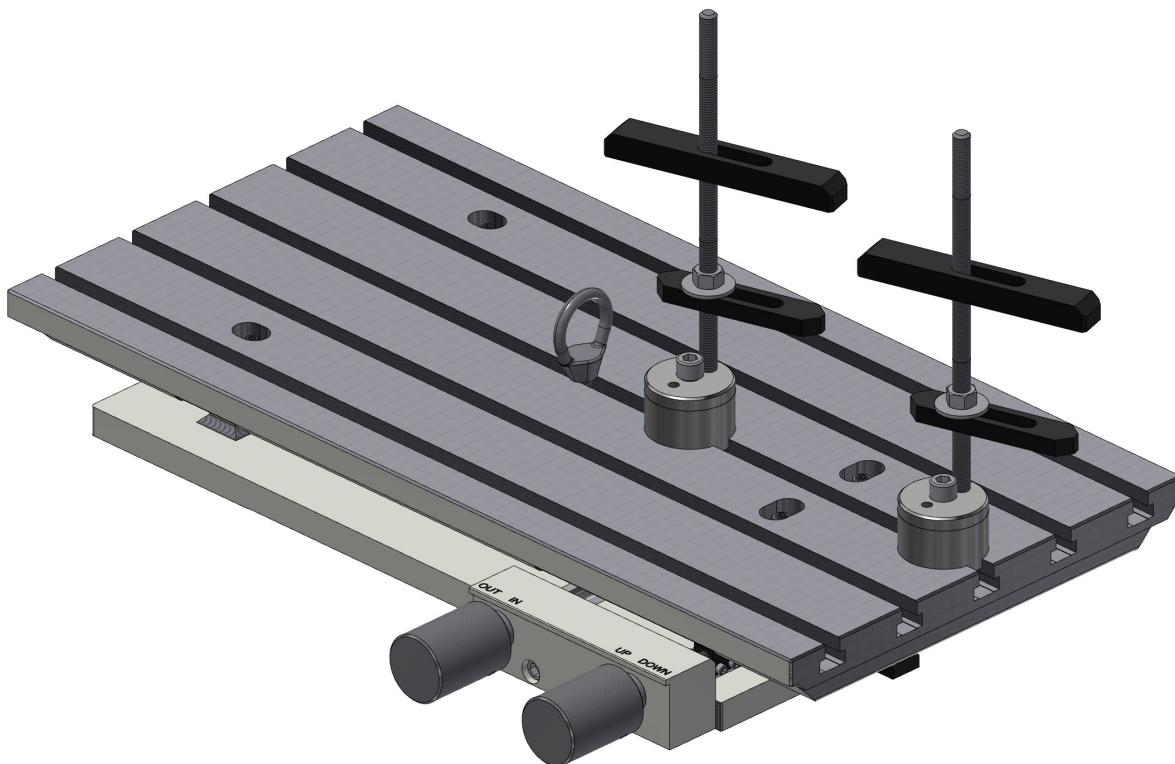
Sold as complete set.

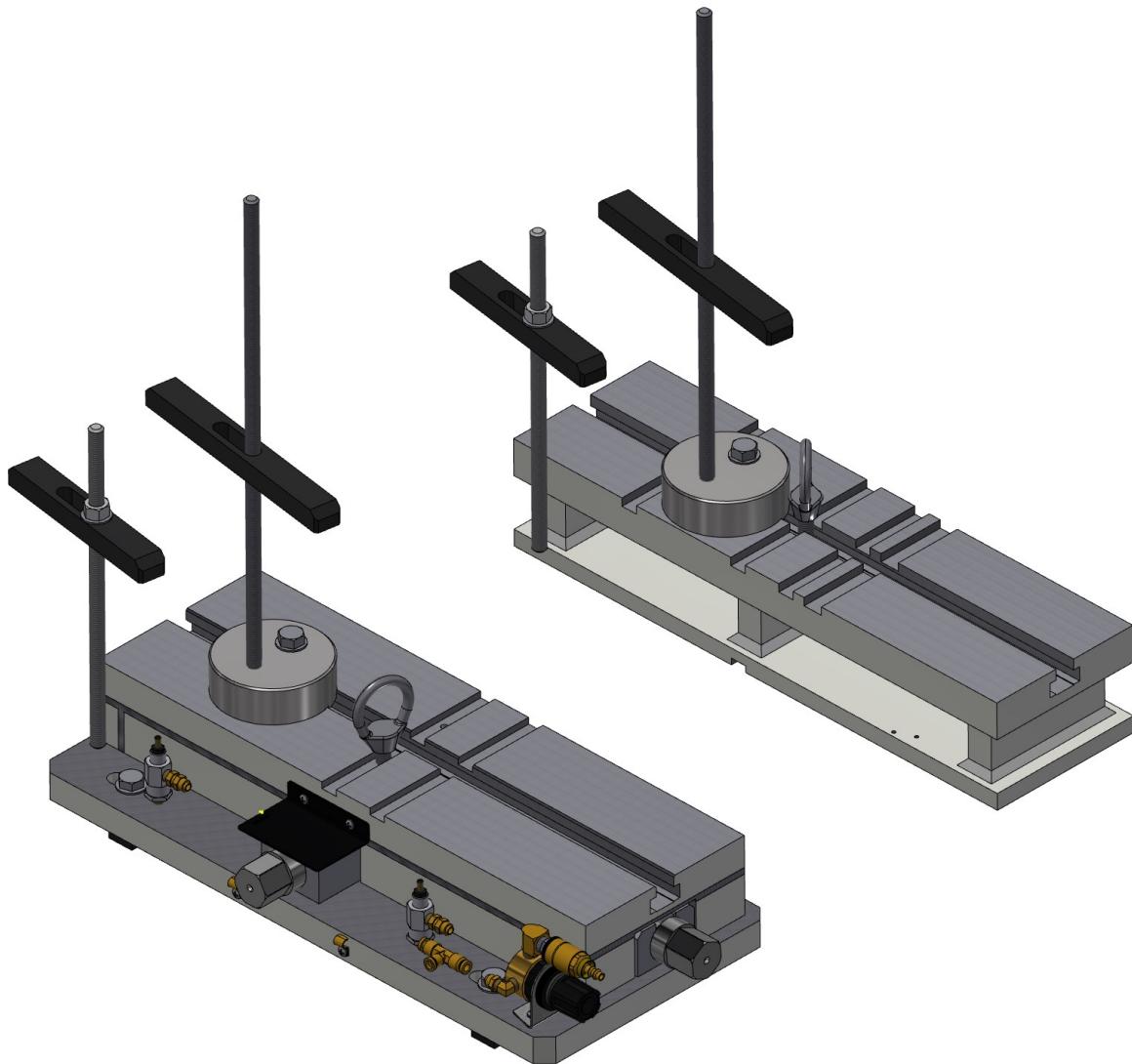


11113L Universal 4" (102mm) Heavy Duty T-Slot Parallels**11112 Universal 8" (203mm) Heavy Duty T-Slot Parallels Parts**

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

Block Locating Fixtures**11121 Small to Mid-Range Universal Fixture, 2-7" Main Bearing Diameter**

650-3-56 Line Bore Pivot Table Parts

11113 Adjustable Universal Line Boring Parallel Assembly Parts

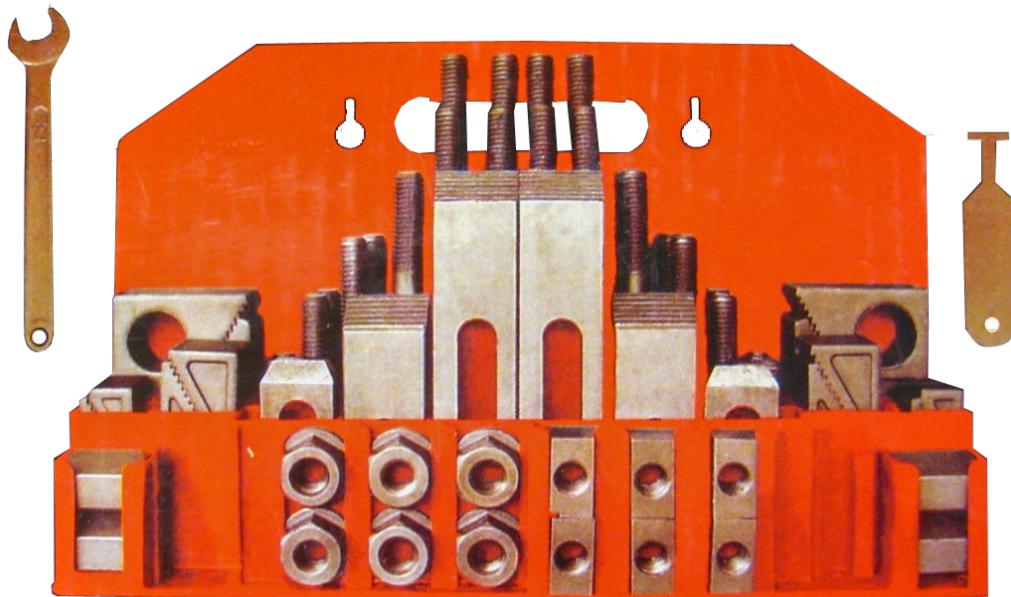
6843 90 Degree V Block Supports Parts**6789L 113 Degree V Block Supports for Detroit Diesel V53**

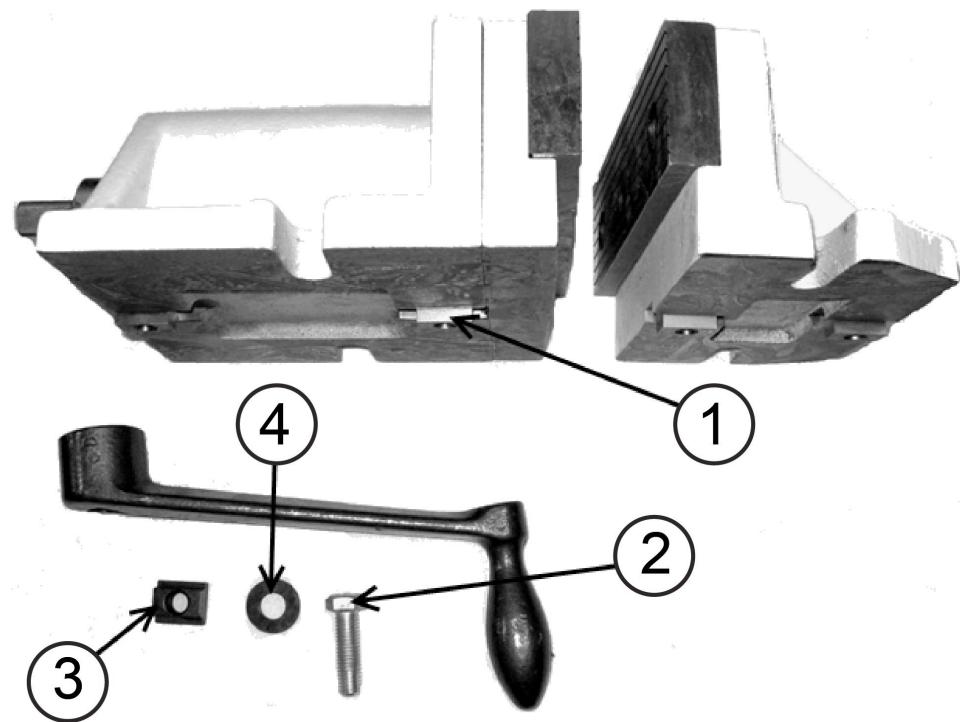
6789E 115 Degree V Block Supports**6789N 116 Degree V Block Supports**

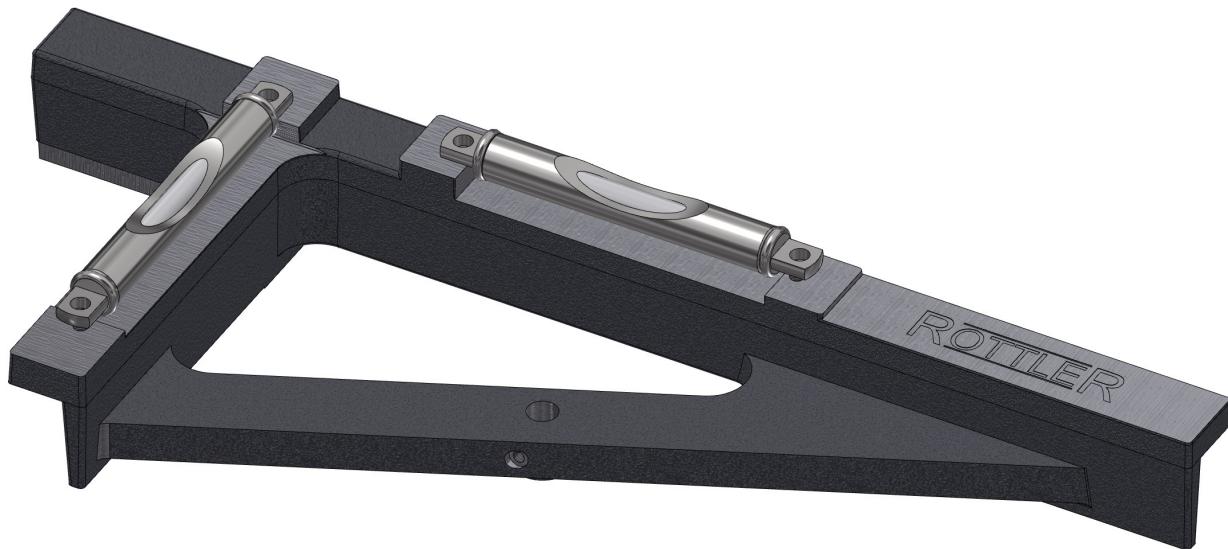
6866 Wedge for Cummins 59liter Camshaft Line Boring

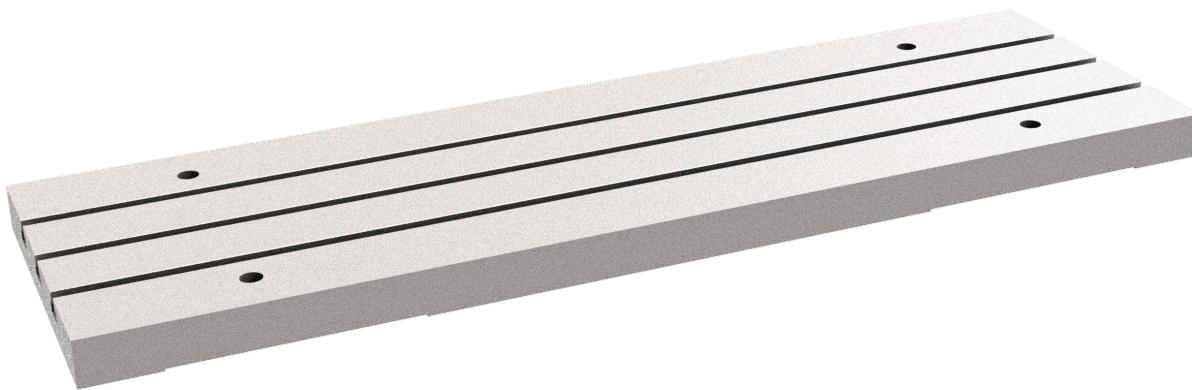
Miscellaneous Fixtures/Accessories**650-3-37 1/2" (127mm) Universal Clamping Kit**

Sold only as complete package.

**7209M Dual Axis Leveling Table**

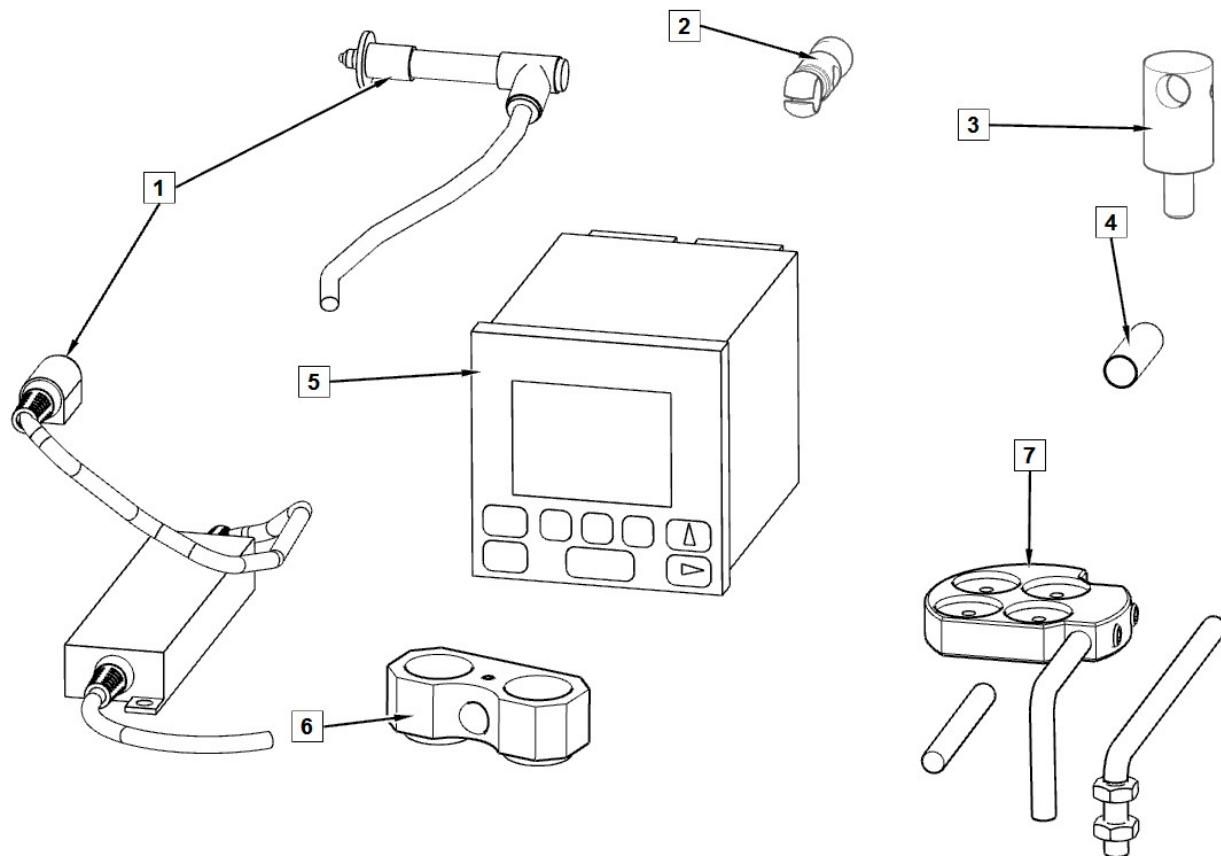
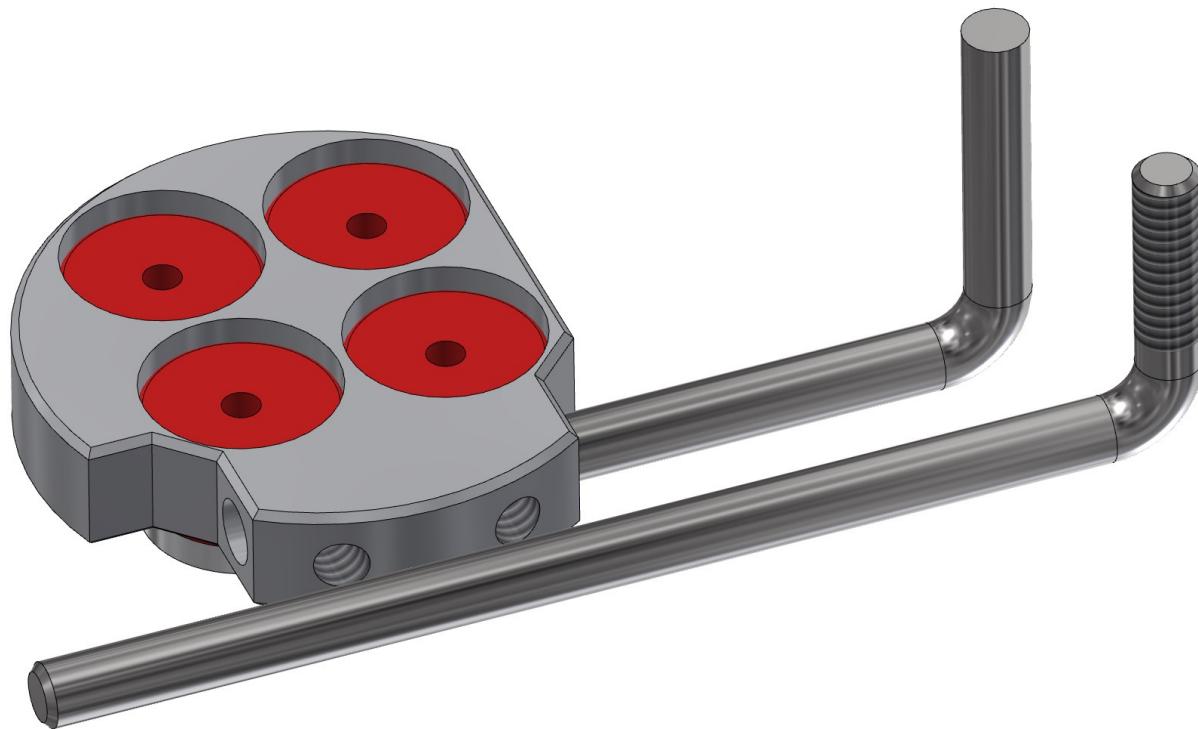
7209N 2-Piece Vise

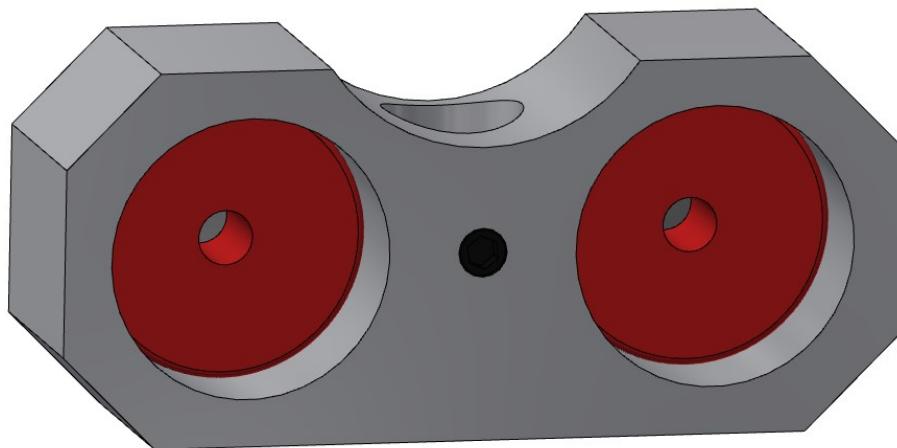
1111 Clamp Tower**7152A Dual Axis Level**

9111A T-Slot Plate**650-2-60N Setting Fixture, Lifter Tooling Package**
Sold only as complete package.

Auxiliary Equipment**650-3-59Y Renishaw Wireless Probing System**

ITEM	PART #	DESCRIPTION
1	650-2-44L	CAT 40 RETENTION KNOB
2	6648P	CAT 40 SHANK
3	650-3-59Z	PROBE RMP40
4	650-3-59C	50MM LONG X 6MM DIA. STYLUS PROBE
5	650-3-59K	STYLUS EXTENSION (50MM)
6	650-3-59D	100MM LONG X 6MM DIA. STYLUS PROBE
7	6648T	STYLUS ADAPTER FOR STYLUS
8	6648R	SWIVEL ADAPTER FOR STYLUS
9	6648U	LITHIUM BATTERY
10	650-3-59E	20MM LONG X 2MM DIA. STYLUS PROBE
11	6648Q	17.5MM LONG X 6MM DIA. STYLUS PROBE
12	6648S	CRASH PROTECTION DEVICE FOR STYLUS

502-12-7B Digital Runout Probe and Readout Components**502-12-4 General Purpose Magnetic Indicator Holder Parts**

502-12-4A Magnetic Indicator Holder Parts

502-9-9S Indicator Mount
Angled for small diameter main line bores

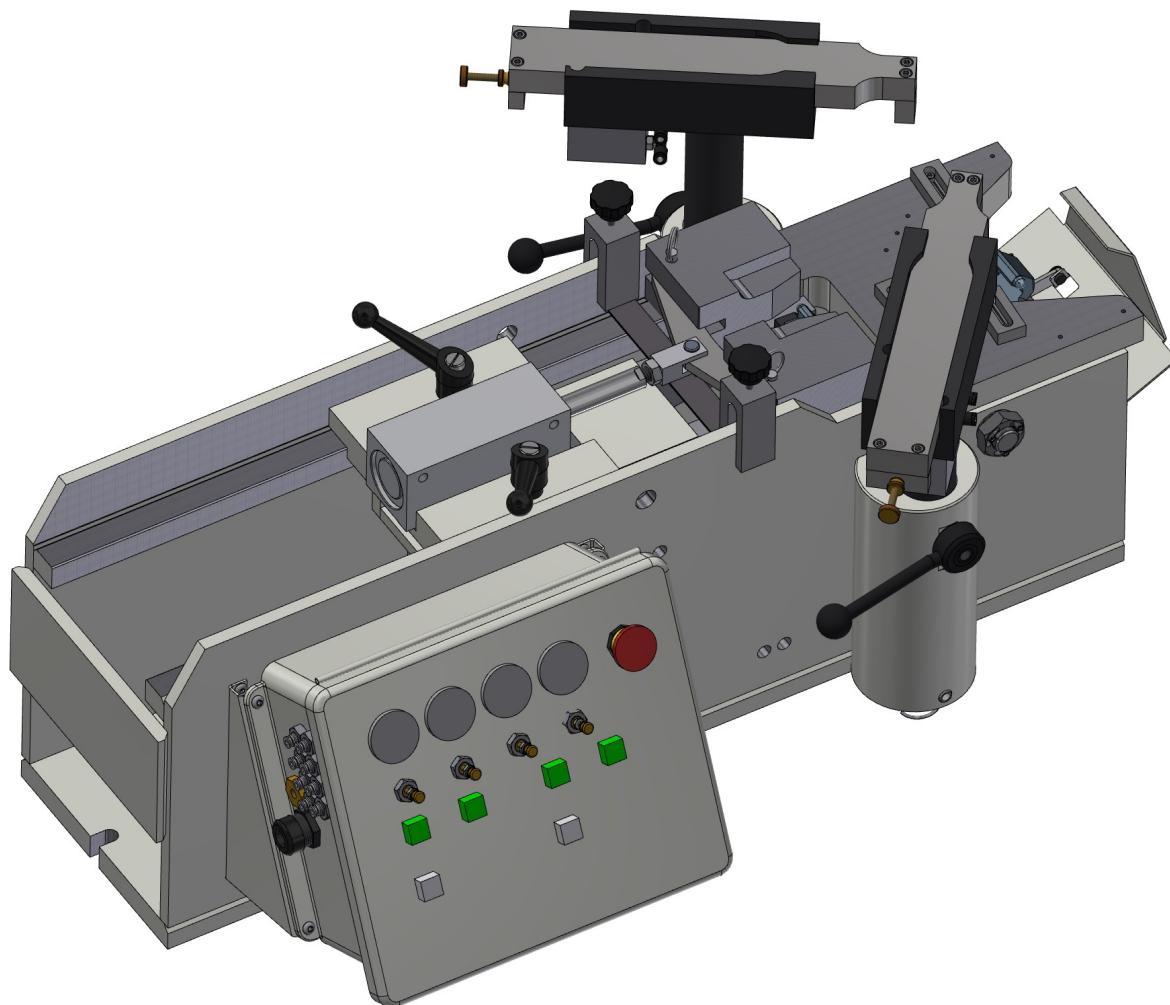


502-9-9A Mechanical Run Out Indicator
General Purpose (.001" Inch Resolution)

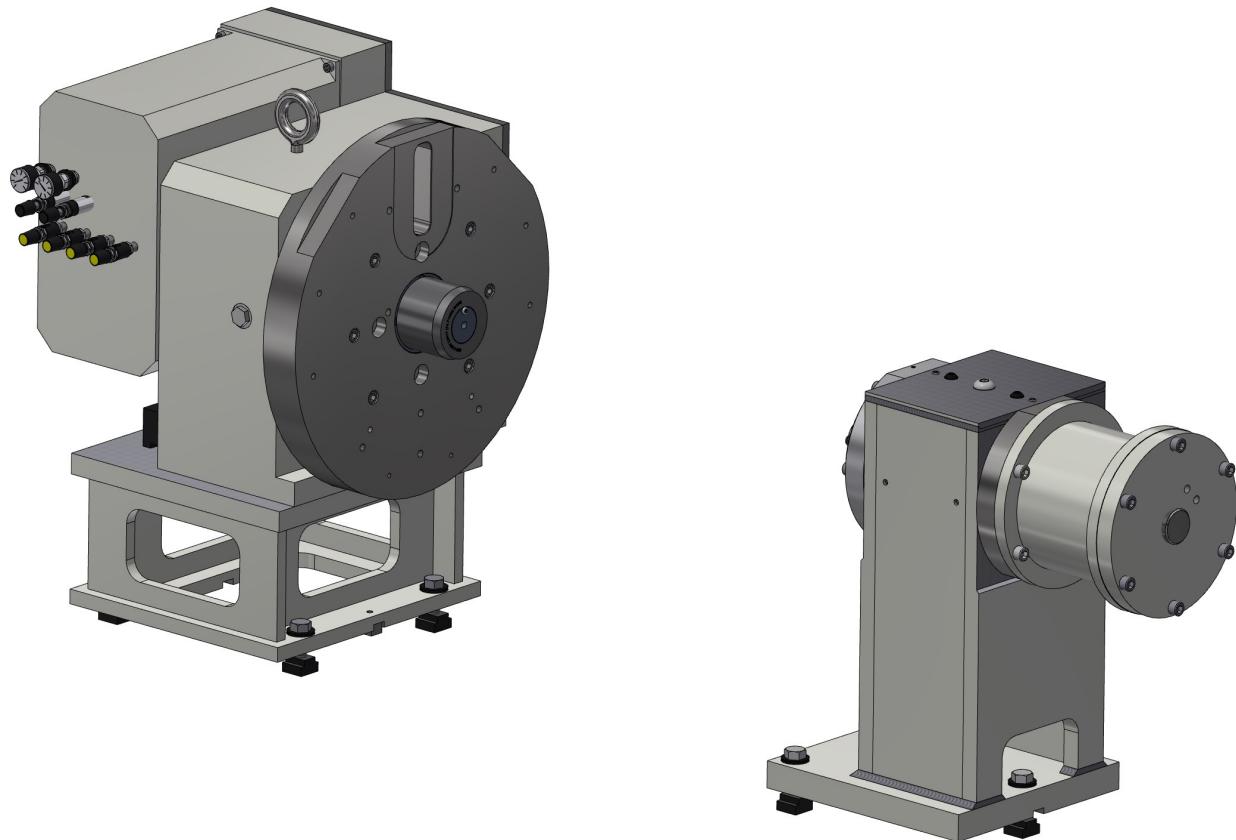


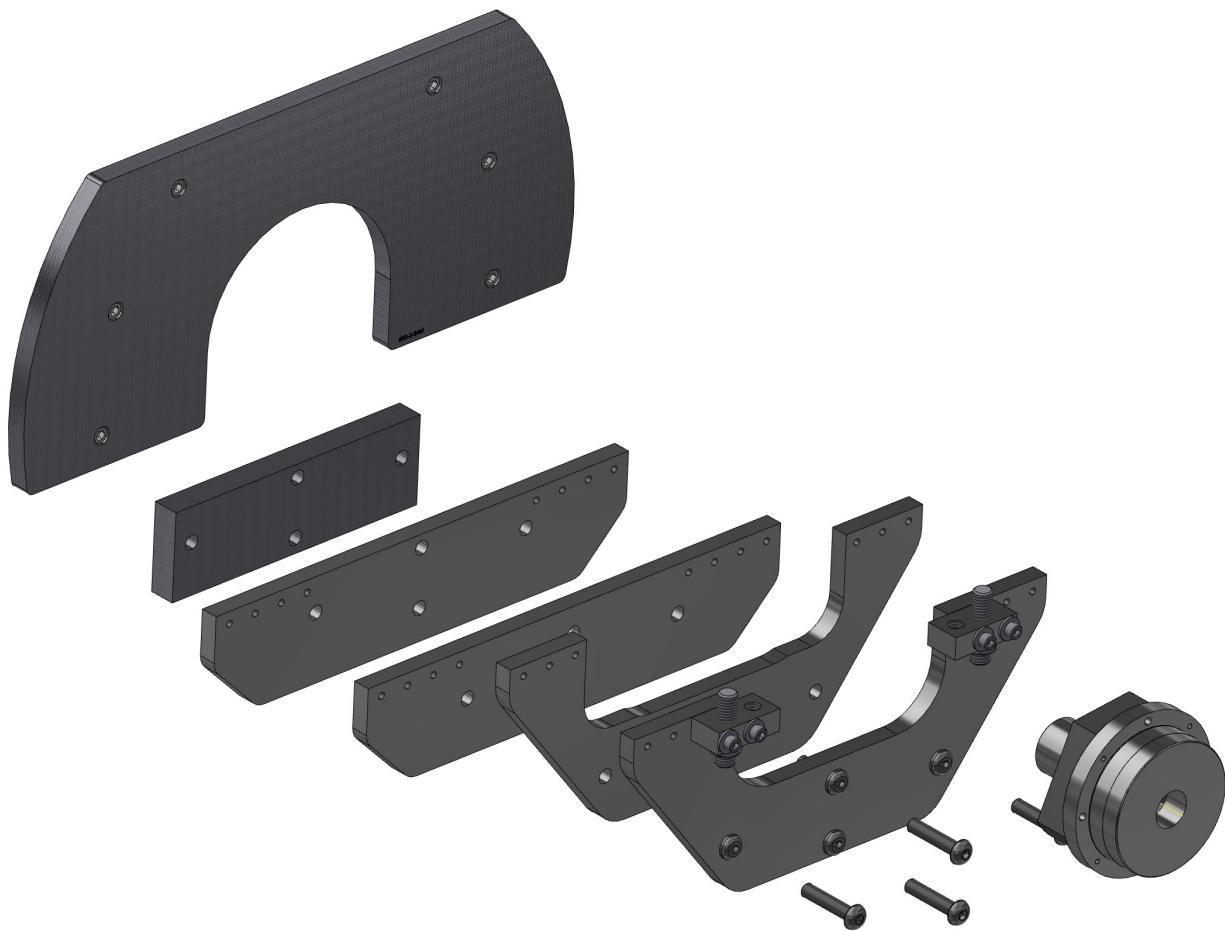
502-9-9J Mechanical Run Indicator
General Purpose (.01mm Metric Resolution)

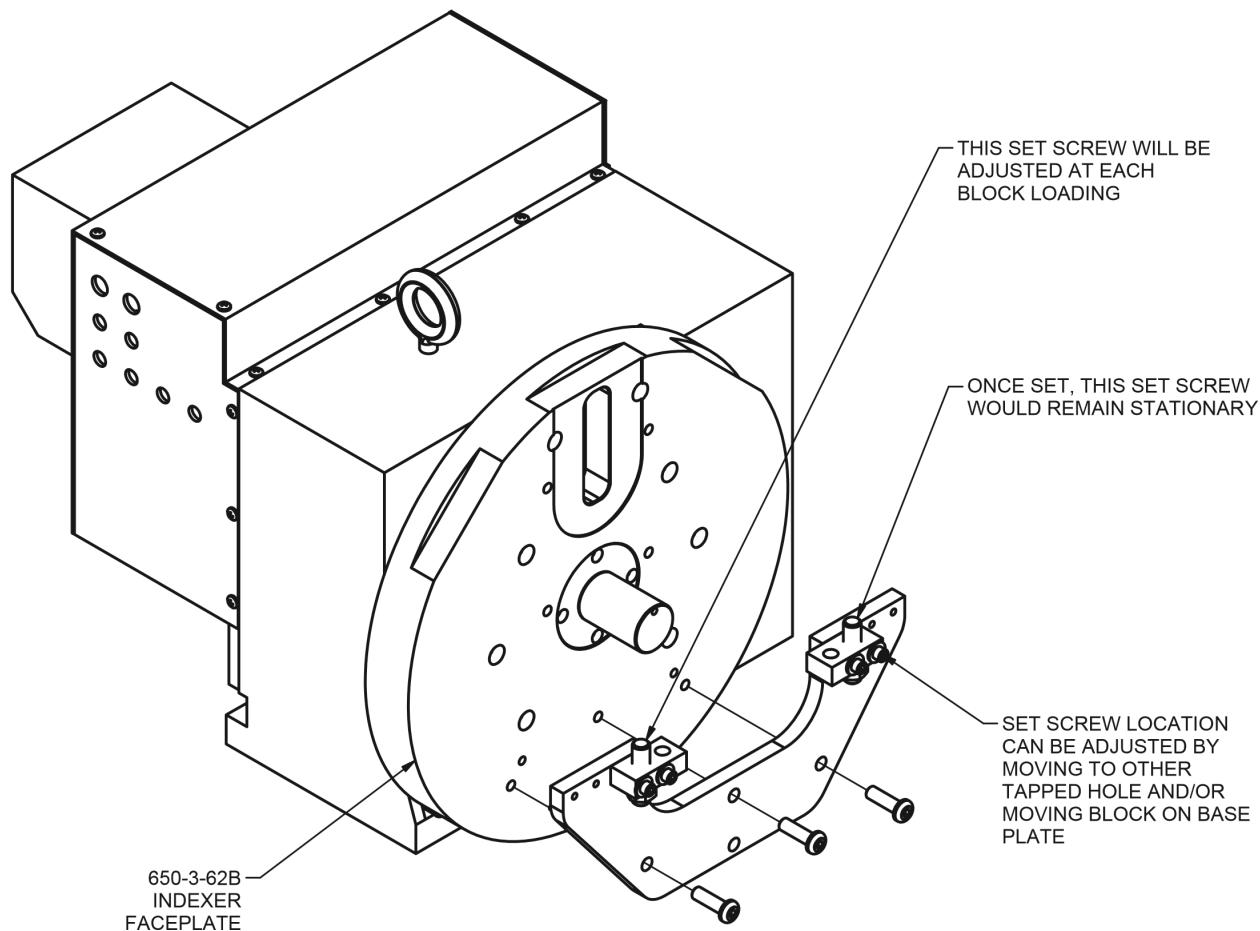


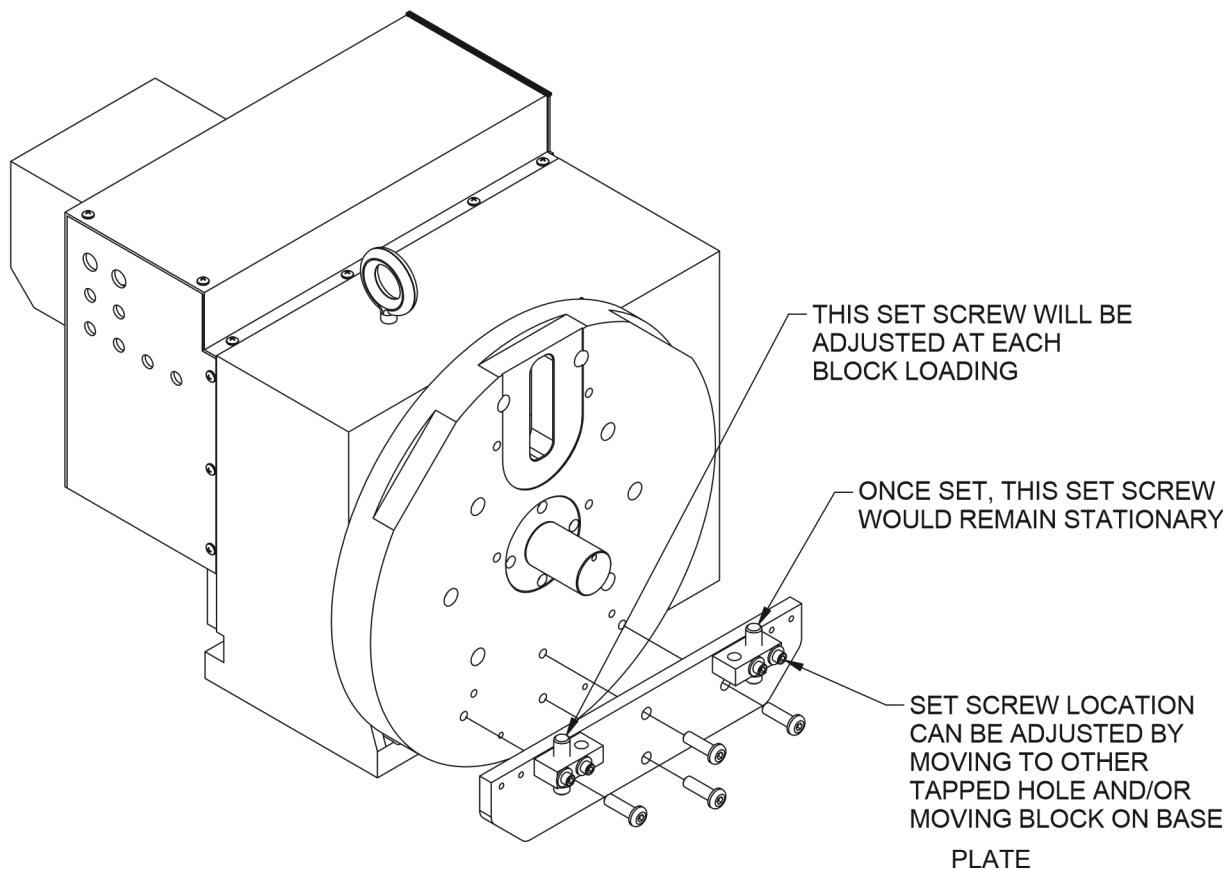
650-3-44S Rottler Precision Connecting Rod Fixturing System

650-3-64 Heavy Duty Precision Connecting Rod Fixturing System
For large blocks, such as CAT 3500, Waukesha 7042, White Superior 825

690-3-70 Automatic 4Th Axis Block Roll Over Fixture

650-3-84 Overhead Cam Block Fixture Plates for 4th Axis

650-3-84 Overhead Cam Block Fixture Setup



**650-3-84 OVERHEAD CAM BLOCK FIXTURE
INSTALLATION AND OPERATING INSTRUCTIONS
Y-BLOCK APPLICATIONS**

INSTALLATION: LOCATE THE 650-3-84E BASE PLATE ONTO THE 650-3-62B INDEXER FACEPLATE USING (4) EXISTING 3/8-16UNC TAPPED HOLES IN FACEPLATE. FASTEN BASE PLATE USING (4) MF-97C SOCKET BUTTONHEAD SCREWS.

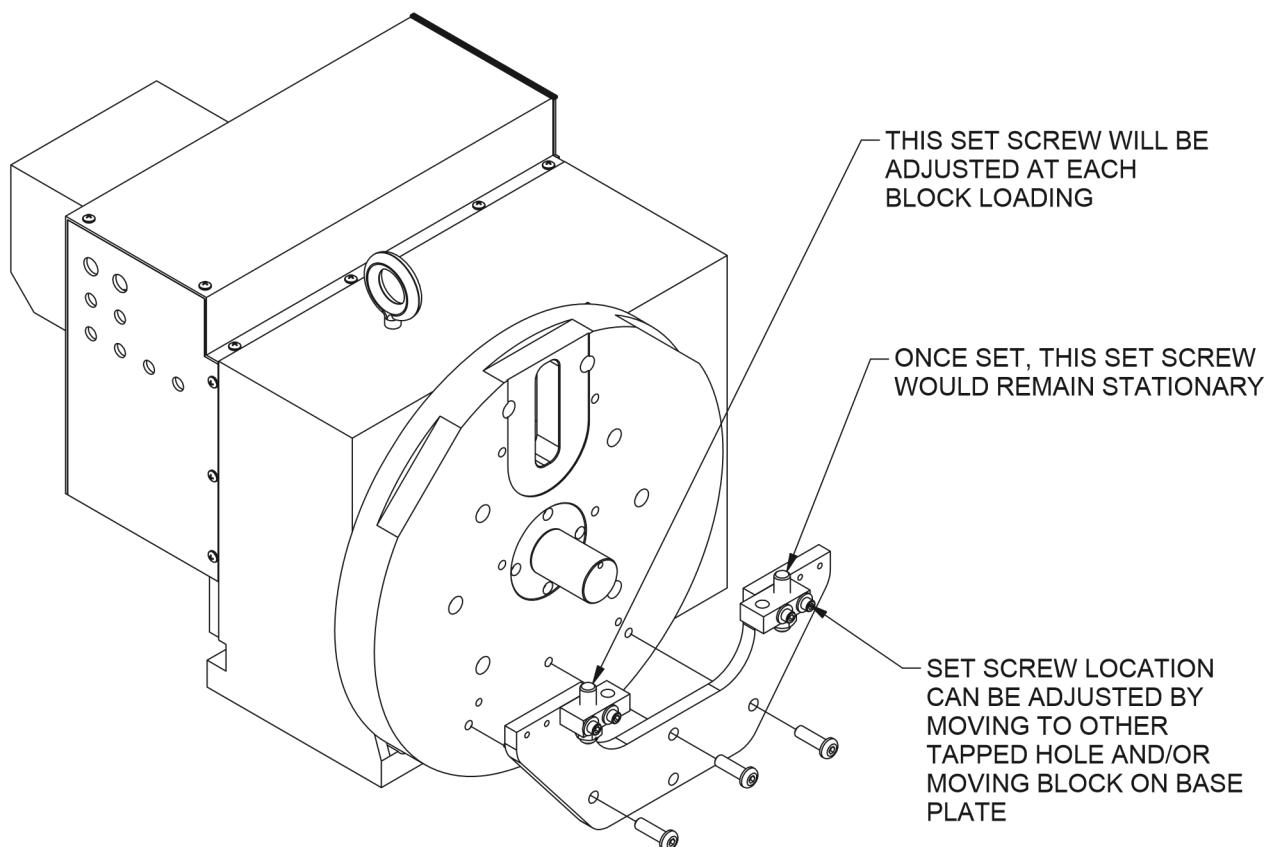
OPERATING: THIS FIXTURE LOCATES THE PAN RAILS OF OVERHEAD CAM BLOCKS USING (2) 650-3-84D FLAT POINT SET SCREWS TO LEVEL THE BLOCK.

INSTALL THE BLOCK USING THE APPROPRIATE MAIN LOCATORS WITH THE INDEXER SET AT 0 DEGREES.

WITH THE MF-171 HEX NUTS LOOSE, ADJUST THE 650-3-84D SET SCREWS TO CONTACT THE PAN RAIL OF THE BLOCK. MULTIPLE MOUNTING HOLES ARE PROVIDED TO ALTER THE LOCATION OF THE 650-3-84C PUSH BLOCKS AND THE SET SCREWS CAN BE MOVED TO EITHER HOLE TO FIT DIFFERENT BLOCKS.

ONCE THE BLOCK IS LEVEL AND THE SET SCREWS ARE BOTH CONTACTING THE PAN RAILS, TIGHTEN THE MF-171 HEX NUTS, CHECK THE BLOCK FOR LEVEL, AND MACHINE.

TO UNLOAD THIS BLOCK AND LOAD ANOTHER BLOCK OF THE SAME STYLE:
LOOSEN THE HEX NUT AND SET SCREW NEAREST TO THE OPERATOR. REMOVE THE BLOCK AND INSTALL THE NEXT BLOCK. ROTATE THIS BLOCK TO CONTACT THE SET SCREW TO THE REAR OF THE FACEPLATE (FURTHEST FROM THE OPERATOR). ADJUST FRONT SET SCREW TO CONTACT THE BLOCK AND TIGHTEN THE HEX NUT. IT IS ADVISABLE TO CHECK THE BLOCK FOR LEVEL DUE TO THE POSSIBILITY OF VARIATION BETWEEN BLOCKS.



**650-3-84 OVERHEAD CAM BLOCK FIXTURE
INSTALLATION AND OPERATING INSTRUCTIONS
V-BLOCK APPLICATIONS**

INSTALLATION: LOCATE THE 650-3-84A BASE PLATE ONTO THE 650-3-62B INDEXER FACEPLATE USING (4) EXISTING 3/8-16UNC TAPPED HOLES IN FACEPLATE. FASTEN BASE PLATE USING (4) MF-97C SOCKET BUTTONHEAD SCREWS.

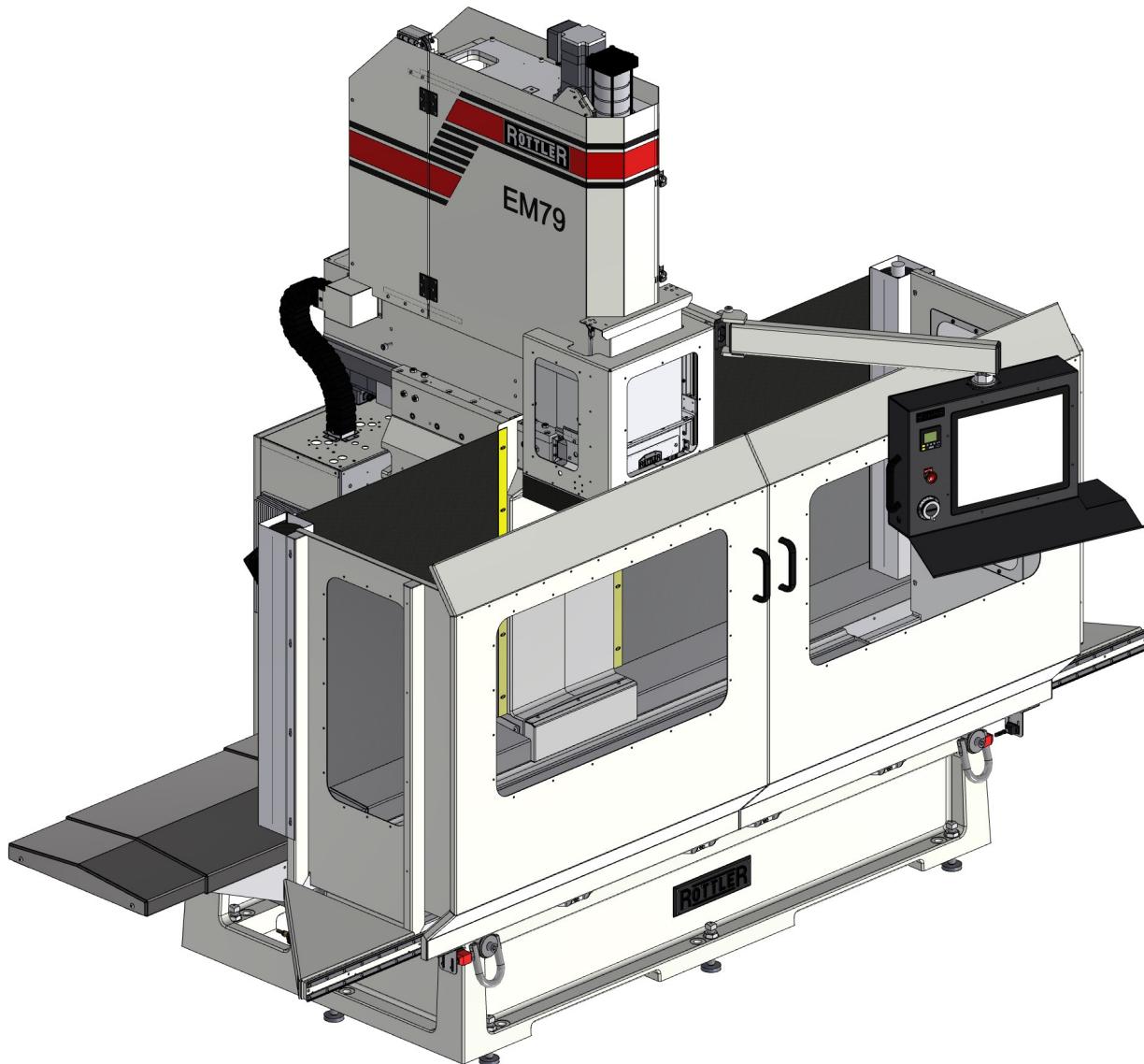
OPERATING: THIS FIXTURE LOCATES THE PAN RAILS OF V-STYLE OVERHEAD CAM BLOCK USING (2) 650-3-84D FLAT POINT SET SCREWS TO LEVEL THE BLOCK.

INSTALL THE BLOCK USING THE APPROPRIATE MAIN LOCATORS WITH THE INDEXER SET AT 0 DEGREES.

WITH THE MF-171 HEX NUTS LOOSE, ADJUST THE 650-3-84D SET SCREWS TO CONTACT THE PAN RAIL OF THE BLOCK. MULTIPLE MOUNTING HOLES ARE PROVIDED TO ALTER THE LOCATION OF THE 650-3-84C PUSH BLOCKS AND THE SET SCREWS CAN BE MOVED TO EITHER HOLE TO FIT DIFFERENT BLOCKS.

ONCE THE BLOCK IS LEVEL AND THE SET SCREWS ARE BOTH CONTACTING THE PAN RAILS, TIGHTEN THE MF-171 HEX NUTS, CHECK THE BLOCK FOR LEVEL, AND MACHINE.

TO UNLOAD THIS BLOCK AND LOAD ANOTHER BLOCK OF THE SAME STYLE:
LOOSEN THE HEX NUT AND SET SCREW NEAREST TO THE OPERATOR. REMOVE THE BLOCK AND INSTALL THE NEXT BLOCK. ROTATE THIS BLOCK TO CONTACT THE SET SCREW TO THE REAR OF THE FACEPLATE (FURTHEST FROM THE OPERATOR). ADJUST FRONT SET SCREW TO CONTACT THE BLOCK AND TIGHTEN THE HEX NUT. IT IS ADVISABLE TO CHECK THE BLOCK FOR LEVEL DUE TO THE POSSIBILITY OF VARIATION BETWEEN BLOCKS.

11038 Optional Machine Enclosure

11042 Automatic Rotary Tool Changer