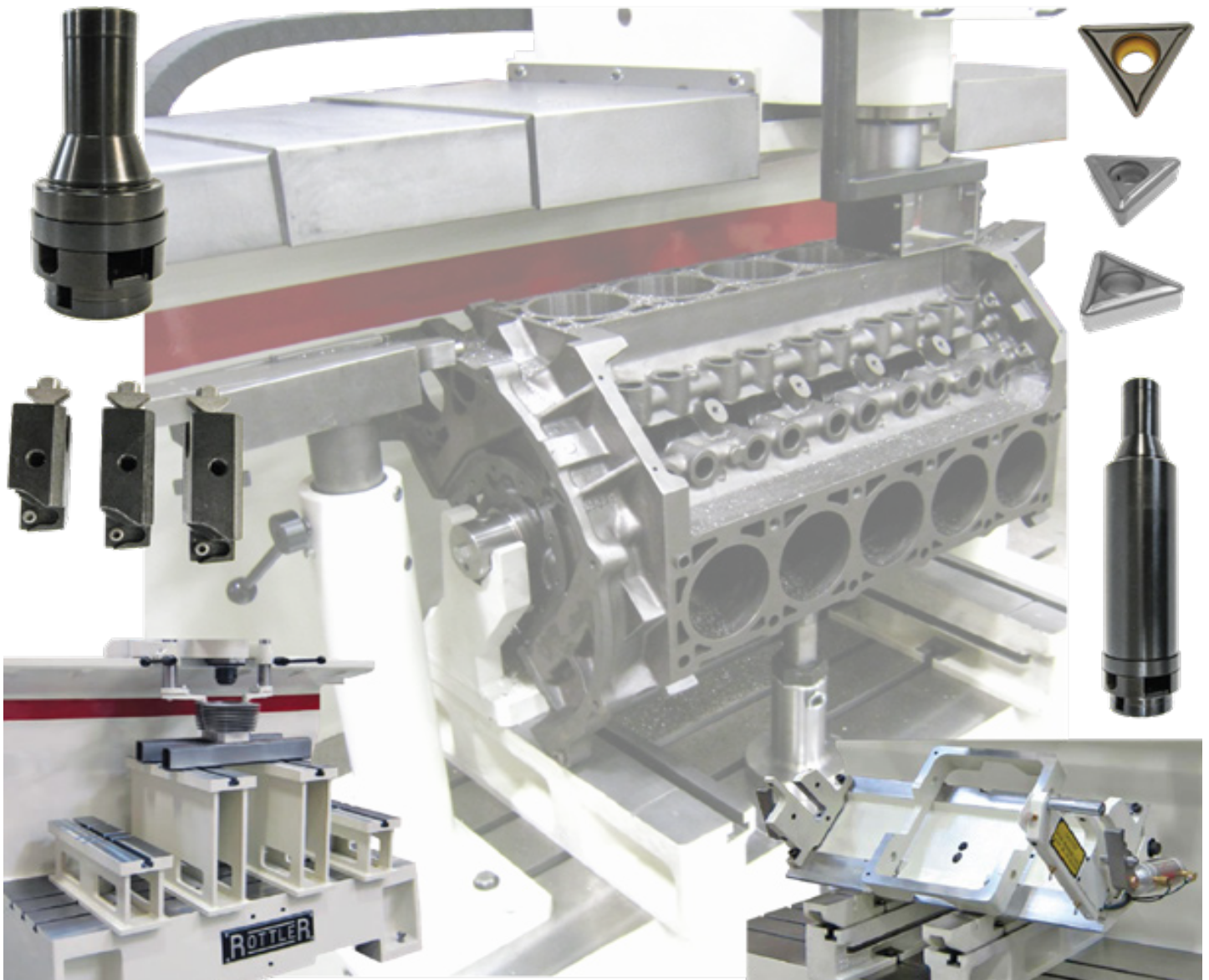




FA OPTIONAL EQUIPMENT CATALOG



8029 S 200th St, Kent, WA 98032 USA | Ph: 253-872-7050 | Fax: 253-395-0230 www.roettlermfg.com

09.03.2020

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

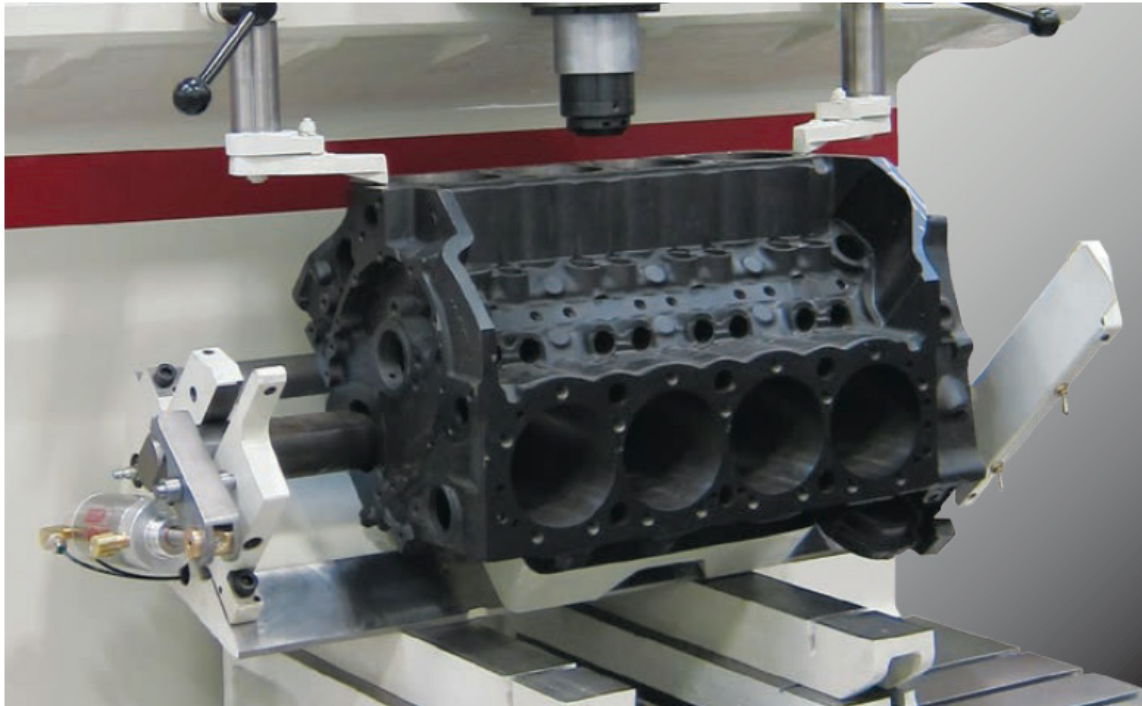
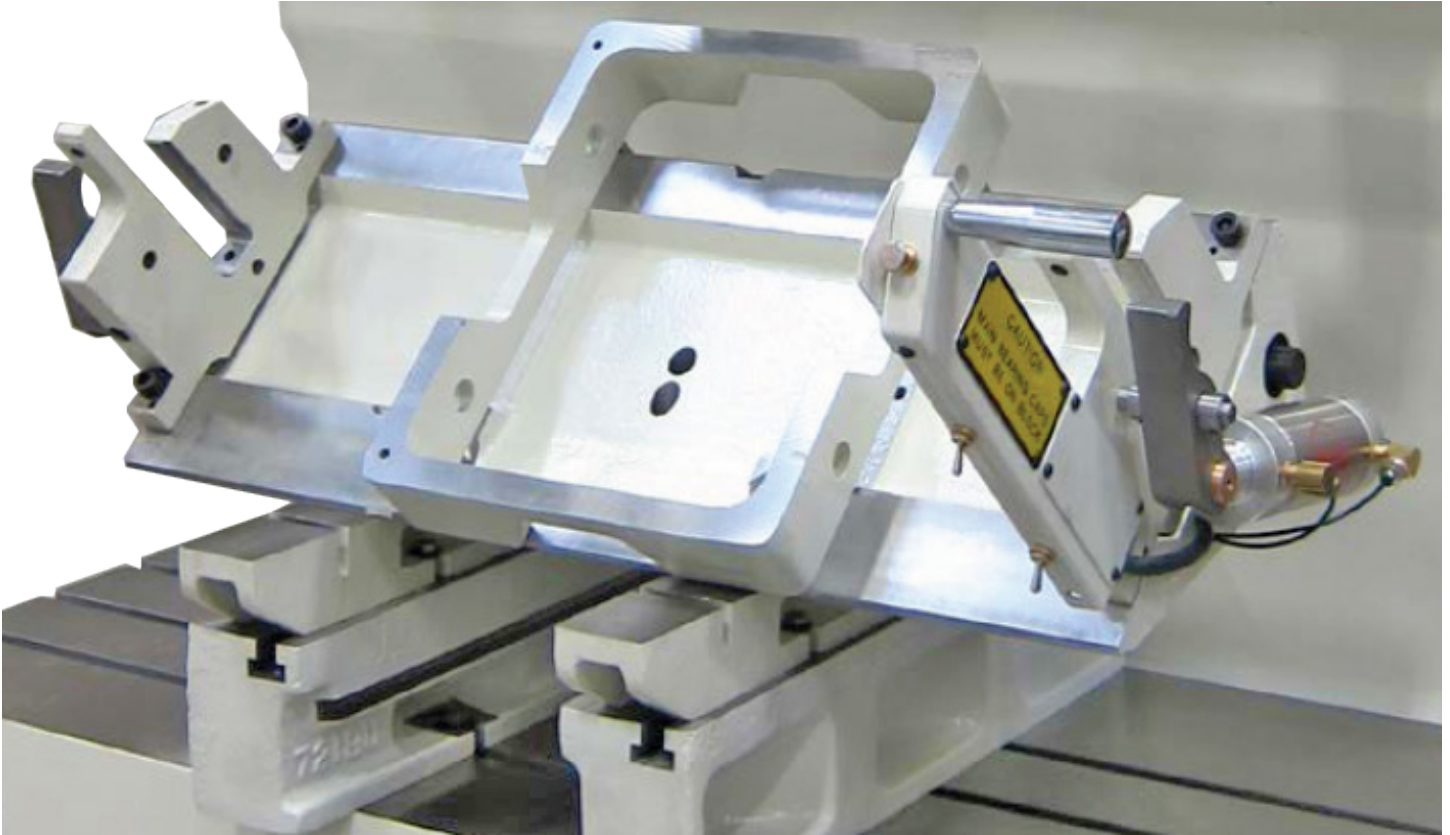
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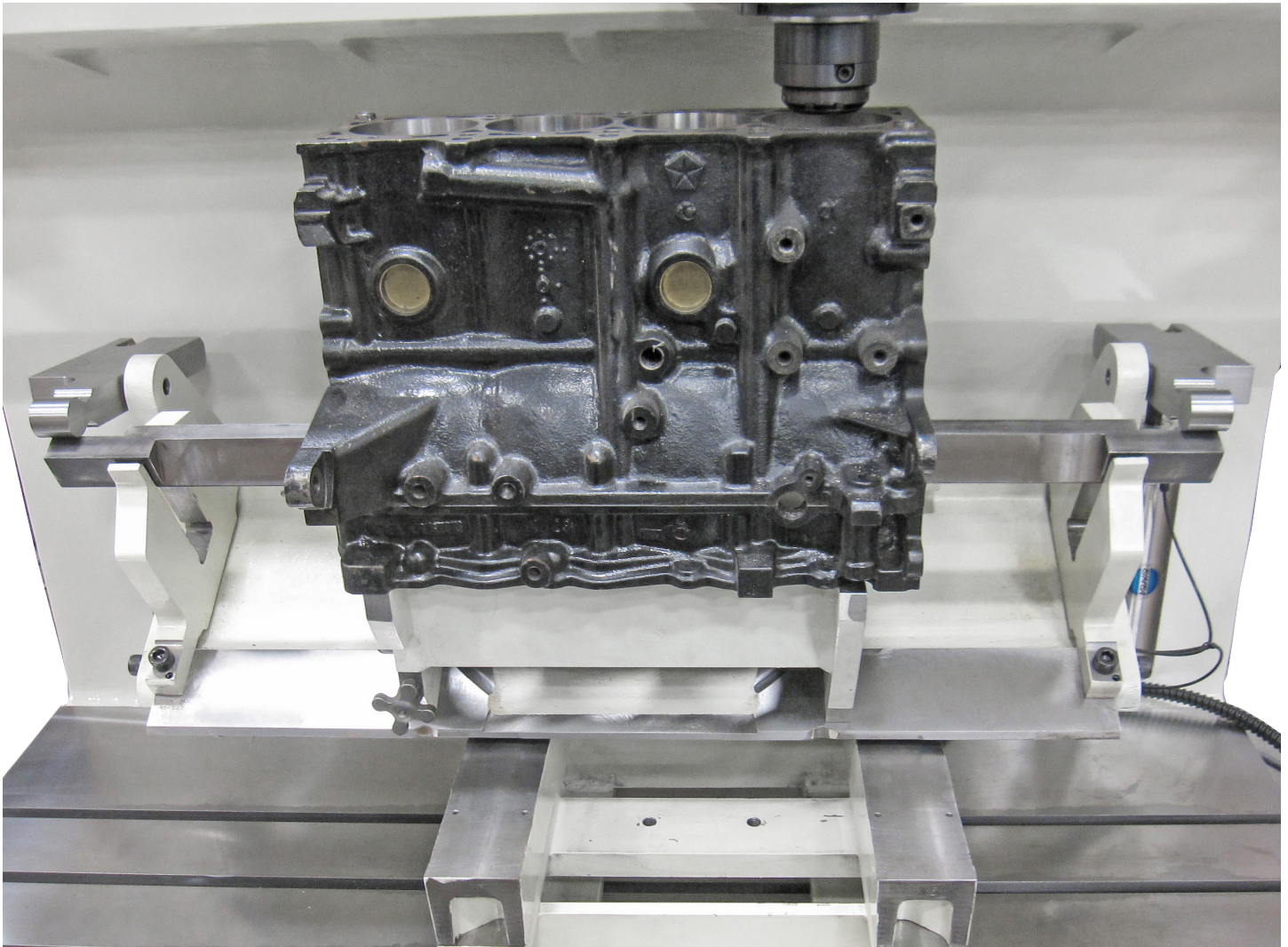
Fixed Angle Fixtures

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

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



502-3-48Q In-line Block Frame
(Requires 502-1-72F Fixture)

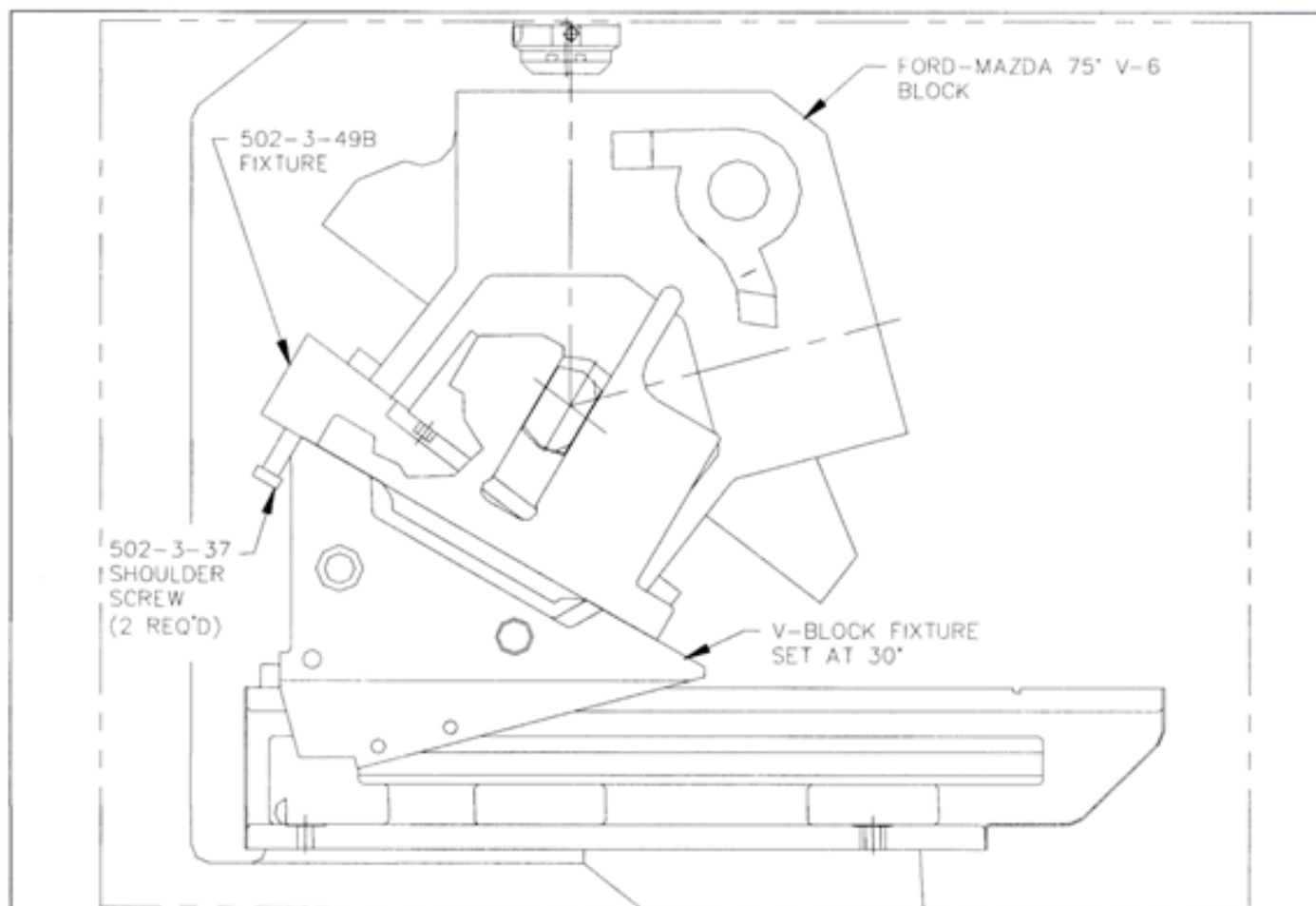


502-3-49 VW 15-degree, Ford Mazda & Isuzu 75-degree V Block Fixture
(Requires 502-1-72F Fixture)**502-3-49**
15 Deg. VW V6 / 75 Deg. Ford-Mazda V6 Fixture
75 Deg. Ford-Mazda V6 Application

This fixture is designed to be used with a customers V8/V6 block fixture on either an SF series surfer or an F series boring machine. Clamping the block will be the same as clamping other v-blocks in the V8/V6 fixture.

The fixture, with (2) 502-3-37 shoulder screws installed, hangs over the top edge of the V8/V6

fixture. The block rests on the fixture with the outboard main caps in the reliefs cut in the fixture. This V6 engine block has main bearing caps that hang down below the pan rail surface. Use caution that the block rests on the fixture with the pan rails flush to the fixture.



15 Deg. VW V6 / 75 Deg. Ford-Mazda V6 Fixture 15 Deg. VW V6 Application

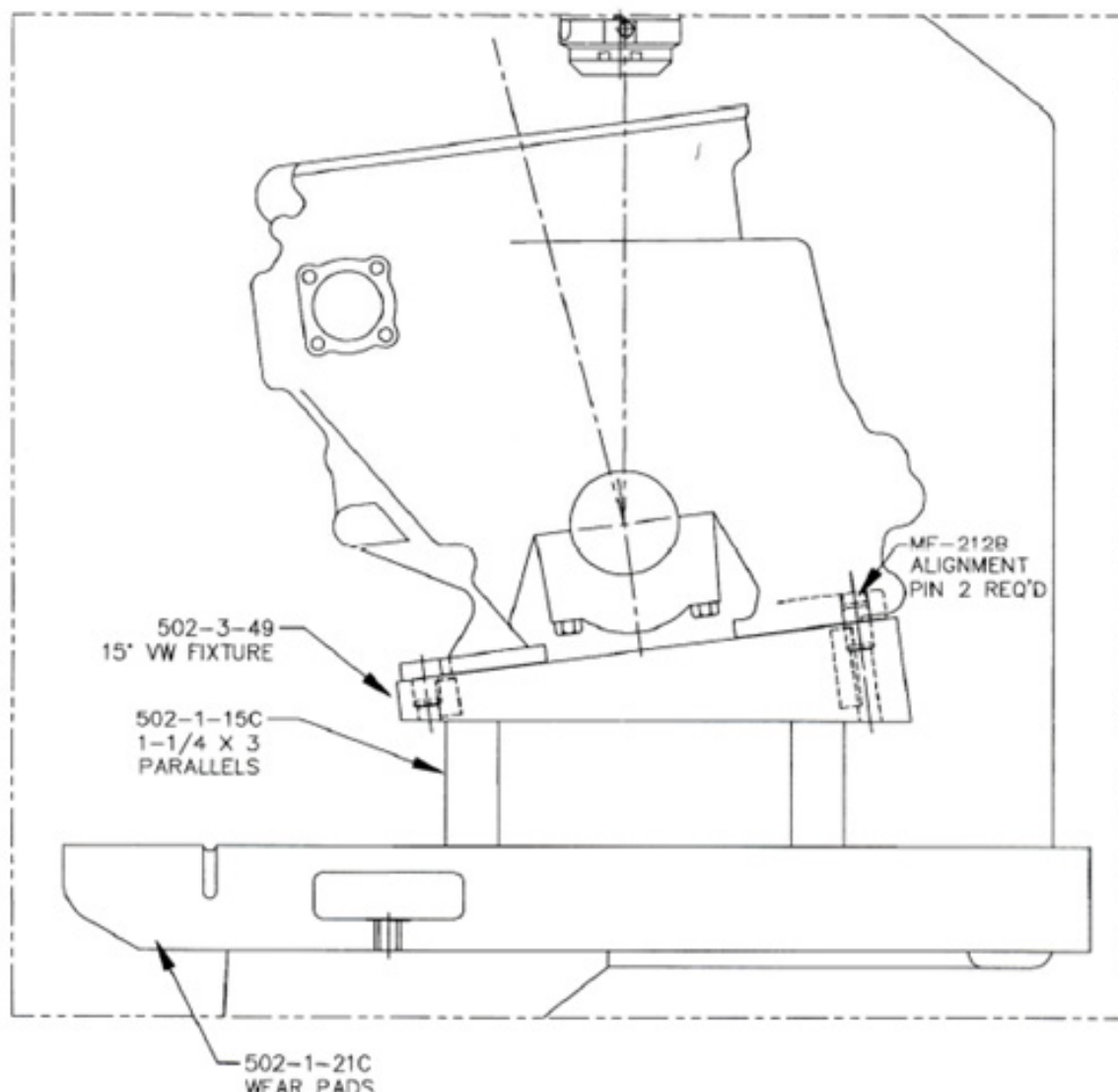
This fixture is designed to be used with a customers existing 1-1/4 x 3 parallels, sitting on top of the 2-1/2" wear pads. The boring machine block clamps must be used to secure the block while boring. Use care in selecting the placement of the clamps, be sure the block is not shifted or tipped when the clamps are applied. Insert the two alignment pins in the corresponding holes in the fixture, and place the block on the fixture using its mating tooling holes.

After the first cylinder bank is bored, lift the block and pull out the two pins. Place the pins in the other set of alignment holes and reposition the block for

boring the second bank. Be sure the engine block is setting down all the way on the fixture and not resting on any burrs or chips. Also be sure the parallels are clean and free from chips.

Care must be taken when centering the cutterhead. Be sure you are far enough in the bore for all of the centering fingers to come in contact with the bore, below the ridge if possible.

For honing the fixture and the engine block will fit into the hone cradle for normal hone operation.



502-3-52 Cadillac Catera 54-degree V Block Fixture

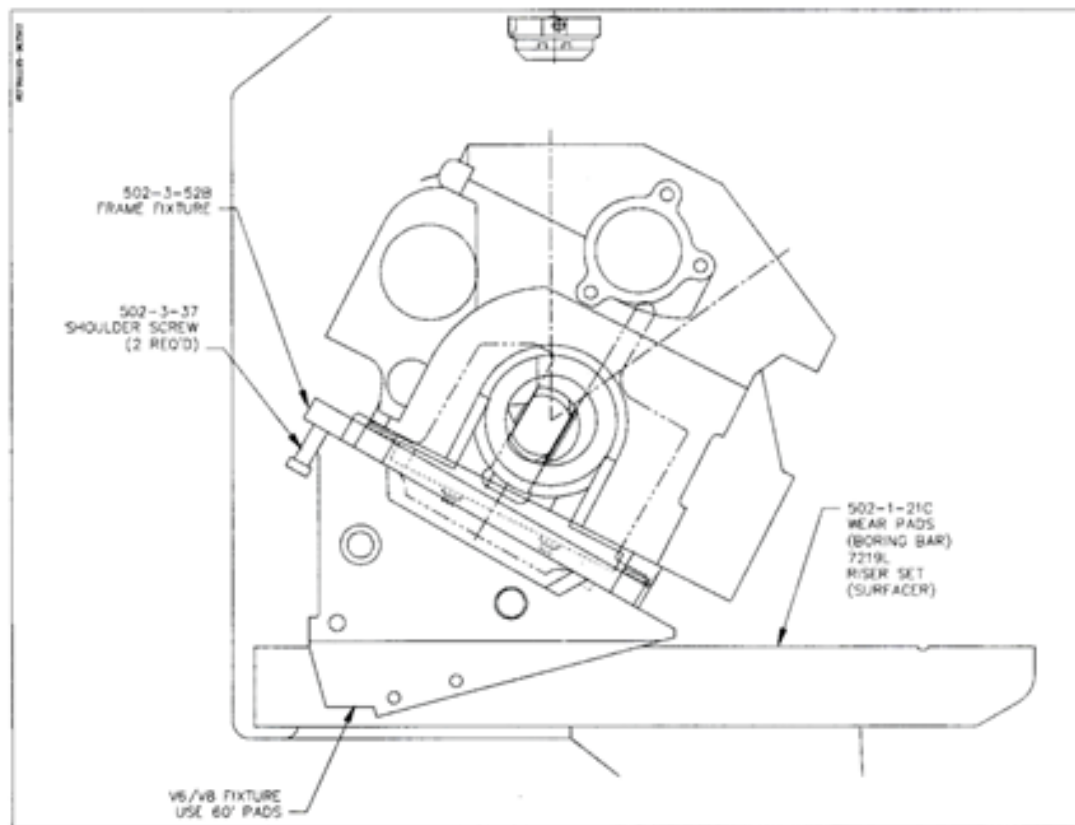
(requires 502-1-72F Fixture)

502-3-52 Cadillac Catera 54 Deg. V6 fixture

This fixture is designed to be used with a customers V8/V6 block fixture on either an SF series surfer or an F series boring machine. Clamping the block will be the same as clamping other v-blocks in the V8/V6 fixture.

The fixture, with (2) 502-3-37 shoulder screws installed, hangs over the top edge of the V8/V6 fixture. The V8/V6 fixture is positioned using

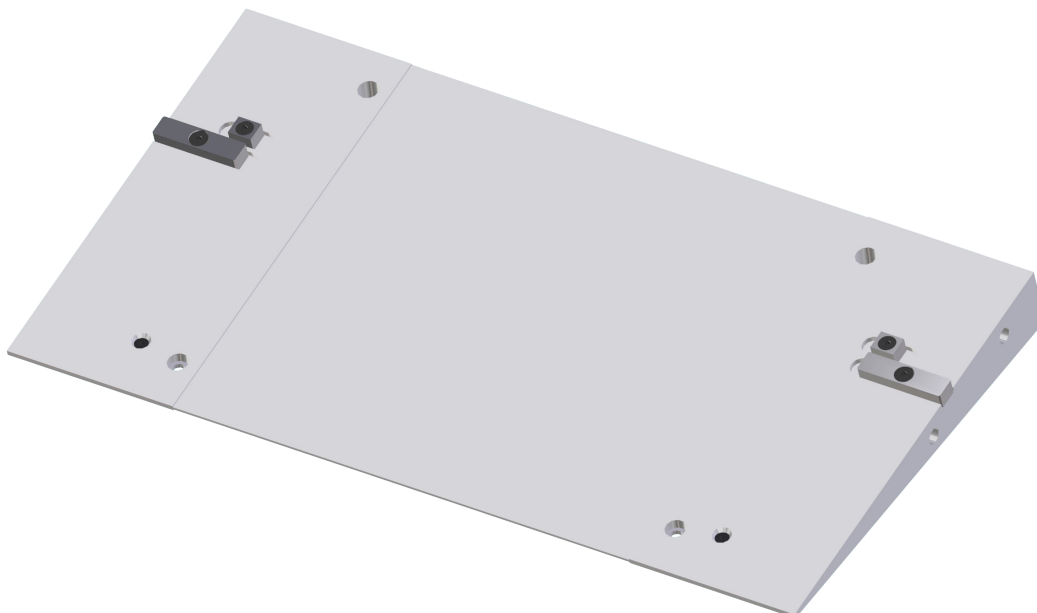
the 60 deg. pads on either 502-1-21C wear pads (F-series boring bar) or 7219L riser set (SF series surfer). This block incorporates a main bearing cap support frame which ties the caps together. When loading the block, the pan rails rest on the milled surfaces of the fixture with the cap support frame hanging inside the rails of the fixture..



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



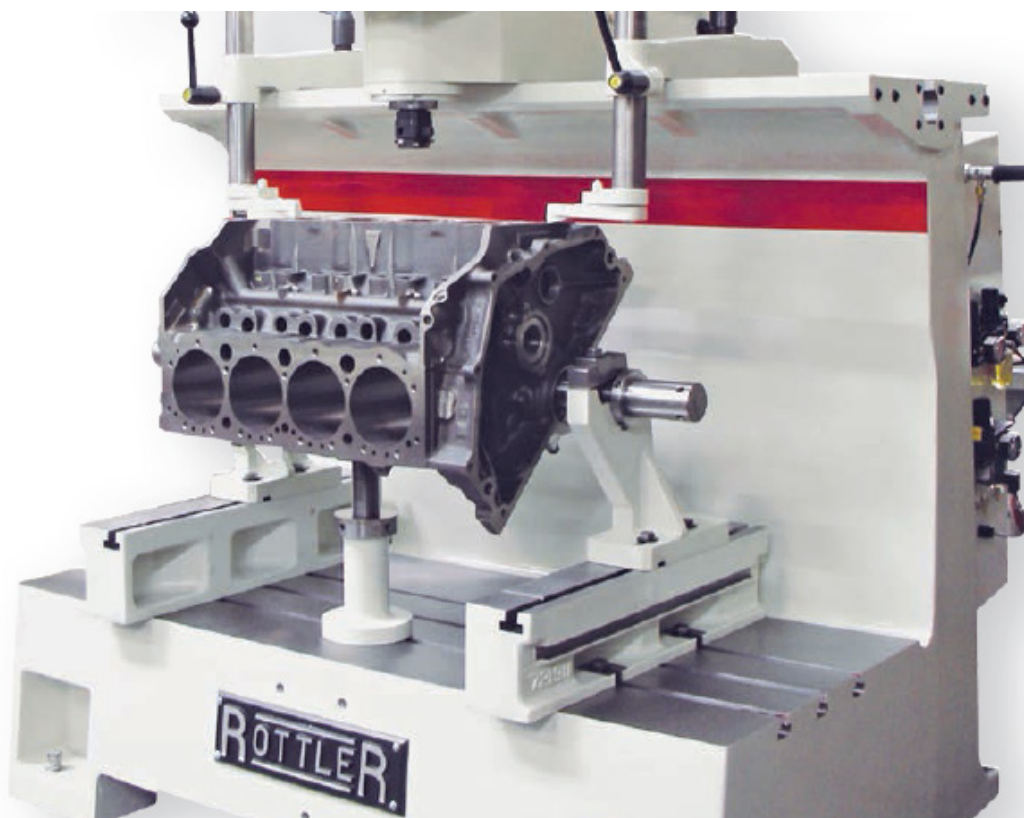
502-3-23C Marine Outboard Fixture, Yamaha 76 degree
(Requires 502-1-72F Fixture)



Adjustable Angle Fixtures

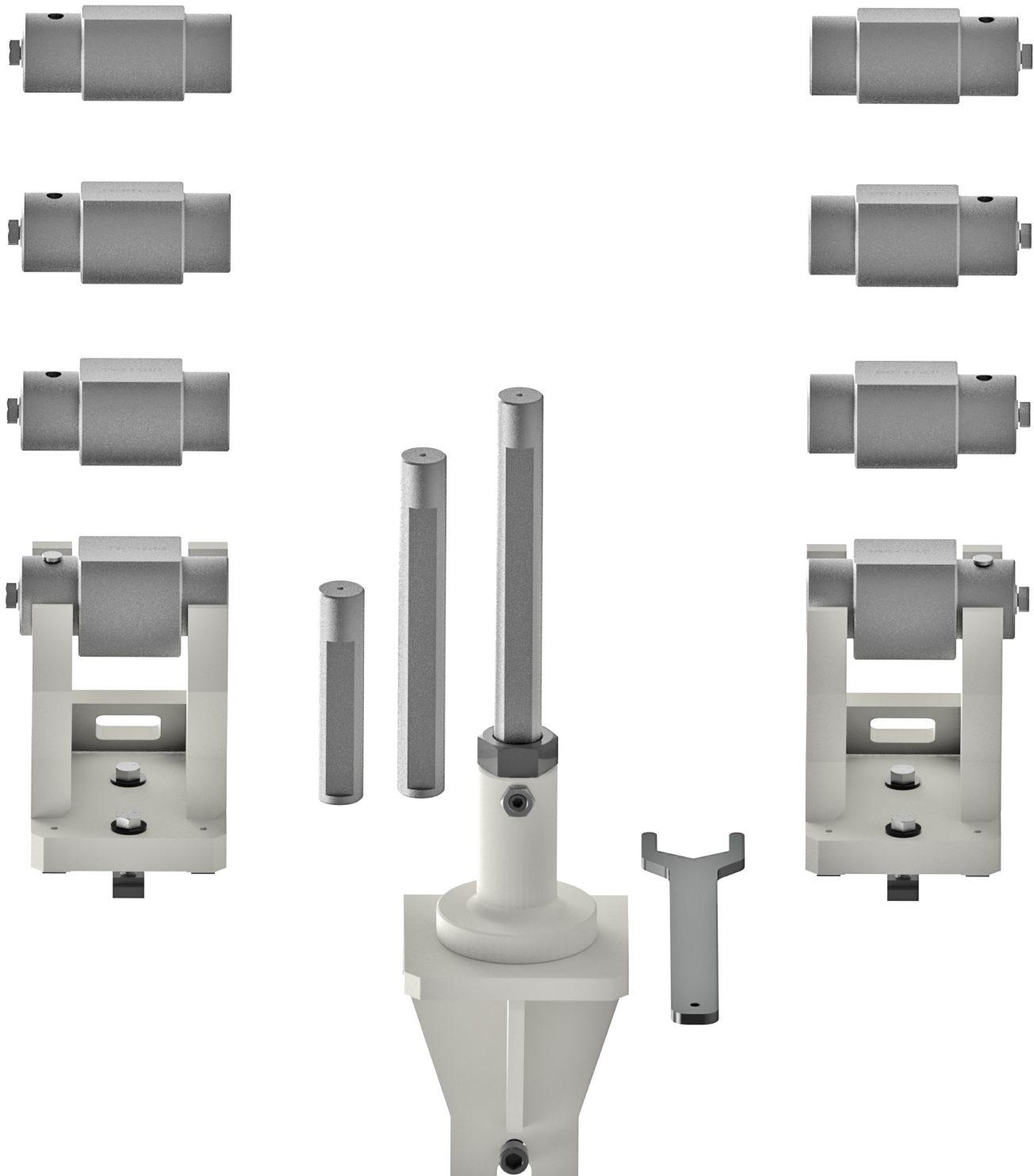
7241R Universal Economy Automotive Block Fixture

(Requires 7219W Parallels)



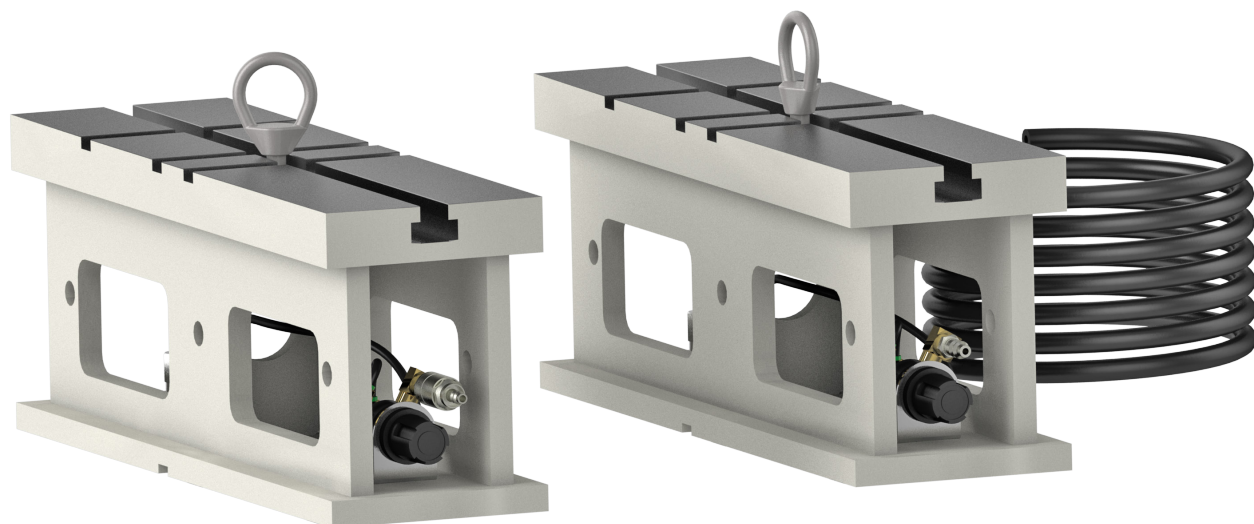
7243 Mid-size Diesel Block Fixture

Includes (4) pair main bearing locators to cover 3 - 5" (76.2 - 127mm) main line diameter range.

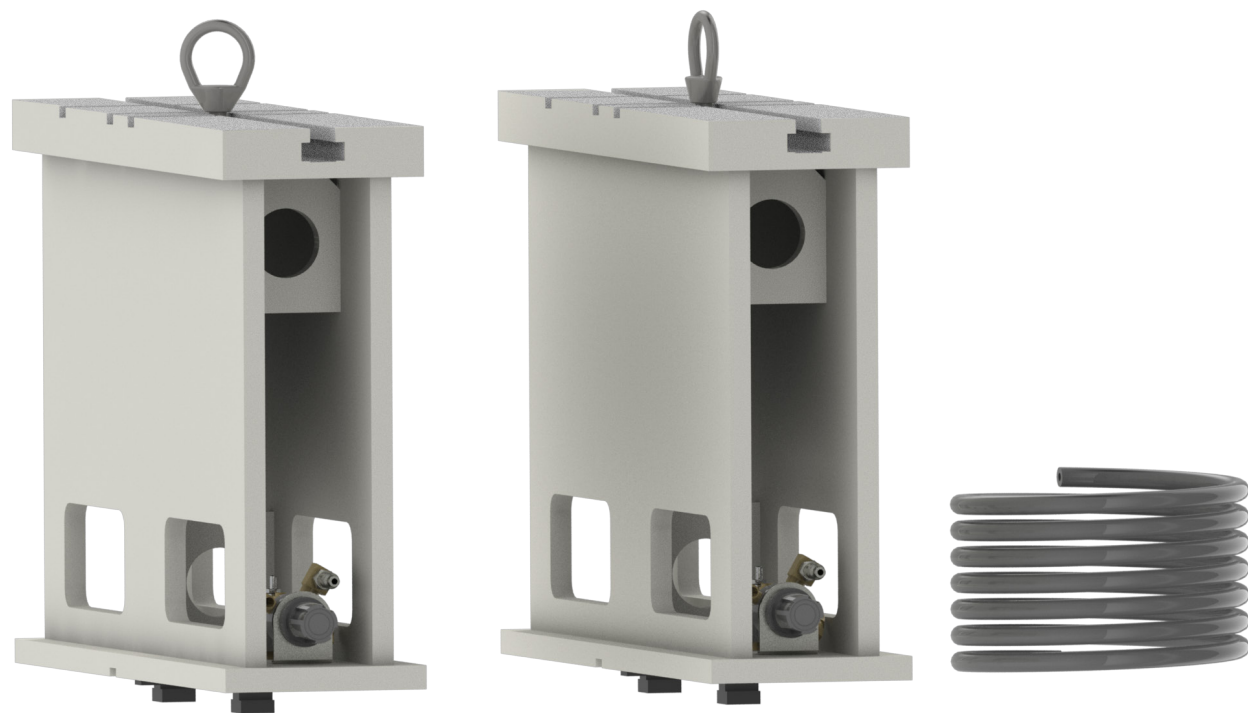


Parallels

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



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



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.

**7219W 5.2" (132.08mm) Heavy Duty T-Slot Universal Parallels**

Required for 7209M and 502-1-72F



Miscellaneous Options

7152A Dual Axis Level Assembly



Boring and Sleeving Cutterhead Packages

Included tooling, cutting inserts and micrometer.

504-35-12A Production Cutter Head Package

Heavy Duty 4.5 x 9" (115 x 230mm) Diameter Complete with Tooling and Digital Micrometer



600-8-4L Production Cutterhead Package

3.250 - 5.0" (82.5 - 127mm) diameter. Complete with Tooling and Digital Micrometer



502-13M Production Stub Cutterhead Package

2.19 - 4.1" (55.6 - 104mm) Diameter X 6.375" (162mm) Length Complete with Tooling and Digital Micrometer.



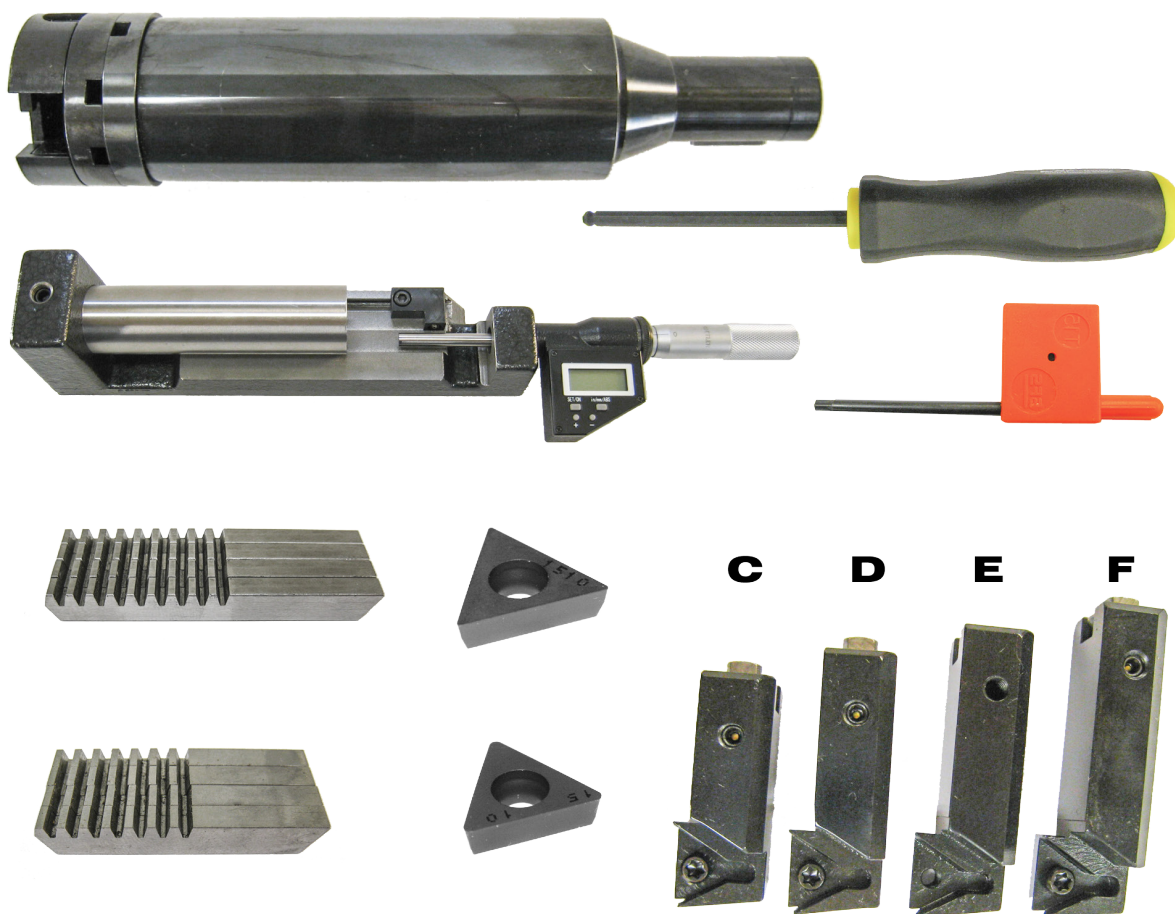
600-8-5 Blind Hole Cutter Head Package

2.6 - 5.0" (66 - 127mm) Diameter. When used with F10 range 3.25 - 5" (83 - 127mm) diameter. Complete with Tooling and Digital Micrometer.



600-2-2 Blind Hole Stub Bar Cutterhead Package

2.2 - 4.0" (56 - 101.60mm) diameter X 6.375" (161.925mm) Length Complete with Tooling and Digital Micrometer.



600-2 Blind Hole Stub Cutter Head Package

1.5 - 4.1" (38 - 104mm) Diameter X 6.5" (165mm) Length Complete with Tooling and Digital Micrometer.

