



S85A 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
8. 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

S85A OPTIONAL EQUIPMENT CATALOG

Contents

Large Cutterhead.....	1
S80SURF.16.....	1
Fixtures and Parallels	2
Universal Quick Leveling Cylinder Head Fixture.....	2
7209M Leveling Table.....	2
7152A Dual Axis Level Assembly.....	2
Adjustable Angle Fixtures	3
7330 Universal Economy Automotive Head & Block Fixture	3
7242M Clamp Tower Assembly	3
7243 Mid-size Diesel Block Fixture	4
Fixed Angle Fixtures for Blocks.....	5
502-1-72F V Block Fixture with Air Float and Air Clamping	5
502-3-48Q In-line Block Frame	6
502-3-49 VW 15-degree, Ford Mazda & Isuzu 75-degree V Block Fixture	6
502-3-52 Cadillac Catera 54-degree V Block Fixture	7
502-3-23 Marine Outboard Fixture, V4 & V6 Evinrude/ Johnson, V6 Mercury	7
502-3-23C Marine Outboard Fixture, Yamaha 76 degree	8
502-1-46T Precision 2" (50.8mm) Locator Bar for 502-1-72F Fixture.....	8
550-5-10 Main Bearing Bushings for Detroit 8.2 Liter Diesel	8
Parallels.....	9
7219W 5.2" (132mm) Heavy Duty T-Slot Universal Parallels.....	9
11112 Universal 8" (203mm) Heavy Duty T-Slot Parallels with Air Float	9
11114 Universal 16" (405mm) Heavy Duty T-Slot Parallels with Air Float	10
Optional Tooling	11
7224 Shell Mill Assembly 2 1/2" (63.50mm) diameter	11
7225Y Shell Mill Assembly 4" (102mm) Diameter.....	11
7224G Shell Mill Assembly 6" (152.4mm) Diameter	12
7038Y Flatness Probe Dial Indicator for Level Assembly.....	12
7209N 2-Piece Vise	13
7226G Exhaust/Intake Manifold Surfacing Fixture	14



650-3-38 Machinist Level for Intake and Exhaust Manifolds	15
201 Mitutoyo Surface Tester.....	15
7202V Holder Assembly.....	16
7202U Holder Assembly.....	16
7202X Tool Holder Assembly.....	16
Cutting Inserts	17
6514T Inserts.....	17
6301V Ceramic Composite Insert.....	17
6301I Ceramic Composite Insert.....	17
6303M PCD Round Insert.....	17
6303K Coated Carbide Insert.....	17
6303R CBN Round Insert.....	17
6303B CBN Round Insert.....	17
6301J CBN Square Insert.....	17
6303S CBN Round Insert	17
6303P PCD Round Insert	17
6303Q CBN Round Insert.....	18
6303V CBN Insert.....	18
6303U CBN Round Insert.....	18
7202Z Round Insert	18
RS322 Insert.....	18
Metric Reading Setting Indicator	18
7154C	18

Large Cutterhead

S85A has 14" (360mm) diameter cutterhead as standard, a 16" (420mm) diameter cutterhead is available as upgrade during manufacturing of new machines.

S80SURF.16

16" (420mm) Diameter Cutterhead. Upgrade Package including chip shroud



Fixtures and Parallels

Universal Quick Leveling Cylinder Head Fixture

7209M Leveling Table

Complete with universal work holding system for cylinder heads and small in-line blocks (requires 7219W Parallels)



7152A Dual Axis Level Assembly



Adjustable Angle Fixtures

7330 Universal Economy Automotive Head & Block Fixture

(Includes Clamp Towers - 7242M) (Replaces 7241)

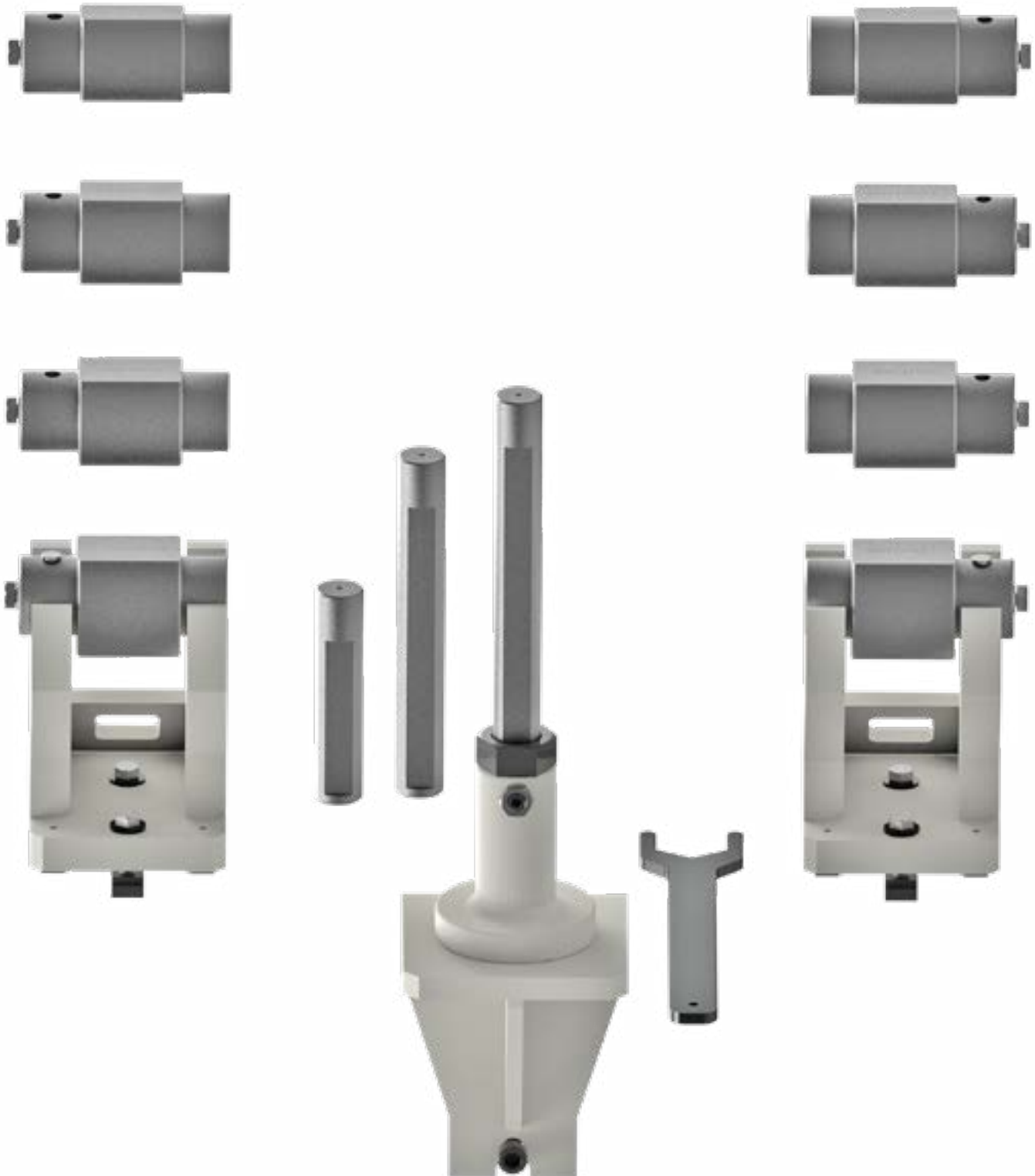


7242M Clamp Tower Assembly



7243 Mid-size Diesel Block Fixture

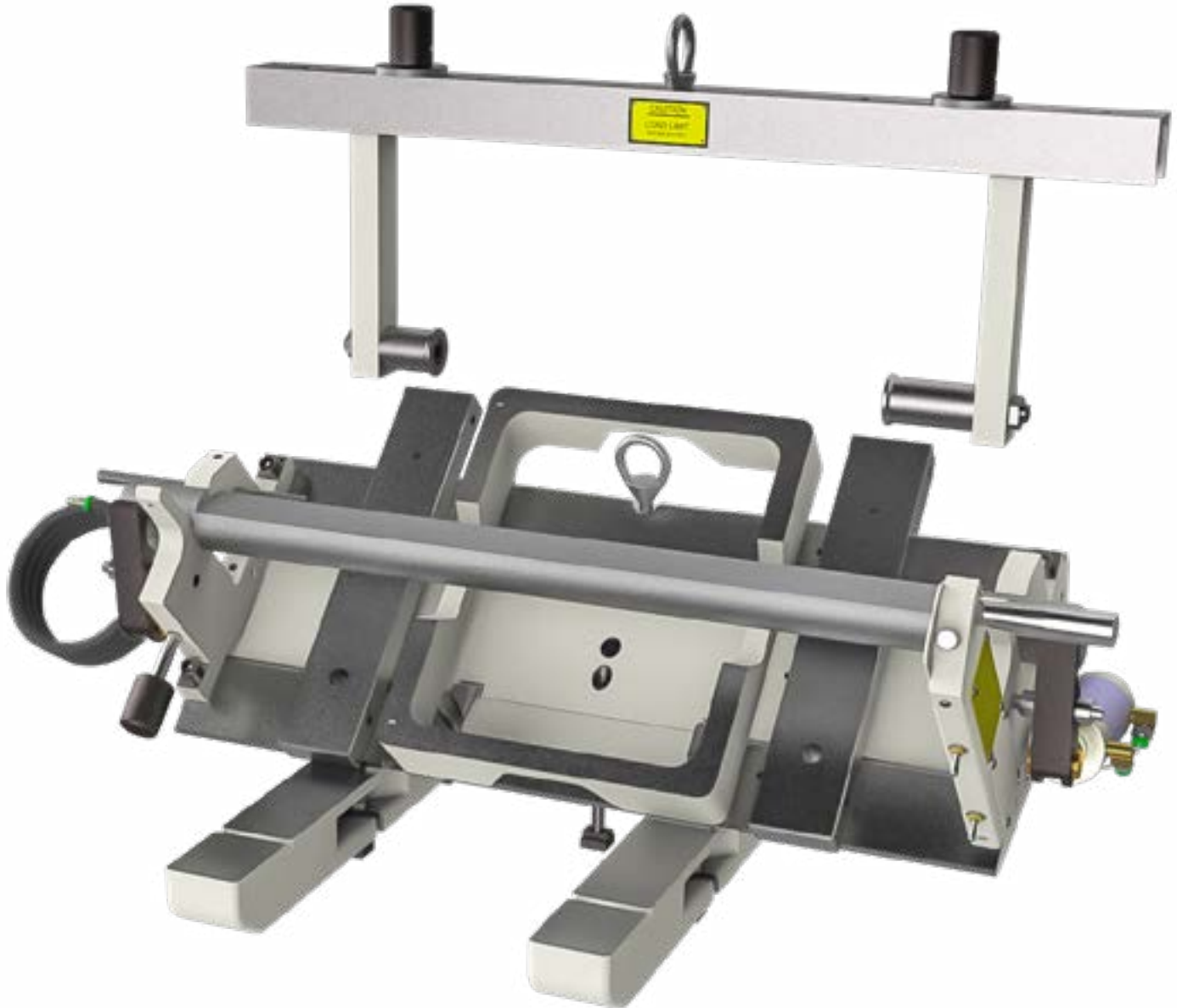
Includes four pair main bearing locators to cover 3 - 5" (76.2 - 127mm) main line diameter range.
Requires 7242M Clamp Towers.



Fixed Angle Fixtures for Blocks

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)

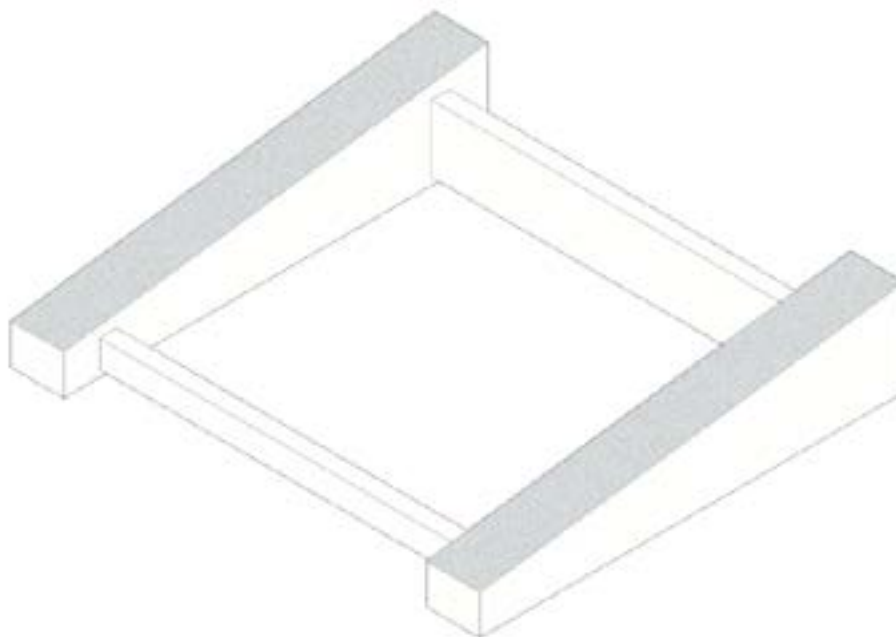


502-3-48Q In-line Block Frame

For V Block Fixture 502-1-72F

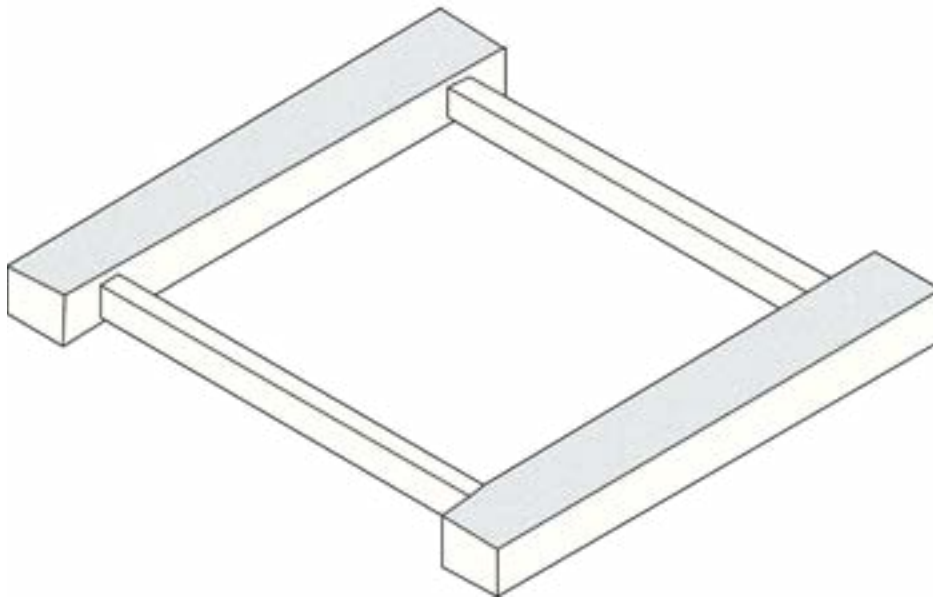
**502-3-49 VW 15-degree, Ford Mazda & Isuzu 75-degree V Block Fixture**

(requires 502-1-72F Fixture)



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

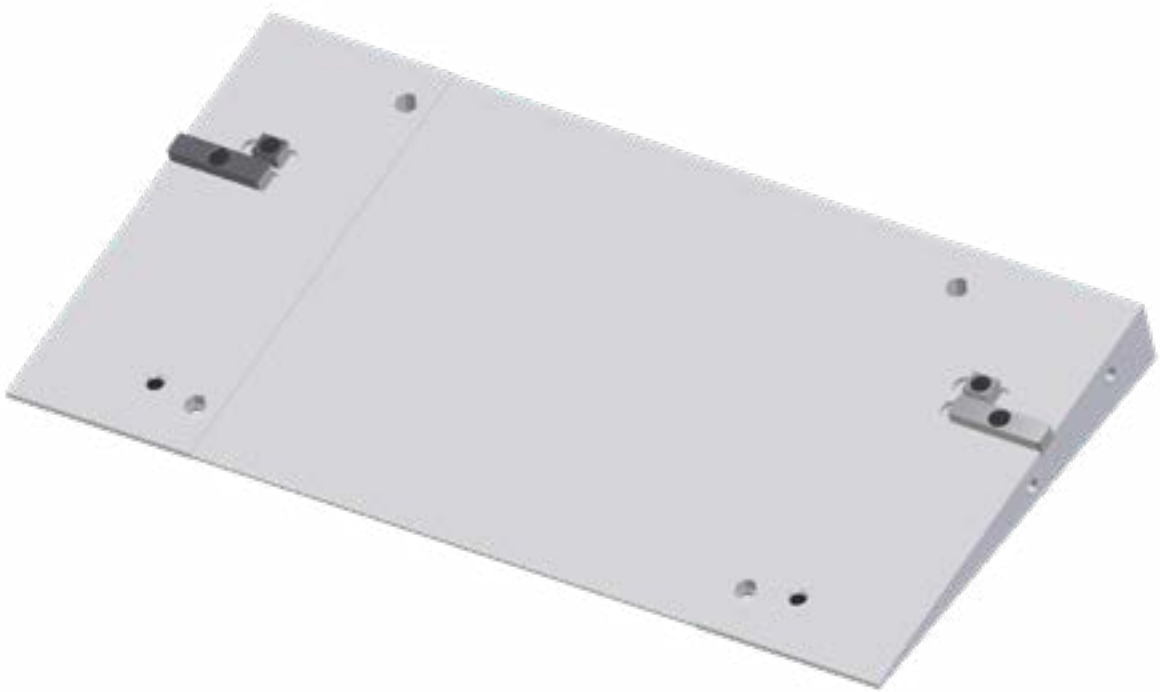
(requires 502-1-72F Fixture)

**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)



502-1-46T Precision 2" (50.8mm) Locator Bar for 502-1-72F Fixture



550-5-10 Main Bearing Bushings for Detroit 8.2 Liter Diesel
(requires 502-1-72F Fixture with special hole location machined on 502-1-15C parallels)



Parallels

7219W 5.2" (132mm) Heavy Duty T-Slot Universal 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

Optional Tooling

7224 Shell Mill Assembly 2 1/2" (63.50mm) diameter



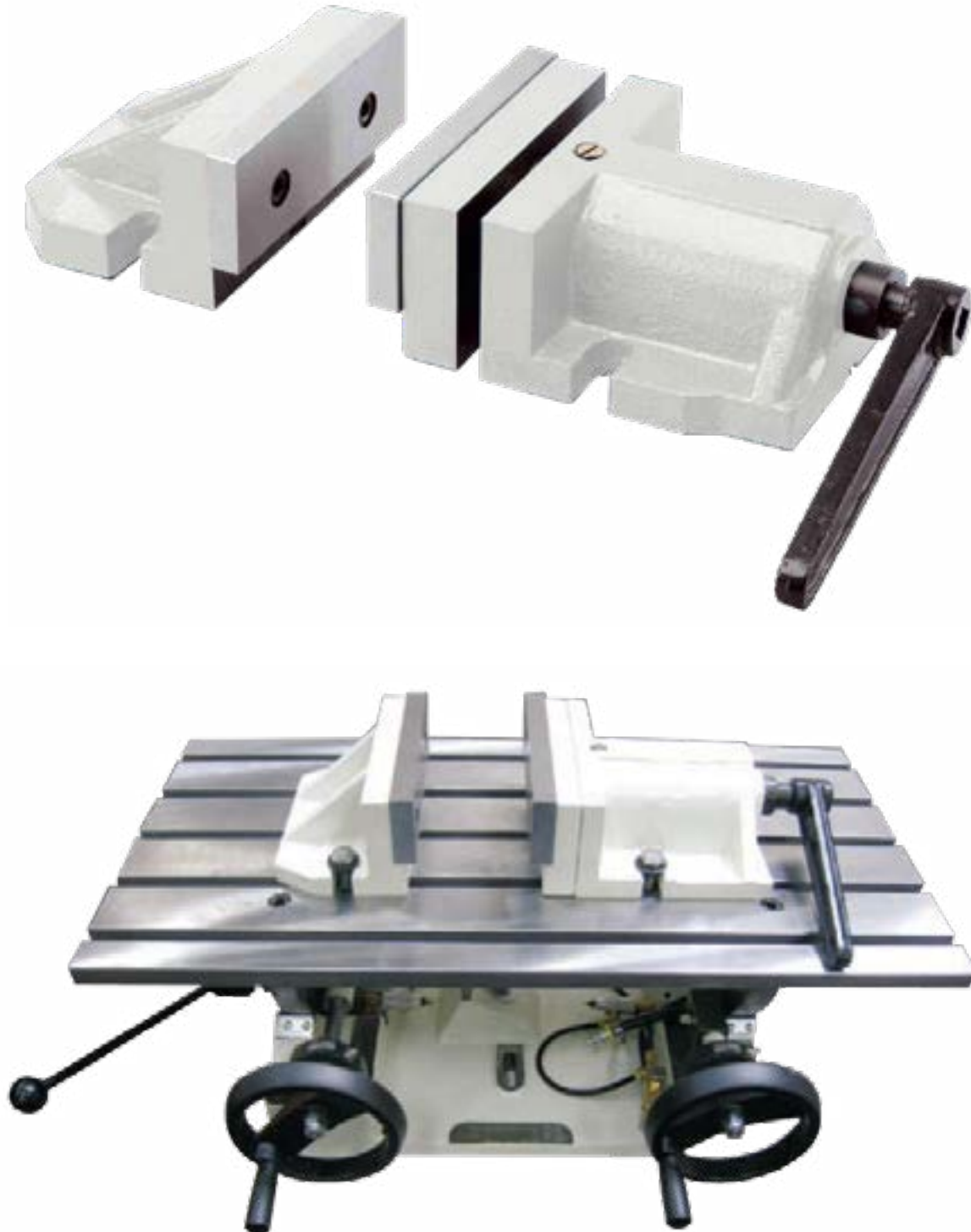
7225Y Shell Mill Assembly 4" (102mm) Diameter

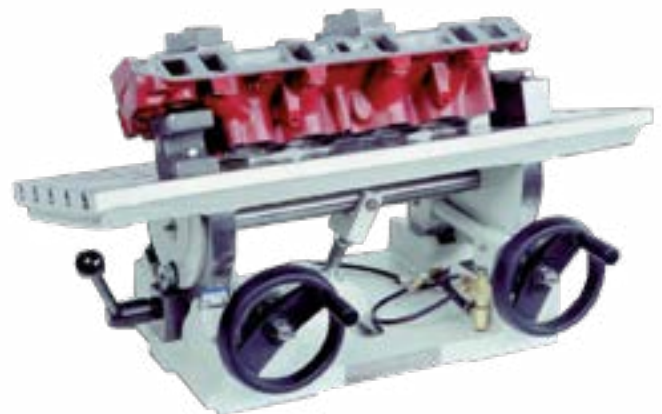


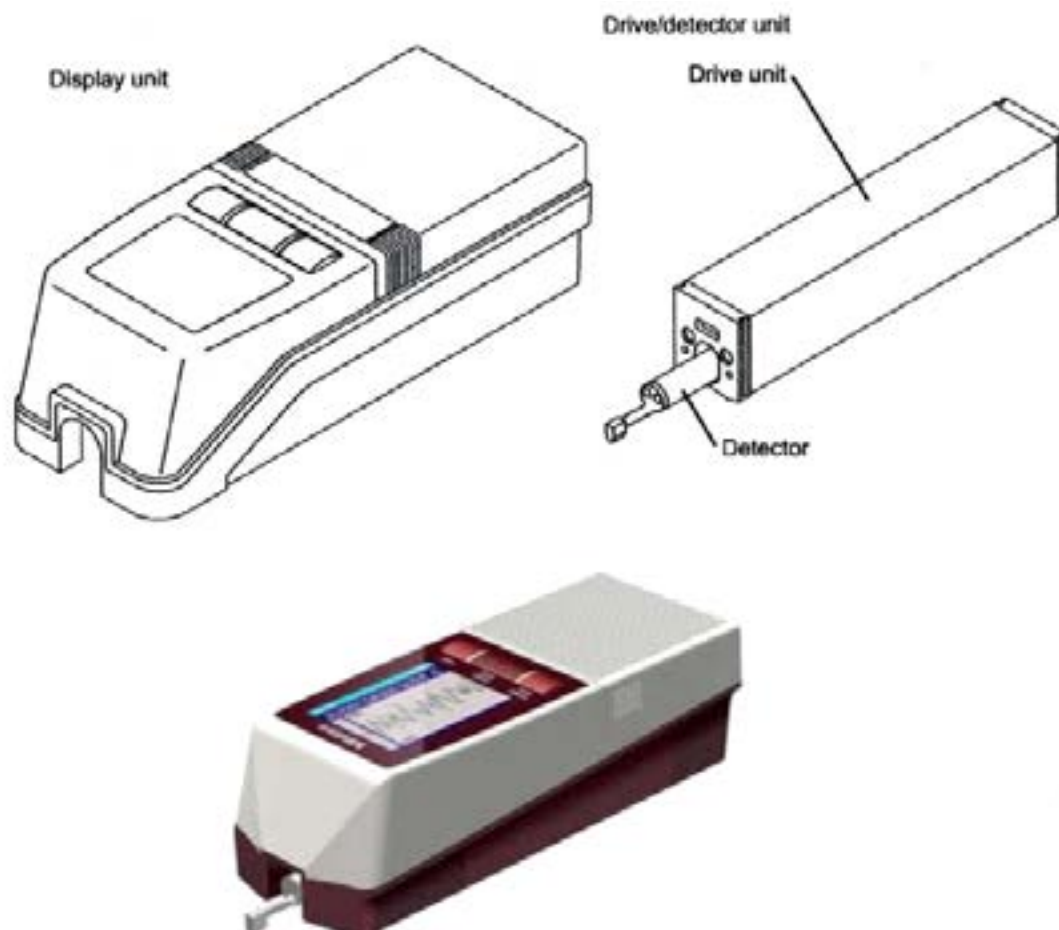
7224G Shell Mill Assembly 6" (152.4mm) Diameter**7038Y Flatness Probe Dial Indicator for Level Assembly**

7209N 2-Piece Vise

For surfacing main caps in preparation for main line boring. Also used for holding exhaust manifolds for surfacing. Requires 7209M Leveling Table.

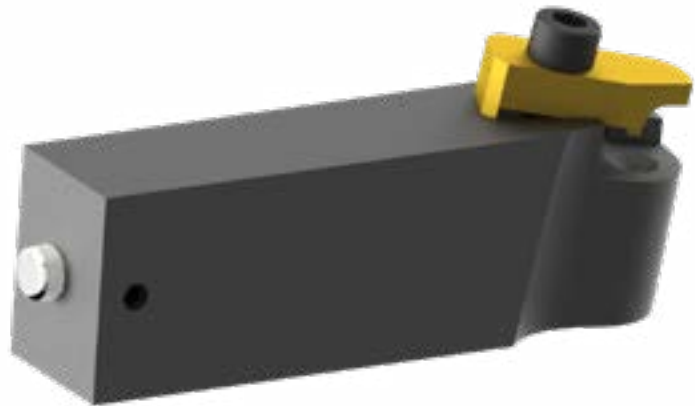


**7226G Exhaust/Intake Manifold
Surfacing Fixture**

650-3-38 Machinist Level for Intake and Exhaust Manifolds**201 Mitutoyo Surface Tester**

7202V Holder Assembly

Fly Cutter Tool 1/2" (12.70mm) IC Negative Rake

**7202U Holder Assembly**

Fly Cutter Tool 1/2" (12.70mm) IC-11 Degree Positive Rake

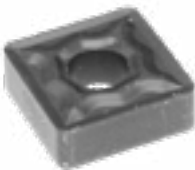
**7202X Tool Holder Assembly**

Fly Cutting (for use with special gold coated round insert 7202Z for surfacing aluminum heads with pre chambers and cast iron heads with soft pre chambers)



Cutting Inserts

6514T Inserts For Shell Mills (7225Y, 7224G, and 7224 - Requires 8 Inserts) 	6301V Ceramic Composite Insert For cutting precombustion chambers, round negative rake 3/8" IC 
6301I Ceramic Composite Insert For cutting precombustion chambers, square negative rake 3/8" IC 	6303M PCD Round Insert 3/8" IC, for super finishing aluminum (15% Discount on orders of 10 or more) 
6303K Coated Carbide Insert 3/8" IC, for aluminum and cast iron 	6303R CBN Round Insert 3/8" IC, for cast iron heads with steel pre-cups 
6303B CBN Round Insert Double Sided, 3/8" IC, for cast iron (15% Discount on orders of 10 or more) 	6301J CBN Square Insert Double Sided, 3/8" IC, 1/16" Radius, for heavy stock removal 
6303S CBN Round Insert 3/8" IC, for cutting aluminum heads with steel pre-cups and aluminum blocks with liners 	6303P PCD Round Insert 1/2" IC, for super finishing aluminum 

6303Q CBN Round Insert Double Sided, 1/2" IC, for general cast iron surfacing 	6303V CBN Insert Octagonal (16-Cutting Corners) for surfacing large diesel blocks 
6303U CBN Round Insert Single Sided, 3/8" IC. For hard cast iron 	7202Z Round Insert 3/8" gold coated for aluminum cylinder head precup cutting, also for soft cast iron precups like Land Rover. Use with 7202X tool holder only. 
RS322 Insert Square negative rake, 1/32" radius for roughing 	

Metric Reading Setting Indicator

7154C

Replaces Cutterhead Setting Dial Indicator to a Metric Reading Unit

Image Currently Unavailable