

ROTTLER

SG100M 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. 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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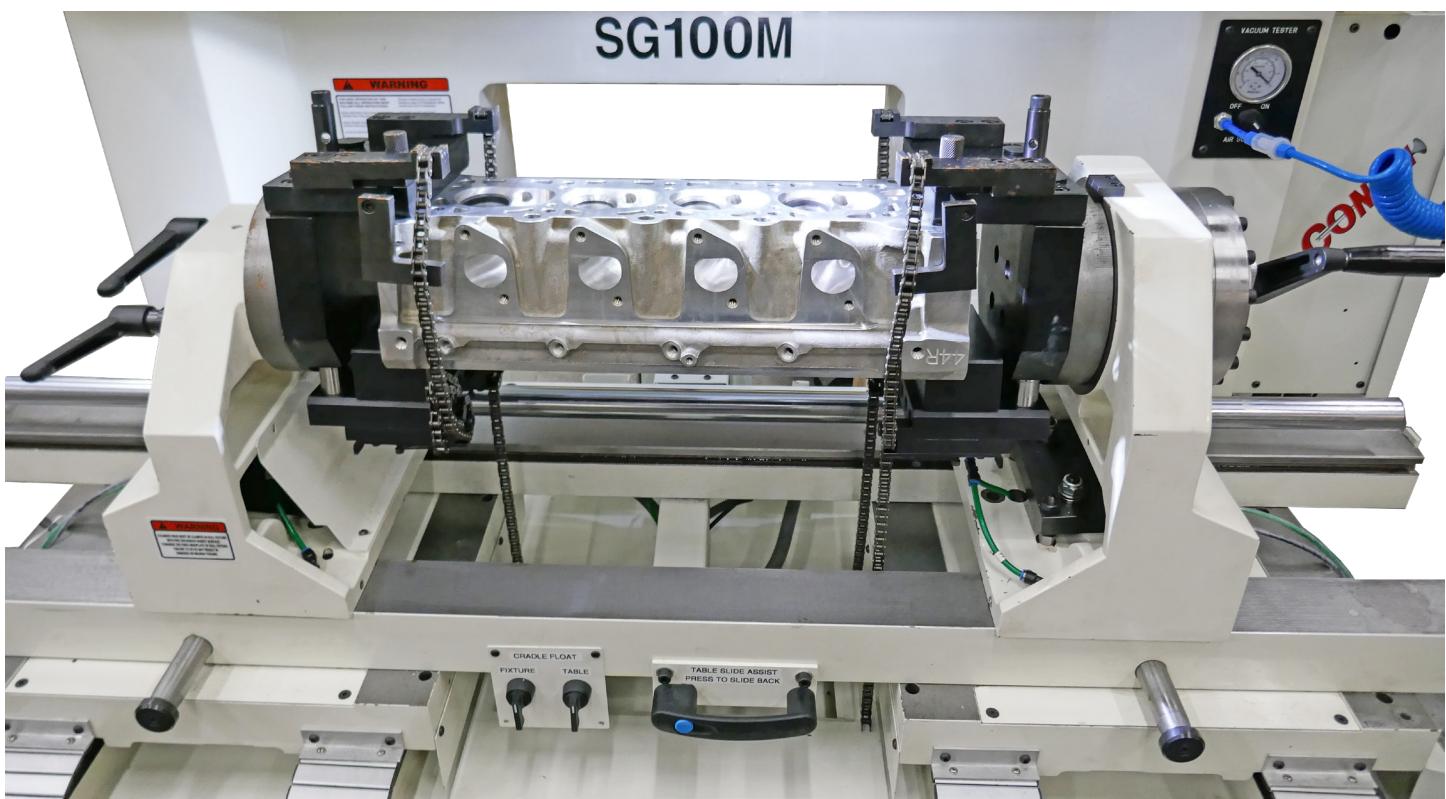
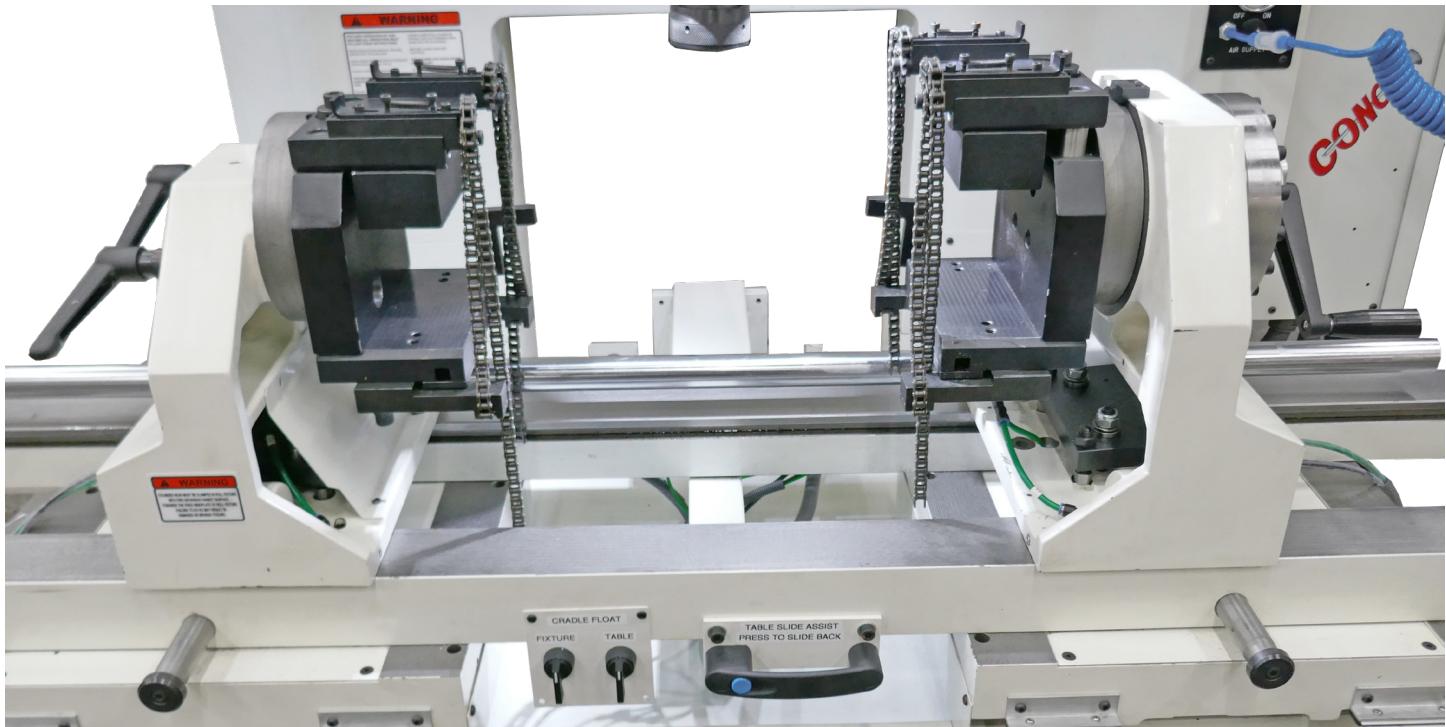
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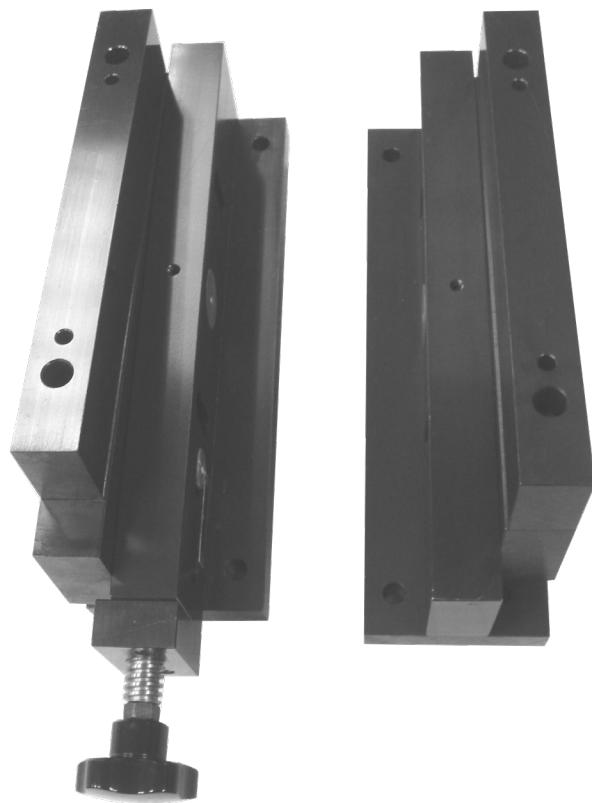
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Optional Fixtures

MAN-TILT-100 Universal Manual Fixture

For Large Cylinder Heads - fixture air floats on table during set up.

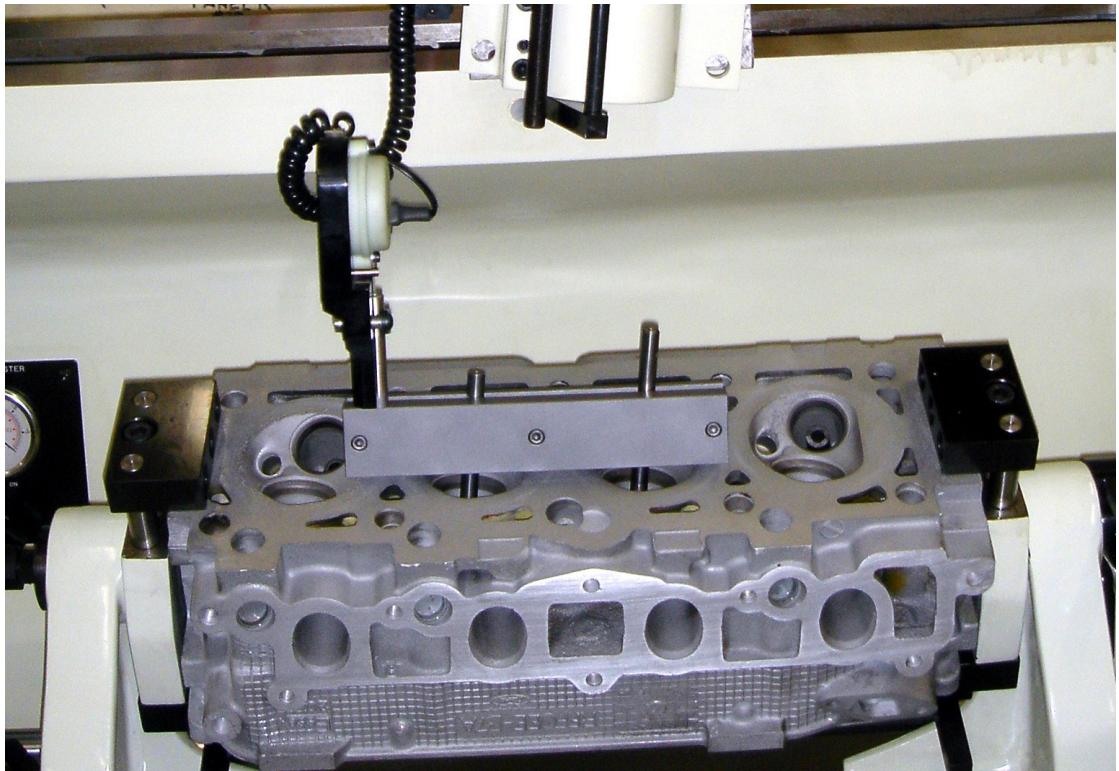


**2DEGREE-TILT**

Tilt Fixtures for large single cylinder head applications including adjustable base plate, Set of two 1-7/8" and 4" parallels; requires one set of Clamp Towers (7242N)

CANTEDFIX

Canted Fixture for leveling Canted cylinder heads on any fixed pilot Seat and Guide Machine



7242N Clamp Tower Assembly

Complete with Lower Base Plates



Rottler UNIPILOT Spindle Adapters and Tool Holders

Valve Seat diameter range will vary depending on design of cutting insert tip. Diameters listed below are only for estimate.

UPT5500

Rottler (Patent Pending) Unipilot Tool holder for 6mm shank Pilots, seat diameter range 0.570 - 1.395" (14.48 - 35.43mm) for TH1999, TH2000



UPT5600

Rottler (Patent Pending) Unipilot Tool holder for .375" (9.52mm) shank Pilots, seat diameter range .800" - 2.360" (20.32 - 59.94mm) for TH2000, TH2001 & TH2002



UPT5700

Rottler (Patent Pending) Unipilot Tool holder for .375" (9.52mm) shank Pilots, Seat diameter range 1.270" - 4.724" (32.26 - 120mm) for TH2003, TH2004 & TH2005



Cutting Insert Tip Holders for Multi Angle RCA and RCB Cutting Inserts

To be used with UPT5500, UPT5600, UPT5700 UNIPILOT Tool Holders, require T8 Torx Driver.

Valve Seat diameter range will vary depending on design of cutting insert tip. Diameters listed below are only for estimate.

TH1999

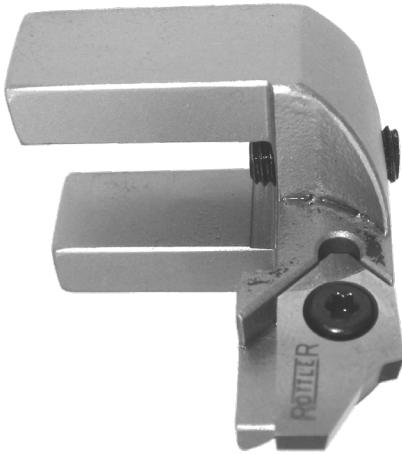
Cutting Insert Tip Holder, using UPT5500 Unipilot Tool holder, Seat diameter range: .570 - 1.250" (14.48 - 33.52mm) (Using RCA630 Cutting Insert) and .800 - 1.320" (20.32 - 33.52mm) Using RCA026 Cutting Insert

**TH2000**

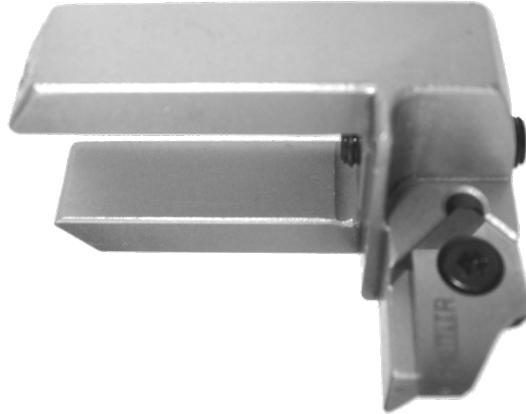
Cutting Insert Tip Holder, using UPT5500 or UPT 5600 Unipilot Tool holder, seat diameter range .800 - 1.395" (20.32 - 35.43mm)

**TH2001**

Cutting Insert Tip Holder, using UPT5600, seat diameter range .850 - 1.625" (21.6 - 41.3mm) (Using RCA630 Cutting Insert)

**TH2002**

Cutting Insert Tip Holder, using UPT5600, seat diameter range 1.270 - 2.360" (32.26 - 59.94mm) Using RCA630 Cutting Insert)

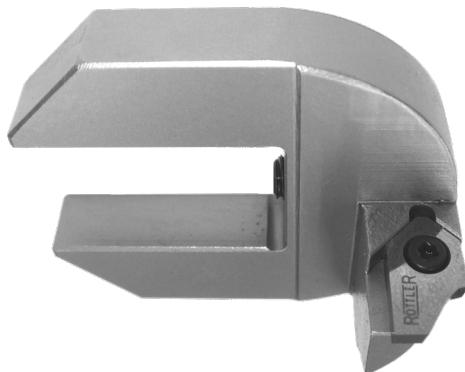


TH2003

Cutting Insert Tip Holder, using UPT5700, seat diameter range: 1.270 - 2.360" (32.26 - 60mm) (Using RCA630 Cutting Insert)

**TH2004**

Cutting Insert Tip Holder, using UPT5700, seat diameter range: 1.850 - 3.150" (47 - 80mm) (Using RCA630 Cutting Insert)

**TH2005**

Cutting Insert Tip Holder, using UPT5700, seat diameter range: 2.625 - 4.724" (66.7 - 120mm) (Using RCA630 Cutting Insert)



Cutting Insert Tip Holders for RT200 Triangular Inserts

To be used with UPT5500, UPT5600, UPT5700 UNIPILOT Tool Holders, requires T7 Torx Driver

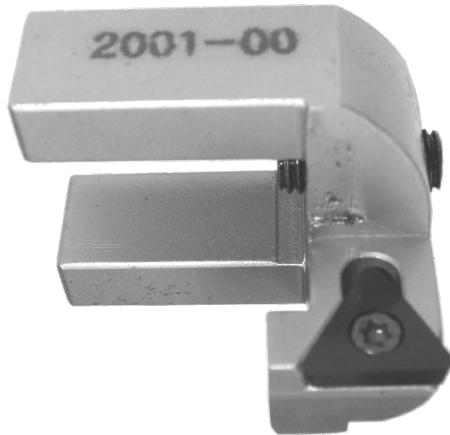
TH2000-00

00 Degree
Triangular Tip
Holder For Valve
Seat Installation
Counterboring.
Uses RT200
Triangular Insert.
Counterbore
diameter range
.1.055 - 1.58"



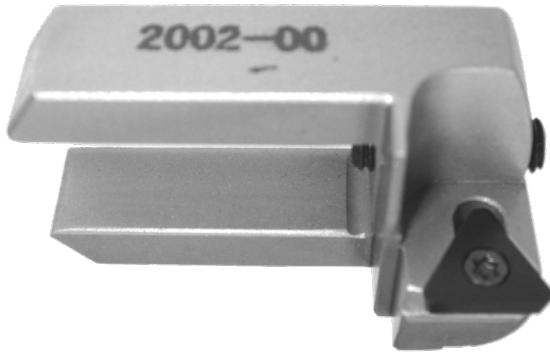
TH2001-00

"00 Degree
Triangular Tip
Holder For Valve
Seat Installation
Counterboring.
Uses RT200
Triangular Insert.
Counterbore
diameter range:
1.100 - 1.570""
(28 - 42mm)"



TH2002-00

"00 Degree Triangular Tip Holder For Valve Seat
Installation Counterboring. Uses RT200 Triangular Insert.
Counterbore diameter range: 1.570 - 2.360"" (40 - 60mm)"



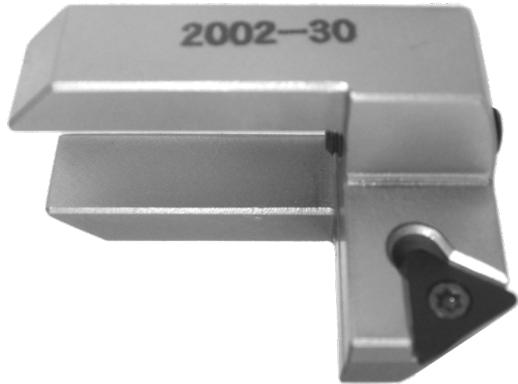
TH2002-20

"20 Degree Triangular Tip Holder For 20 Degree Valve
Seat Angle Cutting. Uses RT200 Triangular Insert. Seat
diameter range: 1.570 - 2.360"" (40 - 60mm)"



TH2002-30

"30 Degree Triangular Tip Holder For 30 Degree Valve
Seat Angle Cutting. Uses RT200 Triangular Insert. Seat
diameter range: 1.570 - 2.360"" (40 - 60mm)"



TH2002-45

"45 Degree Triangular Tip Holder For 45 Degree Valve
Seat Angle Cutting. Uses RT200 Triangular Insert. Seat
diameter range: 1.570 - 2.360"" (40 - 60mm)"

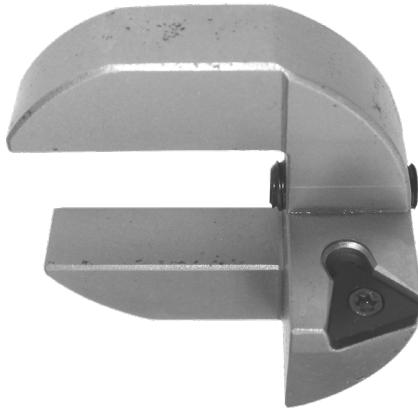


TH2003-00

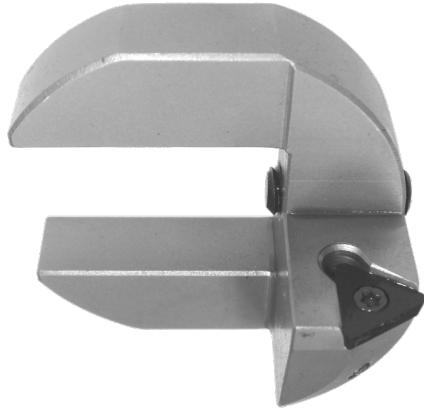
"00 Degree Triangular Tip Holder For Valve Seat Installation Counterboring. Uses RT200 Triangular Insert. Counterbore diameter range: 1.570 - 2.360"" (40 - 60mm)"

**TH2003-20**

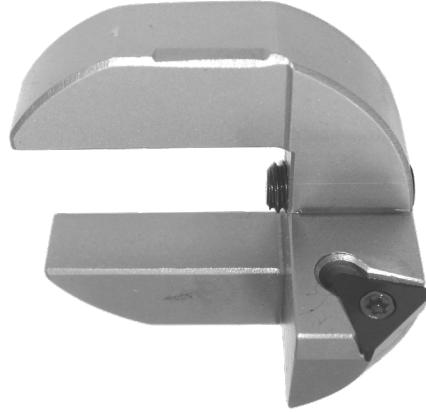
"20 Degree Triangular Tip Holder For 20 Degree Valve Seat Angle Cutting. Uses RT200 Triangular Insert. Seat diameter range: 1.570 - 2.360"" (40 - 60mm)"

**TH2003-30**

"30 Degree Triangular Tip Holder For 30 Degree Valve Seat Angle Cutting. Uses RT200 Triangular Insert. Seat diameter range: 1.570 - 2.360"" (40 - 60mm)"

**TH2003-45**

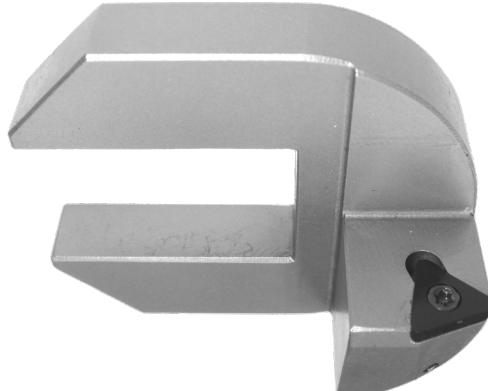
"45 Degree Triangular Tip Holder For 45 Degree Valve Seat Angle Cutting. Uses RT200 Triangular Insert. Seat diameter range: 1.570 - 2.360"" (40 - 60mm)"

**TH2004-00**

"00 Degree Triangular Tip Holder For Valve Seat Installation Counterboring. Uses RT200 Triangular Insert. Counterbore diameter range: 2.280 - 3.150"" (58 - 80mm)"

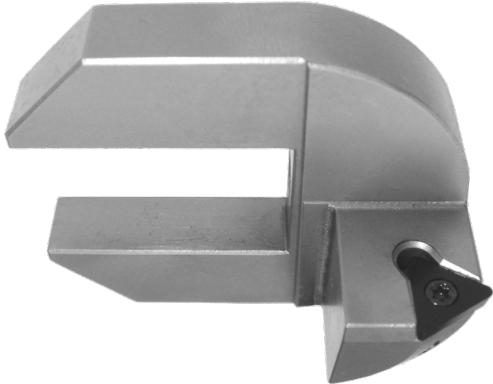
**TH2004-20**

"20 Degree Triangular Tip Holder For 20 Degree Valve Seat Angle Cutting. Uses RT200 Triangular Insert. Seat diameter range: 2.280 - 3.150"" (58 - 80mm)"

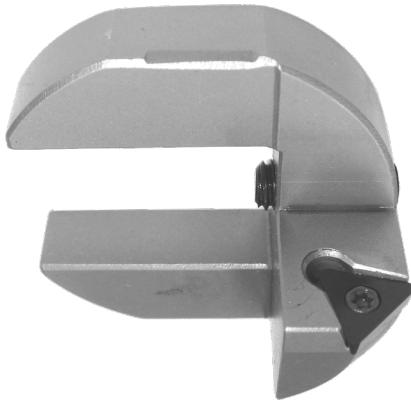


TH2004-30

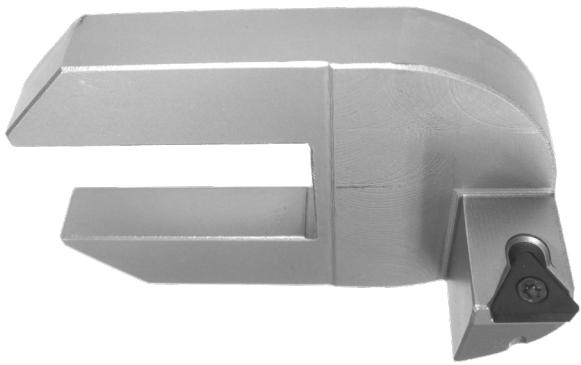
"30 Degree Triangular Tip Holder For 30 Degree Valve Seat Angle Cutting. Uses RT200 Triangular Insert. Seat diameter range: 2.280 - 3.150" (58 - 80mm)"

**TH2004-45**

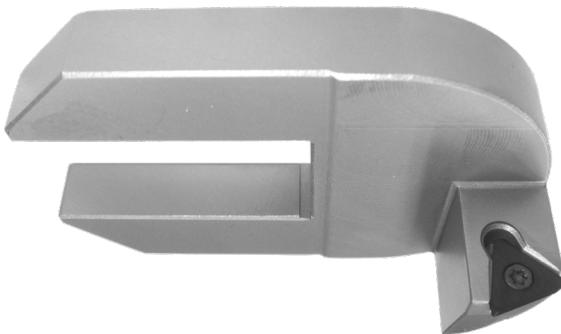
"45 Degree Triangular Tip Holder For 45 Degree Valve Seat Angle Cutting. Uses RT200 Triangular Insert. Seat diameter range: 2.280 - 3.150" (58 - 80mm)"

**TH2005-00**

"00 Degree Triangular Tip Holder For Valve Seat Installation Counterboring. Uses RT200 Triangular Insert. Counterbore diameter range: 3.071" - 4.724" (78mm - 120mm)"

**TH2005-20**

"20 Degree Triangular Tip Holder For 20 Degree Valve Seat Angle Cutting Uses RT200 Triangular Insert. Seat diameter range: 3.071" - 4.724" (78mm - 120mm)"

**TH2005-30**

"30 Degree Triangular Tip Holder For 30 Degree Valve Seat Angle Cutting Uses RT200 Triangular Insert. Seat diameter range: 3.071" - 4.724" (78mm - 120mm)"

**TH2005-45**

"45 Degree Valve Seat Angle Cutting Uses RT200 Triangular Insert. Seat diameter range: 3.071" - 4.724" (78mm - 120mm)"



Rottler Spindle Adapters for Fixed Pilot Applications

Very Large Cylinder Heads with Large Diameter Valve Guides often require Extended Length Pilots which should be fixed in the Valve Guide before Valve Seat cutting can be done. Fixed Pilot system requires special tooling as listed below.

R20-5800 Rotter Spindle for 20mm Pilot Shank

seat diameter range with TH3005 2.677"- 4.645" (68-118mm)



R20-5900 Rotter Spindle for 20mm Pilot Shank

seat diameter range with TH3005 3.937"-5.905" (100-150mm)

Image Currently Unavailable

R20-6000 Rotter Spindle for 20mm Pilot Shank

seat diameter range with TH3005 4.724"-6.69" (120-170mm)

Image Currently Unavailable

R20-6100 Rotter Spindle for 20mm Pilot Shank

seat diameter range with TH3005 5.905"-7.874" (150-200mm)

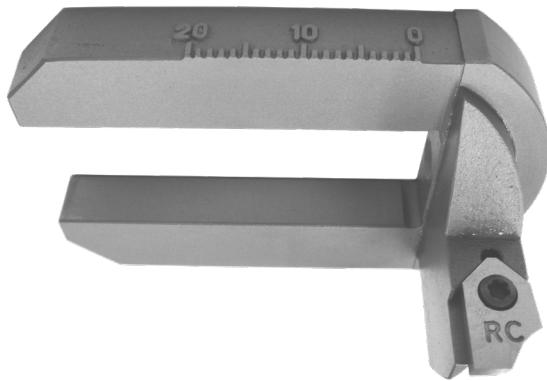
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Cutting Insert Tip Holders, Seat Diameter Range 2.677" - 7.874" (68mm - 200mm)

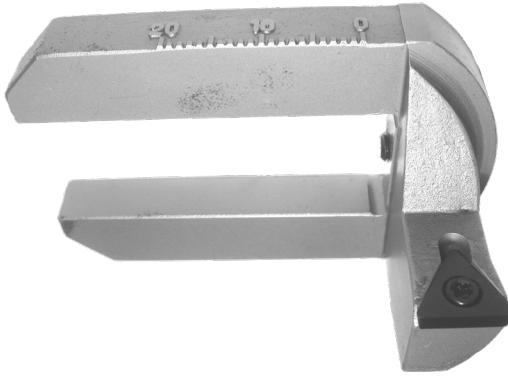
to be used with R20-5800, R20-5900, R20-6000, R20-6100 Spindle Adapters, requires T15 Torx Driver.

TH3005

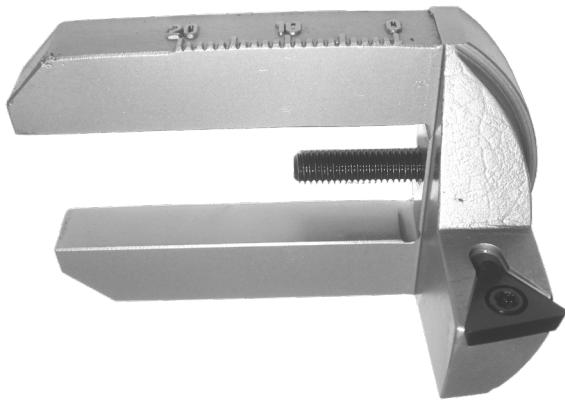
Tip Holder, Range 2.677" - 7.874" (68 - 200mm) using RCCXXX Multi Angle Cutting Inserts

**TH3005-00**

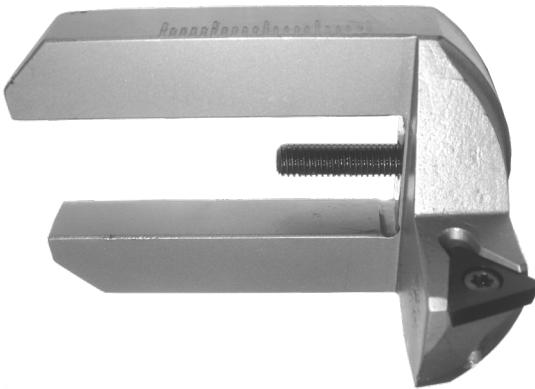
00 Degree using triangular Rottler style inserts RT300 and R20 range of Spindle Adapters (for counterboring valve seat housings)

**TH3005-10**

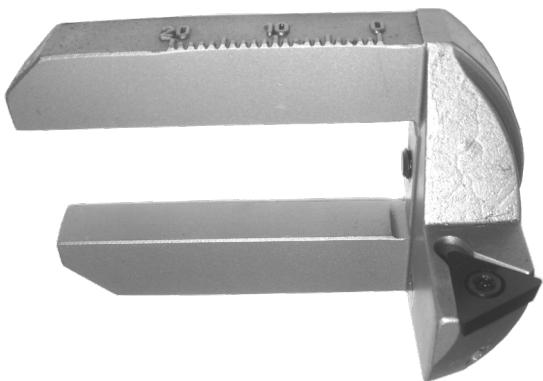
10 Degree Valve Seat Angle using triangular inserts RT300 and R20 range of Spindle Adapters

**TH3005-20**

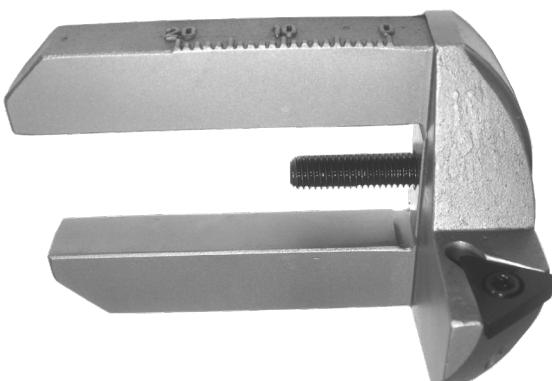
20 Degree Valve Seat Angle using triangular inserts RT300 and R20 range of Spindle Adapters

**TH3005-30**

30 Degree Valve Seat Angle using triangular inserts RT300 and R20 range of Spindle Adapters

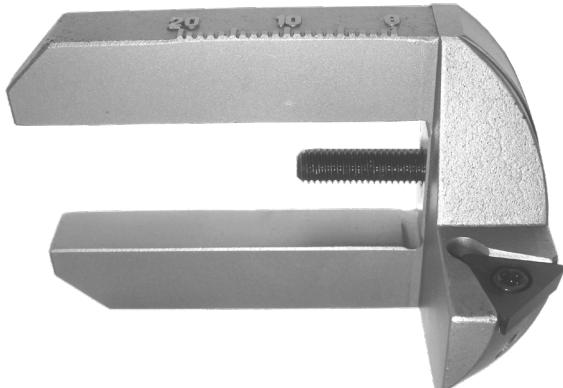
**TH3005-35**

35 Degree Valve Seat Angle using triangular inserts RT300 and R20 range of Spindle Adapters

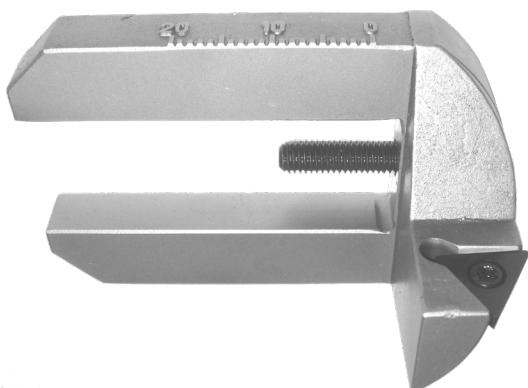


TH3005-45

45 Degree Valve Seat Angle using triangular inserts RT300 and R20 range of Spindle Adapters

**TH3005-60**

60 Degree Valve Seat Angle using triangular inserts RT300 and R20 range of Spindle Adapters



Triangular Inserts For Use In Listed Holders

RT211

Triangular Insert, 1/4" (6.35mm)
IC, 1/64" (.4mm) radius FOR
COUNTERBORING and SINGLE
ANGLE CUTTING INSERT TIP
HOLDERS

**RT212**

Triangular Insert, 1/4" (6.35mm)
IC, 1/32" (.8mm) radius FOR
COUNTERBORING and SINGLE
ANGLE CUTTING INSERT TIP
HOLDERS

**RT321**

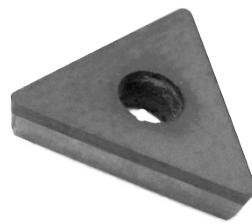
Insert, triangular 3/8" (9.52mm)
IC 1/64" (.4mm) Radius FOR
COUNTERBORING AND SINGLE
ANGLE CUTTING INSERT TIP
HOLDERS

**RT322**

Insert, triangular 3/8" (9.52mm)
IC, 1/32" (.8mm) Radius FOR
COUNTERBORING AND SINGLE
ANGLE CUTTING INSERT TIP
HOLDERS

**RT211CBN**

CBN Triangular Insert, 1/4" (6.35mm)
IC 1/64" (.4mm) radius, for Hard Valve
Seats

**RT321CBN**

CBN Triangular Insert, 3/8" (9.52mm)
IC 1/64" (.4mm) radius, for Hard Valve
Seats



Suggested Basic Tooling

T7D

T7 Torx driver for RT200 Triangular Cutting Inserts


T15D

T15 Torx Tip Holding Screw Driver for RCC Multi Angle Valve Seat Cutting Inserts and RT300 Triangular Cutting Inserts


PRW20

Pilot removable wrench for 20.00mm shack Pilots only


PRW375

Pilot Removal Wrench for .375" pilot shank.


T8D

T8 Torx Tip Holding Screw Driver for RCA and RCB Multi Angle Valve Seat Cutting Inserts


ALLEN-KEYS-IN

INCH Ball end hex Allen Key Set Drivers From: 1/16 - 3/8"

ALLEN-KEYS-MM

METRIC Ball end hex Allen Key Set



Pre-Settable Adjustable Diameter Valve Seat Housing Cutterheads

7630D Pre-settable Adjustable Diameter Valve Seat Housing Cutterhead

Range 2.08 - 2.68" (52.8 - 68.72mm) Designed for .375" (9.52mm)

Shank Pilots.

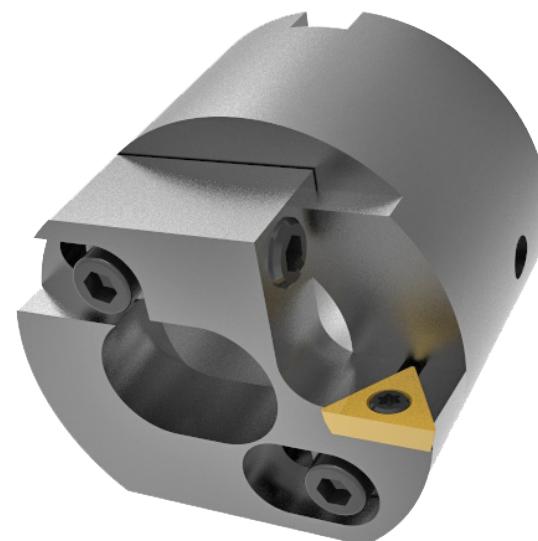
Note: Requires RS105 Driver and BM Micrometer



7630 Pre-Settable Adjustable Diameter Valve Seat Housing Cutterhead

Range 2.599 - 3.233" (66.015 - 82.118mm) Designed for 20mm Shank Pilots.

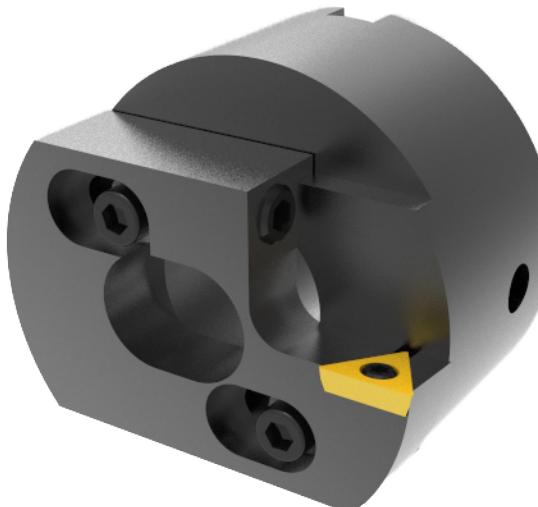
Note: Requires BD3175 Driver and BM20 Micrometer



7630G Pre-Settable Adjustable Diameter Valve Seat Housing Cutterhead

Range 3.180" - 3.790" (80.84 - 96.27mm) designed for 20mm Shank Pilots.

Note: Requires BD3175 Driver and BM20 Micrometer



Spindle Adapters

COLLETKITR40

Collet chuck set of 10 collets Including: (1/4, 5/16, 11/32, 3/8, 7/16, 1/2, 9/16, 3/4, 7/8, 1.00" Spring Collets) Collet Chuck Spindle Adapter with Collet Nut for Rottler R40 Spindle Taper and Spanner Wrench for Collet Chuck.



SAD375R40EL4 Spindle Adapter

For Rottler R40 Spindle Taper for .375" (9.52mm) Shank Diameter Tools, reamers, drills, etc. includes 2 locking set screws, extended 4" (102.4mm)



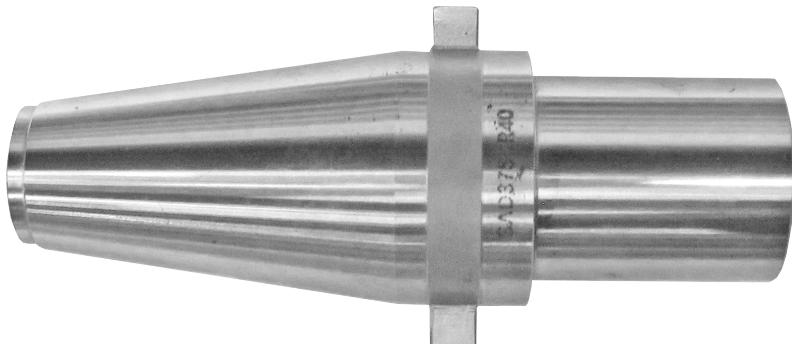
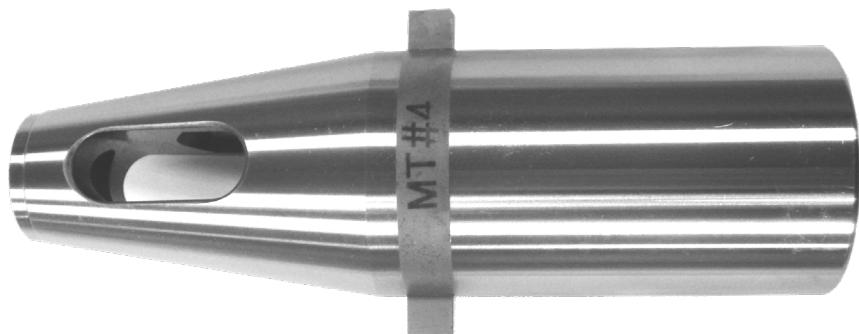
SAD750R40 Spindle Adapter

For Rottler R40 Spindle Taper for 3/4" (19.05mm) Shank Diameter Tools, reamers, drills, etc includes 2 locking set screws



SAD375R40 Spindle Adapter for Rottler R40 Spindle Taper

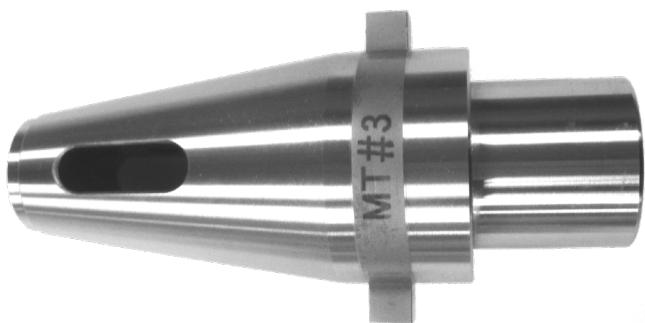
for .375" (9.52mm) Shank Diameter Tools, reamers, drills, etc. includes 2 locking set screws

**R40MT2EL2 Adaptor for Morse #2 to Rottler ISO 40 Spindle Taper (2" Extended Length)****R40MT2**

Adapter for Morse #2 to Rottler ISO 40 Spindle Taper

**R40MT3**

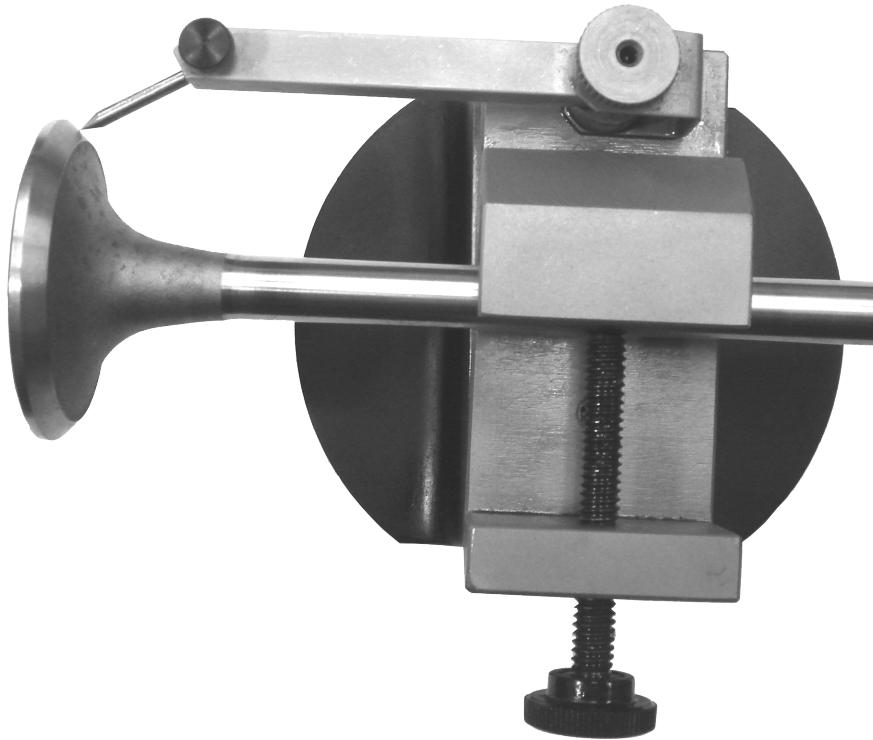
Adapter for Morse #3 to Rottler ISO 40 Spindle Taper



Micrometers Setting Fixtures and Measurement Tools

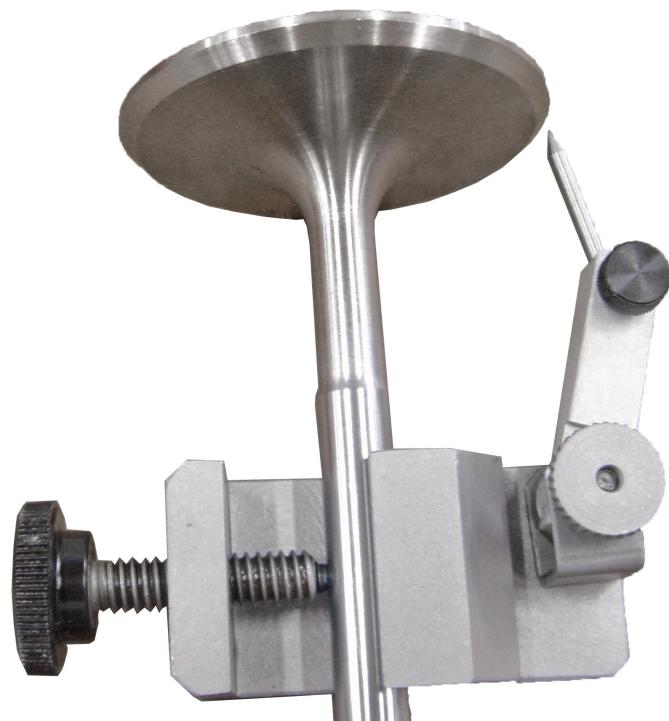
DSP20

Table mount tool setting device with Interchangeable Point for 20.00mm Shank pilots



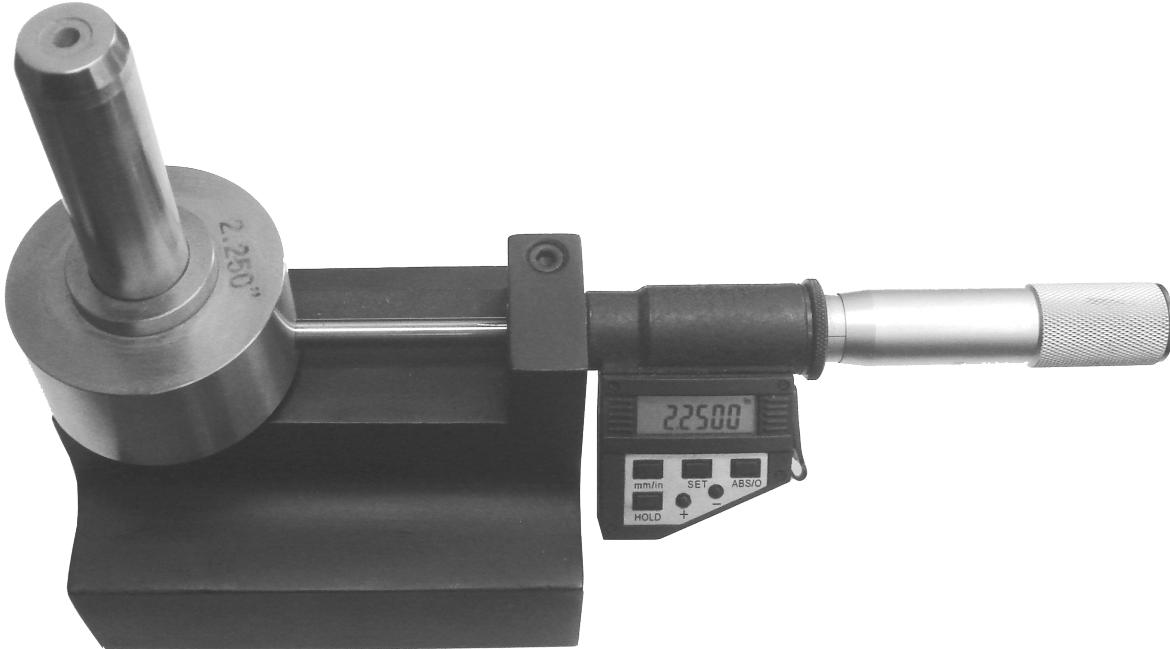
DSP

Tool setting Device with Interchangeable Point



BM20

Counterboring Micrometer Assembly with Digital Reading inch and metric (2.200 - 5.400") For 20mm shank diameter tooling, including Setting Standard

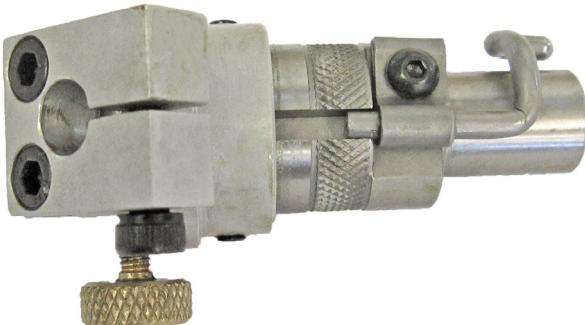
**BM**

Boring Micrometer, Digital Reading Inch and Metric (.800 - 2.80") with setting standard for .375" (9.52mm) and 6.00mm (152.40mm) shank diameter



VSG102-375

Precision Valve Seat Concentricity Gage Base Only for .375" Pilot Shank (Must Order dial indicator .0001" or .002mm Metric indicator)

**VSG2000**

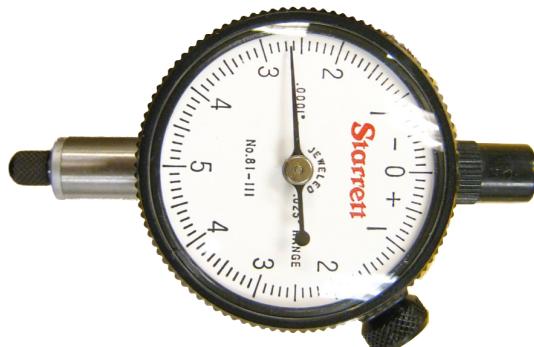
Precision Valve Seat Concentricity Gage Base Only for 20.00mm Pilot Shank Range 2.362 - 5.905" (60.00 - 150.00mm)
Must Order dial indicator .0001" or .002mm Metric indicator

**502-11-39L**

Mechanical run out indicator for Precision bore adjustment (.002mm resolution) METRIC

**502-11-39D**

Mechanical run out indicator for Precision bore adjustment (.0001 resolution) INCH



Cutting Insert Sharpener for Multi Angle Inserts

BWSHD20

Heavy Duty Diamond Wheel Insert
Sharpener for 20.00mm and 9.52mm Pilot
Shank Tooling



BWS02

Diamond Wheel Cutting Bit Sharpener for
9.52mm and 6mm Pilot Shank Tooling



Miscellaneous Tooling

COLLETKITR40

Collet chuck set of 10 collets Including: (1/4, 5/16, 11/32, 3/8, 7/16, 1/2, 9/16, 3/4, 7/8, 1.00" Spring Collets) Collet Chuck Spindle Adapter with Collet Nut for Rottler R40 Spindle Taper and Spanner Wrench for Collet Chuck.



CCWSETR40

Collet Chuck Spindle Adapter (ER40 / ISO40) with Collet Nut for Rottler R40 Spindle Taper (for ER 40 Collets only)



PC750R40

3 jaw key chuck - Max capacity .750" (19.05mm)



UPT40RS625

Rottler R40 Spindle Taper Milling Head Driver for Fixed Milling Heads

Image Currently Unavailable

Valve Seat Cutting Inserts

See the SG Inserts & Profile Catalog on www.rottermfg.com for drawings of the most popular Cutting Inserts. The catalog is linked on each SG machine's webpage under "PDF Resources".

Select the correct Insert profile to match the original factory valve seat shape. The most important specification is the valve seat surface angle and width.

All specifications can be obtained from the OEM Original Equipment Manufacturer.

RCA inserts are designed for regular 3 angle valve seats, make sure the that top angle will not go over the seat insert, and cut the combustion chamber.

RCB inserts Profiles are designed for a multiple angles and radius and are recommended for long profiles often required for high performance applications.

RCC Inserts are made from larger/thicker carbide and use a T15 Torx Screw. RCC inserts are designed for large diameter valve seats.

RCAXXX	Carbide Seat Cutting Inserts RC multi-angle A Blank (Standard Profile)
RCBXXX	Carbide Seat Cutting Inserts RC multi-angle B Blank (Standard Profile)
RCCXXX	Carbide Seat Cutting Inserts RC multi-angle C Blank (Standard Profile)

Rottler Special Profile Cutter Inserts Policy

Special Profile Cutter Inserts can be manufactured to your exact specifications and can include a combination of angles and radius blends. Special Profile Cutting Inserts are generally considered to be "Customer Proprietary". These are uniquely numbered, exclusively for the ordering customer.

Drawing Fee There is a one-time drawing/design fee per each Special Profile Cutting Insert

RCSXXX	On orders of 1-9 A or B Blank Special Profile after drawing fee charge.
RCSXXX	On orders of 10+ A Blank Special Profile after drawing fee charge.
RCSXXX	On orders of 10+ B Blank Special Profile after drawing fee charge.

UNIPILOT Carbide Pilot Pricing by Diameter

See the SG Pilot Catalog on www.rottermfg.com for listings of the most popular Carbide Centralizing Pilots. The catalog is linked on each SG machine's webpage under "PDF Resources".

Common .375"(9.52mm) Shank, Standard 7.5" Length

UCP-5TO10-STD UNITPILOT Carbide Pilots UCP .375" (9.52mm) Shank Diameter / Total Length 7.500" Range from .196 - .394" (5.00 - 10.00mm)

UCP-1001TO12-STD UNITPILOT Carbide Pilots UCP .375" (9.52mm) Shank Diameter / Total Length 7.500" Range from .390 - .470" (10.01 - 12.00mm)

UCP-1201TO14-STD UNITPILOT Carbide Pilots UCP .375" (9.52mm) Shank Diameter / Total Length 7.500" Range from .470 - .550" (12.01 - 14.00mm)

UCP-1401TO15-STD UNITPILOT Carbide Pilots UCP .375" (9.52mm) Shank Diameter / Total Length 7.500" Range from .470 - .550" (14.01-15.00mm)

Extended Length 9.00" Pricing by Diameter

UCP-5TO10-EL9 UNITPILOT Carbide Pilots UCP .375" (9.52mm) Shank Diameter / Total Length 9.00" Range from .196 - .394" (5.00 - 10.00mm)

UCP-10TO12-EL9 UNITPILOT Carbide Pilots UCP .375" (9.52mm) Shank Diameter / Total Length 9.00" Range from .390-.470" (10.01 - 12.00mm)

UCP-12TO14-EL9 UNITPILOT Carbide Pilots UCP .375" (9.52mm) Shank Diameter / Total Length 9.00" Range from .470-.550" (12.01 - 14.00mm)

Extended Length 10.00" Pricing by Diameter

UCP-XXXX-10EL UNITPILOT Carbide Pilots UCP .375" (9.52mm) Shank Diameter / Total Length 10.00" Range from .196 - .394" (5.00 - 10.00mm)

Extended Length 12.00" Pricing by Diameter

UCP-12TO14-EL12 UNITPILOT Carbide Pilots UCP .375" (9.52mm) Shank Diameter / Total Length 12.00" Range from .470 - .550" (12.01 - 14.00mm)

Extended Length Large Shank 20.00mm(.787") Diameter Pricing

UCP-XXXX-1220 .560" UNIPILOT Carbide Pilot (20.00mm) Shank diameter (12.00" Length)

UCP-XXXX-1320 .560" UNIPILOT Carbide Pilot (20.00mm) Shank diameter (13.00" Length)

UCP-XXXX-1520 .560" UNIPILOT Carbide Pilot (20.00mm) Shank diameter (15.00" Length)

UNIPILOT MINI Carbide Pilots with 6.00mm Shank Diameter for Fixed Pilot Application

UCPM-MINI UNIPILOT Carbide Pilots with 6.00mm Shank Diameter / 5.700" long range from 3.50mm up to 7.00mm to be used on BH600-R1 Tool Holder and TH1999 Tip Holder for Fixed Pilot Application

Modular Pilot Pricing by Diameter and Length

FCM20EL380	Modular Carbide Centralizing Pilot for Valve Guides Over 0.875" (22.23mm). Requires a set of Interchangeable Sleeves (FCMSLXXX & FCMSUXXX) - 20mm Shank Pilot
FCMUSXXX	Modular Pilot Upper (Tapered) Sleeve - Hardened and Heat Treated - For .XXX" (XX.XXmm) Guide ID
FCMSLXXX	Modular Pilot Lower (Straight) Sleeve - Hardened and Heat Treated - For .XXX" (XX.XXmm) Guide ID - 3.0" Overall Length

If required diameter is not listed, semi finished modular pilot sleeves are available and customer is able to finish to suit requirements. If customer requires Rottler to manufacture modular sleeves, Customer Must Provide the Size, Including Tolerance, of the Valve Guides the Sleeves Will be Used in. Rottler will use this information to Design the Actual Pilot Sleeves.