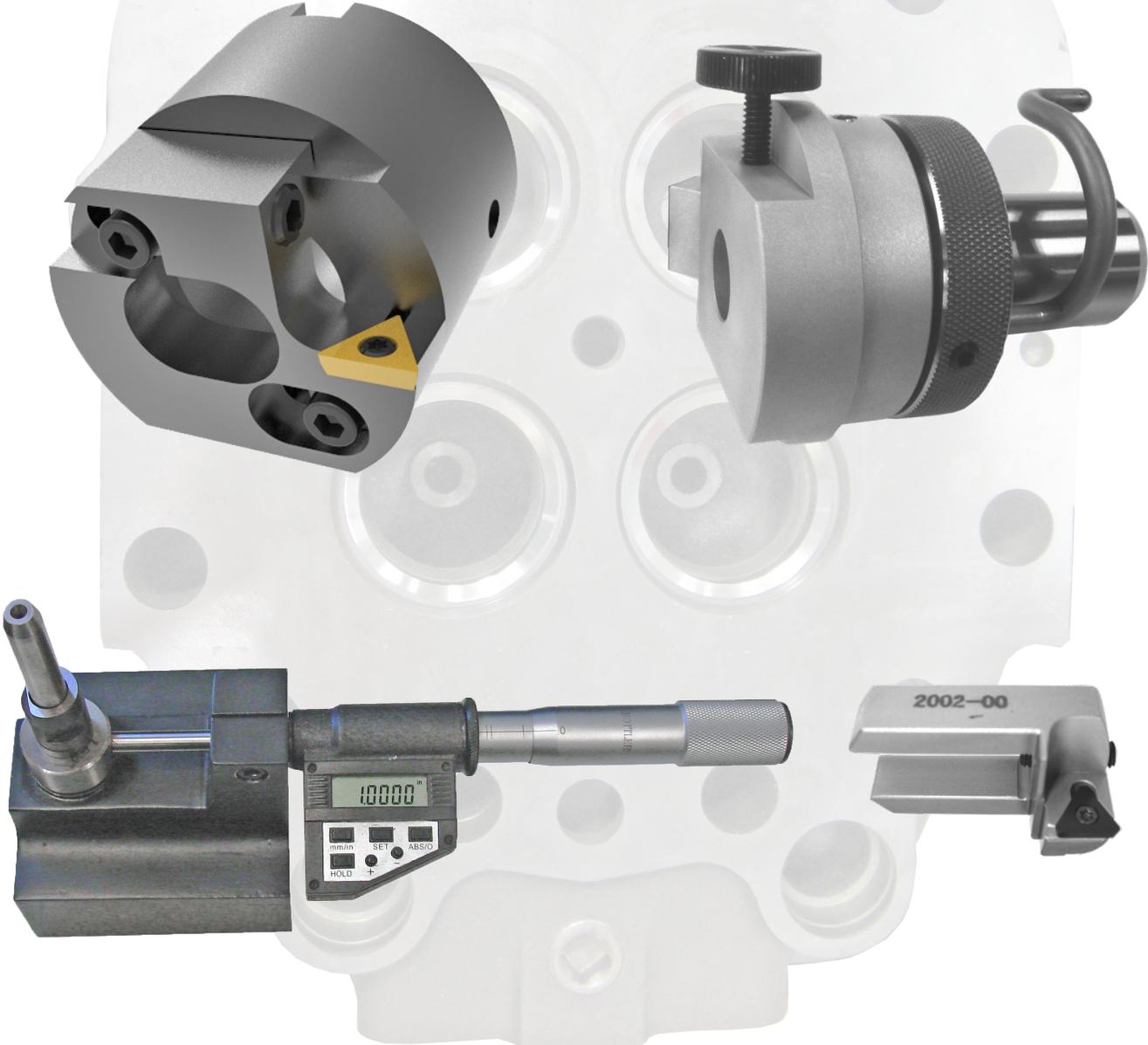


ROTTLER

SG100XY 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@rottermfg.com or intlparts@rottermfg.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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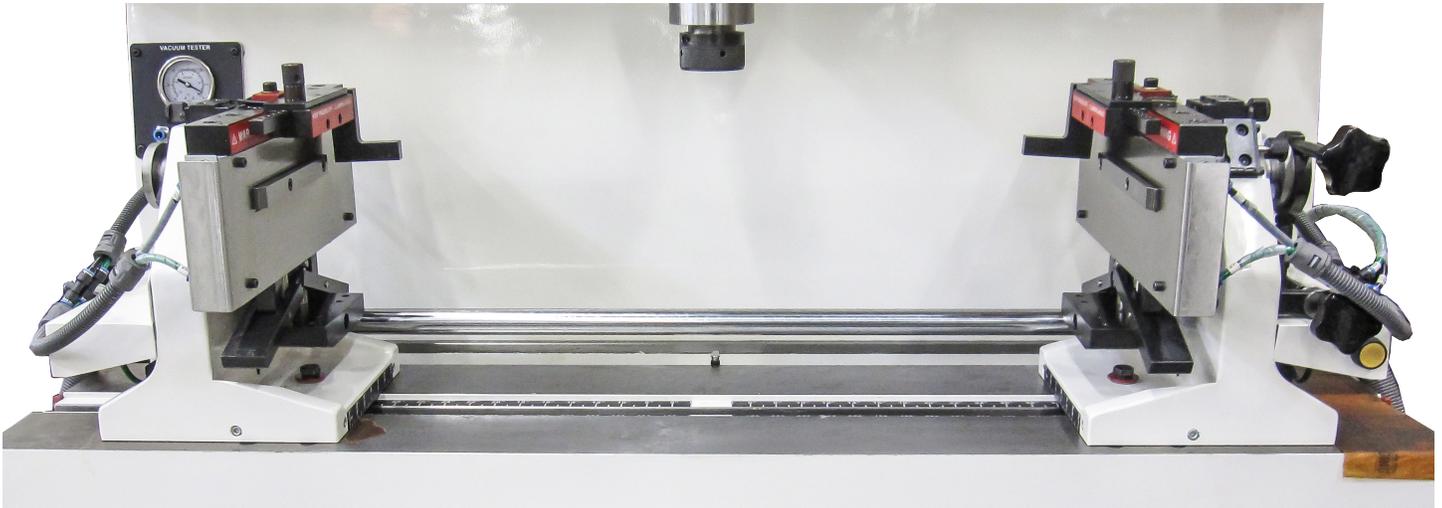
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Optional Fixtures

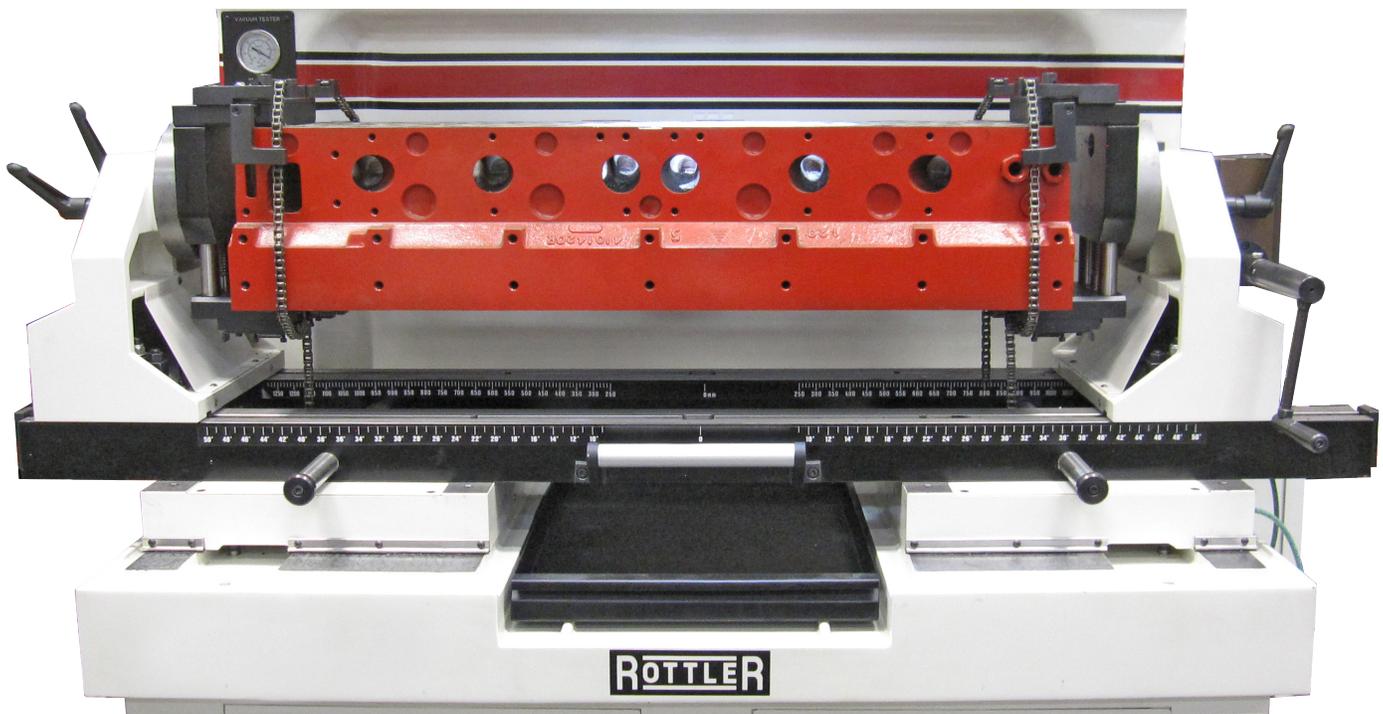
ROLL-FIX100

Servo Powered and CNC controlled 360 Degree Roll Over Fixture



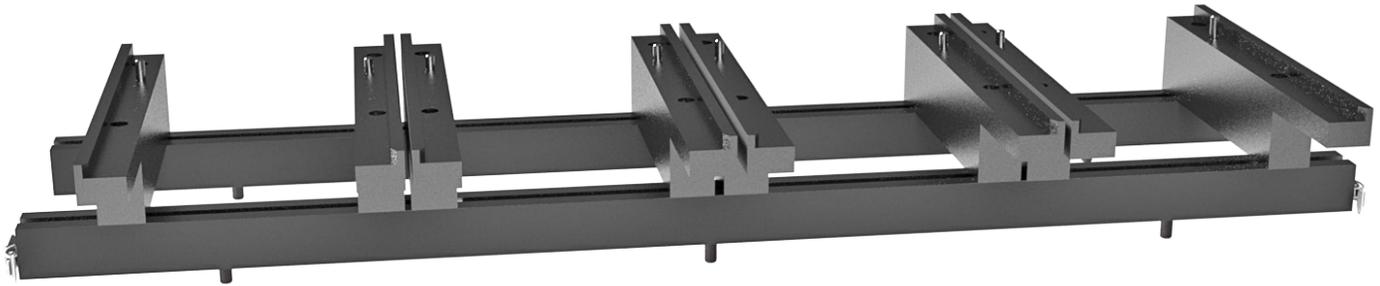
PER-FIX-MH-CAT3500

Allows for multiple heads like the CAT 3500/C175 to be front loaded and located on against stops for proper alignment. At the touch of a button the fixture pneumatically clamps the heads upward against the fire deck thereby cutting all seats to a consistent depth.



12200 Cart Top Loading Fixture

Holds 4 CAT3500 for easy loading and unloading of machine



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)



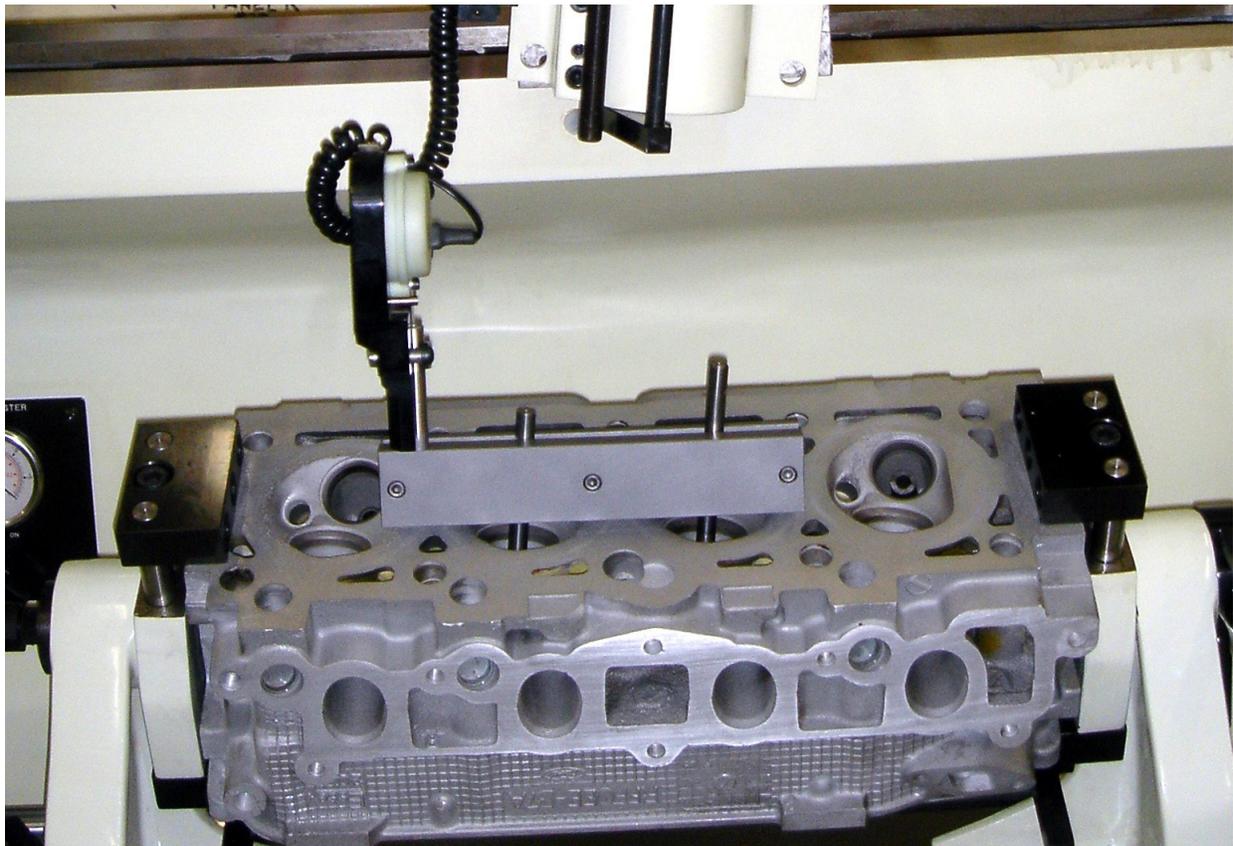
7242N

Clamp Tower Assembly, Complete with Lower Base Plates



CANTEDFIX

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



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 RCAXXX and RCBXXX 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"



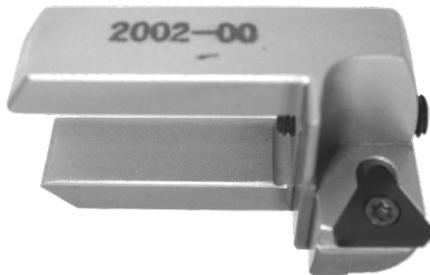
TH2001-00

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)



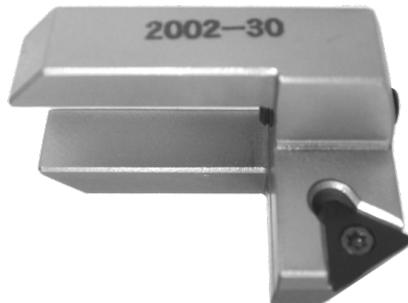
TH2002-20

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)

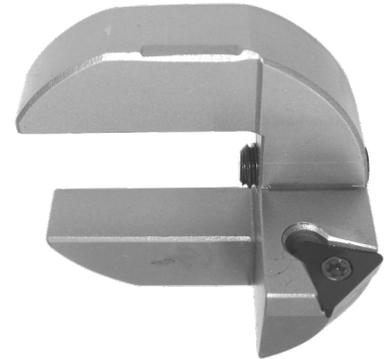


TH2003-30

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**

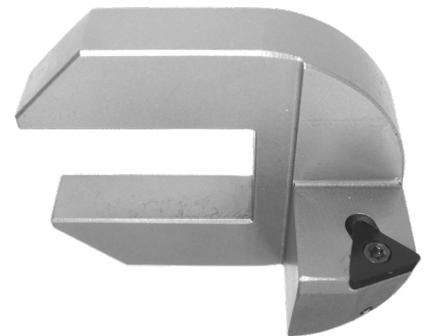
45 Degree Triangular Tip Holder For 45 Degree Valve Seat Angle Cutting. Uses RT200 Triangular Insert. Seat diameter range: 1.570 - 2.360" (40 - 60mm)

**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**

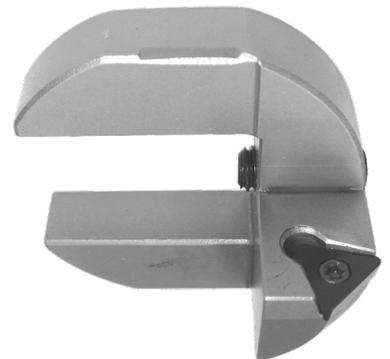
20 Degree Triangular Tip Holder For 20 Degree Valve Seat Angle Cutting. Uses RT200 Triangular Insert. Seat diameter range: 2.280 - 3.150" (58 - 80mm)

**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**

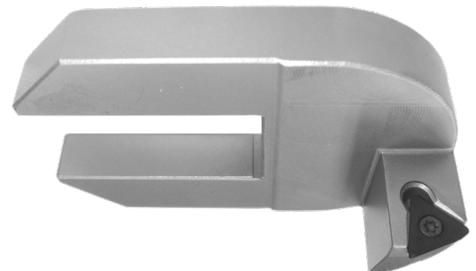
45 Degree Triangular Tip Holder For 45 Degree Valve Seat Angle Cutting. Uses RT200 Triangular Insert. Seat diameter range: 2.280 - 3.150" (58 - 80mm)

**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)

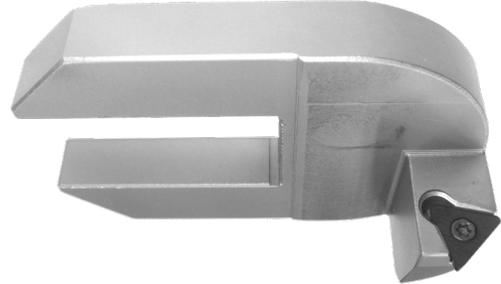


TH2005-30

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)



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.

Rottler Spindle Adapters for Fixed Pilot Applications

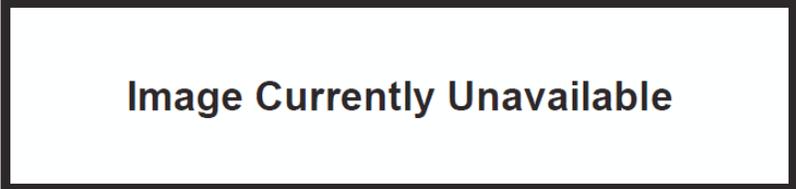
R20-5800

Rotter Spindle for 20mm Pilot Shank Dia., seat diameter range with TH3005 2.677" - 4.645" (68-118mm)



R20-5900

Rotter Spindle for 20mm Pilot Shank Dia., seat diameter range with TH3005 3.937"-5.905" (100-150mm)



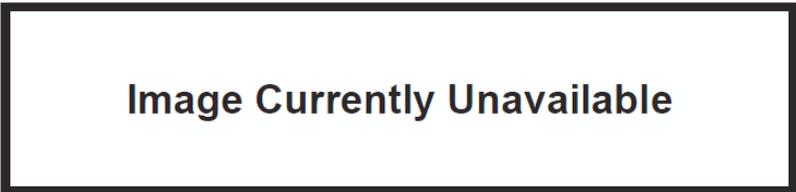
R20-6000

Rotter Spindle for 20mm Pilot Shank Dia., seat diameter range with TH3005 4.724"-6.69" (120-170mm)



R20-6100

Rotter Spindle for 20mm Pilot Shank Dia., seat diameter range with TH3005 5.905"-7.874" (150-200mm)

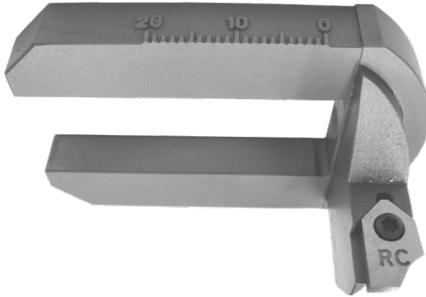


Cutting Insert Tip Holders

Seat Diameter Range (2.677" to 7.874" (68mm to 200mm) to be used with R20-5800, R20-5900, R20-6000, R20-6100 Spindle Adapters, requires T15 Torx Driver

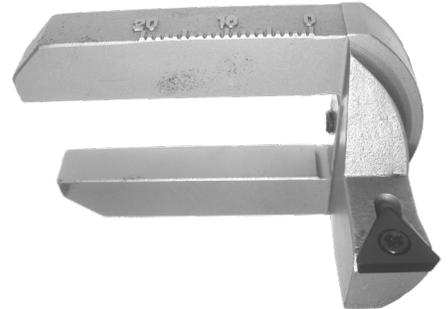
TH3005

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



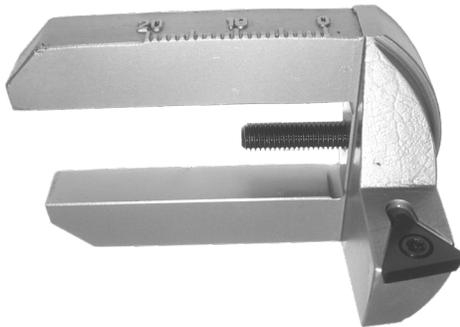
TH3005-00

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



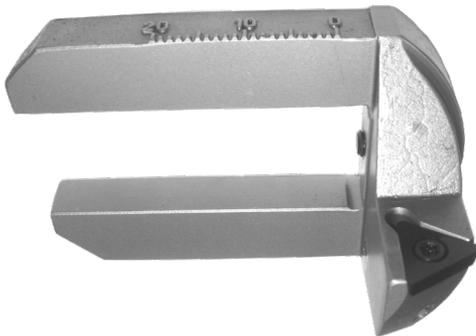
TH3005-20

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



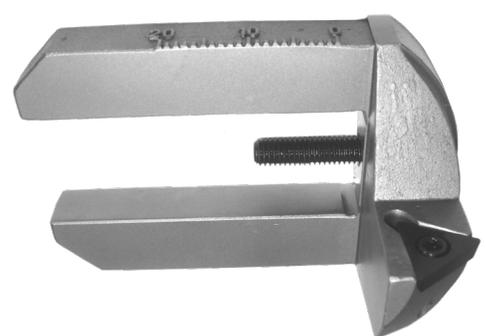
TH3005-30

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



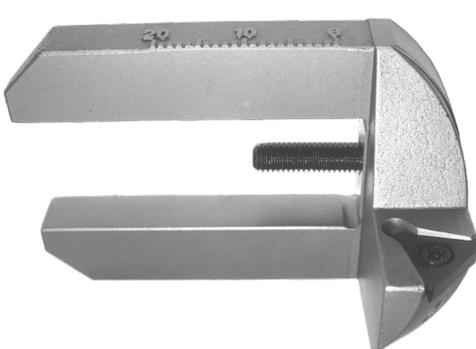
TH3005-35

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



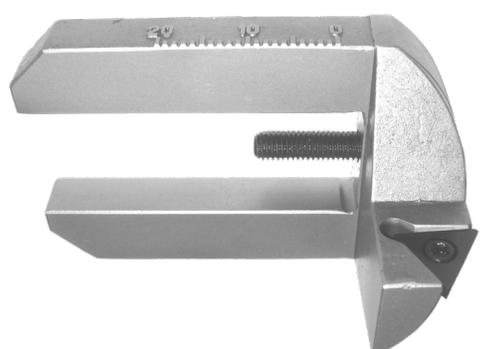
TH3005-45

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

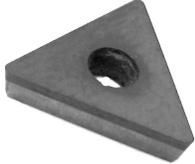


TH3005-60

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



Triangular Inserts

<p>RT211 Triangular Insert, 1/4" (6.35mm) IC, 1/64" (.4mm) radius FOR COUNTERBORING and SINGLE ANGLE CUTTING INSERT TIP HOLDERS</p> 	<p>RT212 Triangular Insert, 1/4" (6.35mm) IC, 1/32" (.8mm) radius FOR COUNTERBORING and SINGLE ANGLE CUTTING INSERT TIP HOLDERS</p> 	<p>RT321 Insert, triangular 3/8" (9.52mm) IC 1/64" (.4mm) Radius FOR COUNTERBORING AND SINGLE ANGLE CUTTING INSERT TIP HOLDERS</p> 
<p>RT322 Insert, triangular 3/8" (9.52mm) IC, 1/32" (.8mm) Radius FOR COUNTERBORING AND SINGLE ANGLE CUTTING INSERT TIP HOLDERS</p> 	<p>RT211CBN CBN Triangular Insert, 1/4" (6.35mm) IC 1/64" (.4mm) radius, for Hard Valve Seats</p> 	<p>RT321CBN CBN Triangular Insert, 3/8" (9.52mm) IC 1/64" (.4mm) radius, for Hard Valve Seats</p> 

Suggested Basic Tooling

<p>T7D T7 Torx driver for RT200 Triangular Cutting Inserts</p> 	<p>T8D T8 Torx Tip Holding Screw Driver for RCA and RCB Multi Angle Valve Seat Cutting Inserts</p> 
<p>T15D T15 Torx Tip Holding Screw Driver for RCC Multi Angle Valve Seat Cutting Inserts and RT300 Triangular Cutting Inserts</p> 	<p>PRW20 Pilot removable wrench for 20.00mm shack Pilots only</p> 

PRW375

Pilot Removal Wrench for .375" pilot shank.



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.

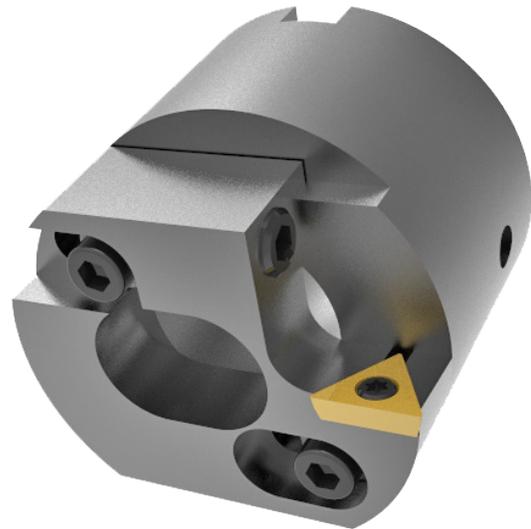
Note: Requires RS105 Driver and BM Micrometer



7630

Pre-settable Adjustable Diameter Valve Seat Housing Cutterhead. Range 2.599 - 3.233" (66.015 - 82.118mm) Designed for 20mm Shank Pilots.

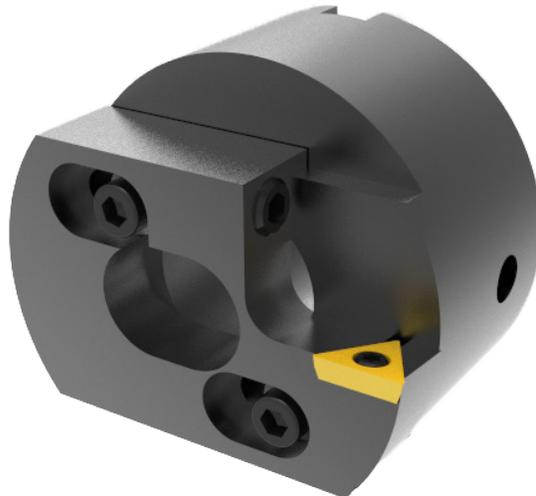
Note: Requires BD3175 Driver and BM20 Micrometer



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.



SAD375R40

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



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



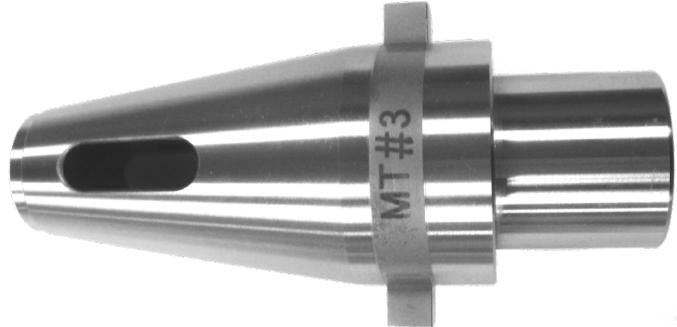
R40MT2

Adapter for Morse #2 to Rottler ISO 40 Spindle Taper



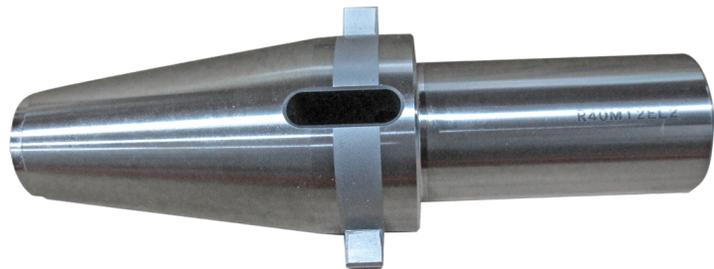
R40MT3

Adapter for Morse #3 to Rottler ISO 40 Spindle Taper



R40MT2EL2

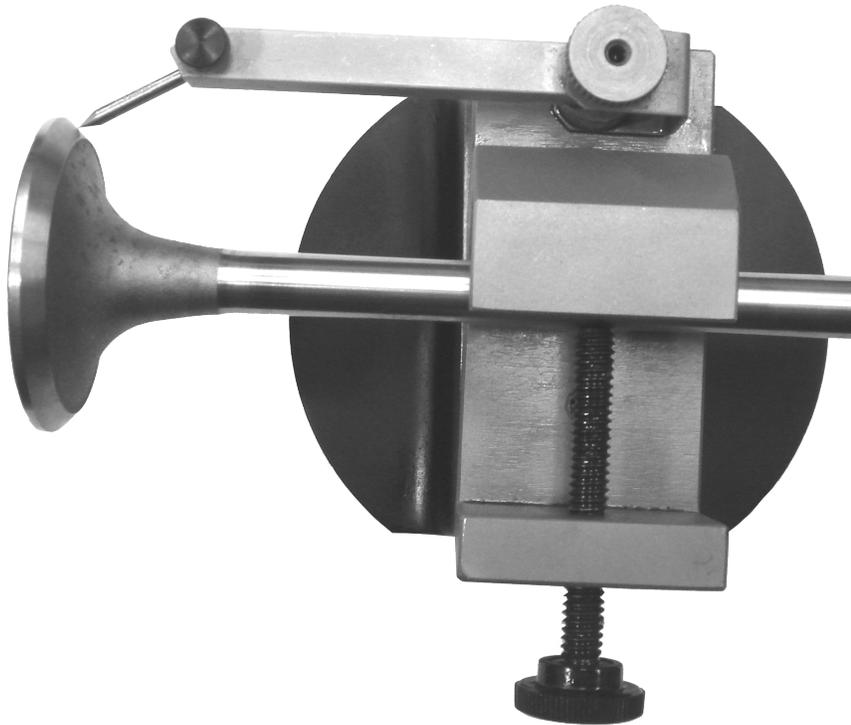
Adaptor for Morse #2 to Rottler ISO 40 Spindle Taper (2" Extended Length)



Micrometers Setting Fixtures and Measurement Tools

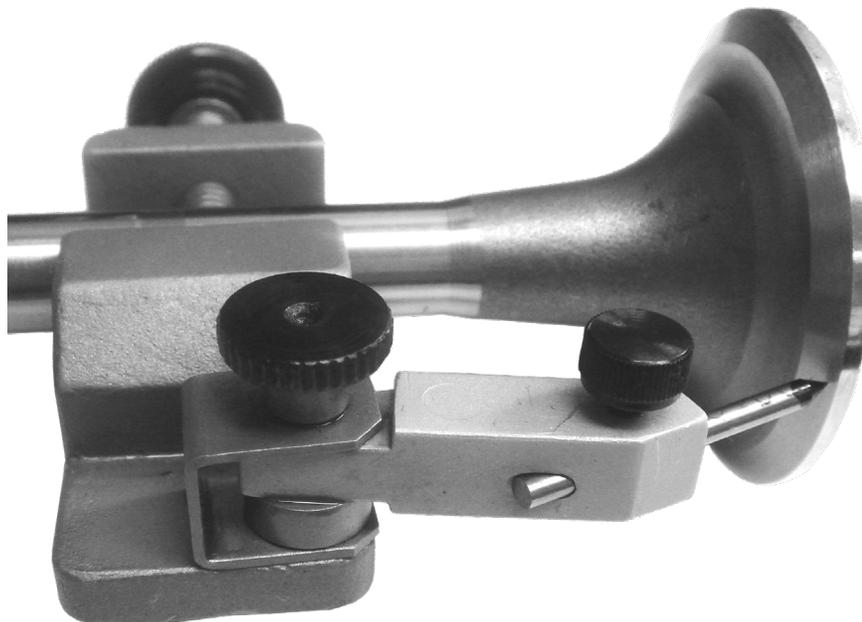
DSP20

Table mount tool setting device with interchangeable point for 20.00Mm shank pilots



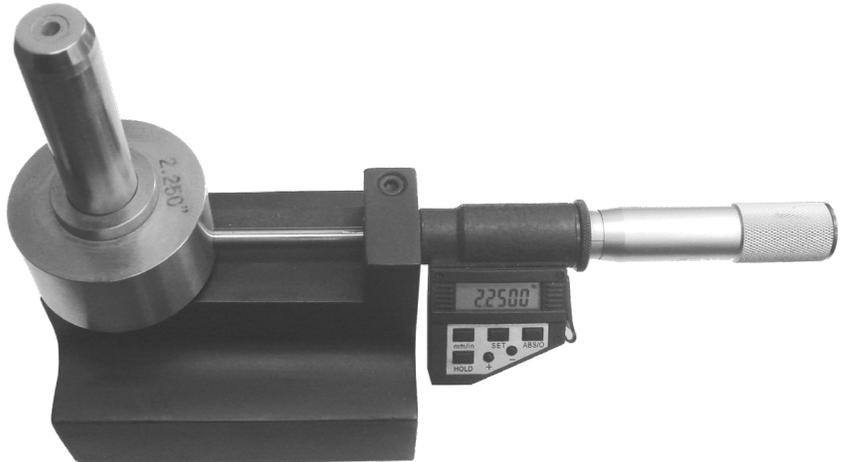
DSP

Tool setting Device with Interchangeable Point



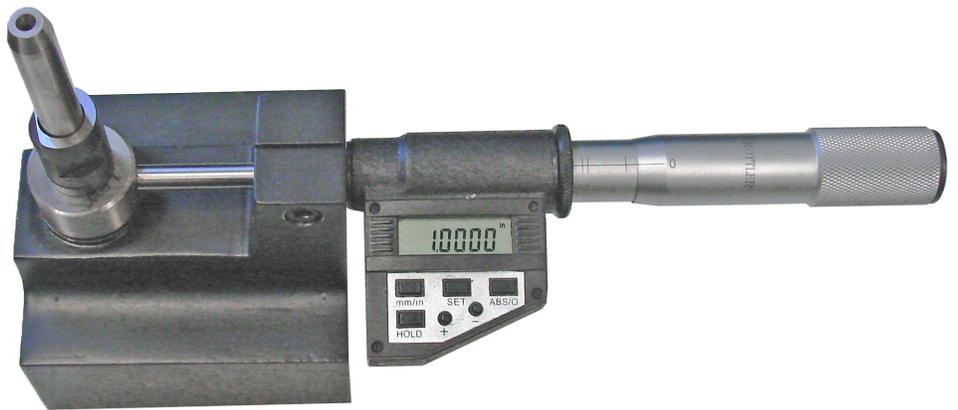
BM20

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



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)

See SG Cutting Insert Catalog for recommend cutting inserts and details

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 Solid Carbide Centralizing Pilots

See the SG Pilot Catalog on www.rottlermfg.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"

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"

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"

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

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 UNITPILOT 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

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