

ROTTLER

H87AXY CNC HONE OPTIONAL EQUIPMENT PARTS MANUAL





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@rottermfg.com, for customers outside of the U.S. use 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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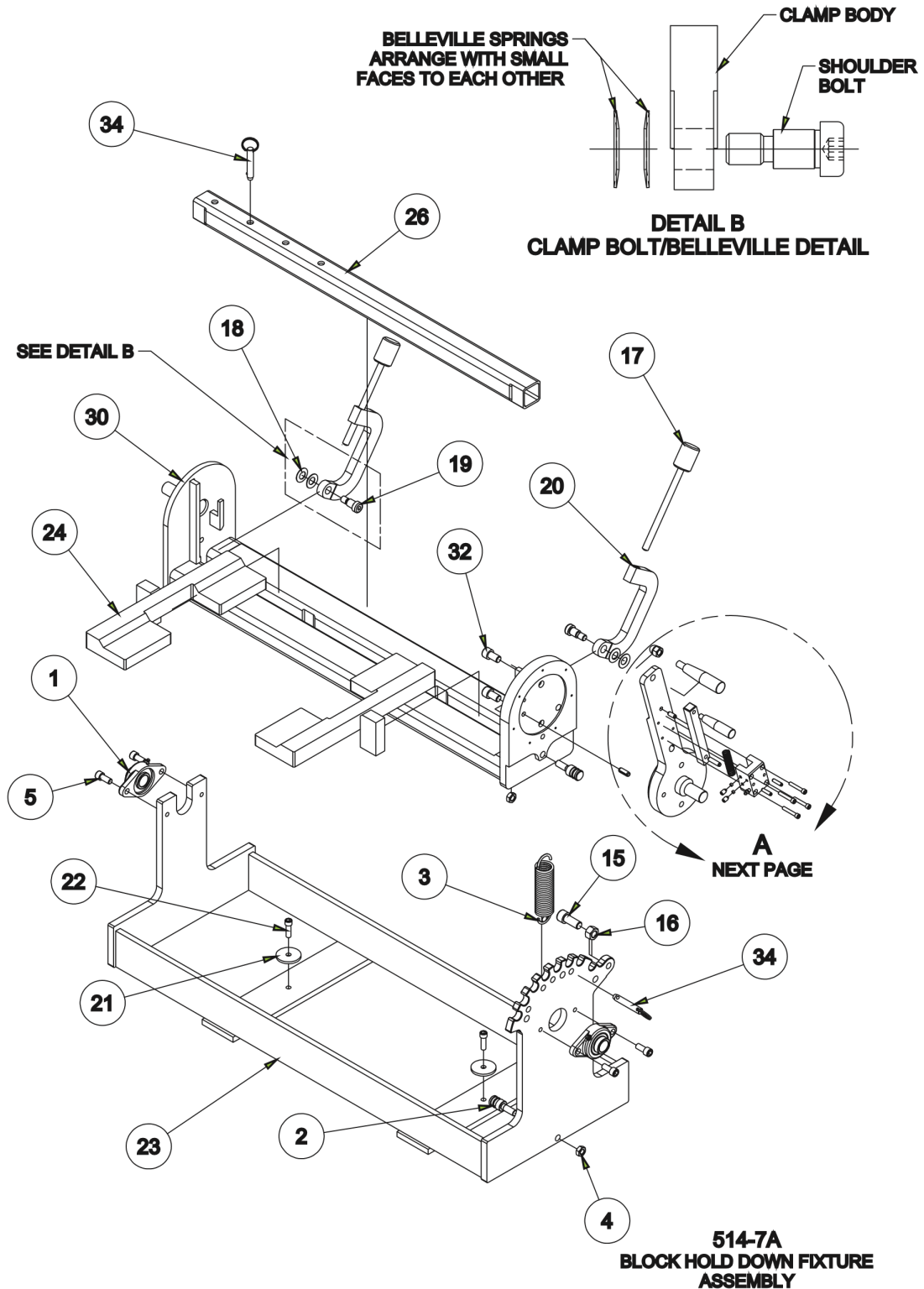


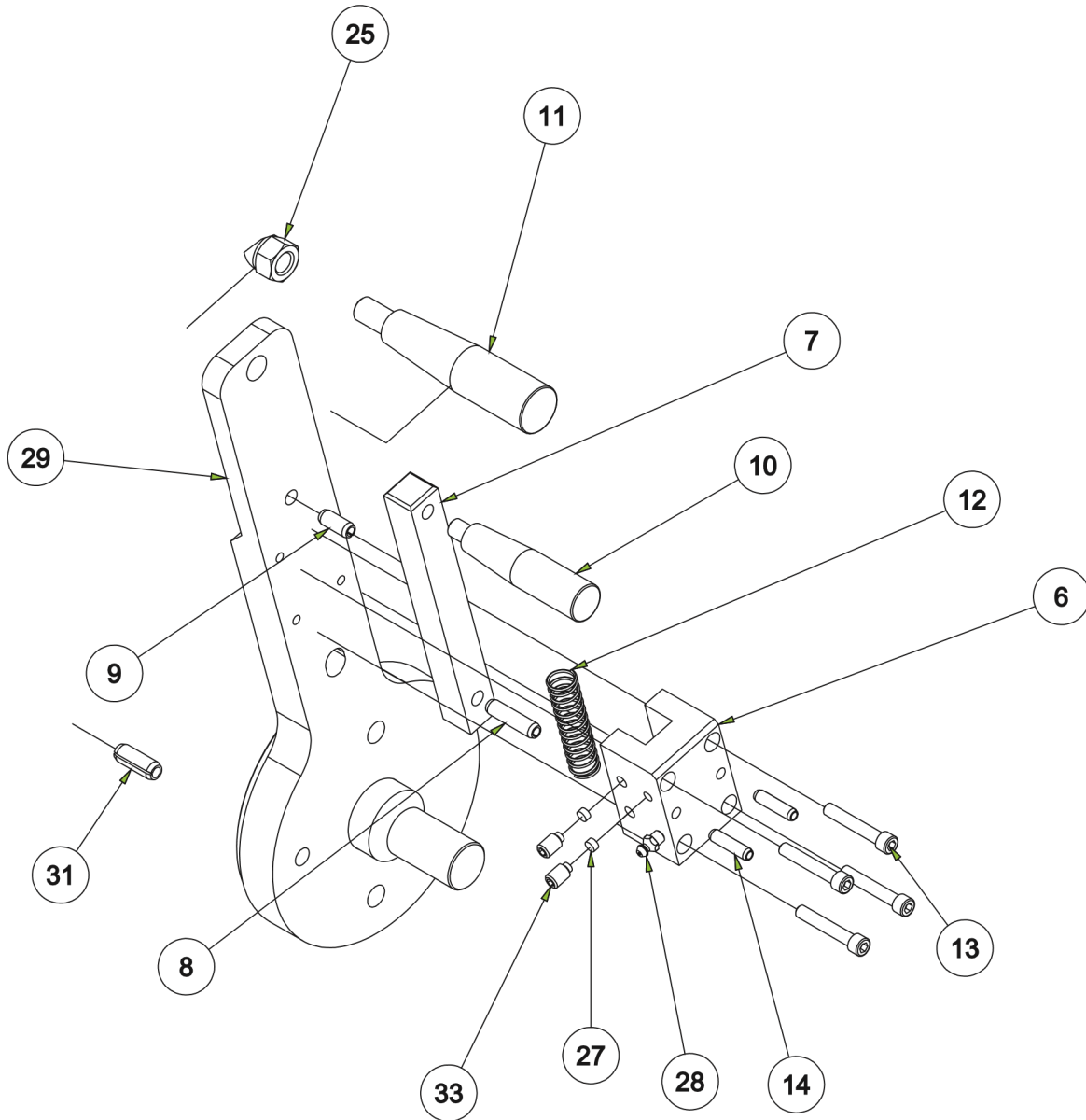
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Fixturing

Block Holding Fixtures

514-7A Manual Indexable Roll-over Fixture



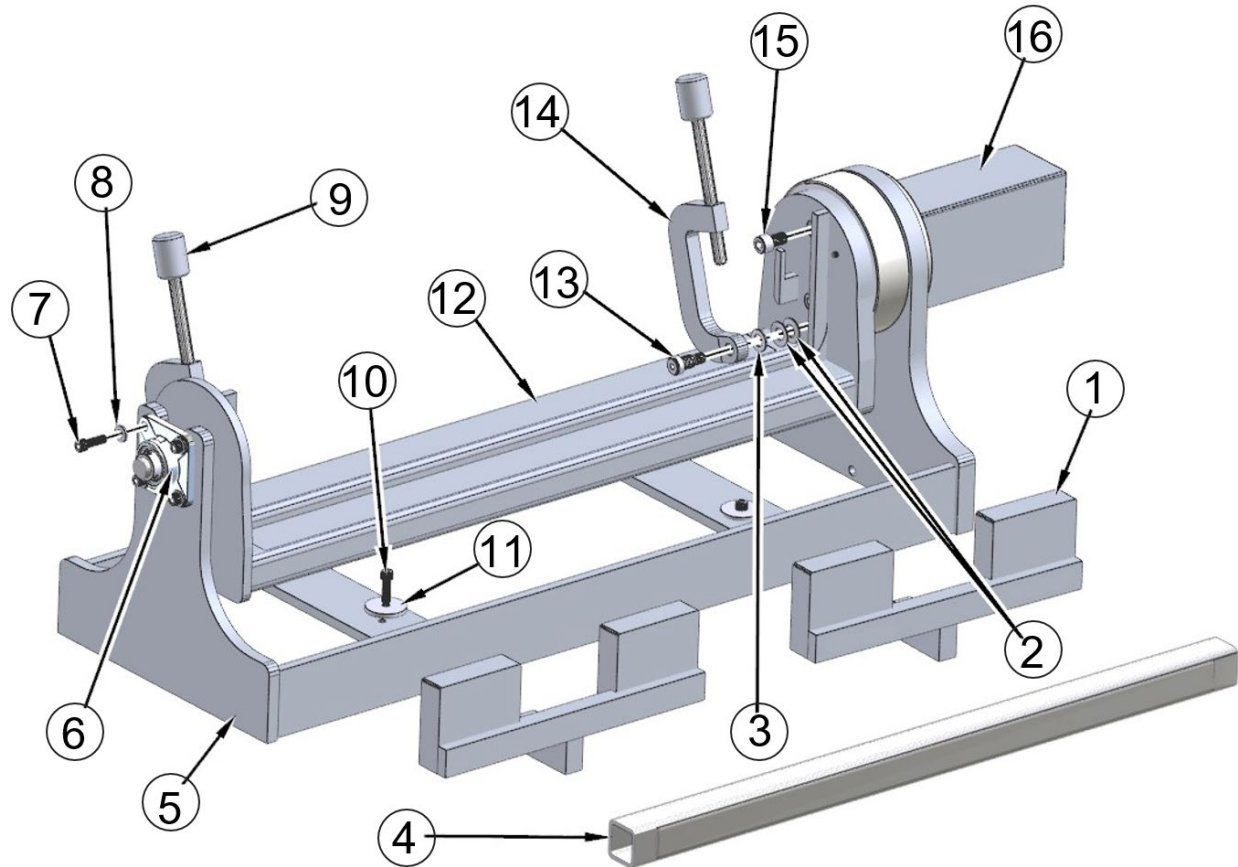


DETAIL A

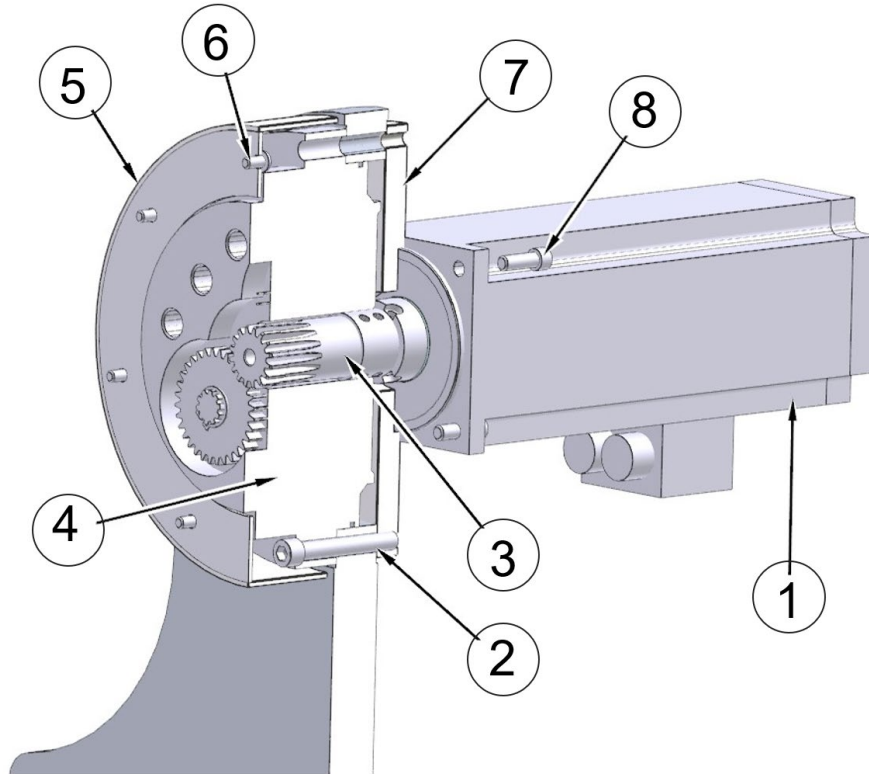


ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	514-7-13	BLOCK, FLANGE, BLOCK HOLDDOWN FIXTURE
2	2	514-3-72A	PIN, SPRING RETAINER, BLOCK HOLD DOWN FIXTURE
3	1	514-3-34A	SPRING, EXTENSION – BLOCK HOLD DOWN FIXTURE
4	2	MF-165	HEX NUT, ½-13
5	4	MF-39	S.H.C.S. 7/16-14 X 1”
6	1	514-3-56A	INDEX PIN SUPPORT – BLOCK HOLD DOWN FIXTURE
7	1	514-7-9B	INDEX PIN – BLOCK HOLD DOWN FIXTURE
8	1	MF-227A	ROLL PIN, 5/16” X 1 ¼”
9	1	MF-227B	ROLL PIN, 5/16” X ¾”
10	1	514-3-58A	HANDLE, INDEX – BLOCK HOLD DOWN FIXTURE
11	1	514-3-59B	HANDLE, PIVOT ARM – BLOCK HOLD DOWN FIXTURE & V6/V8 FIXTURE
12	1	514-3-70	SPRING, HANDLE RETURN
13	4	MF-17	S.H.C.S. ¼-20 X 1 ½”
14	2	MF-226	ROLL PIN, ¼” X 1”
15	1	MF-46A	S.H.C.S. ⅝-11 X 1 ½”
16	1	MF-166	HEX NUT, ⅝-11
17	2	7223	CLAMP ASSEMBLY – MANUAL V6/V8 COMB. FIXTURE
18	4	514-7-21	BELLVILLE SPRING
19	2	514-7-22A	SOCKET SHOULDER SCREW, ⅝” X ¾”
20	2	514-7-10A	CLAMP ARM (MACHINING), BLOCK HOLD DOWN FIXTURE
21	2	514-7-1C	WASHER, HOLDDOWN – BLOCK HOLDDOWN FIXTURE
22	2	MF-32	S.H.C.S. ⅜-16 X 1 ¼”
23	1	514-7-1E	MAIN FRAME REDESIGN (MACHINING)
24	2	514-7-15	SUPPORT, BLOCK – BLOCK HOLD DOWN FIXTURE
25	1	514-3-59C	ACORN NUT, ½-13
26	1	514-7-14B	BAR, CLAMP – HOLD DOWN FIXTURE
27	2	514-3-56B	TERCITE PAD
28	1	MF-189	STRAIGHT GREASE FITTING
29	1	514-7-3D	MANUAL CRADLE HANDLE (MACHINING)
30	1	514-13-14C	H70 – FIXTURE CRADLE MACHINING
31	1	MF-229B	ROLL PIN, ⅜” X 1”
32	2	650-4-49	S.H.C.S. M14x2 X 25mm
33	2	7212C	SOCKET SET SCREW, HALF DOG, 5/16-18 X ½”
34	2	7210C	PIN, GUIDE – ROTTLER LEVELING TABLE

514-14-60 Automatic Programmable Roll-over Fixture



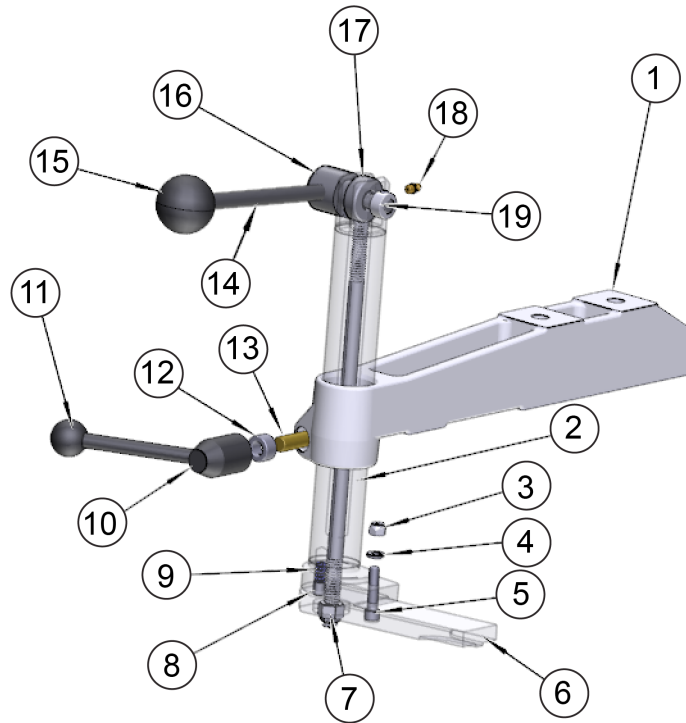
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	514-7-15	SUPPORT, BLOCK
2	4	514-7-21	WASHER, BELLEVILLE
3	2	514-7-20	WASHER, THRUST
4	1	514-7-14B	BAR, CLAMP
5	1	514-13-14A	BASE
6	1	514-13-14L	BEARING, END
7	4	MF-32	S.H.C.S. $\frac{3}{8}$ -16 X 1 $\frac{1}{4}$ "
8	4	MF-179A	FLAT WASHER $\frac{3}{8}$ "
9	2	7223	KNOB ASSY
10	4	MF-32	S.H.C.S. $\frac{3}{8}$ -16 X 1 $\frac{1}{4}$ "
11	4	514-7-1C	WASHER, HOLD DOWN
12	1	514-7-14C	LOCATOR BAR, SMALL
13	2	MF-155	SOCKET SHOULDER SCREW $\frac{3}{8}$ X $\frac{3}{4}$ "
14	2	514-7-10A	ARM, CLAMP
15	1	-	S.H.C.S. M14x2 X 25mm
16	1	514-13-14M	COVER, MOTOR



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	650-3-93B	SERVO MOTOR W/ BRAKE
2	8	MF-27C	S.H.C.S. 5/16-18 X 2 1/4"
3	1	5506D	INPUT SHAFT
4	1	5506C	GEARBOX ASSEMBLY
5	1	514-13-14K	COVER, GEAR BOX
6	8	MF-88	S.H.C.S. #10-24 X 3/8"
7	1	514-13-14J	ADAPTOR, MOTOR GEAR BOX
8	4	MF-14	S.H.C.S. 1/4-20 X 3/4"

502-1-30H Clamp Arm Assembly

Sold as a pair



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	502-1-22G 502-1-22H	CLAMP ARM – LEFT CLAMP ARM – RIGHT
2	1	502-1-31C	LEG, CLAMP – 14 1/2" LONG
3	1	MF-187	NYLOCK NUT, 5/16-18
4	1	MF-184	LOCK WASHER, 5/16"
5	1	MF-25	S.H.C.S. 5/16-18 X 1 1/2"
6	1	502-1-24G	SHOE, CLAMP – HEAVY DUTY
7	1	502-1-25B	LOCKNUT, EYE BOLT, 1/2-13
8	1	MF-211	DOWEL PIN, 3/8 X 1/2"
9	1	500-33	SPRING, CLAMP LEG
10	1	514-2-39C	HANDLE, ADJUSTABLE CLAMP, STOP
11	1	514-2-39E	HANDLE, ADJUSTABLE CLAMP
12	1	7209J	COLLAR, 1/2" SHAFT
13	1	514-4-5B	STUD – CLAMP HANDLE
14	1	502-1-27	ARM, HANDLE – BLOCK CLAMP
15	1	502-1-28	KNOB, PLASTIC BALL – BLOCK CLAMP
16	1	502-1-29L 502-1-29R	CAM BODY, LEFT HAND CAM BODY, RIGHT HAND
17	1	502-1-25A	EYE BOLT ASSEMBLY
18	1	MF-189	STRAIGHT LUBE GREASE FITTING, 1/4-28
19	1	502-1-29A	COLLAR (15/32 ID), CLAMP LEG

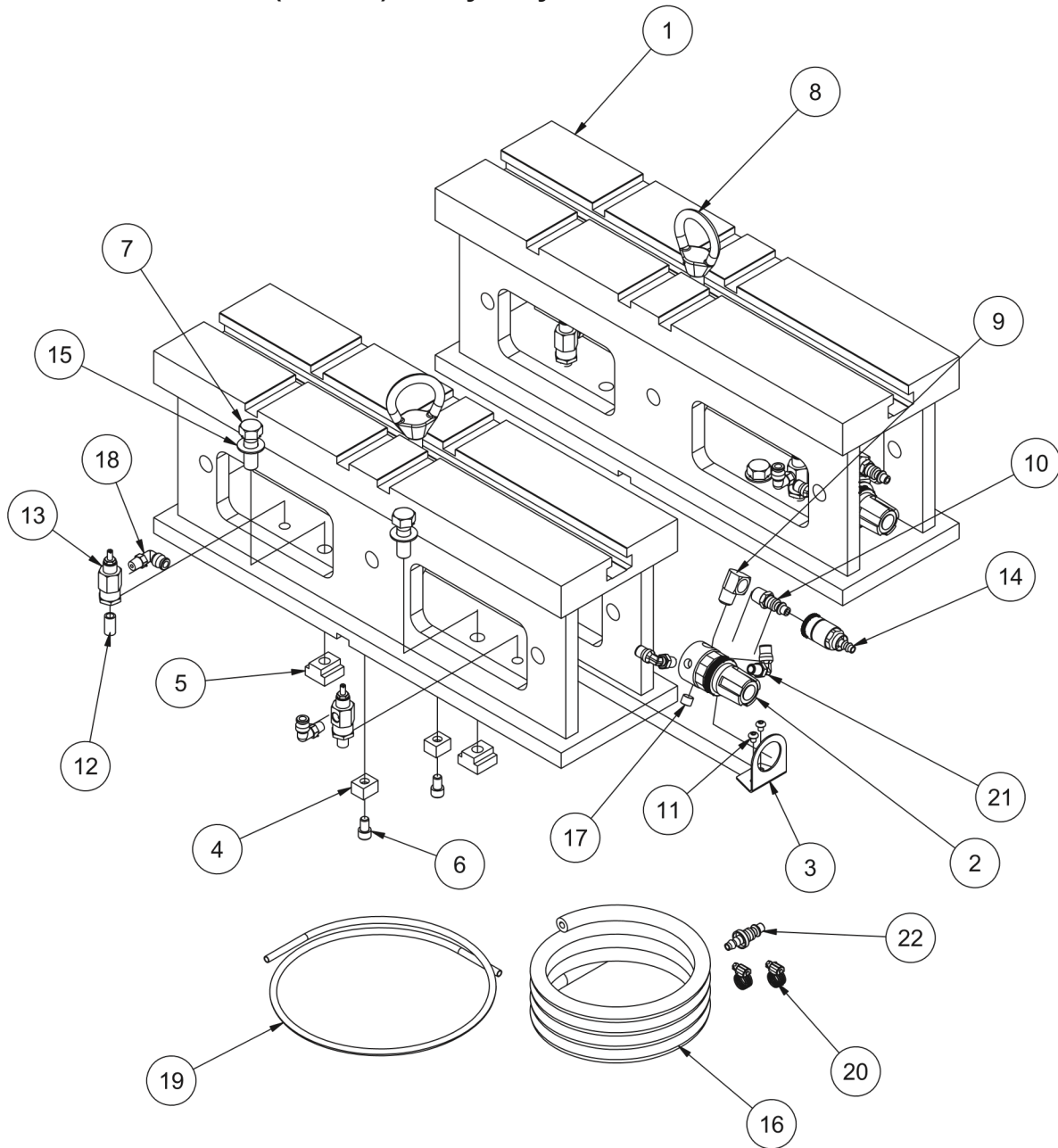
514-7-14E Small Diameter, 2" (508mm), Main Line Bar



11115 2" X 3" (50mm X 75mm) Parallels



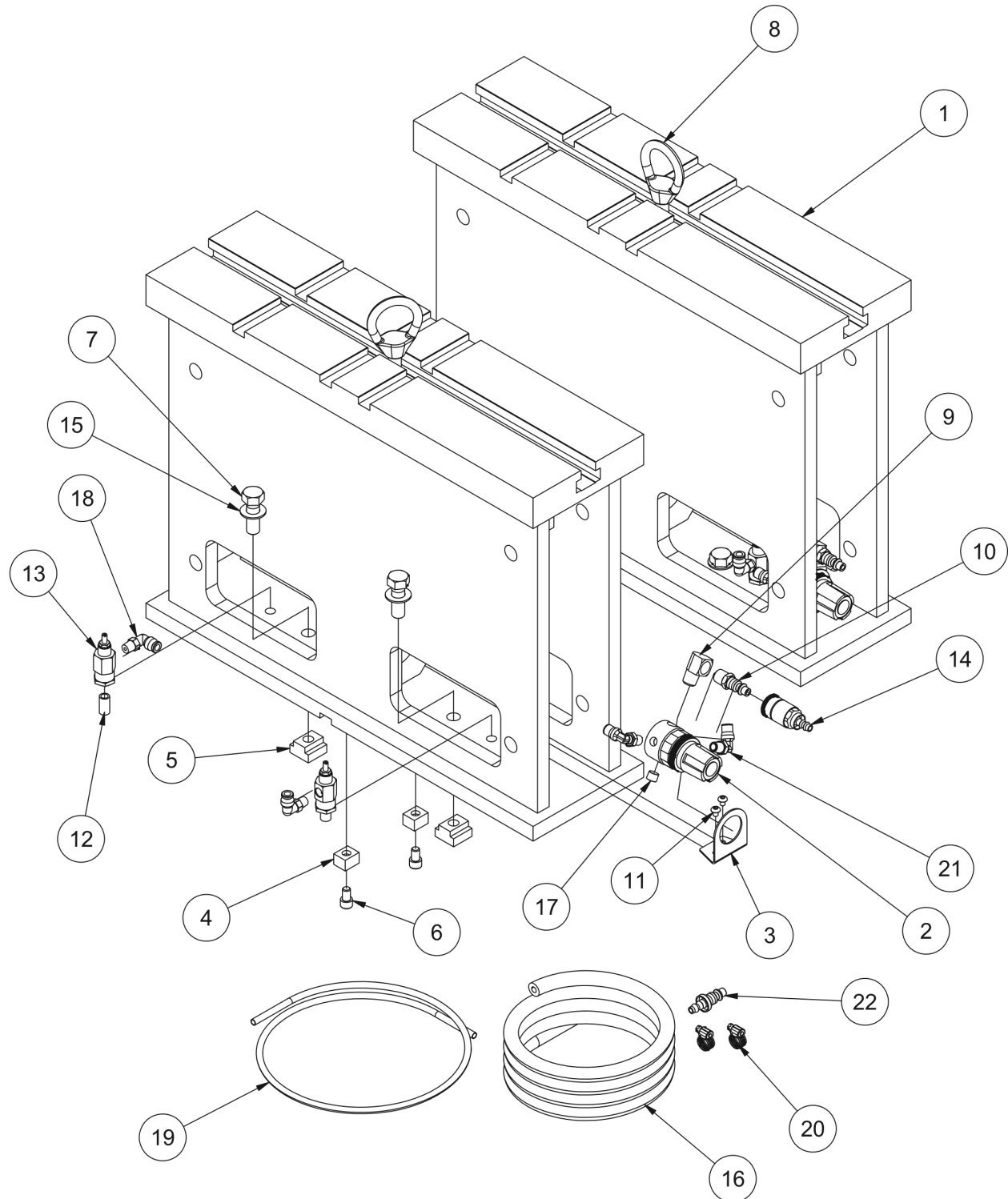
11112 Universal 8" (203mm) Heavy Duty T-Slot Parallels Parts





ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	11112A	SUPPORT PARALLEL, 8" (MACHINING) – F70
2	2	502-27-17	REGULATOR, 0-60 PSI
3	2	502-27-17A	REGULATOR BRACKET
4	4	650-3-9	KEY
5	4	650-3-10	T-NUT, TN-5
6	4	MF-21A	S.H.C.S. 5/16-18 X 1/2"
7	4	MF-137A	H.H.C.S. 1/2-13 X 1 1/2"
8	2	502-3-13	LIFT EYE
9	2	502-11-17S	STREET ELL, 1/4"
10	2	502-11-16X	CONNECTOR, MALE 1/4 NPT, V6/V8 FIXTURE
11	4	MF-87	B.H.C.S. #10-24 X 1/4"
12	4	502-11-17J	NIPPLE, CLOSE, 1/8" NPT
13	4	502-11-35A	FLOW CONTROLER
14	1	502-11-16W	QUICK CONNECT AIR FITTING, FEMALE
15	4	MF-180	FLAT WASHER, 1/2"
16	15 FT	502-1-98	AIR HOSE, 1/4"
17	2	MF-234	HEX HEAD PLUG, 1/8" NPT
18	4	514-4-17E	ELBOW, 90 DEG MALE, 1/4" POLY X 1/8" NPT
19	4 FT	502-11-15	TUBING, BLACK POLYFLO, 1/4" OD
20	2	502-1-97	CLAMP, 1/4" I.D. HOSE
21	4	514-4-17V	FITTING, 90 DEG, 1/8" NPT X 1/4 POLY
22	1	502-11-16Y	CONNECTOR, MALE AIR, 1/4 NPT

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



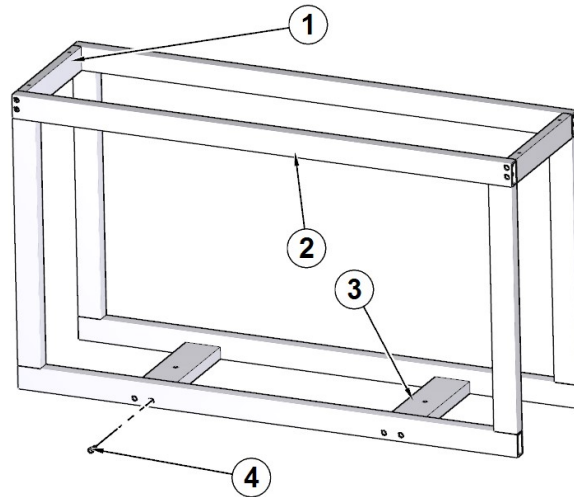
11114
16" SUPPORT PARALLEL ASSEMBLY
F70



ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	11114A	SUPPORT PARALLEL, 16" (MACHINING) – F70
2	2	502-27-17	REGULATOR, 0-60 PSI
3	2	502-27-17A	REGULATOR BRACKET
4	4	650-3-9	KEY
5	4	650-3-10	T-NUT, TN-5
6	4	MF-21A	S.H.C.S. 5/16-18 X 1/2"
7	4	MF-137A	H.H.C.S. 1/2-13 X 1 1/2"
8	2	502-3-13	LIFT EYE
9	2	502-11-17S	STREET ELL, 1/4"
10	2	502-11-16X	CONNECTOR, MALE 1/4 NPT, V6/V8 FIXTURE
11	4	MF-87	B.H.C.S. #10-24 X 1/4"
12	4	502-11-17J	NIPPLE, CLOSE, 1/8" NPT
13	4	502-11-35A	FLOW CONTROLER
14	1	502-11-16W	QUICK CONNECT AIR FITTING, FEMALE
15	4	MF-180	FLAT WASHER, 1/2"
16	15 FT	502-1-98	AIR HOSE, 1/4"
17	2	MF-234	HEX HEAD PLUG, 1/8" NPT
18	4	514-4-17E	ELBOW, 90 DEG MALE, 1/4" POLY X 1/8" NPT
19	4 FT	502-11-15	TUBING, BLACK POLYFLO, 1/4" OD
20	2	502-1-97	CLAMP, 1/4" I.D. HOSE
21	4	514-4-17V	FITTING, 90 DEG, 1/8" NPT X 1/4 POLY
22	1	502-11-16Y	CONNECTOR, MALE AIR, 1/4 NPT

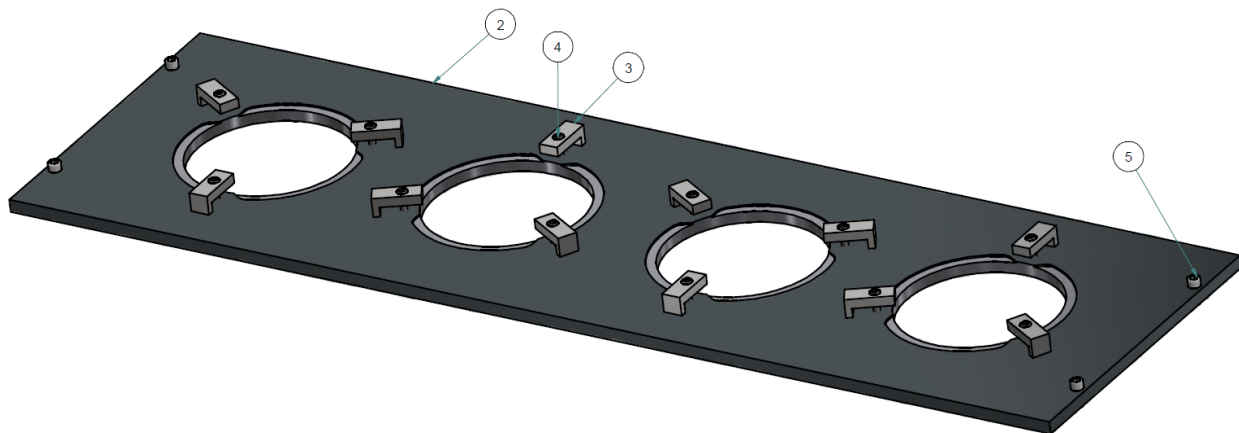
Cylinder Sleeve Fixtures

514-11-5 Cylinder Liner Honing Fixture



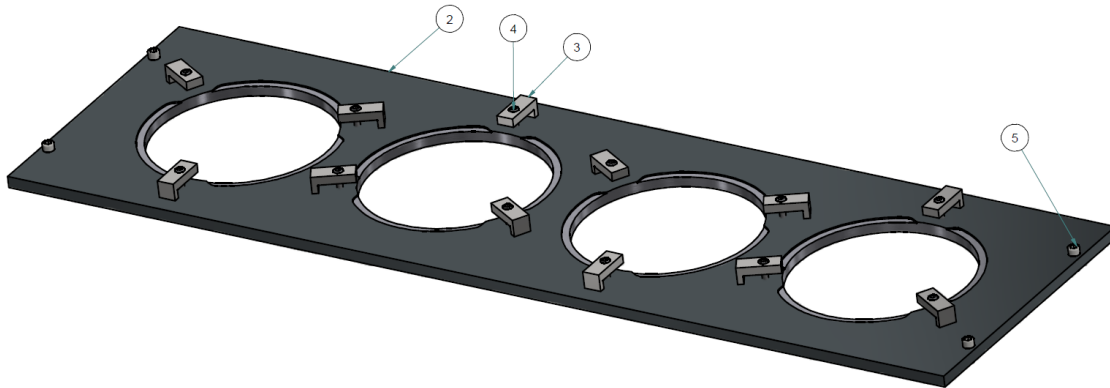
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	514-11-1D	UPPER CROSS BAR
2	2	514-11-5B	SIDE, SLEEVE FIXTURE
3	2	514-11-1E	LOWER CROSS BAR
4	8	MF-21	S.H.C.S. 5/16-18 X 5/8"

514-11-6 Fixture Plate, CAT 3400 Cylinder Sleeve



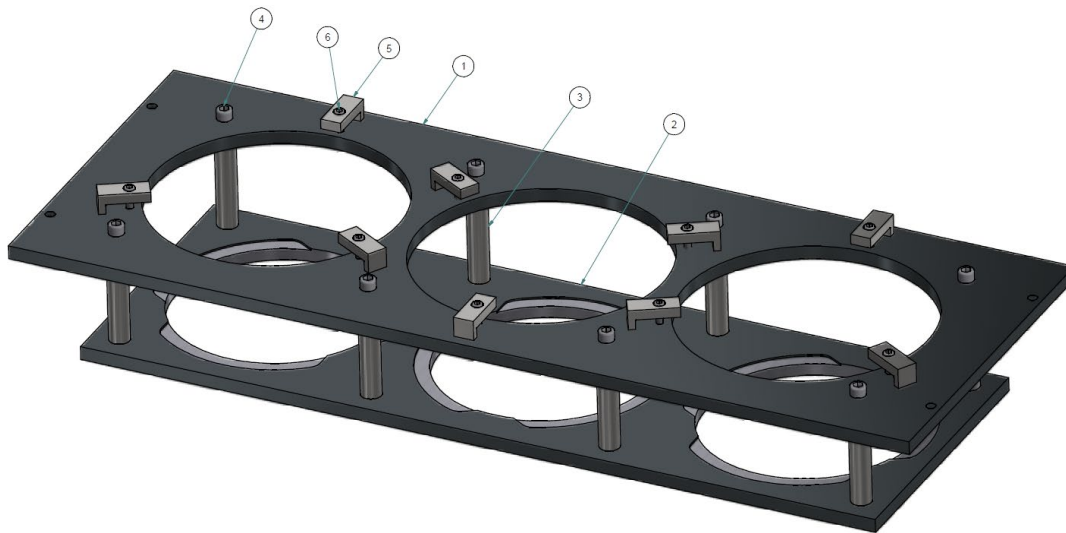
ITEM	QTY	PART NUMBER	DESCRIPTION
2	1	514-11-6B	PLATE, CAT 3400 SLEEVE FIXTURE
3	12	514-11-2C	CLAMP, FIXTURE PLATE
4	12	MF-15	S.H.C.S. 1/4-20 X 1"
5	4	MF-22	S.H.C.S. 5/16-18 X 3/4"

514-11-7 Fixture Plate, CAT 3500 Cylinder Sleeve



ITEM	QTY	PART NUMBER	DESCRIPTION
2	1	514-11-7A	3400 SLEEVE TOP PLATE FIXTURE
3	12	514-11-2C	CLAMP, FIXTURE PLATE
4	12	MF-15	S.H.C.S. 1/4-20 X 1"
5	4	MF-22	S.H.C.S. 5/16-18 X 3/4"

514-11-4 Fixture Plate, CAT C175 Cylinder Sleeve

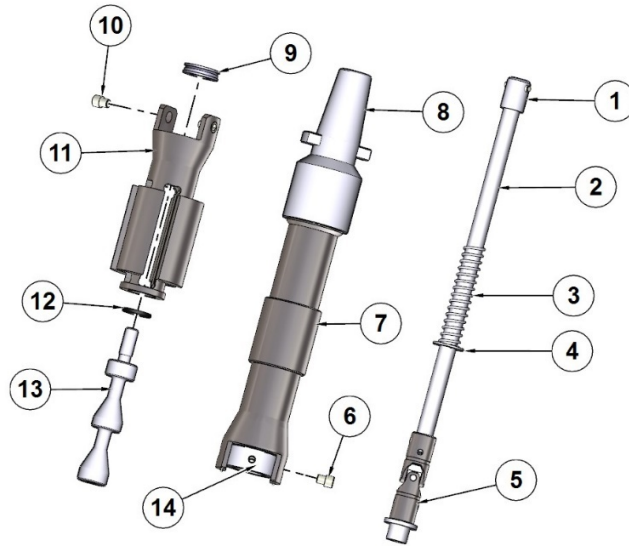


ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-11-4A	FIXTURE PLATE TOP – CAT C175 SLEEVE
2	1	514-11-4C	UPPER PLATE, CAT C175 FIXTURE
3	8	514-11-4E	SPACER, CAT C175 SLEEVE FIXTURE
4	8	MF-38	S.H.C.S. 3/8-16 X 5"
5	9	514-11-2C	CLAMP, FIXTURE PLATE
6	9	MF-15	S.H.C.S. 1/4-20 X 1"

Hone Heads

514-9J Medium Precision 4-Stone Hone Head

18.5" (470mm) Overall Length



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-6-44	COUPLING, DRIVEN
2	1	514-10-20B	SHAFT, ADJUSTING
3	1	514-5-72A	SPRING, COMPRESSION
4	1	100-19	WASHER, THRUST
5	1	514-10-5A	JOINT, UNIVERSAL ASSY
6	2	514-10-10	SCREW, PIVOT
7	1	514-10-20A	YOKE
8	1	514-13-49	ADAPTER, KWIK SWITCH
9	1	514-7-82F	BEARING, THRUST
10	2	514-10-10	SCREW, PIVOT
11	1	514-10-1A	BODY
12	1	7209H	BUMPER
13	1	514-10-2A	CONE ROD
14	1	514-10-6	BLOCK, PIVOT

514-9M Dual Stage, 10-Stone Hone Head

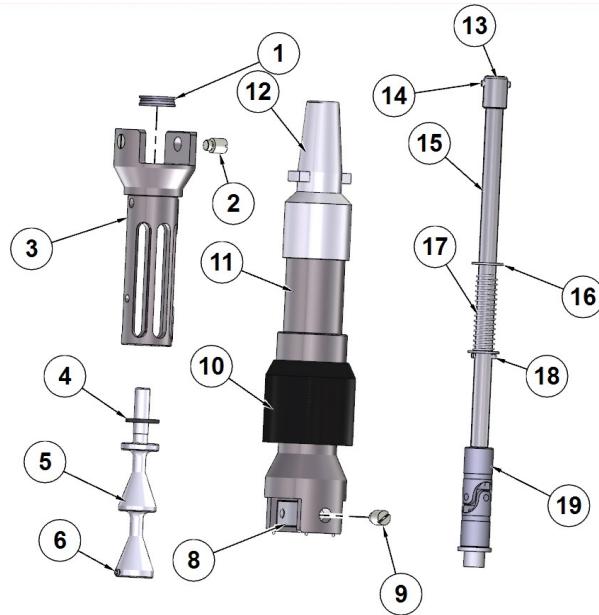


514-9N Single Stage, 12-Stone Hone Head



514-9Q Large Precision 6-Stone Hone Head

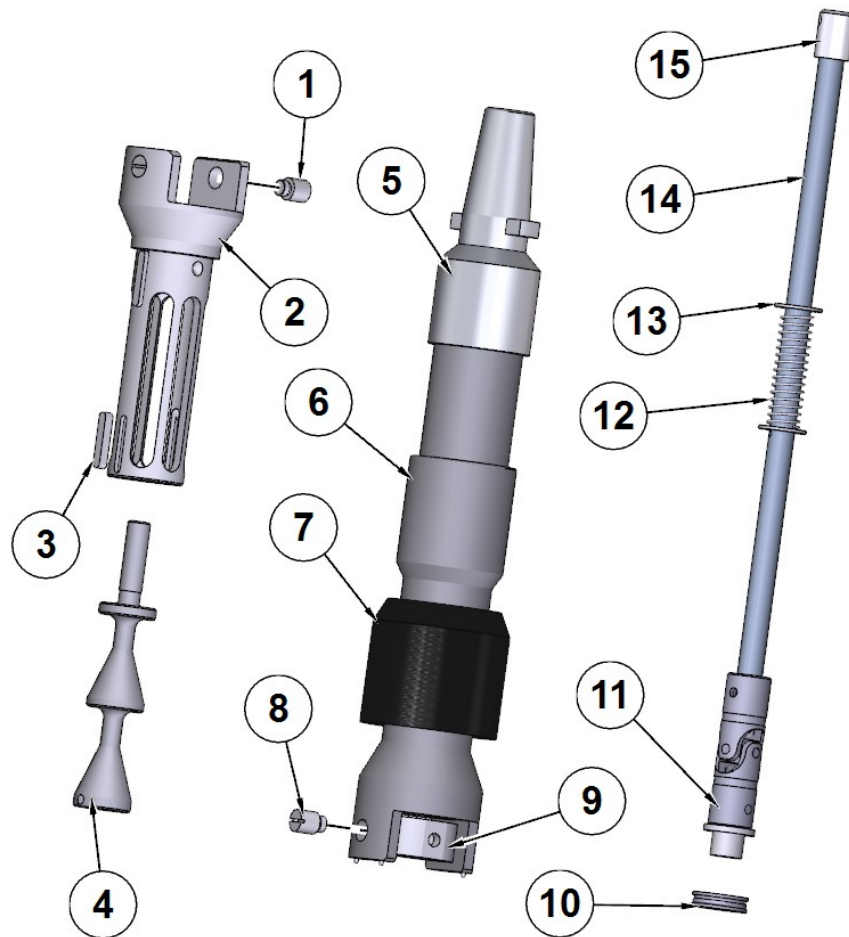
19.5" (496mm) Overall Length



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-7-82F	BEARING, THRUST
2	2	514-5-66G	PIN, THREADED
3	1	514-9-10D	BODY, LARGE HEAVY DUTY HONE HEAD
4	1	514-7-82G	RING, SQUARE CROSS SECTION
5	1	514-9-7A	CONE ROD
6	1	MF-223C	ROLL PIN, 3/16 X 5/8"
8	1	514-7-81S	PIVOT BLOCK
9	2	514-5-66G	PIN, THREADAD
10	1	514-9-10G	COVER, HONE HEAD U-JOINT
11	1	514-7-81T	YOKE, DRIVE SHAFT
12	1	514-13-49	ADAPTER, KWIK SWITCH
13	1	514-6-44	COUPLING, DRIVEN
14	1	MF-198A	DOWEL PIN, 3/16 X 7/8"
15	1	514-7-81U	SHAFT, ADJUSTING HONE HEAD
16	2	100-19	WASHER, THRUST
17	1	514-5-72A	SPRING, COMPRESSION
18	1	MF-219	ROLL PIN, 1/8 X 3/4"
19	1	514-9-8A	JOINT, UNIVERSAL ASSY

514-9S Large Precision 6-Stone Hone Head

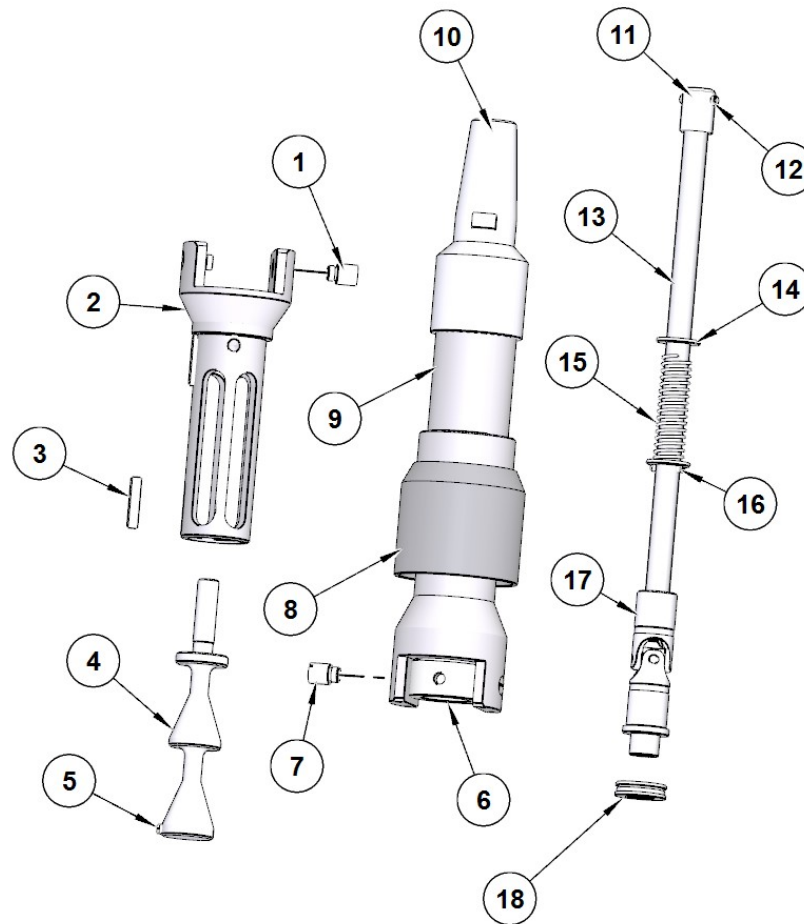
21.5" (547mm) Overall Length



ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	514-5-66G	PIN, THREADED
2	1	514-9-10D	BODY, LARGE HEAVY DUTY HONE HEAD
3	1	514-7-83C	KEY, SLEEVE
4	1	514-9-7A	CONE ROD
5	1	514-13-49	ADAPTER, KWIK SWITCH
6	1	514-7-81R	YOKE, DRIVE SHAFT
7	1	514-9-10G	COVER, HONE HEAD U-JOINT
8	2	514-5-66G	PIN, THREADED
9	1	514-7-81S	PIVOT BLOCK
10	1	514-7-82F	BEARING, THRUST
11	1	514-9-8A	JOINT, UNIVERSAL ASSY
12	1	514-5-72A	SPRING, COMPRESSION
13	2	100-19	WASHER, THRUST
14	1	514-7-81B	SHAFT, ADJUSTING HONE HEAD
15	1	514-6-44	COUPLING, DRIVEN

514-9P Large Precision 4-Stone Hone Head

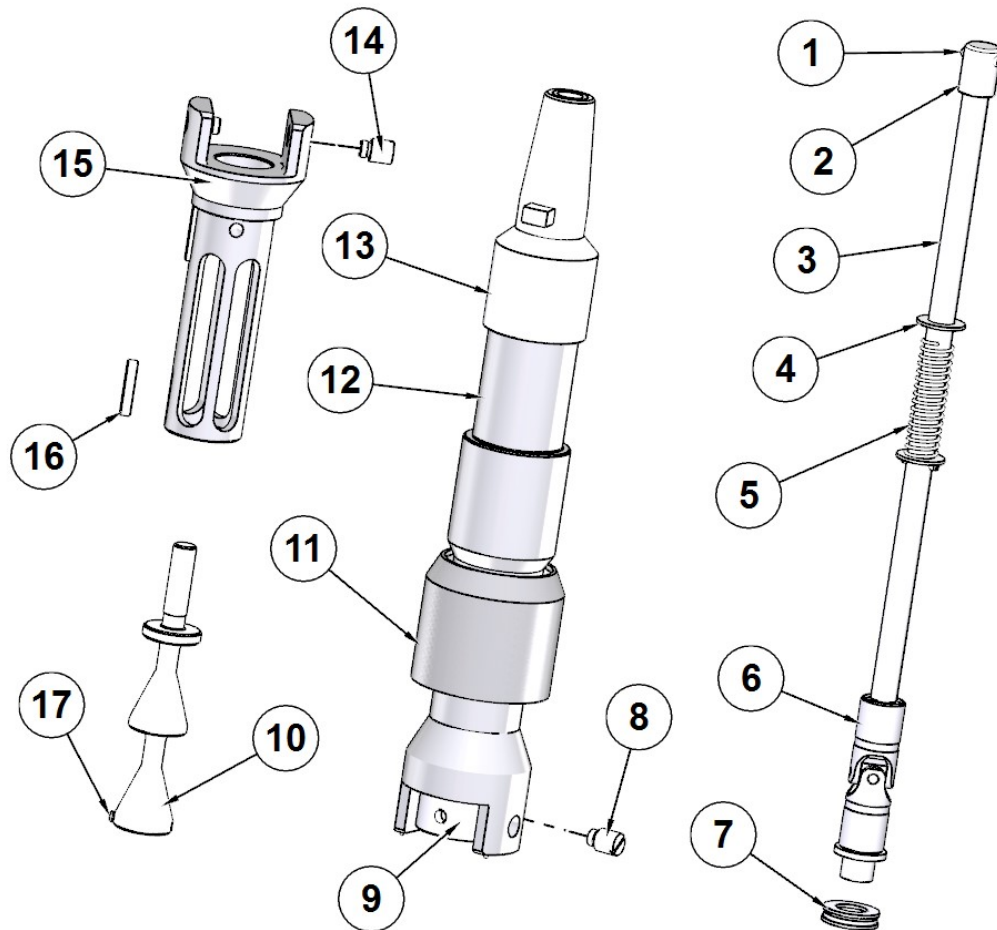
19.5" (496mm) Overall Length



ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	514-5-66G	PIN, THREADED
2	1	514-9-10E	BODY, LARGE HEAVY DUTY HONE HEAD
3	1	514-7-83C	KEY, SLEEVE
4	1	514-9-7A	CONE ROD
5	1	MF-223C	ROLL PIN 3/16 X 5/8"
6	2	514-7-81S	PIVOT BLOCK
7	1	514-7-66G	PIN, THREADED
8	1	514-9-10G	COVER, HONE HEAD U-JOINT
9	1	514-7-81T	YOKE, DRIVE SHAFT
10	1	514-13-49	ADAPTER, KWIK SWITCH
11	1	514-6-44	COUPLING, DRIVEN
12	1	MF-198A	DOWEL PIN 3/16 X 7/8"
13	1	514-7-81U	SHAFT, ADJUSTING HONE HEAD
14	2	100-19	WASHER, THRUST
15	1	514-5-72A	SPRING, COMPRESSION
16	1	MF-219	ROLL PIN 1/8 X 3/4"
17	1	514-9-8A	JOINT, UNIVERSAL ASSY
18	1	514-7-82F	BEARING, THRUST

514-9R Large Precision 4-Stone Hone Head

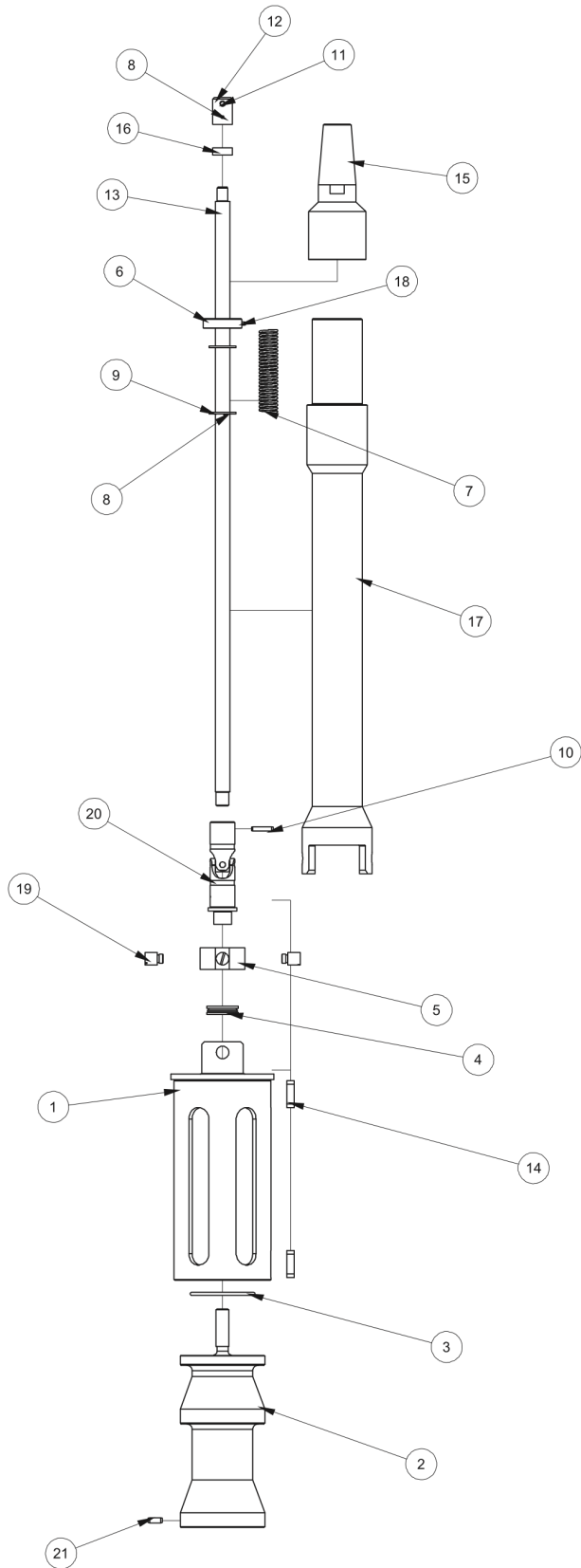
21.5" (547mm) Overall Length



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	MF-198A	DOWEL PIN, 3/16 X 7/8"
2	1	514-6-44	COUPLING, DRIVEN
3	1	514-7-81B	SHAFT, ADJUSTING HONE HEAD
4	2	100-19	WASHER, THRUST
5	1	514-5-72A	SPRING, COMPRESSION
6	1	514-9-8A	JOINT, UNIVERSAL ASSY
7	1	514-7-82F	BEARING, THRUST
8	2	514-5-66G	PIN, THREADED
9	1	514-7-81S	PIVOT BLOCK
10	1	514-9-7A	CONE ROD
11	1	514-9-10G	COVER, HONE HEAD U-JOINT
12	1	514-7-81R	YOKE, DRIVE SHAFT
13	1	514-13-49	ADAPTER, KWIK SWITCH
14	2	514-5-66G	PIN, THREADED
15	1	514-9-10E	BODY, LARGE HEAVY DUTY HONE HEAD
16	1	514-7-83C	KEY, SLEEVE
17	1	MF-223C	ROLL PIN 3/16 X 5/8"



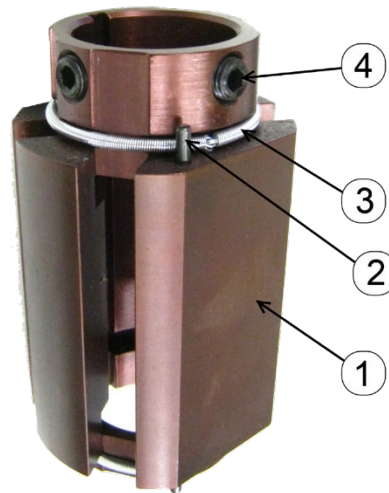
514-9F Extra Large Precision Heavy Duty 4-Stone Hone Head





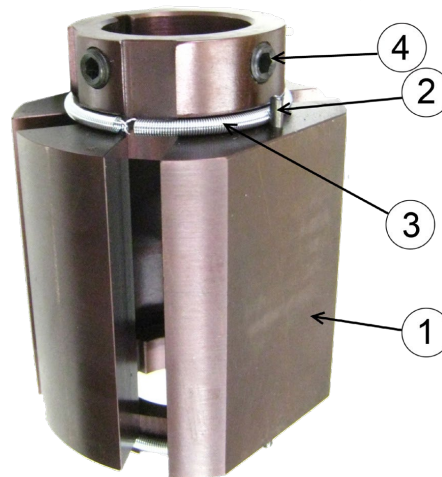
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-9-10F	BODY, EXTRA LARGE HONE HEAD
2	1	514-9-7C	CONE ROD, EXTRA LARGE HONE HEAD
3	1	514-8-9B	O-RING
4	1	514-7-82F	THRUST WASHER
5	1	514-7-81S	PIVOT BLOCK THREADED, HONE HEAD
6	1	514-7-82L	SPRING RETAINER – DRIVE TUBE
7	1	514-5-72	SPRING, COMPRESSION
8	2	MF-218	ROLL PIN 1/8 X 5/8"
9	2	100-19	HARDENED WASHER
10	1	MF-222A	ROLL PIN 5/32 X 3/4"
11	1	MF-198A	DOWEL PIN 3/16 X 7/8"
12	1	514-6-44	DRIVEN COUPLING – HONE #2
13	1	514-7-81N	ADJUSTING SHAFT – 3600 HONE HEAD
14	2	6062	KEY, SPINDLE DRIVE S/SF
15	1	514-13-49	H75 KWIK SWITCH TAPER
16	1	514-7-80T	OILITE BUSHING
17	1	514-7-81H	H75 DRIVE SHAFT – LARGE HONE HEAD
18	1	MF-217	ROLL PIN 1/8 X 1/2"
19	4	514-5-66G	LARGE HONE HEAD THREADED PIN
20	1	514-9-8A	UNIVERSAL JOINT ASSEMBLY – HEAVY DUTY HONE HEAD
21	1	MF-223A	ROLL PIN 3/16 X 1/2"

514-9-4A Sleeve Assembly, 4-Stone, 2.75-3.88" Dia.



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-9-3A	SLEEVE, 2.75-3.56" DIA
2	1	MF-217	ROLL PIN, 1/8 X 1/2"
3	2	514-7-83K	SPRING, GARTER
4	2	514-7-83D	SOCKET SET SCREW, CONE POINT

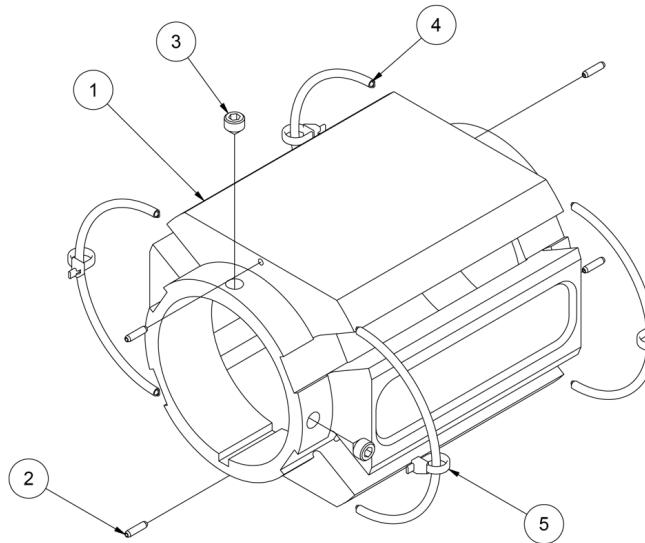
514-9-4B Sleeve Assembly, 4-Stone, 3.50-4.67" Dia.



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-9-3B	SLEEVE, 3.50-4.32" DIA
2	1	MF-217	ROLL PIN, 1/8 X 1/2"
3	2	514-7-83K	SPRING, GARTER
4	2	514-7-83D	SOCKET SET SCREW, CONE POINT

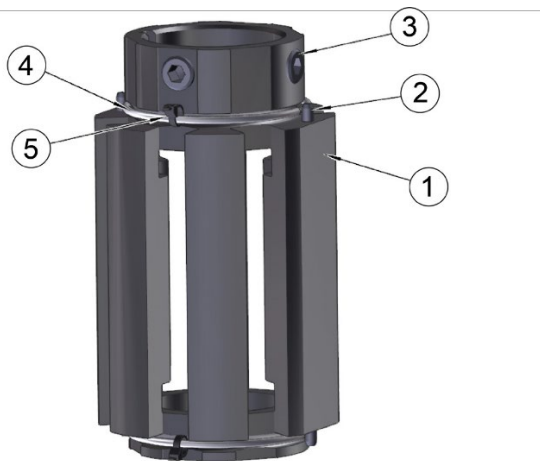


514-9-4D Sleeve Assembly, 4-Stone, 9.30-9.56" Dia.



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-9-3D	EXTRA LARGE H.D. HONE SLEEVE
2	1	MF-217	ROLL PIN, 1/8 X 1/2"
3	2	514-7-83D	SOCKET SET SCREW, CONE POINT
4	2	514-7-83K	SPRING, GARTER
5	4	6147D	TYRAP

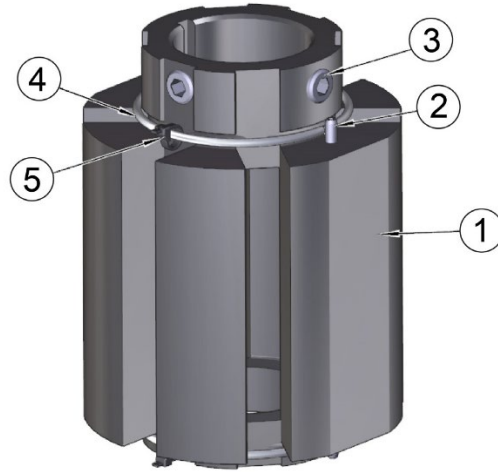
514-9-4E Sleeve Assembly, 6-Stone, 2.77-3.88" Dia.



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-9-3E	SLEEVE, 3.50-4.32" DIA
2	1	MF-217	ROLL PIN, 1/8 X 1/2"
3	2	514-7-83D	SOCKET SET SCREW, CONE POINT
4	2	514-7-83K	SPRING, GARTER
5	4	6147D	TYRAP

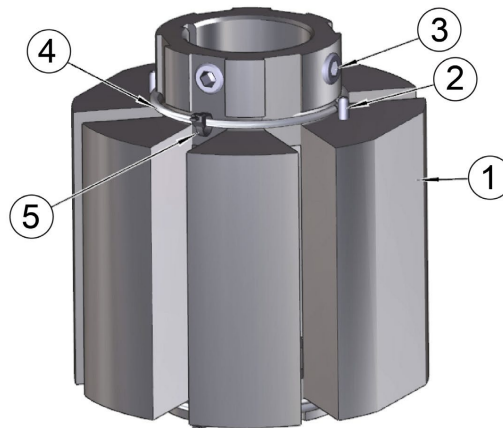


514-9-4F Sleeve Assembly, 6-Stone, 3.67-4.36" Dia.



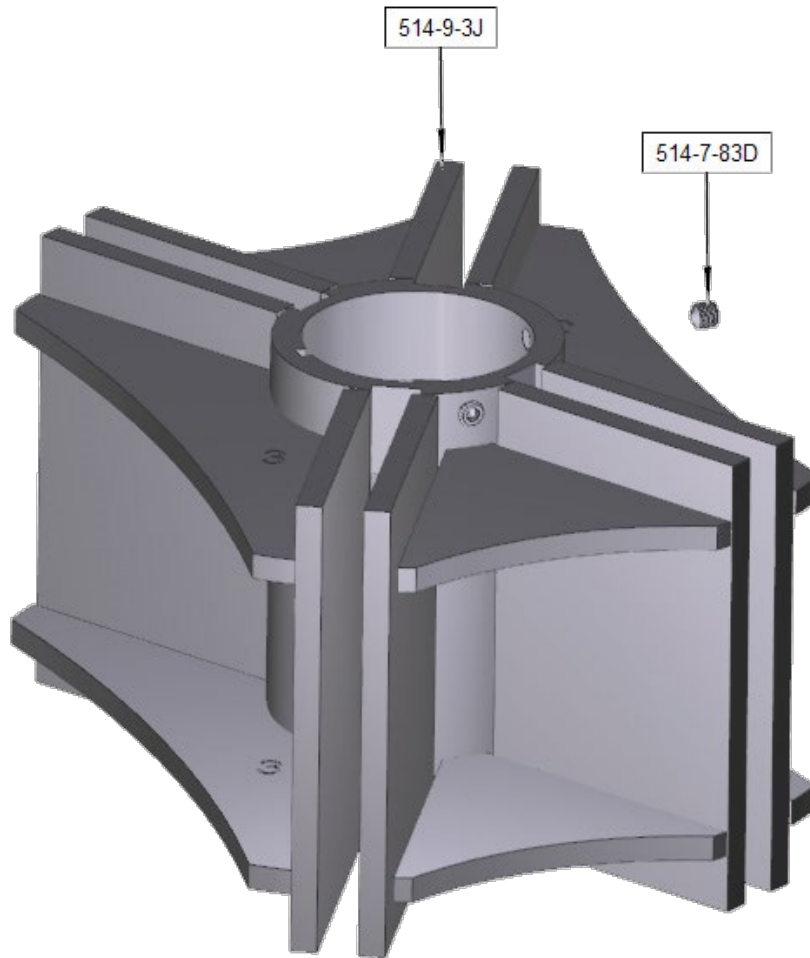
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-9-3F	SLEEVE, 3.50-4.32" DIA
2	1	MF-217	ROLL PIN, 1/8 X 1/2"
3	2	514-7-83D	SOCKET SET SCREW, CONE POINT
4	2	514-7-83K	SPRING, GARTER
5	4	6147D	TYRAP

514-9-4G Sleeve Assembly, 6-Stone, 4.42-7.38" Dia.

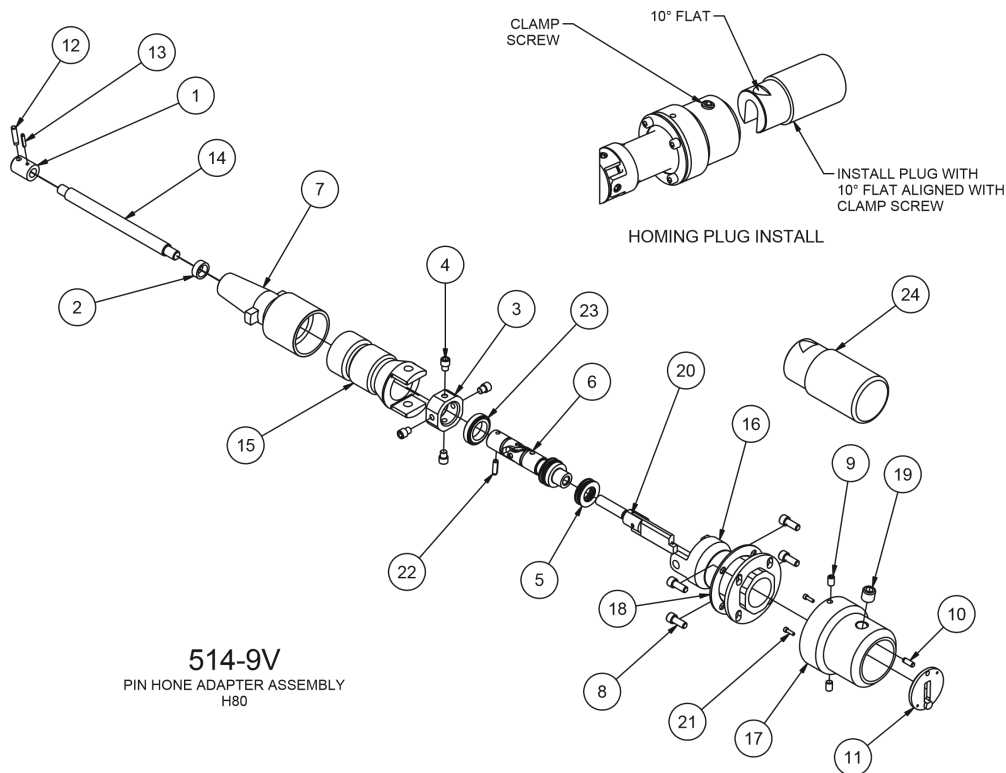


ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-9-3G	SLEEVE, 3.50-4.32" DIA
2	1	MF-217	ROLL PIN, 1/8 X 1/2"
3	2	514-7-83D	SOCKET SET SCREW, CONE POINT
4	2	514-7-83K	SPRING, GARTER
5	4	6147D	TYRAP

514-9-3J Sleeve, Wartsila, 4-Stone, 13.4" (340mm) Dia.



514-9V Pin Hone Adapter



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	514-6-44	DRIVEN COUPLING – HONE #2
2	1	514-7-80T	OILITE BUSHING
3	1	514-10-6	PIVOT BLOCK, UNIVERSAL, JUNIOR PREC. HONE HEAD
4	4	514-10-10	PIVOT SCREW
5	1	514-7-82F	THRUST WASHER
6	1	514-10-5B	U-JOINT ASSEMBLY – PIN HONE ADAPTER
7	1	514-13-49	KWIK SWITCH TAPER
8	4	MF-13	S.H.C.S. ¼-20 X ⅝"
9	2	514-10-1E	SOCKET SET SCREW, FLAT POINT, ¼-28 X ⅜"
10	1	MF-196	DOWEL PIN 3/16 X ½"
11	1	514-10-3D	BACKING PLATE, PIN HONE ADAPTER ASSY
12	1	MF-198A	DOWEL PIN 3/16 X 7/8"
13	1	MF-218	ROLL PIN ⅛ X ⅝"
14	1	514-10-20C	ADJUSTING SHAFT – PIN HONE ADAPTER ASSY
15	1	514-10-20D	YOKE DRIVE TUBE, PIN HONE ADAPTER
16	1	514-10-1B	UPPER BODY, PIN HONE ADAPTER ASSY
17	1	514-10-1C	LOWER BODY, PIN HONE ADAPTER ASSY
18	1	514-10-1D	CLAMP PLATE, PIN HONE ADAPTER ASSY
19	1	6855P	SOCKET SET SCREW, FLAT POINT, ½-13 X ½"
20	1	514-10-3E	ACTUATOR ASSEMBLY, PIN HONE ADAPTER ASSY
21	2	MF-84D	S.H.C.S. #4-40 X ⅜"
22	1	MF-223C	ROLL PIN 3/16 X ⅝"
23	1	514-10-1F	NUT, THRUST BEARING – PIN HONE ADAPTER
24	1	514-10-1G	HOMING PLUG, PIN HONE ADAPTER



Stone Holders

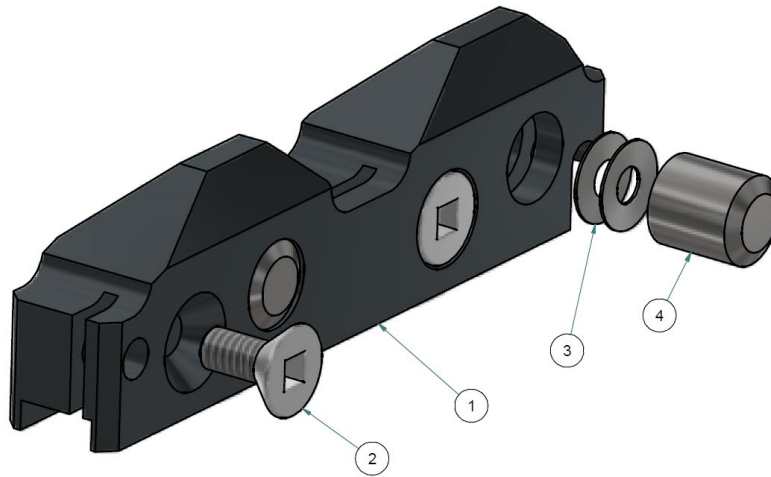
Stone Holder Size Chart

Holder PN	0.200" Stones		0.312" Stones		0.395" Brushes		0.550" Brushes	
	Min Dia in (mm)	Max Dia in (mm)	Min Dia in (mm)	Max Dia in (mm)	Min Dia in (mm)	Max Dia in (mm)	Min Dia in (mm)	Max Dia in (mm)
514-10-13 (4-Stone) Medium Series								
514-10-13A	2.12 (53.75)	2.23 (56.54)	2.34 (59.44)	2.45 (62.23)	2.51 (63.65)	2.62 (66.45)	2.82 (71.53)	2.93 (74.32)
514-10-13F	2.22 (56.29)	2.33 (59.08)	2.44 (61.98)	2.55 (64.77)	2.61 (66.19)	2.72 (68.99)	2.92 (74.07)	3.03 (76.86)
514-10-13B	2.32 (58.83)	2.43 (61.62)	2.54 (64.52)	2.65 (67.31)	2.71 (68.73)	2.82 (71.53)	3.02 (76.61)	3.13 (79.40)
514-10-13G	2.42 (61.37)	2.53 (64.16)	2.64 (67.06)	2.75 (68.85)	2.81 (71.27)	2.92 (74.07)	3.12 (79.15)	3.23 (81.94)
514-10-13C	2.52 (63.91)	2.63 (66.70)	2.74 (69.60)	2.85 (72.39)	2.91 (73.81)	3.02 (76.61)	3.22 (81.69)	3.33 (84.48)
514-10-13H	2.62 (66.45)	2.73 (69.24)	2.84 (72.14)	2.95 (74.93)	3.01 (76.35)	3.12 (79.15)	3.32 (84.23)	3.43 (87.02)
514-10-13D	2.72 (68.99)	2.83 (71.78)	2.94 (74.68)	3.05 (77.47)	3.11 (78.89)	3.22 (81.69)	3.42 (86.77)	3.53 (89.56)
514-9-13 (6-Stone) & 514-9-6 (4-Stone) Large Series								
514-9-31J	2.77 (70.23)	3.23 (82.04)	2.99 (75.92)	3.45 (87.73)	3.16 (80.14)	3.62 (91.95)	3.47 (88.01)	3.93 (99.82)
514-9-6J	2.94 (74.70)	3.41 (86.51)	3.17 (80.39)	3.63 (92.20)	3.33 (84.61)	3.80 (96.42)	3.64 (92.48)	4.11 (104.29)
514-9-31A	3.19 (81.05)	3.66 (92.86)	3.42 (86.74)	3.88 (98.55)	3.58 (90.96)	4.05 (102.77)	3.89 (98.83)	4.36 (110.64)
514-9-31B	3.44 (87.40)	3.91 (99.21)	3.67 (93.09)	4.13 (104.90)	3.83 (97.31)	4.30 (109.12)	4.14 (105.18)	4.61 (116.99)
514-9-31C	3.69 (93.75)	4.16 (105.56)	3.92 (99.44)	4.38 (111.25)	4.08 (103.66)	4.55 (115.47)	4.39 (111.53)	4.86 (123.34)
514-9-31D	3.94 (100.10)	4.41 (111.91)	4.17 (105.79)	4.63 (117.60)	4.33 (110.01)	4.80 (121.82)	4.64 (117.88)	5.11 (129.69)
514-9-31E	4.19 (106.45)	4.66 (118.26)	4.42 (112.14)	4.88 (123.95)	4.58 (116.36)	5.05 (128.17)	4.89 (124.23)	5.36 (136.04)
514-9-31F	4.44 (112.80)	4.91 (124.61)	4.67 (118.49)	5.13 (130.30)	4.83 (122.71)	5.30 (134.52)	5.14 (130.58)	5.61 (142.39)
514-9-31G	4.69 (119.15)	5.16 (130.96)	4.92 (124.84)	5.38 (136.65)	5.08 (129.06)	5.55 (140.87)	5.39 (136.93)	5.86 (148.74)
514-9-31H	4.94 (125.50)	5.41 (137.31)	5.17 (131.19)	5.63 (143.00)	5.33 (135.41)	5.80 (147.22)	5.64 (143.28)	6.11 (155.09)
514-9-31I	5.19 (131.85)	5.66 (143.66)	5.42 (137.54)	5.88 (149.35)	5.58 (141.76)	6.05 (153.57)	5.89 (149.63)	6.36 (161.44)
514-9-31K	5.44 (138.20)	5.91 (150.01)	5.67 (143.89)	6.13 (155.70)	5.83 (148.11)	6.30 (159.92)	6.14 (155.98)	6.61 (167.79)
514-9-31L	5.69 (144.55)	6.16 (156.36)	5.92 (150.24)	6.38 (162.05)	6.08 (154.46)	6.55 (166.27)	6.39 (162.33)	6.86 (174.14)
514-9-31M	5.94 (150.90)	6.41 (162.71)	6.17 (156.59)	6.63 (168.40)	6.33 (160.81)	6.80 (172.62)	6.64 (168.68)	7.11 (180.49)
514-9-31N	6.19 (157.25)	6.66 (169.06)	6.42 (162.94)	6.88 (174.75)	6.58 (167.16)	7.05 (178.97)	6.89 (175.03)	7.36 (186.84)
514-9-31Q	6.44 (163.60)	6.91 (175.41)	6.67 (169.29)	7.13 (181.10)	6.83 (173.51)	7.30 (185.32)	7.14 (181.38)	7.61 (193.19)
514-9-31R	6.69 (169.95)	7.16 (181.76)	6.92 (175.64)	7.38 (187.45)	7.08 (179.86)	7.55 (191.67)	7.39 (187.73)	7.86 (199.54)
514-9-31S								
514-9-6S								



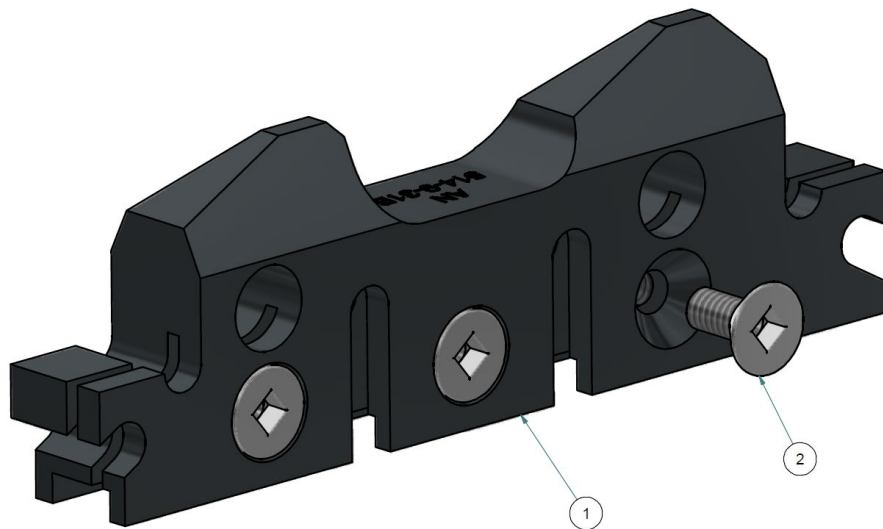
Holder PN	0.200" Stones		0.312" Stones		0.395" Brushes		0.550" Brushes	
	Min Dia in (mm)	Max Dia in (mm)	Min Dia in (mm)	Max Dia in (mm)	Min Dia in (mm)	Max Dia in (mm)	Min Dia in (mm)	Max Dia in (mm)
514-9-25 (4-Stone) Extra Large Series								
514-9-25A	5.99 (152.1)	6.29 (159.7)	6.1 (154.9)	6.4 (162.6)	6.18 (157.0)	6.48 (164.7)	6.34 (161.0)	6.64 (168.6)
514-9-25B	6.19 (157.2)	6.49 (164.8)	6.3 (160.0)	6.6 (167.6)	6.38 (162.1)	6.68 (169.7)	6.54 (166.1)	6.84 (173.7)
514-9-25C	6.49 (164.8)	6.79 (172.4)	6.6 (167.6)	6.9 (175.3)	6.68 (169.7)	6.98 (177.4)	6.84 (173.7)	7.14 (181.3)
514-9-25D	6.79 (172.4)	7.09 (180.0)	6.9 (175.3)	7.2 (182.9)	6.98 (177.4)	7.28 (185.0)	7.14 (181.3)	7.44 (188.9)
514-9-25E	7.09 (180.0)	7.39 (187.7)	7.2 (182.9)	7.5 (190.5)	7.28 (185.0)	7.58 (192.6)	7.44 (188.9)	7.74 (196.5)
514-9-25F	7.39 (187.7)	7.69 (195.3)	7.5 (190.5)	7.8 (198.1)	7.58 (192.6)	7.88 (200.2)	7.74 (196.5)	8.04 (204.2)
514-9-25G	7.69 (195.3)	7.99 (202.9)	7.8 (198.1)	8.1 (205.7)	7.88 (200.2)	8.18 (207.8)	8.04 (204.2)	8.34 (211.8)
514-9-25H	7.99 (202.9)	8.29 (210.5)	8.1 (205.7)	8.4 (213.4)	8.18 (207.8)	8.48 (215.5)	8.34 (211.8)	8.64 (219.4)
514-9-25J	8.29 (210.5)	8.59 (218.1)	8.4 (213.4)	8.7 (221.0)	8.48 (215.5)	8.78 (223.1)	8.64 (219.4)	8.94 (227.0)
514-9-25K	8.59 (218.1)	8.89 (225.8)	8.7 (221.0)	9.0 (228.6)	8.78 (223.1)	9.08 (230.7)	8.94 (227.0)	9.24 (234.6)
514-9-25L	8.89 (225.8)	9.19 (233.4)	9.0 (228.6)	9.3 (236.2)	9.08 (230.7)	9.38 (238.3)	9.24 (234.6)	9.54 (242.3)
514-9-25M	9.19 (233.4)	9.49 (241.0)	9.3 (236.2)	9.6 (243.8)	9.38 (238.3)	9.68 (245.9)	9.54 (242.3)	9.84 (249.9)
514-9-25Q	9.49 (241.0)	9.79 (248.6)	9.6 (243.8)	9.9 (251.5)	9.68 (245.9)	9.98 (253.6)	9.84 (249.9)	10.14 (257.5)
514-9-25R	9.79 (248.6)	10.09 (256.2)	9.9 (251.5)	10.2 (259.1)	9.98 (253.6)	10.28 (261.2)	10.14 (257.5)	10.44 (265.1)
514-9-25S	10.09 (256.2)	10.39 (263.9)	10.2 (259.1)	10.5 (266.7)	10.28 (261.2)	10.58 (268.8)	10.44 (265.1)	10.74 (272.7)
514-9-25T	10.39 (263.9)	10.69 (271.5)	10.5 (266.7)	10.8 (274.3)	10.58 (268.8)	10.88 (276.4)	10.74 (272.7)	11.04 (280.4)
514-9-25U	10.69 (271.5)	10.99 (279.1)	10.8 (274.3)	11.1 (281.9)	10.88 (276.4)	11.18 (284.0)	11.04 (280.4)	11.34 (288.0)
514-9-25N	10.79 (274.0)	11.09 (281.6)	10.9 (276.9)	11.2 (284.5)	10.98 (279.0)	11.28 (286.6)	11.14 (282.9)	11.44 (290.5)
514-9-25P	11.56 (293.6)	11.86 (301.2)	11.67 (296.4)	11.97 (304.0)	11.75 (298.5)	12.05 (306.1)	11.91 (302.5)	12.21 (310.1)

514-10-13 Series Stone Holders
Sold in sets of 4



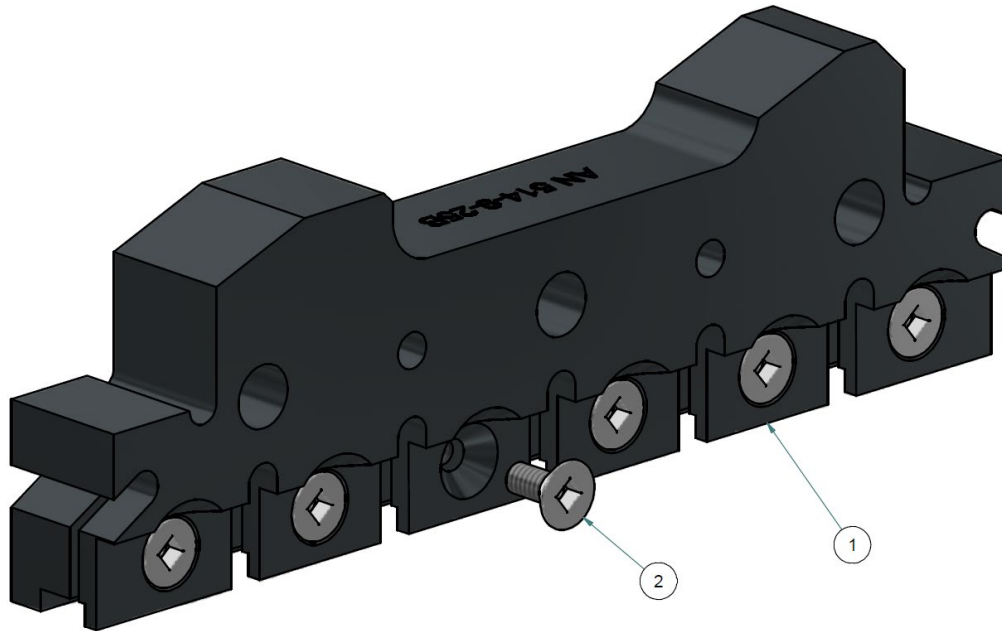
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	-	STONE HOLDER BODY (ONLY SOLD AS ASSY)
2	2	514-7-81J	SCREW, FLAT HEAD, SQUARE DRIVE
3	4	514-10-11D	SPRING, BELLEVILLE
4	2	514-10-11C	PIN, DAMPENING

514-9-31 (Set of 6) & 514-9-6 (Set of 4) Series Stone Holders



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	-	STONE HOLDER BODY (ONLY SOLD AS ASSY)
2	3	514-7-81J	SCREW, FLAT HEAD, SQUARE DRIVE


514-9-25 (Set of 4) Series Stone Holders



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	-	STONE HOLDER BODY (ONLY SOLD AS ASSY)
2	6	514-7-81J	SCREW, FLAT HEAD, SQUARE DRIVE

Stone Sets


Note: Ra – Roughness Average measurement. Surface finish values listed are expected under typical use.





Diamond Stone Sets		
0.312" (7.92mm) Height, Set of 4		
<p>514-9-14F, 80 Grit 3" (76mm) Long, 90Ra (2.25µm), stock removal 0.004-.007in/min</p>  <p>ROTTLER 514-9-14F 1 JN1366403</p>	<p>514-9-14R, 80 Grit 3 ½" (89mm) Long, 90Ra (2.25µm), stock removal 0.004-.007in/min</p>  <p>ROTTLER 514-9-14R 1 JN1181801</p>	<p>514-9-21R, 80 Grit 4" (102mm) Long, 90Ra (2.25µm), stock removal 0.004-.007in/min</p>  <p>ROTTLER 514-9-21R 1 JN1181801</p>
<p>514-9-14W, 140/170 Grit 3" (76mm) Long, 50-75Ra (1.25-1.88µm)</p>  <p>ROTTLER 514-9-14W 1 JN1272606</p>	<p>514-9-21W, 140/170 Grit 4" (102mm) Long, 50-75Ra (1.25-1.88µm)</p>  <p>ROTTLER 514-9-21W 1 JN1465701</p>	<p>514-9-14K, 170/200 Grit 3" (76mm) Long, 45-60Ra (1.13-1.5µm)</p>  <p>ROTTLER 514-9-14K 1 JN1366404</p>
<p>514-9-14M, 170/200 Grit 3 ½" (89mm) Long, 45-60Ra (1.13-1.5µm)</p>  <p>ROTTLER 514-9-14M 1 JN1366405</p>	<p>514-9-21M, 170/200 Grit 4" (102mm) Long, 45-60Ra (1.13-1.5µm)</p>  <p>ROTTLER 514-9-21M 1 JN1460302</p>	<p>514-9-14J, 270/325 Grit 3" (76mm) Long, 35-45Ra (.88-1.13µm)</p>  <p>ROTTLER 514-9-14J 1 JN1254802</p>
<p>514-9-14T, 270/325 Grit 3 ½" (89mm) Long, 35-45Ra (.88-1.13µm)</p>  <p>ROTTLER 514-9-14T 1 JN1302304</p>	<p>514-9-14Z, 270/325 Grit 4" (102mm) Long, 35-45Ra (.88-1.13µm)</p>  <p>ROTTLER 514-9-14Z 1 JN1445801</p>	<p>514-9-14E, 325/400 Grit 3" (76mm) Long, 24-30Ra (.6-.75µm)</p>  <p>ROTTLER 514-9-14E 1 JN1348401</p>
<p>514-9-14Q, 325/400 Grit 3 ½" (89mm) Long, 24-30Ra (.6-.75µm)</p>  <p>ROTTLER 514-9-14Q 1 JN1334901</p>	<p>514-9-14X, 325/400 Grit 4" (102mm) Long, 24-30Ra (.6-.75µm)</p>  <p>ROTTLER 514-9-14X 1 JN1307806</p>	<p>514-9-14C, 325/400 Grit 3" (76mm) Long, 18-22Ra (.45-.55µm)</p>  <p>ROTTLER 514-9-14C 1 JN1370901</p>



<p>514-9-14U, 500 Grit 2 ½" (64mm) Long, 18-22Ra (.45-.55µm)</p> 	<p>514-9-14V, 500 Grit 3" (76mm) Long, 18-22Ra (.45-.55µm)</p> 	<p>514-9-14P, 500 Grit 3 ½" (89mm) Long, 18-22Ra (.45-.55µm)</p> 
<p>514-9-14L, 550 Grit 3" (76mm) Long, 15-19Ra (.38-.48µm)</p> 	<p>514-9-14N, 550 Grit 3 ½" (89mm) Long, 15-19Ra (.38-.48µm)</p> 	<p>514-9-14G, 600 Grit 3" (76mm) Long, 8-12Ra (.2-.3µm)</p> 
<p>514-9-14S, 600 Grit 3 ½" (89mm) Long, 8-12Ra (.2-.3µm)</p> 	<p>514-9-21G, 800 Grit 3" (76mm) Long</p> 	<p>514-9-21H, 1000 Grit 3" (76mm) Long</p> 
<p>514-9-21J, 1200 Grit 3" (76mm) Long</p> 		
<p>0.312" (7.92mm) Height, Set of 6</p>		
<p>514-9-32F, 80 Grit 3" (76mm) Long, 90Ra (2.25µm)</p> 	<p>514-9-32R, 80 Grit 3 ½" (89mm) Long, 90Ra (2.25µm)</p> 	<p>514-9-32W, 140/170 Grit 3" (76mm) Long, 50-75Ra (1.25-1.88µm)</p> 

<p>514-9-32K, 170/200 Grit 3" (76mm) Long, 45-60Ra (1.13-1.5µm)</p> 	<p>514-9-32J, 270/325 Grit 3" (76mm) Long, 35-45Ra (.88-1.13µm)</p> 	<p>514-9-33B, 270/325 Grit 3 1/2" (89mm) Long, 35-45Ra (.88-1.13µm)</p> 
<p>514-9-32E, 325/400 Grit 3" (76mm) Long, 24-30Ra (.6-75µm)</p> 	<p>514-9-32D, 325/400 Grit 3" (76mm) Long, 18-22Ra (.45-.55µm)</p> 	<p>514-9-32C, 500 Grit 3" (76mm) Long, 18-22Ra (.45-.55µm)</p> 
<p>514-9-32L, 550 Grit 3" (76mm) Long, 15-19Ra (.38-.48µm)</p> 	<p>514-9-32G, 600 Grit 3" (76mm) Long, 8-12Ra (.2-.3µm)</p> 	<p>514-9-33, 800 Grit 3" (76mm) Long</p> 
<p>514-9-33A, 800 Grit 3 1/2" (89mm) Long</p> 	<p>514-9-33C, 800 Grit 4" (102mm) Long</p> 	<p>514-9-33J, 1200 Grit 3" (76mm) Long</p> 

CBN Stone Sets		
0.312" (7.92mm) Height, Set of 4		
<p>514-9-35C, 320 Grit 3" (76mm) Long</p> 	<p>514-9-35D, 400 Grit 3" (76mm) Long</p> 	<p>514-9-35E, 500 Grit 3" (76mm) Long</p> 
<p>514-9-35B, 600 Grit 3" (76mm) Long</p> 		
Brushes and Miscellaneous Finishing		
<p>514-9-14H Brushes For Plateau Finishing 0.550" (14mm) High x 3 1/2" (89mm) Long. Set of 4</p> 	<p>514-9-14Y Brushes For Plateau Finishing 0.395" (10mm) High x 3 1/2" (89mm) Long. Set of 4</p> 	<p>514-9-14D Diamond Stones, 325/400 Grit 0.20" (5.1mm) High x 3" (76mm) Long 18-22Ra (.45-.55 µm). Set of 4</p> 
<p>514-9-18P Special Red Finish Diamonds For final sizing. Set of 4.</p> 	<p>514-9-18N Silicone Abrasive Exposing Stones For removing aluminum. Set of 4.</p> 	<p>514-9-21 Polishing Felt Pads For use with 514-9-21F Paste. Set of 4.</p> 
<p>514-9-21F Silicone Paste For final sizing. Set of 4.</p> 		

Single Stage Diamond Stone Sets (For use with 514-9N Hone Head), Sets of 12		
<p>110-171-01, 600 Grit 0.781" (19.83mm) Height</p> 	<p>110-171-02, 1200 Grit 0.781" (19.83mm) Height</p> 	<p>110-171-03, 325/400 Grit 0.781" (19.83mm) Height</p> 
Dual Stage Diamond Stone Sets (For use with 514-9M Hone Head), Sets of 6		
<p>110-162R, 325/400 Grit 0.781" (19.38mm) Height</p> 	<p>110-163R, 325/400 Grit 0.859" (22.73mm) Height</p> <p>Image Currently Unavailable</p>	<p>110-163R-01, 140/170 Grit 0.859" (22.73mm) Height</p> <p>Image Currently Unavailable</p>
<p>110-163R-03, 600 Grit 0.859" (22.73mm) Height</p> <p>Image Currently Unavailable</p>	<p>110-164R, 325/400 Grit 0.937" (23.80mm) Height</p> <p>Image Currently Unavailable</p>	<p>110-164R-01, 140/170 Grit 0.937" (23.80mm) Height</p> <p>Image Currently Unavailable</p>
<p>110-164R-03, 60 Grit 0.937" (23.80mm) Height</p> <p>Image Currently Unavailable</p>		
Dual Stage Brush Sets (For use with 514-9M Hone Head), Sets of 4		
<p>124-24 Brush Set 0.781" (19.84mm) Height</p> <p>Image Currently Unavailable</p>	<p>124-25 Brush Set 0.859" (21.82mm) Height</p> <p>Image Currently Unavailable</p>	<p>124-26 Brush Set 0.937" (23.80mm) Height</p> <p>Image Currently Unavailable</p>

Coolant and Filter Equipment

514-4-71C Synthetic Coolant

For use with Diamond stones. 5 gal (20L). Mix with water 20:1

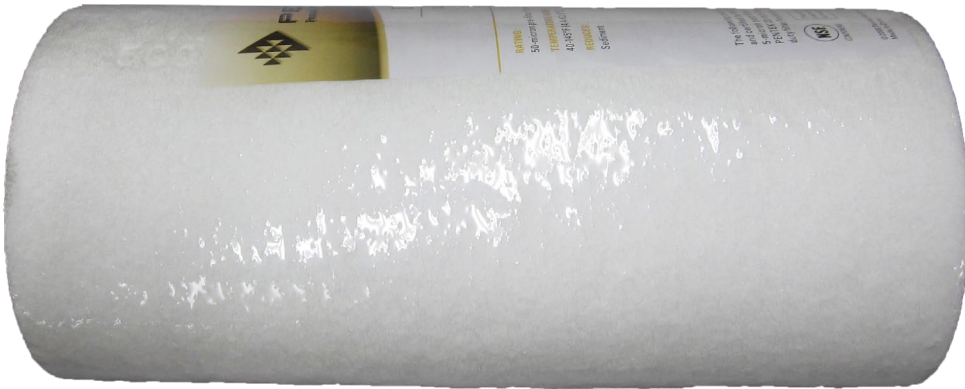


514-4-71D Coolant Refractor



514-2-42C Dual Gradient 50-5 Micron Replacement Filter Cartridge

For standard filter system



514-2-42A Cannister Magnetic Filter System

Replacement parts: 514-2-42M O-Ring, 514-2-42P Bowl Spanner, 514-2-42Q Bowl



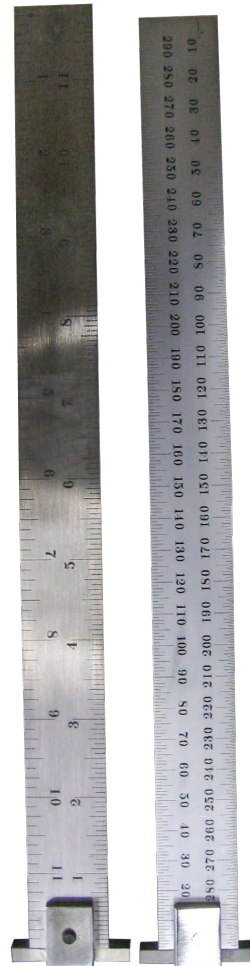
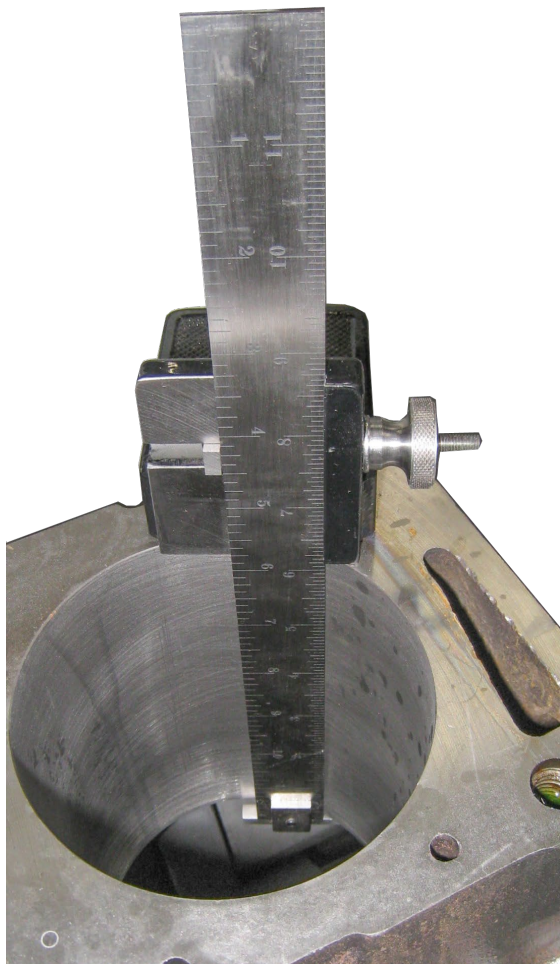
Measuring Equipment

201 Mitutoyo Surface Tester



514-8-27 Stone Depth Scale and Holder, Inch

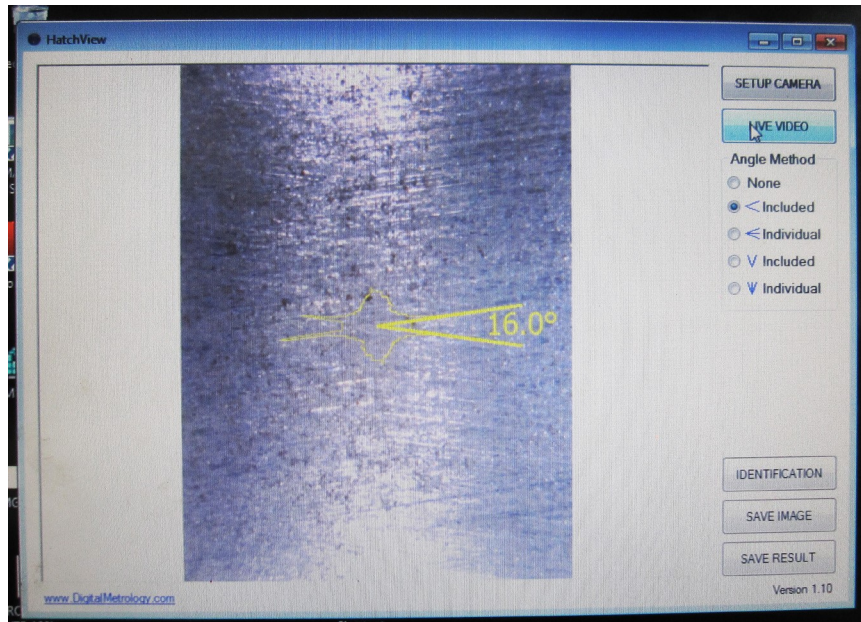
514-8-27F Stone depth Scale and Holder, Metric



514-14-29 Crosshatch Inspection Camera



514-14-29B Crosshatch Inspection Software



Safety Systems

514-14-99 Laser Light Curtain

