

ROTTLER

S85 & S86 SURFACING MACHINE 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. 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

S85 & S86 OPTIONAL EQUIPMENT PARTS CATALOG

Contents

Cutting Tools	1
Surfacing Tools	1
S80SURF.16 Flycutter Kit, 16" Dia	1
7224 Shell Mill, 2 1/2" Dia	1
7225Y Shell Mill, 4" Dia	2
Tool Holders	3
7202V Holder, Flycutter, 1/2" IC Inserts, Negative Rake	3
7202U Holder, Flycutter, 1/2" IC Inserts, 11° Positive Rake	3
7202X Holder, Flycutter, 3/8" IC Inserts	3
Cutting Inserts	4
Shell Mill Inserts	4
3/8" IC Inserts	4
1/2" IC Inserts	5
Fixturing	6
Parallels	6
11112 Universal 8" (203mm) Parallel	6
11114 Universal 16" (405mm) Parallel	6
7219W Universal 5.2" (132mm) Parallels	7
Block Locating Fixtures	8
502-1-72F V-Block Fixture	8
502-3-48Q In-Line Block Frame	9
502-3-49 VW 15° / Ford, Mazda, Isuzu 75° V-Block Fixture	9
502-3-52 Cadillac Catera V6 Fixture	10
502-3-23 Marine Outboard Fixture	10
502-3-23C Marine Outboard Fixture	10
7330 Universal Economy Automotive Head & Block Fixture	11
7243 Mid-size Diesel Block Fixture	12
502-1-46T Locator Bar, 2" (50.8mm)	13
550-5-10 Main Bearing Bushings, Detroit 8.2L Diesel	13



Auxiliary Equipment..... 14

- 7209M Leveling Table 14
- 7242M Clamp Tower 14
- 7119P Tooling Package, Universal Work Holding System 15
- 7152A Dual Axis Level 15
- 201 Mitutoyo Surface Tester 16
- 7209N 2-Piece Vise Parts 16
- 7226G Exhaust/Intake Manifold Surfacing Fixture 17
- 7038Y Flatness Probe Dial Indicator 17
- 650-3-38 Machinist Level 17

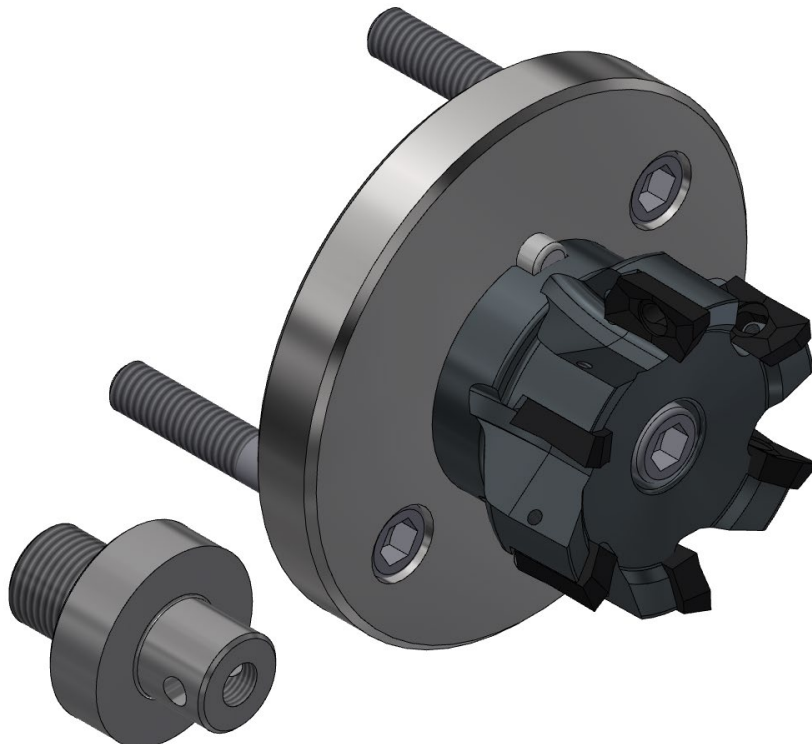
Cutting Tools

Surfacing Tools

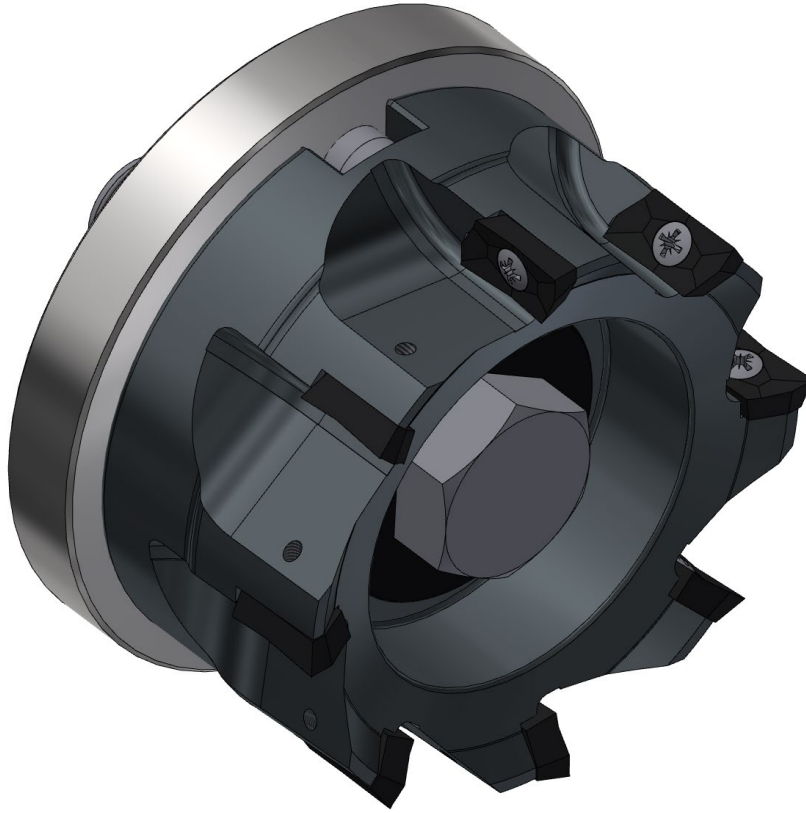
S80SURF.16 Flycutter Kit, 16" Dia.



7224 Shell Mill, 2 1/2" Dia

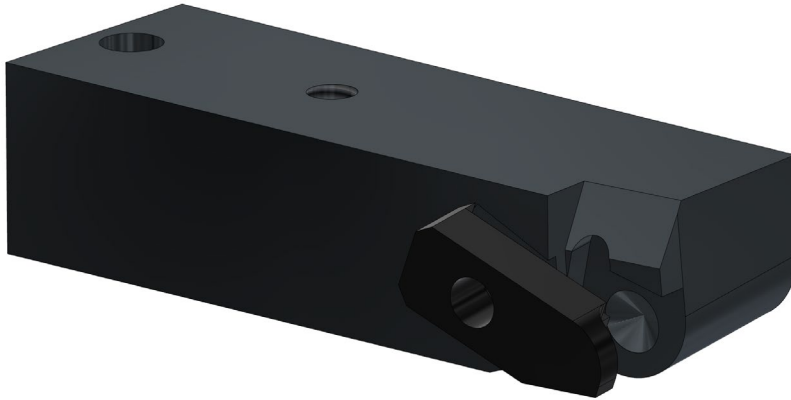


7225Y Shell Mill, 4" Dia



Tool Holders

7202V Holder, Flycutter, 1/2" IC Inserts, Negative Rake






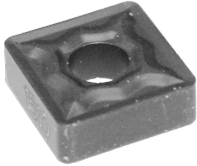






7202U Holder, Flycutter, 1/2" IC Inserts, 11° Positive Rake



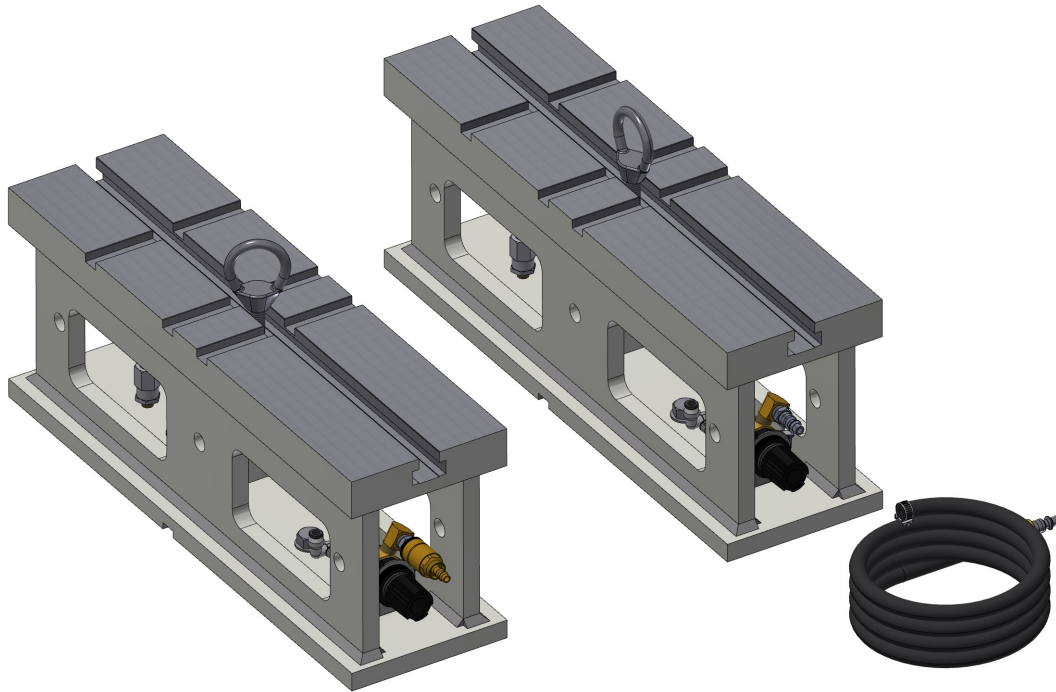
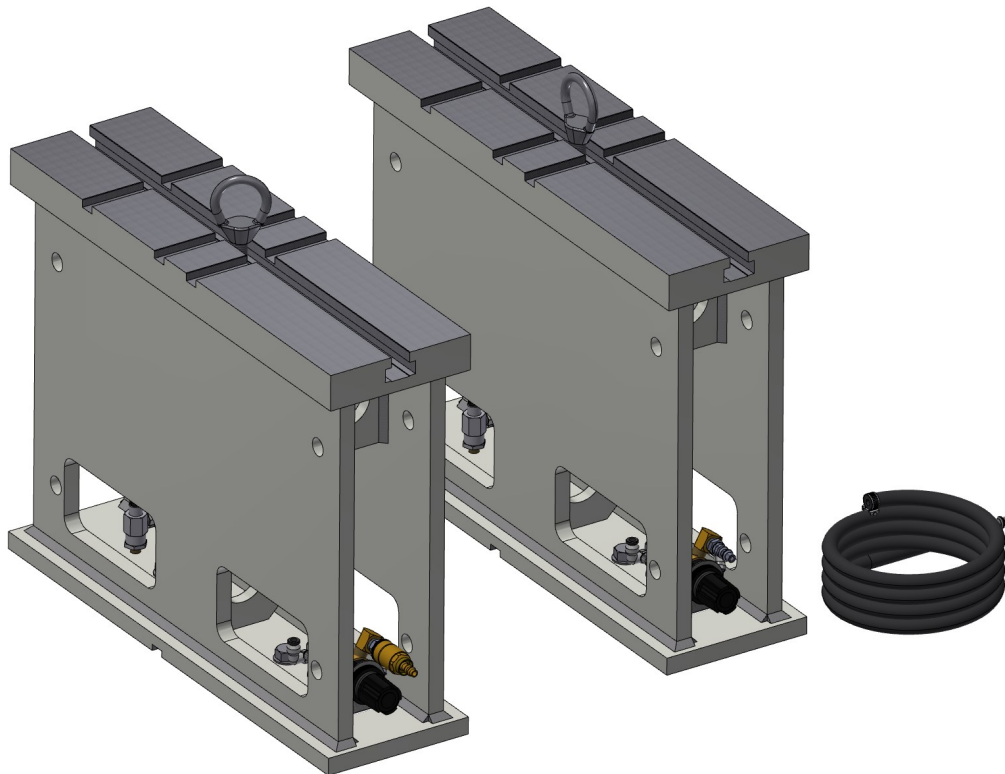
7202X Holder, Flycutter, 3/8" IC Inserts



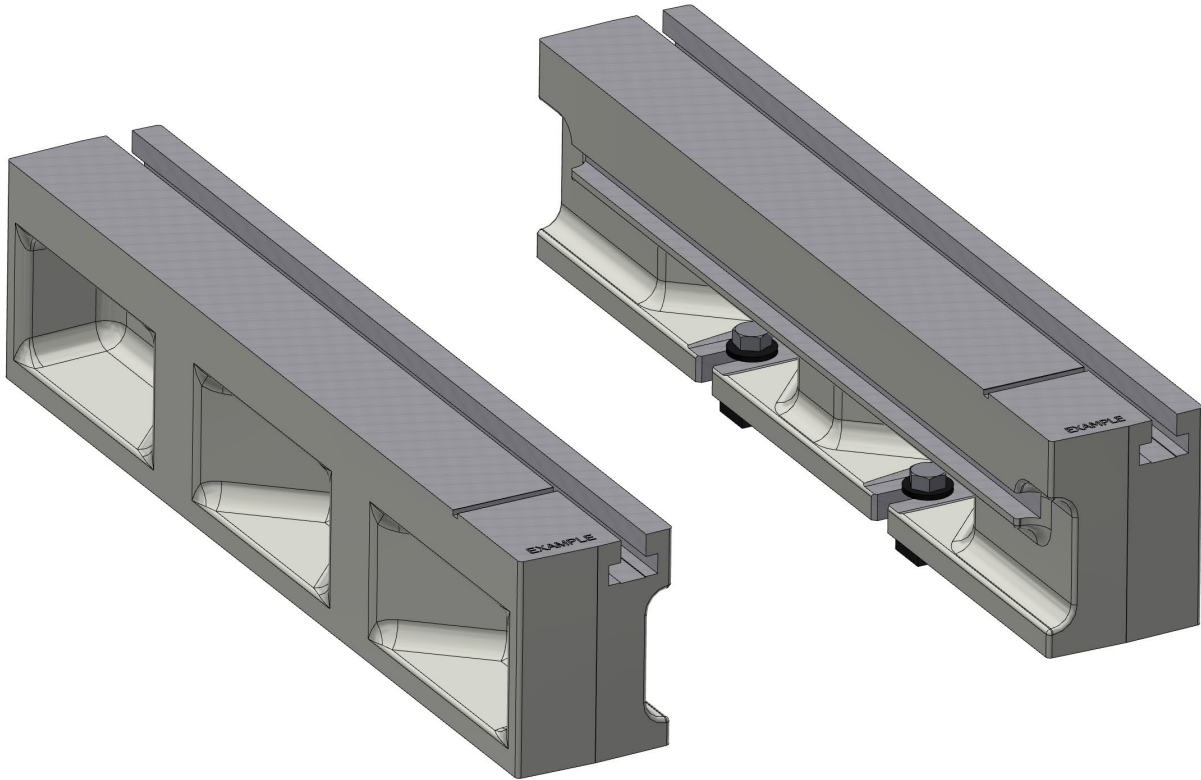
Cutting Inserts

<p>6514T Insert, Shell Mills, 18mm, 0.8mm radius For Shell Mills: 7224, 7225Y</p> 		
<p>6301I, 3/8" IC, 1/16" radius, Ceramic Composite Insert For cutting pre-combustion chambers, negative rake</p> 	<p>6301J 3/8" IC, 1/16" radius, CBN Insert Double Sided, for heavy stock removal</p> 	<p>RS322 3/8" IC, 1/32" radius, Square negative rake, for roughing</p> 
<p>6303B 3/8" IC, Round, CBN Insert Double Sided, for cast iron</p> 	<p>6303K 3/8" IC, Round, Coated Carbide Insert for aluminum and cast iron</p> 	<p>6303M 3/8" IC, Round, PCD Insert for finishing aluminum</p> 
<p>6303R 3/8" IC, Round, CBN Insert for cast iron heads with steel pre-cups</p> 	<p>6303S 3/8" IC, Round, CBN Insert for cutting aluminum heads with steel pre-cups and aluminum blocks with liners</p> 	<p>6301V 3/8" IC, Round, Ceramic Composite Insert For cutting pre-combustion chambers, negative rake</p> 

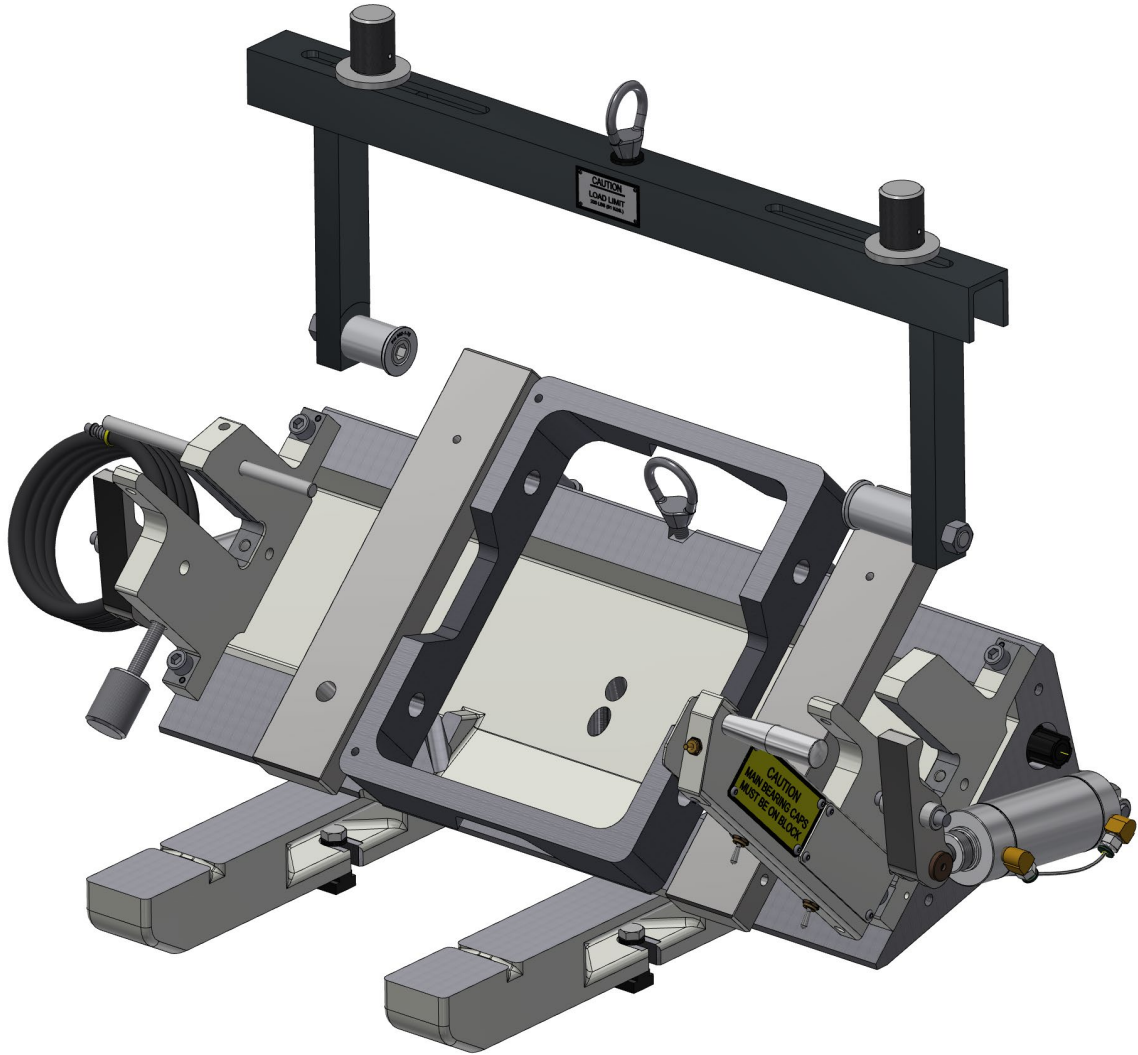
<p>6303U 3/8" IC, Round, CBN Insert Single Sided, For hard cast iron</p> 	<p>6303V 3/8" IC, Octagonal, CBN Insert for surfacing large diesel blocks</p> 	<p>7202Z 3/8" IC, Round Insert coated for aluminum cylinder head precup cutting, also for soft cast iron precups like Land Rover. Use with 7202X tool holder only.</p> 
<p>6303Q 1/2" IC, Round, CBN Insert Double Sided, for general cast iron surfacing</p> 	<p>6303P 1/2" IC, Round, PCD Insert for finishing aluminum</p> 	

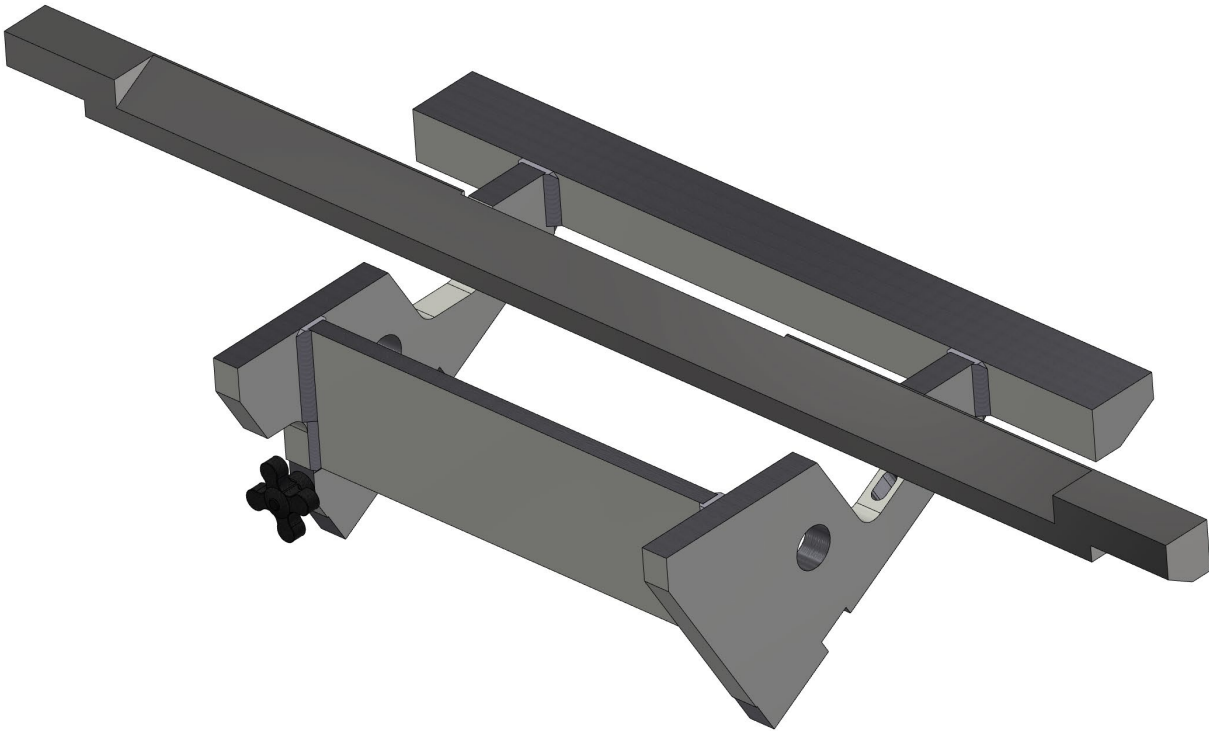
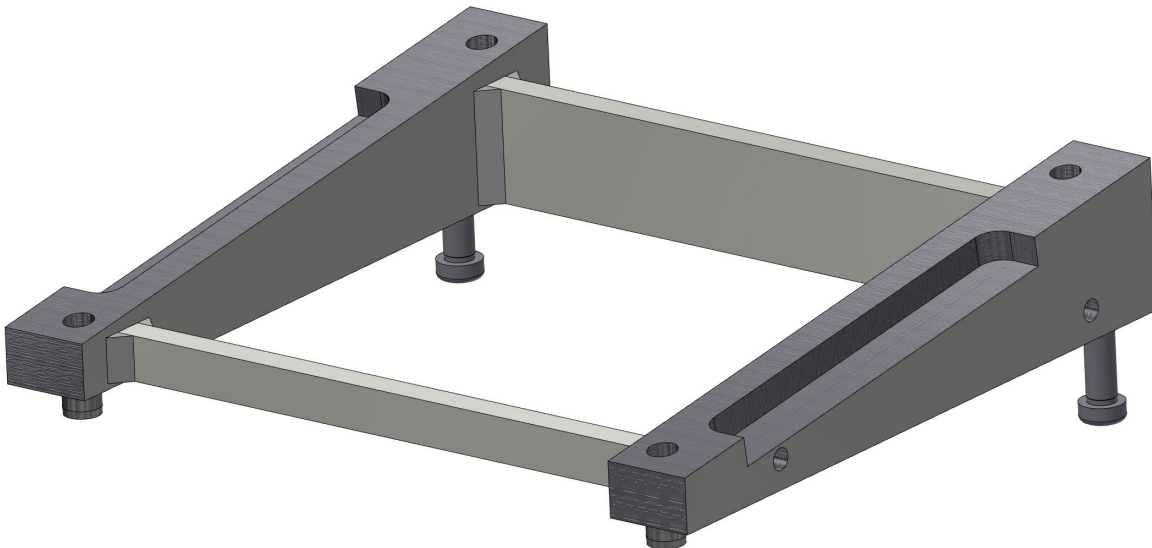
Fixturing**Parallels****11112 Universal 8" (203mm) Heavy Duty T-Slot Parallels Parts****11114 Universal 16" (406mm) Heavy Duty T-Slot Parallels**

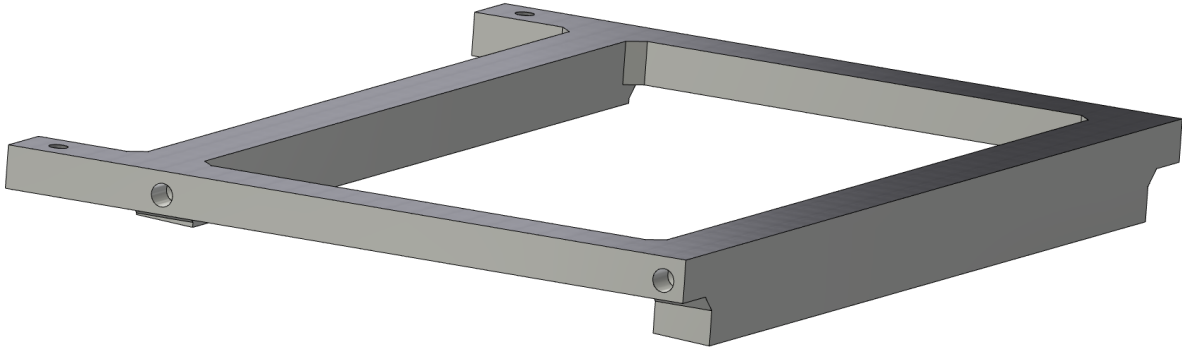
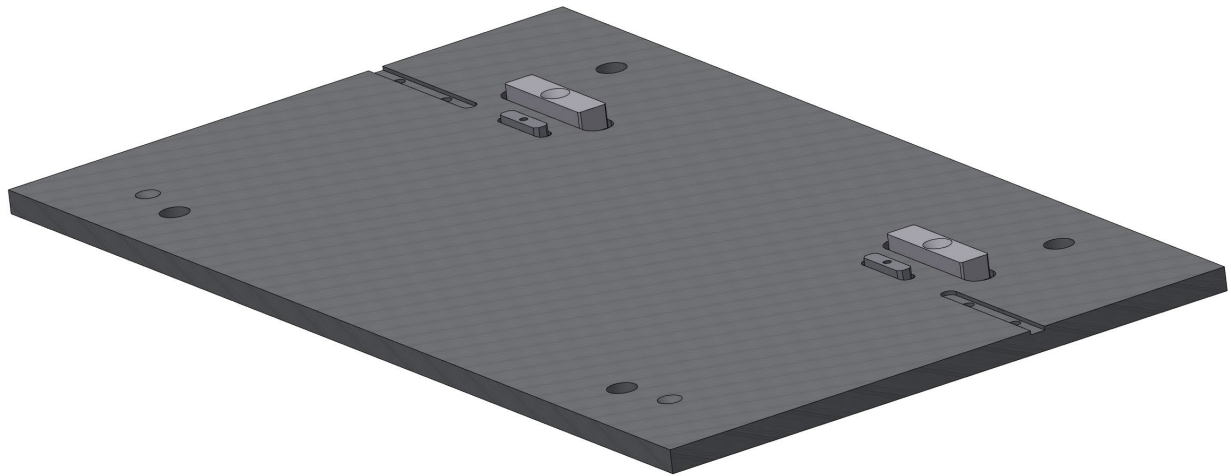
7219W Universal 5.2" (132mm) Parallels



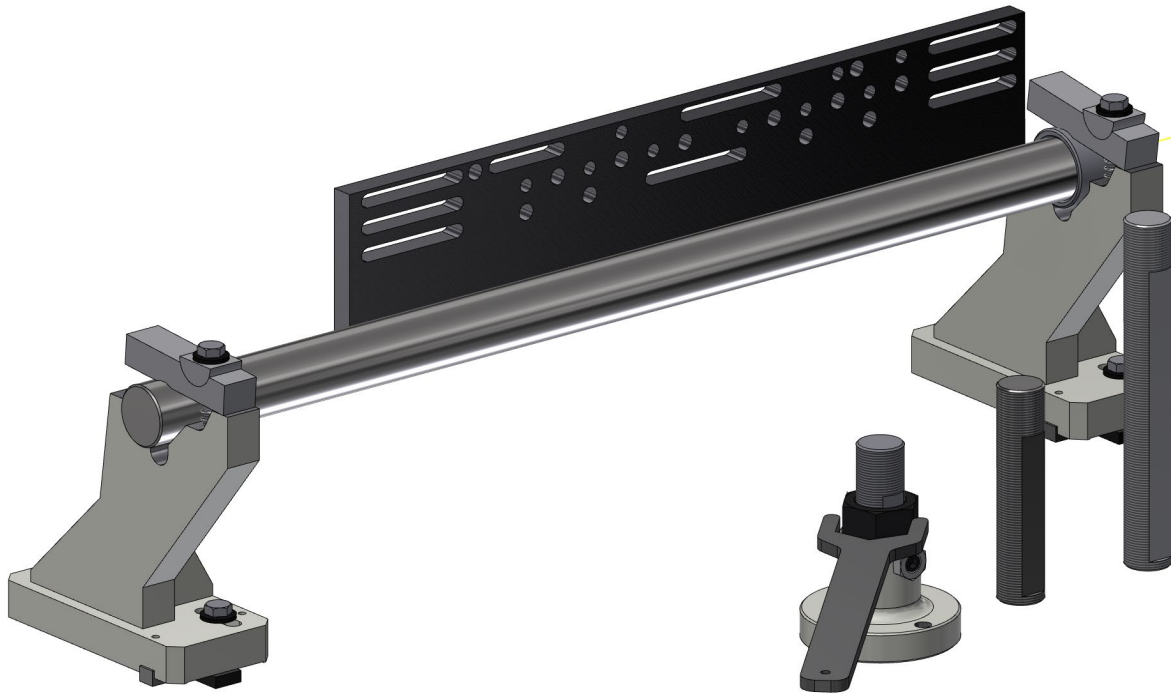
Block Locating Fixtures 502-1-72F V-Block Fixtures



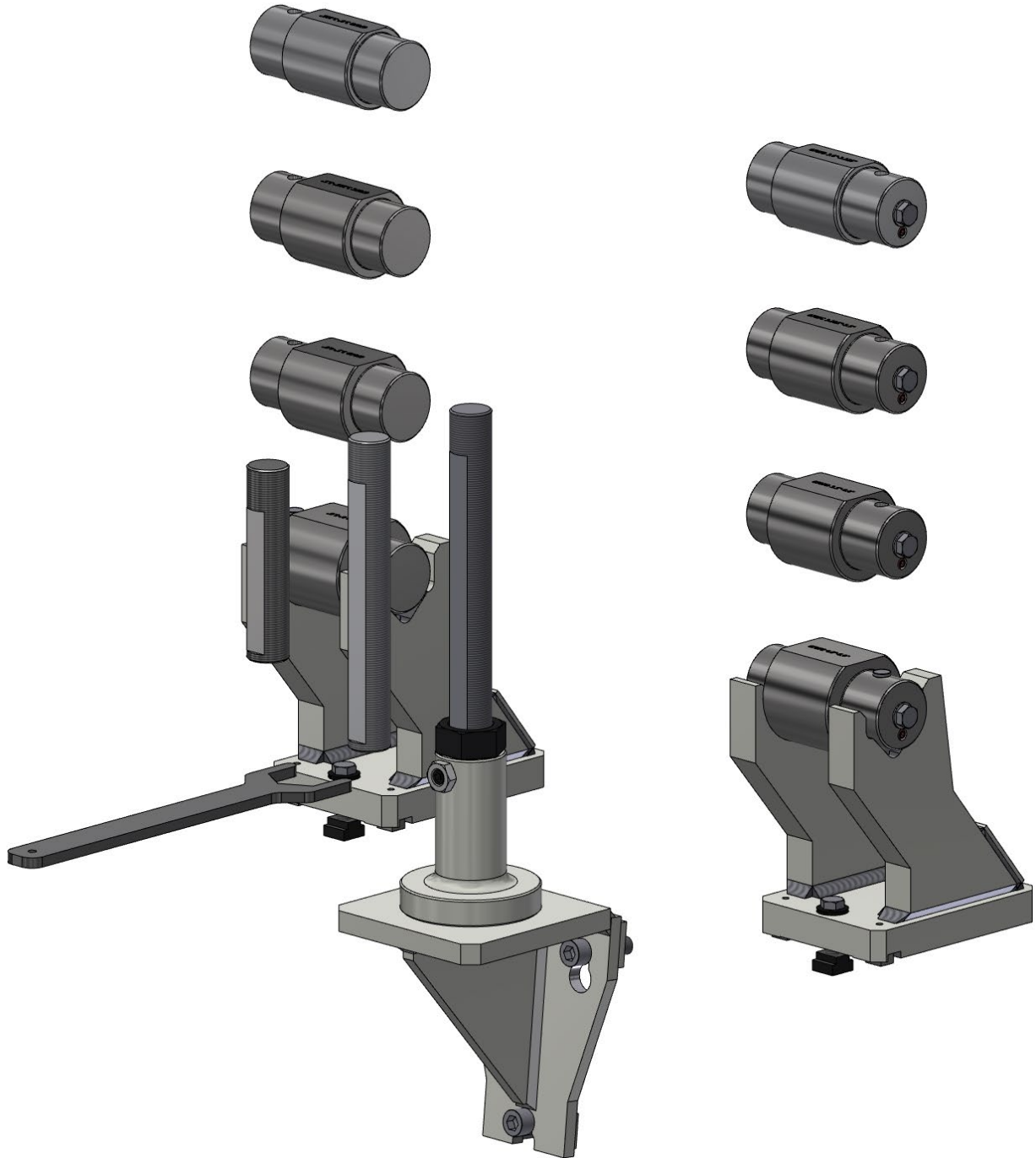
502-3-48Q In-Line Block Frame
Mounts onto 502-1-72F V-Block Frame**502-3-49 VW 15° / Ford, Mazda, Isuzu 75° V-Block Fixture**

502-3-52 Cadillac Catera V6 Fixture**502-3-23 Marine Outboard Fixture****502-3-23C Marine Outboard Fixture**

7330 Universal Economy Automotive Block Fixture



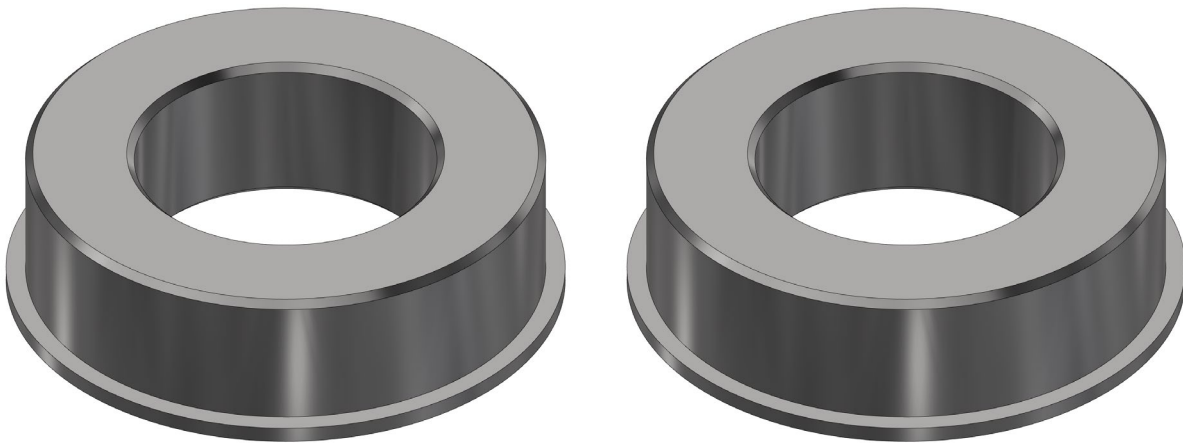
7243 Mid-size Diesel Block Fixture



502-1-46T Locator Bar, 2" (50.8mm) Dia.

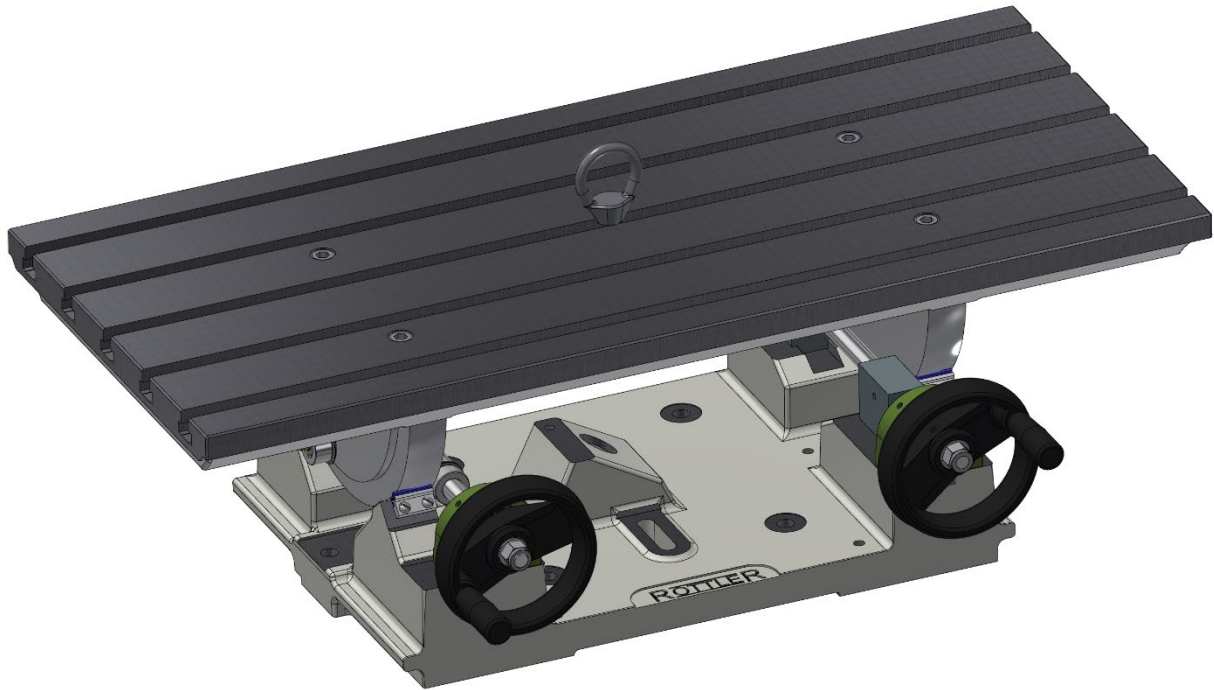


550-5-10 Main Bearing Bushings, Detroit 8.2L Diesel



Auxiliary Equipment

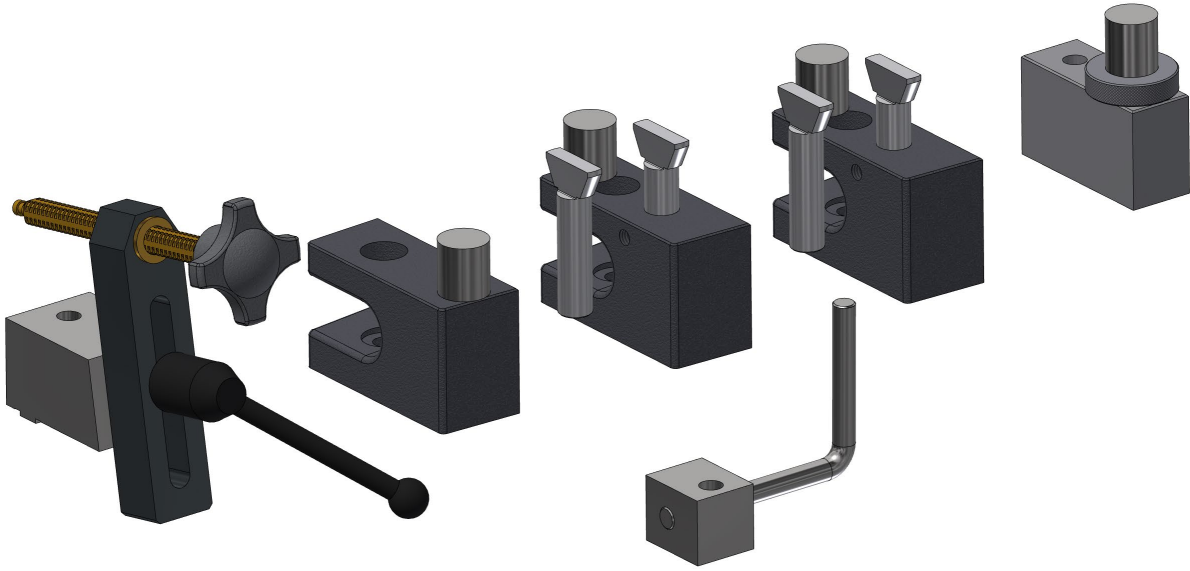
7209M Dual Axis Leveling Table



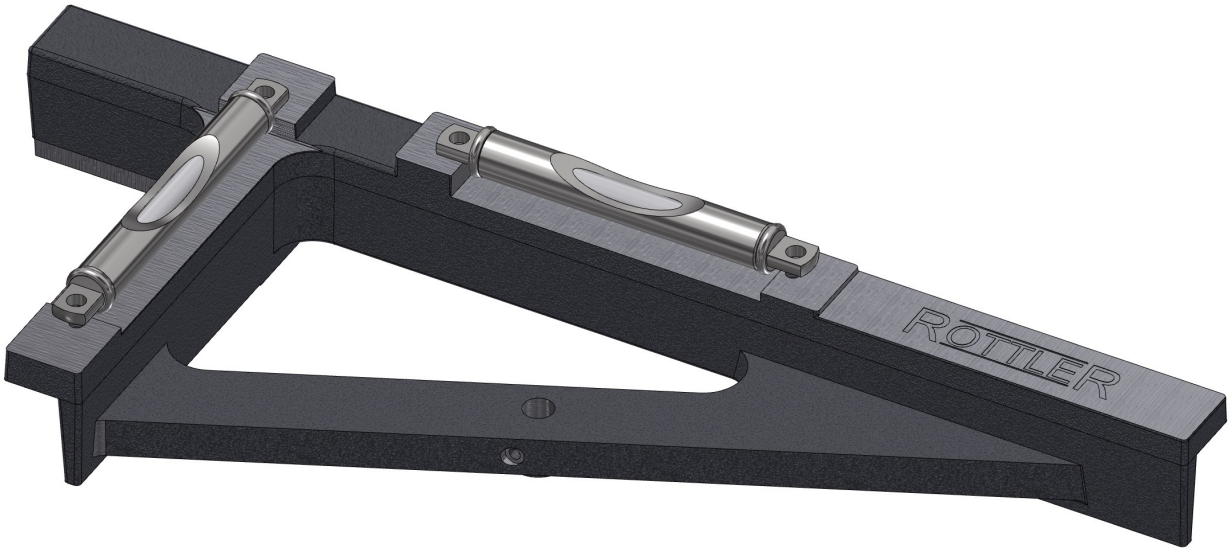
7242M Clamp Towers



7119P Tooling Package, Universal Work Holding System



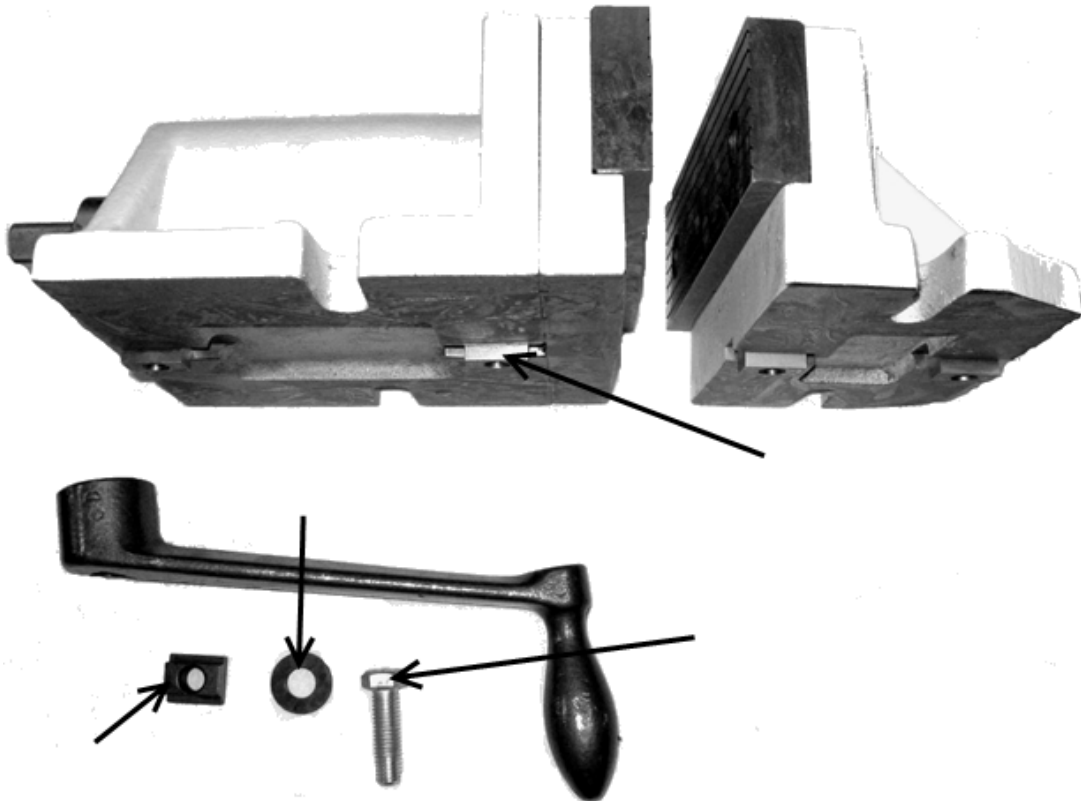
7152A Dual Axis Level

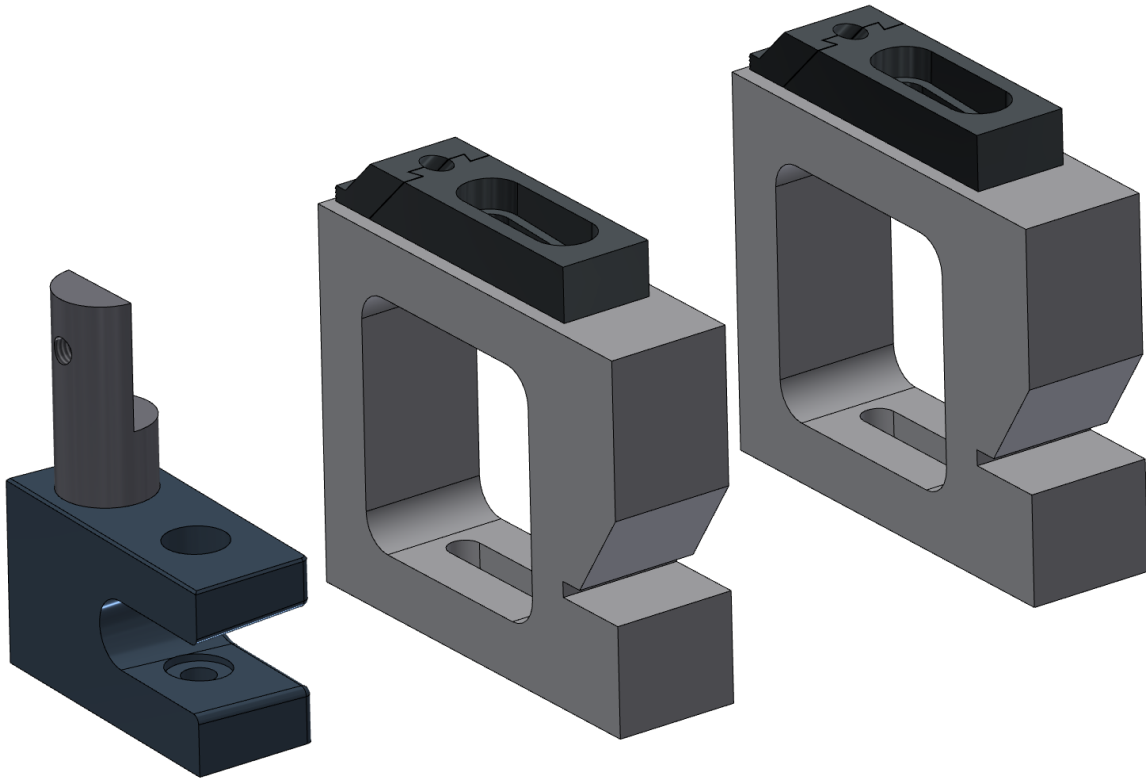
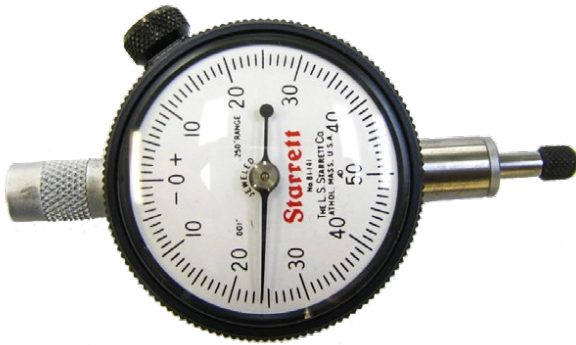


201 Mitutoyo Surface Tester



7209N 2-Piece Vise



7226G Exhaust/Intake Manifold Surfacing Fixture**7038Y Flatness Probe Dial Indicator****650-3-38 Machinist Level**