

# ROTLER

## THE CUTTING EDGE H70 SERIES OPTIONAL EQUIPMENT



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December 5, 2014



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**NOTE:** WHEN ORDERING OPTIONS ORDER BY PART NUMBER  
ALONG WITH MACHINE MODEL AND SERIAL NUMBER

**THERE IS A MINIMUM ORDER OF \$25.00**



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## OPTIONAL CONTROL

### Special Automated Operating System

Special operating system for use with automatic roll over fixture. Allows fully automated operation from start to completion of honing process.

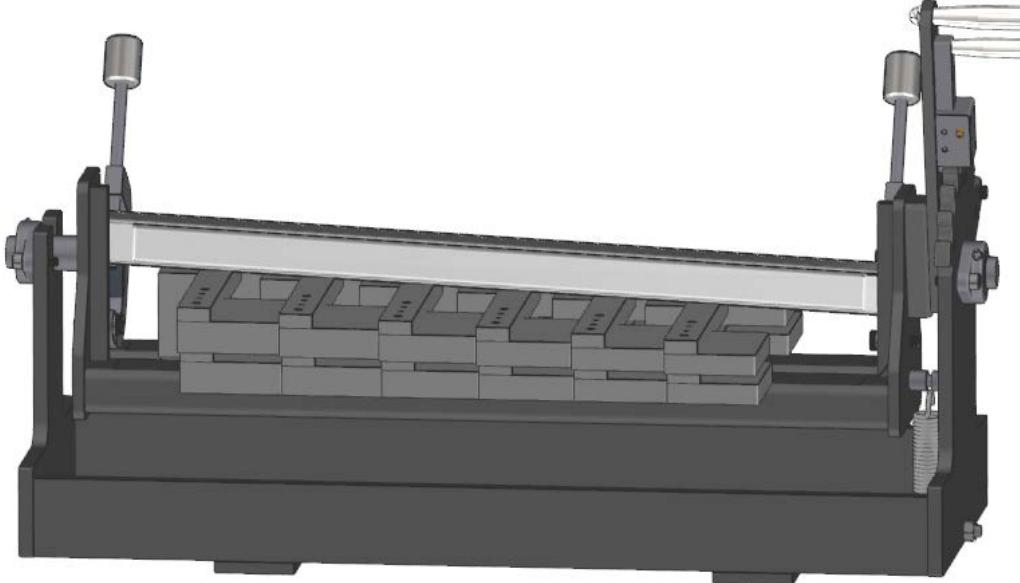
### 9050 Software and Training Package

All equipment, software and training for automated honing system. Design for manual and automatic Roll Over Fixture

## Fixtures

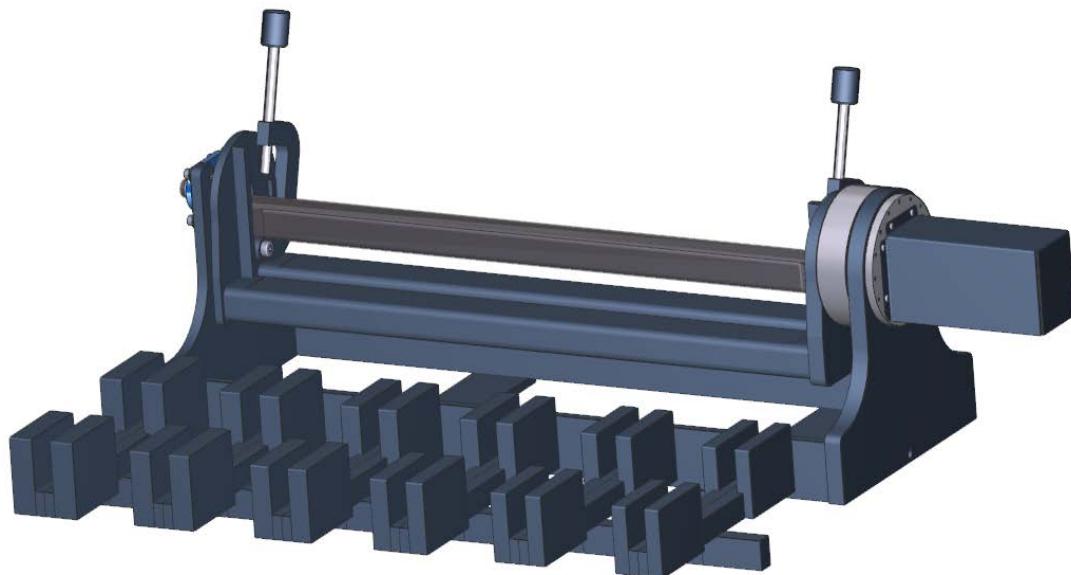
### 514-7C Manual Indexable Roll Over Fixture

For small to medium size In-line and V Blocks up to 31" (787mm) overall length including 6 sets of parallels



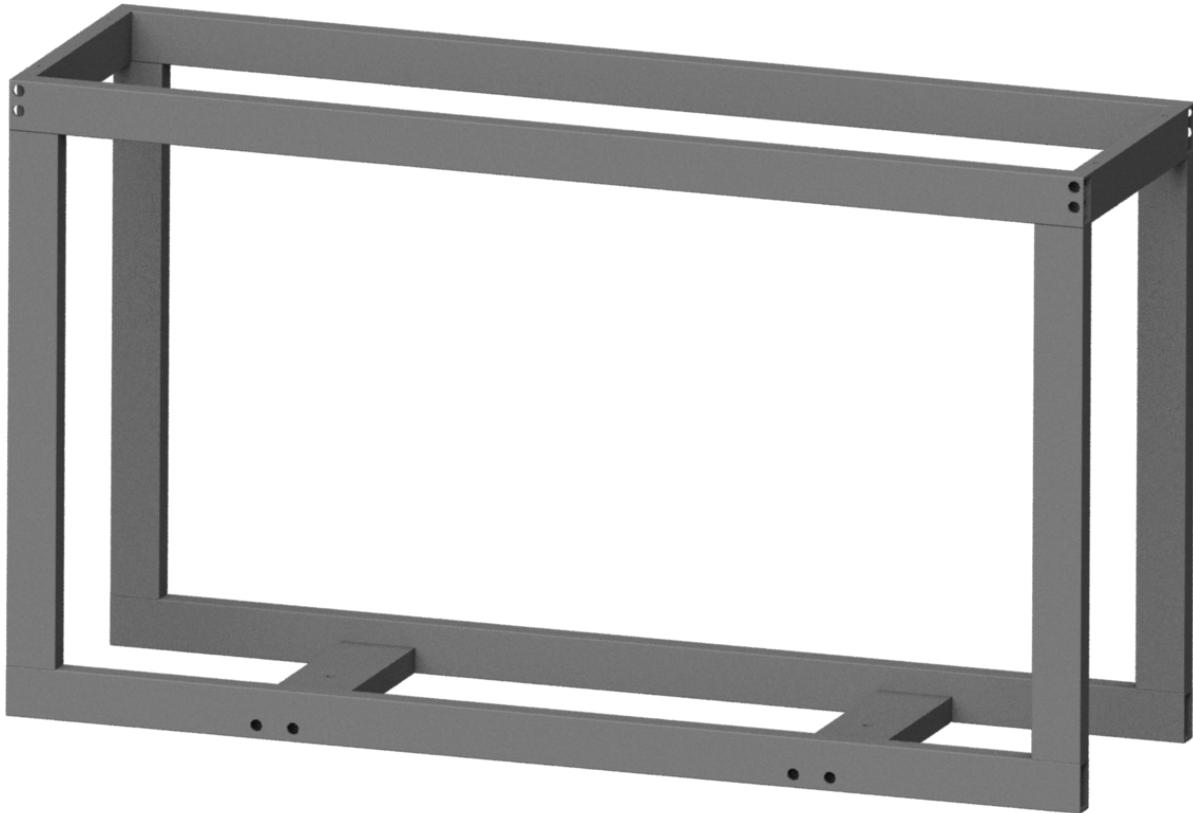
### 514-13-14 Automatic Programmable Roll Over Fixture

For In-Line and V Blocks up to 31" (787mm) overall length, combined with 9050, machine will hone complete V block automatically unattended including 6 sets of parallels



**514-11-5 Cylinder Liner Honing Fixture**

Fixture for Honing Multiple Cylinder Liners (4 Liners) (Note: Must order Fixture Plate Separately)



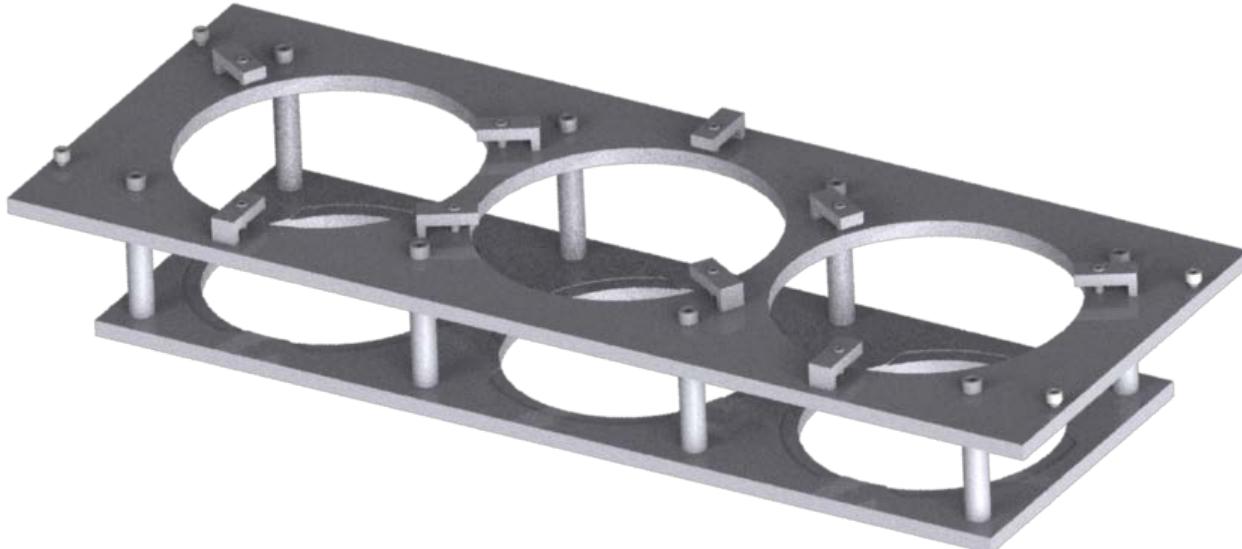
**514-11-6 Fixture Plate, CAT 3400**



**514-11-7 Fixture Plate, CAT 3500**



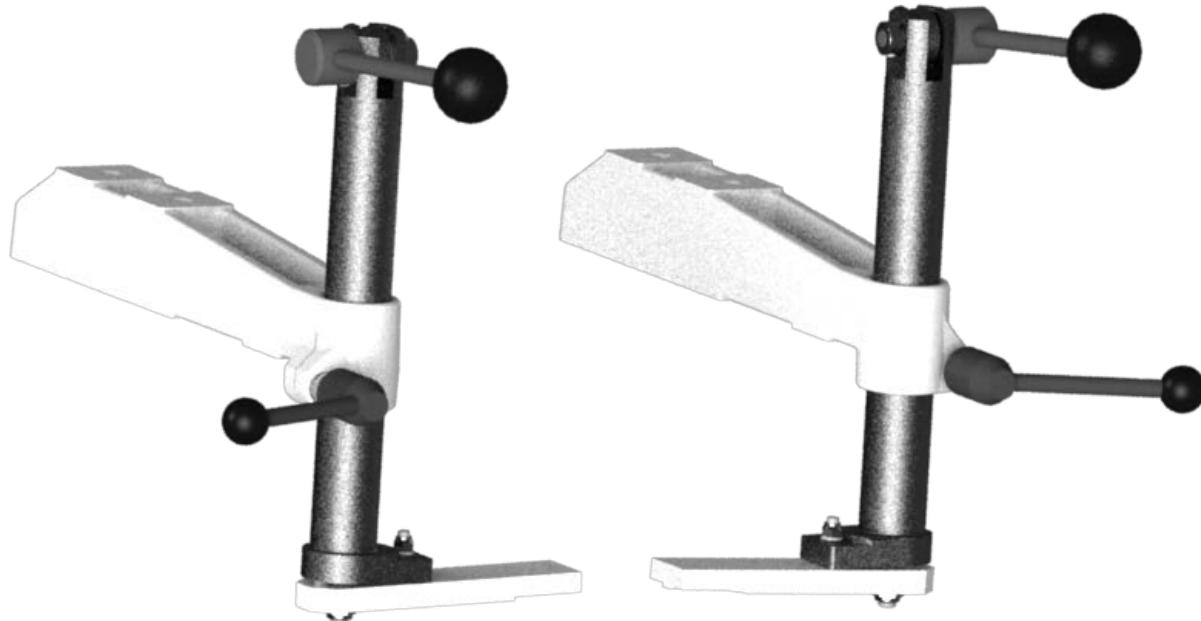
**514-11-4 Fixture Plate, CAT C175**



## FIXTURE ACCESSORIES

### 502-1-30H Clamp Arm Assembly

Set of 2, for blocks without main caps when using manual Roll Over Fixture and large in-line blocks without roll over fixture, max length of block 50" 1270mm



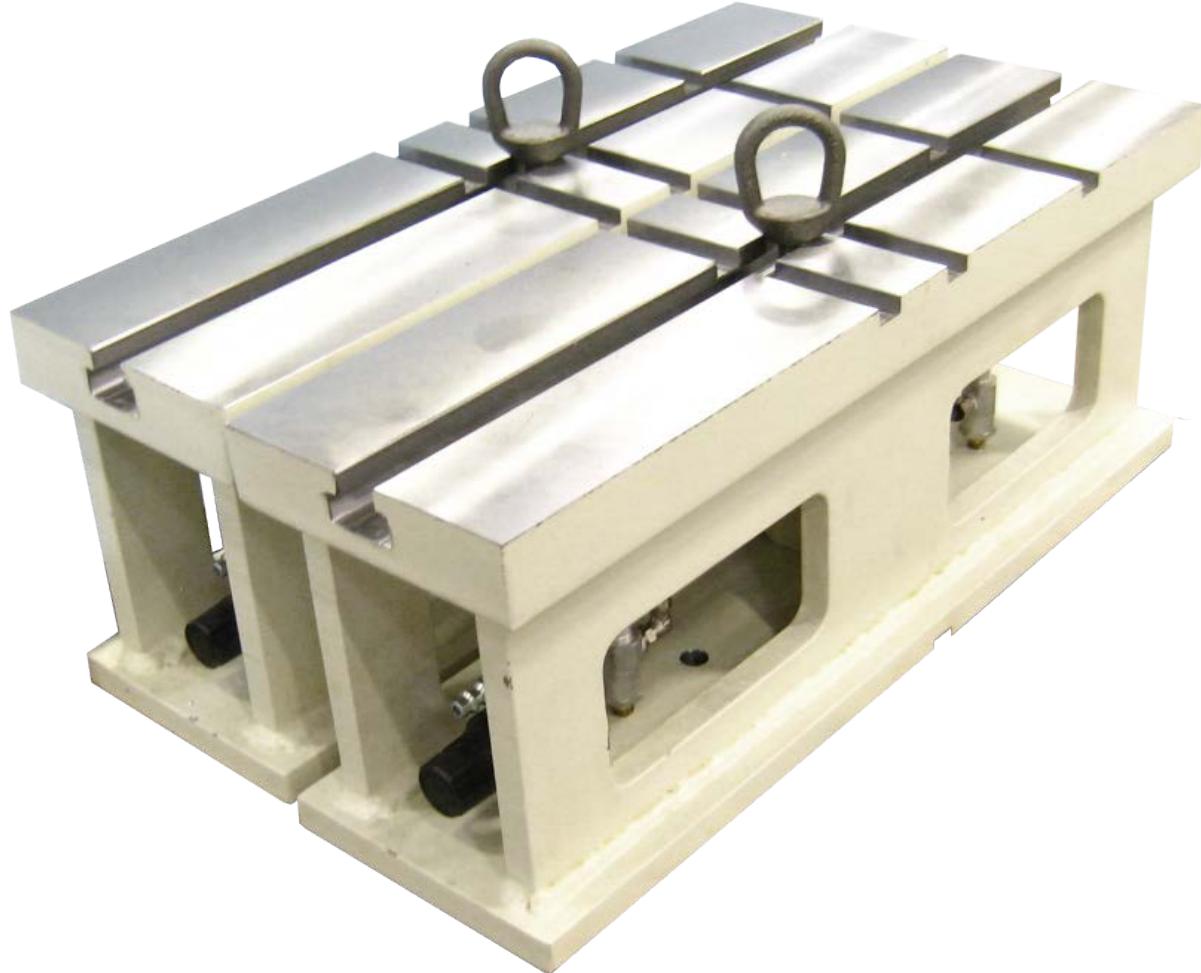
### 11115 2" (50mm) X 3" (75mm) Parallels

for general purpose machine work such as setting up small in-line blocks such as motorcycle or small single cylinders such as Harley



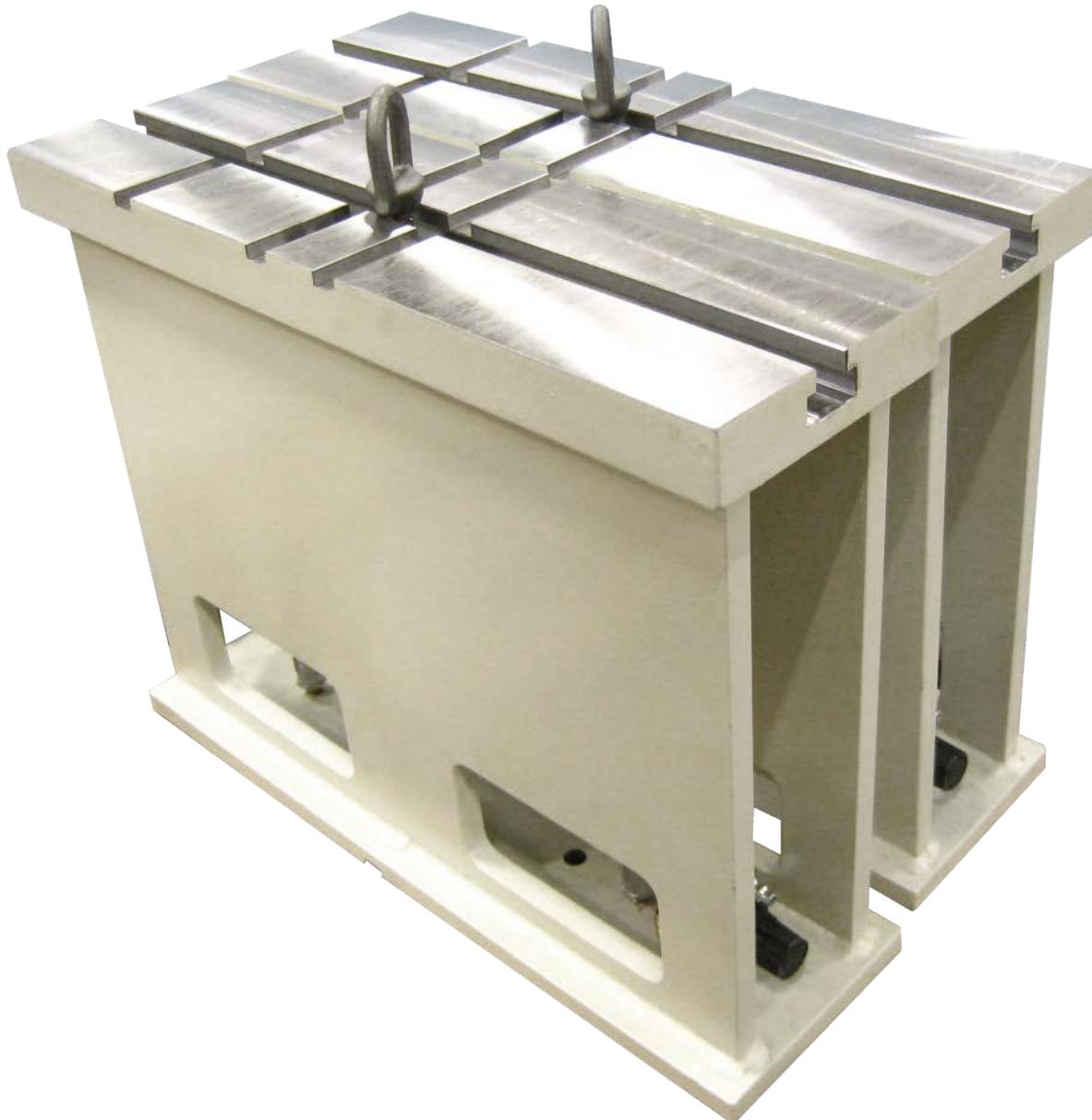
**11112 Universal 8" (203mm) Heavy Duty T-Slot Parallels**

for general purpose machine work such as setting up small in-line blocks such as motorcycle or small single cylinders such as Harley



**11114 Universal 16" (405mm) Heavy Duty T-Slot Parallels**

for general purpose machine work such as setting up small in-line blocks such as motorcycle or small single cylinders such as Harley



## COOLANT AND FILTER EQUIPMENT

### 514-4-71C Synthetic coolant

For use with diamond stones 5 gal (20 liter) (mix with water 20:1)



### 514-4-71 Coolant refractor

For measuring synthetic coolant to water mix ratio



**514-7-66D Filter paper**

For standard coolant system (minimum order of 25)



**514-2-39P Filter Cartridge 10 micron**

(replacement filter for 514-2-40) for synthetic coolant only



**514-2-39Q Filter Cartridge 20 micron**

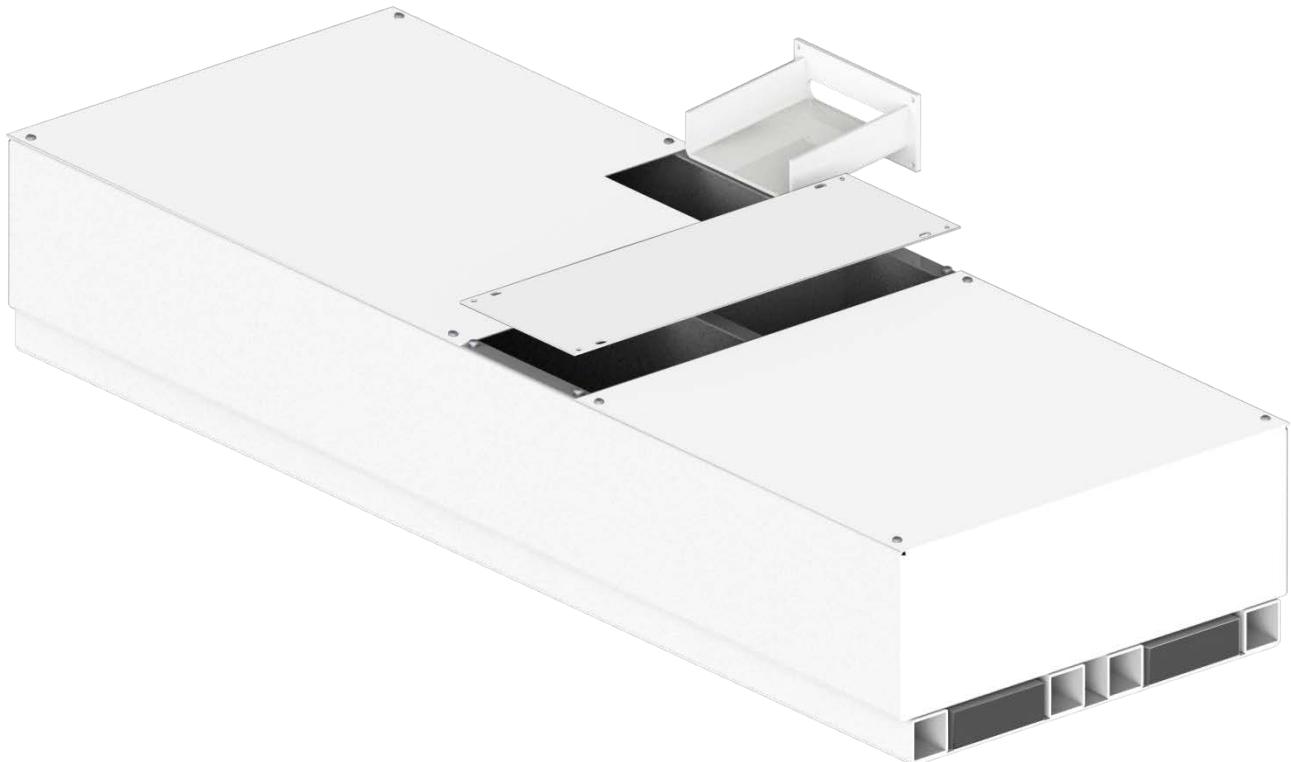
(replacement filter for 514-2-40) for synthetic coolant only

**514-2-39Z Filter Cartridge 150 micron**

(replacement filter for 514-2-40 for oil base coolant only)



**514-3-68W External Coolant Tank System**  
With High Volume Pump and Magnetic Filtration System



## HONE TOOLING

Optional Rottler Precision Hone Heads, Sleeves and Stone Holders

Diameters specified are with new stones with a maximum stone height of .312" (7.90mm)

### Medium Hone Head

#### 514-9J Medium Rottler Precision Hone Head Assembly

2.34 - 3.05" (59.44 - 77.47mm) Bore Diameter Range includes sleeve without stone holders - H70 Series Quick Change



#### 514-10-13A Stone holder

2.34 - 2.45" (59.44 - 62.23mm), set of 4



#### 514-10-13B Stone holder

2.54 - 2.65" (64.52 - 67.31mm), set of 4



#### 514-10-13C Stone holder

2.74 - 2.85" (69.60 - 72.39mm), set of 4



**514-10-13D Stone holder**

2.94 - 3.05" (74.68 - 77.47mm), set of 4



**Stone Holder Sizing Chart**

Diameter (New Stones) Inches				
	0.312	Stones	0.2	Stones
	Min	Max	Min	Max
514-13-13A	2.34	2.45	2.22	2.23
514-10-13B	2.54	2.65	2.32	2.43
514-10-13C	2.74	2.85	2.52	2.63
514-10-13D	2.94	3.05	2.72	2.83
Diameter (New Stones) (Metric)				
	7.9248	Stones	5.08	Stones
	Min	Max	Min	Max
514-13-13A	59.44	62.23	53.75	56.54
514-10-13B	64.52	67.31	58.83	61.62
514-10-13C	69.60	72.39	63.91	66.70
514-10-13D	74.68	77.47	68.99	71.78

Diameter (New Brushes ) Inches				
	0.55	Stones	0.395	Stones
	Min	Max	Min	Max
514-13-13A	2.82	2.93	2.51	2.62
514-10-13B	3.02	3.13	2.71	2.82
514-10-13C	3.22	3.33	2.91	3.02
514-10-13D	3.42	3.53	3.11	3.22
Diameter (New Brushes) (Metric)				
	13.97	Stones	10.033	Stones
	Min	Max	Min	Max
514-13-13A	71.53	74.32	63.65	66.45
514-10-13B	76.61	79.40	68.73	71.53
514-10-13C	81.69	84.48	73.81	76.61
514-10-13D	86.77	89.56	78.89	81.69

**Large Hone Head****514-9H Large Rottler Precision Heavy Duty Hone Head Assembly**

2.840" - 7.38" (72.14mm - 187.45mm) Bore Diameter Range without sleeves and stone holders - H70 Series Quick Change

**514-9-4A Sleeve assembly**

2.840" - 3.880" (72.14 - 98.55mm)



**514-9-6J Stone Holder**

2.990 - 3.44" (75.95 - 87.38mm)

set of 4 (Requires Sleeve 514-9-4A)

Note: To hone diameter 2.84" (72.14mm)

use 514-9-14D Stone Set .200" (5.1mm) height



**514-9-6A Stone Holder**

3.165 - 3.630" (80.39 - 92.20mm)

set of 4 (Requires Sleeve 514-9-4A)



**514-9-6B Stone Holder**

3.415 - 3.880" (86.74 - 98.55mm)

set of 4 (Requires Sleeve 514-9-4A)



**514-9-4B Sleeve assembly**

3.500 - 4.670" (88.00 - 118.62mm)



**514-9-6C Stone Holder**

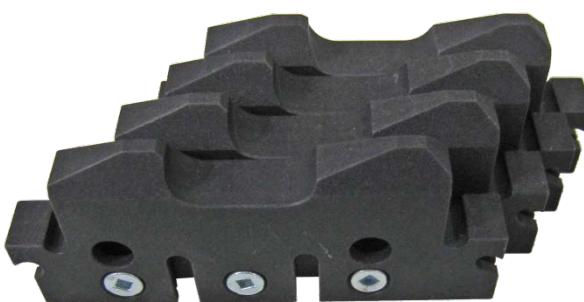
3.665 - 4.130" (93.09 - 104.90mm)  
set of 4 (Requires Sleeve 514-9-4B)

**514-9-6D Stone Holder**

3.915 - 4.380" (99.44 - 111.25mm)  
set of 4 (Requires Sleeve 514-9-4B)

**514-9-6E Stone Holder**

4.165 - 4.630" (105.79 - 117.60mm)  
set of 4 (Requires Sleeve 514-9-4B)

**514-9-4C Sleeve assembly**

4.250 - 7.380" (107.95 - 187.45mm)



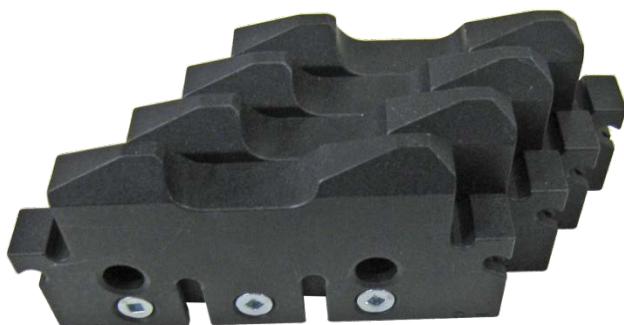
**514-9-6F Stone Holder**

4.415 - 4.880" (112.14 - 123.95mm)  
set of 4 (Requires Sleeve 514-9-4C)



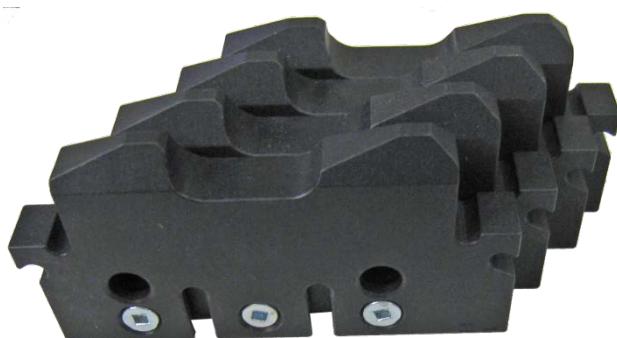
**514-9-6G Stone Holder**

4.665 - 5.130" (118.49 - 130.30mm)  
set of 4 (Requires Sleeve 514-9-4C)



**514-9-6H Stone Holder**

4.915 - 5.380" (124.84 - 136.65mm)  
set of 4 (Requires Sleeve 514-9-4C)



**514-9-6K Stone Holder**

5.165 - 5.630" (131.19 - 143.00mm)  
set of 4 (Requires Sleeve 514-9-4C)



**514-9-6L Stone Holder**

5.415 - 5.880" (137.54 - 149.35mm)  
set of 4 (Requires Sleeve 514-9-4C)

**514-9-6M Stone Holder**

5.665 - 6.130" (143.89 - 155.70mm)  
set of 4 (Requires Sleeve 514-9-4C)

**514-9-6N Stone Holder**

5.915 - 6.380" (150.24 - 162.05mm)  
set of 4 (Requires Sleeve 514-9-4C)



**514-9-6P Stone Holder**

6.165 - 6.630" (156.59 - 168.40mm)  
set of 4 (Requires Sleeve 514-9-4C)



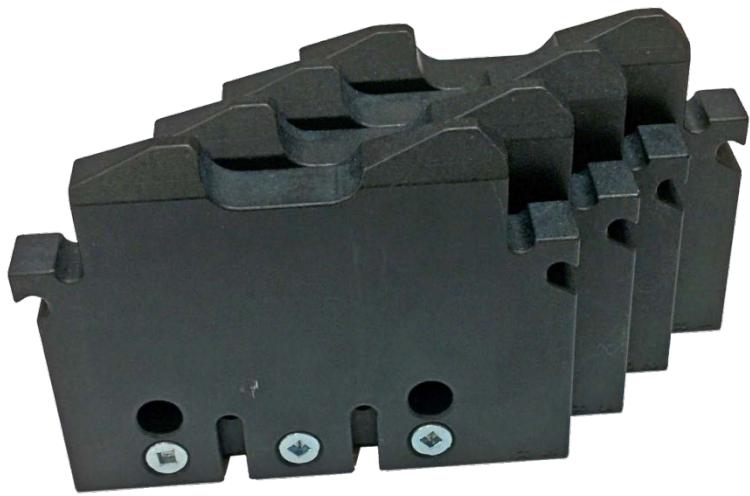
**514-9-6Q Stone Holder**

6.415 - 6.880" (162.94 - 174.75mm)  
set of 4 (Requires Sleeve 514-9-4C)



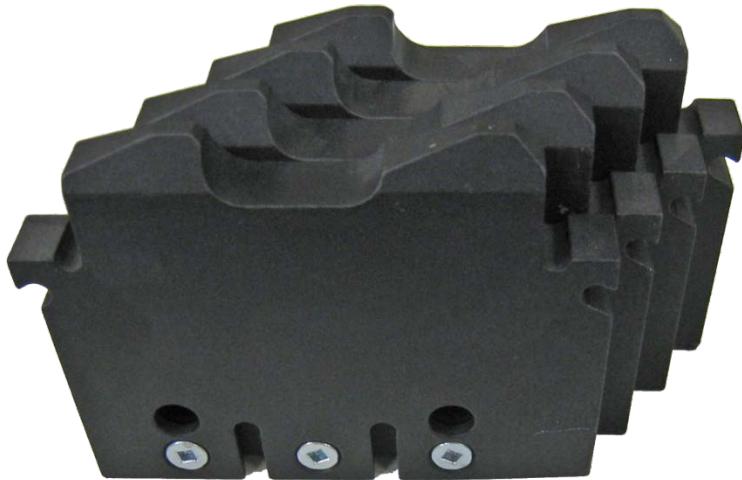
**514-9-6R Stone Holder**

6.665 - 7.130" (169.29 - 181.10mm)  
set of 4 (Requires Sleeve 514-9-4C)



**514-9-6S Stone Holder**

6.915 - 7.380" (175.64 - 187.45mm)  
set of 4 (Requires Sleeve 514-9-4C)



**Stone Holder Sizing Chart****Stones**

Diameter (New Stones) Inches				
	0.312	Stones	0.2	Stones
	Min	Max	Min	Max
514-9-5J	2.99	3.45	2.77	3.23
514-9-5A	3.17	3.63	2.94	3.41
514-9-5B	3.42	3.88	3.19	3.66
514-9-5C	3.67	4.13	3.44	3.91
514-9-5D	3.92	4.38	3.69	4.16
514-9-5E	4.17	4.63	3.94	4.41
514-9-5F	4.42	4.88	4.19	4.66
514-9-5G	4.67	5.13	4.44	4.91
514-9-5H	4.92	5.38	4.69	5.16
514-9-5K	5.17	5.63	4.94	5.41
514-9-5L	5.42	5.88	5.19	5.66
514-9-5M	5.67	6.13	5.44	5.91
514-9-5N	5.92	6.38	5.69	6.16
514-9-5P	6.17	6.63	5.94	6.41
514-9-5Q	6.42	6.88	6.19	6.66
514-9-5R	6.67	7.13	6.44	6.91
514-9-5S	6.92	7.38	6.69	7.16
Diameter (New Stones) (Metric)				
	7.9248	Stones	5.08	Stones
	Min	Max	Min	Max
514-9-5J	75.92	87.73	70.23	82.04
514-9-5A	80.39	92.20	74.70	86.51
514-9-5B	86.74	98.55	81.05	92.86
514-9-5C	93.09	104.90	87.40	99.21
514-9-5D	99.44	111.25	93.75	105.56
514-9-5E	105.79	117.60	100.10	111.91
514-9-5F	112.14	123.95	106.45	118.26
514-9-5G	118.49	130.30	112.80	124.61
514-9-5H	124.84	136.65	119.15	130.96
514-9-5K	131.19	143.00	125.50	137.31
514-9-5L	137.54	149.35	131.85	143.66
514-9-5M	143.89	155.70	138.20	150.01
514-9-5N	150.24	162.05	144.55	156.36
514-9-5P	156.59	168.40	150.90	162.71
514-9-5Q	162.94	174.75	157.25	169.06
514-9-5R	169.29	181.10	163.60	175.41
514-9-5S	175.64	187.45	169.95	181.76

**Brushes**

Diameter (New Brushes ) Inches				
	0.55	Stones	0.395	Stones
	Min	Max	Min	Max
514-9-5J	3.47	3.93	3.16	3.62
514-9-5A	3.64	4.11	3.33	3.80
514-9-5B	3.89	4.36	3.58	4.05
514-9-5C	4.14	4.61	3.83	4.30
514-9-5D	4.39	4.86	4.08	4.55
514-9-5E	4.64	5.11	4.33	4.80
514-9-5F	4.89	5.36	4.58	5.05
514-9-5G	5.14	5.61	4.83	5.30
514-9-5H	5.39	5.86	5.08	5.55
514-9-5K	5.64	6.11	5.33	5.80
514-9-5L	5.89	6.36	5.58	6.05
514-9-5M	6.14	6.61	5.83	6.30
514-9-5N	6.39	6.86	6.08	6.55
514-9-5P	6.64	7.11	6.33	6.80
514-9-5Q	6.89	7.36	6.58	7.05
514-9-5R	7.14	7.61	6.83	7.30
514-9-5S	7.39	7.86	7.08	7.55
Diameter (New Brushes) (Metric)				
	13.97	Stones	10.033	Stones
	Min	Max	Min	Max
514-9-5J	88.01	99.82	80.14	91.95
514-9-5A	92.48	104.29	84.61	96.42
514-9-5B	98.83	110.64	90.96	102.77
514-9-5C	105.18	116.99	97.31	109.12
514-9-5D	111.53	123.34	103.66	115.47
514-9-5E	117.88	129.69	110.01	121.82
514-9-5F	124.23	136.04	116.36	128.17
514-9-5G	130.58	142.39	122.71	134.52
514-9-5H	136.93	148.74	129.06	140.87
514-9-5K	143.28	155.09	135.41	147.22
514-9-5L	149.63	161.44	141.76	153.57
514-9-5M	155.98	167.79	148.11	159.92
514-9-5N	162.33	174.14	154.46	166.27
514-9-5P	168.68	180.49	160.81	172.62
514-9-5Q	175.03	186.84	167.16	178.97
514-9-5R	181.38	193.19	173.51	185.32
514-9-5S	187.73	199.54	179.86	191.67

## ABRASIVES

Abrasives for Rottler Precision Hone Heads

NOTE: Ra - Roughness Average. Value before Ra is in micro inches. Value in brackets um is micro meters.  
Long designates length of stone. Height designated thickness of stone.

### Diamond Stones

.312" (7.90mm) Height

#### 514-9-14F Diamond stones, 80 grit

3" (76mm) long, 90Ra (2.25um)

stock removal .004-.007/min.



#### 514-9-14R Diamond stones, 80 grit

3 1/2" (89mm) long, 90Ra (2.25um)

stock removal .004-.007/min. (.102 - .178mm)



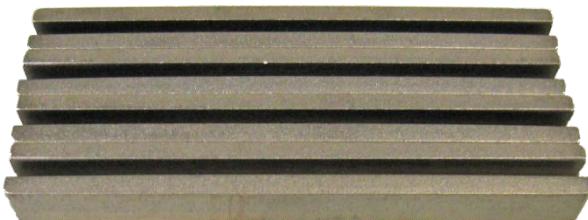
#### 514-9-14W Diamond stones, 140/170 grit

3" (76mm) long, 50-75Ra (1.25 - 1.875um)



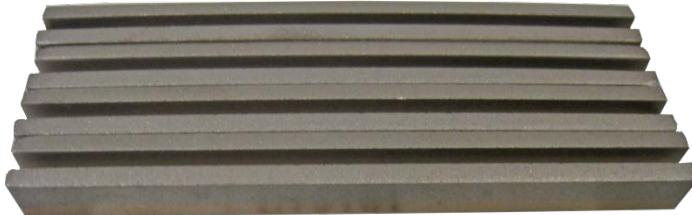
#### 514-9-14K Diamond stones, 170/200 grit

3" (76mm) long, 45-60Ra (1.125 - 1.5um)



**514-9-14M Diamond stones, 170/200 grit**

3 1/2" (89mm) long, 45-60Ra (1.125 - 1.5um)

**514-9-14J Diamond stones, 270/325 grit**

3" (76mm) long, 35-45Ra (.875 - 1.125um)

**514-9-14T Diamond stones, 270/325 grit**

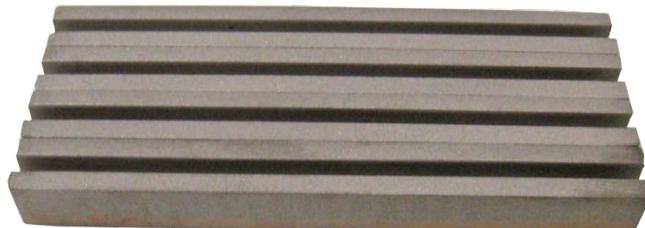
3 1/2" (89mm) long, 35-45Ra (.875 - 1.125um)

**514-9-14Z Diamond Stones, 270/325 grit**

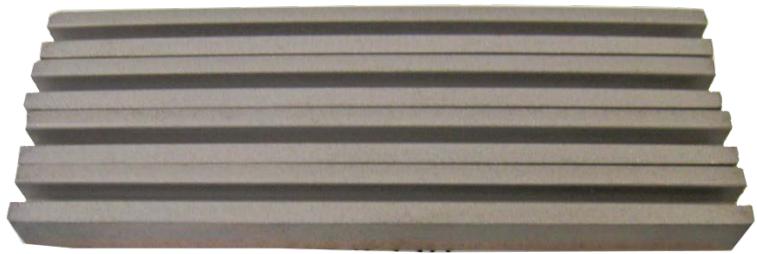
4" (102mm) long, 35-45Ra (.875 - 1.125um)

**514-9-14E Diamond stones, 325/400 grit**

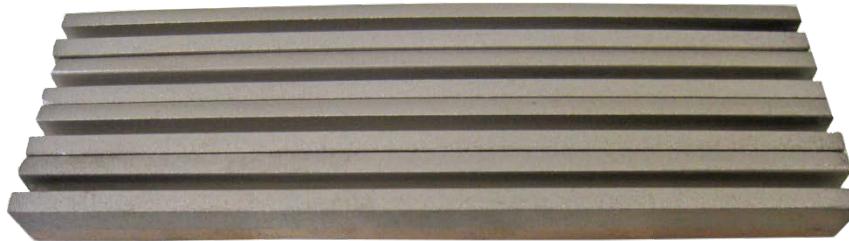
3" (76mm) long, 24-30Ra (.6 - .75um)



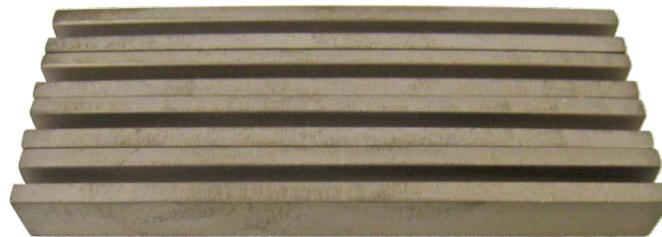
**514-9-14Q Diamond stones, 325/400 grit**  
3 1/2" (89mm) long, 24-30Ra (.6 - .75um)



**514-9-14X Diamond stones, 325/400 grit**  
4" (102mm) long, 24-30Ra (.6 - .75um)



**514-9-14V Diamond stones, 400 grit**  
3" (76mm) long, 15-19Ra (.375 - .475um)



**514-9-14C Diamond stones, 500 grit**  
3" (76mm) long, 18-22Ra (.45 - .55um)



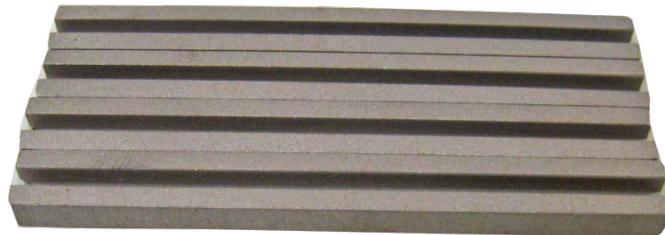
**514-9-14P Diamond stones, 500 grit**  
3-1/2" (89mm) long, 18-22Ra (.45 - .55um)



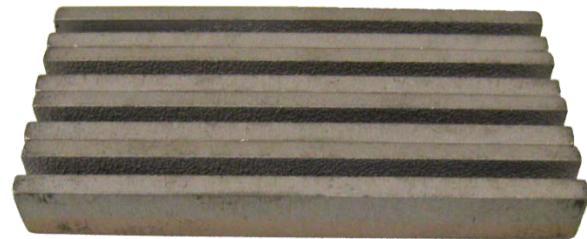
**514-9-14D Diamond stones, 325/400 grit**

3" (76mm) long, 18-22Ra (.45 - .55um)

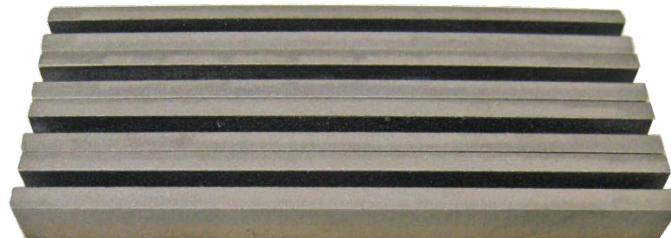
Special required for bores under 2.990" diameter (75.94mm) .200" (5.1mm) Height

**514-9-14U Diamond stones, 500 grit**

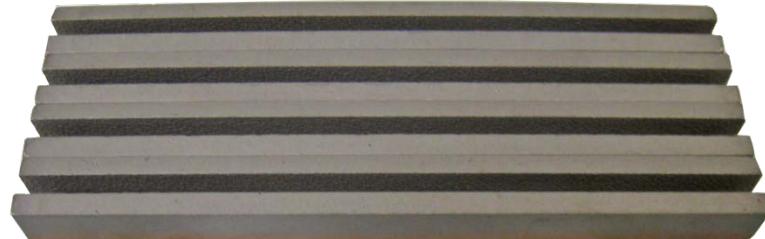
2 1/2" (64mm) long, 18-22Ra (.45 - .55um)

**514-9-14L Diamond stones, 550 grit**

3" (76mm) long, 15-19Ra (.375 - .475um)

**514-9-14N Diamond stones, 550 grit**

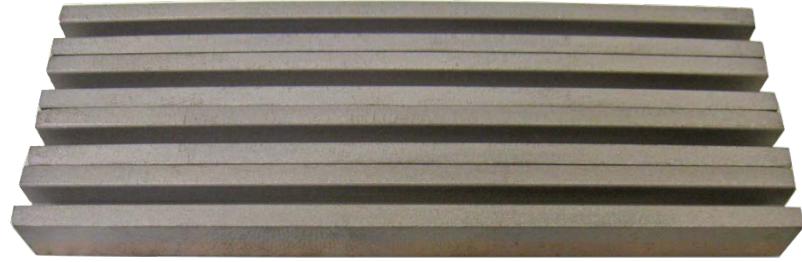
3 1/2" (89mm) long, 15-19Ra (.375 - .475um)



**514-9-14G Diamond stones, 600 grit**  
3" (76mm) long, 8-12Ra (.2 - .3um)



**514-9-14S Diamond stones, 600 grit**  
3 1/2" (89mm) long, 8-12Ra (.2 - .3um)



**514-9-21G Diamond stones, 800 grit**  
3" (76mm) long



**514-9-21H Diamond stones, 1000 grit**  
3" (76mm) long



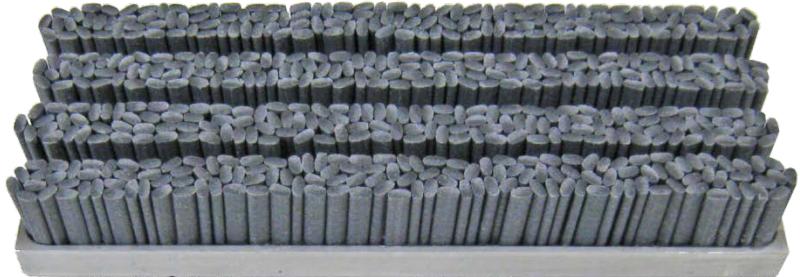
**514-9-21J Diamond stones, 1200 grit**  
3" (76mm) long



## Brushes for Plateau Finishing

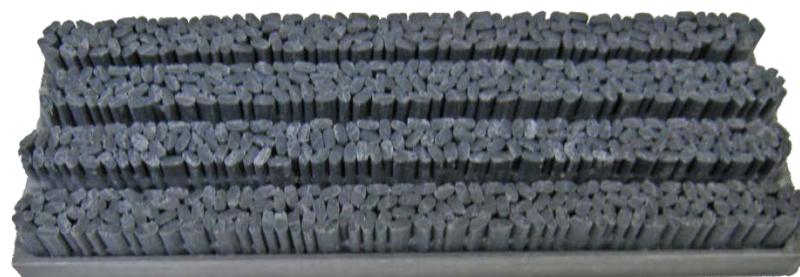
### 514-9-14H Brushes

For Plateau Finishing, .550" (14mm) height, 3 1/2" (89mm) long, requires one or two size smaller stone holder compared to .312" (7.90mm) height diamond stone. For diameter range, please see machine manual.



### 514-9-14Y Brushes

For Plateau Finishing, .395" (10mm) height, 3 1/2" (89mm) long, requires same or one size smaller stone holder compared to .312" (7.90mm) height diamond stone. For diameter range, please see machine manual.



## Special Stones for Finishing Aluminum Silicone Cylinders

(Refer to bulletin No. 284) Requires Rottler Precision Hone Heads

### 514-9-18P Special Red Finish Diamonds

For Final Sizing (set of 4)



### 514-9-18N Silicone Abrasive Exposing Stones

For Removing Aluminum (set of 4)



### 514-9-21 Polishing felt pads

For use with 514-9-21F silicon paste. (set of 4)

### 514-9-21F Silicone Paste

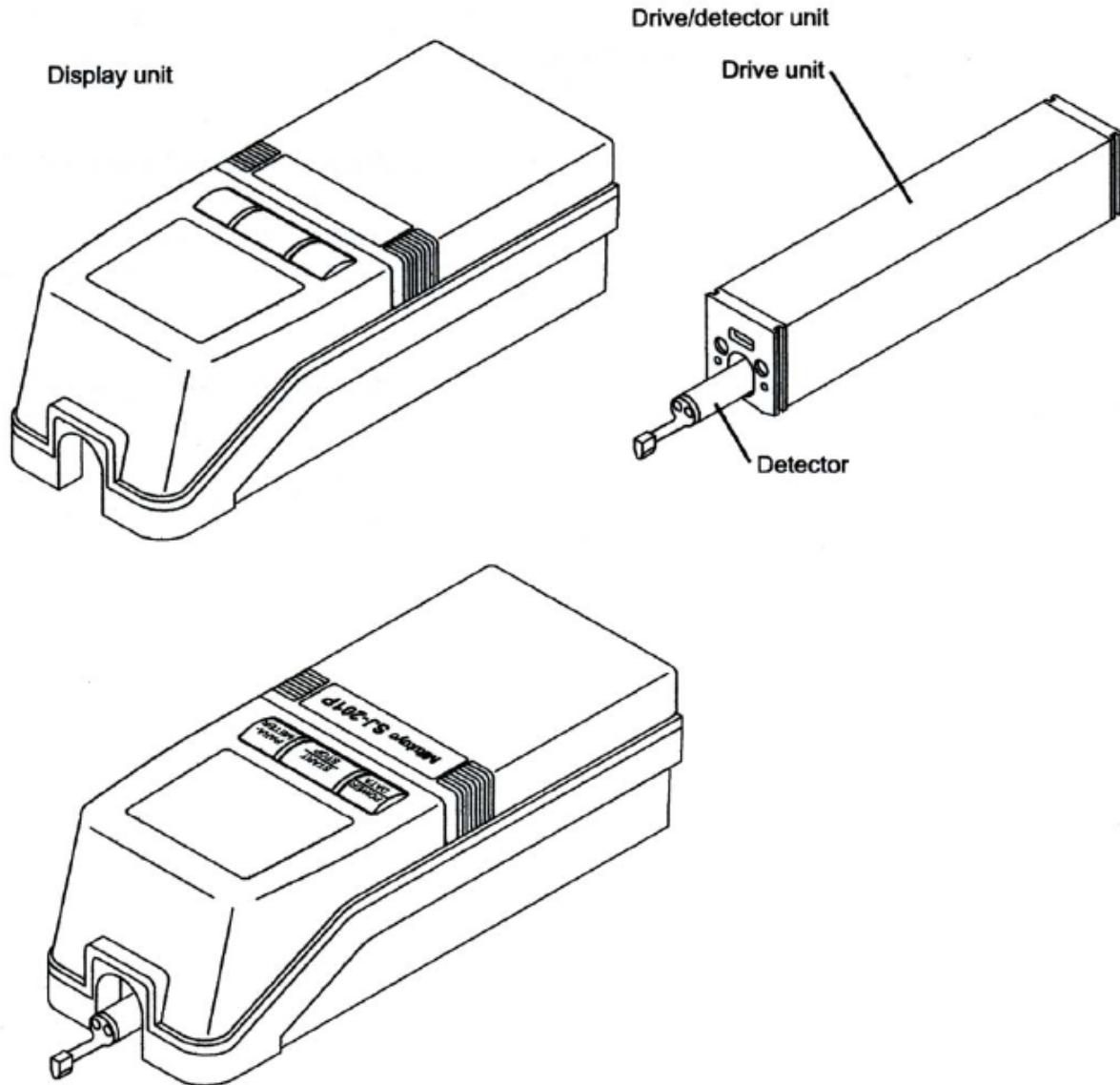
For use with 514-9-21 Polishing felt pads



## MEASURING EQUIPMENT

### 201 Mitutoyo Surface Tester

Surftest 201



**514-8-27 Stone Depth Scale and Holder Assembly (inch)**

**514-8-27F Stone Depth Scale and Holder Assembly (metric)**

