

ROTTLER

EM79 CNC MACHINING CENTER 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

EM79 OPTIONAL EQUIPMENT PARTS MANUAL

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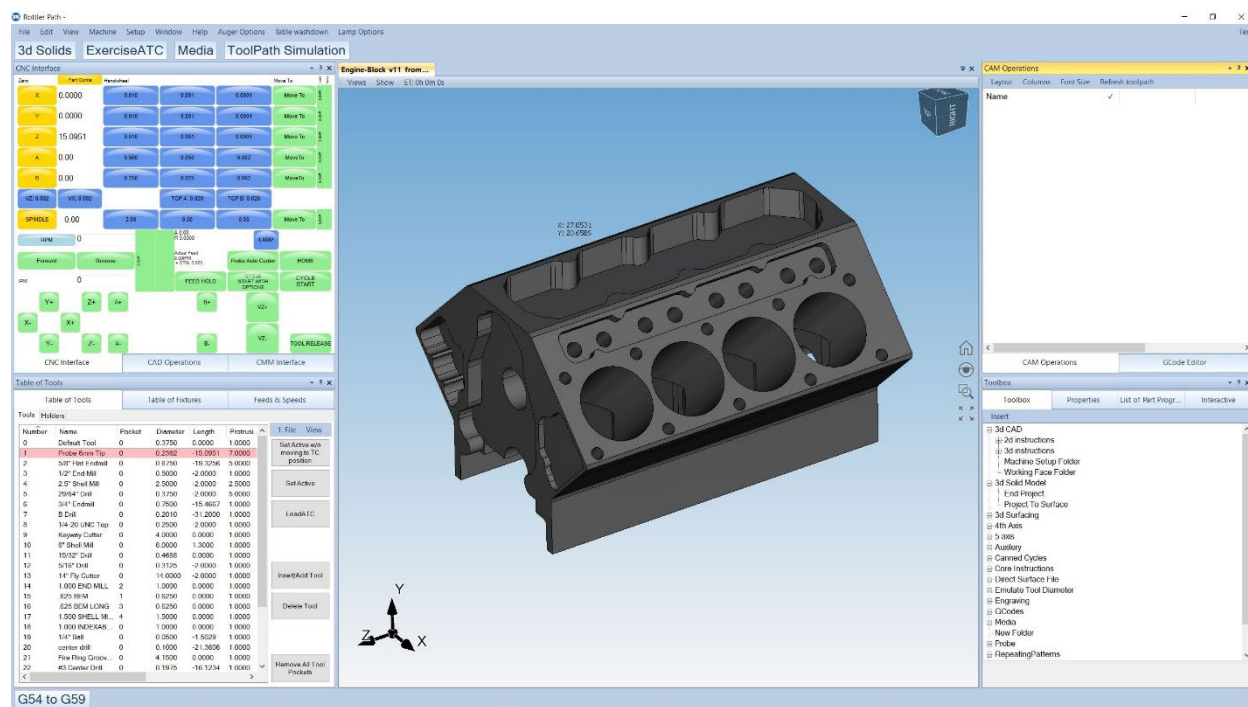
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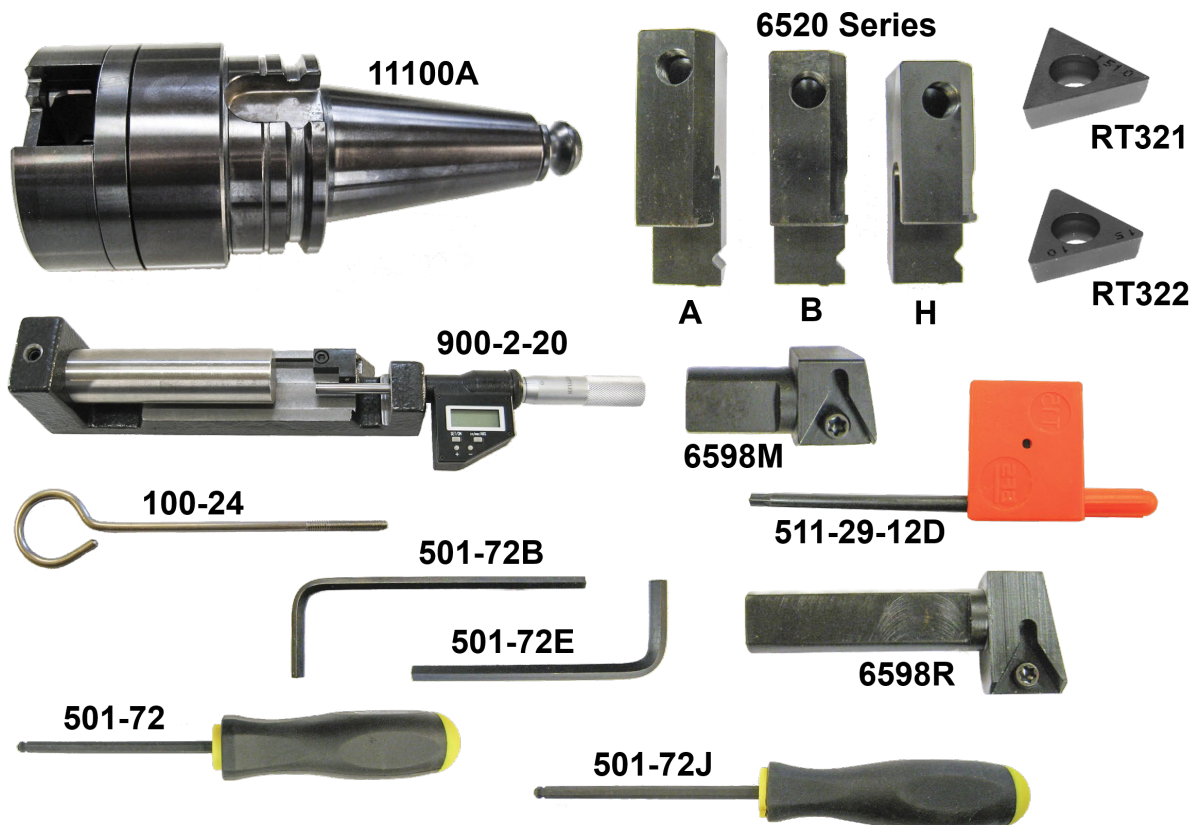
RPATH-4C Software Package

Next Generation Toolpath Software powered by 4C allows users to quickly and easily produce CNC toolpath programs for producing custom parts and fixtures. Intuitive Conversational programming with no G-code knowledge necessary for 2+1 axis machining.



Cutting Tools**Boring Tools****650-2-1D Cutterhead Package Components**

650-2-3T Cutterhead Package Components

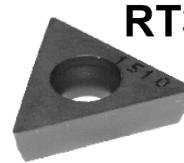
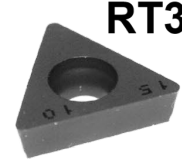
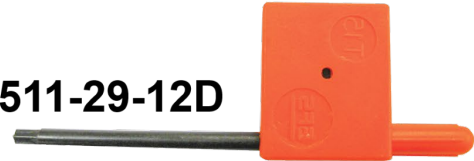
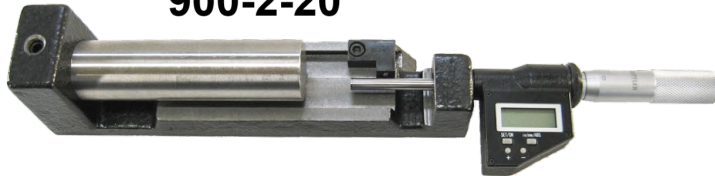
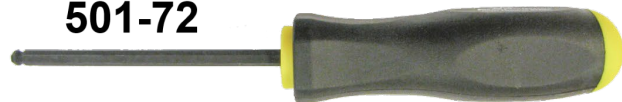
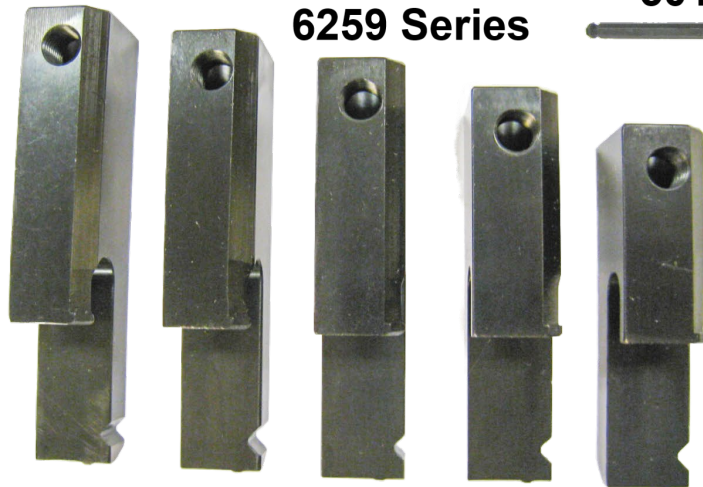
11100 Cutterhead Package Components

650-2-15F Cutterhead Package Components

650-2-14B Cutterhead Package Components**650-2-16D 1400" (355mm) Spacer (Extension)**

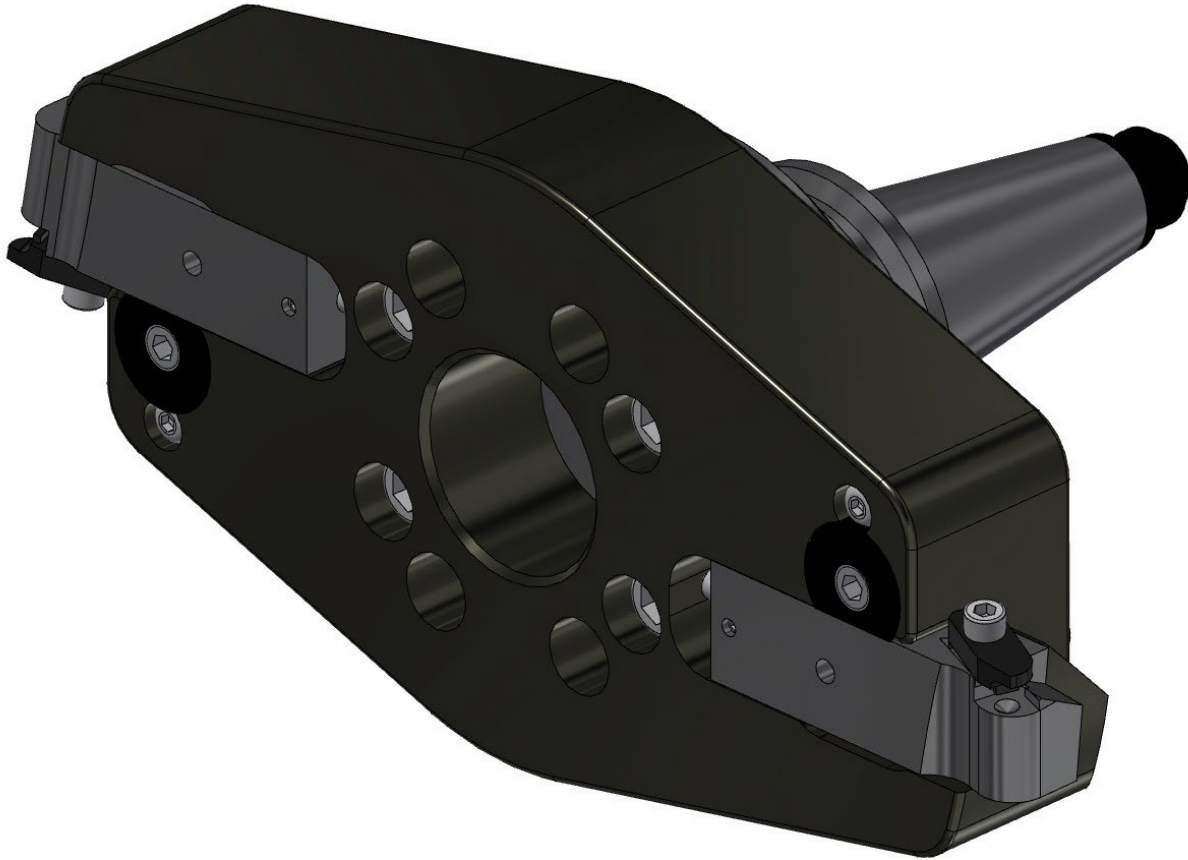
For use with 650-2-14B Cutterhead Sold only as complete assembly.

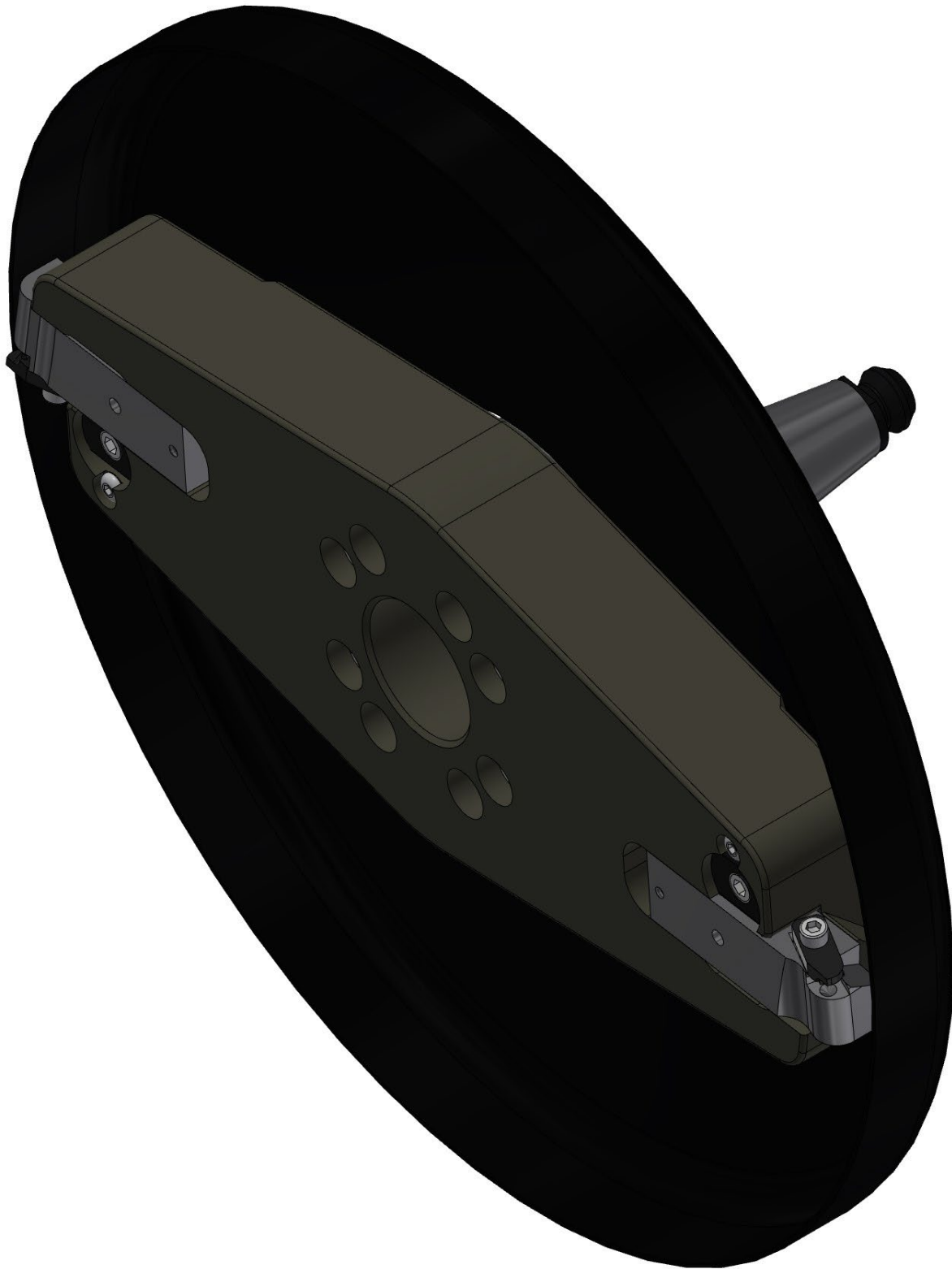


11101 Heavy Duty Cutter Head Package Components**11101A****RT321****RT322****511-29-12D****900-2-20****6598K****501-72****6259 Series****6598R****6598M**

Surfacing Tools

650-2-8E Surfacing Cutterhead, 10" (254mm Diameter Parts)



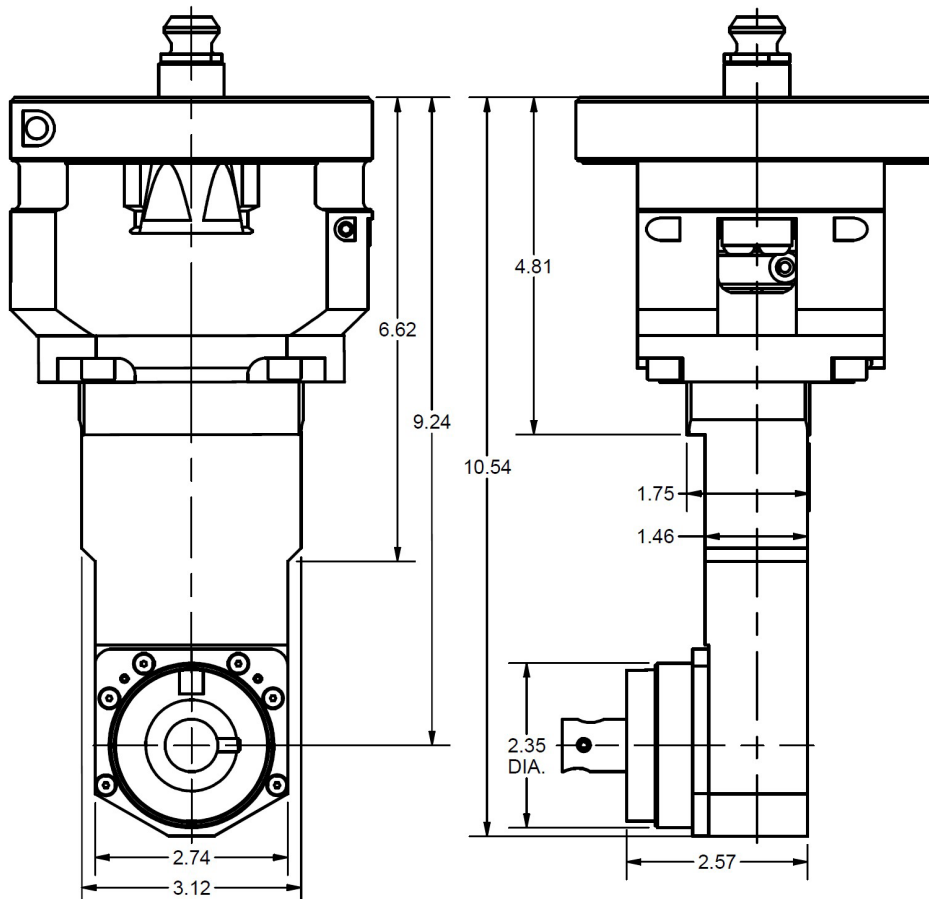
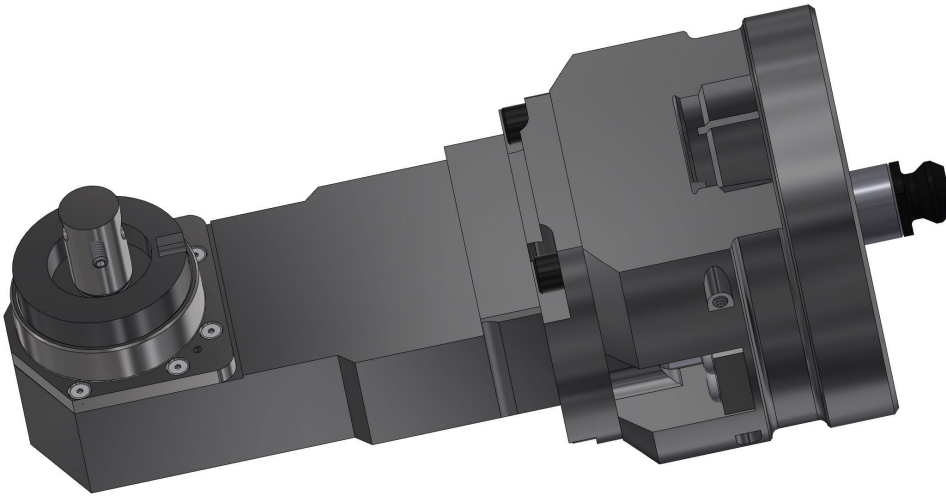
650-2-8F Surfacing Cutterhead, 14" (356mm) Diameter Parts

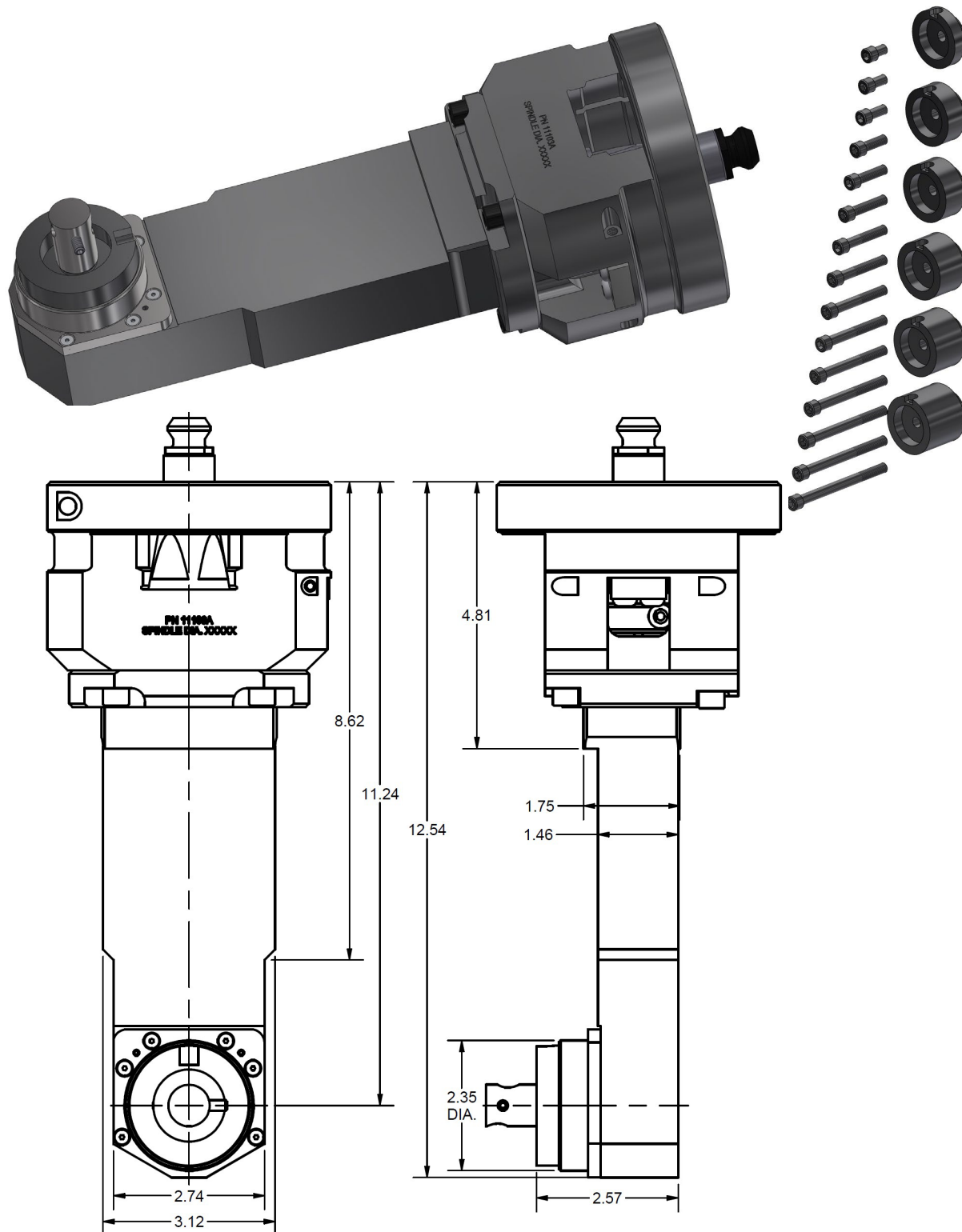
650-2-44N Shell Mill, 2" (50.8mm)

650-2-44P Shell Mill, 4" (10160mm)

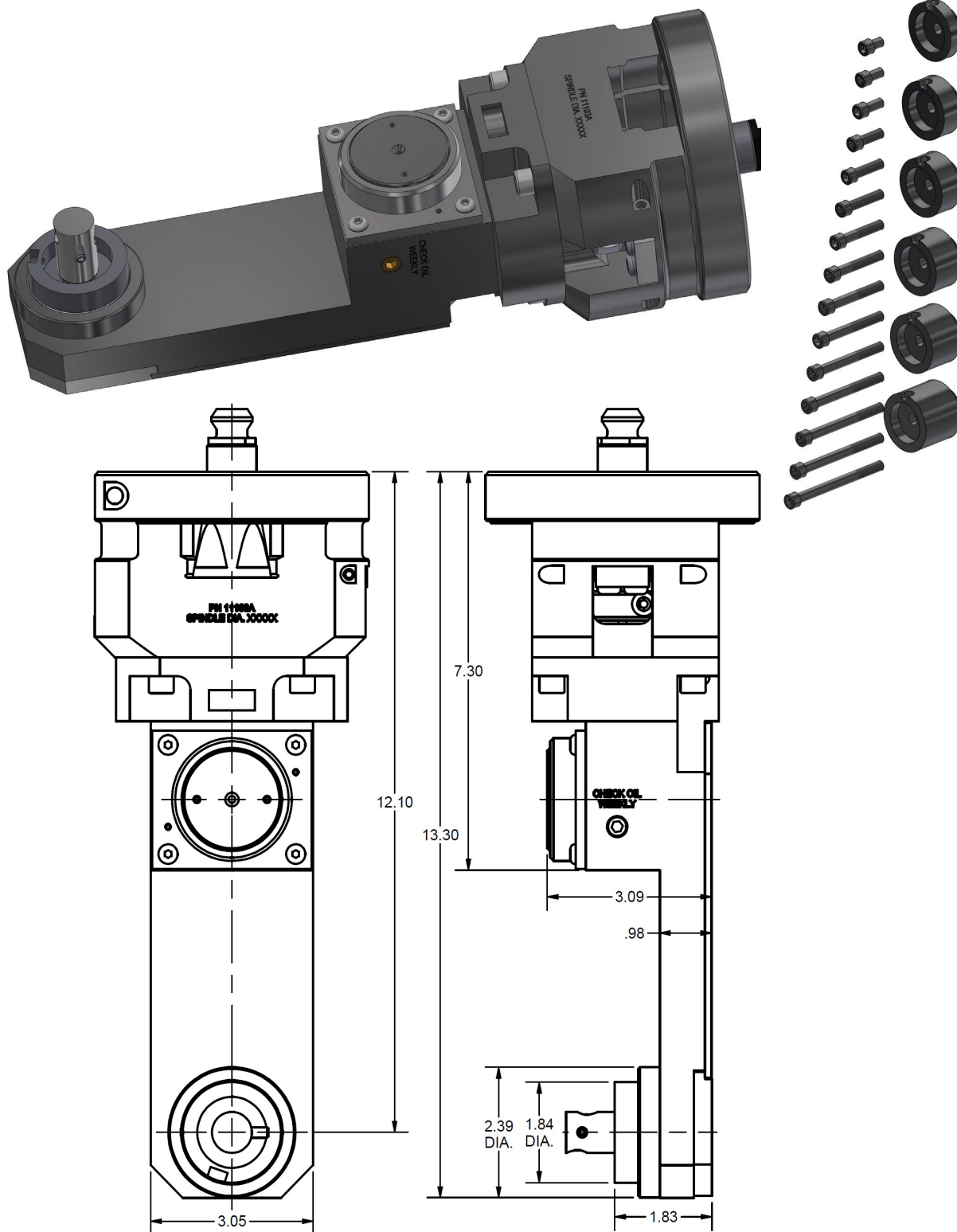
Right Angle Drives

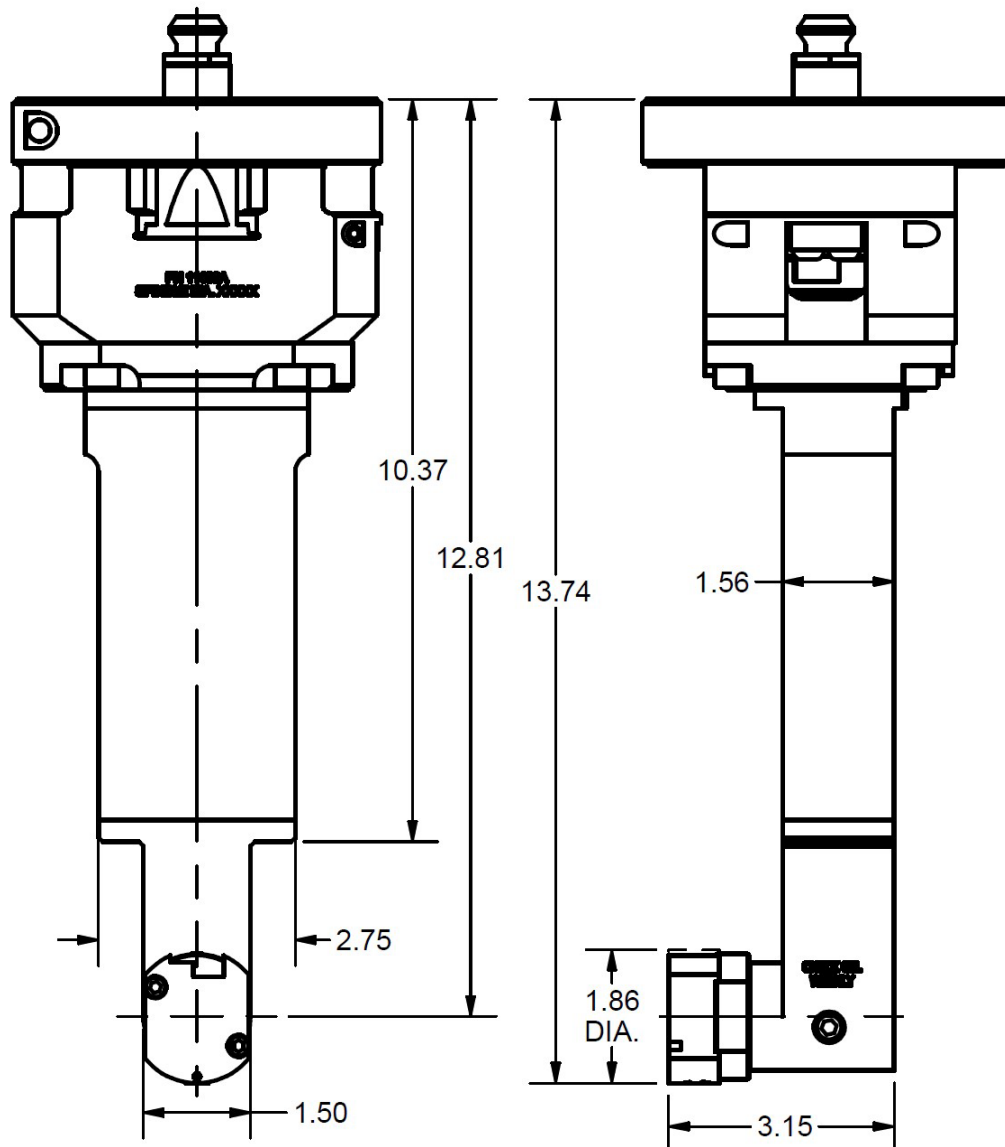
11103 Main Line Bore 90 Degree Right Angle Drive



11103E Main Line Bore 90 Degree Right Angle Drive, 2" Extended

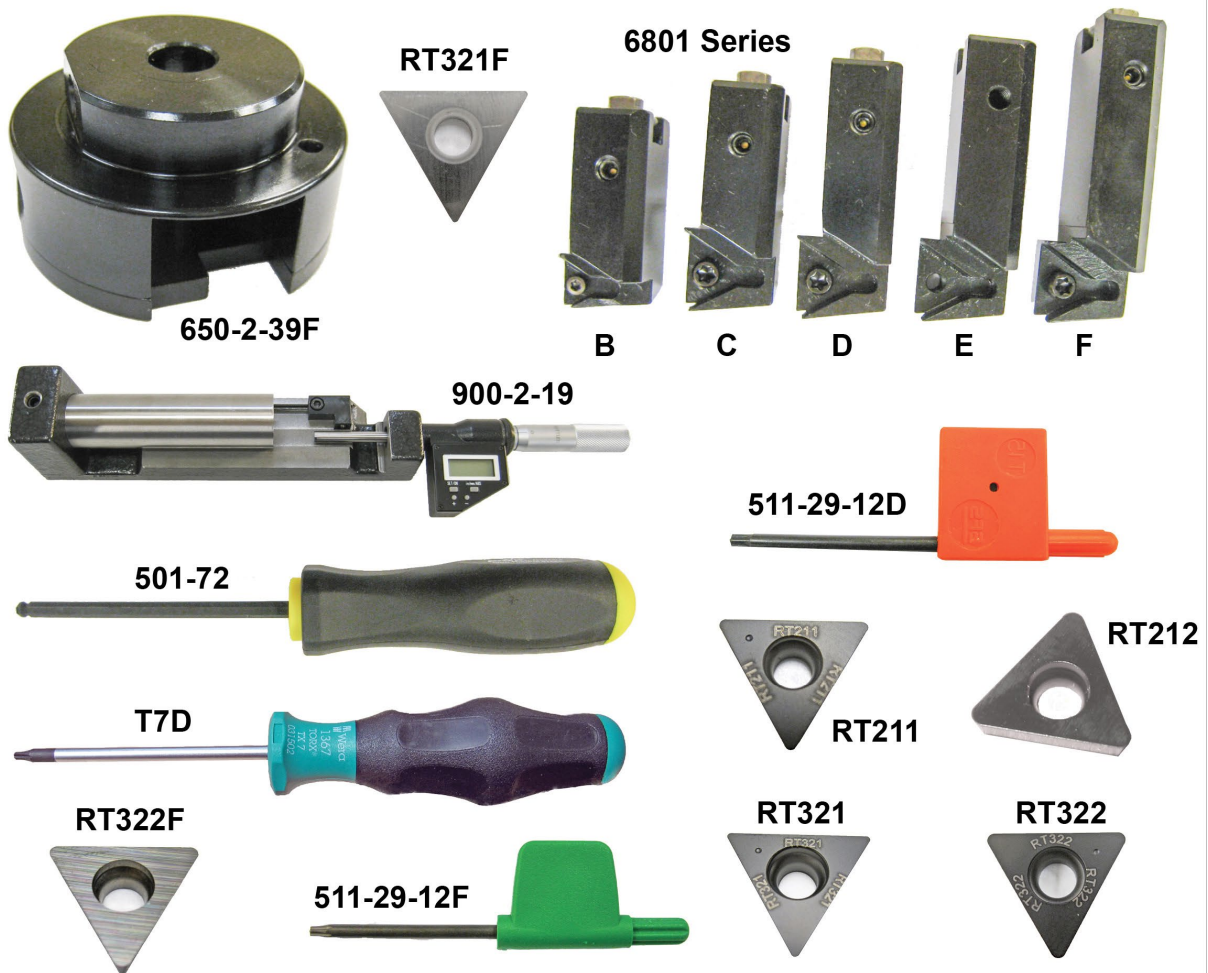
11104 Special Belt Drive 90 Degree Right Angle Drive

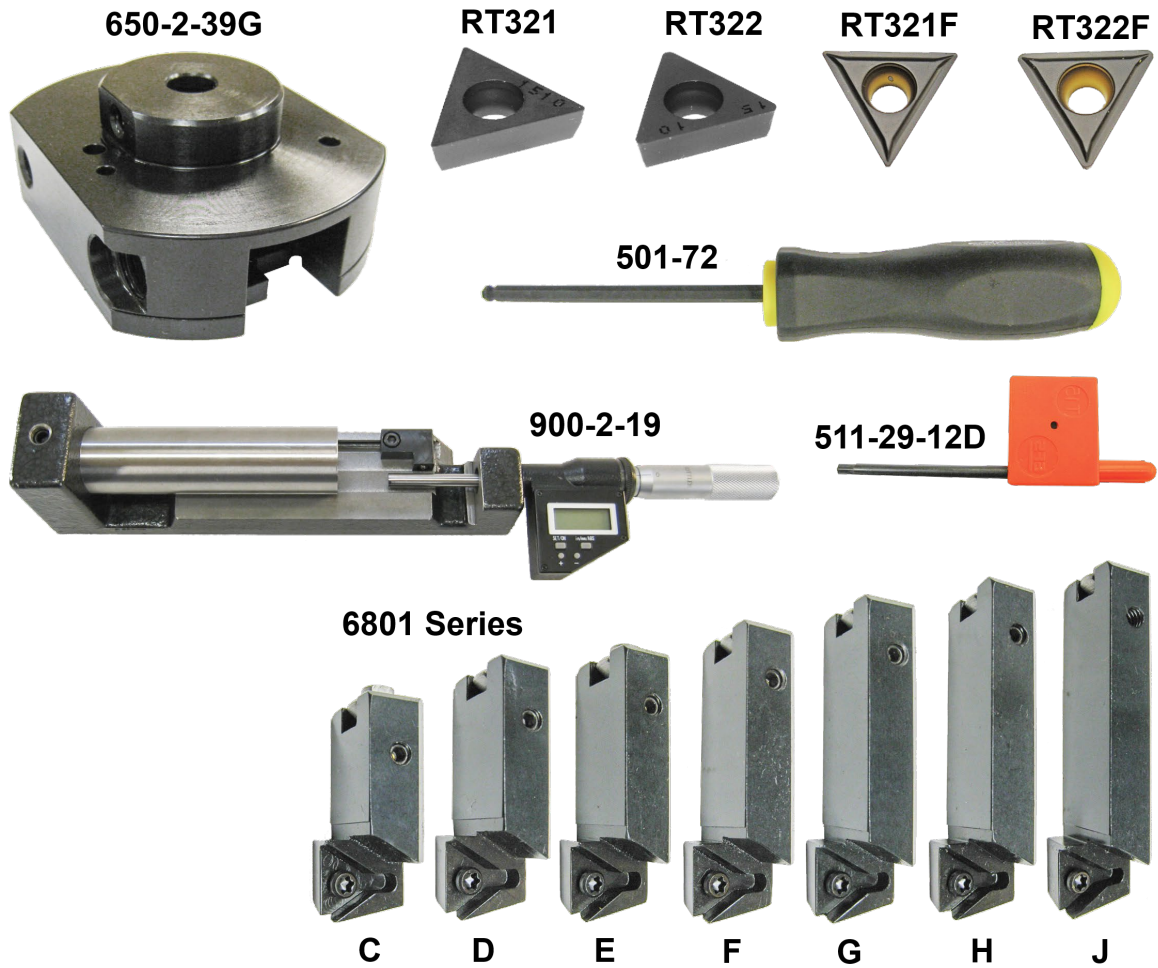


11105 Narrow Right Angle Drive

Right Angle Drive Accessories

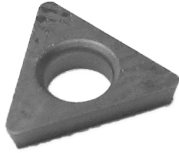
650-2-39B Line Boring Cutterhead Package Components



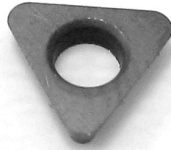
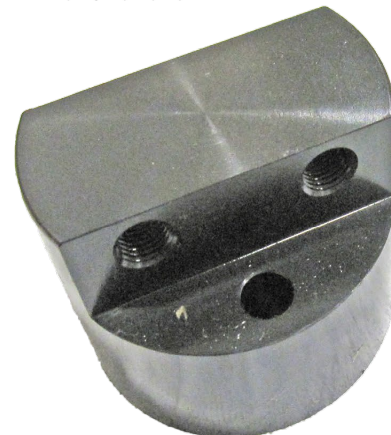
650-2-39C Line Boring Cutterhead Package Components

**501-29-6G Insert,
Triangular**

.160 IC 1/64" (.397mm) Radius

**501-29-6J Insert,
Triangular**

.160 IC 1/32" (.787mm) Radius

**501-29-6H Insert Screw****6855Q Thrust Facing Tooling Package Components****6855****6855D****6855J****6855A****6855E**

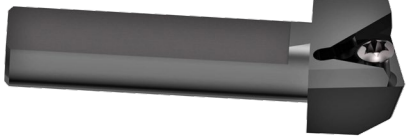
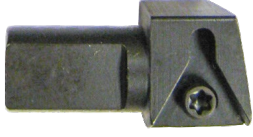
Special Main Line Boring Chamfering Tools**199-90 Tool Holder, 2 - 3"
(5080 - 7620mm)****199-96 Tool holder, 3 - 4"
(7620 - 10160mm)****501-33E Tool Bit, 45-
Degree
Chamfer**

Insert Holders

Tool Holder Diameter Ranges by Cutterhead Size

Cutterhead Diam	Centerline Offset	Tool Holder	CAT40	650-2-76A		-		-	
			ROTTLER	6516C / G / Q / T		-		-	
			HSK80	10118A		-		-	
			RAD	-		650-2-39G		650-2-39E	
			OL	(1.5")		(2.82")		(5.4")	
1.5"	-0.655"		6801A	1.23	1.5	2.02	-	-	-
2.82"	-0.500"		6801B	1.44	1.93	2.53	-	-	5.4
2.88"	-1.080"		6801C	1.56	2.3	2.9	2.82	3.2	5.46
4.5"	-1.762"		6801D	1.85	-	-	2.99	3.59	5.85
5.4"	0.960"		6801E	2.05	-	-	3.4	4	6.26
7.75"	-0.280"		6801F	2.25	-	-	3.8	4.4	6.66
12"	1.570"		6801G	2.45	-	-	4.2	4.8	7.06
14"	3.000"		6801H	2.56	-	-	4.63	5.23	7.49
									8.09

Tool Holder	OL W/O Tool Bit	CAT40	650-2-14A / C / G / J		11101A		-		-		-	
		ROTTLER	6519Y		6256P		6464H		6588A		6587D	
		HSK80	10108 / 10131A		10103A / 10116A / 10117A		10107		10104		10105B	
		RAD	6519U / S / Q / R		-		6779F		-		-	
		Tool Bit	(2.88")		(4.5")		(7.75")		(12")		(14")	
6593C	2.75	-	2.92	3.35	-	-	-	-	-	-	-	-
6593D	2.97	-	3.36	3.79	-	-	-	-	-	-	-	-
6520H	2.25	6598M	3.48	3.88	-	-	-	-	-	-	-	-
6520A	2.38	6598M	3.74	4.24	-	-	-	-	-	-	-	-
6520B	2.63	6598K	5.57	6.74	-	-	-	-	-	-	14	15.84
6520C	2.88	6598K	-	-	-	-	-	-	-	-	14	16.25
6520D	3.13	6598K	-	-	-	-	-	-	-	-	14	15.13
6520E	3.38	6598K	-	-	4.55	5.85	7.75	8.8	-	-	14	15.3
6520F	3.63	6598K	-	-	5.05	6.35	8	9.3	12	12.82	14.5	15.8
6520G	4.13	6598K	-	-	6.05	7.35	9	10.3	12.52	13.82	15.5	16.8
6259P	3.13	6598K	-	-	5.63	6.64	8.58	9.59	12.1	13.11	15.08	16.09
6259C	3.38	6598K	-	-	5.73	7.14	8.68	10.09	12.2	13.61	15.18	16.59
6259D	3.63	6598K	-	-	5.63	7.64	8.58	10.59	12.1	14.11	15.08	17.09
6259I	3.88	6598K	-	-	5.63	8.05	8.58	11	12.1	14.52	15.08	17.5
6259E	4.13	6598K	-	-	6.04	7.34	8.99	10.29	12.51	13.81	15.49	16.79
6259F	4.63	6598K	-	-	7.04	8.34	9.99	11.29	13.51	14.81	16.49	17.79
6259G	5.13	6598K	-	-	-	-	10.99	12.29	-	-	17.49	18.79
6259H	5.63	6598K	-	-	-	-	-	-	-	-	18.49	19.79
6259J	6.13	6598K	-	-	-	-	-	-	-	-	19.49	20.79
6259M	7.63	6598K	-	-	-	-	-	-	-	-	22.49	23.79

6593S Cartridge, Triangular For Circular Interpolation Counterbore Facing 	6598M Cartridge, Triangular, 13/16" (20mm) length For Counterboring 
6598K Cartridge, Triangular, 1-7/8" (48mm) length For Counterboring 	6598R Cartridge, Triangular Offset 250 (64mm) For Blind Holes 
6513J Tool bit, Brazed Carbide - 037" (940mm) Wide O Ring Grooving 	6513L Tool bit, Brazed Carbide - 039" (991mm) Wide O Ring Grooving 
6513N Tool bit, Brazed Carbide - 060" (1524mm) Wide O Ring Grooving 	6513Q Tool bit, Brazed Carbide - 120" (3048mm) Wide O Ring Grooving 
6513P Tool bit, Brazed Carbide - 085" (2159mm) Wide O Ring Grooving 	6747K Cartridge, Triangular - 5 Degree Chamfer 

6747P Cartridge, Triangular - 10 Degree Chamfer



6747G Cartridge, Triangular - 15 Degree Chamfer



6747F Cartridge, Triangular- 20 Degree Chamfer



6747M Cartridge, Triangular - 20 Degree Chamfer

(Special Application Only)

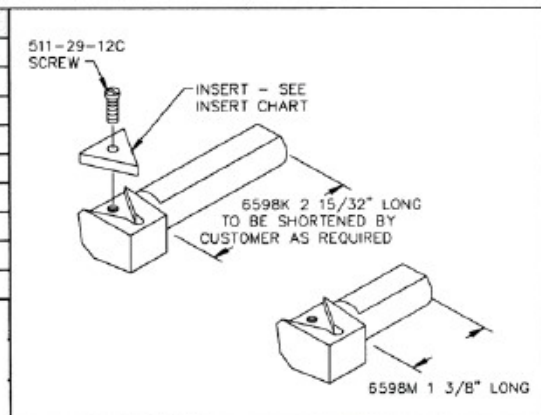


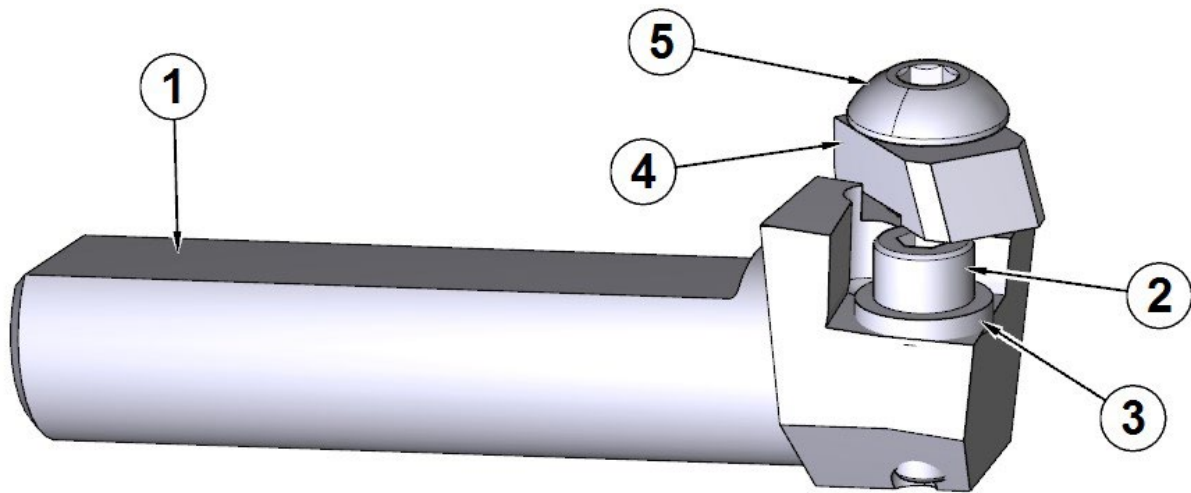
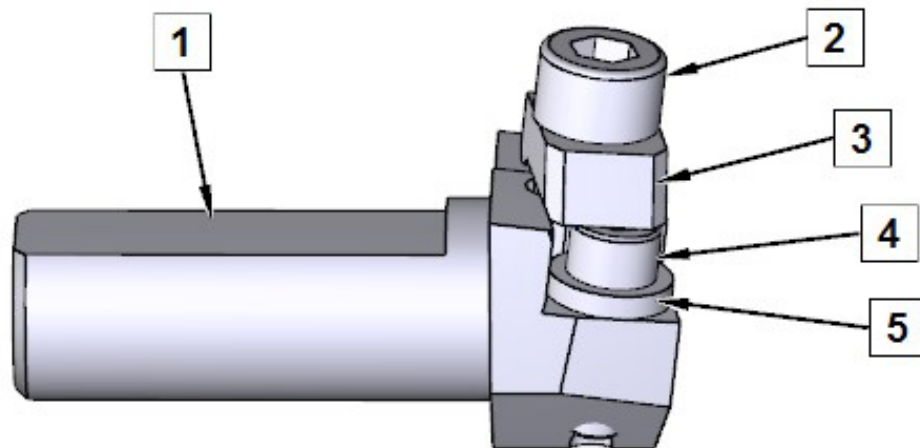
6747H Cartridge, Triangular - 30 Degree Chamfer



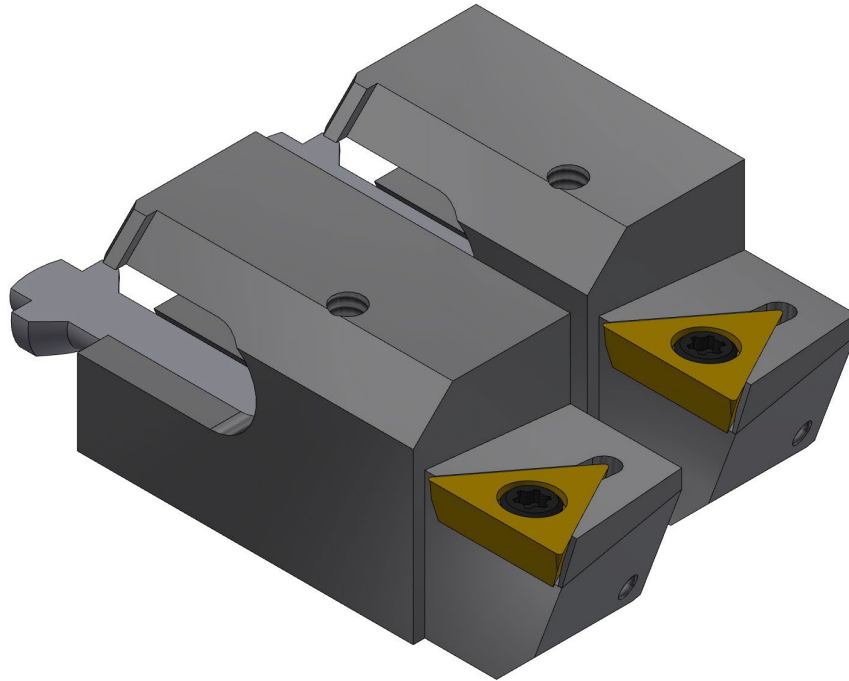
6598 Series Insert Cartridge Parts and Size Chart

6598 Series Tool Bit when used with 6520 Holders		
Tool Bit	Tool Holder	Bore Range
6598M	6520H	3.75" – 4.00"
6598M	6520A	4.00" – 4.50"
6598K	6520B	4.50" – 5.00"
6598K	6520C	5.00" – 5.50"
6598K	6520D	5.50" – 6.00"
6598K	6520E	6.00" – 6.50"
6598K	6520F	6.50" – 7.00"
6598K	6520G	7.00" – 8.00"

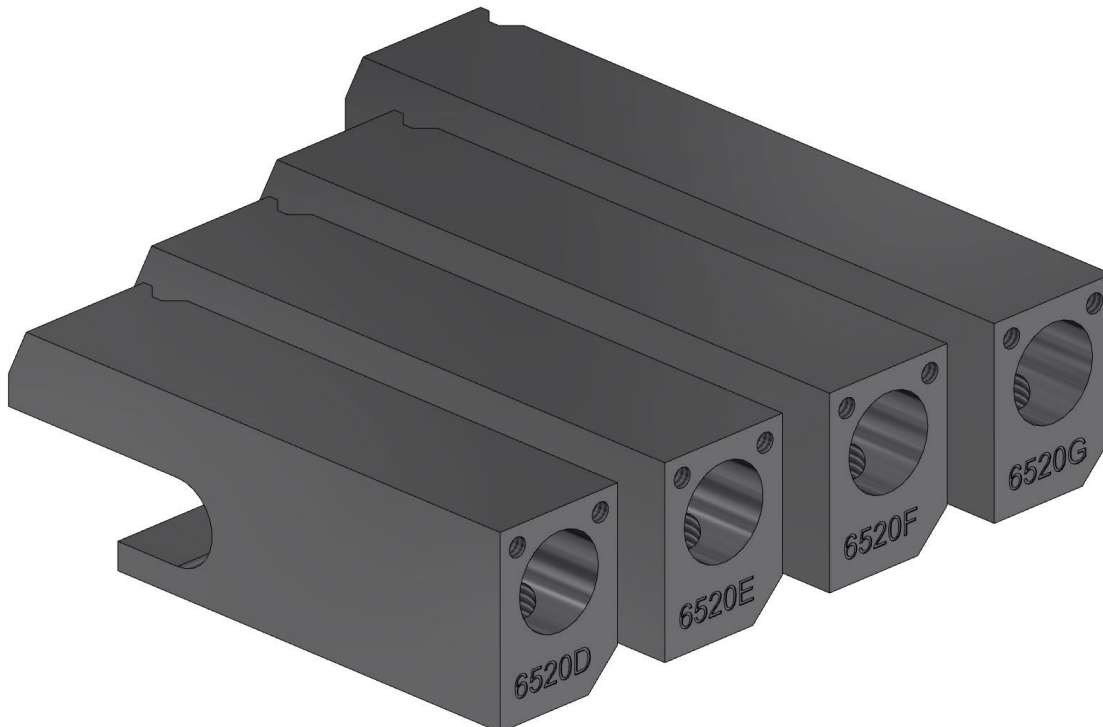


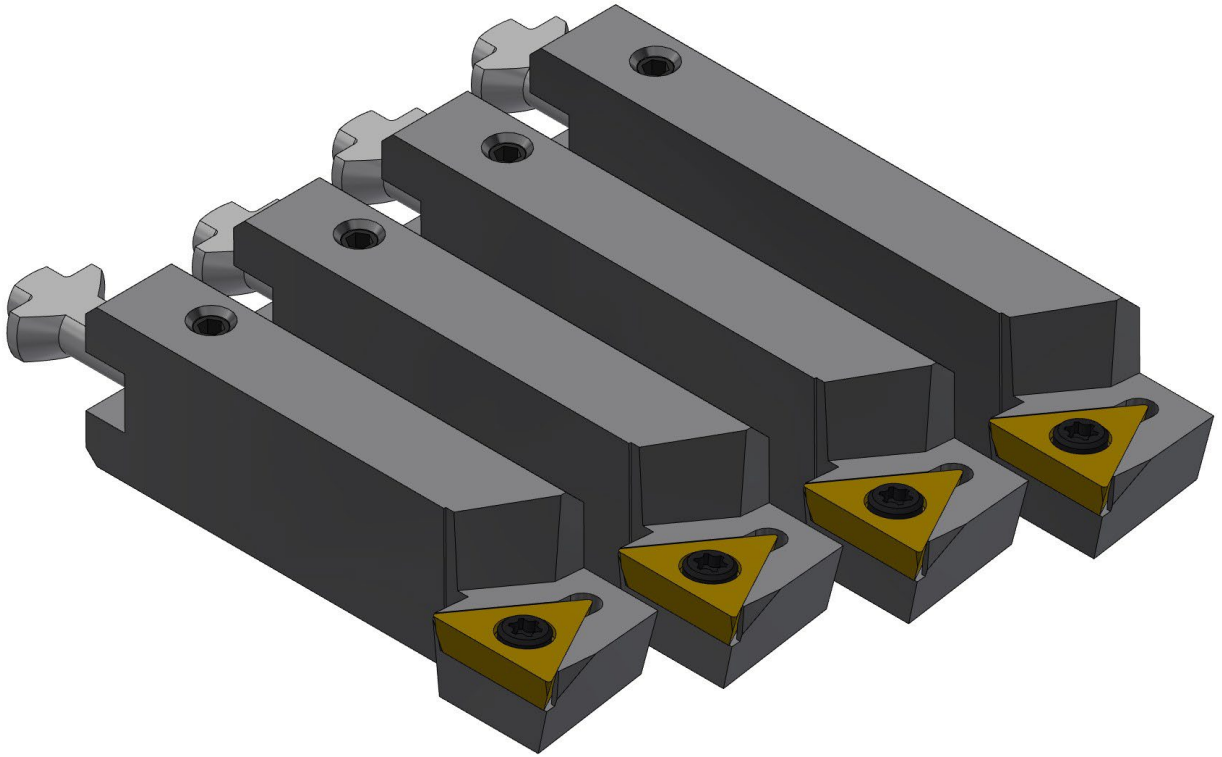
6260L Insert Cartridge Parts**6260W Insert Cartridge Parts**

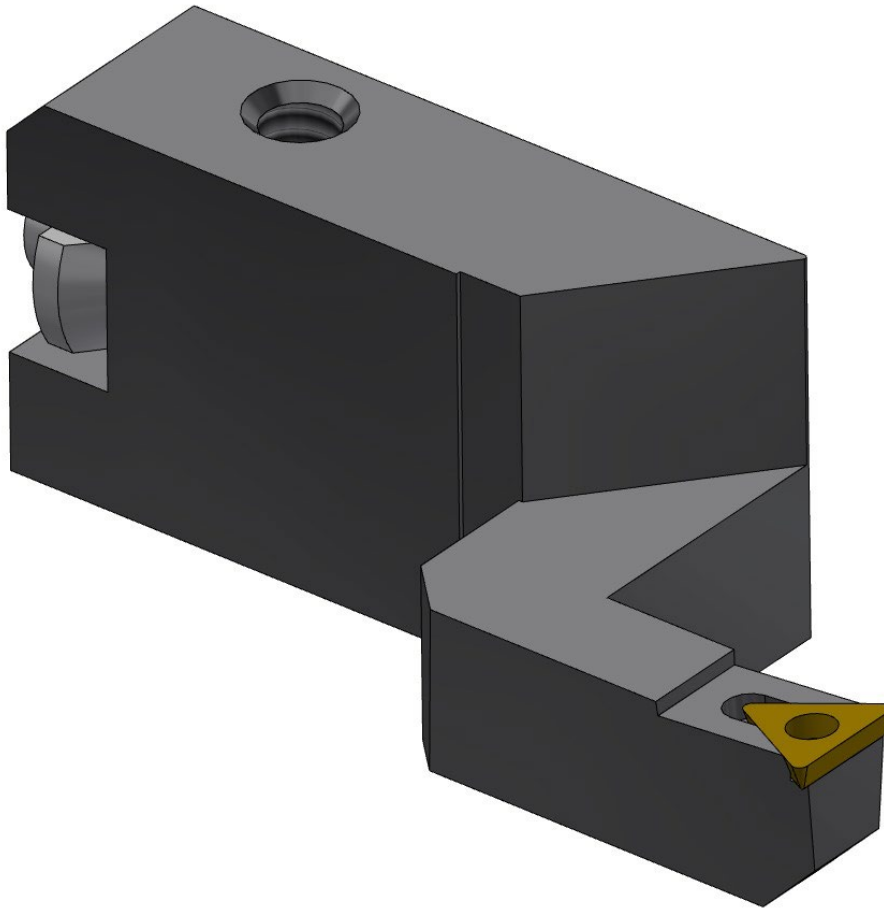
6593 Series Insert Holder Parts



6520 Series Toolholders



6801 Series Insert Holders

6801M Tool Holder Package

501-29-6G INSERT, TRIANGLE-.160" IC 1/64 RADIUS



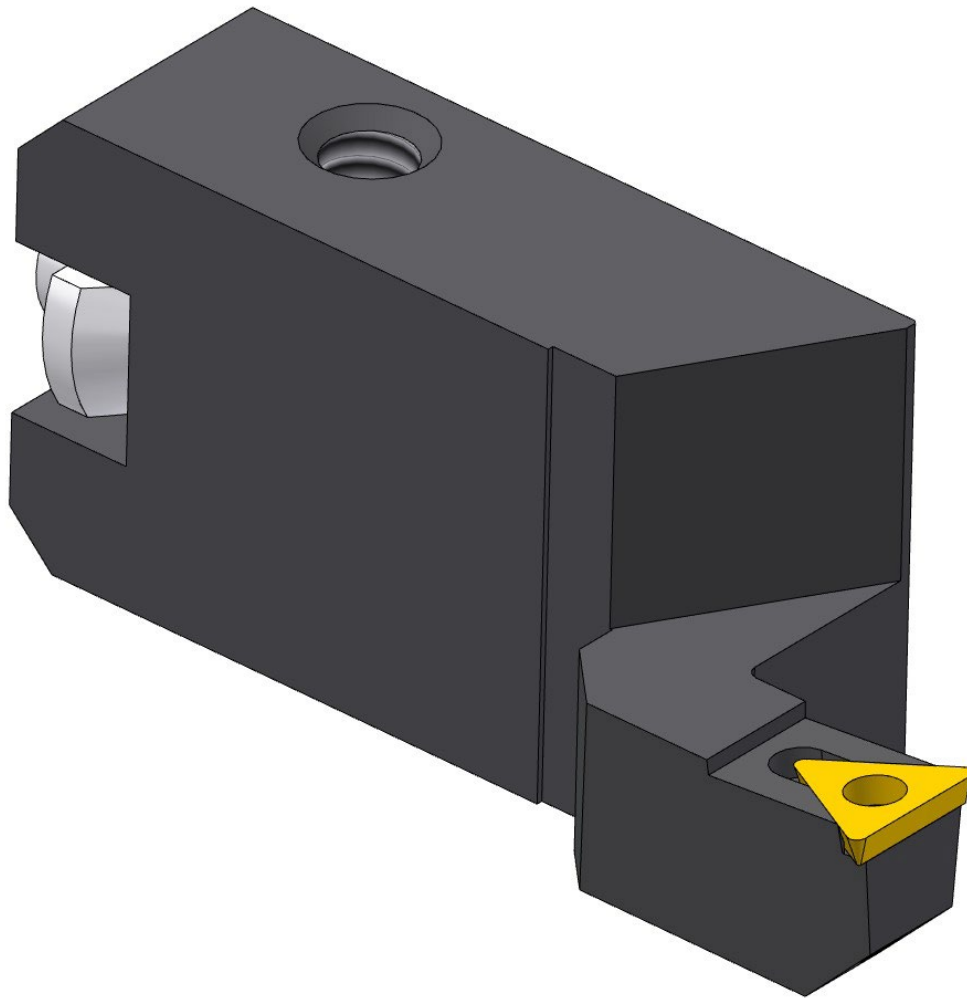
501-29-6H SCREW, INSERT THRUST FACING
TOOLBIT-.160" IC TRIANGLE



T7D T7 TORX TIP HOLDING SCREW DRIVER



T8D T8 TORX TIP HOLDING SCREW DRIVER

6801P Tool Holder Package

501-29-6G INSERT, TRIANGLE-.160" IC 1/64 RADIUS



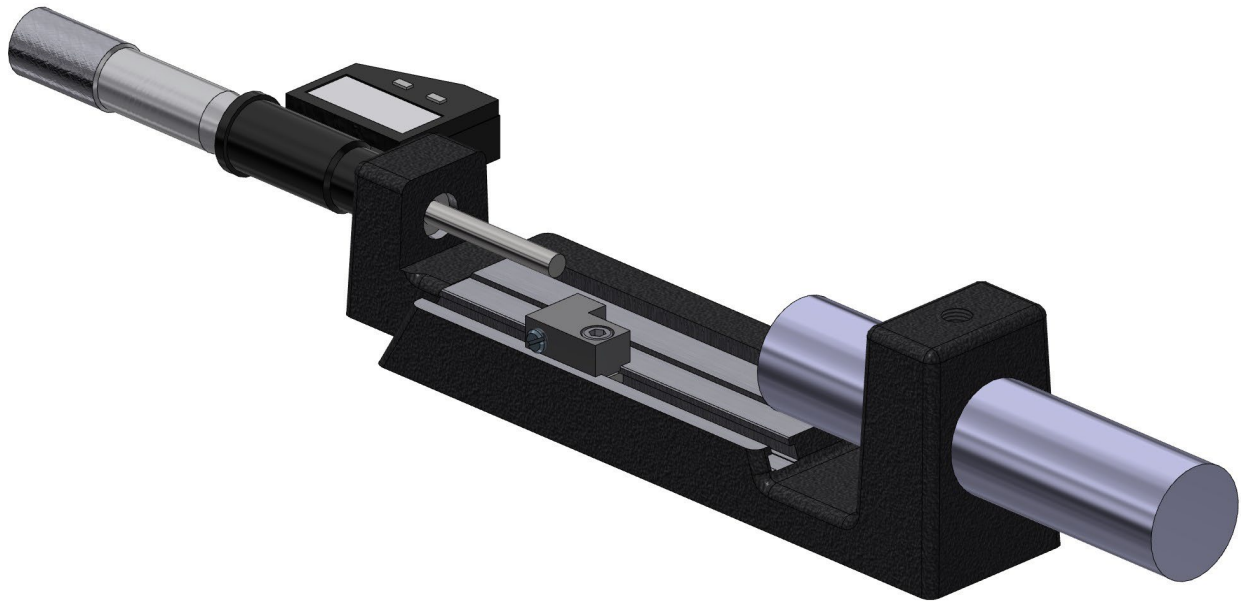
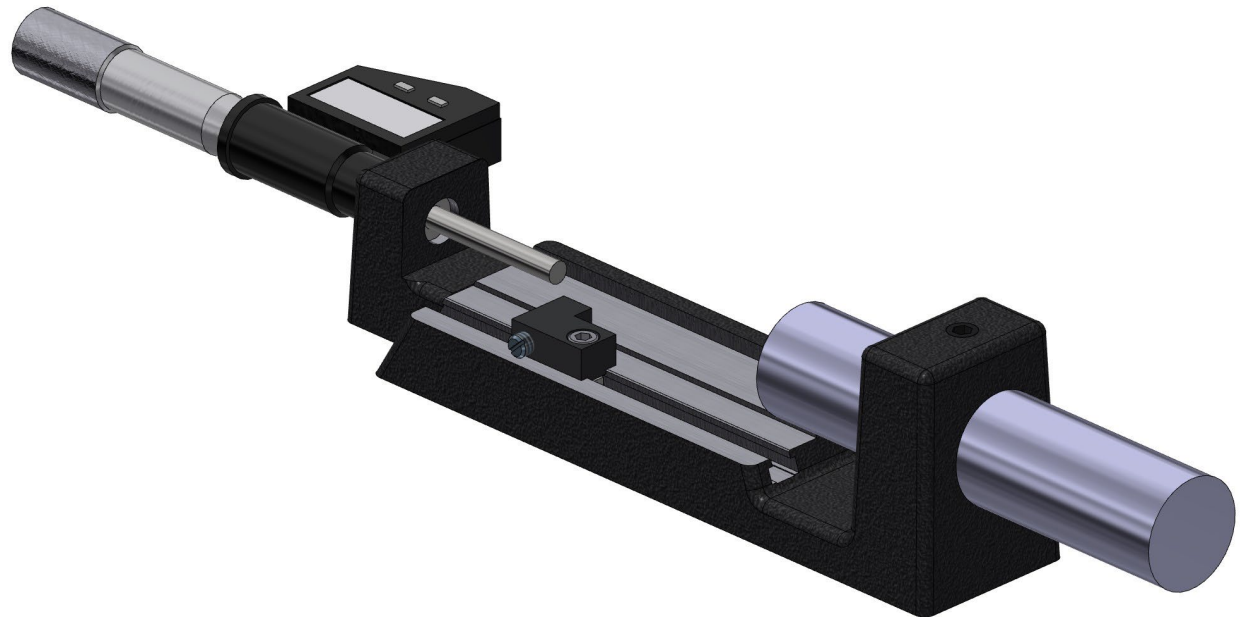
501-29-6J INSERT, TRIANGLE-.160" IC 1/32 RADIUS

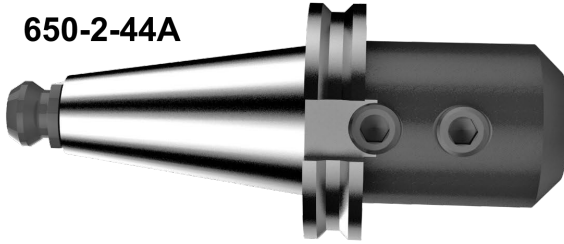
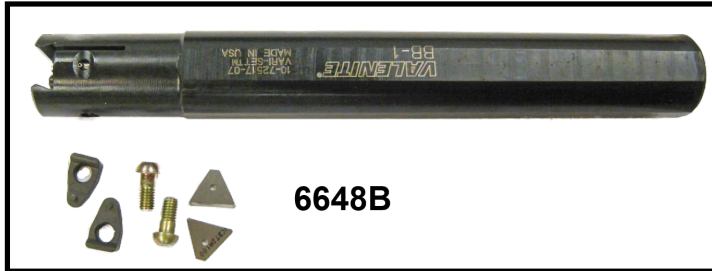
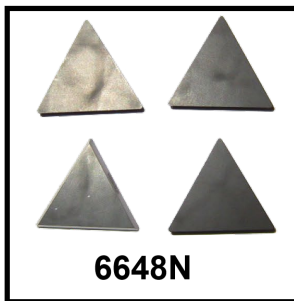


511-29-12F WRENCH, TORX

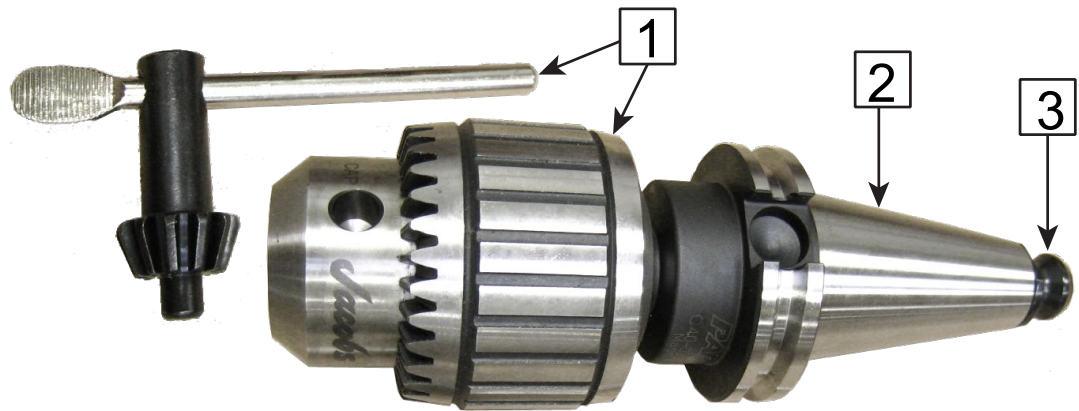


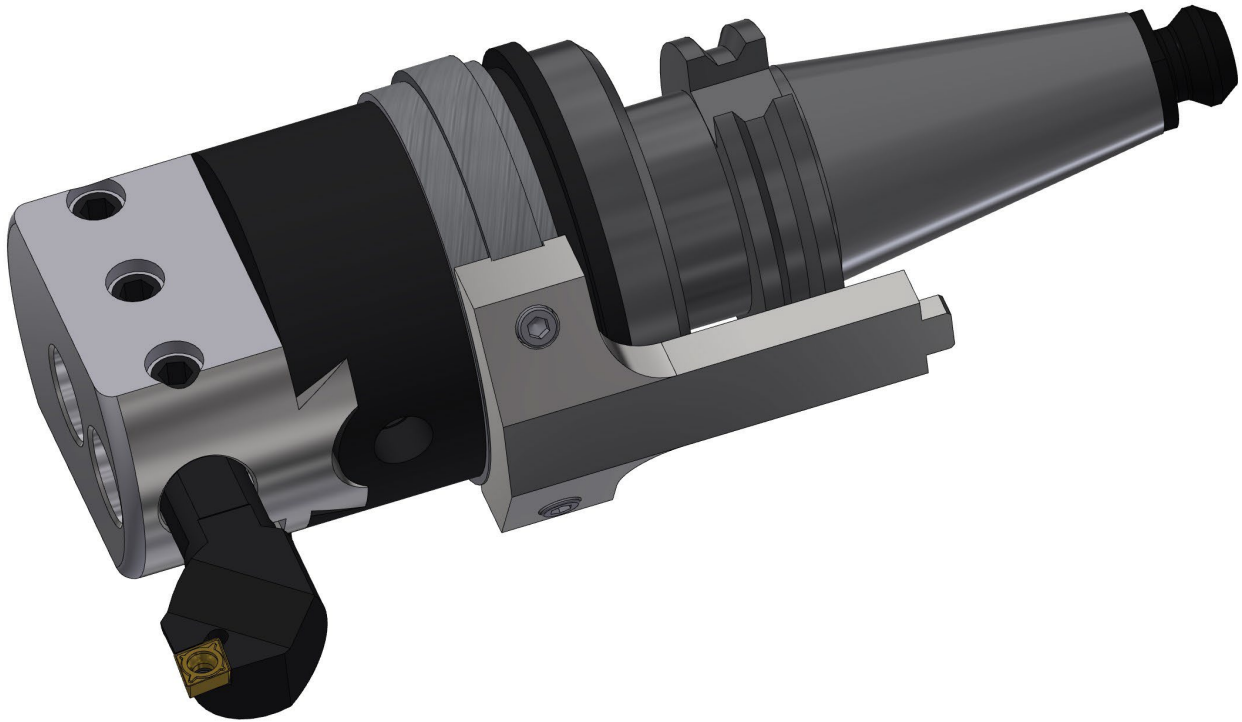
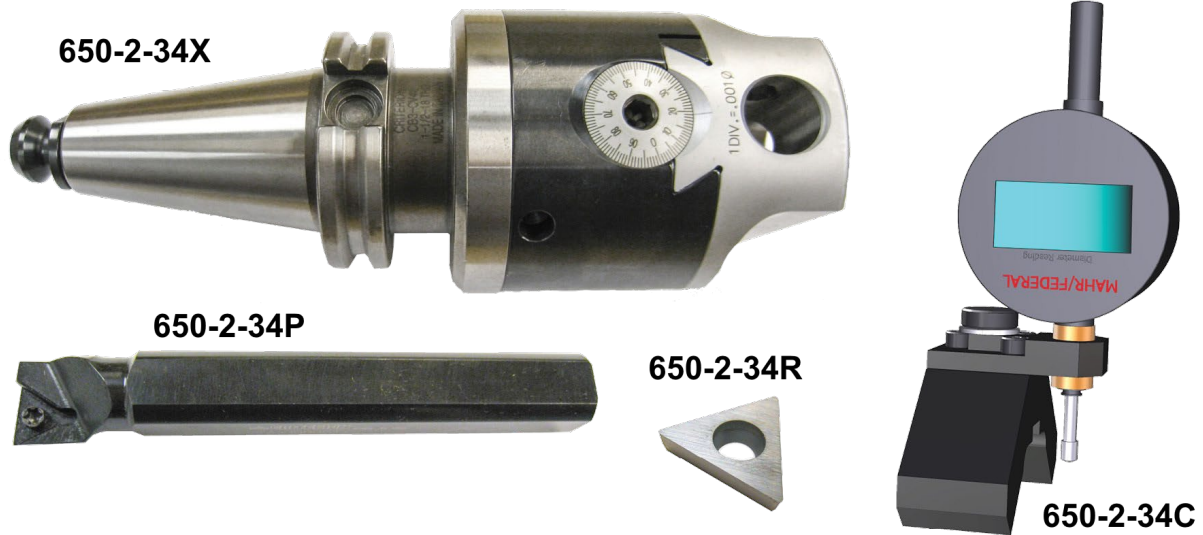
T8D T8 TORX TIP HOLDING SCREW DRIVER

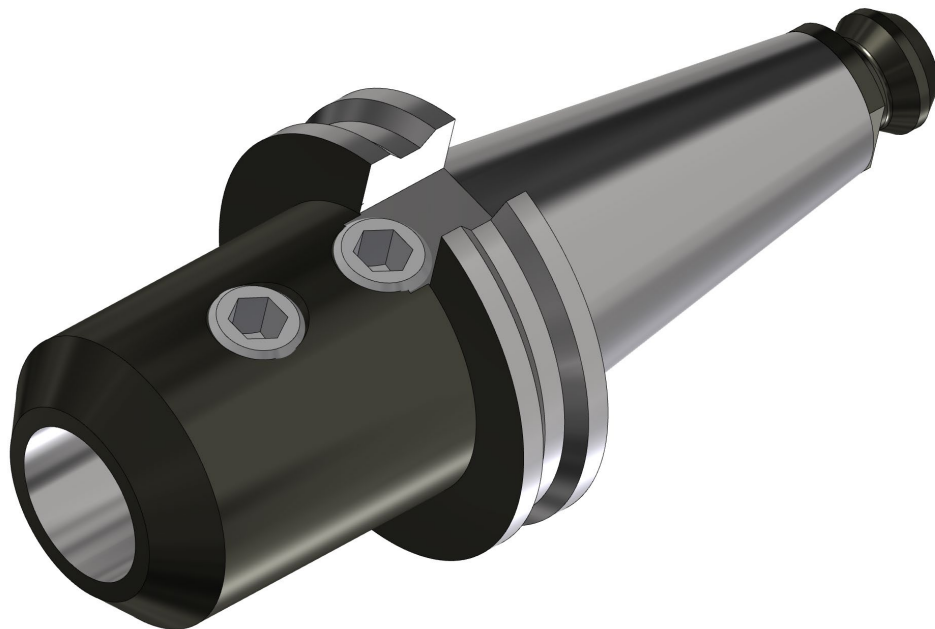
Micrometers:**900-2-19 Tool Setting Micrometer, 1/2"****Tooling** 6801 Series Tool Holders**900-2-20 Tool Setting Micrometer, 3/4"****Tooling** 6593, 6520, and 6259 Series Tool Holders

General Purpose Tooling**6648W Cat 3400 Series Tappet Bore Repair Tooling Package Components****650-2-44A****6648C****6648D****6648B****6648F****6648N****502-11-39F****MF-71D****650-2-34D**

650-2-53 Splayed 4 Bolt Main Cap Machining Tooling Package Components

650-2-44M Drill Chuck Kit**650-2-53E Collet Kit**

11116 Cross Feed Head Assembly**650-2-3S Cutterhead Package Components**

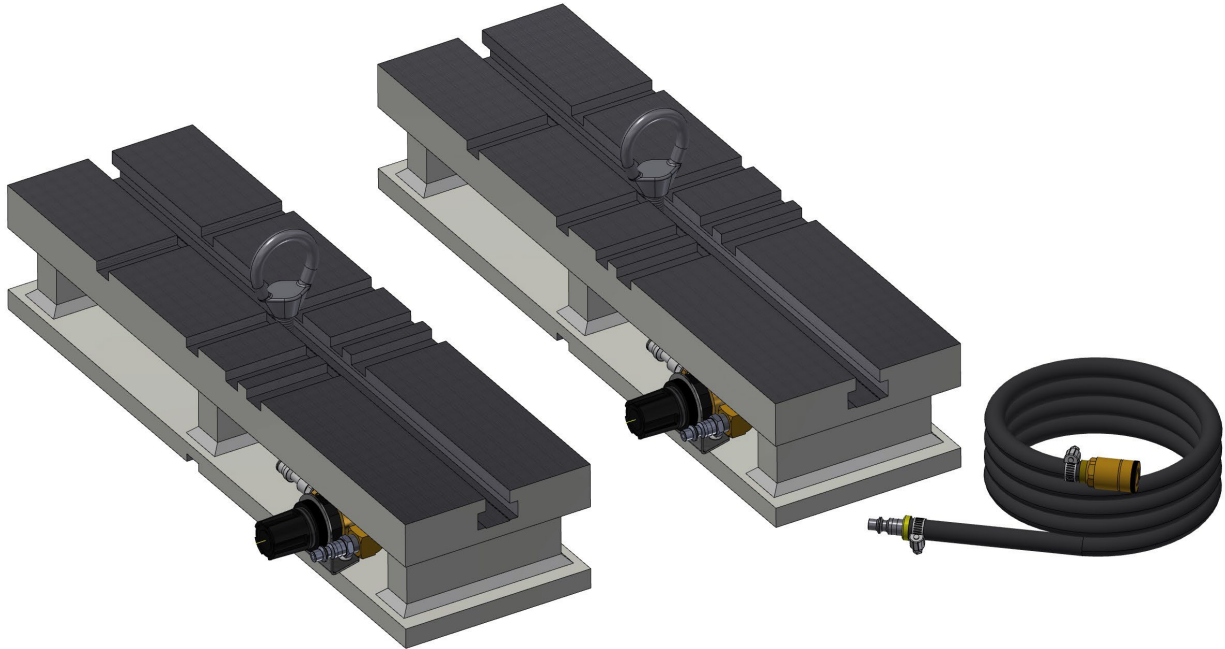
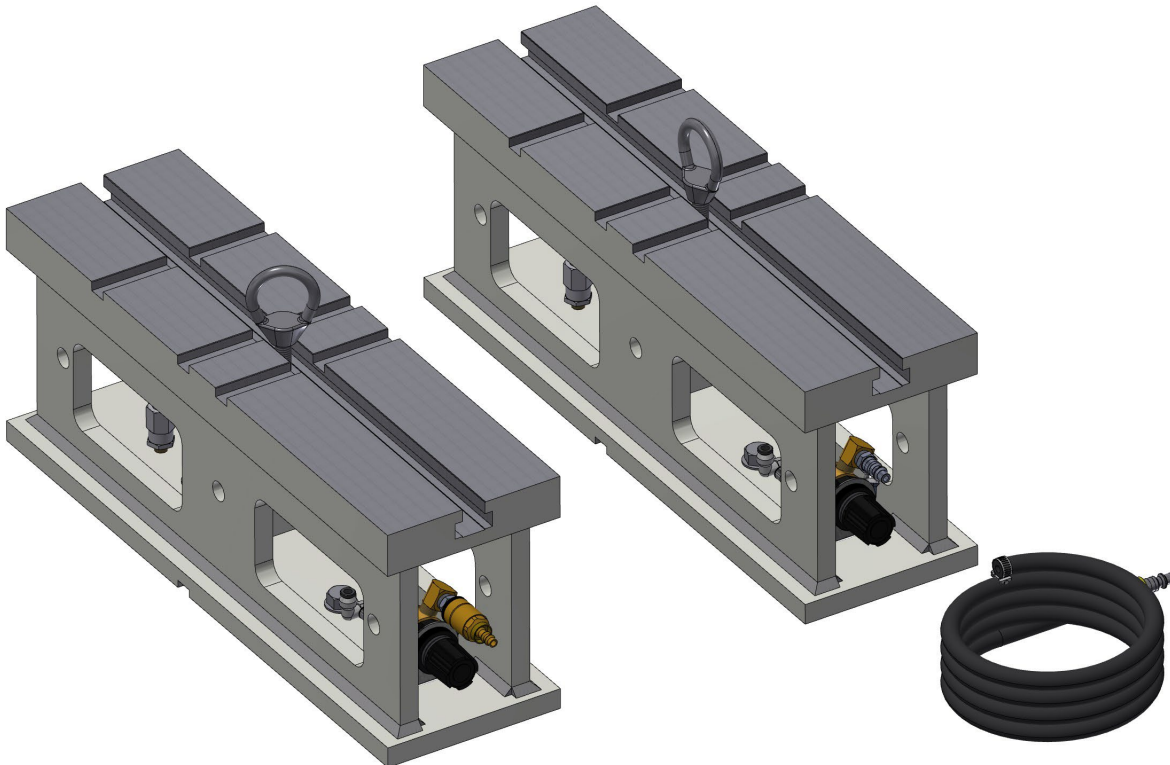
650-2-11K Tap Driver**650-2-44A Endmill Adapter, 1" (25.4mm) Shank Tooling****650-2-45H Endmill, 1" (25.4mm) x 8.5" (216mm) OL Roughing**

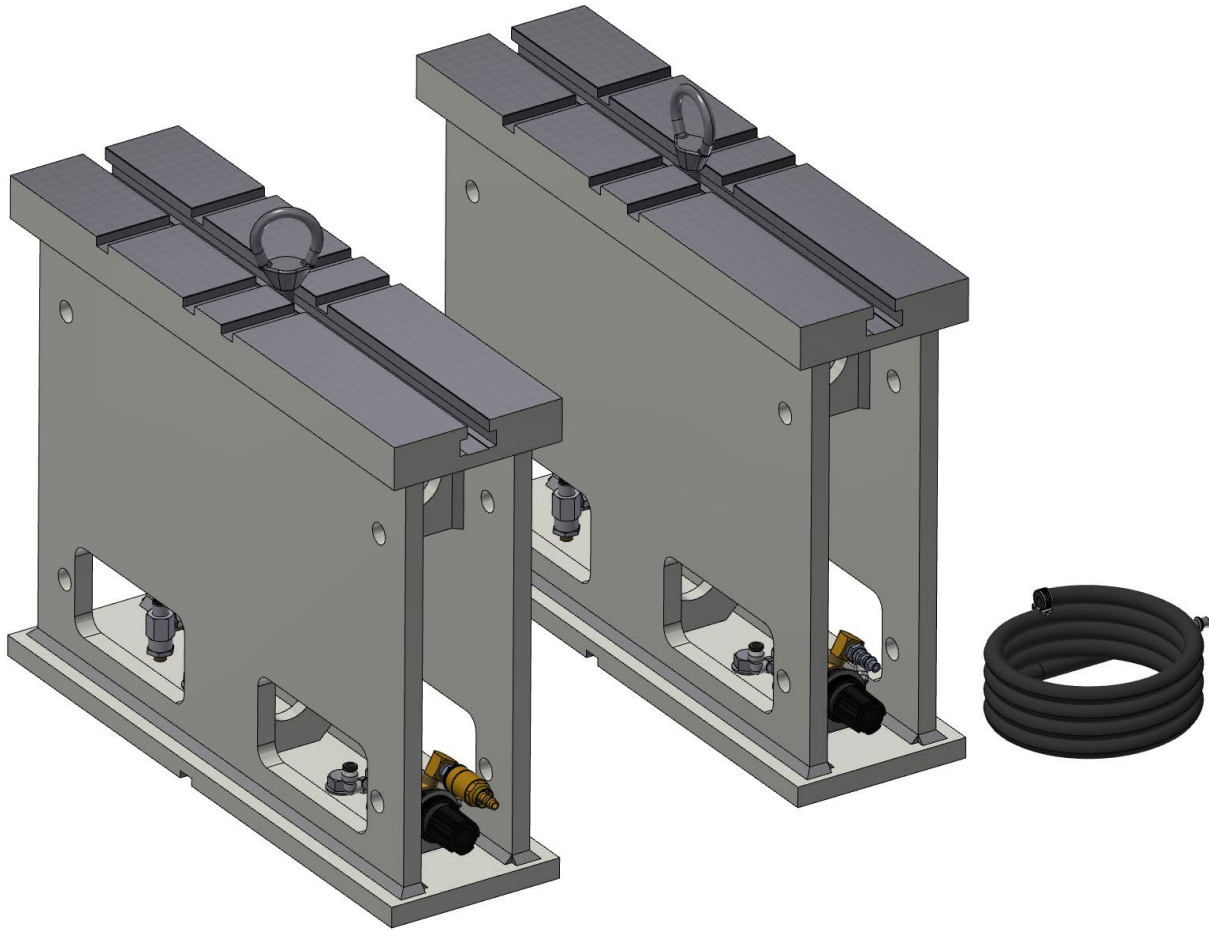
650-2-60B Lifter Bore Tooling Kit**650-2-60C****650-2-60D****650-2-60K****650-2-60J****650-2-60E****650-2-60F****650-2-20C****650-2-20L****650-2-60H****650-2-60G****650-2-60L****650-2-44A****650-2-32J****650-2-32U****511-29-12F**

Fixtures: Parallels**11115 2" (50mm) X 3" (75mm) Parallels**

Sold as complete set.

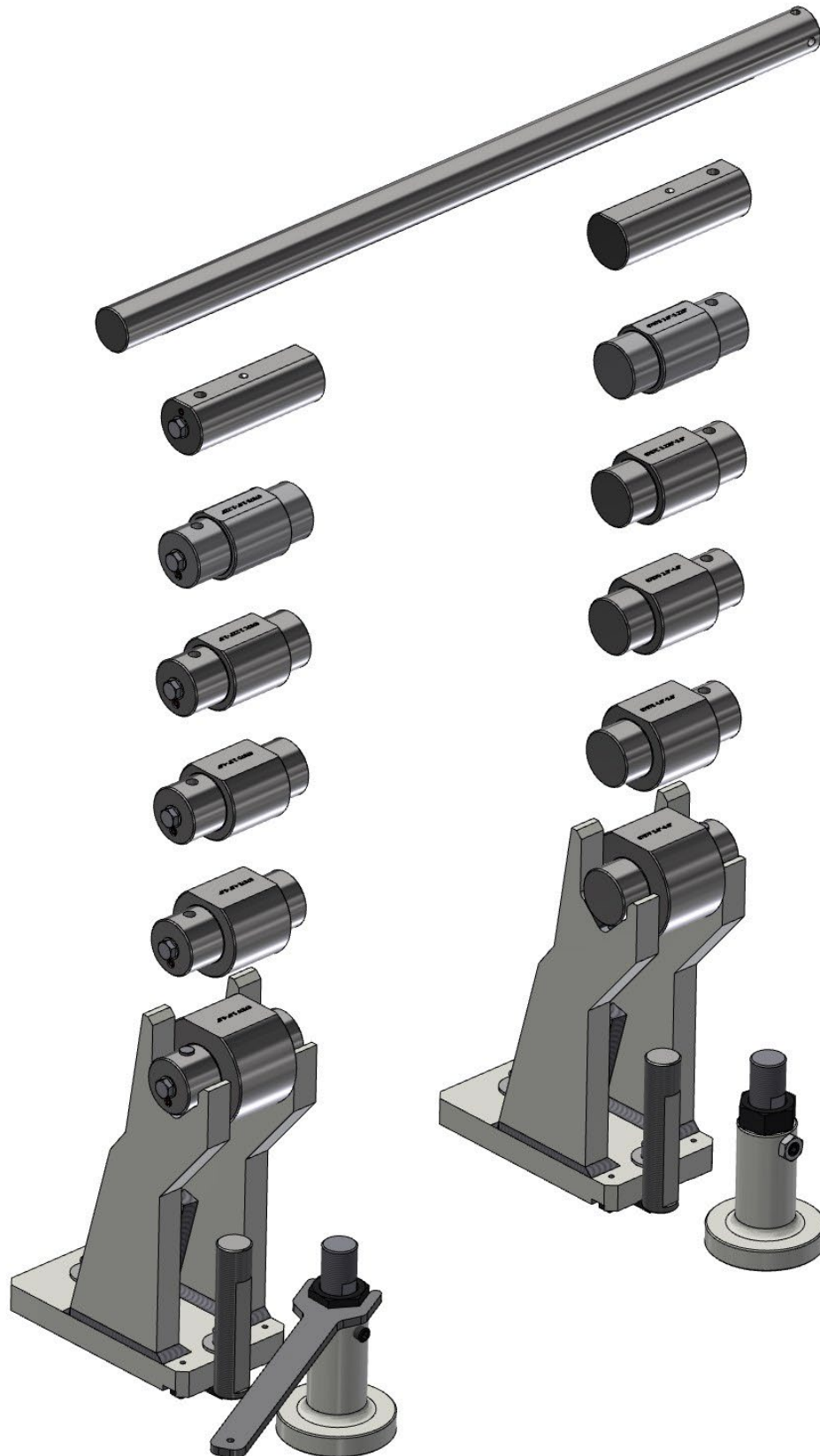


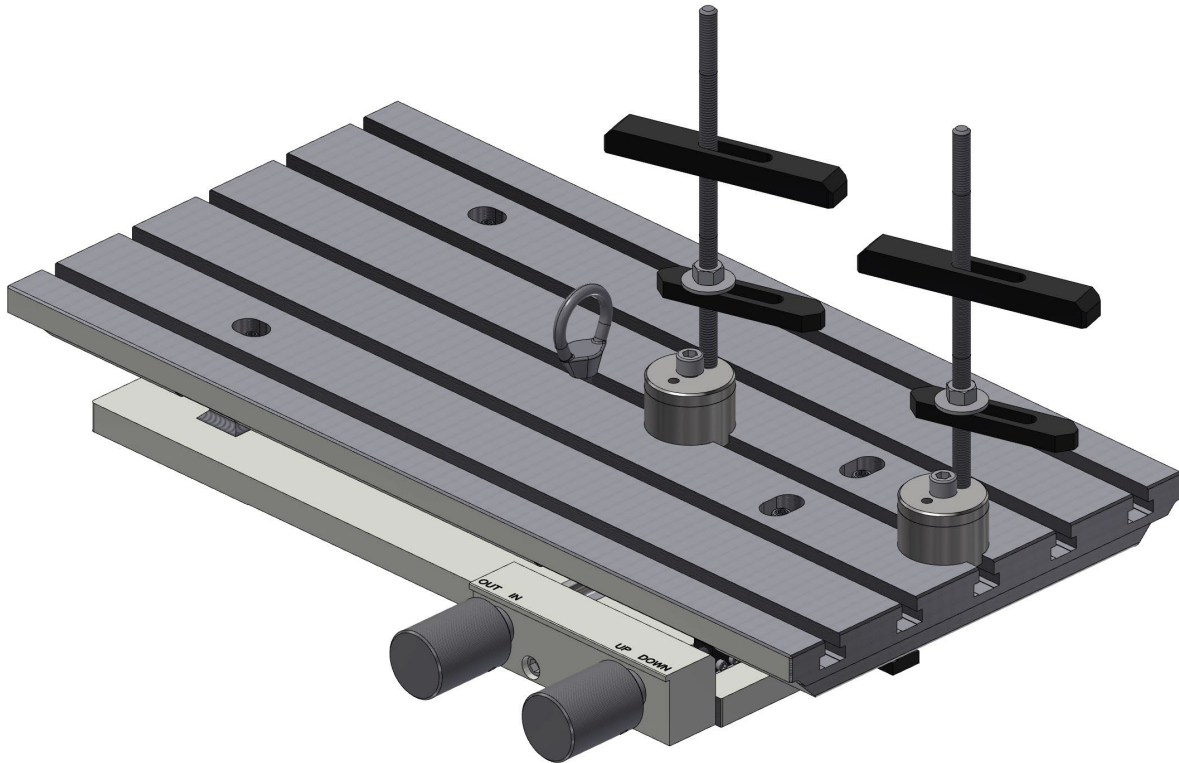
11113L Universal 4" (102mm) Heavy Duty T-Slot Parallels**11112 Universal 8" (203mm) Heavy Duty T-Slot Parallels Parts**

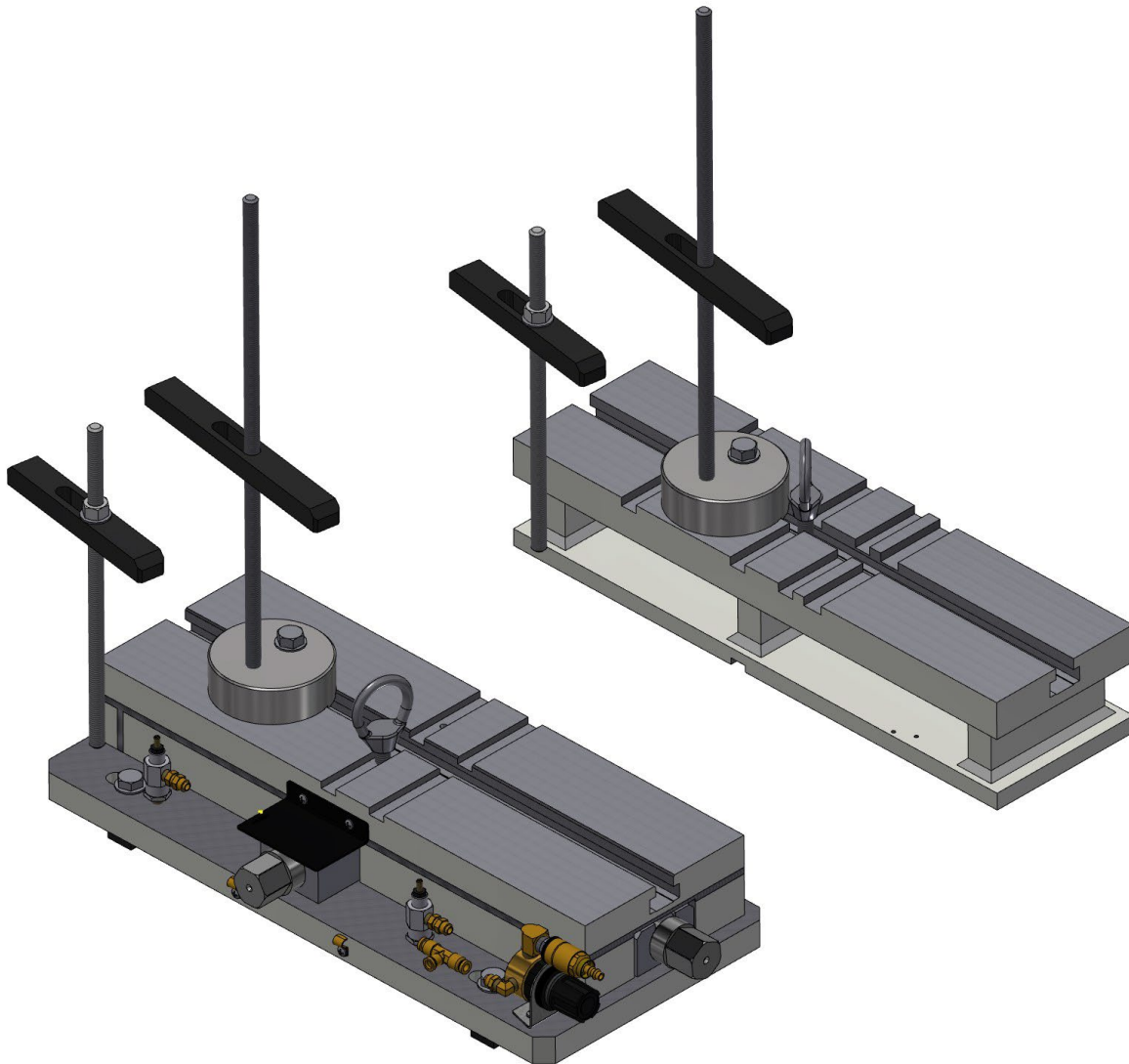
11114 Universal 16" (406mm) Heavy Duty T-Slot Parallels

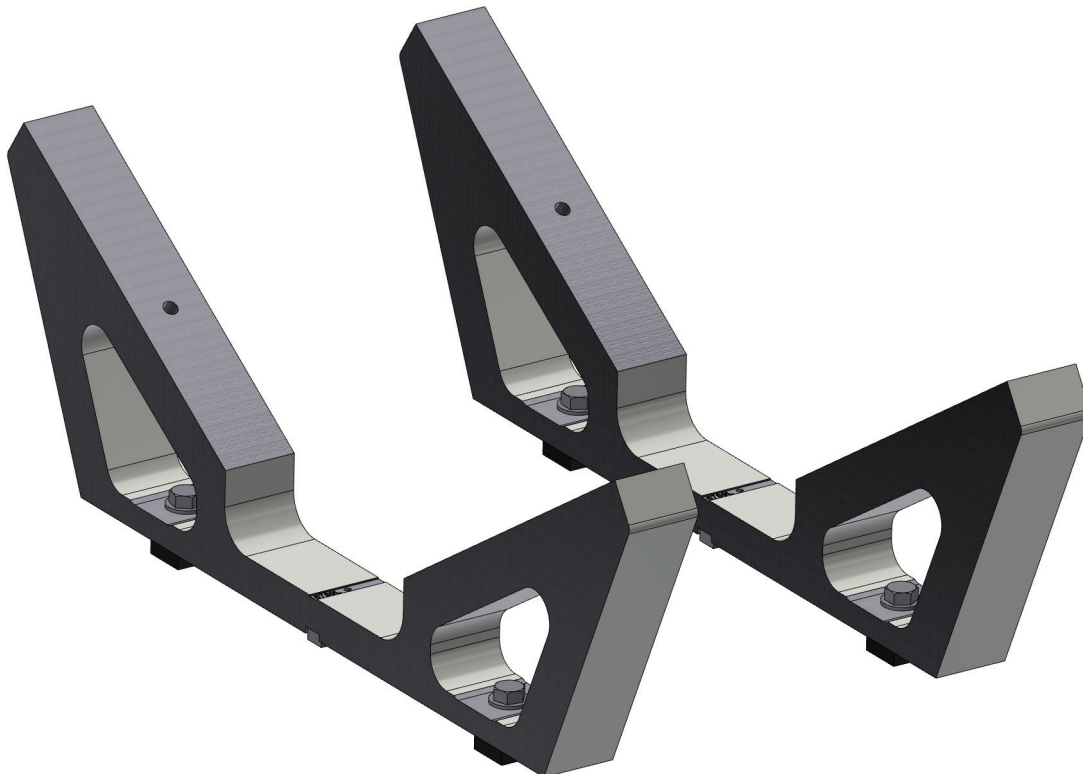
Block Locating Fixtures

11121 Small to Mid-Range Universal Fixture, 2-7" Main Bearing Diameter



650-3-56 Line Bore Pivot Table Parts

11113 Adjustable Universal Line Boring Parallel Assembly Parts

6843 90 Degree V Block Supports Parts**6789L 113 Degree V Block Supports for Detroit Diesel V53**

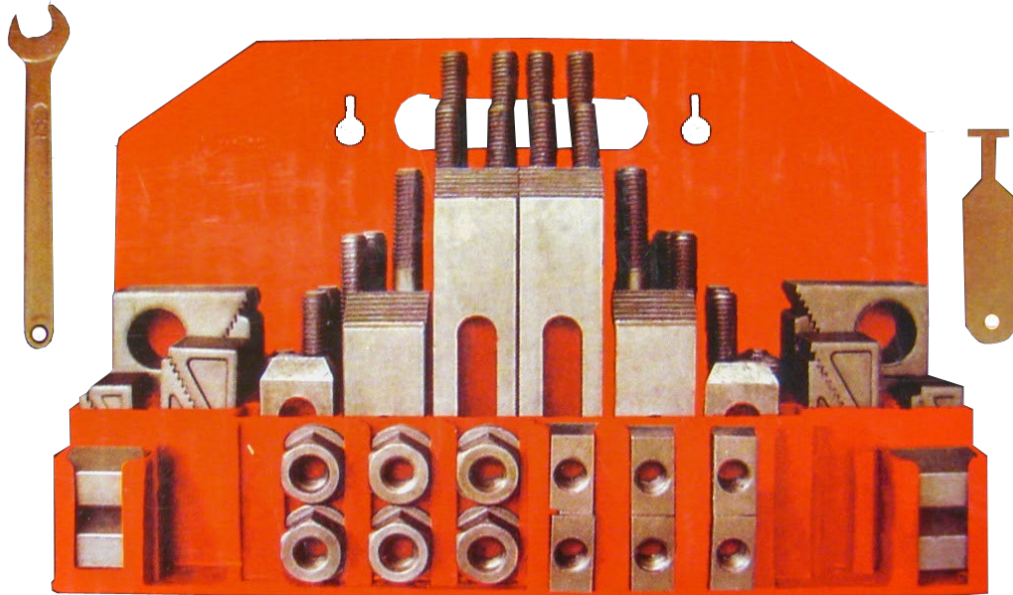
6789E 115 Degree V Block Supports**6789N 116 Degree V Block Supports**

6866 Wedge for Cummins 59liter Camshaft Line Boring

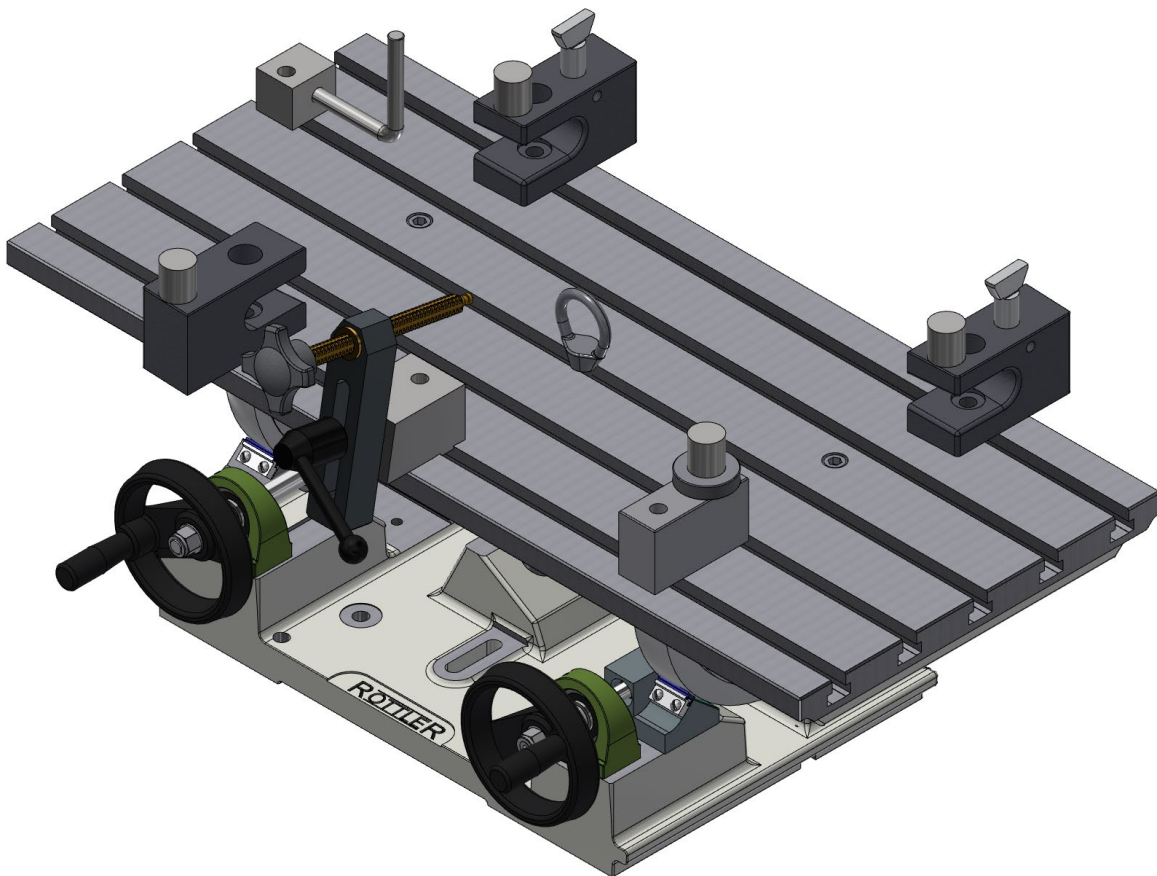
Miscellaneous Fixtures/Accessories

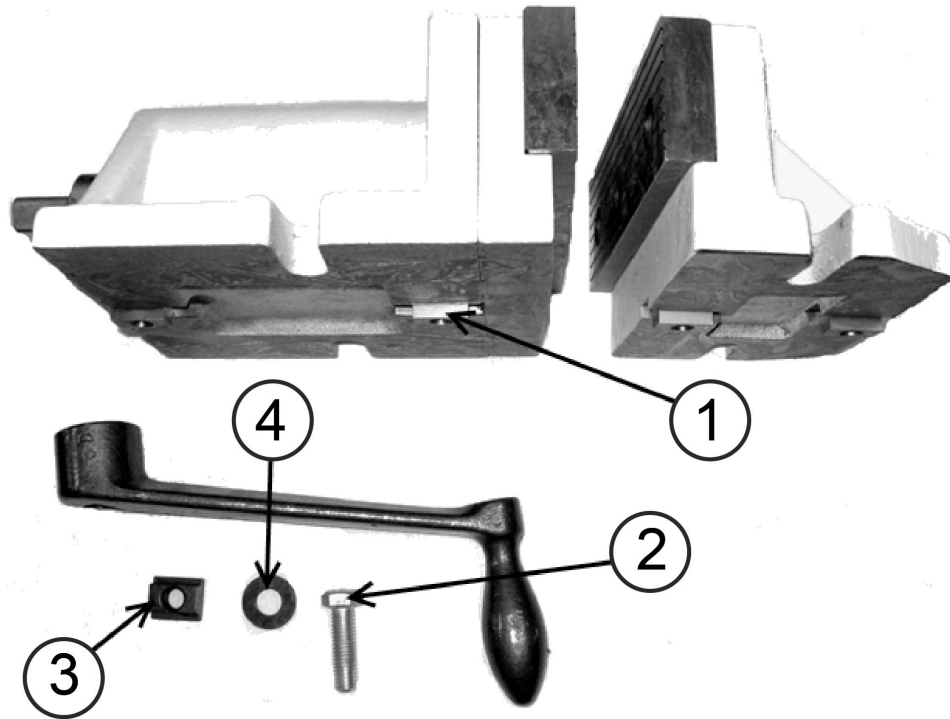
650-3-37 1/2" (127mm) Universal Clamping Kit

Sold only as complete package.

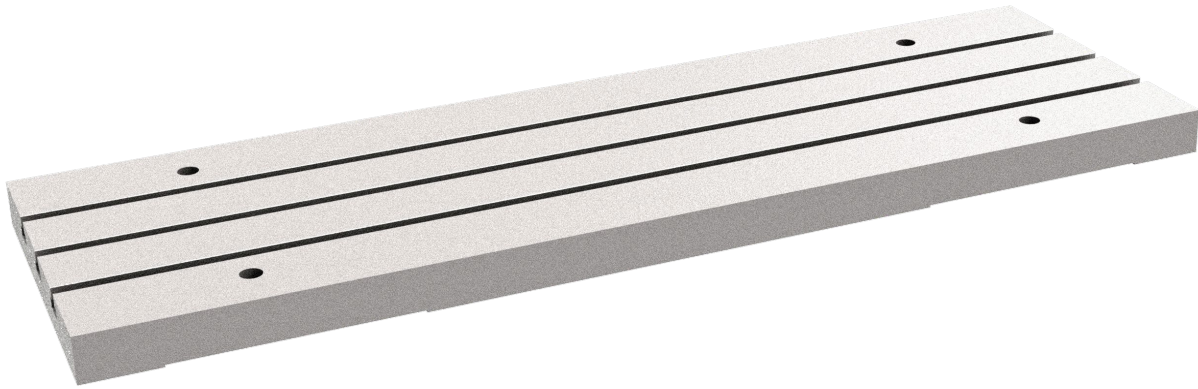


7209M Dual Axis Leveling Table



7209N 2-Piece Vise

11111 Clamp Tower**7152A Dual Axis Level**

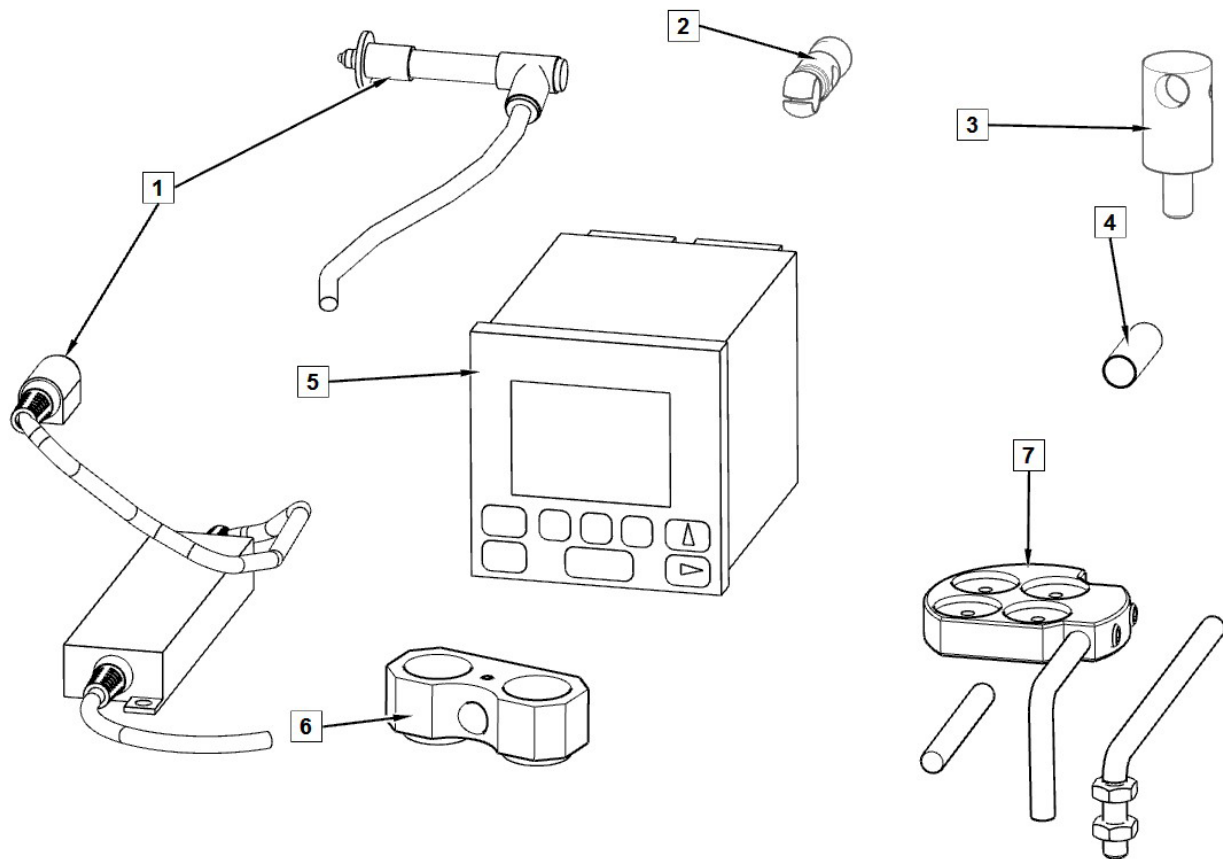
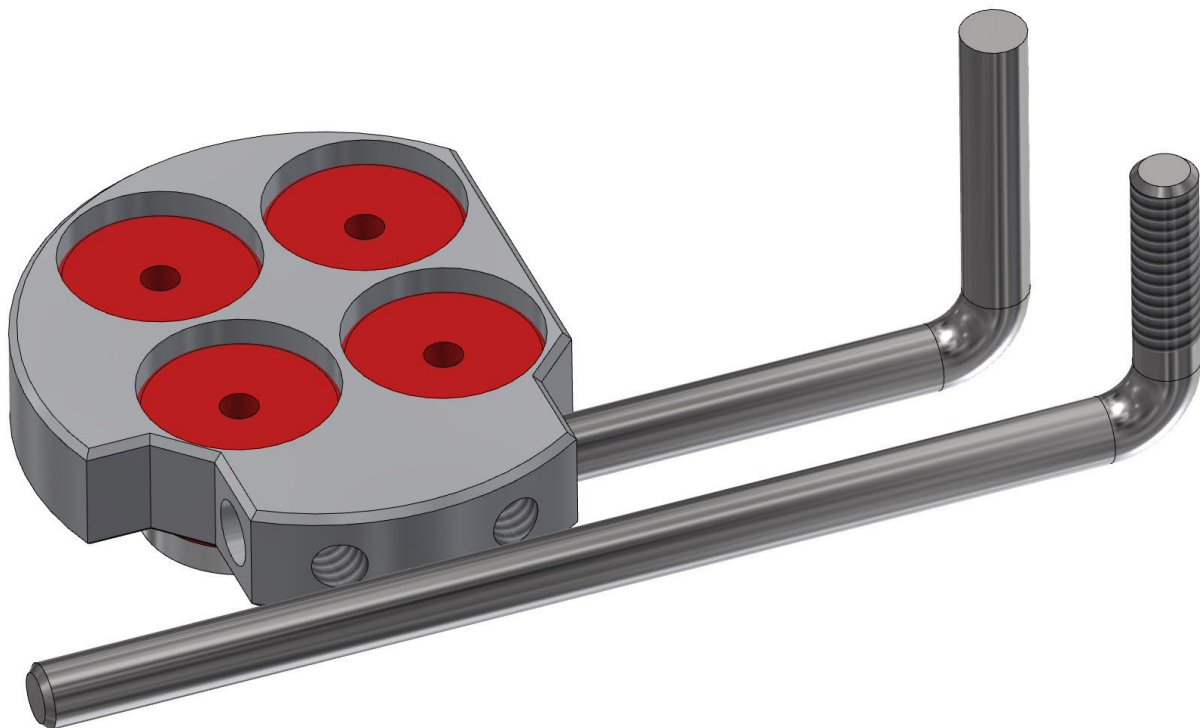
9111A T-Slot Plate**650-2-60N Setting Fixture, Lifter Tooling Package**
Sold only as complete package.

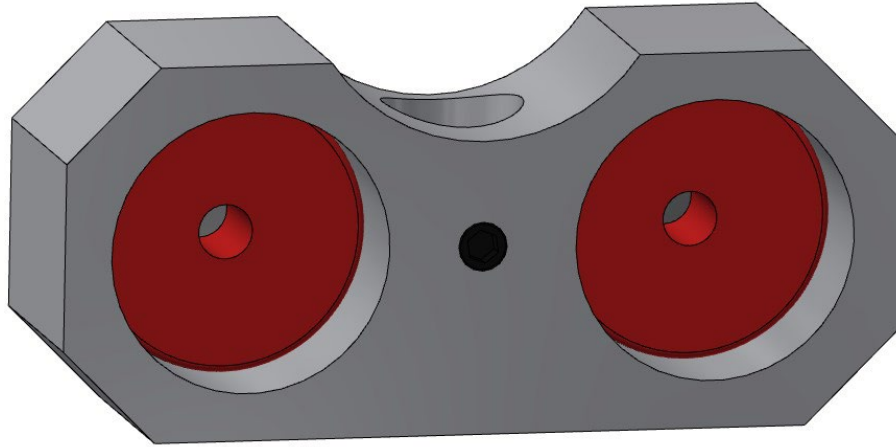
Auxiliary Equipment

650-3-59Y Renishaw Wireless Probing System



ITEM	PART #	DESCRIPTION
1	650-2-44L	CAT 40 RETENTION KNOB
2	6648P	CAT 40 SHANK
3	650-3-59Z	PROBE RMP40
4	650-3-59C	50MM LONG X 6MM DIA. STYLUS PROBE
5	650-3-59K	STYLUS EXTENSION (50MM)
6	650-3-59D	100MM LONG X 6MM DIA. STYLUS PROBE
7	6648T	STYLUS EXTENSION
8	6648R	SWIVEL ADAPTER FOR STYLUS
9	6648U	LITHIUM BATTERY
10	650-3-59E	20MM LONG X 2MM DIA. STYLUS PROBE
11	6648Q	17.5MM LONG X 6MM DIA. STYLUS PROBE
12	6648S	CRASH PROTECTION DEVICE FOR STYLUS

502-12-7B Digital Runout Probe and Readout Components**502-12-4 General Purpose Magnetic Indicator Holder Parts**

502-12-4A Magnetic Indicator Holder Parts**502-9-9S Indicator Mount**

Angled for small diameter main line bores

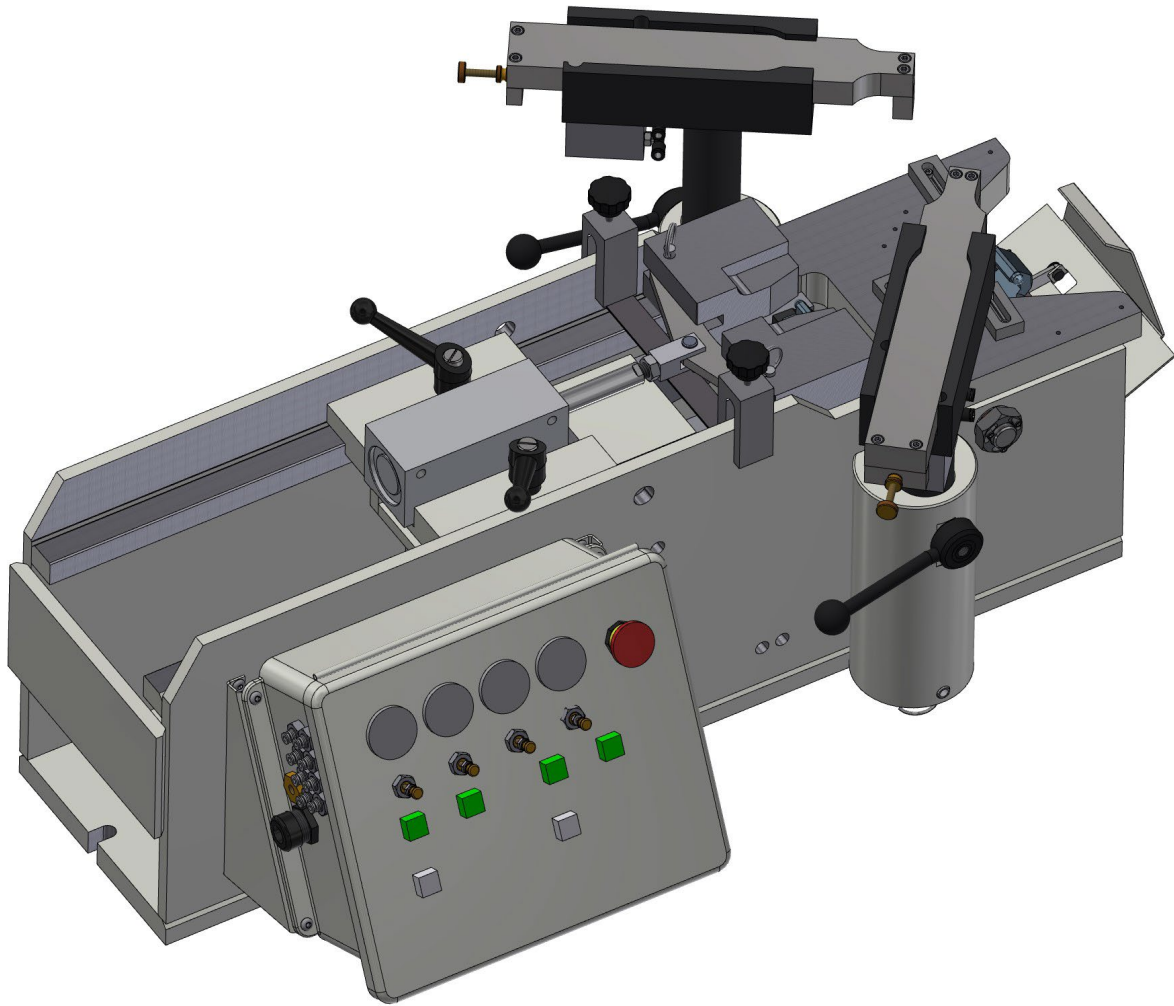
**502-9-9A Mechanical Run Out Indicator**

General Purpose (.001" Inch Resolution)

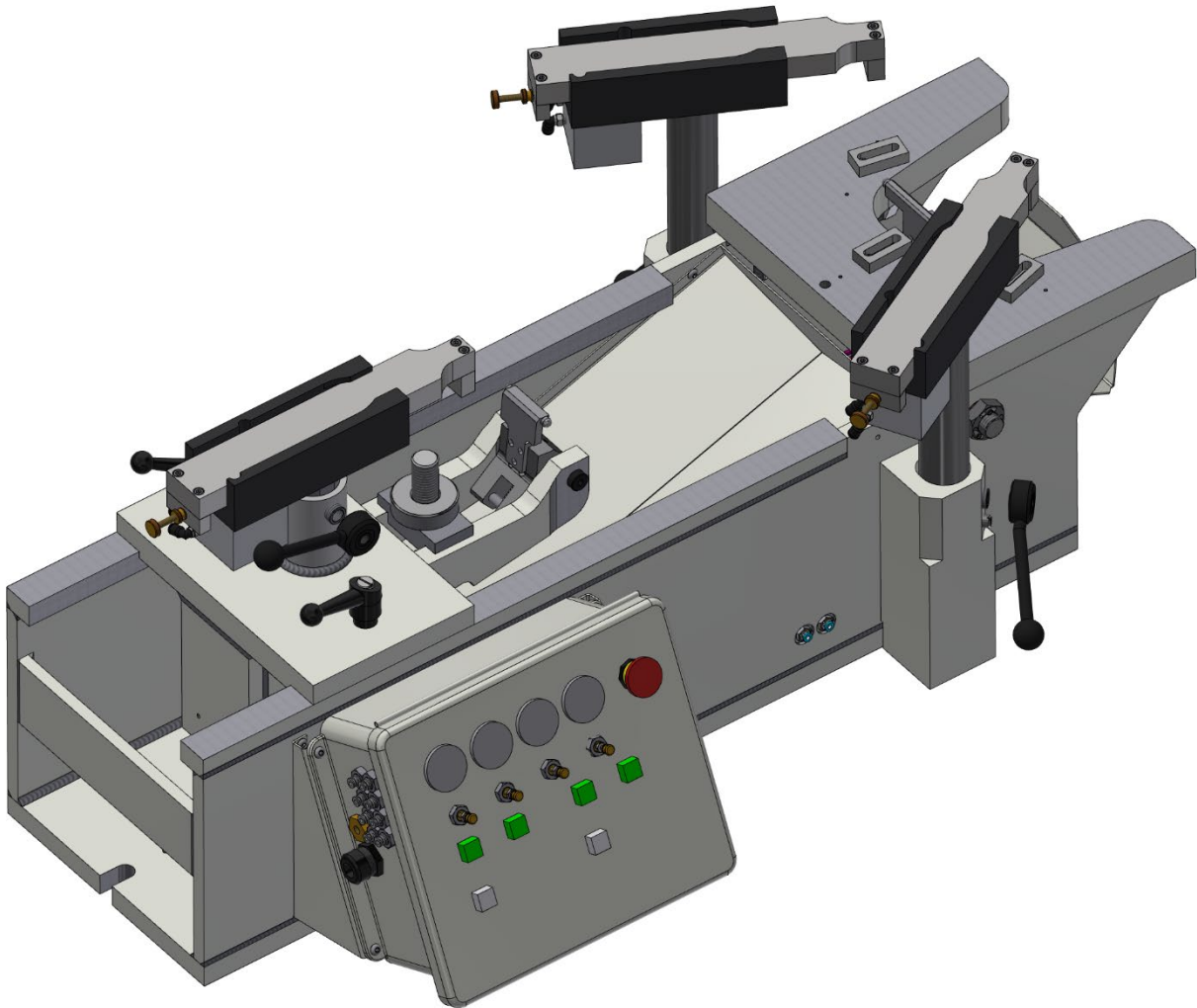
**502-9-9J Mechanical Run Indicator**

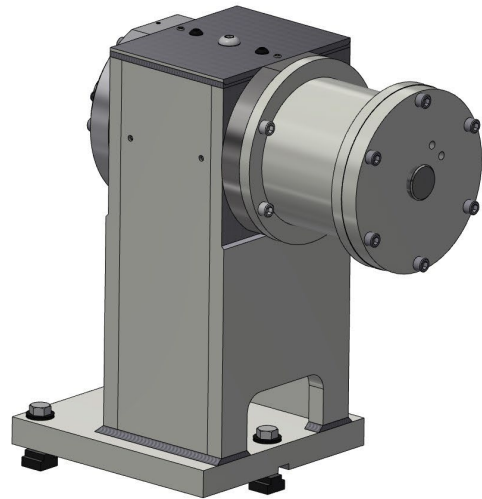
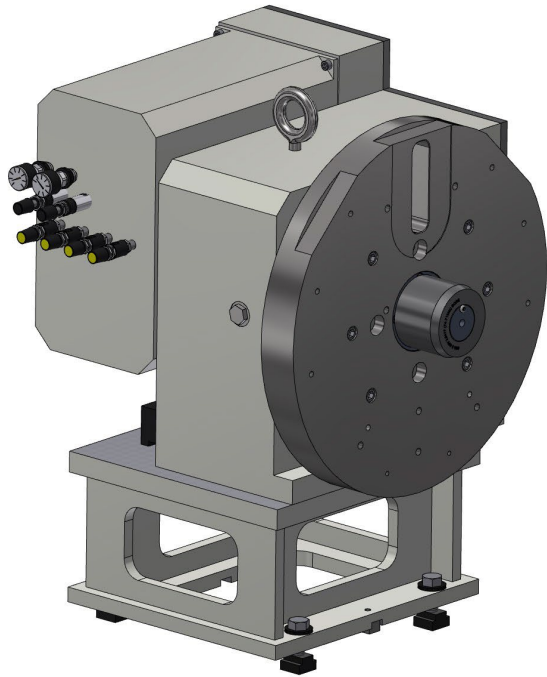
General Purpose (.01mm Metric Resolution)

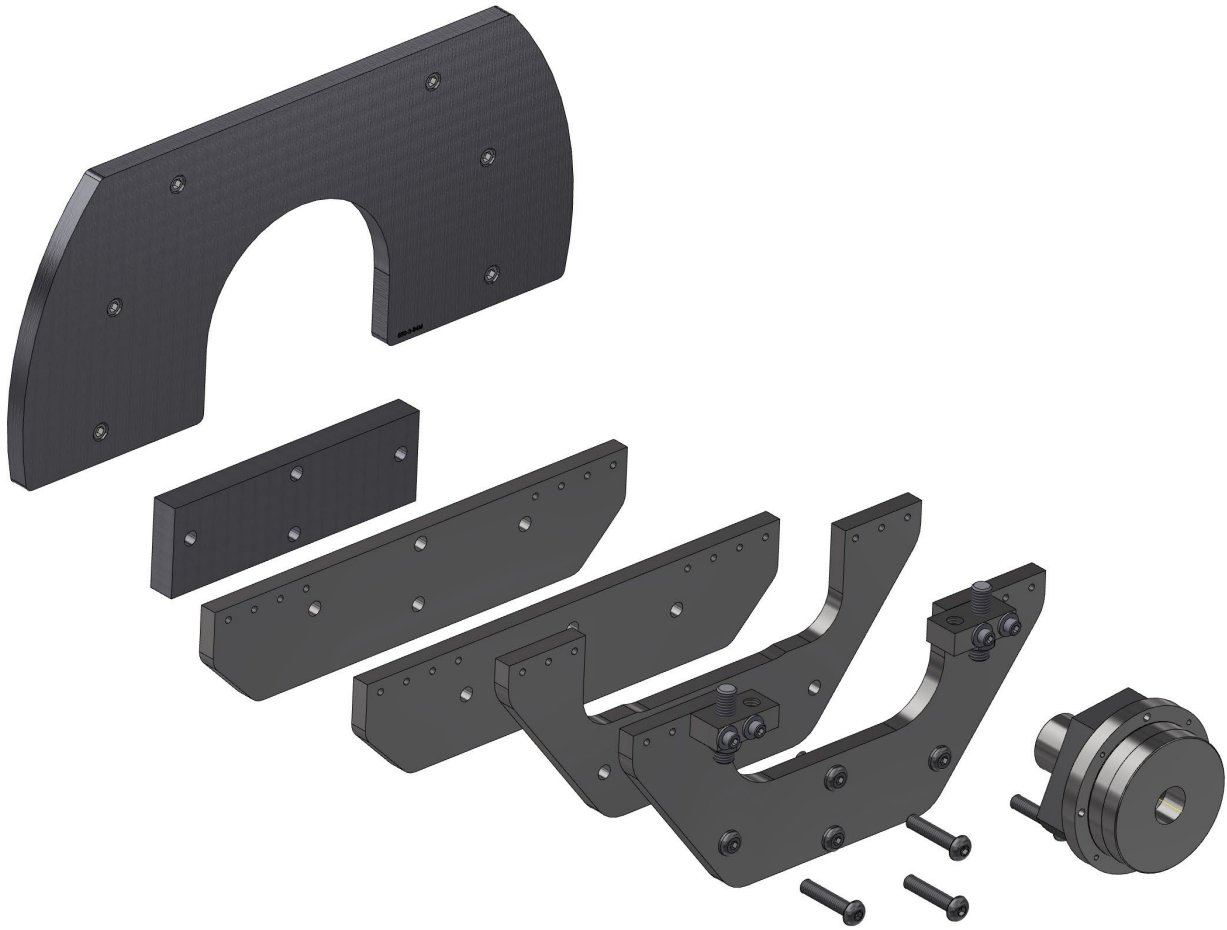


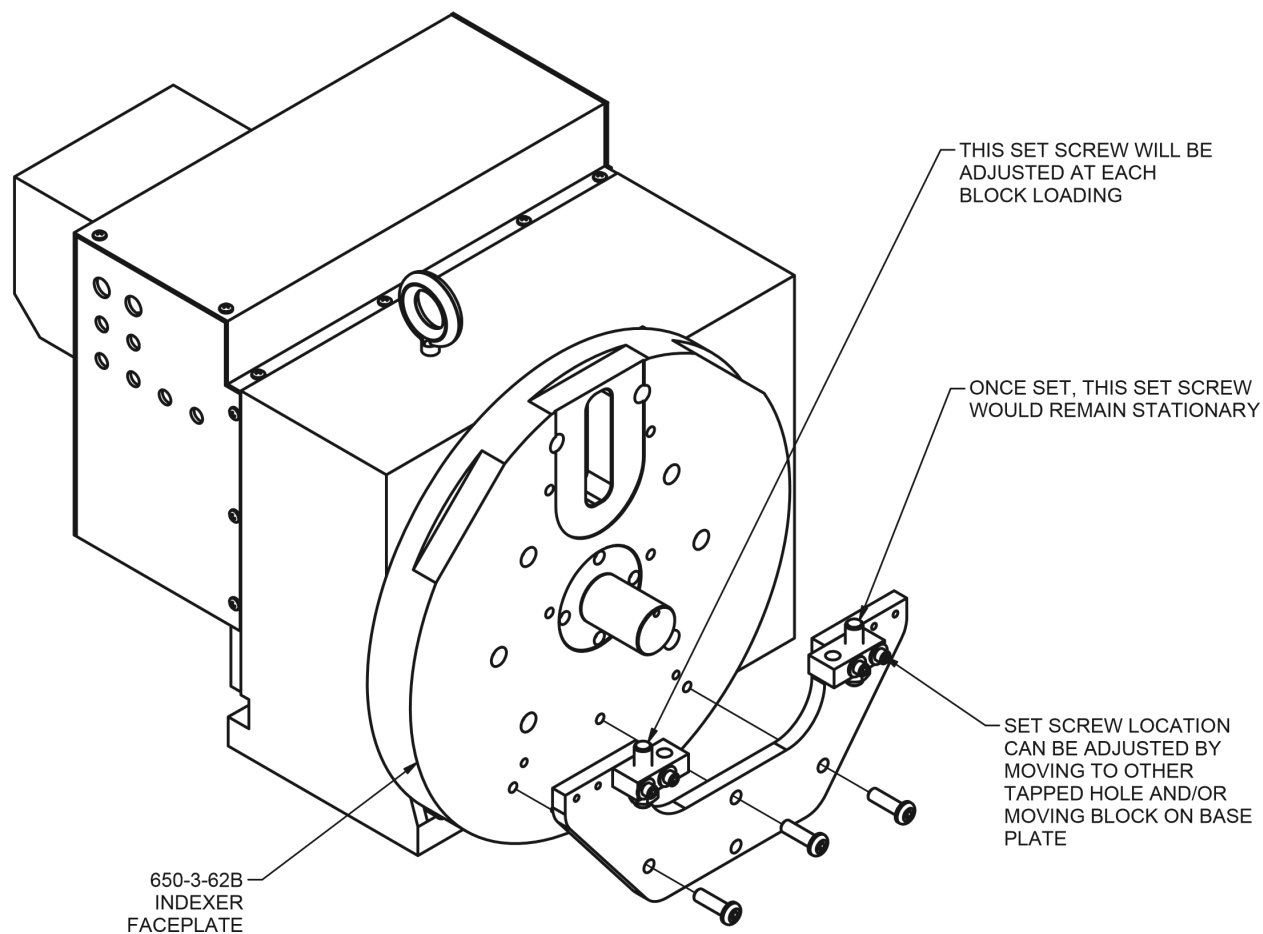
650-3-44S Rottler Precision Connecting Rod Fixturing System

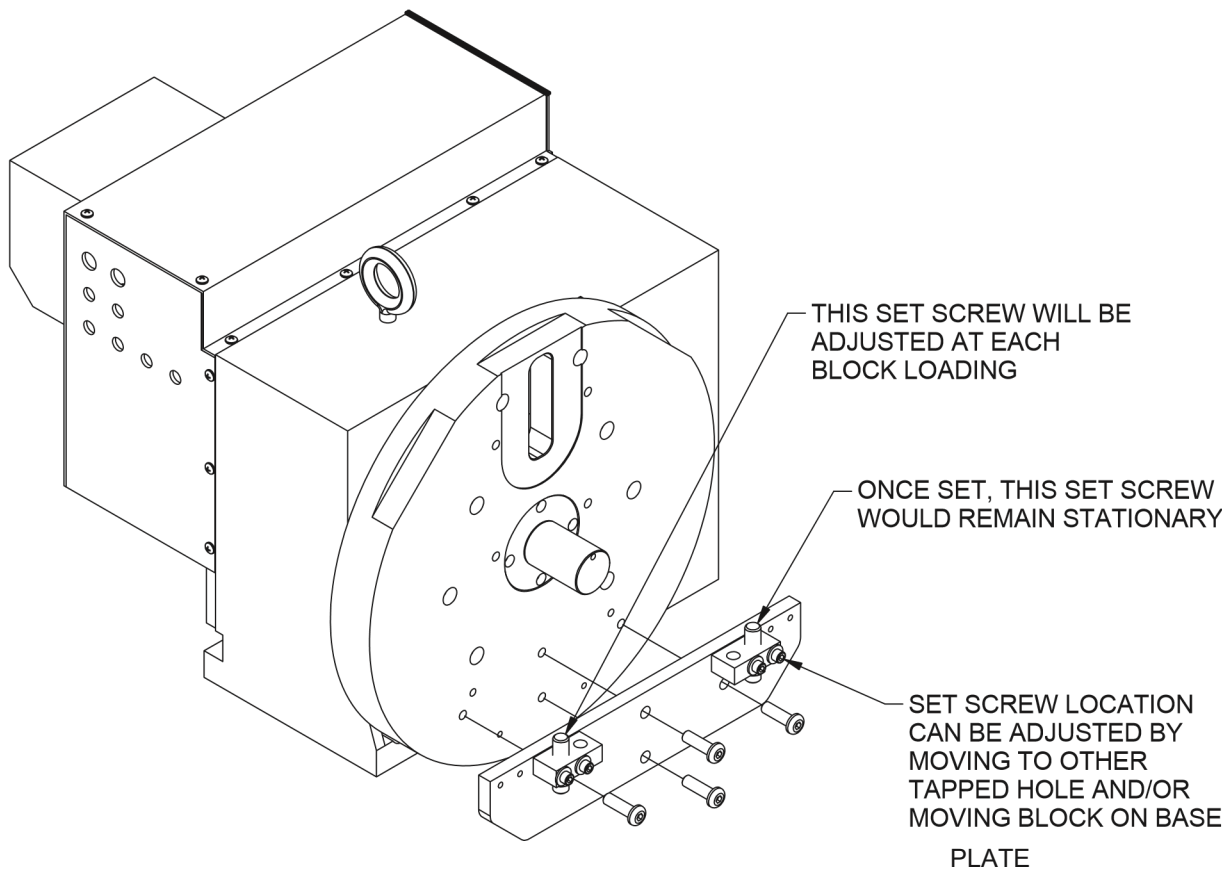
650-3-64 Heavy Duty Precision Connecting Rod Fixturing System
For large blocks, such as CAT 3500, Waukesha 7042, White Superior 825



690-3-70 Automatic 4Th Axis Block Roll Over Fixture

650-3-84 Overhead Cam Block Fixture Plates for 4th Axis

650-3-84 Overhead Cam Block Fixture Setup



650-3-84 OVERHEAD CAM BLOCK FIXTURE INSTALLATION AND OPERATING INSTRUCTIONS Y-BLOCK APPLICATIONS

INSTALLATION: LOCATE THE 650-3-84E BASE PLATE ONTO THE 650-3-62B INDEXER FACEPLATE USING (4) EXISTING 3/8-16UNC TAPPED HOLES IN FACEPLATE. FASTEN BASE PLATE USING (4) MF-97C SOCKET BUTTONHEAD SCREWS.

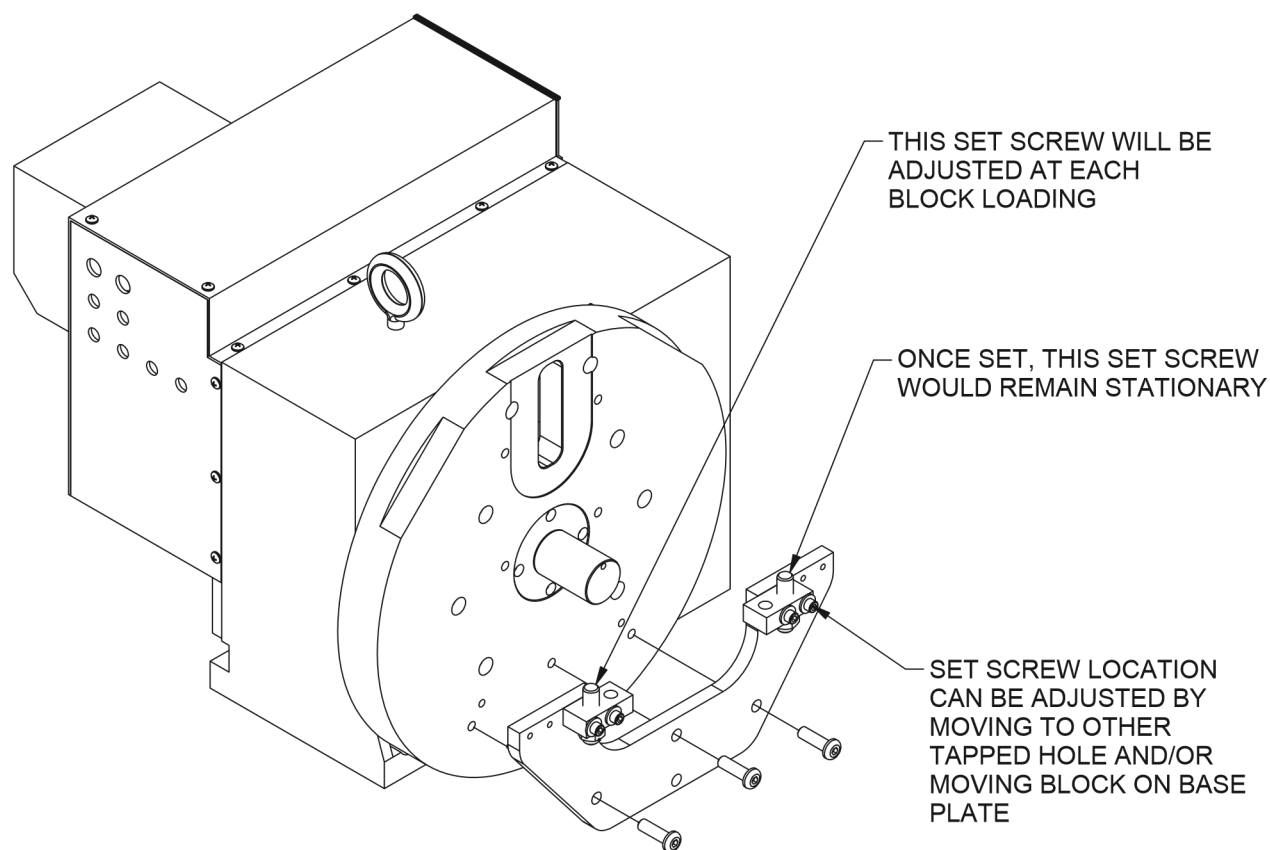
OPERATING: THIS FIXTURE LOCATES THE PAN RAILS OF OVERHEAD CAM BLOCKS USING (2) 650-3-84D FLAT POINT SET SCREWS TO LEVEL THE BLOCK.

INSTALL THE BLOCK USING THE APPROPRIATE MAIN LOCATORS WITH THE INDEXER SET AT 0 DEGREES.

WITH THE MF-171 HEX NUTS LOOSE, ADJUST THE 650-3-84D SET SCREWS TO CONTACT THE PAN RAIL OF THE BLOCK. MULTIPLE MOUNTING HOLES ARE PROVIDED TO ALTER THE LOCATION OF THE 650-3-84C PUSH BLOCKS AND THE SET SCREWS CAN BE MOVED TO EITHER HOLE TO FIT DIFFERENT BLOCKS.

ONCE THE BLOCK IS LEVEL AND THE SET SCREWS ARE BOTH CONTACTING THE PAN RAILS, TIGHTEN THE MF-171 HEX NUTS, CHECK THE BLOCK FOR LEVEL, AND MACHINE.

TO UNLOAD THIS BLOCK AND LOAD ANOTHER BLOCK OF THE SAME STYLE:
LOOSEN THE HEX NUT AND SET SCREW NEAREST TO THE OPERATOR. REMOVE THE BLOCK AND INSTALL THE NEXT BLOCK. ROTATE THIS BLOCK TO CONTACT THE SET SCREW TO THE REAR OF THE FACEPLATE (FURTHEST FROM THE OPERATOR). ADJUST FRONT SET SCREW TO CONTACT THE BLOCK AND TIGHTEN THE HEX NUT. IT IS ADVISABLE TO CHECK THE BLOCK FOR LEVEL DUE TO THE POSSIBILITY OF VARIATION BETWEEN BLOCKS.



650-3-84 OVERHEAD CAM BLOCK FIXTURE INSTALLATION AND OPERATING INSTRUCTIONS V-BLOCK APPLICATIONS

INSTALLATION: LOCATE THE 650-3-84A BASE PLATE ONTO THE 650-3-62B INDEXER FACEPLATE USING (4) EXISTING 3/8-16UNC TAPPED HOLES IN FACEPLATE. FASTEN BASE PLATE USING (4) MF-97C SOCKET BUTTONHEAD SCREWS.

OPERATING: THIS FIXTURE LOCATES THE PAN RAILS OF V-STYLE OVERHEAD CAM BLOCK USING (2) 650-3-84D FLAT POINT SET SCREWS TO LEVEL THE BLOCK.

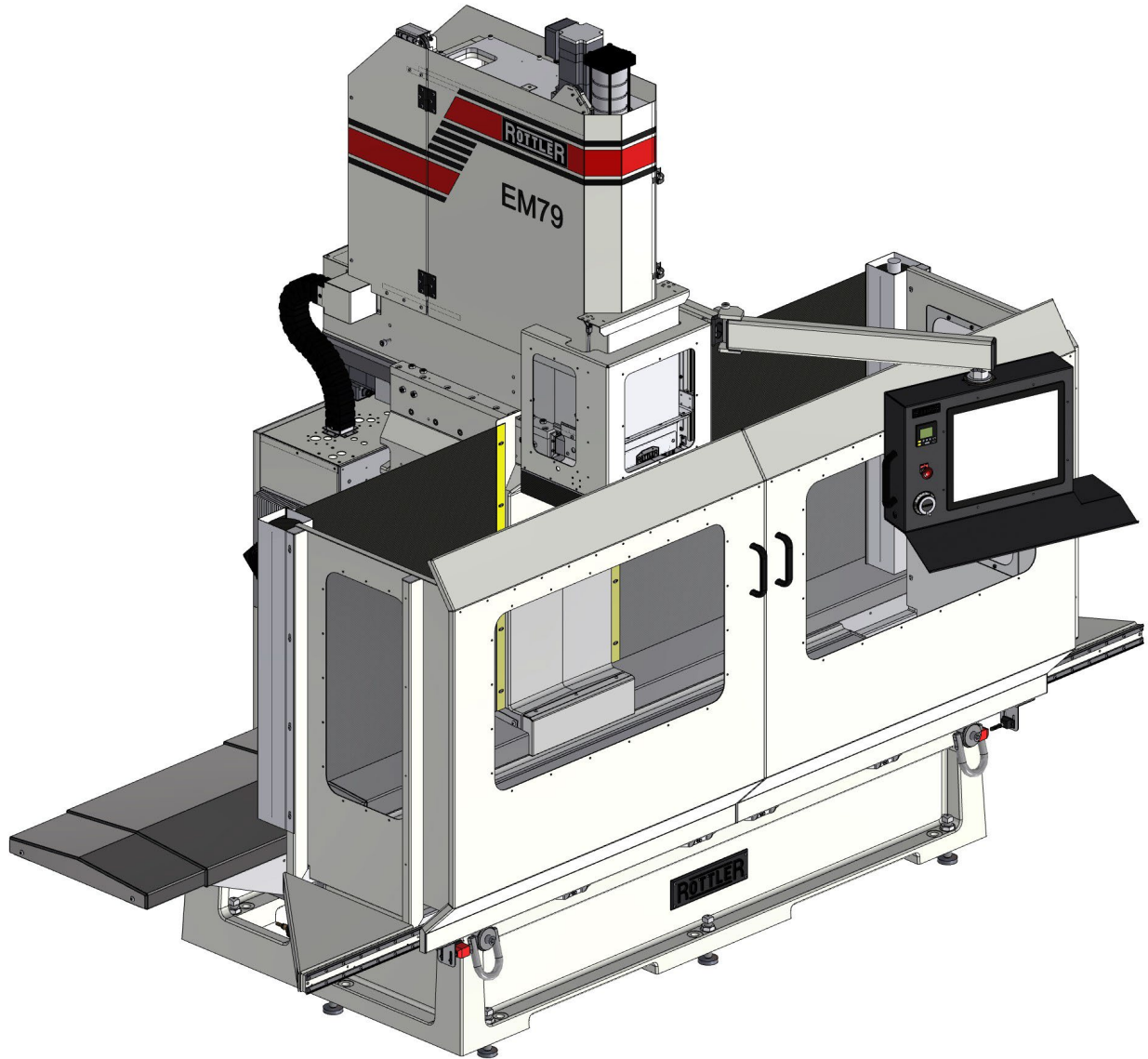
INSTALL THE BLOCK USING THE APPROPRIATE MAIN LOCATORS WITH THE INDEXER SET AT 0 DEGREES.

WITH THE MF-171 HEX NUTS LOOSE, ADJUST THE 650-3-84D SET SCREWS TO CONTACT THE PAN RAIL OF THE BLOCK. MULTIPLE MOUNTING HOLES ARE PROVIDED TO ALTER THE LOCATION OF THE 650-3-84C PUSH BLOCKS AND THE SET SCREWS CAN BE MOVED TO EITHER HOLE TO FIT DIFFERENT BLOCKS.

ONCE THE BLOCK IS LEVEL AND THE SET SCREWS ARE BOTH CONTACTING THE PAN RAILS, TIGHTEN THE MF-171 HEX NUTS, CHECK THE BLOCK FOR LEVEL, AND MACHINE.

TO UNLOAD THIS BLOCK AND LOAD ANOTHER BLOCK OF THE SAME STYLE:
LOOSEN THE HEX NUT AND SET SCREW NEAREST TO THE OPERATOR. REMOVE THE BLOCK AND INSTALL THE NEXT BLOCK. ROTATE THIS BLOCK TO CONTACT THE SET SCREW TO THE REAR OF THE FACEPLATE (FURTHEST FROM THE OPERATOR). ADJUST FRONT SET SCREW TO CONTACT THE BLOCK AND TIGHTEN THE HEX NUT. IT IS ADVISABLE TO CHECK THE BLOCK FOR LEVEL DUE TO THE POSSIBILITY OF VARIATION BETWEEN BLOCKS.

11038 Optional Machine Enclosure



11042 Automatic Rotary Tool Changer