

H85AX CNC HONE

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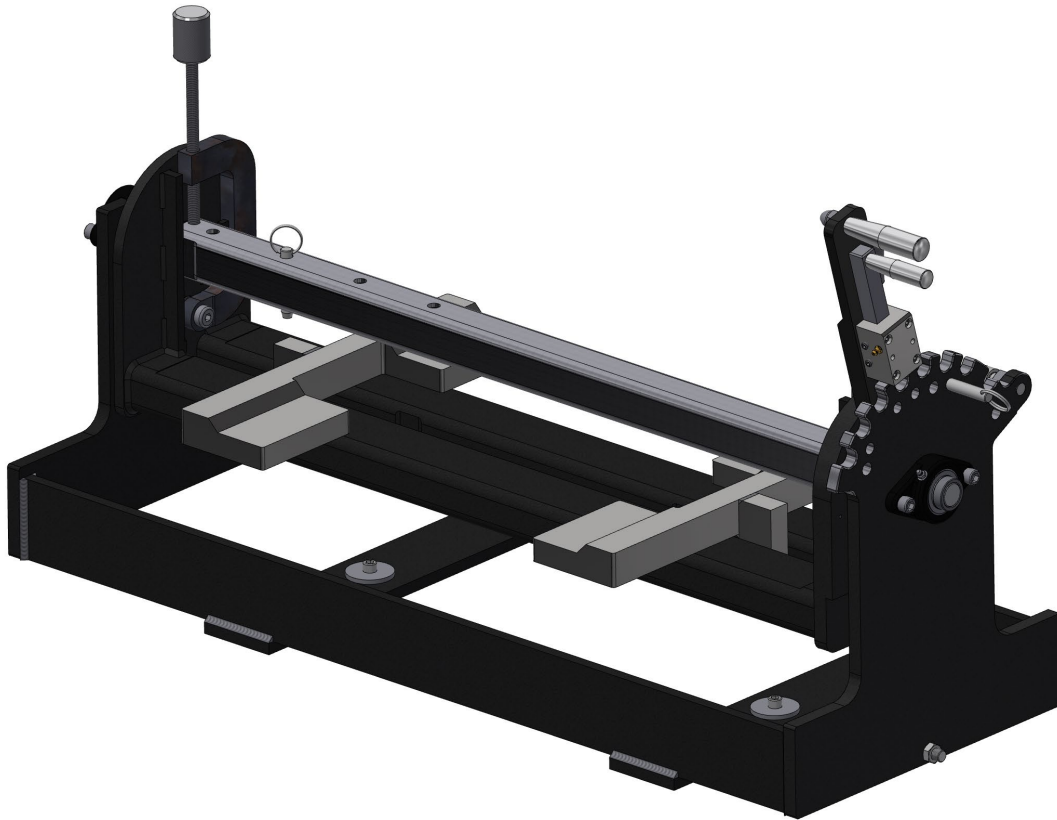


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Fixturing

Block Holding Fixtures

514-7A Manual Indexable Roll-over Fixture



502-1-30H Clamp Arm Assembly

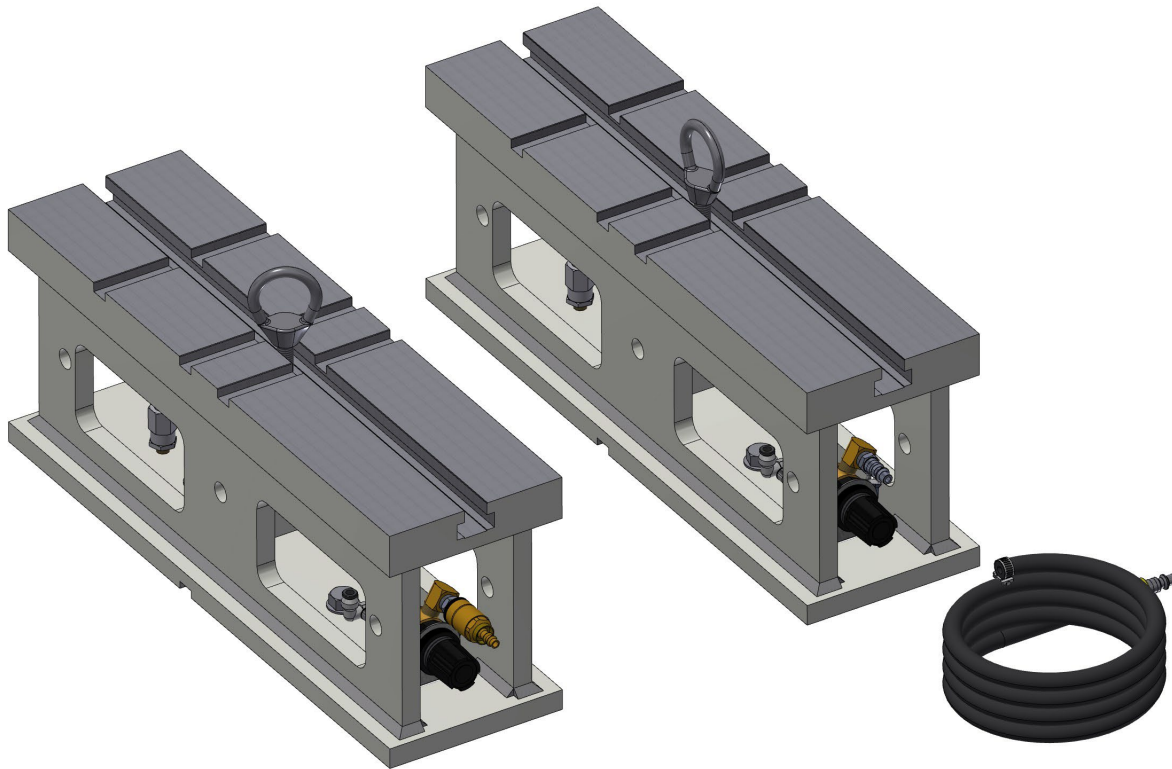
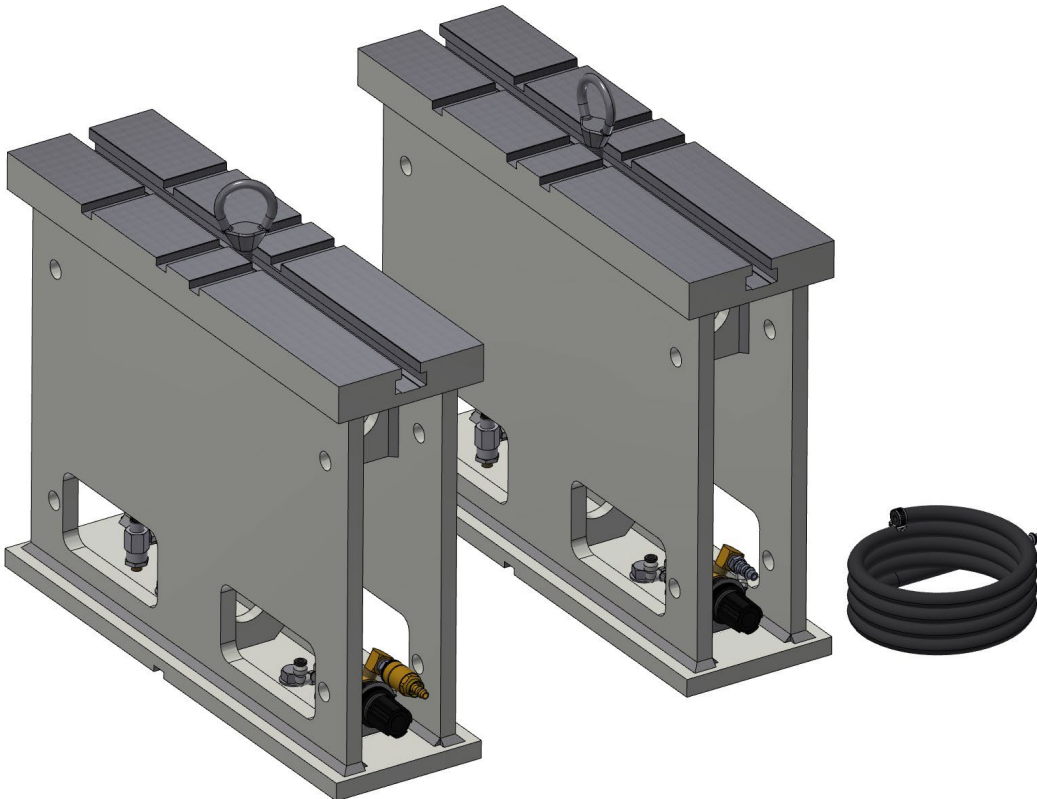


514-7-14E Small Diameter, 2" (508mm), Main Line Bar

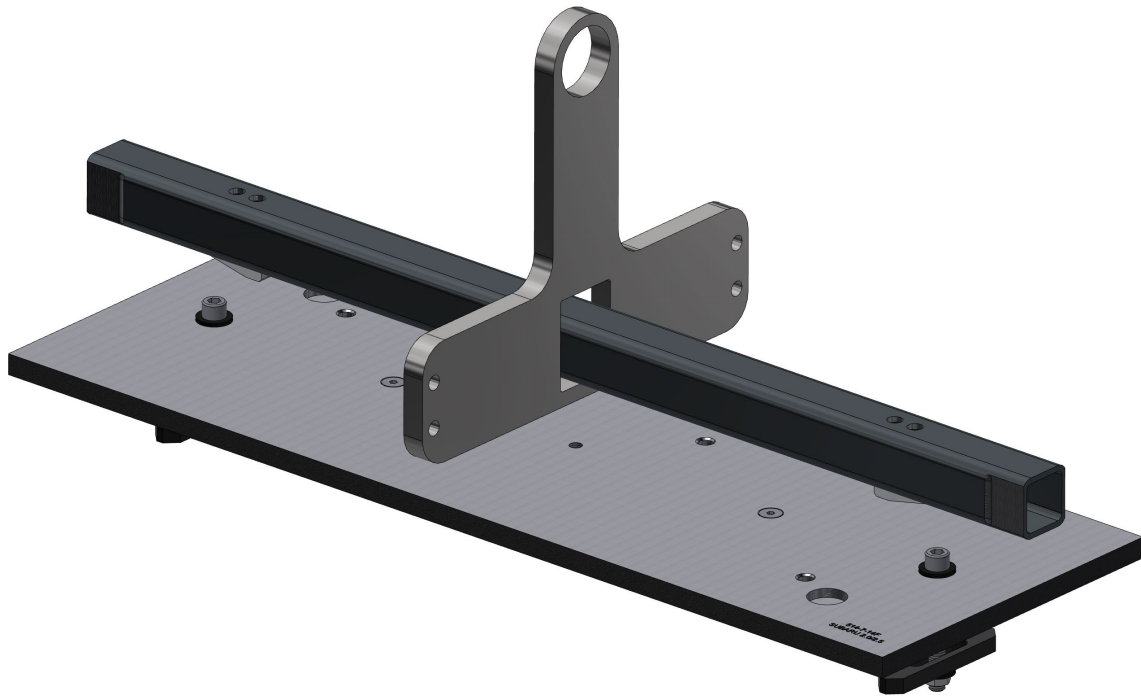


11115 2" X 3" (50mm X 75mm) Parallels



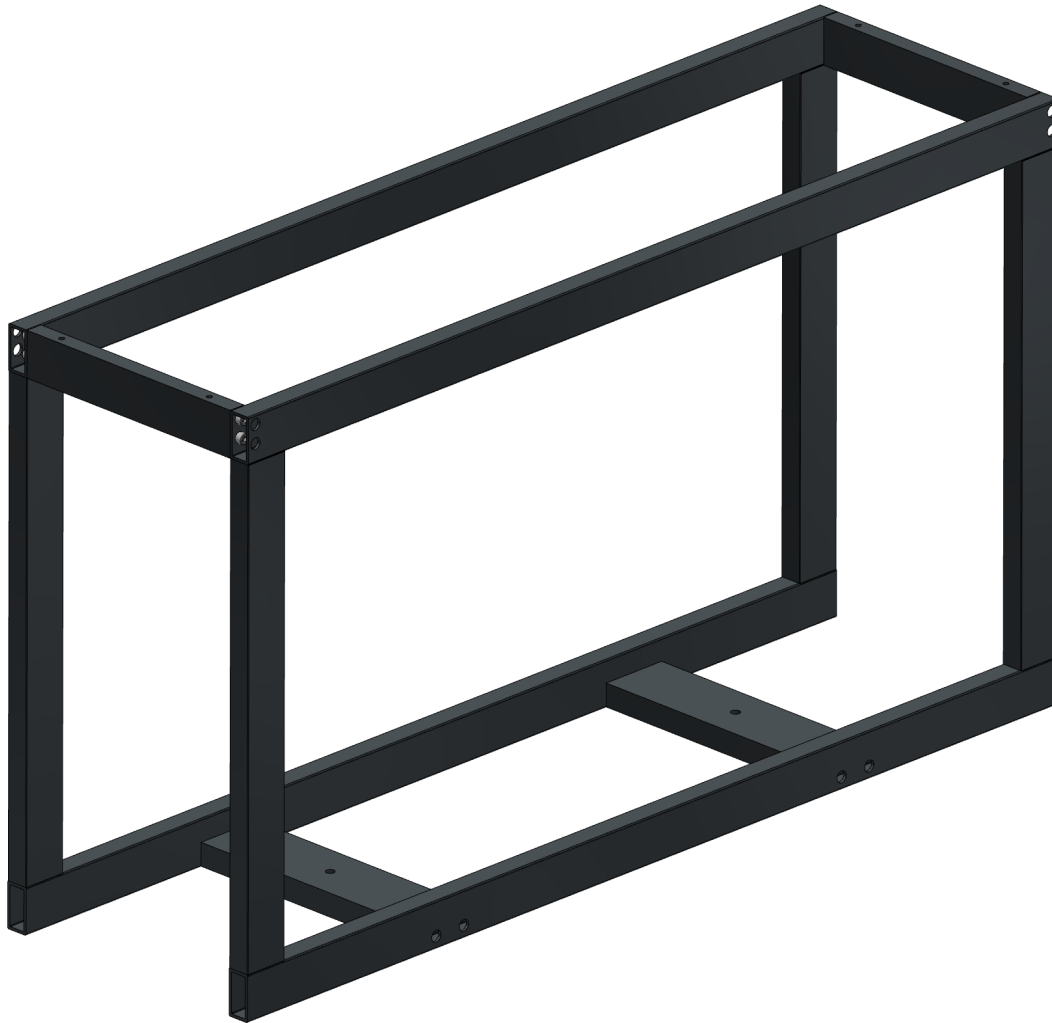
11112 Universal 8" (203mm) Heavy Duty T-Slot Parallels Parts**11114 Universal 16" (406mm) Heavy Duty T-Slot Parallels**

514-7-14F Subaru Block Hone Fixture



Cylinder Sleeve Fixtures

514-11-5 Cylinder Liner Honing Fixture



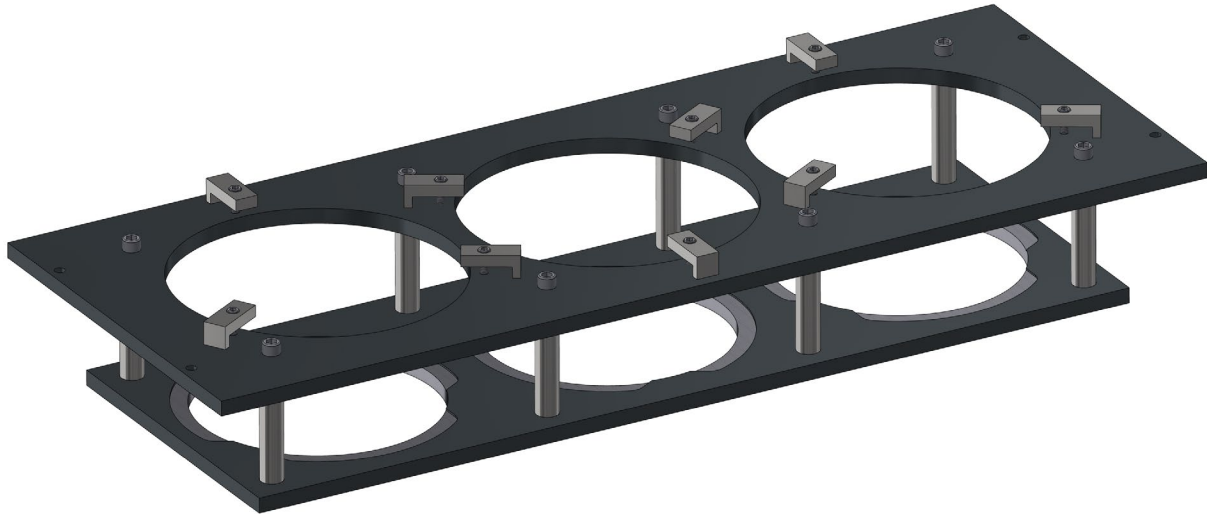
514-11-6 Fixture Plate, CAT 3400 Cylinder Sleeve



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



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



Hone Heads

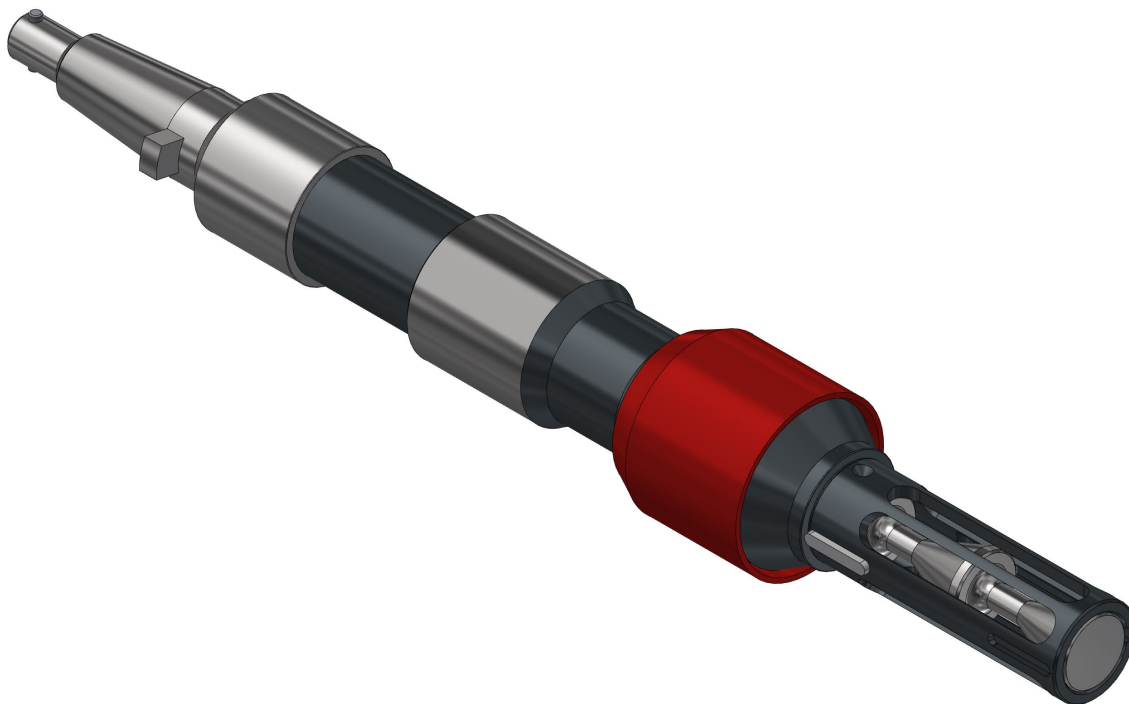
514-9J Medium Precision 4-Stone Hone Head

18.5" (470mm) Overall Length



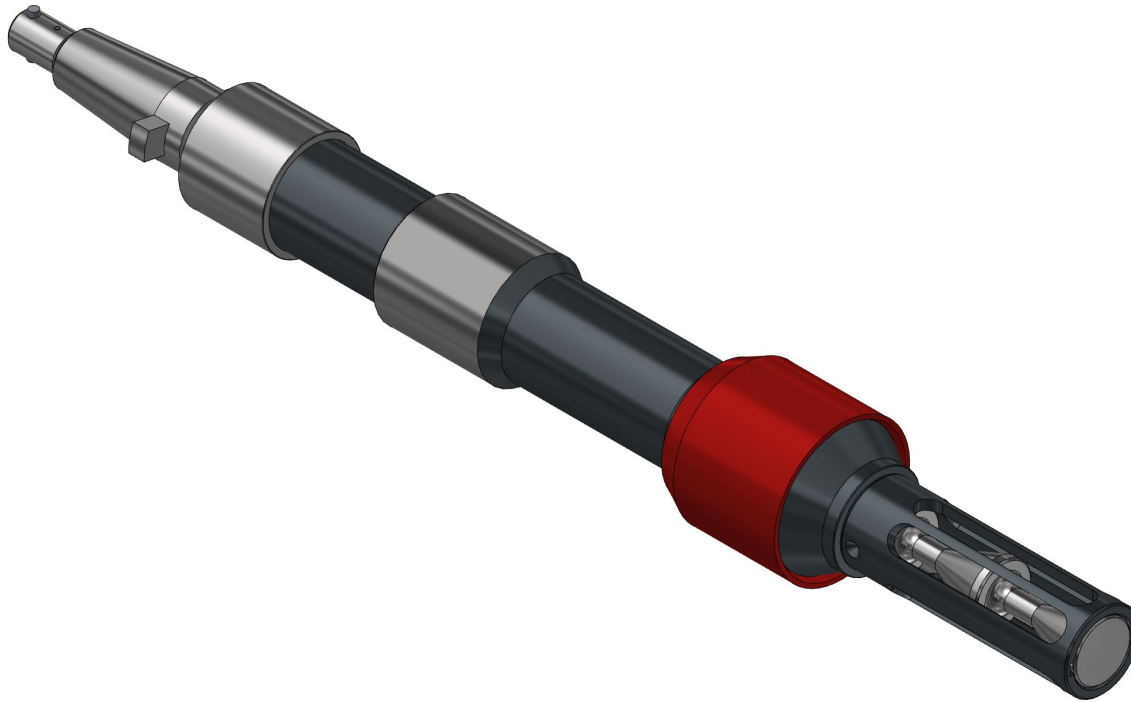
514-9Q Large Precision 6-Stone Hone Head

19.5" (496mm) Overall Length



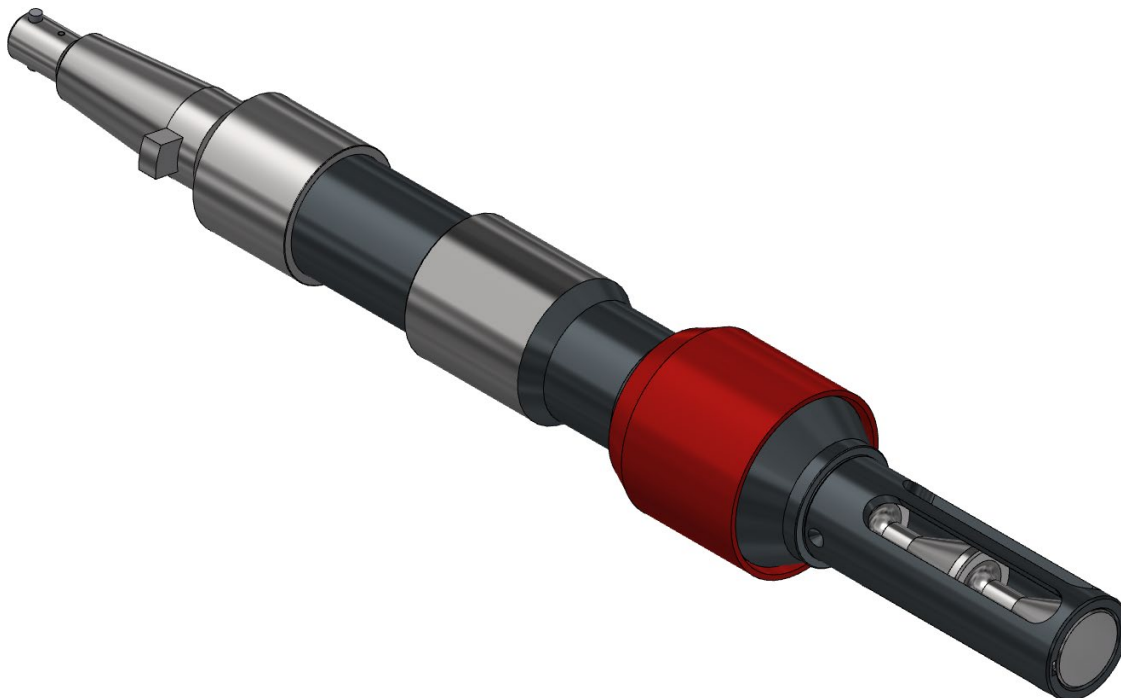
514-9S Large Precision 6-Stone Hone Head

21.5" (547mm) Overall Length



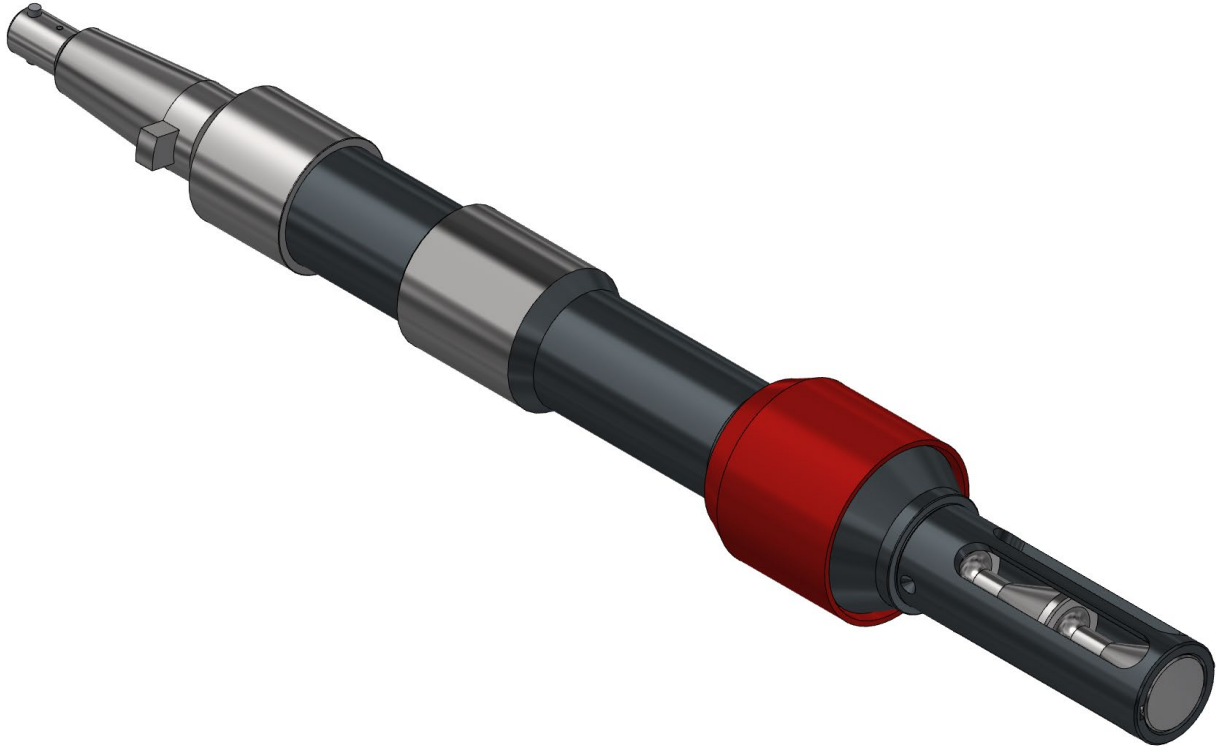
514-9P Large Precision 4-Stone Hone Head

19.5" (496mm) Overall Length



514-9R Large Precision 4-Stone Hone Head

21.5" (547mm) Overall Length



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



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



514-9-4C Sleeve Assembly, 4-Stone, 4.25-5.06" Dia.**514-9-4E Sleeve Assembly, 6-Stone, 2.77-3.88" Dia.**

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



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



514-9V Pin Hone Adapter



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



514-9M Dual Stage, 6-Stone Hone Head



Stone Holders

Stone Holder Size Chart

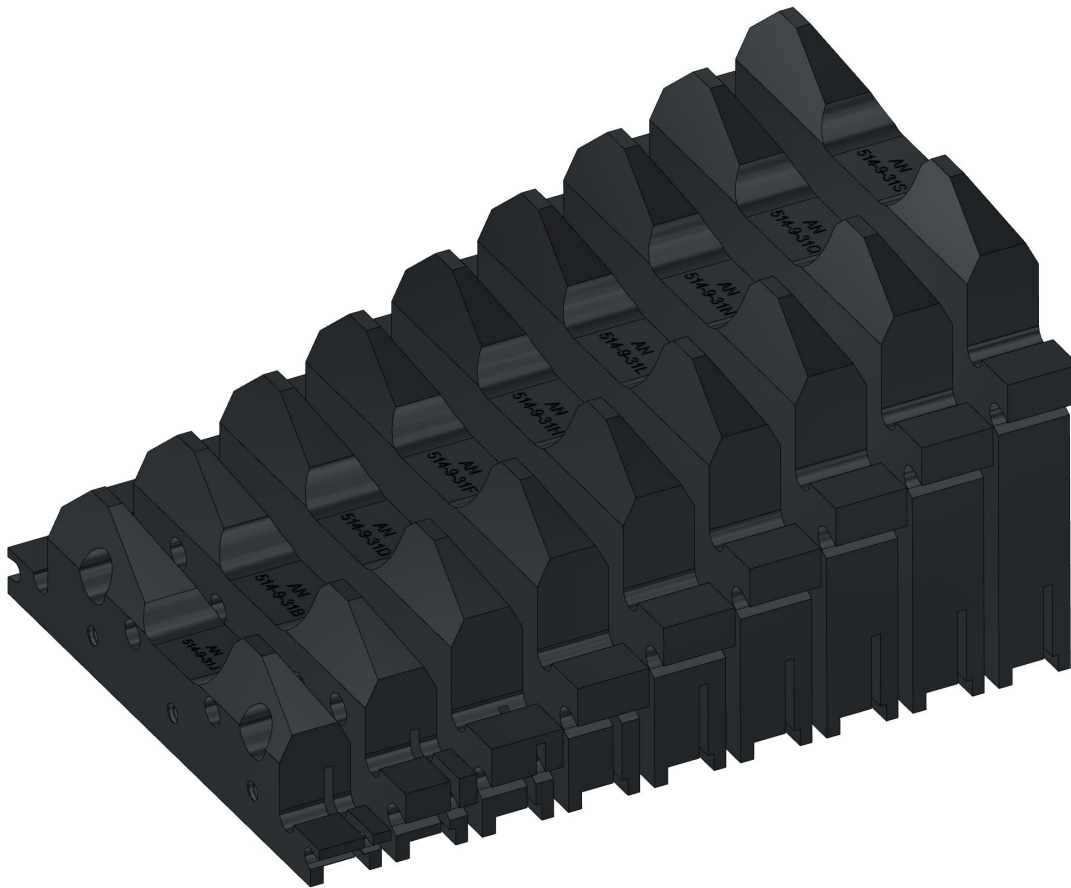
Holder PN	0.200" Stones		0.312" Stones		0.395" Brushes		0.550" Brushes	
	Min Dia in (mm)	Max Dia in (mm)	Min Dia in (mm)	Max Dia in (mm)	Min Dia in (mm)	Max Dia in (mm)	Min Dia in (mm)	Max Dia in (mm)
514-10-13 (4-Stone) Medium Series								
514-10-13A	2.12 (53.75)	2.23 (56.54)	2.34 (59.44)	2.45 (62.23)	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)
514-9-31 (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)
514-9-6B	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)
514-9-31C	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)
514-9-6C	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)
514-9-31D	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)
514-9-6D	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)
514-9-31E	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)
514-9-6E	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)
514-9-31F	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)
514-9-6F	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)
514-9-31G	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)
514-9-6G	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)
514-9-31H	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)
514-9-6H	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)

514-10-13 Series Stone Holders

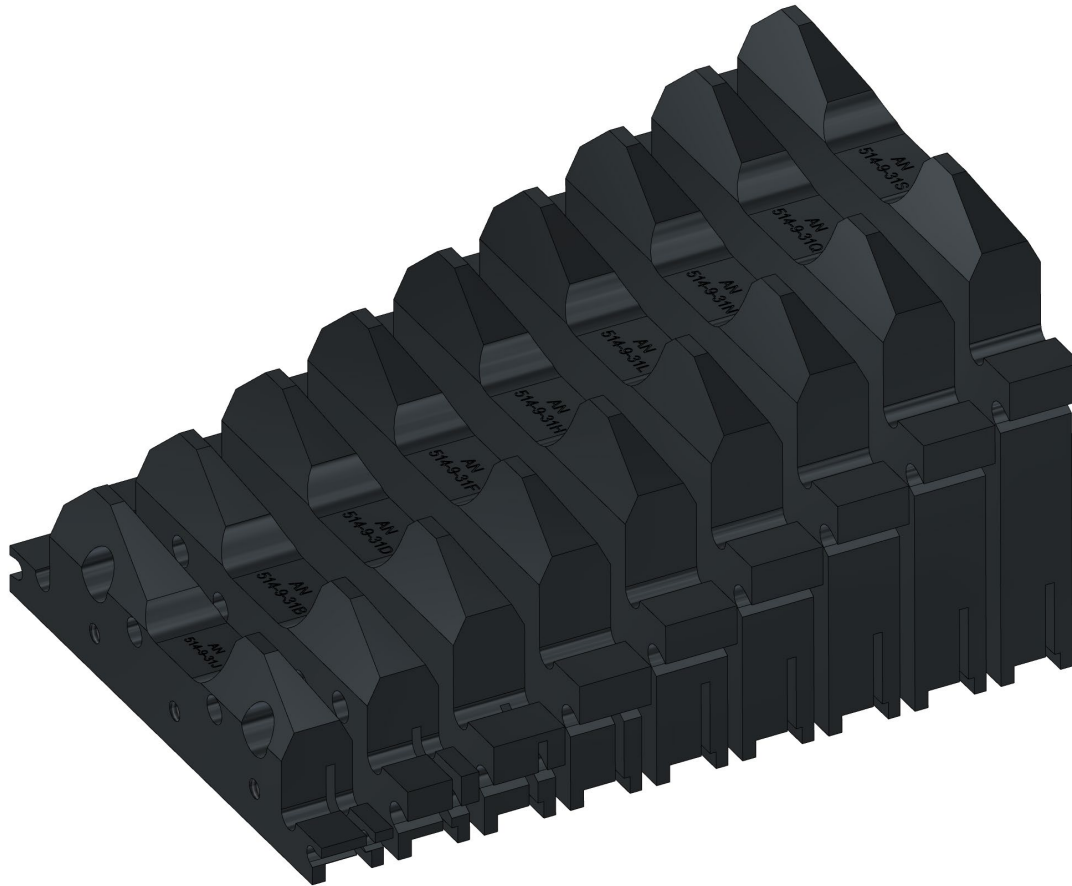
Sold in sets of 4

**514-9-31 Series Stone Holders**

Sold in sets of 6

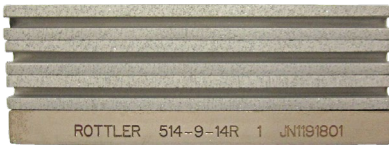
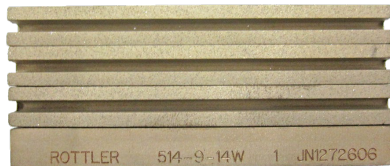
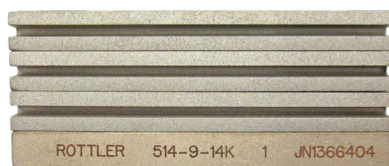
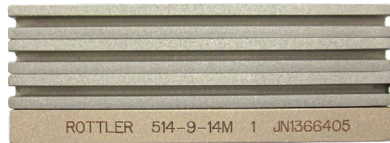
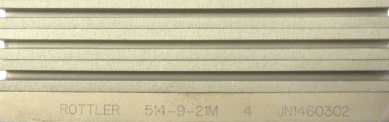
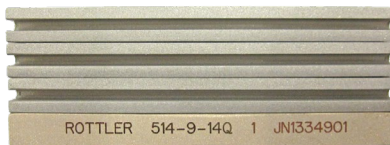


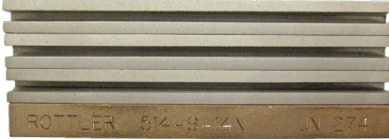
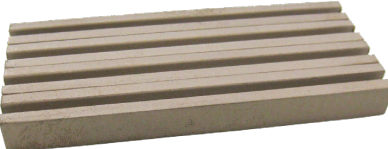
514-9-6 Series Stone Holders
Sold in sets of 4

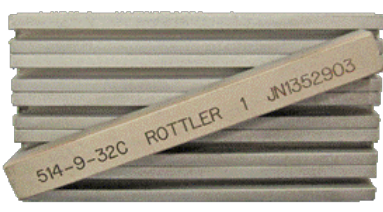
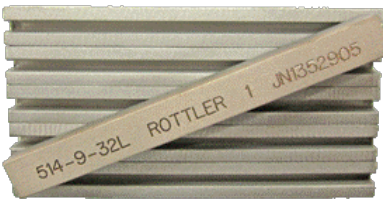
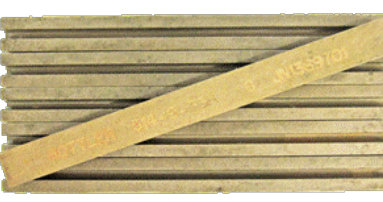


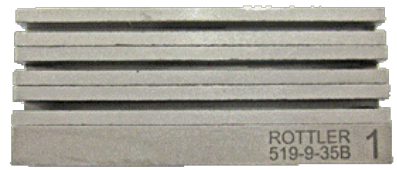
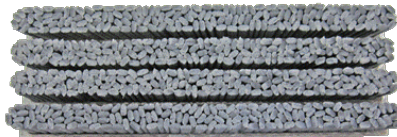
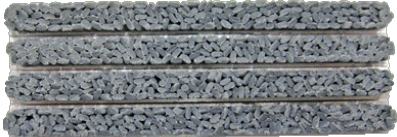
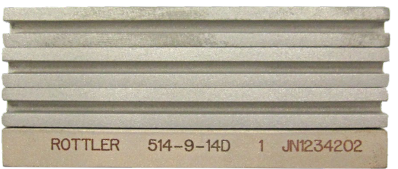
Stone Sets

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		
514-9-14F, 80 Grit 3" (76mm) Long, 90Ra (2.25µm), stock removal 0.004-.007in/min 	514-9-14R, 80 Grit 3 ½" (89mm) Long, 90Ra (2.25µm), stock removal 0.004-.007in/min 	514-9-21R, 80 Grit 4" (102mm) Long, 90Ra (2.25µm), stock removal 0.004-.007in/min 
514-9-14W, 140 Grit 3" (76mm) Long, 50-75Ra (1.25-1.88µm) 	514-9-21W, 140 Grit 4" (102mm) Long, 50-75Ra (1.25-1.88µm) 	514-9-14K, 170 Grit 3" (76mm) Long, 45-60Ra (1.13-1.5µm) 
514-9-14M, 170 Grit 3 ½" (89mm) Long, 45-60Ra (1.13-1.5µm) 	514-9-21M, 170 Grit 4" (102mm) Long, 45-60Ra (1.13-1.5µm) 	514-9-14J, 270/325 Grit 3" (76mm) Long, 35-45Ra (.88-1.13µm) 
514-9-14T, 270/325 Grit 3 ½" (89mm) Long, 35-45Ra (.88-1.13µm) 	514-9-14Z, 270/325 Grit 4" (102mm) Long, 35-45Ra (.88-1.13µm) 	514-9-14E, 325/400 Grit 3" (76mm) Long, 24-30Ra (.6-.75µm) 
514-9-14Q, 325/400 Grit 3 ½" (89mm) Long, 24-30Ra (.6-.75µm) 	514-9-14X, 325/400 Grit 4" (102mm) Long, 24-30Ra (.6-.75µm) 	514-9-14C, 325/400 Grit 3" (76mm) Long, 18-22Ra (.45-.55µm) 

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

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

CBN Stone Sets		
0.312" (7.92mm) Height, Set of 4		
514-9-35C, 320 Grit 3" (76mm) Long 	514-9-35D, 400 Grit 3" (76mm) Long 	514-9-35E, 500 Grit 3" (76mm) Long 
514-9-35B, 600 Grit 3" (76mm) Long 		
Brushes and Miscellaneous Finishing		
514-9-14H Brushes For Plateau Finishing 0.550" (14mm) High x 3 1/2" (89mm) Long. Set of 4 	514-9-14Y Brushes For Plateau Finishing 0.395" (10mm) High x 3 1/2" (89mm) Long. Set of 4 	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 
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 Paste. Set of 4. 
514-9-21F Silicone Paste For final sizing. Set of 4. 		

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

Coolant and Filter Equipment

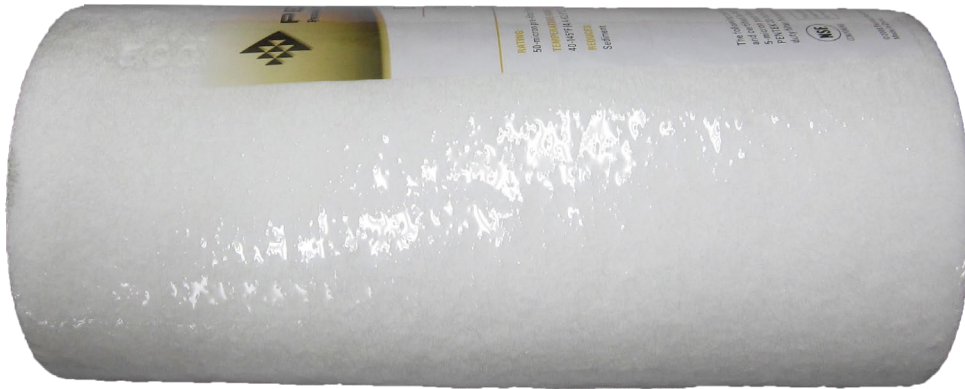
514-4-71C Synthetic Coolant

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



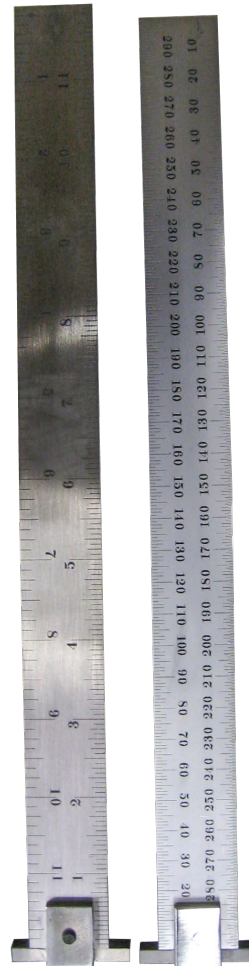
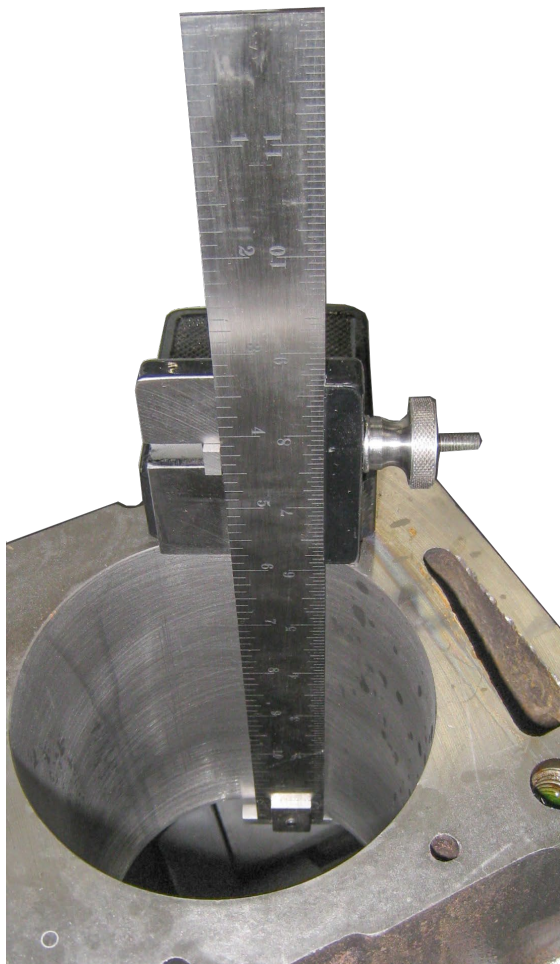
514-4-71D Coolant Refractor

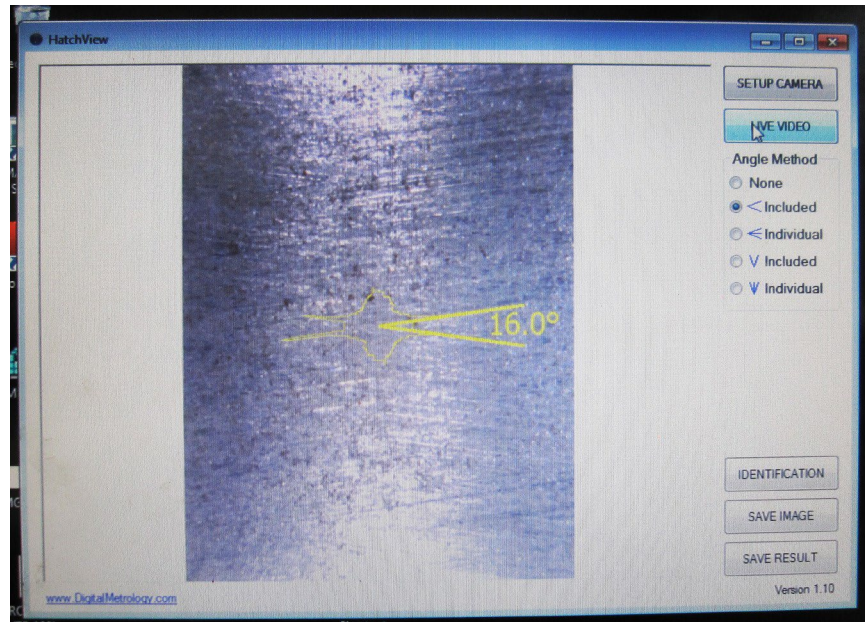


514-2-42C Dual Gradient 50-5 Micron Replacement Filter Cartridge
For standard filter system**514-2-42A Cannister Magnetic Filter System**

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 Equipment

514-14-99 Laser Light Curtain Safety System

