



H87AXY 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@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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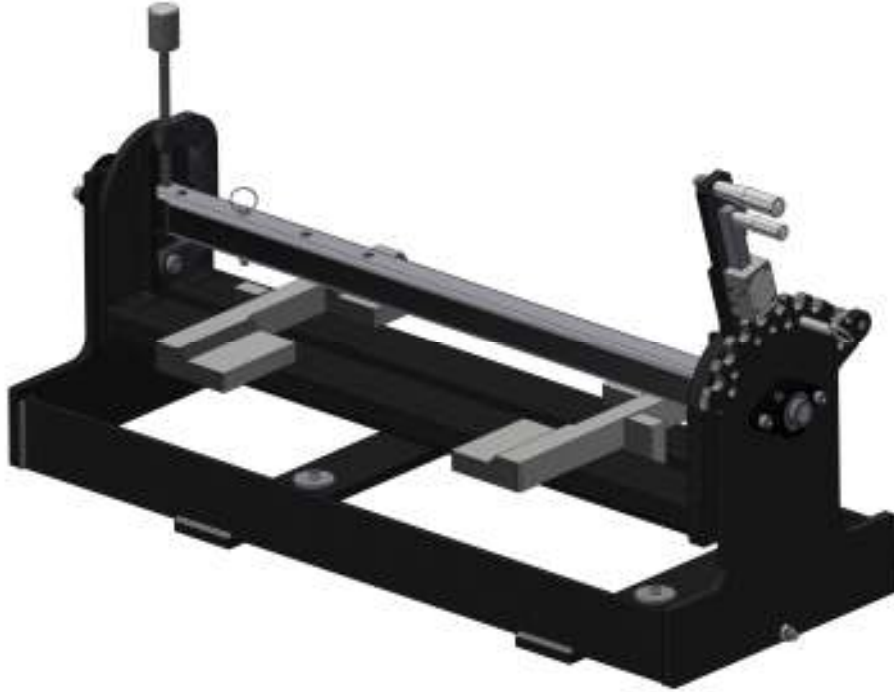


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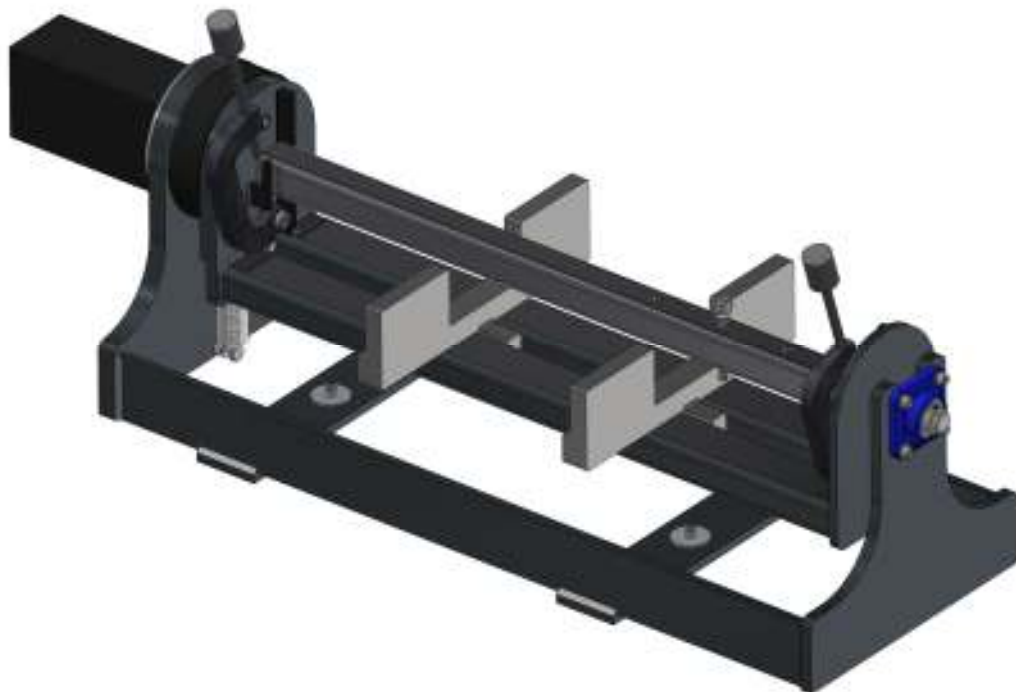
Fixturing

Block Holding Fixtures

514-7A Manual Indexable Roll-over Fixture



514-14-60 Automatic Programmable Roll-over Fixture



502-1-30H Clamp Arm Assembly



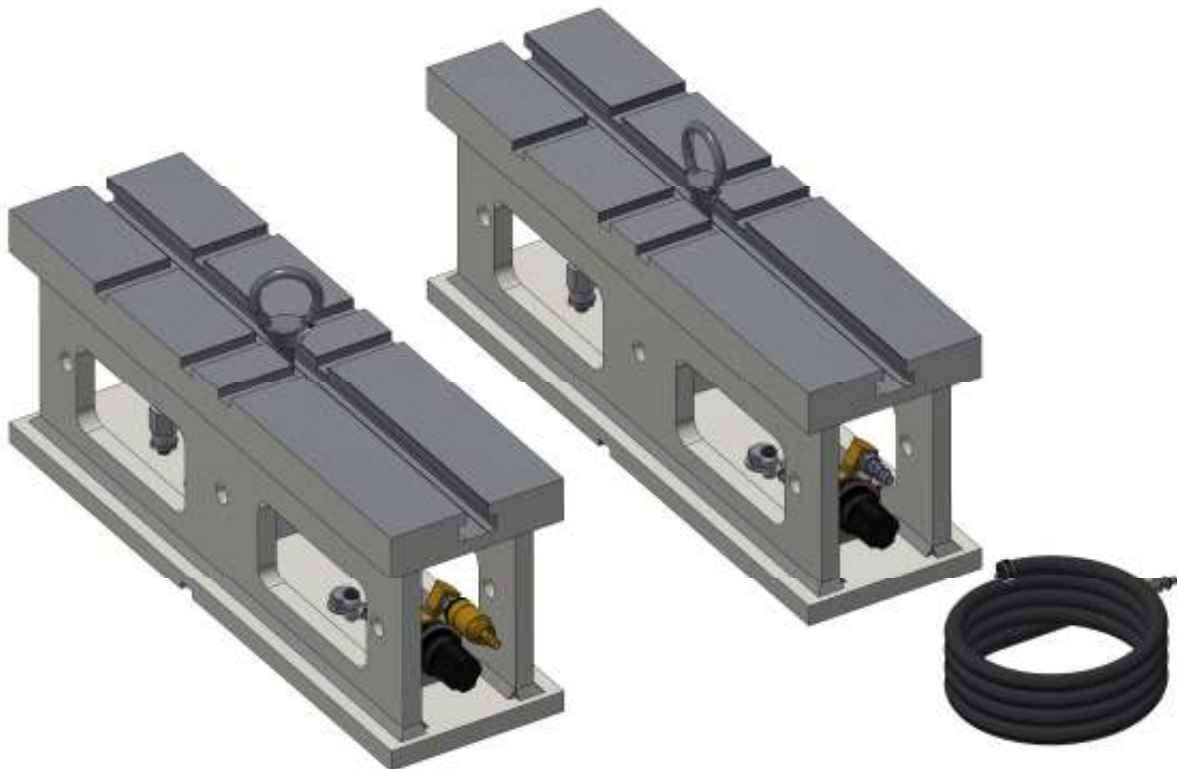
514-7-14E Small Diameter, 2" (508mm), Main Line Bar



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

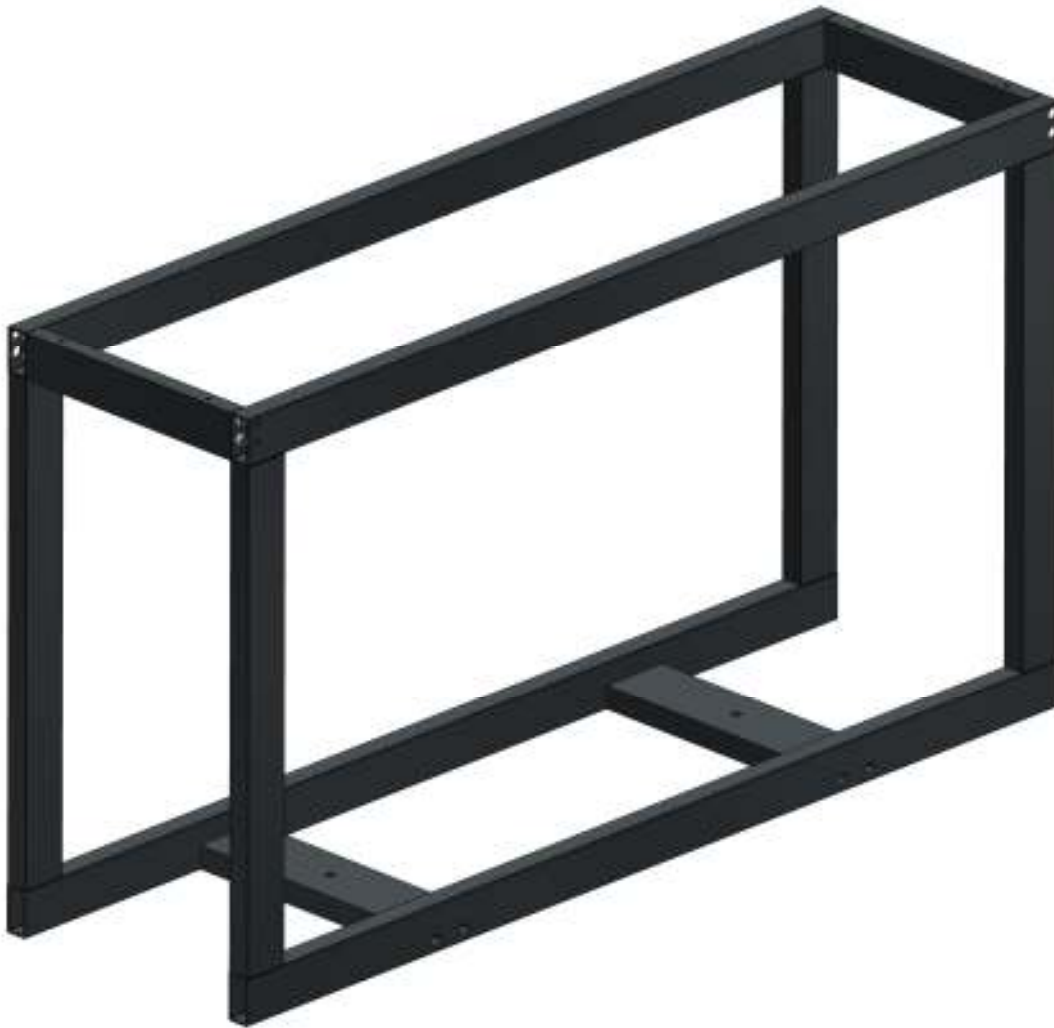


514-7-14F Subaru Block Hone Fixture



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



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



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



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



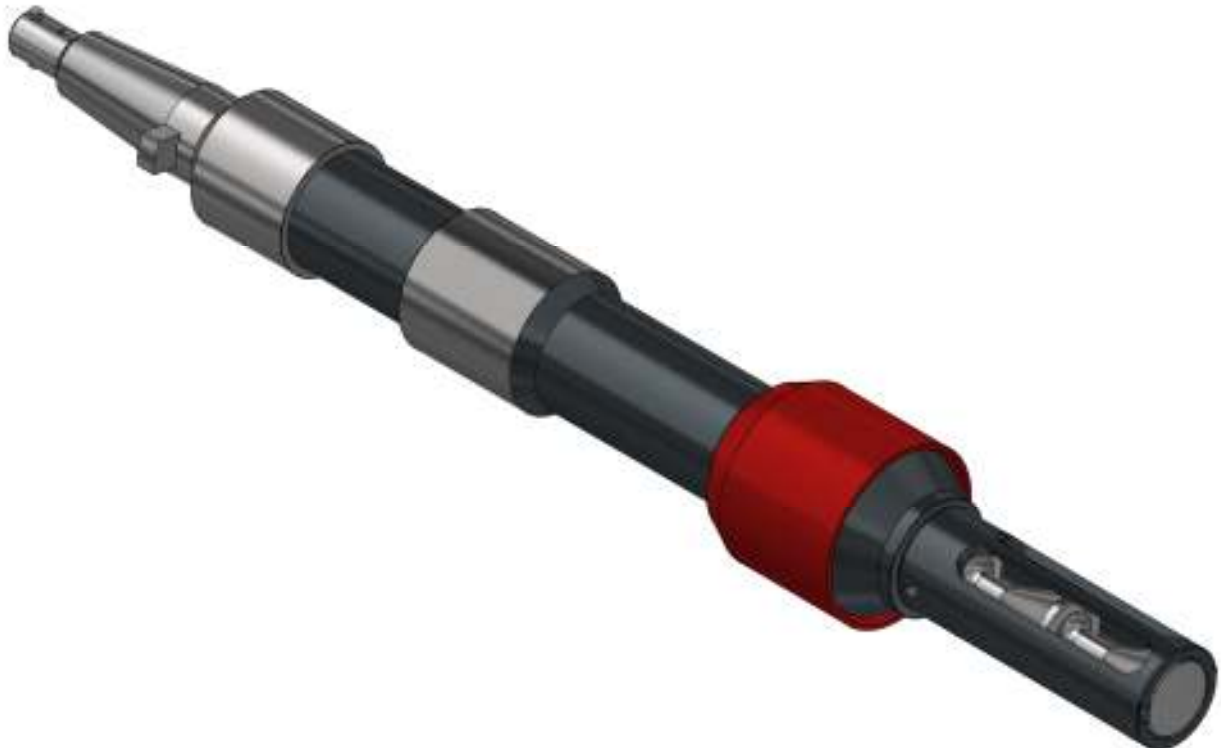
514-9P Large Precision 4-Stone Hone Head

19.5" (496mm) Overall Length



514-9R Large Precision 4-Stone Hone Head

21.5" (547mm) Overall Length



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



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



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



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



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



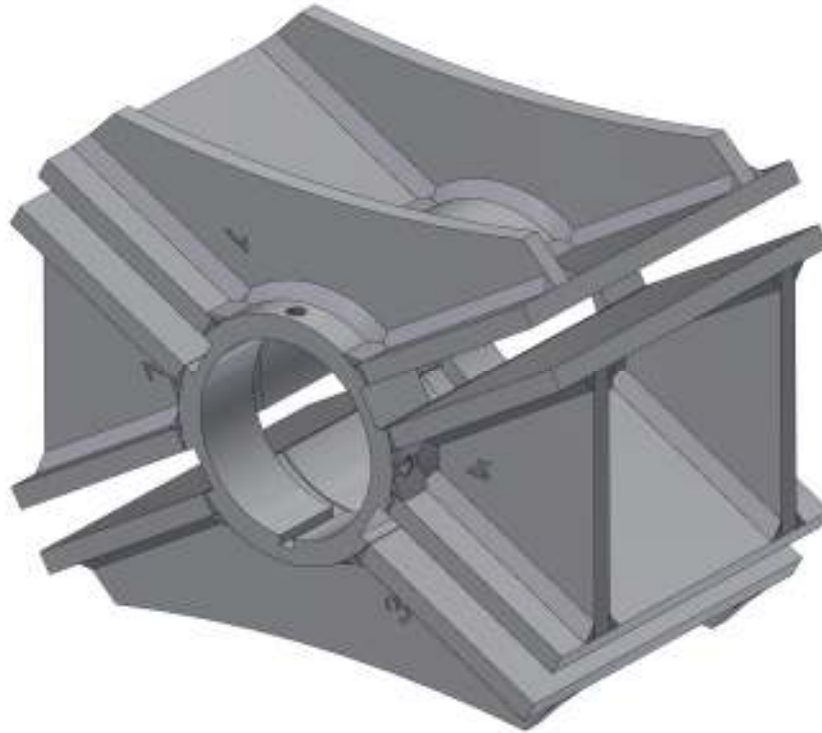
514-9-4F Sleeve Assembly, 6-Stone, 3.67-4.36" Dia.



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



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



514-9V 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)
514-9-6A	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)
514-9-6B	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)
514-9-6C	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)
514-9-6D	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)
514-9-6E	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)
514-9-6F	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)
514-9-6G	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)
514-9-31I								
514-9-6H								
514-9-31K								
514-9-6I								
514-9-31L								
514-9-6J								
514-9-31M								
514-9-6K								
514-9-31N								
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514-9-31S								
514-9-6P								

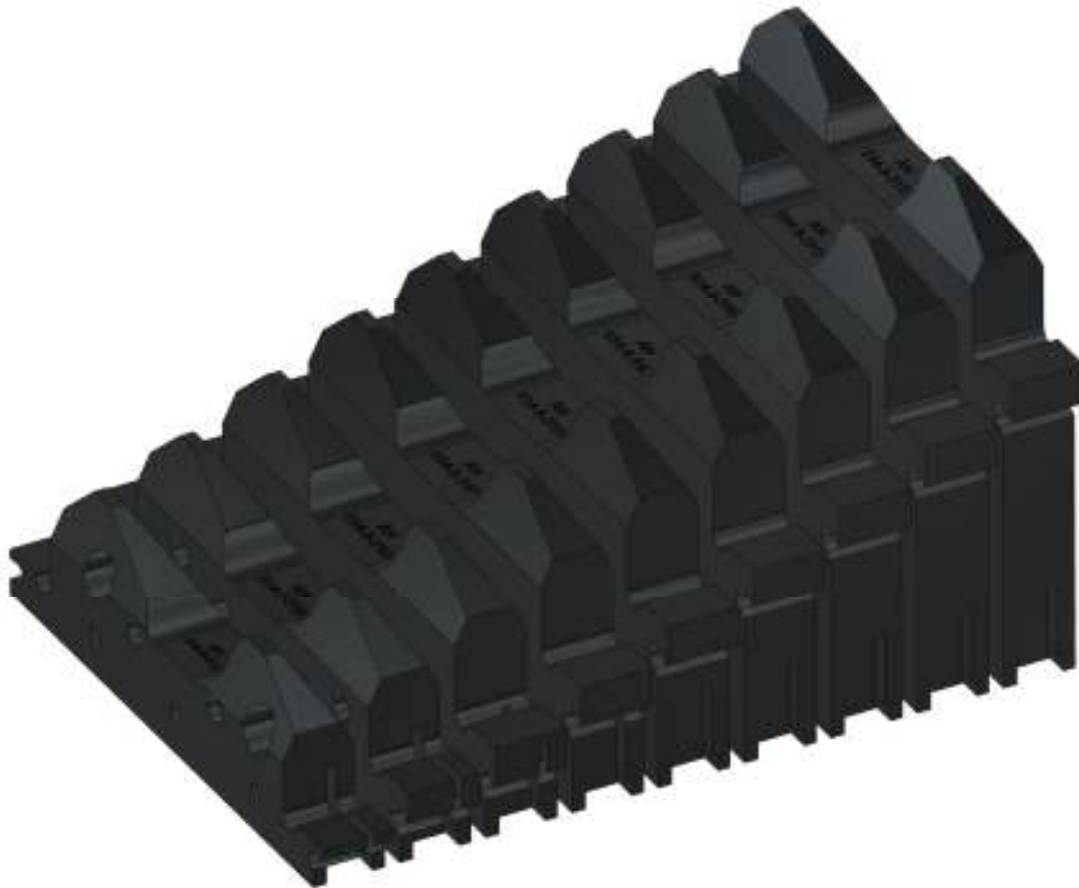


Holder PN	0.200" Stones		0.312" Stones		0.395" Brushes		0.550" Brushes	
	Min Dia in (mm)	Max Dia in (mm)	Min Dia in (mm)	Max Dia in (mm)	Min Dia in (mm)	Max Dia in (mm)	Min Dia in (mm)	Max Dia in (mm)
514-9-25 (4-Stone) Extra Large Series								
514-9-25A	5.99 (152.1)	6.29 (159.7)	6.1 (154.9)	6.4 (162.6)	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



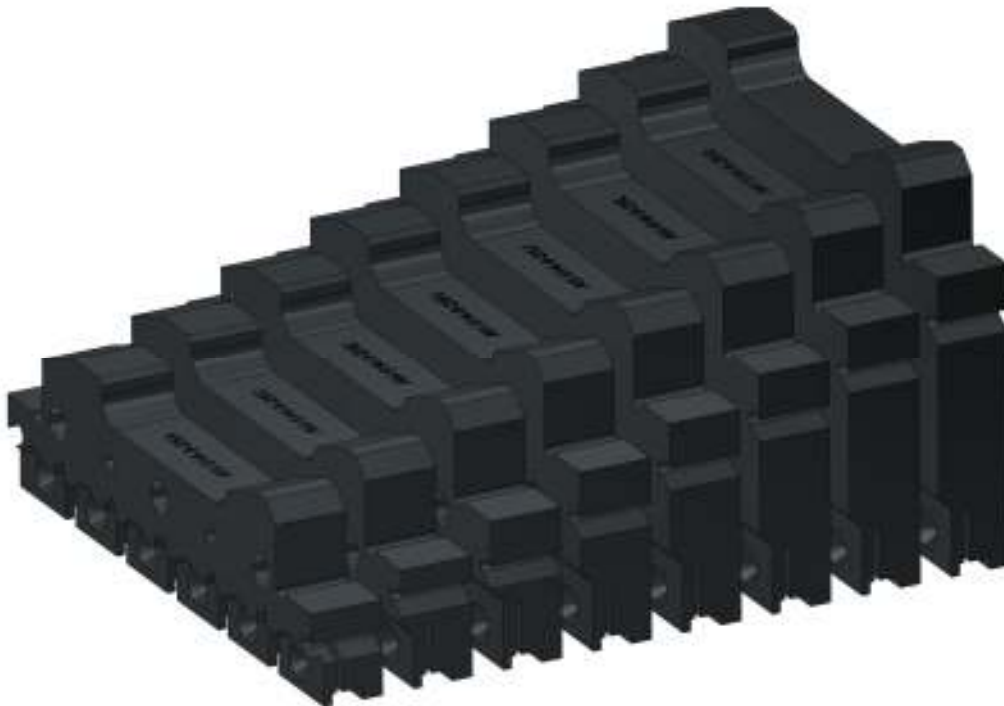
514-9-31 Series Stone Holders
Sold in sets of 6



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



514-9-25 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" (19.38mm) Height 	110-163R, 325/400 Grit 0.859" (22.73mm) Height Image Currently Unavailable	110-163R-01, 140/170 Grit 0.859" (22.73mm) Height Image Currently Unavailable
110-163R-03, 600 Grit 0.859" (22.73mm) Height Image Currently Unavailable	110-164R, 325/400 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-03, 60 Grit 0.937" (23.80mm) Height Image Currently Unavailable		
Dual Stage Brush Sets (For use with 514-9M Hone Head), Sets of 4		
124-24 Brush Set 0.781" (19.84mm) 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

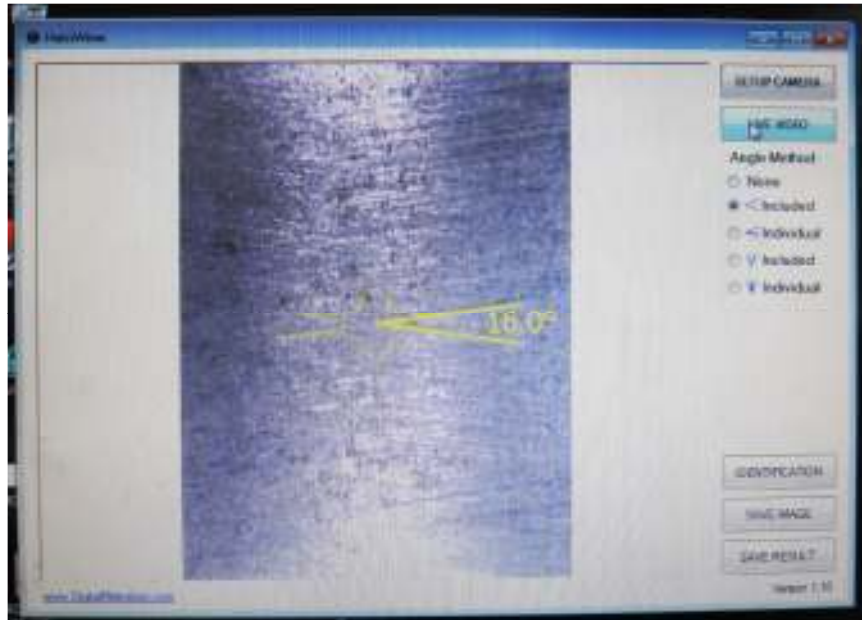
201 Mitutoyo Surface Tester



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 Systems

514-14-99 Laser Light Curtain

