



# Haas Factory Outlet

A Division of Lance Company

## Haas Vertical Machining Center Recommended Maintenance Schedule

### Daily

- ∞ Run spindle warm up program at the beginning of the first shift.
- ∞ Check coolant level and concentration each eight-hour shift.
- ∞ Check way lube lubrication tank level.
- ∞ Clean chips from way covers and bottom pan.
- ∞ Clean chips from tool changer.
- ∞ Clean pallets and pallet change switches (if applicable).
- ∞ Wipe spindle taper with a clean cloth rag and apply light oil.

### Weekly

- ∞ Check Through the Spindle Coolant (TSC) filters. Clean or replace element if needed.
- ∞ Check for proper operation of auto drain on filter regulator.
- ∞ On machines with the TSC option, clean the chip basket on the coolant tank.
- ∞ Remove the tank cover and remove any sediment inside the tank. Disconnect the coolant pump from the cabinet and **power off** the machine before working on the coolant tank.
  - **Do this MONTHLY for machines without the TSC option.**
- ∞ Check air gauge/regulator for 85 psi. Check the spindle air pressure regulator for 17 psi.
  - For 15K-spindle machines, check spindle air pressure regulator for 20 psi.
- ∞ For machines with the TSC option, place a dab of grease on the V-flange of tools.
  - **Do this MONTHLY for machines without the TSC option.**
- ∞ Clean exterior surfaces with mild cleaner. **DO NOT** use solvents.
- ∞ Check the hydraulic counterbalance pressure according to the machine's specifications.

### Monthly

- ∞ Check oil level in gear box.
  - **For 40 taper spindles:** Remove inspection cover beneath spindle head. Add oil slowly from top until oil begins dripping from overflow tube at bottom of sump tank
  - **For 50 taper spindles:** Check oil level in sight glass. Add from side of gearbox if necessary. (Check dipstick on some models)
- ∞ Inspect way covers for proper operation and lubricate with light oil, if necessary.
- ∞ Place a dab of grease on the outside edge of the guide rails of the (carousel style) tool changer and run through all tools.
- ∞ **EC-400** Clean the locating pads on the A-axis and the load station. This requires removing the pallet

**Maintenance and Service Questions please call 215.245.5500 and ask for the Service Department**



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### Six months

- ∞ Replace coolant and thoroughly clean the coolant tank.
- ∞ Check all hoses and lubrication lines for cracking.
- ∞ Check the rotary A-axis. If necessary add oil (Mobil SHC-630). The correct oil level is halfway on the sight glass.
- ∞ Check SMTC oil level in sight glass, (see Side Mount Tool Changer Oil Level in maintenance section of operators manual).

### Annually

- ∞ Replace the gearbox oil. Drain the oil from the bottom of the gearbox. Remove inspection cover beneath spindle head. Add oil slowly from top until oil begins dripping from overflow tube at bottom of sump tank.
  - **For 50 taper spindles**, add oil from the side of the transmission.
- ∞ Check oil filter and clean out residue at bottom of filter.

### 2 years

- ∞ Replace air filter on control box.
- ∞ **EC-400** Replace the Rotary A-axis oil

#### Note:

These suggested intervals are for the average installation. Your manufacturing environment may dictate higher frequency of these inspections and actions.

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