



Haas Factory Outlet

A Division of Lance Company

Haas Horizontal Machining Center Recommended Maintenance Schedule

Daily

- ∞ Run spindle warm up program at the beginning of the first shift.
- ∞ Check coolant level and concentration (between 6% and 7%) each eight-hour shift.
- ∞ Check way lube lubrication tank level. Add oil as necessary per label on tank.
- ∞ Clean chips from way covers and bottom pan.
- ∞ Clean chips from tool changer carousel (HS series) or double arm (EC series)
- ∞ Clean pallets.
- ∞ Wipe spindle taper with a clean cloth rag and apply light oil.
- ∞ Check oil level on 1000 psi TSC system pump.

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 coolant 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 25 psi. The 12K and 15 K spindles are set to 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 (if applicable).

Monthly

- ∞ Check oil level in gear box (if applicable)
 - **For 40 taper spindles:** Add oil slowly into the fill cup on the oil reservoir until full.
 - **For 50 taper spindles:** Check oil level in sight glass on side of transmission. Add oil in fill cup if necessary (Mobil DTE-25)
- ∞ Inspect way covers for proper operation and lubricate with light oil, if necessary.
- ∞ Clean the locating pads on the A-axis and the load station. This requires removing the pallets.

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 oil level. If necessary add oil (Mobil SHC-630). The correct oil level is halfway on the sight glass.
- ∞ Check EC series SMTC oil level by removing plug and feeling for oil with finger. (see Side Mount Tool Changer Oil Types) in maintenance section of operators manual).
- ∞ Lubricate HS 3/4/6/7 38-Tool Toolchanger
 - Magazine drive gear, tool pot, changer slide rack with red grease
 - Arm shaft with Moly grease
 - Changer slide linear guide with red grease

Annually

- ∞ Replace the gearbox oil (if applicable) in **40 taper spindles**. Drain the oil from the bottom of the gearbox sump. Add two quarts of DTE-25 oil slowly in the oil fill cup until level is at bottom of cup.
 - **For 50 taper spindles**, (EC-1600 and HS 3-7) remove sheetmetal necessary to gain access to the transmission. Drain and replace oil as per operator manual.
- ∞ Check oil filter and clean out residue at bottom of filter.
- ∞ Check fluid level in hydraulic brake booster (EC-1600 – 3000 , HS 3-7R) Fill to proper level.

2 years

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

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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