



# Haas Factory Outlet

A Division of Lance Company

## Haas Lathe Recommended Maintenance Schedule

The following is a list of required regular maintenance for the Haas SL-Series Turning Centers. Listed are the frequency of service, capacities, and type of fluids required. These required specifications must be followed in order to keep your machine in good working order and protect your warranty.

### Daily

- Clean chips from way covers and bottom pan.
- Clean chips from turret, housing, rotating union and extension tube.
- Make sure the drawtube cover plate is installed either on the rotating union or on the chuck opening.
- Check hydraulic unit oil level (DTE-25 only). Capacity: 8 gallons.

### Weekly

- Check for proper operation of auto drain on filter regulator.
- Check air gauge / regulator for 85 psi.
- Clean exterior surfaces with mild cleaner. **Do not** use solvents.
- Clean out small chip catch pan in coolant tank.

### Monthly

- Inspect way covers for proper operation and lubricate with light oil, if necessary.
- Remove pump from the coolant tank. Clean sediment from inside the tank. Reinstall pump. **CAUTION!** Disconnect the coolant pump from the controller and Power Off the control before working on the coolant tank.
- Dump the oil drain bucket. Check Gearbox oil level (if applicable). If oil is not visible at the bottom edge of the sight gauge, remove the end panel and add DTE-25 through the top filler hole until it is visible in the sight gauge.

**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.
- Replace hydraulic unit oil filter.
- Check all hoses and lubrication lines for cracking.

### Annually

- Replace gearbox oil.
- Clean oil filter and remove residue from the bottom of filter.

### 2 years

- Replace air filter on control box every (2) years.  
**CAUTION!** Do not use a wash-down hose on the Haas lathe; doing so may cause damage to the spindle.
- USE SLOT TO REST PUMP BASKET FILTER
- DO NOT USE PLAIN WATER, PERMANENT CORROSION DAMAGE WILL RESULT.
- RUST INHIBITING COOLANT IS REQUIRED.
- DO NOT USE TOXIC OR FLAMMABLE LIQUIDS AS A COOLANT.
- CLEAN THE GATE FILTER REGULARLY
- Poor Coolant flow can be caused by a dirty filter. To clean the filter, turn off the coolant pump, lift the coolant tank lid and remove the filter. Clean and reinstall filter.

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## Chuck Maintenance

- Ensure all moving part are thoroughly greased
- Check for excessive wear on jaws.
- Check T-nuts for excessive wear.
- Check front retaining bolts for damage.
- Chucks should be broken in according to the manufactures' specifications.
- Disassemble and inspect chuck once a year.
- Refer to chuck manual for disassembly procedures.
- Check for excessive wear.
- Check for galling or burnishing.
- Clean guide ways of contamination, chips and coolant
- Lubricate chuck before reassembly.

**CAUTION!** Lack of grease significantly reduces clamping force and can result in chatter, improper clamping, or thrown parts.

## Chuck Jaws

- Each chuck jaw requires two strokes of grease every 1000 clamp/unclamp cycles, or at least once a week.
- Use the provided grease gun for chuck lubrication. The Lubrication type is Molybdenum Disulfide Grease (20%-25% moly content).

### **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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