



## HAAS SERVICE AND OPERATOR MANUAL ARCHIVE

### Haas Tailstock Operators Manual 96-5000 RevU English June 2008

- This content is for illustrative purposes.
- Historic machine Service Manuals are posted here to provide information for Haas machine owners.
- Publications are intended for use only with machines built at the time of original publication.
- As machine designs change the content of these publications can become obsolete.
- You should not do mechanical or electrical machine repairs or service procedures unless you are qualified and knowledgeable about the processes.
- Only authorized personnel with the proper training and certification should do many repair procedures.

**WARNING: Some mechanical and electrical service procedures can be extremely dangerous or life-threatening. Know your skill level and abilities.**

**All information herein is provided as a courtesy for Haas machine owners for reference and illustrative purposes only. Haas Automation cannot be held responsible for repairs you perform. Only those services and repairs that are provided by authorized Haas Factory Outlet distributors are guaranteed.**

**Only an authorized Haas Factory Outlet distributor should service or repair a Haas machine that is protected by the original factory warranty. Servicing by any other party automatically voids the factory warranty.**



## TAILSTOCK SETUP

**IMPORTANT!** Warranty card should be filled out prior to operation.

**When using Servo 5C Indexers, Haas Automation recommends using LIVE CENTERS ONLY!**

**Tailstocks cannot be used with the HRT320FB table.**

### PREPARATION

Clean bottom surface of tailstock casting before mounting to mill table. If there are any noticeable burrs or nicks on the mounting surface, clean them with a deburring stone.

### TAILSTOCK ALIGNMENT

1. Mount the supplied 0.625 dia. locating pins to bottom of tailstock using **1/4-20 x 1/2" socket head cap screw (SHCS)**.
2. Mount tailstock to clean mill table.
3. Fasten lightly to mill table using **1/2-13 hex head bolt (HHB), hardened tooling washers** and **1/2-13 T-Nuts**.
4. Extend the tailstock spindle from the body. Use the spindle surface to sweep the spindle center line to rotary product center line, align to within 0.003 TIR. Once the unit is properly aligned, torque the 1/2-13 nuts to 50 ft-lb.

### INSTALLATION/REMOVAL OF MORSE TAPER ACCESSORIES

1. Inspect and clean tailstock taper and tapered surface of live center.
2. Apply a light coat of oil on the center, before inserting into the spindle. This aids in removing the center and also prevents corrosion buildup.

### MANUAL TAILSTOCK

**Live or dead centers:** Retract the spindle into the body and the leadscrew will force the center out.

### PNEUMATIC TAILSTOCK

**Live centers:** Wedge an aluminum bar between the face of the spindle and the rear surface of the live centers' flange.

**Dead centers:** Thread dead centers are recommended (often called N/C Dead Centers). Use a wrench to hold the center in place and turn the nut until it backs the center out from the spindle.

### TAILSTOCK OPERATION

#### MANUAL TAILSTOCK OPERATION

1. The tailstock should be positioned so that after approximately 1" of spindle travel, the center comes into contact with the work piece/fixture. If the tailstock needs to be repositioned, repeat Step 4 of Tailstock Alignment.
2. Once in contact, apply only enough force on the handwheel to hold the workpiece/fixture securely.

**NOTE:** The force required on the hand wheel is similar to the force used in closing a typical garden faucet.

3. Tighten the spindle lock at this time.

## PNEUMATIC TAILSTOCK OPERATION

1. The tailstock should be positioned so that after approximately 1" of spindle travel, the center comes into contact with the work piece/fixture. If the tailstock needs to be repositioned, repeat Step 4 of Tailstock Alignment.
2. Use of the spindle lock is optional when using pneumatic tailstock models. Use the following information to determine tailstock air pressure:
  - **Rotary Tables: Normal operating range 10-60 psi (.7-4.1 bar), Max: 100 psi (7bar)**
  - **Servo 5c indexers\*: Normal operation range 5-40 psi. (.3-2.7 bar) Max: 60 psi. (4.1 bar) Live Centers Only!**
  - **Maximum Air pressure = 150 psi (10.3 bar) results in 450 lbs (204kg) tailstock force.**
  - **Minimum Air pressure = 5 psi (.3 bar) results in 15 lbs (6.8kg) tailstock force.**

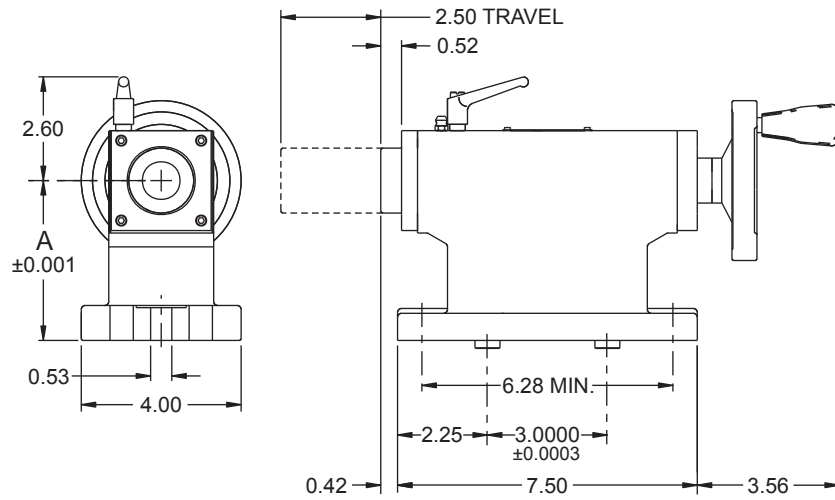
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**NOTE:** Excessive tailstock force and misalignment greater than 0.003 tir will cause premature wear on the geartrain and motor.

## MAINTENANCE

- **Daily:** Use a shop rag to thoroughly clean the unit free of chips and apply a rust preventative such as WD-40.
  - **Weekly:** Use a standard grease gun and apply 1 full stroke to the top mount Zerk fitting, for a pneumatic tailstock.
  - **Monthly:** Use a standard grease gun and apply 1-2 full strokes to the top mount Zerk fitting, for a manual tailstock.
- Lubrication:** Use Mobil multipurpose grease with Moly (Molybdenum disulfide) or equivalent.

HTS 4, 5, 6, 9 MANUAL TAILSTOCKS

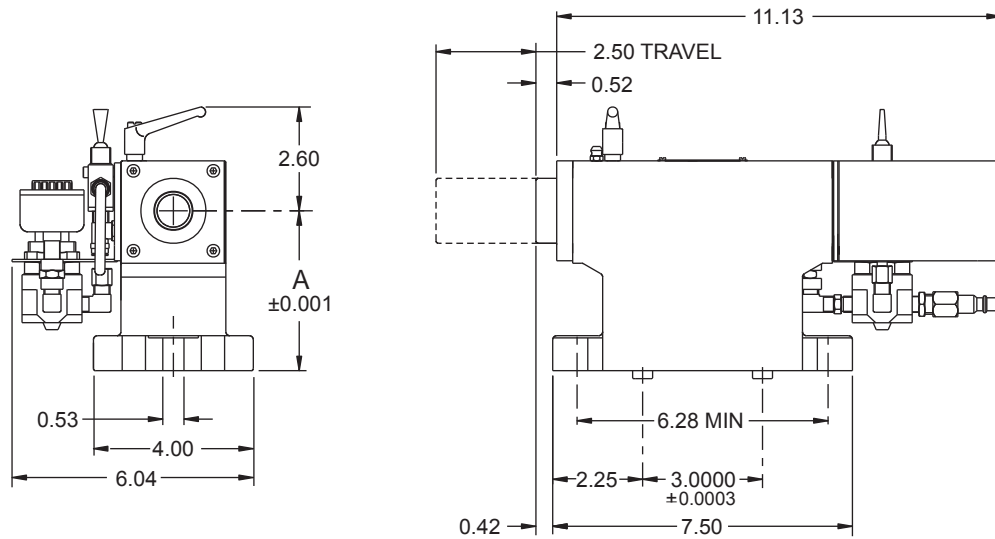


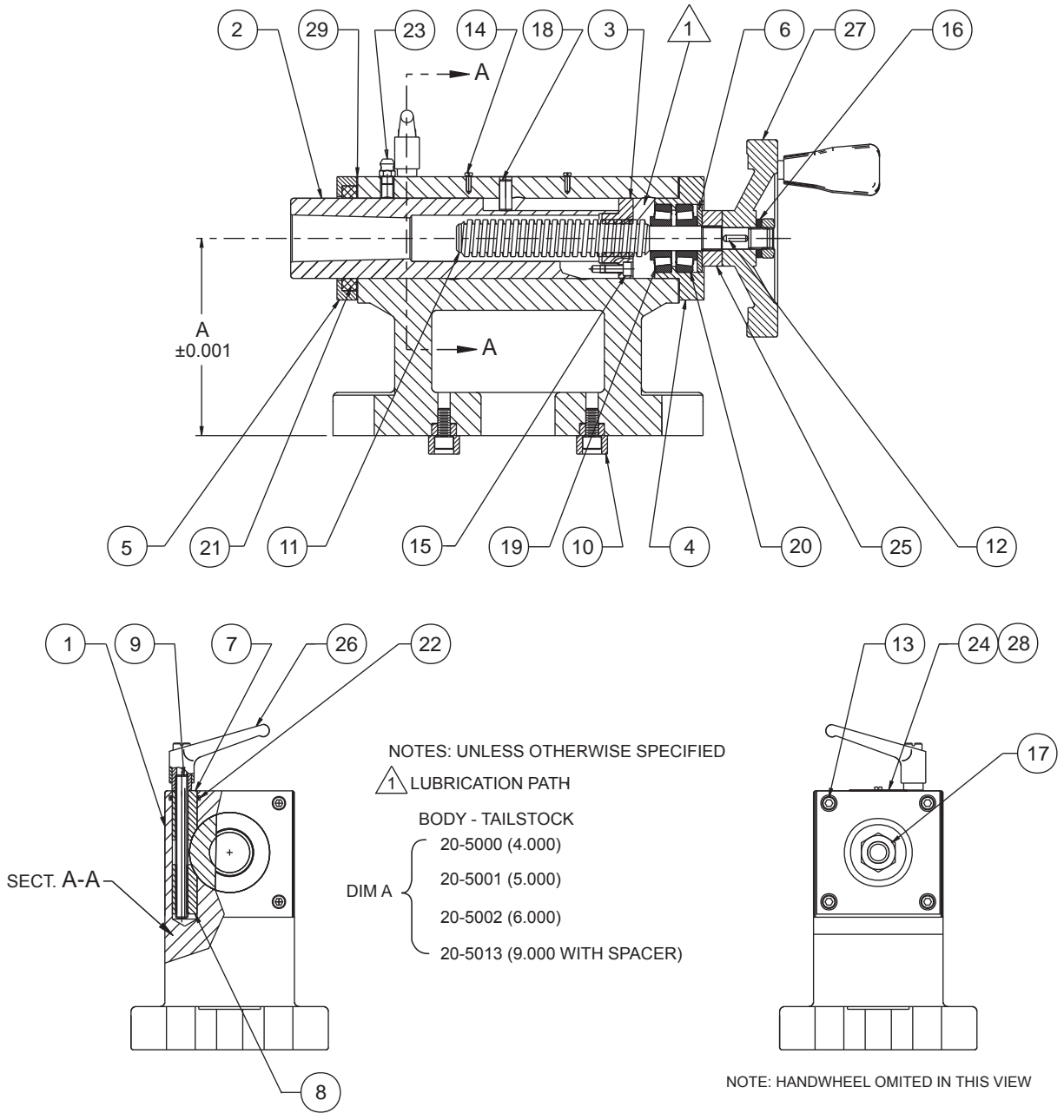
NOTES: UNLESS OTHERWISE SPECIFIED

BODY - TAILSTOCK

- DIM A {
- 20-5000 (4.000)
  - 20-5001 (5.000)
  - 20-5002 (6.000)
  - 20-5013 (9.000 WITH SPACER)

HPTS 4, 5, 6, 9 PNEUMATIC TAILSTOCKS

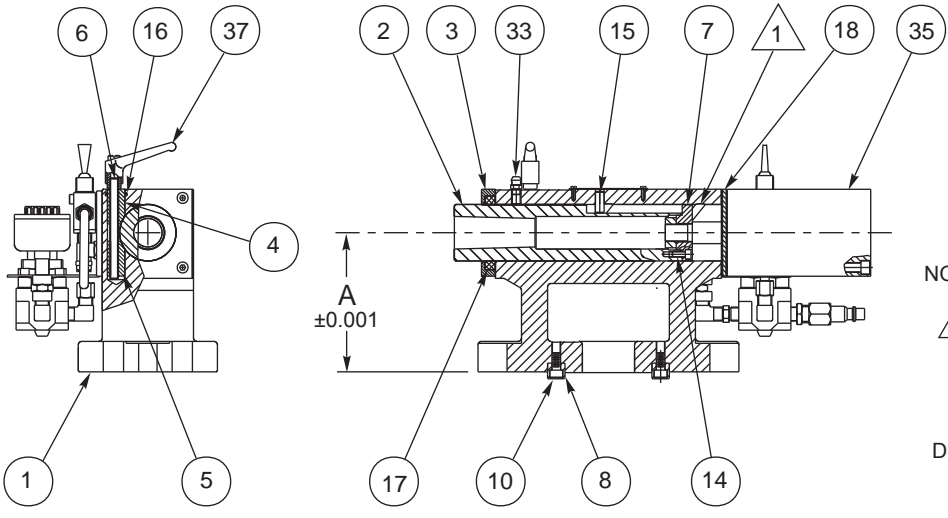
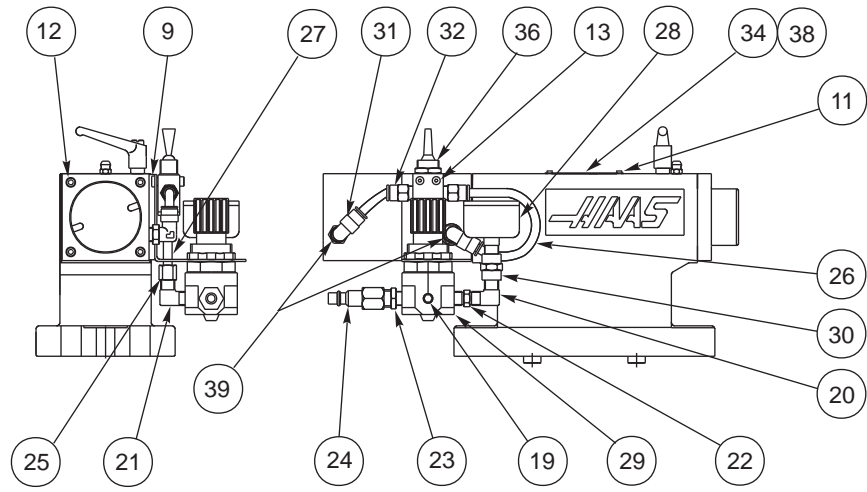




30-50000 TAILSTOCK ASSEMBLY DWG.

1	1	20-5000	BODY - TAILSTOCK 4"	14	2	40-1666	MC.DR.SCREW #2 x 1/4"RD.HEAD
1	1	20-5001	BODY - TAILSTOCK 5"	15	4	40-1801	SHCS,8-32 x 3/8"
1	1	20-5002	BODY - TAILSTOCK 6"	16	1	45-1680	FLAT WASHER,7/16 SAE
1	1	20-5013	BODY - TAILSTOCK 7.25"	17	1	46-1660	HEX. JAM NUT,7/16-20
2	1	20-5003	SPINDLE	18	1	48-0060	PULL PIN 1/4 x 5/8 LG.
3	1	20-5005	NUT, LEAD SCREW	19	2	51-5000	BEARING CAP,TIMKEN #A 4138
4	1	20-5006	BEARING HOUSING	20	2	51-5010	BEARING CONE,TIMKEN #A 4050
5	1	20-5007	SEAL CAP	21	1	57-5012	WIPER,1/4"THICK
6	1	20-5008	THRUST WASHER	22	1	57-0058	O'RING,2-014
7	1	20-5009	UPPER CLAMP	23	1	59-2016	GREASE FITTING
8	1	20-5010	LOWER CLAMP	24	1	59-2091	NAME PLATE, GENERAL PURPOSE
9	1	20-5011	CLAMP STUD	25	1	59-6010	SHAFT COLLAR,#TCL8-20F
10	2	22-5017	LOCATING PIN	26	1	59-6700	CLAMPING HANDLE
11	1	22-5004	LEAD SCREW	27	1	59-6800	HANDWHEEL,GN 321-100-B10D
12	1	22-5014	SQUARE KEY, 1/8	28	1	29-5022	TAILSTOCK LABEL
13	10	40-1632	SHCS,1/4-20 x 1/2"	29	2	57-5020	GASKET, AIR CYLINDER

# HPTS MANUAL TAILSTOCKS



NOTES: UNLESS OTHERWISE SPECIFIED

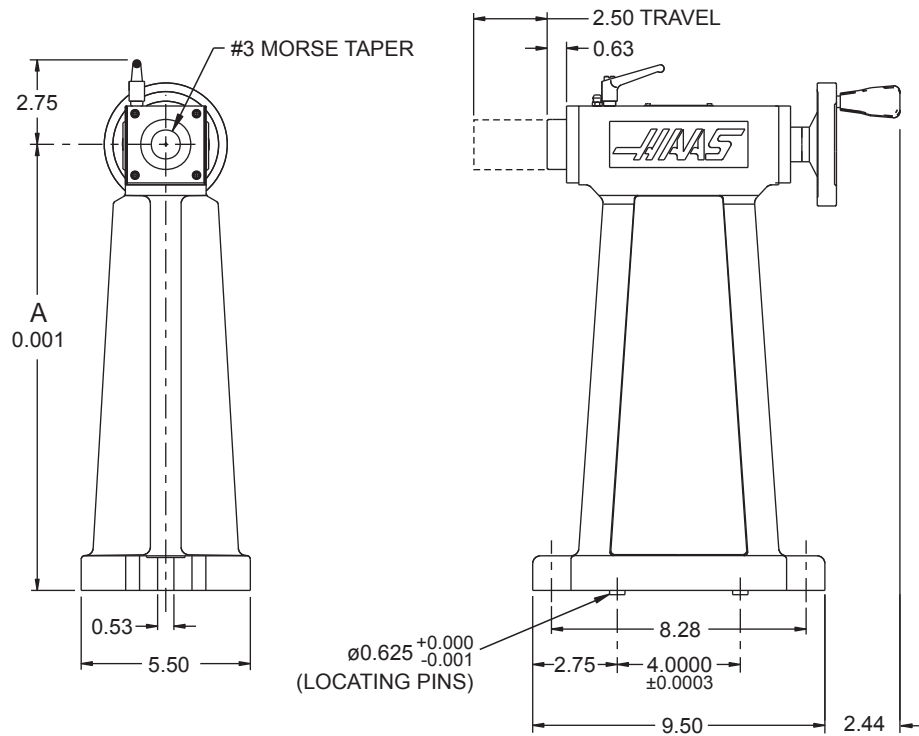
LUBRICATION PATH

BODY - TAILSTOCK

DIM A { 20-5000 (4.000)  
20-5001 (5.000)  
20-5002 (6.000)  
20-5013 (9.000 WITH SPACER)

IT	QTY	HAAS P/N	TITLE	IT	QTY	HAAS P/N	TITLE
1	1	20 - { 5013 5002 5001 5000 }	7.25" 6" 5" 4" } BODY - TAILSTOCK	19	1	58 - 1627	1/8 - 27 PIPE PLUG
				20	1	58 - 16700	STREET ELBOW 1/8"
				21	1	58 - 16705	MALE ELBOW 1/8 M TO 1/8 M
				22	1	58 - 16732	1/1 x 1/8 MALE HEX.JOINT
				23	1	58 - 1674	ADAPTER MALE 1/4 NPT
24	1	58 - 1675	QUIK RELEASE FITTING, FEMALE				
25	2	58 - 16755	MALE AIR FITTING				
26	2 Ft.	58 - 1981	TUBING, AIR LINE, 1/4 O.D.				
27	2"	58 - 19900	COPPER TUBING				
28	1	58 - 27395	AIR PRESSURE GAUGE				
29	1	58 - 2740	AIR REGULATOR				
30	1	58 - 2746	1/8 TO 1/8 FEMALE COUPLER				
31	2	58 - 3050	ELBOW 1/8 NPT - 1/4				
32	2	58 - 3070	FITTING, 1/8 NPT - 1/4				
33	1	59 - 2016	GREASE FITTING				
34	1	59 - 2091	NAME PLATE, GENERAL PURPOSE				
35	1	59 - 2736	AIR CYLINDER, #QJ 92-1673				
36	1	59 - 2746	4 WAY VALVE, CLIPPARD, #TV-4DP				
37	1	59 - 6700	CLAMPING HANDLE				
38	1	29 - 5022	TAILSTOCK LABEL				
39	2	58-4040	AIR CHOKE DISK				
8	2	22 - 5017	LOCATING PIN				
9	1	25 - 5021	VALVE, BRACKET				
10	6	40 - 1632	SHCS, 1/4-20 x 1/2"				
11	2	40 - 1666	MC.DR.SCREW #2 x 1/4" RD.HEAD				
12	4	40 - 1696	SHCS, 1/4-20 x 4 1/2"				
13	2	40 - 1800	SHCS, 8 - 32 x 3/4"				
14	4	40 - 1801	SHCS, 8 - 32 x 3/8"				
15	1	48 - 0060	PULL PIN 1/4 x 5/8"				
16	1	57 - 0058	O'RING, 2 - 014				
17	1	57 - 5012	WIPER, 1/4" THICK				
18	2	57 - 5020	GASKET, AIR CYLINDER				

## HTS 11.5 AND HTS 14.5 MANUAL TAILSTOCKS



## HPTS 11.5 AND HPTS 14.5 PNEUMATIC TAILSTOCKS

