



Front Window - ST-20/30/40 - Replacement

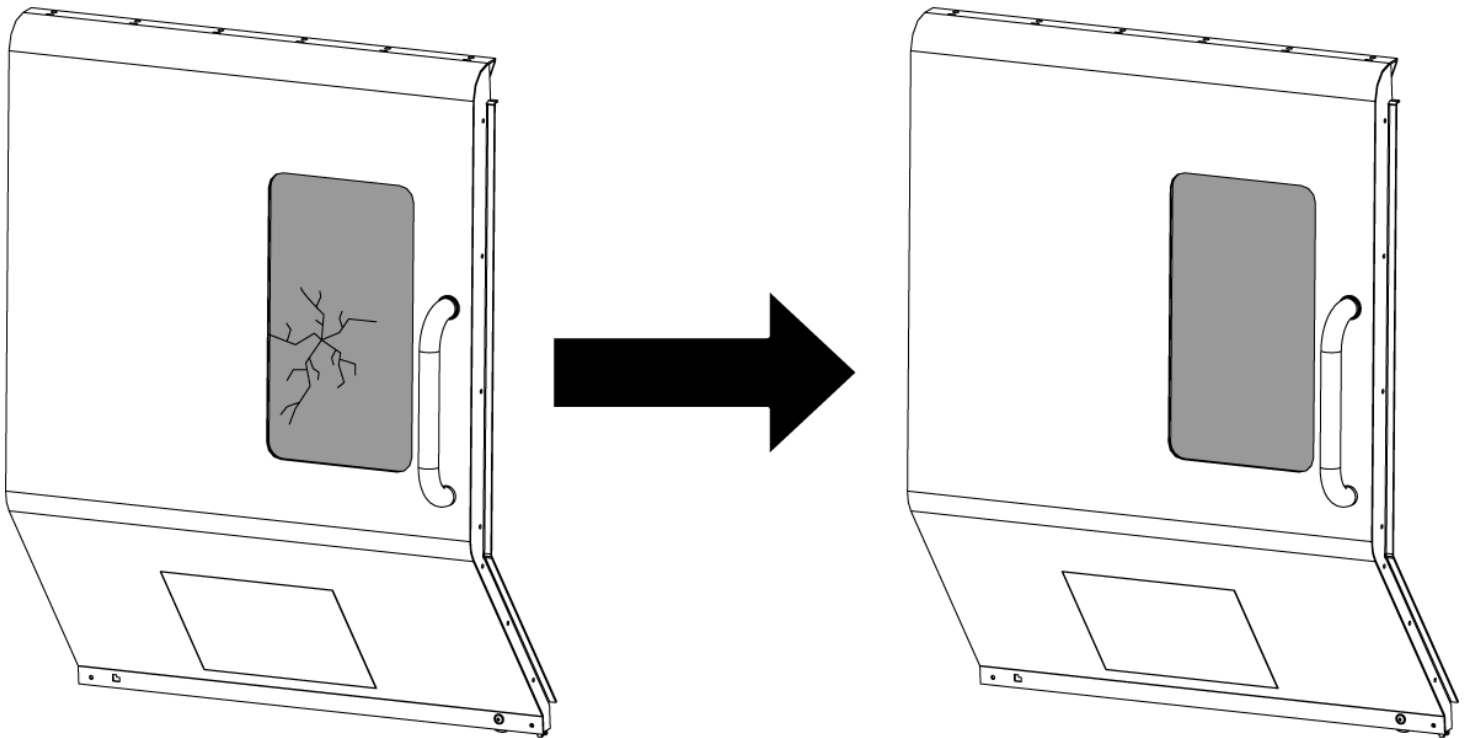
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ST-20/30/40 - Front Window - Replacement - Introduction

Do this procedure to replace safety glass or polycarbonate windows.




 **Caution:** When you do maintenance or repair on CNC machines and their components, you must always follow basic safety precautions. This decreases the risk of injury and mechanical damage.

Do these steps before you do work in the machine or in the control cabinet:

- Set the main circuit breaker to the **[OFF]** position.
- Use an approved lock with an approved safety tag. Always follow lock-out procedures in accordance to local government rules.
- After turning off the machine, wait at least 5 minutes before working in the control cabinet, to allow power to dissipate. Wait for the voltage indicator LED on the vector drive to go off completely.
- Always turn off the main air supply when you work on any part of the pneumatic system.
- Make sure to rest the spindle head on a block of wood when work is done on a vertical axis. This will prevent any unintended movement that could result in the axis falling.
- Never alter any safety circuits on the machine.

You should not do machine repair or service procedures unless you are qualified and knowledgeable about the processes. Serious damage to the machine components can result in costly repairs. The service technicians at your Haas Factory Outlet (HFO) have the training and experience, and are certified to do these tasks safely and correctly. The repair and service work performed by your HFO is protected with a limited warranty.

 **Danger:** Some service procedures can be dangerous or life-threatening. DO NOT attempt a procedure that you do not fully understand. If you have any doubts about doing a procedure contact your Haas Factory Outlet (HFO) and schedule a service visit.

Machine Compatibility

Do this procedure for these machines:

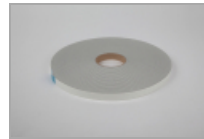
- ST-20/30/40

Parts Included

KIT PN: 93-2224, WINDOW, GLASS 23.25" X 17.25" KIT. QTY: 1



[A] 28-0124 QTY: 1
WINDOW, GLASS 23 .25" X 17.25"



[B] 57-0505 QTY: 1 UOM: 244"
SEAL, 0.75" X 0.1875" FOAM TAPE
VINYL



[C] 26-0359 QTY: 8
EDGE TRIM, ULTRA HIGH
MOLECULAR WEIGHT (UHMW) X 4.00
IN

ST-10/20/30/40 - Front Window - Replacement

STEP 1

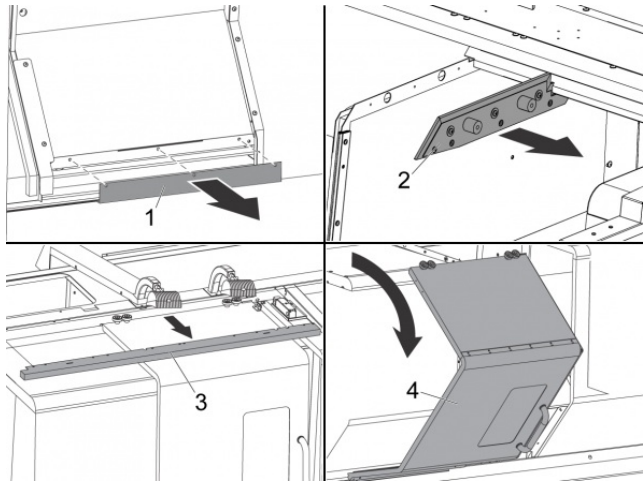


Push **[POWER OFF]**.

Set the main circuit breaker to the **OFF** position.

Lock the main circuit breaker. Use an approved lock with an approved safety tag.

STEP 2



Remove these parts:

- The bottom roller-cover [1] from the inside of the door
- The top wiper assembly [2]
- The top door-track [3]



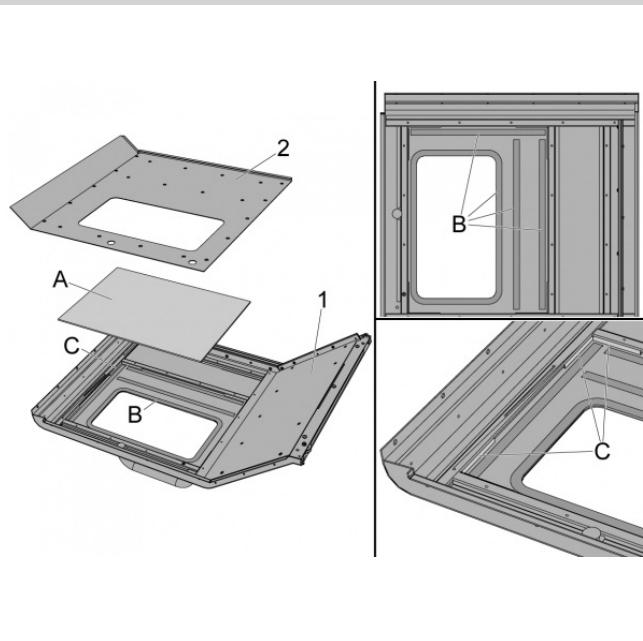
Caution: Before you remove the top door-track [1], support the door.

- The door [4]



Note: You cannot remove the window retainer if the door is installed.

STEP 3



Carefully remove the retainer [2], the old foam tape [B], and the old glass window [A].

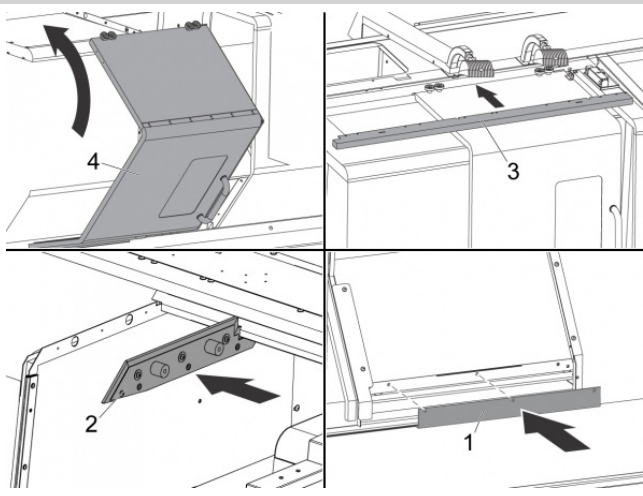
Use a scraper to fully remove all of the old foam tape [B] from the door [1]. Clean the areas of all remaining tape.

Replace the old edge trims [C] at each corner.

Cut (1) piece of the new FOAM TAPE [B] to go along the edge of the window opening. Cut (3) more strips to go on the door. Put the strips in a position that supports the window. The strips must not interfere with the z-shape channels on the door. Apply the (4) pieces of tape. Make a 3/4" overlap at the ends of the (1) piece of tape that goes along the window opening.

Install the new parts in the opposite sequence that you removed the old parts. Find the engraved label "THIS SIDE OUT" on the pane of the new GLASS WINDOW [A]. This label must face the outside of the door.

STEP 4



Clean all of the chips from the door tracks.

Install these parts:

- The door [4]



Caution: Support the door to keep it from falling.

- The top door-track [3]
- The top wiper assembly [2] for the door
- The bottom roller-cover [1] from the inside of the door

Make sure the full length of the felt touches the door equally. If necessary, loosen the screws to adjust the felt on each wiper.