



Lathe - Extruded Spindle Liner - Adapter Kit Ø2.50 - Installation

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Translation Available

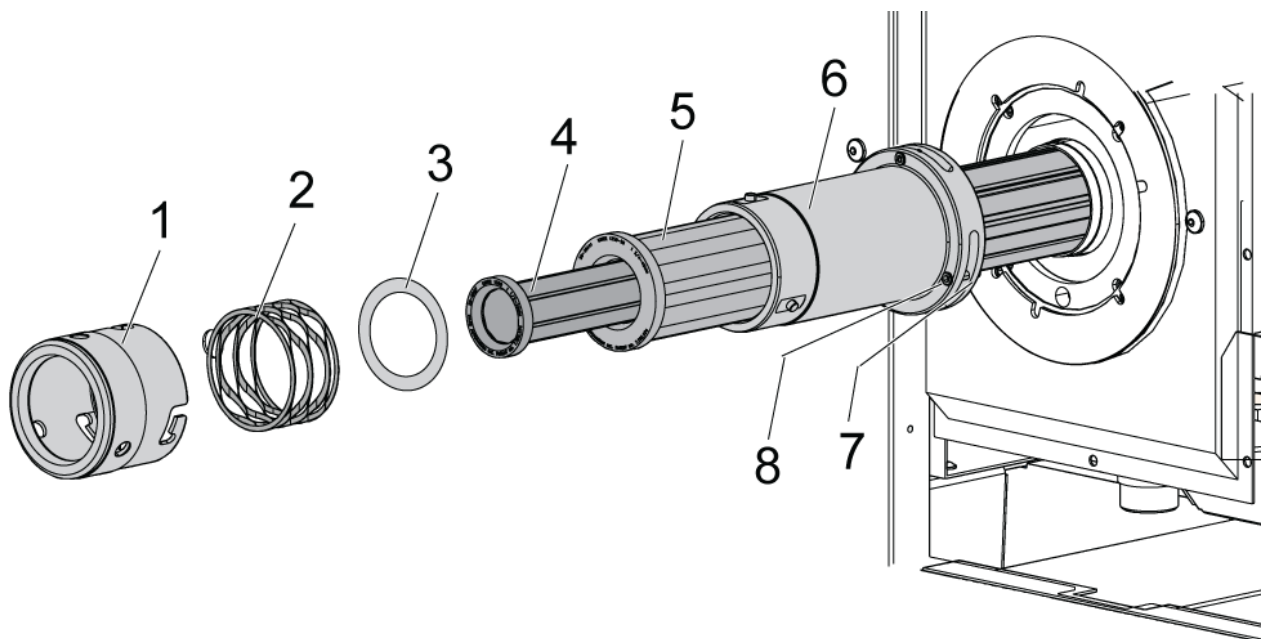
Lathe - Extruded Spindle Liner - Adapter Kit Ø2.50 - Installation - Introduction

Extruded spindle liners [4] adapt the lathe spindle bore to different sizes of bar stock. Extruded spindle liners are held in place with the LINER ADAPTER 2.50, an optional washer [3], and a “nesting” liner [5]. This procedure tells you how to install the LINER ADAPTER 2.50 kit for a Ø2.50” spindle bore.

A liner adapter 2.50 Spring-Lock Body) [6] fits onto the rear of the hydraulic closer. The extruded spindle liner [4] fits inside the Spring-Lock Body [6]. The Liner Adapter 2.50 ID Spring Lock Cap (Spring-Lock Cap) [1] and Spring [2] hold the extruded spindle liner [4] in position. For this kit, a Washer [3] is added to the Spring-Lock Cap [1] and Spring [2], when a “nesting” liner [5] is used.

 **Note:** All lathes with a spindle bore larger than Ø1.75” use a “nesting” liner [5] to support bars smaller than Ø1.75”.

The size of the bar stock determines the size of the extruded spindle liner. For correct liner configuration, contact your Haas Factory Outlet.




1. Spring-Lock Cap
2. Spring
3. Washer (only required with optional “Nesting” Liner)
4. Extruded Spindle Liner
5. “Nesting” Liner (optional)
6. Spring-Lock Body
7. Nuts

8. Button Head Cap Screws

Prerequisites

Refer to [Spindle Liner Kit Reference Table](#) for more information.

If you have a Servo Bar 300, lower the transfer tray. If you have a Haas Bar Feeder, move the Bar Feeder to the setup position. Refer to the Operator's Manual for instructions on how to do this.

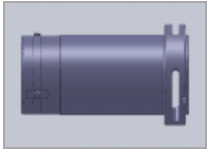
 **Note:** The illustrations do not show the coolant collector and Bar Feeder. This lets you see the steps. The removal of these parts is not necessary.

Machine Compatibility

This procedure is applicable to lathes with a bore of Ø2.50"

Parts Included

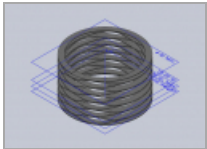
KIT PN: LINER ADAPTER 2.50, LINER GUIDE ADAPTER KIT, 2.50" (64 MM). QTY: 1



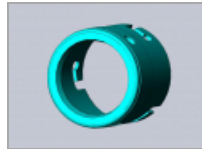
[A] 20-6745A QTY: 1
LINER ADAPTER 2.50 ID SPRING
LOCK BODY



[B] 25-12114 QTY: 1
WASHER 3.63OD X 2.0ID X .06THK



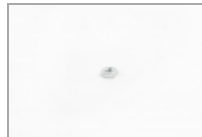
[C] 59-1527 QTY: 1
WAVE SPRING MULTI 3.580 4.0-
30.0LB



[D] 20-6765 QTY: 1
LINER ADAPTER 3.00 ID SPRING
LOCK CAP



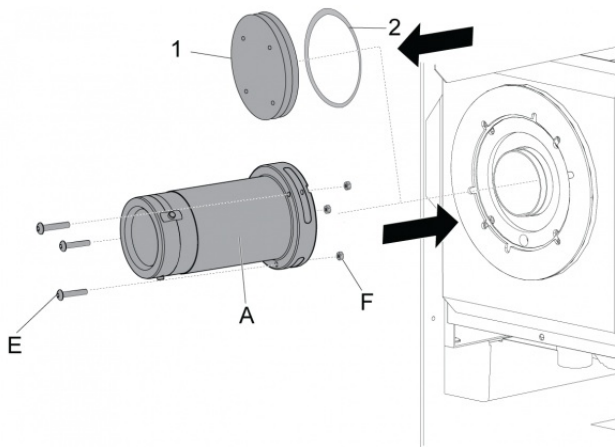
[E] 40-16091 QTY: 3
BOLT, BHCS 10-32 X 1




[F] 46-16175 QTY: 3
NUT, 10-32 HEX

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STEP 1



Remove the bolts on the bore cover [1]. Remove the bore cover [1] and the sensor ring [2] from the hydraulic closer.

 **Note:** Do not discard the bore cover [1] and sensor ring [2]. You can install them again if you remove the SPRING-LOCK BODY [A] from the lathe.

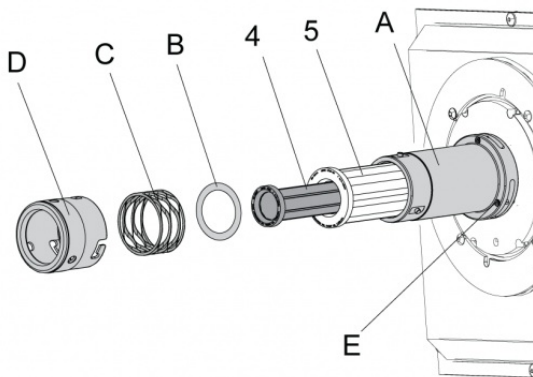
Make sure these parts are clean:

- the threads on the hydraulic closer
- the face of the hydraulic closer
- the threads and inside shoulder of the SPRING-LOCK BODY [A].


Put the (3) BUTTON-HEAD CAP SCREWS (BHCS) [E] through the holes in the SPRING-LOCK BODY [A]. Attach the (3) NUTS [F]. Tighten the BHCS and NUTS with your hand.

Turn the SPRING-LOCK BODY [A] onto the hydraulic closer. Tighten the SPRING-LOCK BODY [A] with your hand.


STEP 2



Torque the (3) BHCS [E] to approximately 30 in-lb (339 N-cm).

 **Caution:** To prevent damage to the SPRING-LOCK BODY [A], do not torque the BHCS more than 30 in-lb (339 N-cm).

Install the correct spindle liner [4] for your size bar stock.

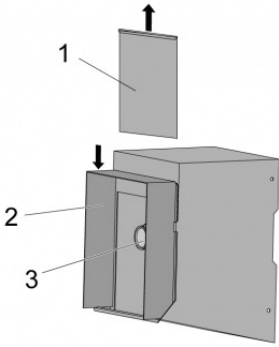
 **Note:** All lathes with spindle bore larger than Ø1.75" use a "nesting" liner [5] to support bars smaller than Ø1.75".

Put the SPRING [C] (and WASHER [B] if "nesting" liners) in the SPRING-LOCK CAP [D]. Align the SPRING-LOCK CAP [D] with the adapter guides. Press and turn the SPRING-LOCK CAP [D] until it locks.

 **Note:**

- Remove the SPRING-LOCK CAP [D] to push full-bore size stock.
- Clean debris from the SPRING-LOCK CAP [D], SPRING [C], and WASHER [B] when necessary.

STEP 3



To use this Adapter Kit Ø2.50 [3] on lathes built before November 1, 2015, install a COOLANT COLLECTOR EXTENSION [2] (P/N 25-2618) to help prevent coolant leaks during operation. Remove the coolant collector door [1] and insert the COOLANT COLLECTOR EXTENSION [2].

To install the coolant collector door [1] again on these lathes, you must remove the COOLANT COLLECTOR EXTENSION [2] and the Adapter Kit Ø2.50 [3].