



Lathe - Extruded Spindle-Liner - Installation

Scan code to get the latest version of this document



Translation Available

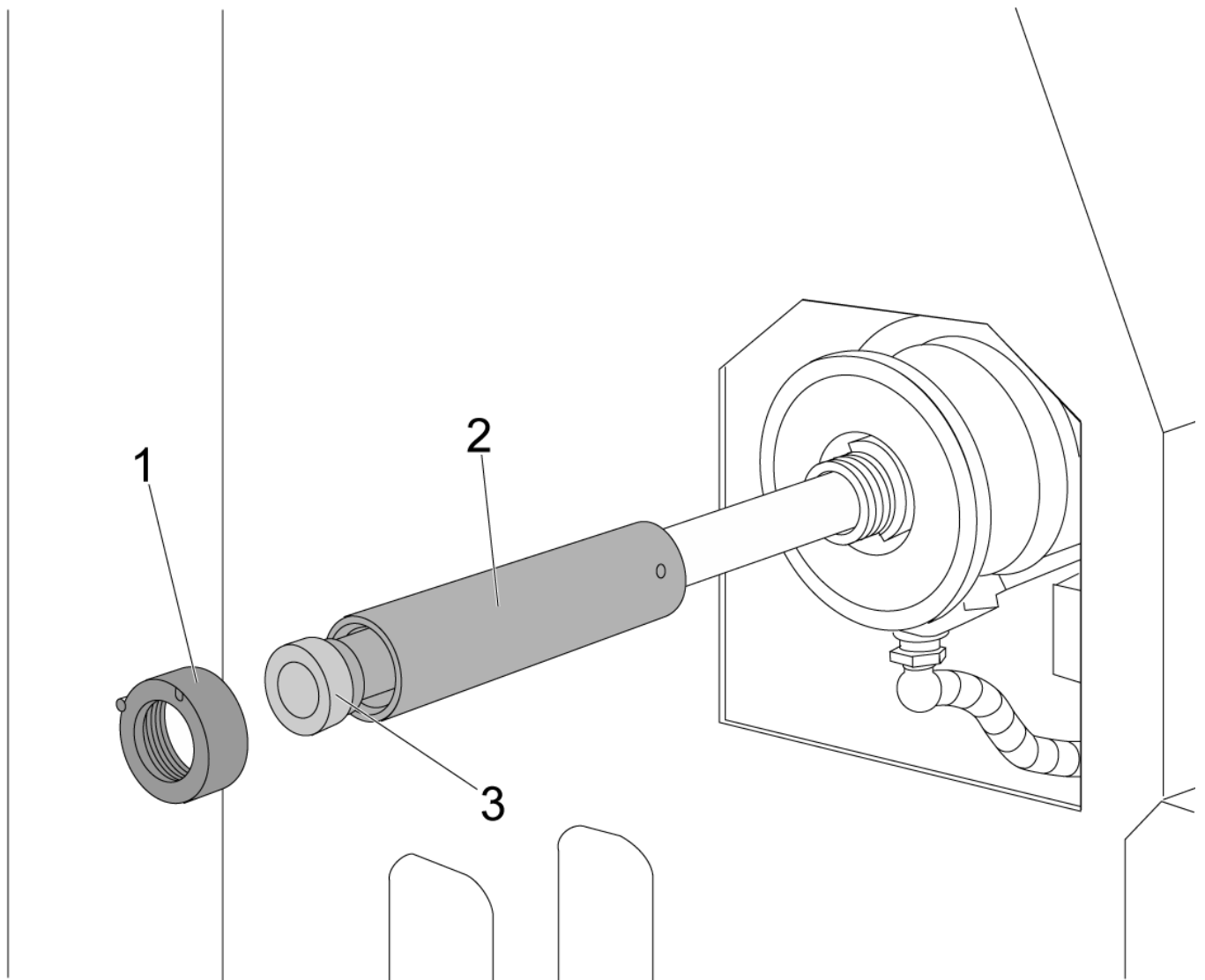



Lathe - Extruded Spindle-Liner - Installation - Introduction

This procedure tells you how to install these components:

1. The adapter [2] for the extruded spindle-liner
2. The extruded spindle-liner [3]

The adapter [2] goes onto the end of the hydraulic cylinder. The extruded spindle-liner [3] goes inside the adapter. The liner end-cap [1] holds the extruded spindle-liner in position. The size of the adapter changes with the size of the spindle bore. The size of the extruded spindle-liner changes with the size of the bar stock. Speak to the Haas Applications department to help you select the correct configuration.




 **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.

Prerequisites

Refer to [Spindle Liner Kit Reference Table](#) to match your lathe to the correct Spindle Liner Kit and Adapter.

For non-extruded spindle-liner installations, refer to [ST-30/30Y Big Bore](#), [ST-35/35Y Spindle Liner Kit Installation](#).

 **Note:** You can remove the coolant collector to get easier access to some of the parts, but this is not necessary.

Machine Compatibility

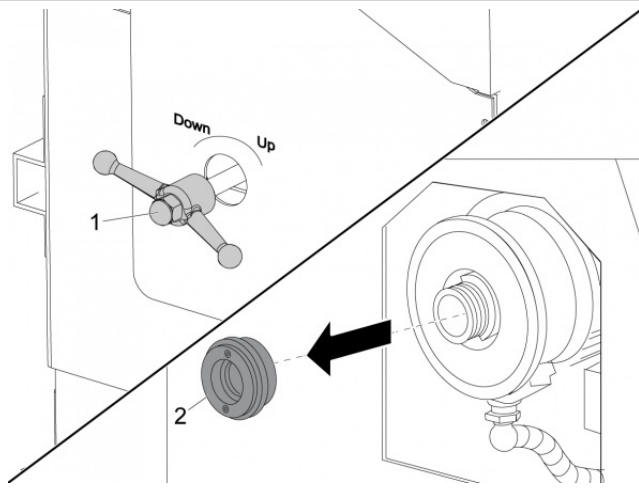
Do this procedure for these machines:

- ST-10/10Y/15/20/20Y/20SS/20SSY/25/25Y/30/30Y/30SS/30SSY
- DS-30/30Y/30SS/30SSY
- DS-30/30Y with DS-3B
- DS-30SS/30SSY with DS-BSS

Lathe - Extruded Spindle-Liner - Installation Preparation

This procedure tells you how to prepare a lathe for the installation of an extruded spindle liner.

STEP 1



If the Bar Feeder is installed, use the height adjustment handle [1] to move the transfer tray down.

To let you see the procedure, the illustrations do not show the bar feeder. Do not remove the Bar Feeder to do this procedure.

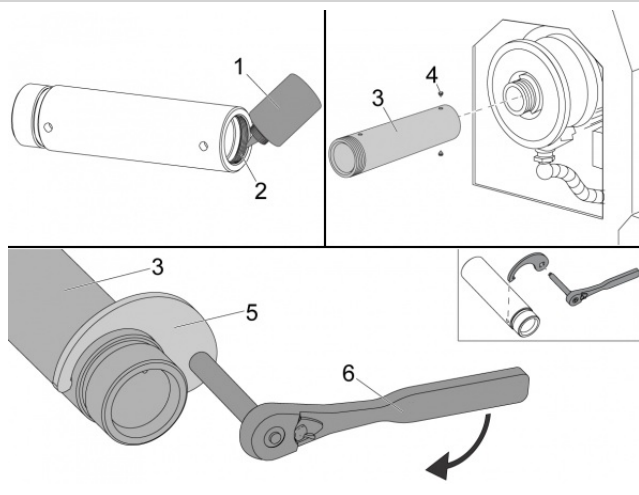
Remove the bore cover from the hydraulic union. Keep the bore cover. You must install it if you remove spindle liners from the lathe.

Remove the switch plate assembly [2] from the end of the spindle. The removal is different for each manufacturer.

Keep the switch plate assembly. You must install it if you remove the spindle liners from the lathe.

Lathe - Extruded Spindle-Liner Adapter - Installation

STEP 1



Apply removable thread-locking compound [1] to the inner threads [2] of the liner adapter.

Turn the liner adapter [3] onto the threads of the hydraulic union.

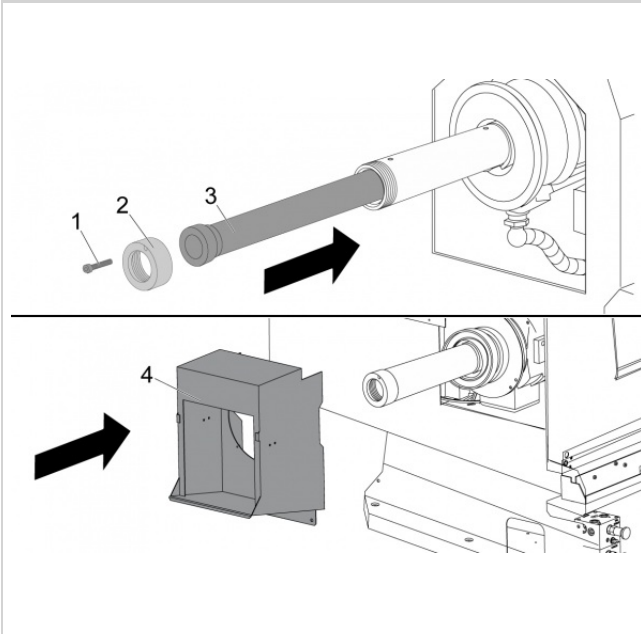
Torque the liner adapter to approximately 70 ft-lb (95 Nm). Use these tools to tighten the liner adapter:

- A torque wrench [6] with an extension
- The adapter spanner [5] that is included with the installation kit


ST-30 Only: Tighten the set screws [4] into the liner adapter.

Lathe - Extruded Spindle-Liner - Installation

STEP 1



Select the correct spindle liner [3] for your bar stock. Put the spindle liner into the spindle.

 **Note:** All lathes except ST-10/10Y: Put LINER1750 [1] onto liners that are smaller than 1-3/4".

Turn the liner end-cap [2] onto the threads on the end of the liner adapter. With your hand, fully tighten the cap.

Insert the 8-32 x 1-1/2" thread-locking screw [1] into the liner end cap. Tighten the screw to approximately 2 ft-lb (3 Nm). If you tighten the screw too much, you can cause damage to the threads. If the screw is too loose, the cap moves.

If you removed the coolant collector [4], install it.

Make sure you unblock the spindle before you continue operation.

Make sure you unblock the spindle before you continue operation.