How it Works

The spindle Minimal Lubrication System optimizes the amount of lubrication to the spindle by automatically supplying a specific amount of air/oil mist lubrication only when it is needed. This reduces waste and limits the possibility of excess lubrication.

The spindle lubrication solenoid [8], located in the CALM cabinet, provides a constant stream of air [9] to the sight glass when the spindle is turning.

The oil slowly drips through the sight glass and into the air stream.

The air carries the oil droplets [10] up the spindle air/oil tube to lubricate the spindle bearings.

If the oil level in the reservoir [5] is low, the low lubrication level switch [2] turns on. This generates Alarm 805 LOW SPINDLE LUBRICATION.

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Section 1

**Symptom:** Alarm 805 LOW SPINDLE LUBRICATION. Hot, noisy, or failed spindle.

**Possible Cause:** The reservoir oil level is low. The reservoir is filled with the incorrect oil type.

**Corrective Action:**

Refill the oil reservoir with Mobil SCH 625. If Mobil SCH 625 is not available, use Mobil 1 5W-20 or Mobil 1 10W-30.

Refer to the lubricant tables at [diy.haascnc.com](http://diy.haascnc.com).

Section 2

**Symptom:** Alarm 805 LOW SPINDLE LUBRICATION.

**Possible Cause:** The oil level sensor is faulty.

**Corrective Action:**

Make sure the oil float [1] moves freely.

Go to Proximity Sensor - How it Works and Troubleshooting Guide to troubleshoot the proximity sensor [2].

Section 3

**Symptom:** Hot, noisy, or failed spindle.

**Possible Cause:** There are leaks in the fittings.

**Corrective Action:**

Examine the fittings on top top of the oil pump tank. The oil collects on top of the oil pump tank, underneath the leaking fitting. Tighten or replace any leaking fittings.
Section 4

Symptom: Hot, noisy, or failed spindle.

Possible Cause: The lubrication tube is damaged.

Corrective Action:

Examine the lubrication tube between the lube panel and the spindle for kinks, splits, or pinches.

Make sure you can see oil droplets in the tube.

Replace the tube if it is damaged.

Section 5

Symptom: Hot, noisy, or failed spindle.

Possible Cause: A solenoid is not functioning.

Corrective Action:

Use a multimeter or voltage detector to measure voltage at the solenoid connector while you do the Spindle Lubrication Test:

- Next Generation Control: Press [DIAGNOSTIC]. Cursor to the Maintenance and Lube tabs.
- Classic Haas Control: Press [PARAM DGNOS] (2) times and cursor to the LUBE tab.
- Press [F3] to start the 30 second Spindle Lubrication Test.

If the multimeter or voltage detector does not show 120 VAC during the test, go to I/O PCB - How it Works and Troubleshooting Guide (Classic Haas Control) to troubleshoot the I/O PCB.
Symptom: Hot, noisy, or failed spindle.

Possible Cause: Incorrect oil flow.

Corrective Action:

Perform an oil collection test [1]. Refer to Mill - Spindle - Lubrication Oil - Collection Test.

If the oil supply is insufficient, and all other functions have been checked, replace the flow meter [2] in the oil pump.