

Haas Coolant ring install.

If you have a sidemount tool changer all you need to do is slide the ring up on the spindle until the brass nozzles are just above the face of the spindle lock in place with the 3 set screws and connect the coolant line.

On a carousel type it is a little more involved.

Start with no tool in the spindle and the pocket facing the spindle empty.

Also have tools in both adjacent pockets.

Place the coolant ring up on the spindle as far as you can put it to be safe.

Now start a tool change and just when the machine unclamps the tool, either press feed hold “ newer machines” or press emergency stop.

Now you can slide the ring down the spindle and see the fit between the ring and the adjacent tools.

You probably won't be able to get it this low, but never let the brass nozzles extend below the spindle face or interference will occur.

Secure it in place with a set screw then either press cycle start to finish the tool change or use the tool changer restore function to get the tool changer reset.

After the carousel has retracted tighten all 3 set screws and connect the coolant line.

Most installs usually only use the ring and the programmable coolant the rest are shut off.

If you find your coolant pressure is lacking you can remove one or two nozzles and put a 3/8-24 set screw or bolt in to plug the port.

Thank you for your purchase

Ray

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