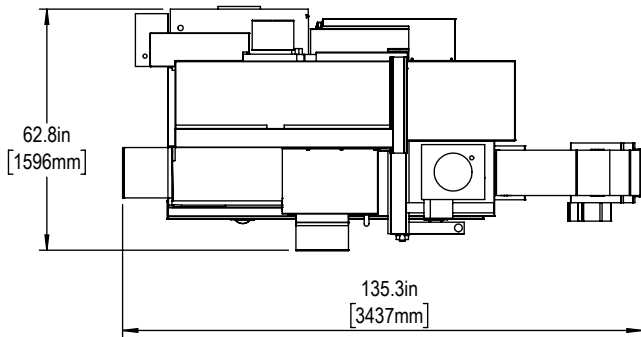
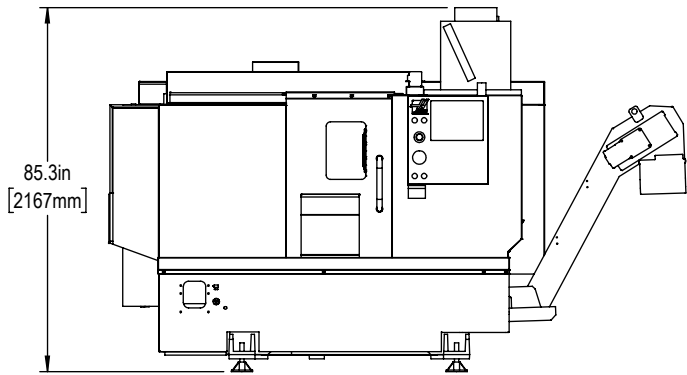
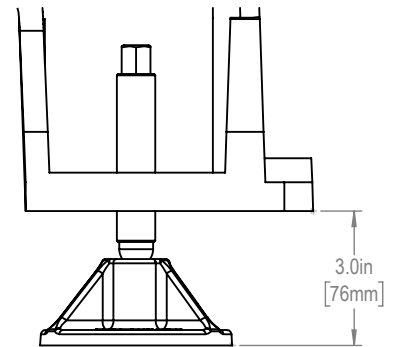




Installed Dimensions

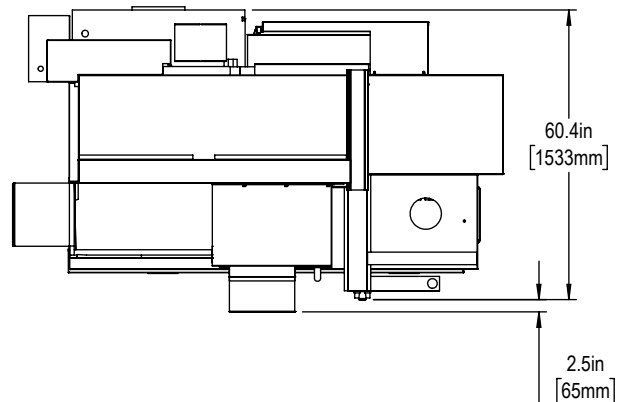
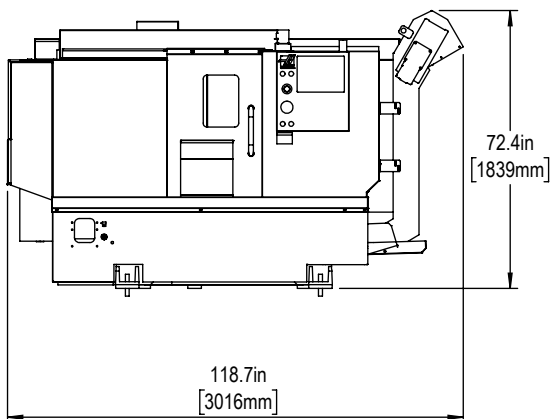


Leveling Pad Height

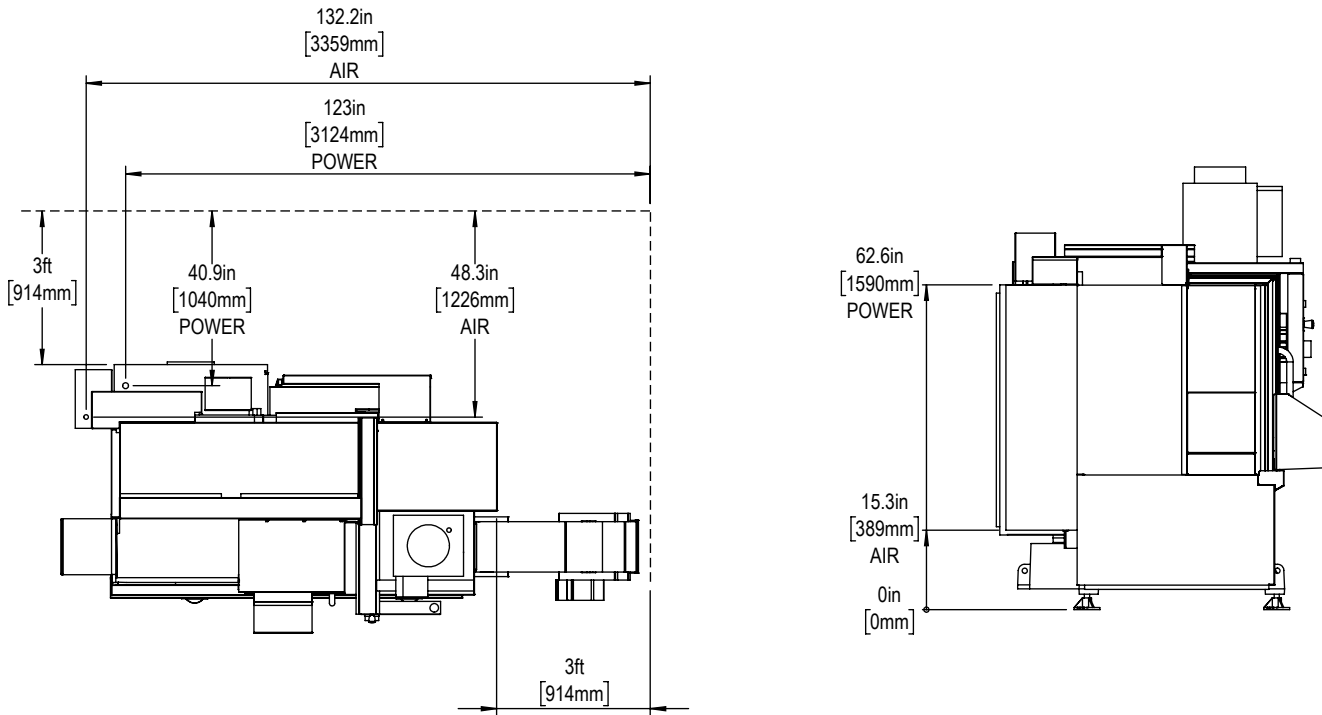


*All Height Dimensions Based on Suggested Leveling Pad Height

Shipping Dimensions



Air & Power



Maintain 3 feet [915mm] clearance to the nearest obstruction around all sides of machine perimeter for maintenance access

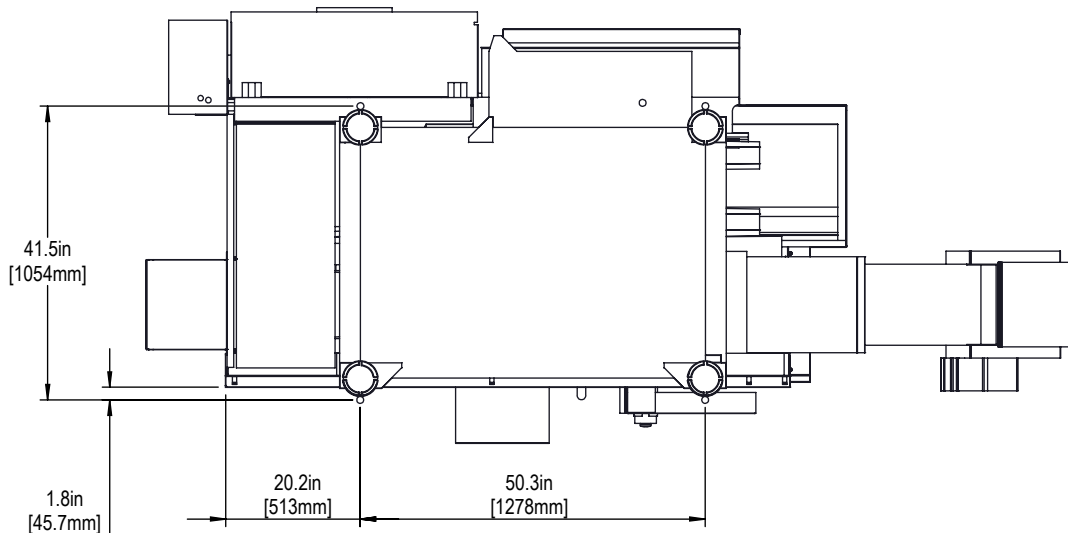
Note:

Machine must be placed on one continuous concrete slab. Slab should extend 12in [305mm] beyond anchor holes in all directions

Anchor Pattern

Anchor Hole Detail

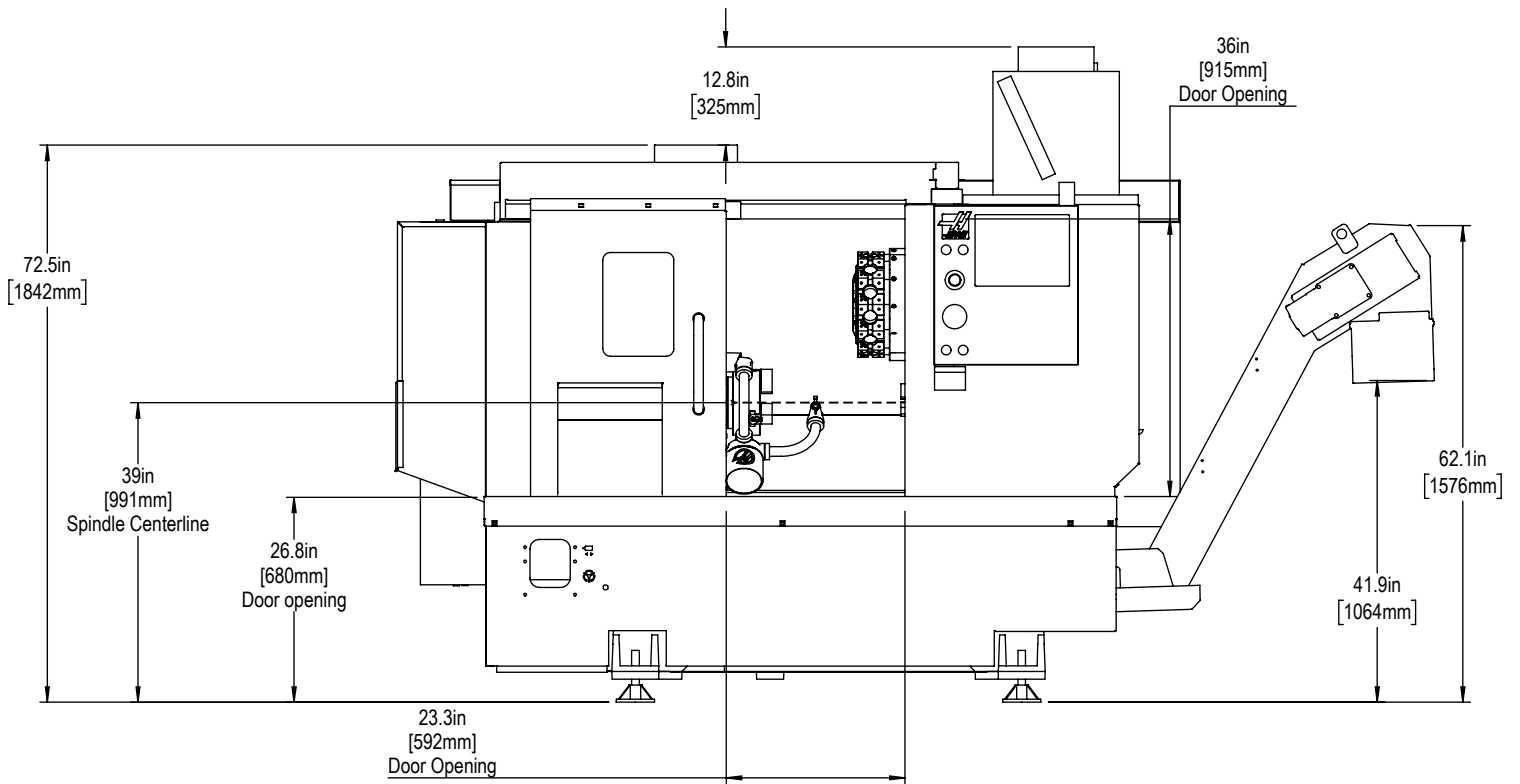
- Ø 1.0in[25mm]
- ▽ 2.0in[50mm]
- ▽ 2.5in[66mm]



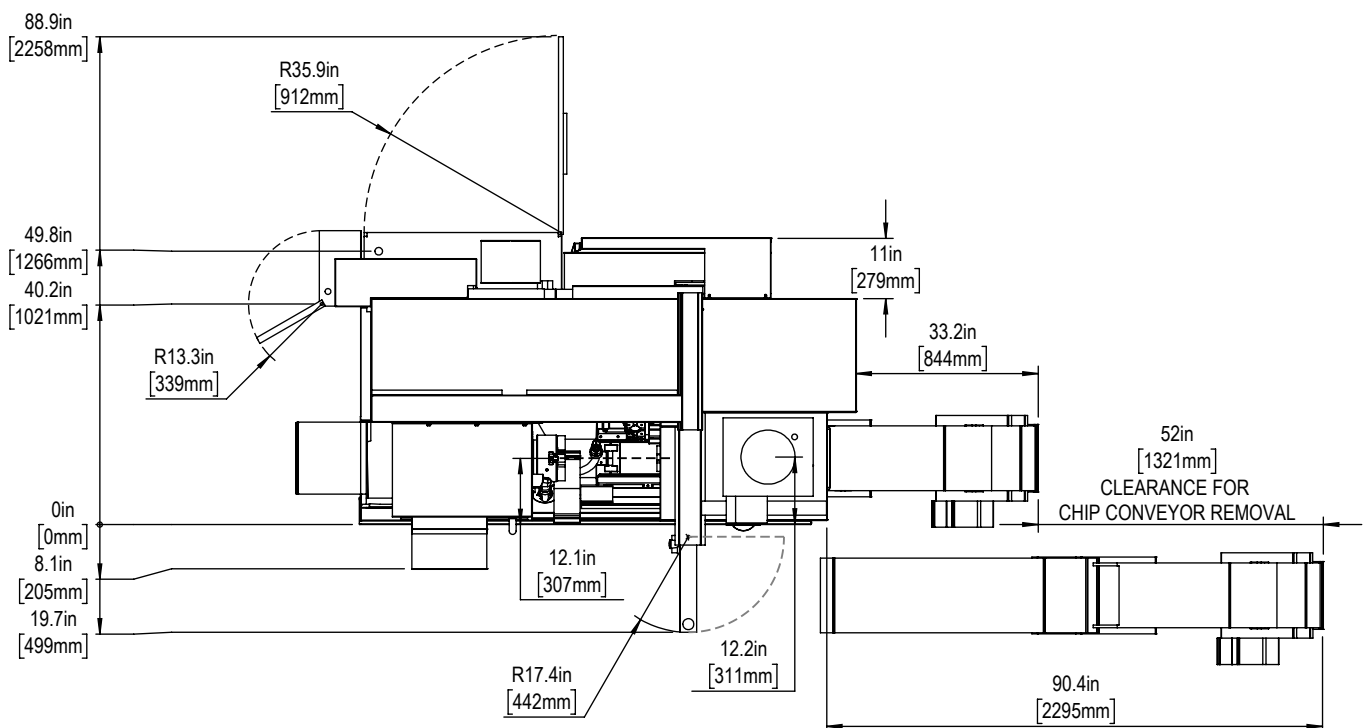
For precise locations and specifications please use template in Anchoring Kit found at Haascnc.com

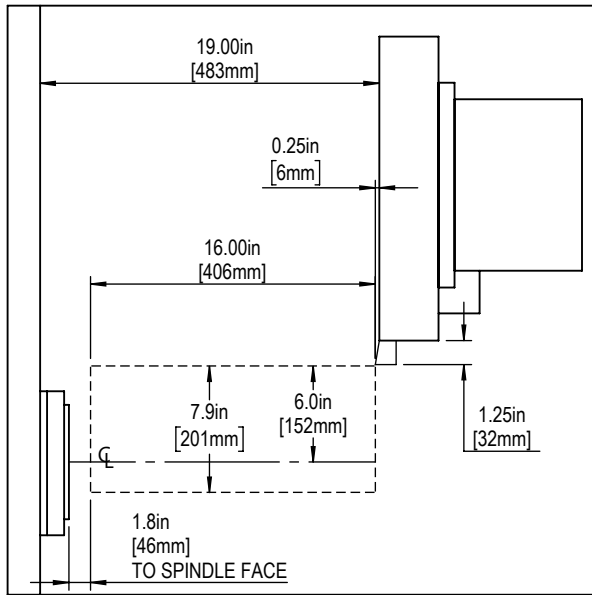


Height Breakdown

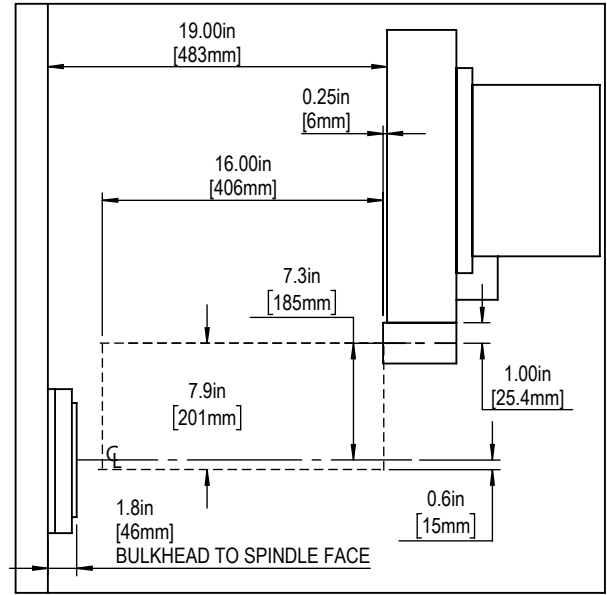


Width Breakdown





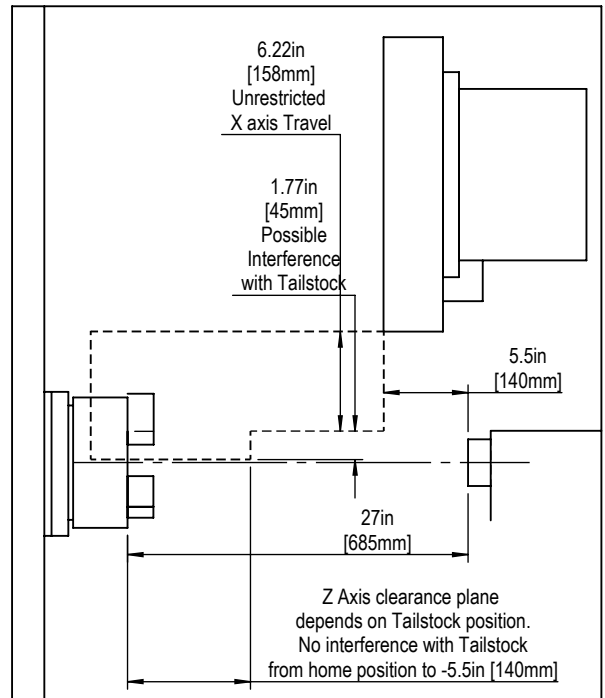
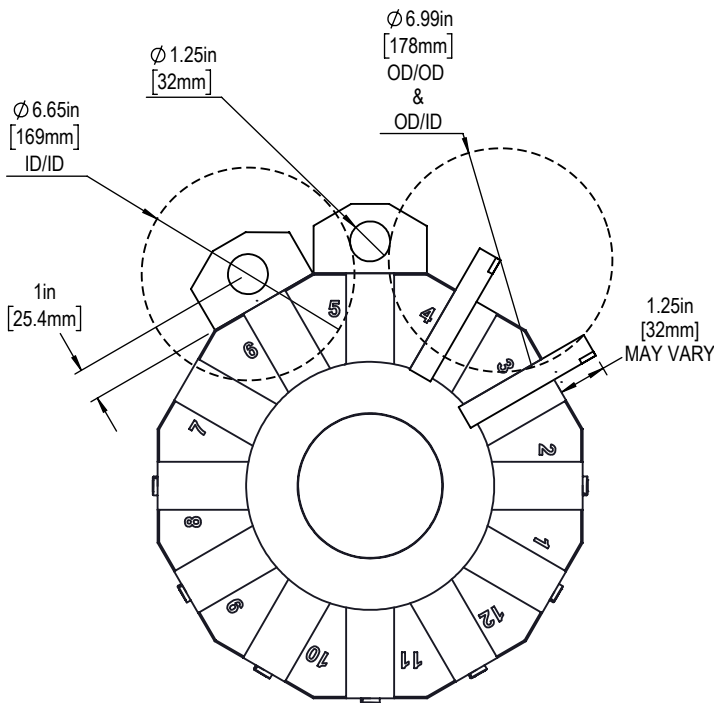
BOT OD*



BOT ID / Drill / Bore */**

AVERAGE CHUCK WIDTH IS 3.6in [91mm] - AVERAGE CHUCK JAWS HEIGHT IS 1.25in [32mm]

ALTERNATIVE TALLER WORKHOLDING OR JAWS WILL REDUCE THE AVAILABLE WORK ENVELOPE

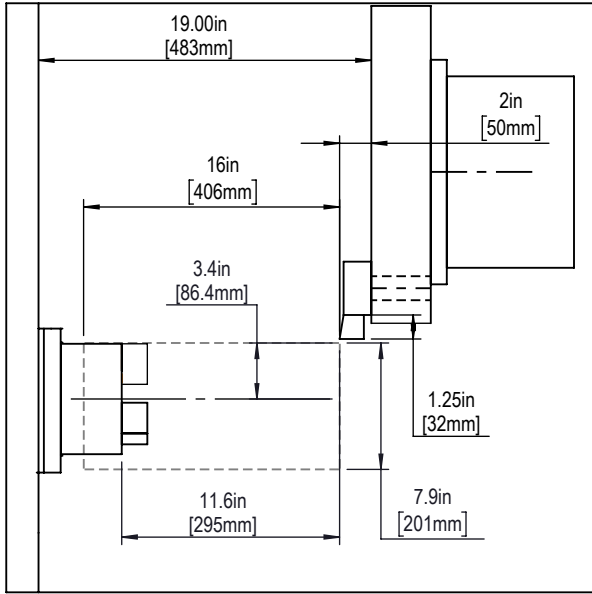


Tailstock

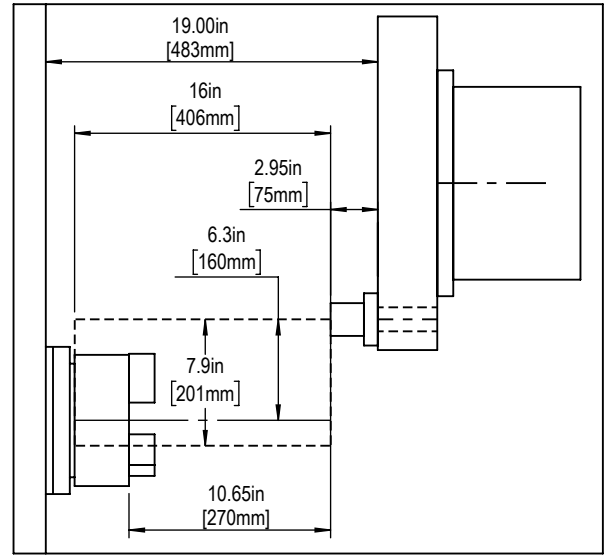
* Shift the work envelope in X by the tool protrusion length

** Shift the work envelope in Z by the tool protrusion length

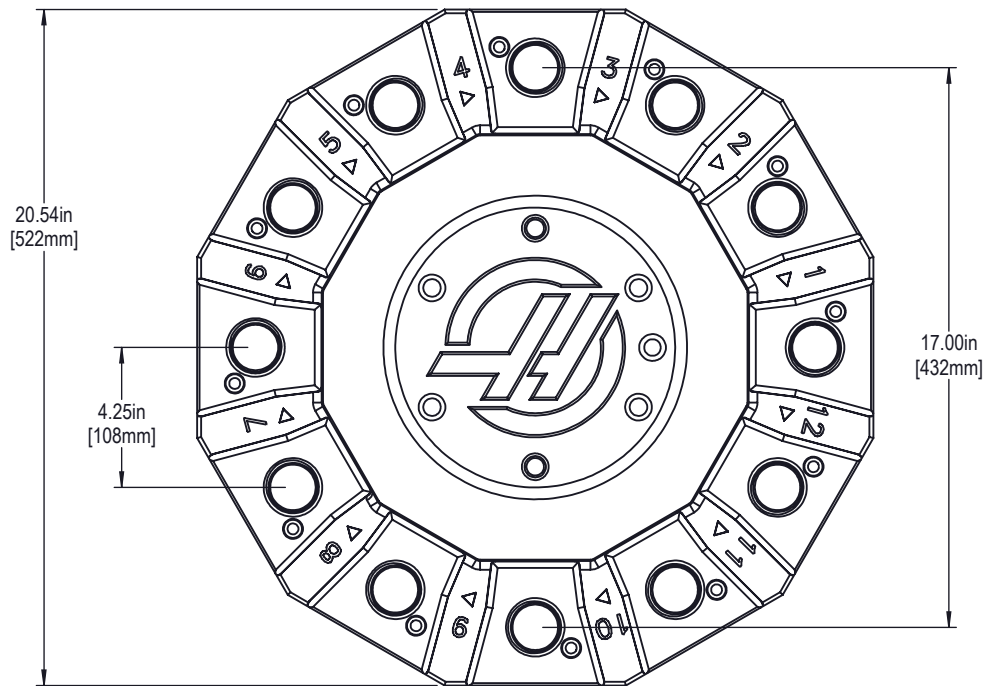
Note - Sub Spindle not compatible with BOT Turret



VDI OD



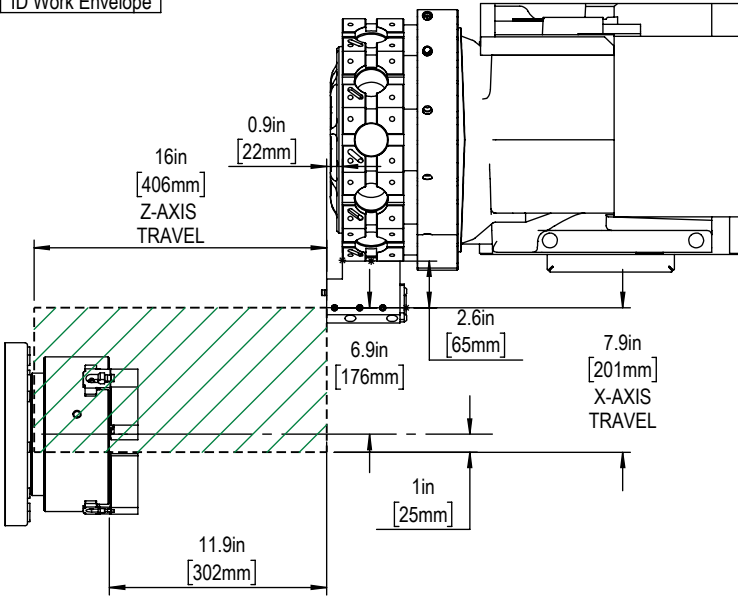
VDI ID



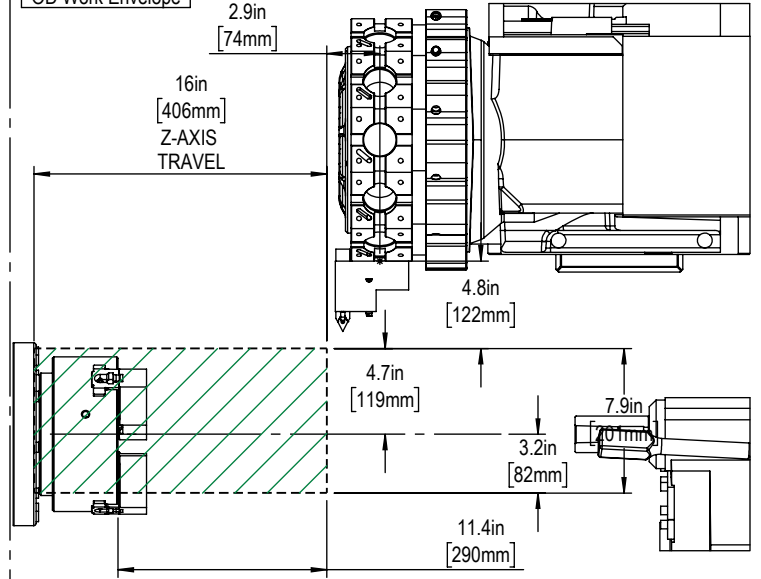
Note: The TURRET shape and dimensions may vary depending on the vintage of the machine.

Parallel Plane Envelope Diagrams

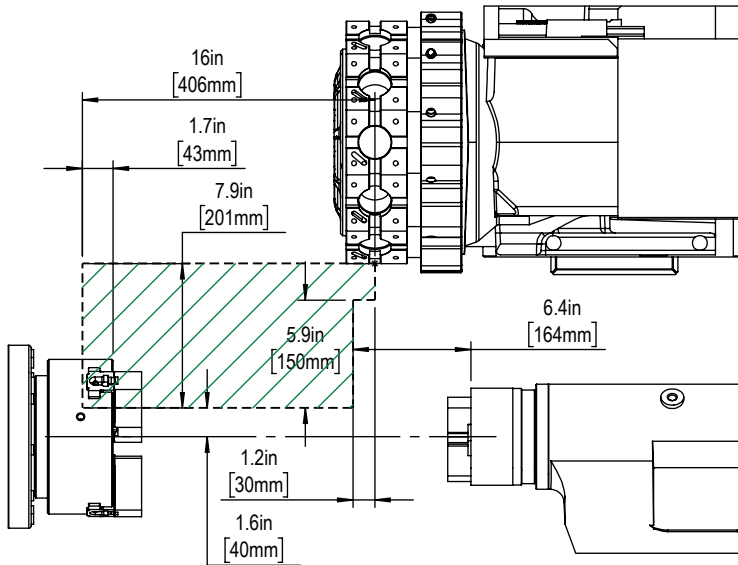
ID Work Envelope



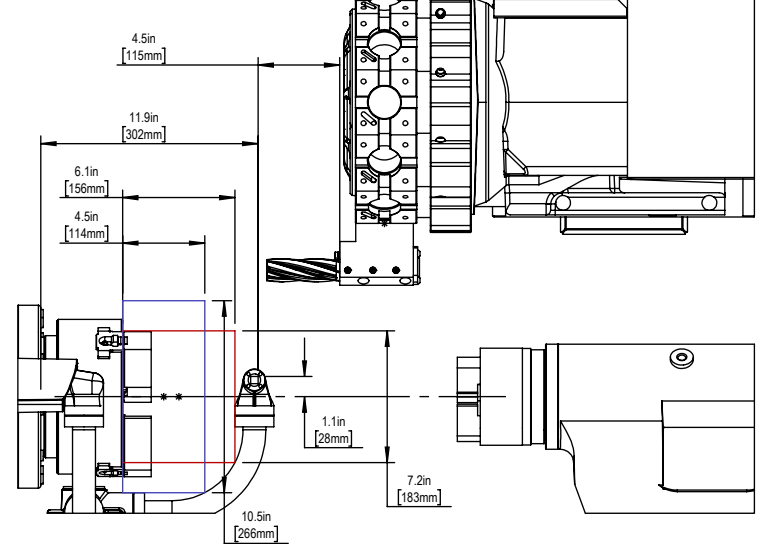
OD Work Envelope



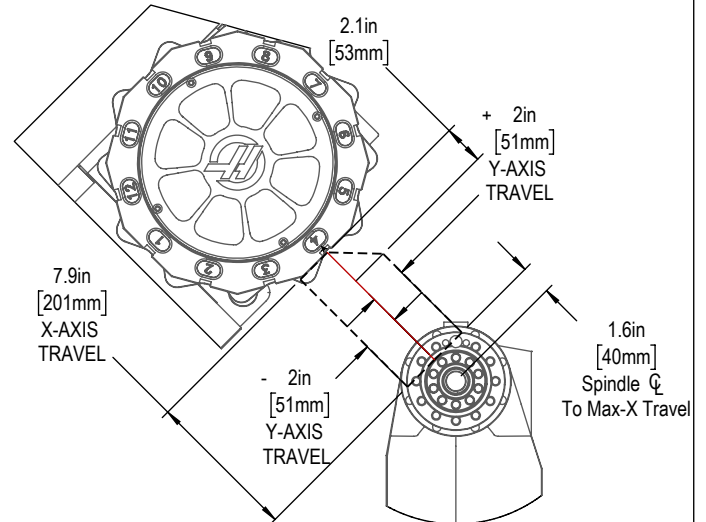
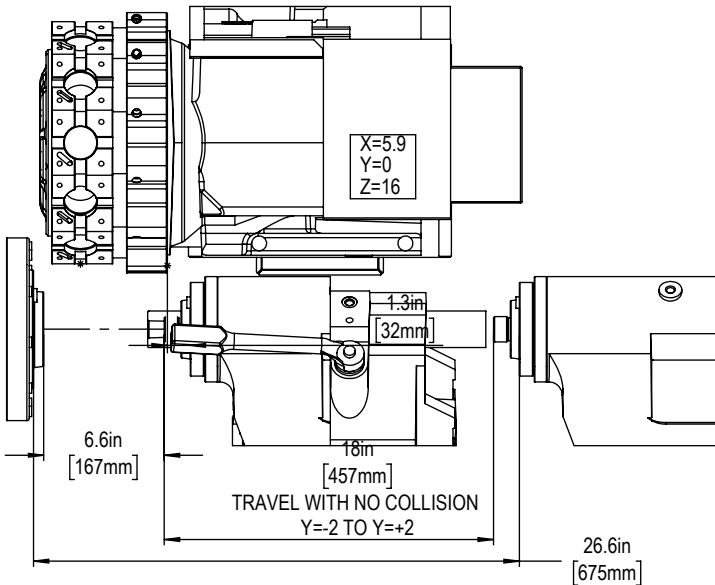
No main/sub-spindle chuck travel

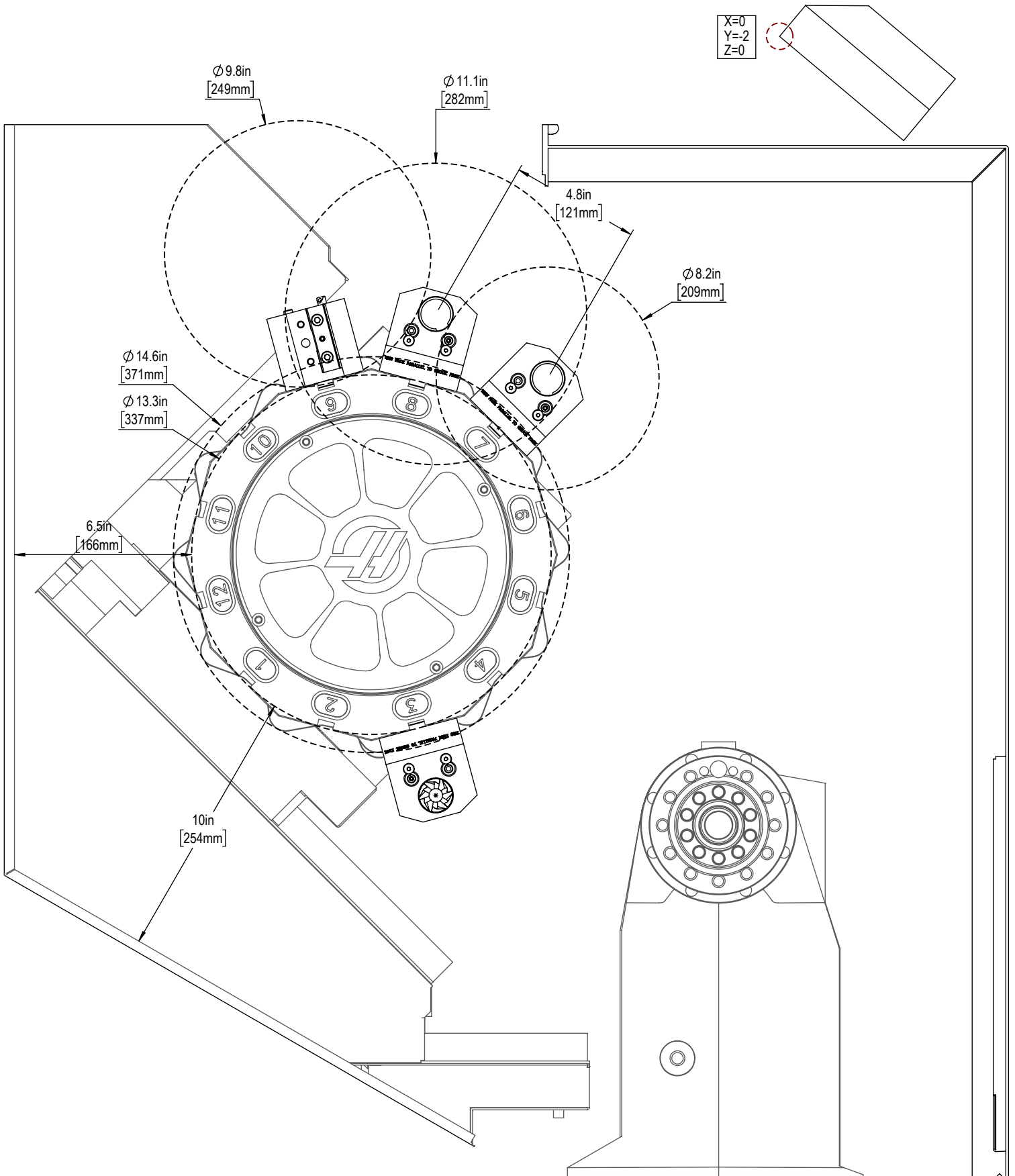


Automatic Tool Probe Clearance



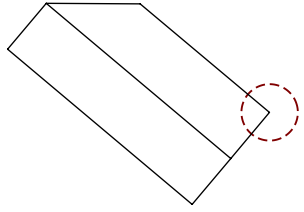
Y-AXIS Travels



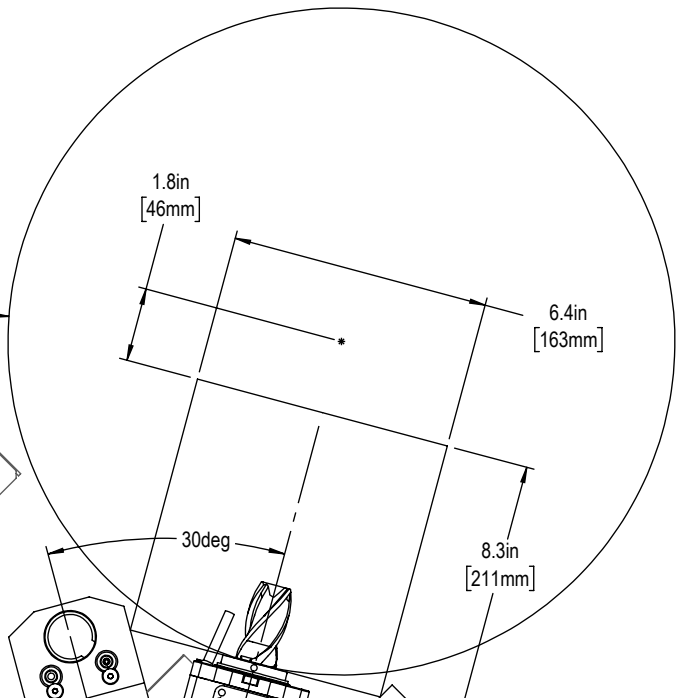




X=7.9
Y=2
Z=0



Ø 16.5in
[419mm]
MAX PART SIZE



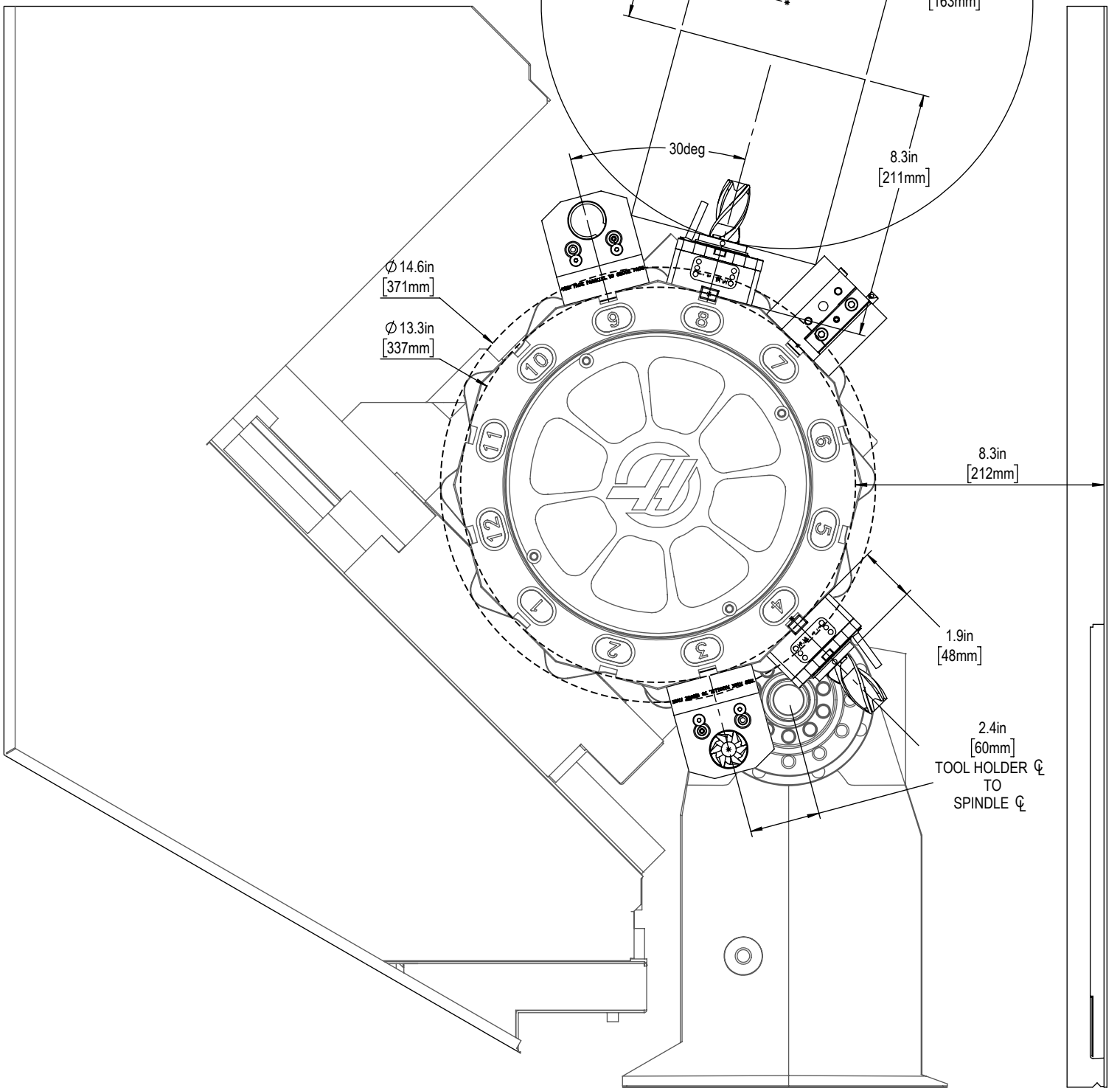
Ø 14.6in
[371mm]

Ø 13.3in
[337mm]

8.3in
[212mm]

1.9in
[48mm]

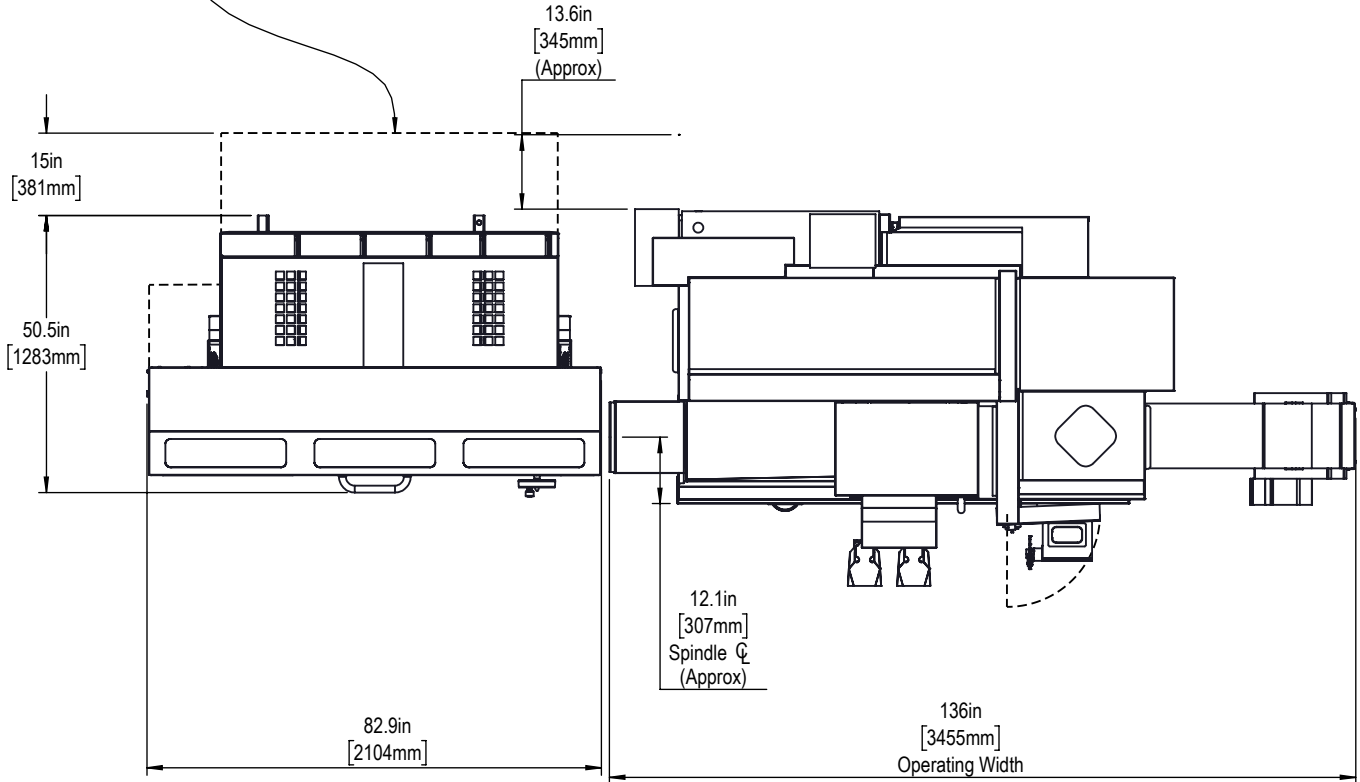
2.4in
[60mm]
TOOL HOLDER Ø
TO
SPINDLE Ø

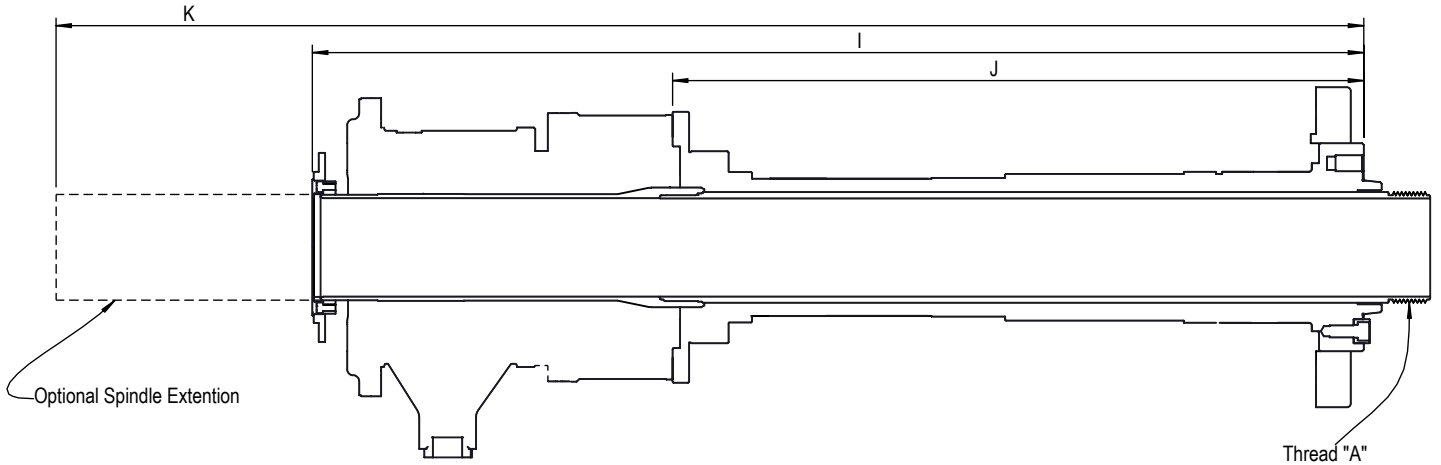




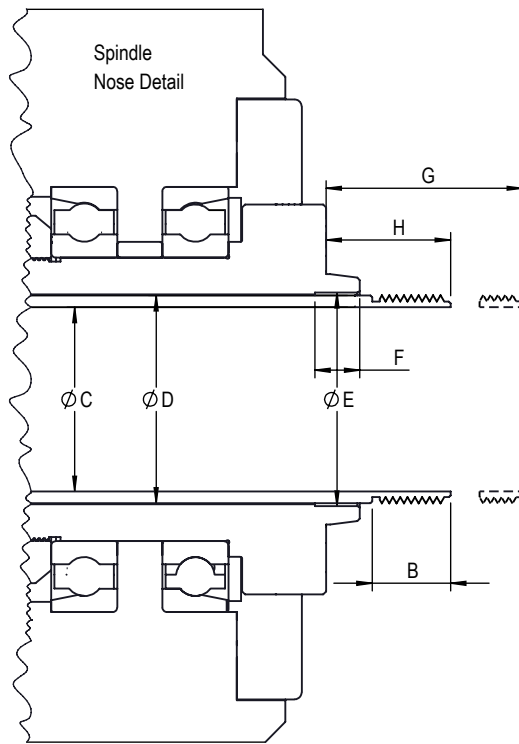
Barfeeder Layout

Footprint with Bar Feeder in Rear / Service position

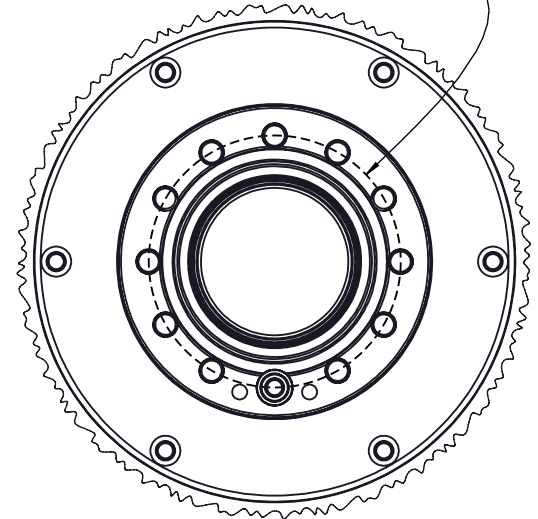




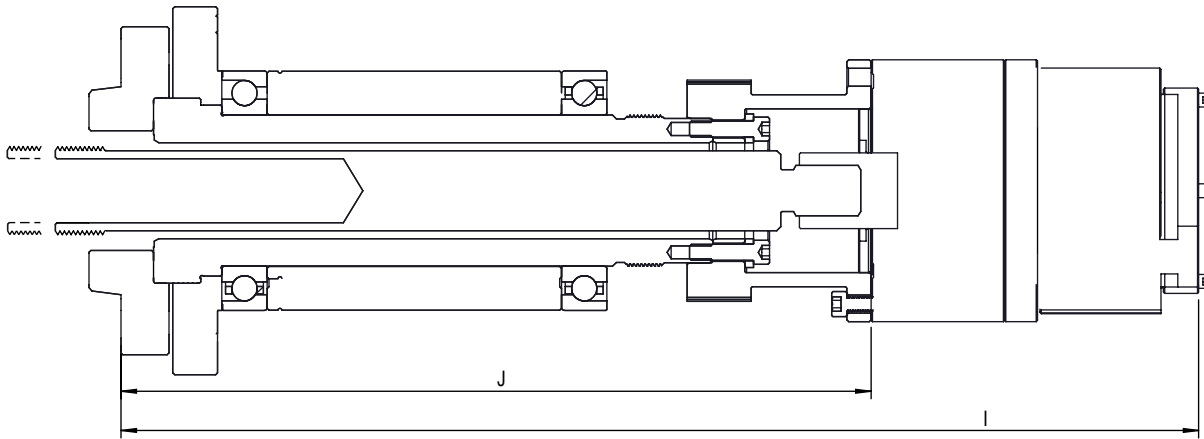
The following dimensions should be used as a reference only. Haas uses many different vendors for our drawtube assemblies. If any custom workholding is required Haas recommends you retrieve the exact dimensions from your delivered machine.



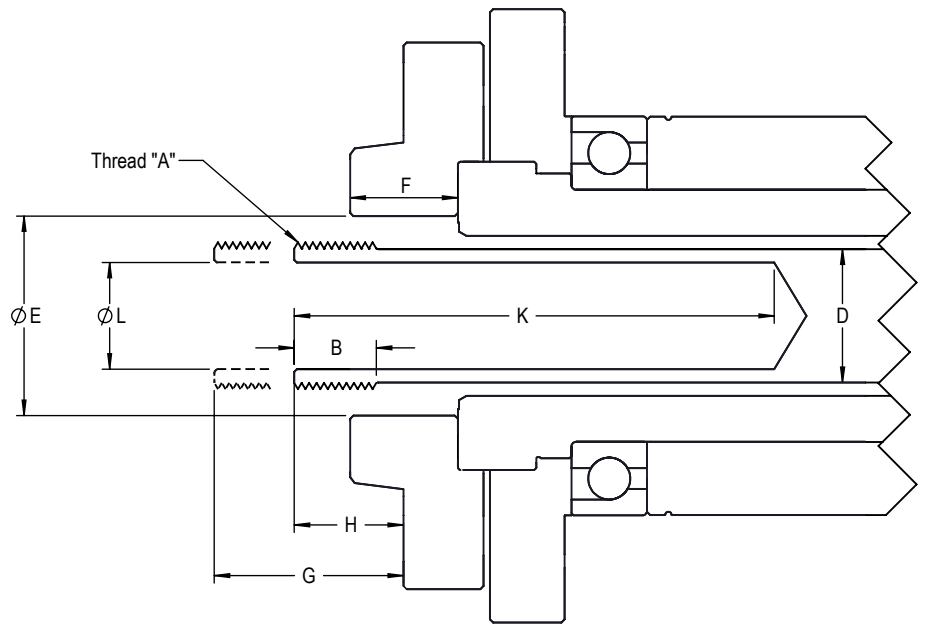
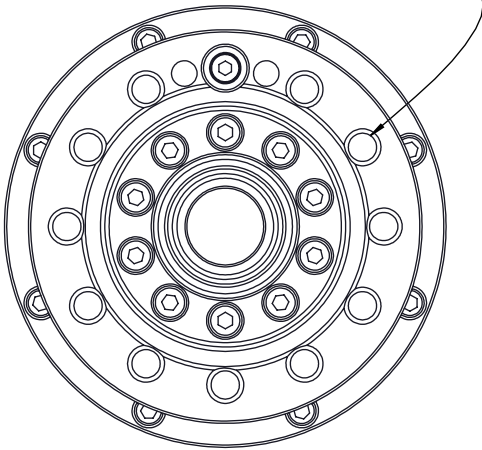
BHC and Spindle Nose dimensions per American Standard Bulletin ASA B5.9 1960



ST-10/15/Y/Reboot Spindle Schematic for all vintages					
DESCRIPTION	DIMENSION	ST-10/Y		ST-15/Y	
		SAE	METRIC	SAE	METRIC
MAIN OR SUB SPINDLE & TYPE		Main / A2-5		Main / A2-6	
DIAMETER OF THREAD	A	2.165"	55 MM	2.95"	75 MM
THREAD PITCH	A	0.0787"	2.0 MM	0.0787"	2.0 MM
INTERNAL OR EXTERNAL	A	External		External	
LENGTH OF THREAD	B	0.70"	17.78 MM	1.36"	34.54 MM
DRAWTUBE INNER DIAMETER	C	1.81"	45.98 MM	2.56"	65 MM
DRAWTUBE OUTER DIAMETER	D	2.25"	57.15 MM	3.03"	76.96 MM
COUNTERBORE INNER DIAMETER	E	2.50"	63.5 MM	3.52"	89.4 MM
COUNTERBORE DEPTH	F	0.620"	15.75 MM	0.75"	19.05 MM
DRAWTUBE EXTENDED DISTANCE	G	1.52"	38.6 MM	2.50"	63.5MM
DRAWTUBE RETRACTED DISTANCE	H	0.93"	23.6 MM	1.52"	38.6MM
SPINDLE FACE TO BACK OF UNION	I	30.78"	781.8 MM	33.53"	851.67 MM
SPINDLE FACE TO UNION ADAPTOR	J	22.75"	578 MM	22.53"	572.3 MM
TO BACK OF EXTENTION (OPTION)	K	48.0"	1219MM	48.0"	1219MM



BHC and Spindle Nose dimensions per American Standard Bulletin ASA B5.9 1960



The following dimensions should be used as a reference only. Haas uses many different vendors for our drawtube assemblies. If any custom workholding is required Haas recommends you retrieve the exact dimensions from your delivered machine.

SUB-SPDL-A2-5 for ST-10 to ST-25			
DESCRIPTION	DIMENSION	SAE	METRIC
MAIN OR SUB SPINDLE & TYPE		Sub-Spindle / A2-5	
DIAMETER OF THREAD	A	1.378"	35 MM* or 40 MM
THREAD PITCH	A	0.059"	1.5 MM
INTERNAL OR EXTERNAL	A	External	
LENGTH OF THREAD	B	0.50"	12.7 MM
DRAWTUBE INNER DIAMETER	C	N/A - SOLID DRAWBAR	
DRAWTUBE OUTER DIAMETER	D	1.25"	31.75MM
COUNTERBORE INNER DIAMETER	E	1.870"	47.5 MM
COUNTERBORE DEPTH	F	1.01"	25.65MM
EXTENDED DISTANCE TO NOSE	G	1.465"	37.2 MM
RETRACTED DISTANCE TO NOSE	H	0.874"	22.2 MM
FROM SPINDLE FACE TO BACK OF UNION	I	11.72	297.7MM
FROM SPINDLE FACE TO UNION ADAPTOR	J	16.84	427.7MM
EJECTOR POCKET DEPTH	K	4.5"	114.3MM
EJECTOR POCKET DIAMETER	L	1.0"	25.4MM
*M35 applies to Sub-Spindles made after July 2019 - M40 applies to older vintages			