



Haas Oil Skimmer - Installation - AD0480

4.1 HAAS OIL SKIMMER - INSTALLATION

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AD0480

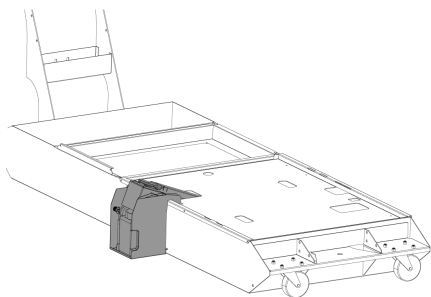
Introduction

This procedure tells you how to install the Haas Oil Skimmer system. The Oil Skimmer does these functions:

- Automatically removes tramp oil. This decreases bacteria and helps to keep the coolant clean
- Constant rotation removes oil from the surface of the coolant and deposits it into an external collection container.
- Starts and stops easily with the toggle switch on the side of the unit. You can also add an electrical timer to automatically start and stop the Oil Skimmer.

For information on maintenance, refer to the [HAAS OIL SKIMMER - MAINTENANCE](#) procedure.

For information on troubleshooting, refer to the [HAAS OIL SKIMMER - TROUBLESHOOTING GUIDE](#).



Machine Compatibility

- You can install the Oil Skimmer on machines that have an external 55-gallon (208 L) or 95-gallon (360 L) coolant tank.
- ST-10/15/L machines:** Require Oil Skimmer Mount Bracket Kit (P/N: **93-1001137**). ST-10/15/L HPC option is **not** compatible with the Oil Skimmer.

The coolant tanks in the list below have a hole and a slot in the coolant tank cover for the Oil Skimmer:

- 55-gallon (208L) coolant tanks made after May, 2019.
- 95-gallon (360L) coolant tanks made after Feb, 2019.

For all other machines, you must use the Tank Cover Template to make the hole and the slot in the coolant tank cover.

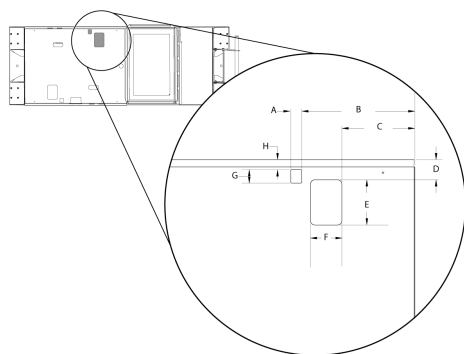
For all machines made before October 2014, you must use the Enclosure Apron Template to make holes in the enclosure apron for the female connector on the 25 FT EXTENSION CABLE [B].

Note: This procedure shows a vertical machine. The installation on lathes and horizontal machines is similar.

Tools Required

- Drill
- Jigsaw
- Drill Bit - 5/32" (0.156")
- Hole Saw - 1.75"

Templates



Tank Cover -Template

Use this template to make the hole and the slot in the coolant tank cover.

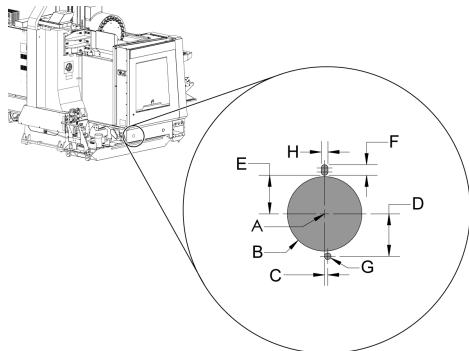
Cut the hole and slot on the left or right side of the cover. Choose the side for your machine that gives you access to the Oil Skimmer.

On the top of the cover for the coolant tank, measure and mark the dimensions of the holes.

- A - 1.20" (3 cm).
- B - 12.50" (32 cm).

- C - 8.10" (21 cm).
- D - 2.20" (6 cm).
- E - 5.00" (13 cm).
- F - 3.50" (9 cm).
- G - 1.50" (4 cm).
- H - 1.10" (3 cm).

Cut and de-burr the hole and the slot.



Enclosure Apron - Template

For all machines made before October 2014, you must use this template to make (3) holes in the enclosure apron for the female connector on the 25 FT EXTENSION CABLE.

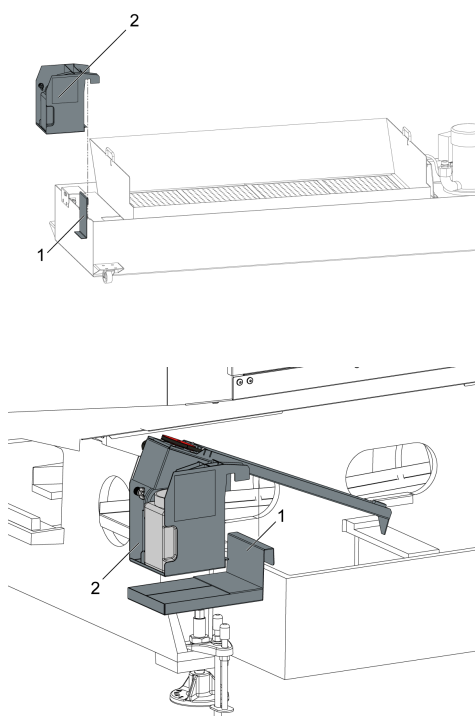
Choose a location in the apron that is near the Oil Skimmer. Put a mark in the apron [A] for the center of the hole.

Measure and mark these dimensions for the holes:

- B - Ø1.75" (4.4 cm).
- C - 0.07" (0.1 cm).
- D - 1.00" (2.5 cm).
- E - 0.90" (2.3 cm).
- F - 0.25" (0.6 cm).
- G - Ø0.156" (0.4 cm).
- H - 0.156" (0.4 cm).

Cut and de-burr the (3) holes.

Oil Skimmer Installation



1

Note: This step is for DC-1 machines only.

Install OIL SKIMMER BRACKET [1] onto the coolant tank edge before hanging the OIL SKIMMER BASE [2].

Hang the OIL SKIMMER BASE [2] over the OIL SKIMMER BRACKET [1].

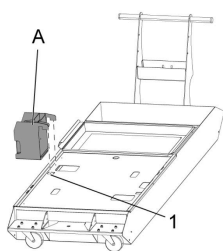
2

Note: This step is for ST-10/15/L machines only.

Note: For machines that were purchased with the oil skimmer option [2], the bracket [1] must be adjusted to match the image.

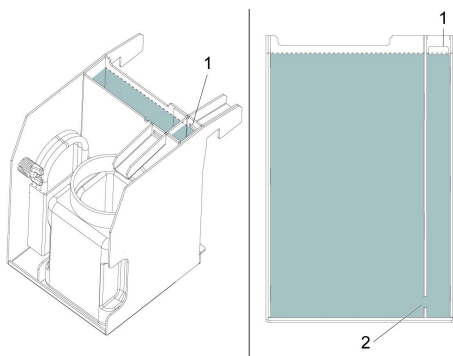
Install OIL SKIMMER BRACKET [1] onto the coolant tank edge before hanging the OIL SKIMMER BASE [2].

Hang the OIL SKIMMER BASE [2] over the OIL SKIMMER BRACKET [1].



3

Hang the OIL SKIMMER BASE [A] from the Coolant Tank with the hanging hooks engaged onto the Coolant Tank Lid [1]. The horizontal surface of the hanging hooks should be flat on the top of the Coolant Tank Lid edge.



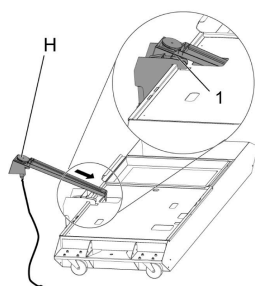
4

Fill the Oil Skimmer Chambers with clean coolant up to the drain [1] facing the coolant tank.

NOTE: The two chambers are connected with a slot at the bottom [2]. Make sure both chambers are filled.

5

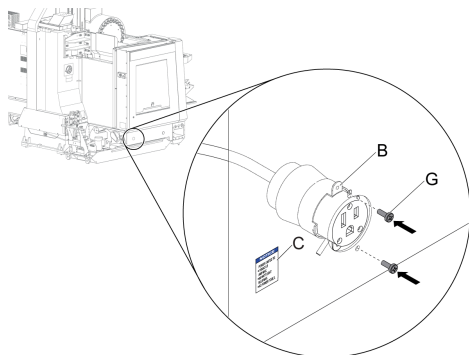
Install the OIL SKIMMER TOP ASSEMBLY [H] by positioning the narrow end of the Oil Skimmer into the Coolant Tank lid opening and then fitting the motor end onto the base engaging the alignment slots [1].



6

Attach the female connector on the 25 FT EXTENSION CABLE [B] to the enclosure apron. Use the (2) BOLTS [G].

Apply the DECAL [C] to the enclosure apron.

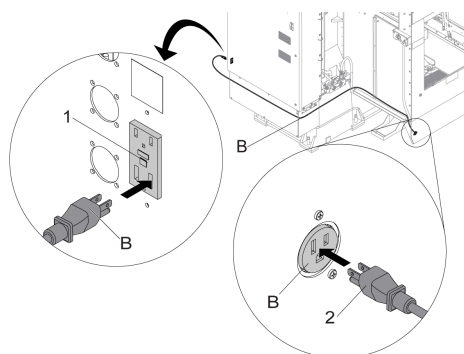


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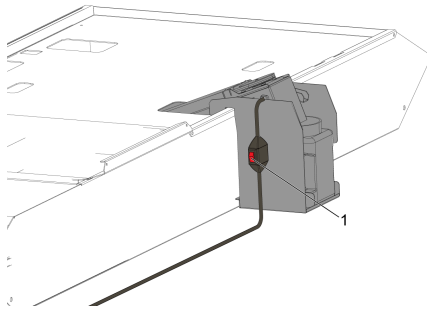
Connect the 25 FT EXTENSION CABLE [B] to the GFCI outlet [1] on the control cabinet.

Use the CABLE TIES [D], the CLAMPS [E], and the MOUNTS [F] as necessary to route the cable.

Connect the power cable [2] for the Oil Skimmer to the female connector on the 25 FT EXTENSION CABLE [B] in the enclosure apron.



Oil Skimmer Operation



Turn the switch [1] to the on position.

Empty the Oil Container when full.

The oil skimmer is equipped with replacement scraper rings and replacement skimmer belt. Replace these components periodically based on their condition.

Overtime, coolant will get dirty. Replace with clean coolant periodically based on it's condition.