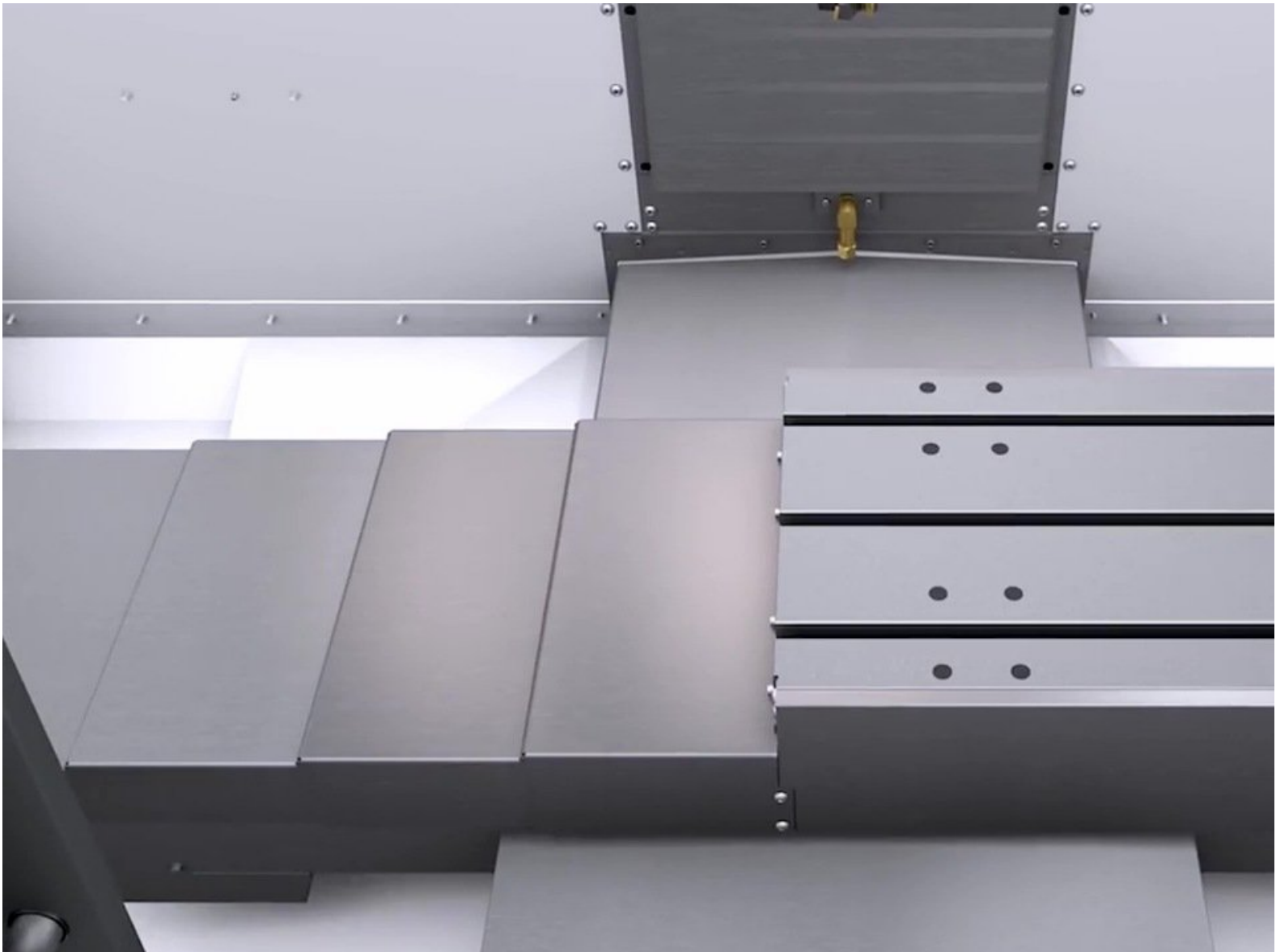


DOZUKI

Haas Mill X-Axis Waycover Wiper Gasket Replacement

This is how to maintain and replace the waycover wiper gaskets on Haas mills.

Written By: Quality Manager



INTRODUCTION

Note: This guide is an example of how standard work instructions are presented through the Dozuki format.

If you hear a popping noise coming from the waycovers, it's time to complete the maintenance items in this Guide. The video below gives an overview of the symptom we will resolve.



TOOLS:

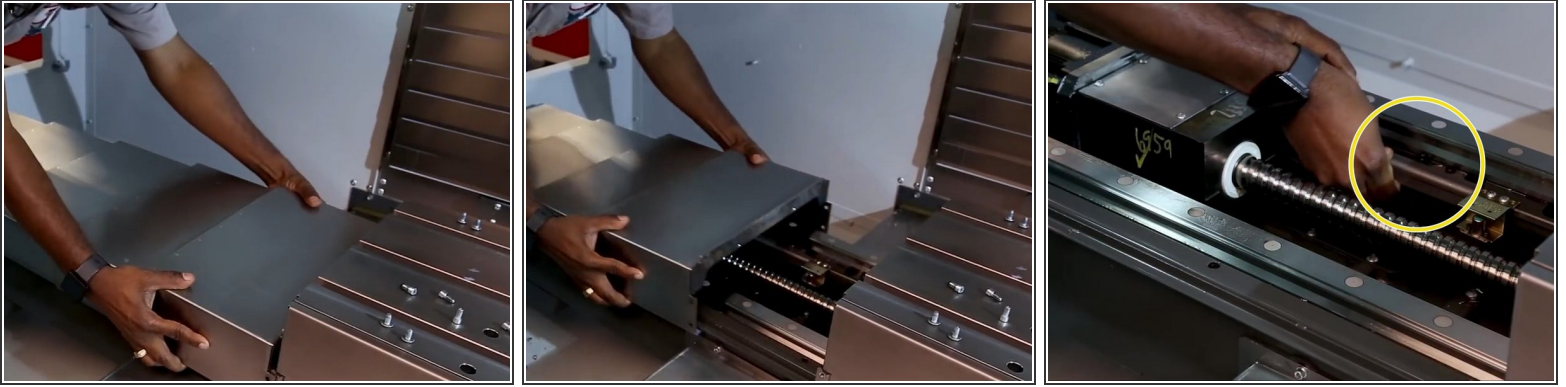
- [Scraper](#) (1)
- [Flashlight](#) (1)
- [Hex Wrench #3](#) (1)
- [Socket 5/8](#) (1)
- [Cutters](#) (1)
- [Leather Glove](#) (1)
- [Rubber Mallet](#) (1)



PARTS:

- [Red-I Grease \(P/N 99-4520A\)](#) (1)
- [RTV 502 Sealant \(P/N 99-4452\)](#) (1)
- [Wiper, Telescopic Waycover 0.081 THICK 23 FT \(X\)VF-4](#) (1)

Step 1 — Inspect Waycover Rails



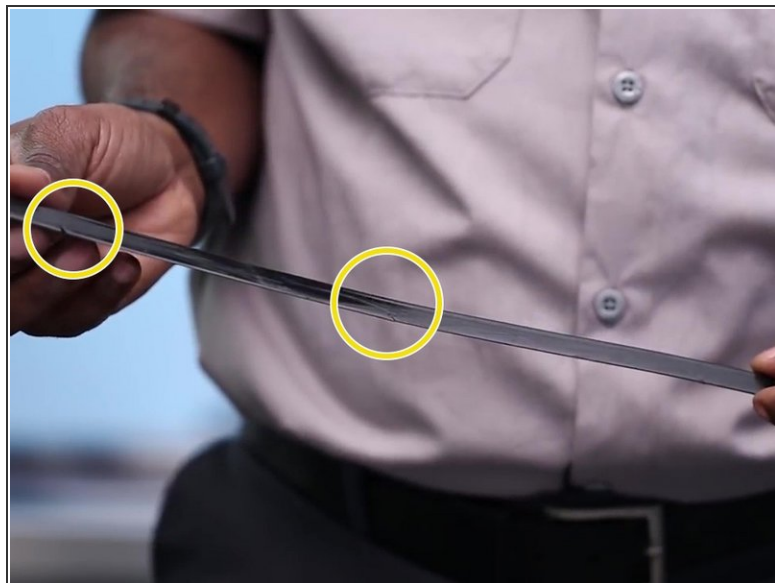
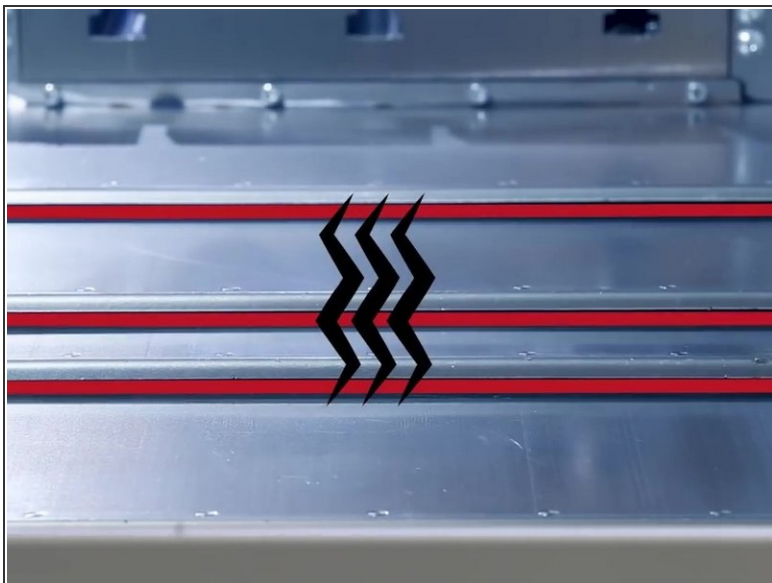
- Start by pulling the waycovers back.
- Inspect the rails for loose fasteners by wiggling the rails.
 - ✱ There should be no play in the rail.

Step 2 — Tighten Fasteners & Grease Rails



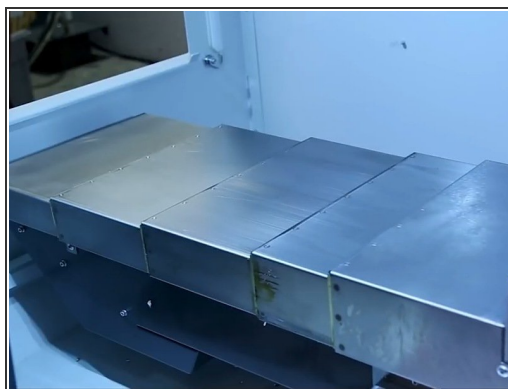
- Tighten the fastener bolts using a hex wrench.
- Apply a thin coat of red grease to the guide rails.
 - ✱ If the seals and waycovers are in good condition, this concludes the maintenance and should fix the popping noise.

Step 3 — Waycover & Seals (Wipers) Inspection



- ☀ If the waycovers show signs of damage, or the wiper seals are allowing lubricant to leak into the housing, they should be replaced
 - Wipers will often show small cracks as they have reached end of life.

Step 4 — Jog and E-Stop the Machine



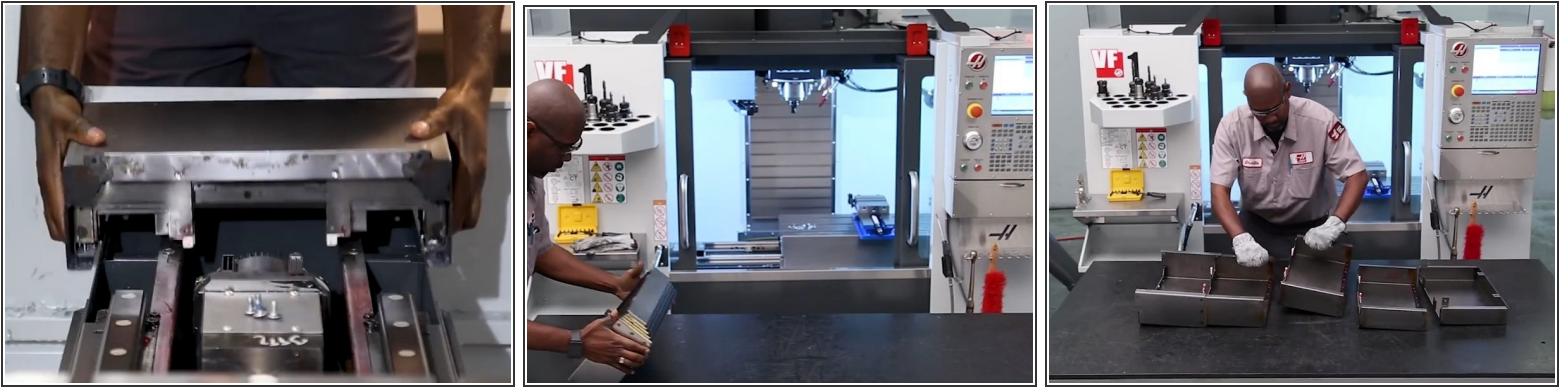
- Jog the X-Axis to the end of travel by rotating the **Handle Jog** counter clockwise.

⚠ Press the Emergency Stop button.

⚡ **Failure to E-Stop the machine can put operator at risk of electric shock!**

☠ DO NOT PROCEED WITHOUT E-STOP

Step 5 — Remove the Waycover



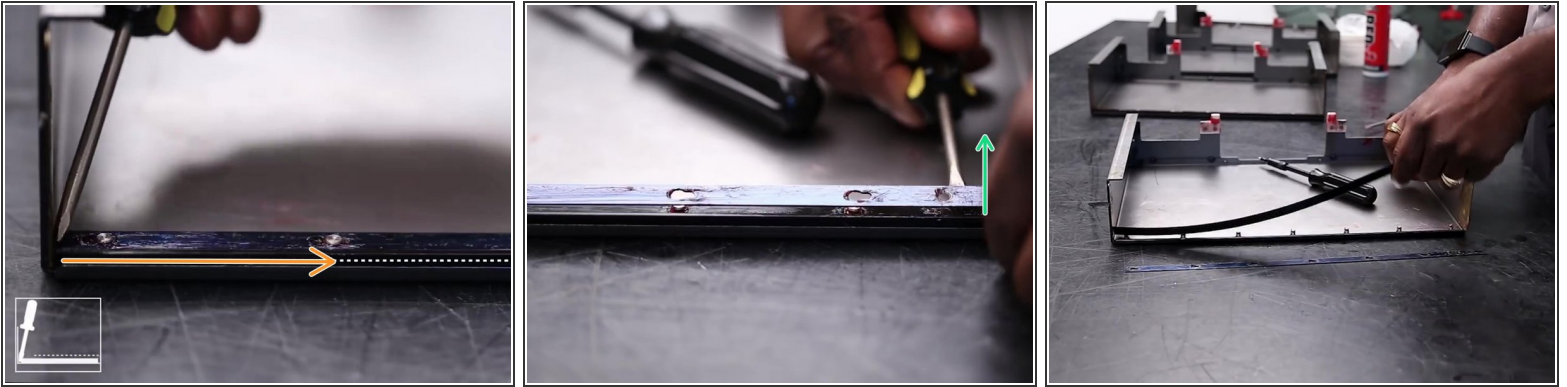
- Collapse the waycover and lift it from the end of the guide rail
- Remove the waycover from the machine and place it upside down on a work surface.
- Manually separate each section
 - Sections can be separated by hand simply by lifting up and pulling apart.

Step 6 — Preparation



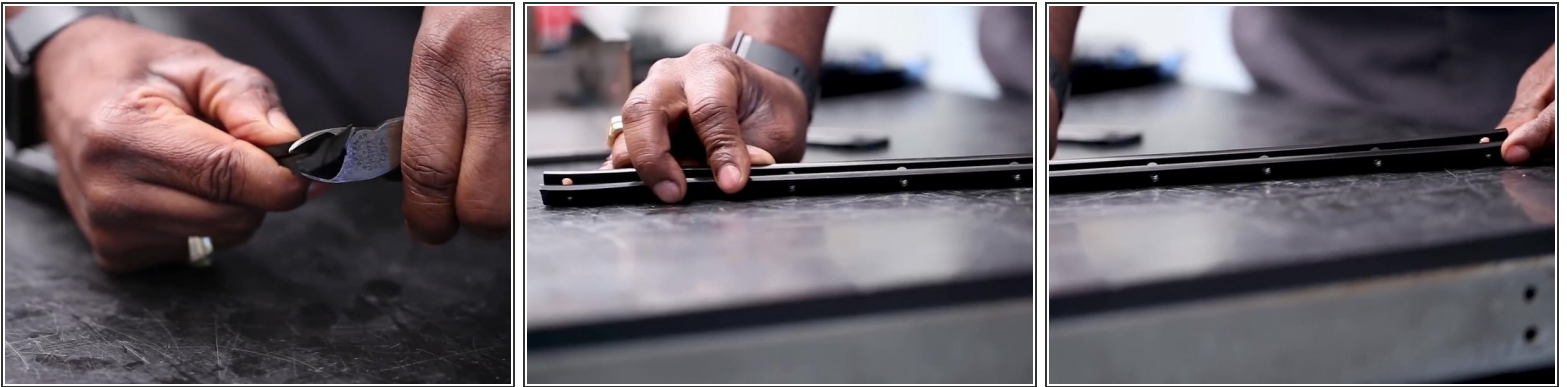
- Wipe excess grease from the rubber wiper gaskets.
- Locate and remove the small philips screw that secures the wiper blade.

Step 7 — Retaining Strip & Wiper Removal



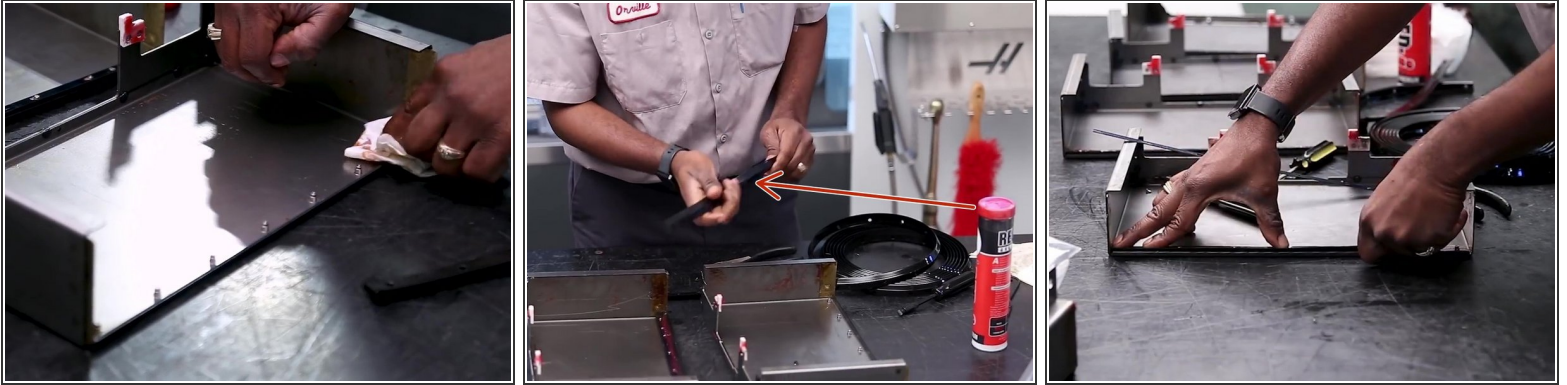
- Using a flathead screwdriver slide the retaining strip towards the opposite end of the waycover to disengage from the standoffs.
- Pry the retaining strip up away from the standoffs.
- Remove the damaged wiper.

Step 8 — Wiper Sizing



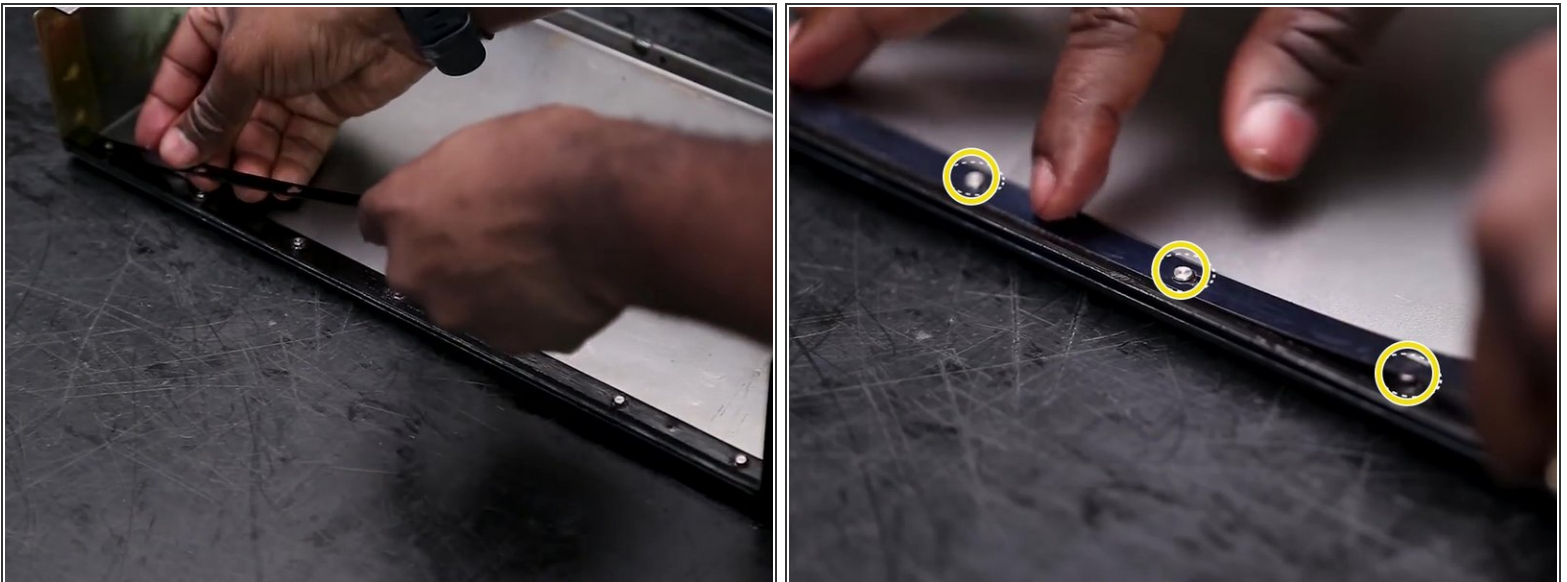
- Cut the new wiper to exact length
 - ✦ The old wiper can be used as a reference point for length and to make sure holes are aligned.

Step 9 — Wiper Re-Installation



- Prior to installation, clean any remaining grease from the waycover
- Apply a light coat of red grease to the new wiper.
- Place the new wiper onto the waycover.

Step 10 — Retainer Re-Installation



- Install the retainer over the top of the wiper.
- Make sure the retainer captures all of the standoffs.

Step 11 — Retainer Re-Installation



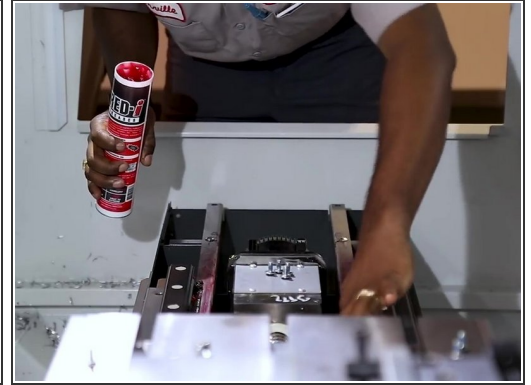
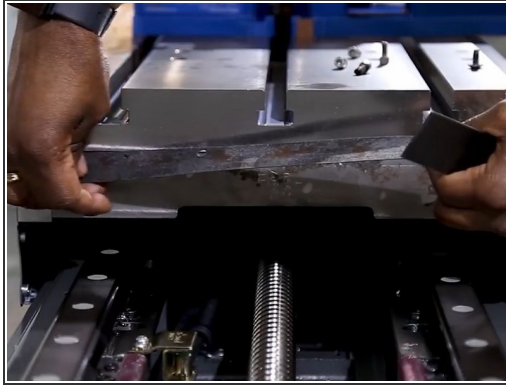
- With one hand, apply downward pressure to the retainer.
- Use a flathead screwdriver to slide the retainer into the locked position on the standoffs.
- Verify the standoffs and retainer are locked together.

Step 12 — Waycover Re-Assembly



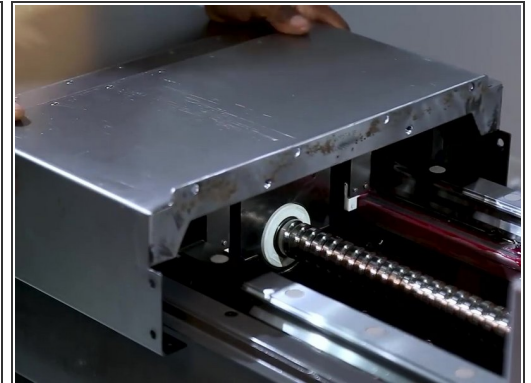
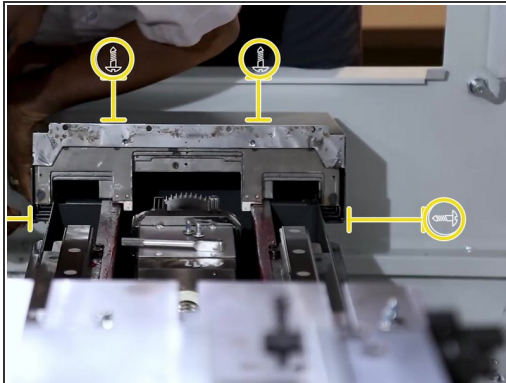
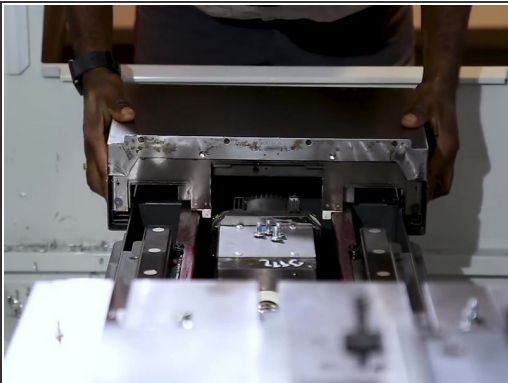
- Put the waycover sections back together.

Step 13 — Mill Preparation



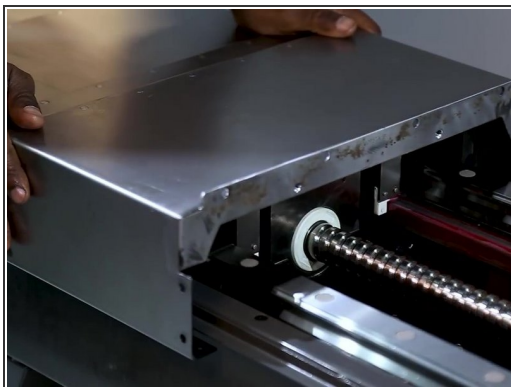
- Remove any remaining chips or debris from the linear guides.
- Remove the used gasket and sealant from the table mounting surface.
- Apply a thin coat of grease to the waycover guide bars

Step 14 — Install the Waycover



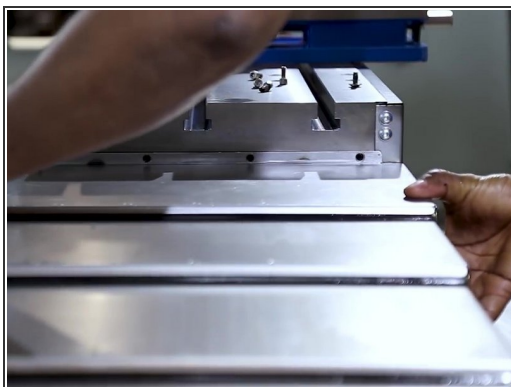
- Install the waycover over the guide bars.
- Attach the waycover end panel to the waycover bracket with the fasteners.
- Fully extend the waycover one leaf at a time.
 - ⚠ Make sure the sections do not separate.

Step 15 — Gasket Replacement



- With the largest leaf of the cover away from the table:
 - Put a bead of rtb silicone on the way cover
 - Put the new gasket on the face of the waycover

Step 16



- Extend the waycover to the table
- Install the fasteners.
- Wipe away any excess silicone.

Step 17 — Release the Emergency Stop & Reset



- Release the E-Stop by pulling the Emergency Stop button outwards.
- Press the "Reset" button multiple times until all alarms are cleared.

Step 18 — Lubricate and Jog



- Apply a light coat of oil to all sections of the e-cover.
- Manually jog the X-Axis slowly to make sure none of the leaves bind.

Step 19

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The Industry Benchmark for
Standard Work Instructions

This has been an example of a basic machine maintenance
work instruction formatted in Dozuki.

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