



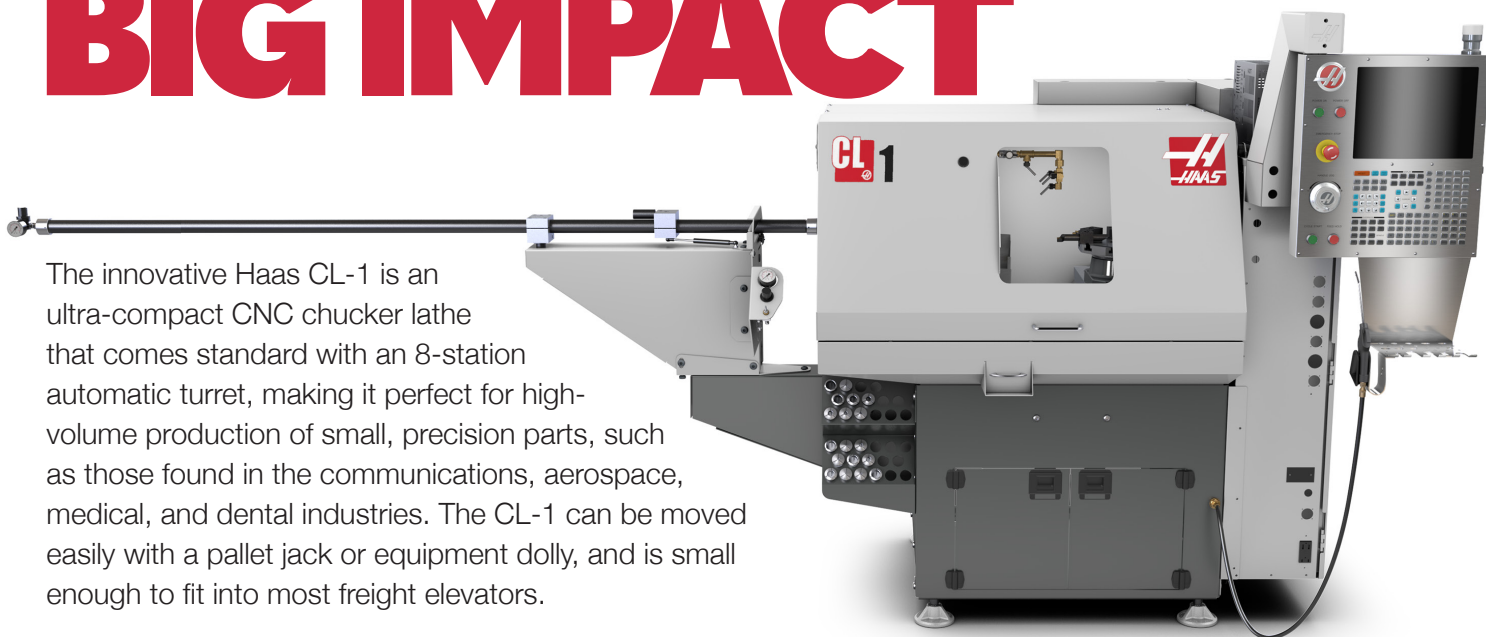
Haas
F1 Team
OFFICIAL MACHINE TOOL

Small-footprint, affordable
CHUCKER LATHE
for prototyping or
production work



SMALL FOOTPRINT BIG IMPACT

The innovative Haas CL-1 is an ultra-compact CNC chucker lathe that comes standard with an 8-station automatic turret, making it perfect for high-volume production of small, precision parts, such as those found in the communications, aerospace, medical, and dental industries. The CL-1 can be moved easily with a pallet jack or equipment dolly, and is small enough to fit into most freight elevators.



SWING DIAMETER

Over Cross Slide	11.0 in
Over Table	4.95 in

CAPACITIES

Chuck Size (max)	4.0 in
Max Cutting Diameter	5.0 in
Bar Capacity	1.00 in

TRAVELS

X Axis	12.0 in
Z Axis	8.0 in

FEEDRATES

Max Cutting	500 ipm
Rapids on X	757 ipm
Rapids on Z	757 ipm

AXIS MOTORS

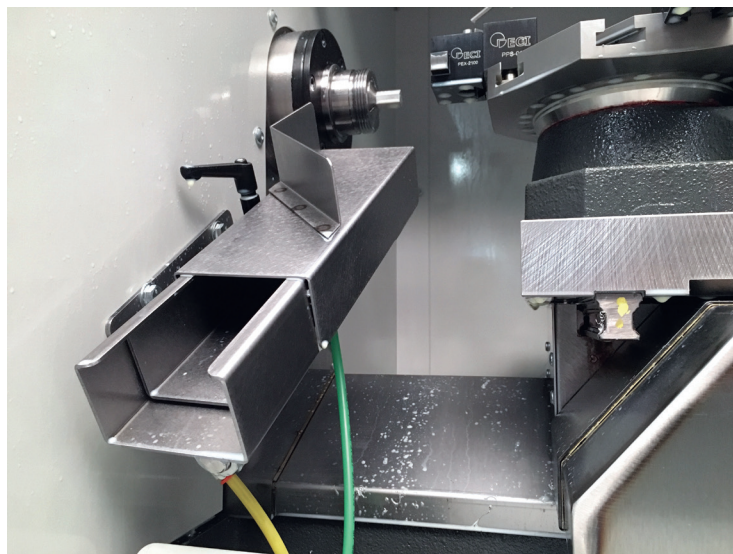
Max Thrust X	1149 lbf
Max Thrust Z	1149 lbf

SPINDLE

Spindle Nose	5C (collet) Type Nose
Drive System	Direct Speed, Belt Drive
Max Rating	5.0 hp
Max Speed	6000 rpm
Spindle Bore \emptyset	1.25 in

TOOLING

Tooling	Gang Style-Any Combination
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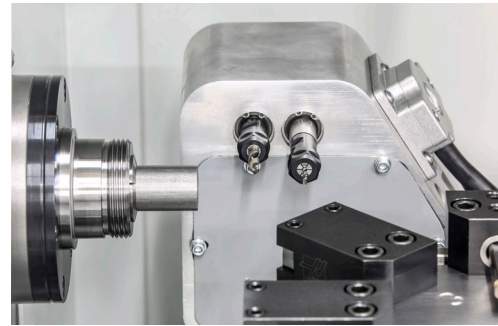
PARTS CATCHER

The CL Parts Catcher rotates into position to catch the finished part as it is cut off, and directs it into a bin located on the front of the machine. It is easily adjusted to accommodate different part-off locations, and finished parts can be retrieved without opening the door.

- Allows for unattended machining
- Fully integrated with the Haas control; activated by M-code
- Easily adjusts for different part-off locations
- Allows retrieval of finished parts without opening the door

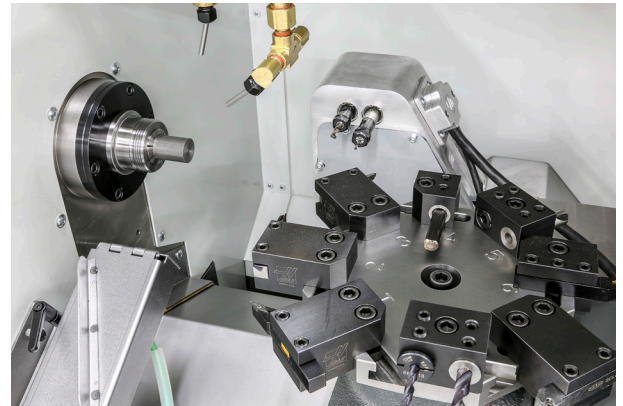


Haas Automation, Inc.
Chucker Lathe



LIVE TOOLING

Our 6000-rpm Live Tooling option for the CL-1 features dual ER-11 spindles that accept 1/16" - 1/4" tools. It includes fully synchronized C-axis motion, allowing you to perform secondary milling operations around the diameter of the part.



TOOL TURRET

The CL-1 comes standard with an 8-station automatic tool turret. This turret accommodates gang-style tooling with 1/2" centers.

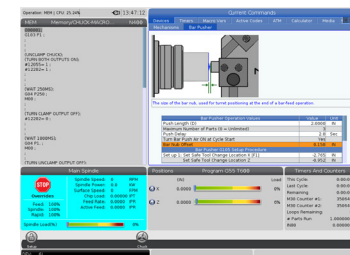
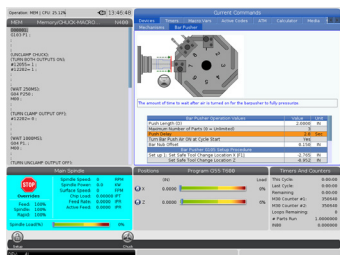
SPINDLE

The CL-1 features a 6000-rpm 5C collet spindle designed specifically for bar feeding operations. For larger diameter parts, a 4" manual 3-jaw scroll chuck can be mounted to the spindle nose. All Haas spindles are designed and built in-house at our Southern California manufacturing facility.



VISUAL PROGRAMMING SYSTEM

The Haas Visual Programming System uses graphical templates and a form-like interface to help you quickly create G-code programs for not only basic part features, but also more complex operations, like Y-axis milling/drilling, probing, and more. Simply define the feature in the template, and VPS then outputs working G-code at the touch of a button. VPS also includes a custom template generator, so you can create templates for your own part features or frequently used programs.



Operation: MEM | CPU: 24.22% | 13:46:27

MEM Memory/CHUCK-MACRO... N400

```

000001:
CL03 P1:
:
:(UNCLAMP CHUCK);
:(TURN BOTH OUTPUTS ON);
#12055=1;
#12202=1;
:
:(WAIT 250MS);
G04 P250;
M00;
:
:(TURN CLAMP OUTPUT OFF);
#12202=0;
:
:(WAIT 1000MS);
G04 P1;
M00;
:
:(TURN UNCLAMP OUTPUT OFF);

```

Bar Pusher operation values table:

Bar Pusher operation values	Value	Unit
Push Length (D)	2.0000	IN
Maximum Number of Parts (0 = Unlimited)	3	
Push Delay	2.0	Sec
Turn Bar Push Air ON at Cycle Start	Yes	
Bar Hub Offset	0.150	IN
Bar Pusher G10S Setup Procedure		
Set up 1: Set Safe Tool Change Location X [F1]	-2.765	IN
Set Safe Tool Change Location Z	-0.952	IN

Main Spindle: Spindle Speed: 0 RPM, Spindle Power: 0.0 KW, Surface Speed: 0 FPM, Chip Load: 0.0000 IPT, Feed Rate: 0.0000 IPR, Active Feed: 0.0000 IPR, Spindle Load: 100%, Rapid: 100%

Positions: X: 0.0000 IN, Z: 0.0000 IN, Load: 0%, 6%

Timers And Counters: This Cycle: 0:00:00, Last Cycle: 0:00:00, Remaining: 0:00:00, M30 Counter #1: 350640, M30 Counter #2: 350640, Loops Remaining: 0, # Parts Run: 1,000,000, INB0: 0.000000

Specifications subject to change without notice. Machines shown with optional equipment. Product appearance may differ. Not responsible for typographical errors.

AUTOMATE YOUR TURNING CENTER PRODUCTION

CL-1 BAR FEEDER

Boost throughput and automate small-parts production on your CL-1 Chucker Lathe with our fully integrated pneumatic bar feeder. The CL-1 Bar Feeder automatically loads 0.25" to 1" diameter bars, and is available in two sizes to handle either 40"- or 72"-long bars for extended production runs and unattended operation.

- Easy-to-use interface in the Haas control
- Simple bar loading procedure
- Available to handle either 40" or 72" bars
- Fully integrated automation solution

Note: Spindle speed is limited to 3000 rpm when using the bar feeder.



WE ARE INDUSTRY 4.0 READY

TECHNOLOGY FOCUS: MAKE THE CONNECTION WITH HAASCONNECT

The Haas Control has the ability to send you, and others you designate, email notifications about the operating status of your Haas machine. Set up is simple and easy through the MyHaas Portal and HaasCNC.com.



GET YOUR MACHINE STATUS NOTIFICATIONS ANYWHERE. ON ANY DEVICE.

Go to HaasCNC.com and click on MyHaas to get set up on HaasConnect.

Haas
F1 Team
OFFICIAL MACHINE TOOL



Haas Automation, Inc. | www.HaasCNC.com | 800-331-6746 | Made in U.S.A.

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