MORA INDUSTRIAL SOLUTIONS

Haas VF Mill Alarm Guide

Next Generation Control (NGC) · Serial [_____] · Page 1 of 5

SAMPLE · LEAD-TECH REVIEW REQUIRED

✓ DO NOW: your crew can fix it

CALL SERVICE: stop and call

FIRST 5 MINUTES

- ☐ **Record it.** Alarm #, text, tool. Photo the screen.
- ☐ **Find the first alarm** in history. 102 follows others.
- ☐ **Easy checks:** E-stops, doors, air, lube, coolant.
- ☐ **Fix the cause, then RESET once.** Finish any recovery before you resume.
- ☐ **Back again?** Stop resetting. Work its entry in order.
- ☐ **Log both outcomes** on page 5. Repeats get fixed for good.

SYSTEMS

Control · Air
Way lube · Axes
Spindle · Coolant
Tool changer

SERVICE LINE

[YOUR SERVICE PHONE]

Scan for this guide on any phone at the machine.

Reviewed by _____

Date _____

ALARMS 1–5 OF 15

Every check is done from outside the cabinet.

102 SERVOS TURNED OFF

Usually follows an E-stop or another alarm.

Control

DO NOW
Open the alarm history.
Fix the alarm that came first.
Press RESET to restore servos.

CALL SERVICE IF
It's the only alarm in history and it keeps returning.

107 EMERGENCY STOP

An E-stop button was pressed.

Control

DO NOW
Release every E-stop button.
Check the remote jog handle too.
Press RESET.

CALL SERVICE IF
It stays active with every E-stop released.

120 LOW AIR PRESSURE OR FLOW

Air supply is below the minimum.

Air

DO NOW
Read the air gauge mid-cycle.
Check compressor, regulator, line.
Check the filter: clean, dry air.

CALL SERVICE IF
The gauge reads normal and it returns. The sensor may be misreading.

121/2075 LOW OIL · LUBE RESERVOIR EMPTY

Axis lube is low or not building pressure.

Way lube

DO NOW
Fill with Haas-specified oil.
Run the axis lube test (F2).
Look for leaking fittings.

CALL SERVICE IF
The level is good and it returns: filter, line, pump or switch.

1.103 AXIS SERVO ERROR TOO LARGE · also 2.103, 3.103

The axis fell behind its commanded position.

Axes

DO NOW
Ask what happened just before.
Jog slowly; listen for roughness.
On zero return? Clean home sensor.

CALL SERVICE IF
It returns after a crash, or the axis runs rough or noisy.

Follow your shop's safety and lockout/tagout rules. This guide doesn't replace them or the Haas manual. Alarm text can vary by software version; go by your screen.

Haas VF Mill Alarm Guide · Axes and Spindle

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BEFORE YOU CALL

Have ready: the alarm #, a photo of the screen, what changed, and what you already checked.

SERVICE LINE

[YOUR SERVICE PHONE]

ALARMS 6–10 OF 15 — Every check is done from outside the cabinet.

1.108 AXIS SERVO OVERLOAD · also 2.108, 3.108

The axis motor is working too hard. — Axes

DO NOW
Check the tool for wear.
Back off feeds and speeds.
Clear anything blocking travel.

CALL SERVICE IF
It happens with a sharp tool and normal feeds.

145–147 AXIS LIMIT SWITCH

A limit sensor isn't reading correctly. — Axes

DO NOW
Wipe chips off the sensor face.
Check its M12 plug is tight.

CALL SERVICE IF
The cable is damaged, or it returns with a clean sensor.

4.116 SPINDLE ORIENTATION FAULT

Spindle didn't stop in tool-change position. — Spindle

DO NOW
In E-stop, turn the spindle by hand.
Note if it hit during a tool change.
RESET; watch one tool change.

CALL SERVICE IF
It repeats. The likely causes are inside the cabinet.

123 SPINDLE DRIVE FAULT · often with 236

The spindle drive shut down on a fault. — Spindle

DO NOW
Note spindle load and the cut.
Lighten an aggressive cut.
Look for the spindle fan icon.

CALL SERVICE IF
It repeats on a light cut. The causes are inside the cabinet.

966 EXCESSIVE PART/TOOL IMBALANCE

Vibration from an unbalanced tool or part. — Spindle

DO NOW
Indicate runout: 0.0003 in. max.
Reseat or swap the holder.
Clamp the part tight.

CALL SERVICE IF
Chatter continues with good tools. Ask for a vibration analysis.

Follow your shop's safety and lockout/tagout rules. This guide doesn't replace them or the Haas manual.

Haas VF Mill Alarm Guide · Tool Changer and Coolant

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WHICH CHANGER?

Umbrella (carousel on the side of the head): 115 applies.
Side-mount (arm swaps tools): 626 applies.

SERVICE LINE

[YOUR SERVICE PHONE]

ALARMS 11–15 OF 15

Every check is done from outside the cabinet.

9941 CRASH DETECTED · software 100.21 and later

The head's accelerometer sensed a crash.

Spindle

DO NOW
Don't restart blind.
Inspect tool, holder, part, fixture.
Check moves and offsets in graphics.

CALL SERVICE IF
Servo alarms or rough axis motion follow the crash. Have the ballscrew couplings checked.

115 CAROUSEL POSITION FAULT · umbrella changer

The carousel didn't reach position in time.

Tool changer

DO NOW
Clear chips jamming rotation.
Press RECOVER; follow the screen.

CALL SERVICE IF
Recovery fails, or it repeats with no jam: motor, sensor or relay.

626 TOOL CHANGER FAULT · side-mount changer

Tool pocket out of position or didn't move.

Tool changer

DO NOW
Run tool change recovery.
Check the shop air supply.
Clear the slide; wipe pocket sensors.

CALL SERVICE IF
The air cylinder sticks, or the pocket, slide or follower is loose or damaged.

143 SPINDLE ROTATED DURING A TOOL CHANGE

The spindle turned as the changer engaged.

Tool changer

DO NOW
Watch one tool change closely.
Note any recent noisy changes.

CALL SERVICE IF
It repeats: alignment or orientation needs resetting.

151 LOW THROUGH SPINDLE COOLANT

TSC pressure is too low.

Coolant

DO NOW
Check coolant level and TSC filter.
RESET, restart TSC, watch I/O page.
Gauge stuck at 0? Suspect sensor.

CALL SERVICE IF
Pressure stays low: pump, check valve or sensor.

Follow your shop's safety and lockout/tagout rules. This guide doesn't replace them or the Haas manual.

Preventive Maintenance Checklist

Each task is tagged with the alarm it heads off. Intervals follow Haas's VMC Maintenance Schedule; the daily list follows the VF operator's manual. Skip lines for options this machine doesn't have.

DAILY · START OF SHIFT · WEEK OF _____	M	T	W	T	F	HEADS OFF
Check the coolant level.	☐	☐	☐	☐	☐	151
Check the way lube tank level.	☐	☐	☐	☐	☐	121/2075
Clear chips from the way covers and bottom pan.	☐	☐	☐	☐	☐	145–147
Clear chips from the tool changer.	☐	☐	☐	☐	☐	115 · 626
Wipe the spindle taper; apply light oil.	☐	☐	☐	☐	☐	966
Check the windows; test the door interlock.	☐	☐	☐	☐	☐	Safety

WEEKLY	HEADS OFF
☐ Check the spindle air regulator pressure.	120
☐ Check the auto drain on the air filter-regulator.	120
☐ Check the TSC filter; clean or replace it.	151
☐ Check coolant concentration; log it.	

MONTHLY · DATE _____	HEADS OFF
☐ Check the way lube reservoir; refill.	121/2075
☐ Inspect tool changer motors and sensors.	115 · 626
☐ Clean the vector drive air vents / filter.	123
☐ Inspect the way covers; lubricate.	
☐ Check the counterbalance pressure.	
☐ Gearbox oil and spindle lube levels (if equipped).	

EVERY 6 MONTHS · DATE _____	HEADS OFF
☐ Run the axis lube test (Diagnostics › Maintenance › Lube).	2075
☐ Inspect air and lube hoses for cracks.	120 · 121
☐ Clean the TSC pump filter; check auto clean.	151
☐ Clean the tank, replace coolant, clean the filter.	151
☐ Run the spindle lube test (if equipped).	

ANNUALLY · DATE _____	HEADS OFF
☐ Measure spindle drawbar force.	
☐ Clean the air purge solenoid.	
☐ Replace gearbox oil (if equipped).	
☐ Side-mount changer: grease the cams; replace worn pocket springs and plungers.	626

AS REQUIRED	HEADS OFF
☐ Clean the coolant filter screen.	151
☐ Grease the pull studs.	

Follow your shop's safety and lockout/tagout rules for any task inside the guards. This checklist doesn't replace the Haas manual.

Reviewed by _____ Date _____

Critical Spares and Alarm Log

KEEP ON THE SHELF

A part on the shelf turns a wait into a swap.

ITEM	HEADS OFF	KEEP	HAAS PART #	LEAD TIME
Way lube oil, Haas-specified	121/2075	1 refill	[P/N]	[__ days]
Lube line fittings	121	1 set	[P/N]	[__ days]
Air filter-regulator element	120	1	[P/N]	[__ days]
TSC filter element	151	2	[P/N]	[__ days]
Axis home/limit proximity sensor (M12)	145–147	1	[P/N]	[__ days]
Tool pocket up/down sensor (side-mount)	626	1	[P/N]	[__ days]
Spindle taper wiper	966	1	[P/N]	[__ days]

Quantities are a starting point; adjust them with your lead tech. Part numbers and lead times depend on your serial number, so we fill them in with your Haas dealer during setup.

ALARM LOG

Log both outcomes. Repeats get fixed for good.

DATE	ALARM #	WHAT YOU FOUND	WHAT YOU DID	RESULT	BY
				☐ Fixed ☐ Called	
				☐ Fixed ☐ Called	
				☐ Fixed ☐ Called	
				☐ Fixed ☐ Called	
				☐ Fixed ☐ Called	
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