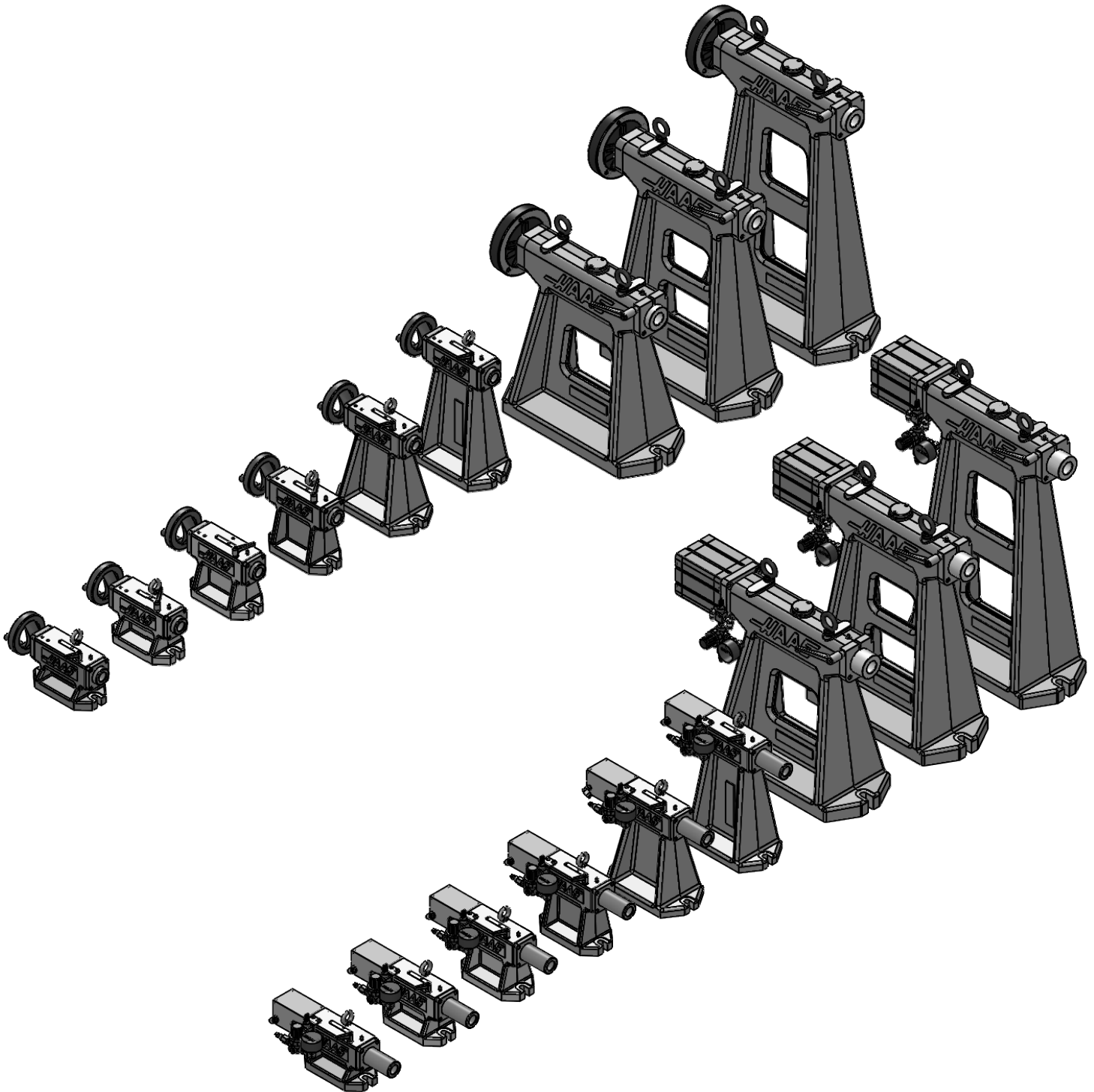
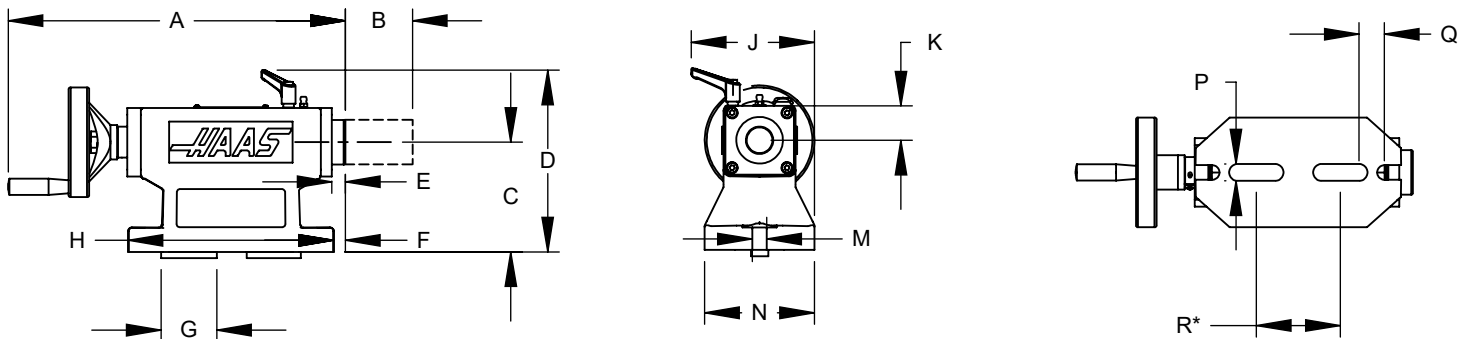


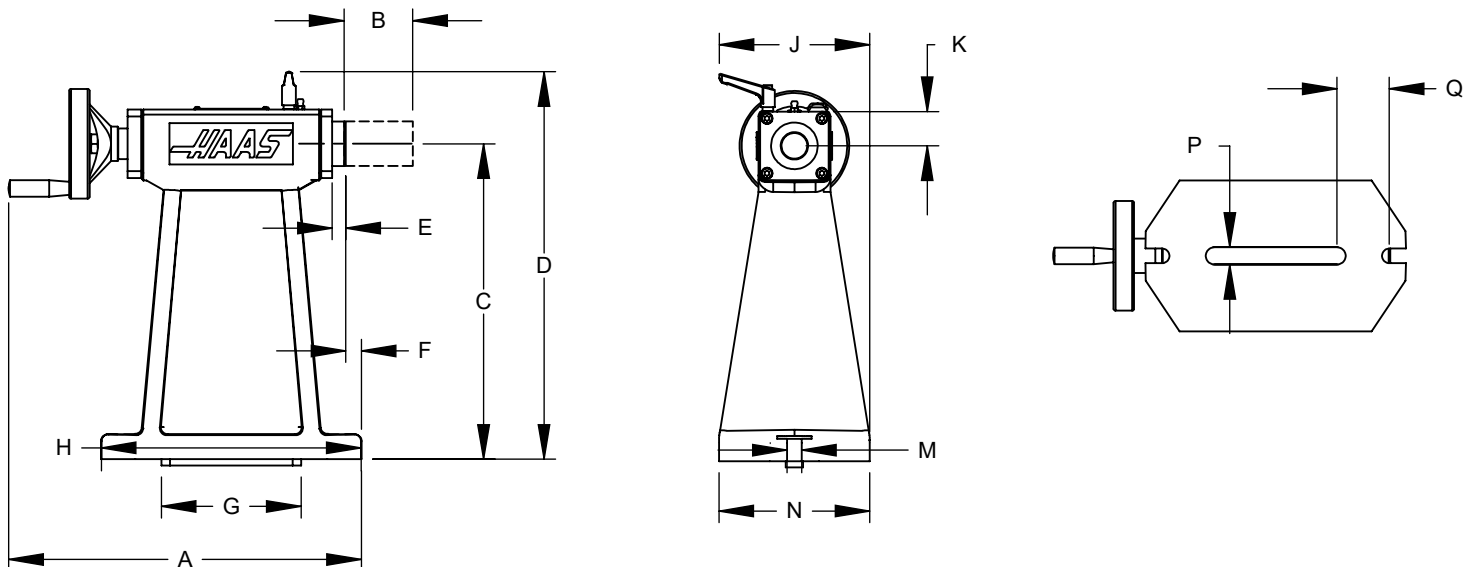
Haas Automation Tailstock Schematics

HTS Manual Series & HPTS Pneumatic Series

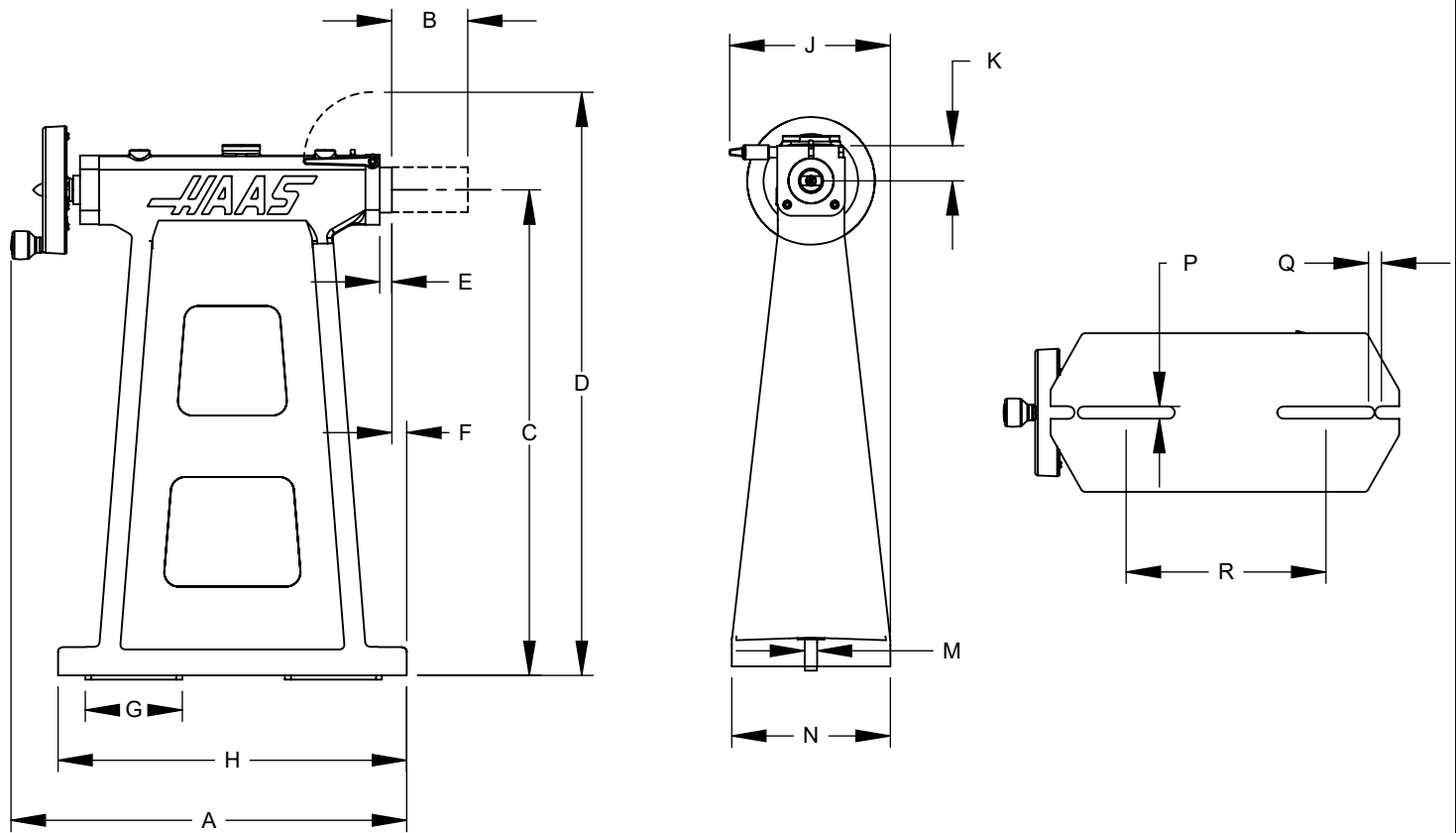


Small HTS Series generic representation

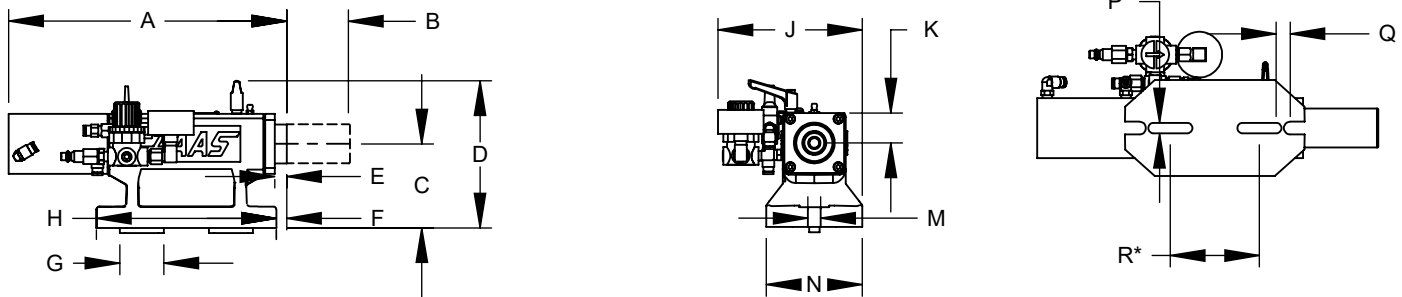
*Dimension R only applies to Tailstocks with 2 locating pins

Medium HTS Series generic representation

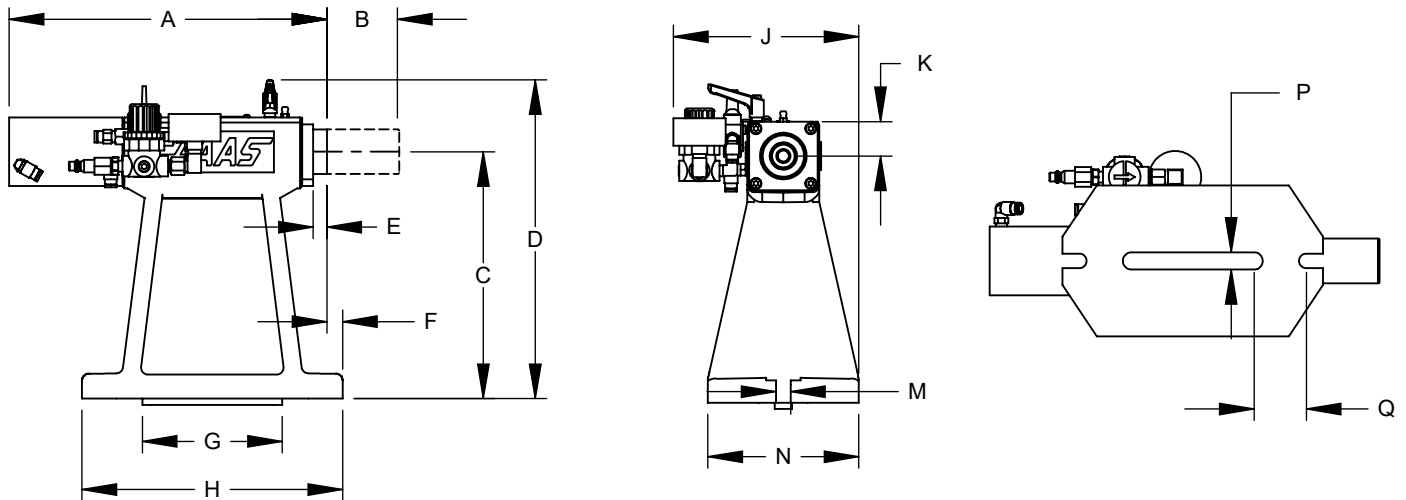
Letter	Description	HTS3.5		HTS4		HTS5		HTS6		HTS9	
		SAE	Metric	SAE	Metric	SAE	Metric	SAE	Metric	SAE	Metric
A	Minimum OAL	12.3in	312mm	12.3in	312mm	12.3in	312mm	12.3in	312mm	12.875in	327mm
B	Nose Stroke / max extension	2.50in	63.5mm	2.50in	63.5mm	2.50in	63.5mm	2.50in	63.5mm	2.50in	63.5mm
C	∅ Height	3.500in	88.90mm	4.000in	101.60mm	5.000in	127.0mm	6.000in	152.40mm	9.000in	228.60mm
D	Maximum Height	6.13in	155mm	6.62in	168mm	7.625in	193.7mm	8.625in	219mm	11.625in	295mm
E	Nose to nose plate, Minimum	.495in	12.6mm	.495in	12.6mm	.495in	12.6mm	.495in	12.6mm	.495in	12.6mm
F	Front of base to nose (minimum)	.43in	10.9mm	.43in	10.9mm	.43in	10.9mm	.43in	10.9mm	.575in	14.6mm
G	Overall Length of locating pin(s)	1.837in	46.7mm	5.10in	129.5mm	5.10in	129.5mm	5.10in	129.5mm	5.10in	129.5mm
H	Base OAL	7.5in	190.5mm	7.5in	190.5mm	7.5in	190.5mm	7.5in	190.5mm	9.5in	241mm
J	Max Overall width	4.75in	120.5mm	4.75in	120.5mm	4.75in	120.5mm	4.75in	120.5mm	5.50in	140mm
K	Top of body to ∅	1.25in	31.8mm	1.25in	31.8mm	1.25in	31.8mm	1.25in	31.8mm	1.25in	31.8mm
M	Bolt Slot Width	.53in	13.4mm	.53in	13.4mm	.53in	13.4mm	.53in	13.4mm	.53in	13.4mm
N	Max base width	4.00in	101.6mm	4.00in	101.6mm	4.00in	101.6mm	4.00in	101.6mm	5.50in	140mm
P	Width or ∅ of locating pin(s)	.437 (2x)	11.10mm (2x)	.629in	15.98mm	.629in	15.98mm	.629in	15.98mm	.629in	15.98mm
Q	Alignment pin ∅ to bolt slot ∅	.584in	14.8mm	.905in	23mm	.905in	23mm	.905in	23mm	1.905in	48.4mm
R	Alignment pins ∅ to ∅	3.712in	94.3mm	(Single locating pin)		(Single locating pin)		(Single locating pin)		(Single locating pin)	
	Reference Drawing	Small		Small		Small		Small		Medium	

Large HTS Series generic representation

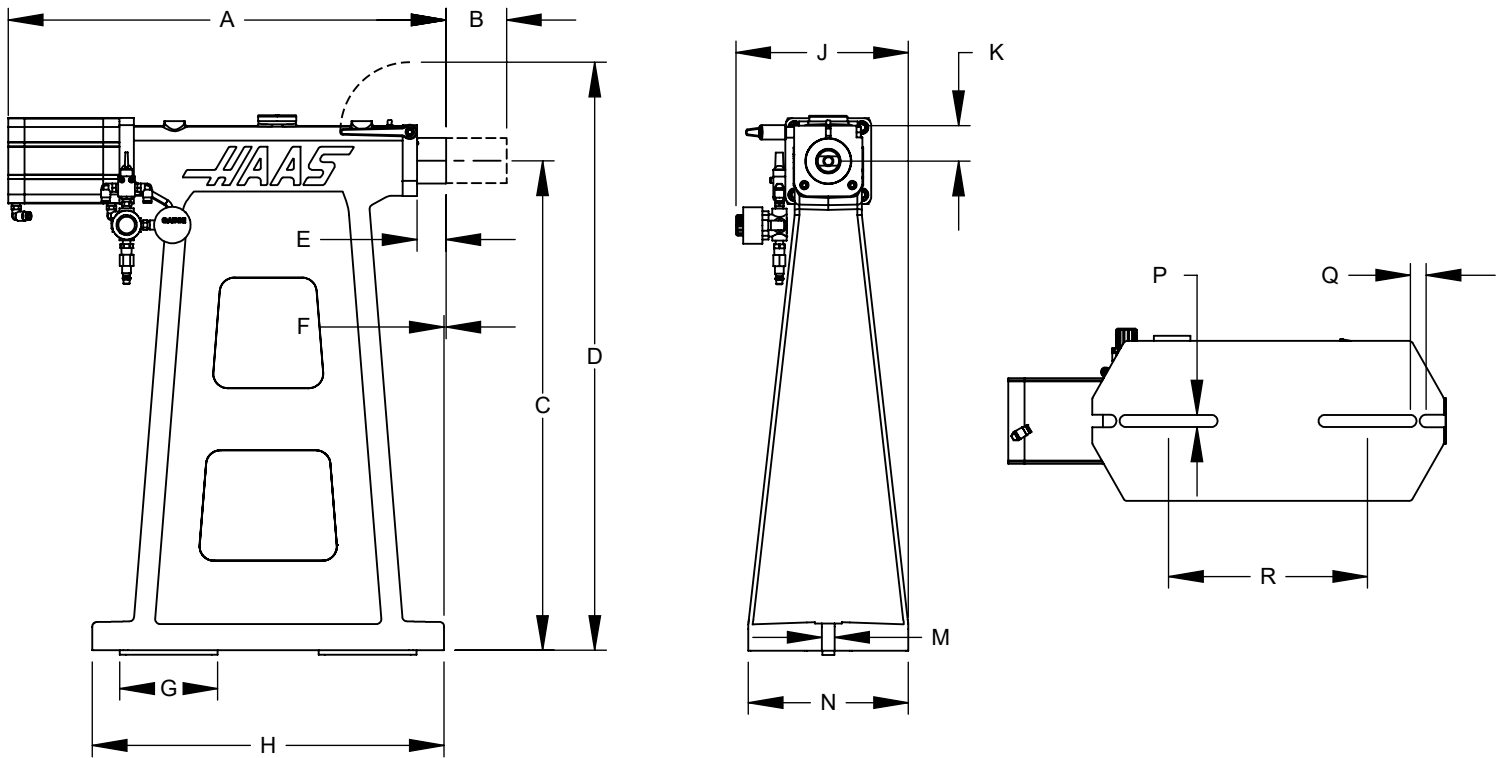
Letter	Description	HTS11.5		HTS16		HTS20.5		HTS25.5	
		SAE	Metric	SAE	Metric	SAE	Metric	SAE	Metric
A	Minimum OAL	12.875in	327mm	20.9in	530mm	20.9in	530mm	20.9in	530mm
B	Nose Stroke / max extension	2.50in	63.5mm	4.25in	108mm	4.25in	108mm	4.25in	108mm
C	∅ Height	11.500in	292.10mm	16.000in	406.40mm	20.500in	520.70mm	25.500in	647.70mm
D	Maximum Height	14.125in	359mm	21.125in	528mm	25.625in	528mm	30.625in	778mm
E	Nose to nose plate, Minimum	.495in	12.6mm	1.5in	38.1mm	1.5in	38.1mm	1.5in	38.1mm
F	Front of base to nose (minimum)	.575in	14.6mm	.09in	2.3mm	.09in	2.3mm	.09in	2.3mm
G	Overall Length of locating pin(s)	5.10in	129.5mm	5.10in (2x)	129.5mm (2x)	5.10in (2x)	129.5mm (2x)	5.10in (2x)	129.5mm (2x)
H	Base OAL	9.5in	241mm	18.32in	465mm	18.32in	465mm	18.32in	465mm
J	Max Overall width	5.50in	140mm	8.45in	214mm	8.45in	214mm	8.45in	214mm
K	Top of body to ∅	1.25in	31.8mm	1.85in	47mm	1.85in	47mm	1.85in	47mm
M	Bolt Slot Width	.53in	13.4mm	.66in	16.75mm	.66in	16.75mm	.66in	16.75mm
N	Max base width	5.50in	140mm	8.335in	212mm	8.335in	212mm	8.335in	212mm
P	Width or ∅ of locating pin(s)	.629in	15.98mm	.629in (2x)	15.98mm (2x)	.629in (2x)	15.98mm (2x)	.629in (2x)	15.98mm (2x)
Q	Alignment pin ∅ to bolt slot ∅	1.905in	48.4mm	.815in	20.7mm	.815in	20.7mm	.815in	20.7mm
R	Alignment pins ∅ to ∅	(Single locating pin)		10.36in	263mm	10.36in	263mm	10.36in	263mm
	Reference Drawing	Medium		Large		Large		Large	

Small HPTS Series generic representation

* Dimension R only applies to models with 2 locating pins

Medium HPTS Series generic representation

Letter	Description	HPTS3.5		HPTS4		HPTS5		HPTS6		HPTS9	
		SAE	Metric	SAE	Metric	SAE	Metric	SAE	Metric	SAE	Metric
A	Minimum OAL	11.6in	295mm	11.6in	295mm	11.6in	295mm	11.6in	295mm	12.2in	310mm
B	Nose Stroke / max extension	2.50in	63.5mm	2.50in	63.5mm	2.50in	63.5mm	2.50in	63.5mm	2.50in	63.5mm
C	∅ Height	3.500in	88.90mm	4.000in	101.60mm	5.000in	127.0mm	6.000in	152.40mm	9.000in	228.60mm
D	Maximum Height	6.13in	155mm	6.62in	168mm	7.625in	193.7mm	8.625in	219mm	11.625in	295mm
E	Nose to nose plate, Minimum	.495in	12.6mm	.495in	12.6mm	.495in	12.6mm	.495in	12.6mm	.495in	12.6mm
F	Front of base to nose (minimum)	.43in	10.9mm	.43in	10.9mm	.43in	10.9mm	.43in	10.9mm	.575in	14.6mm
G	Overall Length of locating pin(s)	1.837in	46.7mm	5.10in	129.5mm	5.10in	129.5mm	5.10in	129.5mm	5.10in	129.5mm
H	Base OAL	7.5in	190.5mm	7.5in	190.5mm	7.5in	190.5mm	7.5in	190.5mm	9.5in	241mm
J	Max Overall width	6.05in	154mm	6.05in	154mm	6.05in	154mm	6.05in	154mm	6.8in	173mm
K	Top of body to ∅	1.25in	31.8mm	1.25in	31.8mm	1.25in	31.8mm	1.25in	31.8mm	1.25in	31.8mm
M	Bolt Slot Width	.53in	13.4mm	.53in	13.4mm	.53in	13.4mm	.53in	13.4mm	.53in	13.4mm
N	Max base width	4.00in	101.6mm	4.00in	101.6mm	4.00in	101.6mm	4.00in	101.6mm	5.50in	140mm
P	Width or ∅ of locating pin(s)	.437 (2x)	11.10mm (2x)	.629in	15.98mm	.629in	15.98mm	.629in	15.98mm	.629in	15.98mm
Q	Alignment pin ∅ to bolt slot ∅	.584in	14.8mm	.905in	23mm	.905in	23mm	.905in	23mm	1.905in	48.4mm
R	Alignment pins ∅ to ∅	3.712in	94.3mm	(Single locating pin)		(Single locating pin)		(Single locating pin)		(Single locating pin)	
	Reference Drawing	Small		Small		Small		Small		Medium	

Large HTS Series generic representation

Letter	Description	HPTS11.5		HPTS16		HPTS20.5		HPTS25.5	
		SAE	Metric	SAE	Metric	SAE	Metric	SAE	Metric
A	Minimum OAL	12.2in	310mm	22.8in	580mm	22.8in	580mm	22.8in	580mm
B	Nose Stroke / max extension	2.50in	63.5mm	3.15in	80mm	3.15in	80mm	3.15in	80mm
C	∅ Height	11.500in	292.10mm	16.000in	406.40mm	20.500in	520.70mm	25.500in	647.70mm
D	Maximum Height	14.125in	359mm	21.125in	528mm	25.625in	528mm	30.625in	778mm
E	Nose to nose plate, Minimum	.495in	12.6mm	1.5in	38.1mm	1.5in	38.1mm	1.5in	38.1mm
F	Front of base to nose (minimum)	.575in	14.6mm	.1in	2.5mm	.1in	2.5mm	.1in	2.5mm
G	Overall Length of locating pin(s)	5.10in	129.5mm	5.10in (2x)	129.5mm (2x)	5.10in (2x)	129.5mm (2x)	5.10in (2x)	129.5mm (2x)
H	Base OAL	9.5in	241mm	18.32in	465mm	18.32in	465mm	18.32in	465mm
J	Max Overall width	6.8in	173mm	9.0in	229mm	9.0in	229mm	9.0in	229mm
K	Top of body to ∅	1.25in	31.8mm	1.85in	47mm	1.85in	47mm	1.85in	47mm
M	Bolt Slot Width	.53in	13.4mm	.66in	16.75mm	.66in	16.75mm	.66in	16.75mm
N	Max base width	5.50in	140mm	8.335in	212mm	8.335in	212mm	8.335in	212mm
P	Width or ∅ of locating pin(s)	.629in	15.98mm	.629in (2x)	15.98mm (2x)	.629in (2x)	15.98mm (2x)	.629in (2x)	15.98mm (2x)
Q	Alignment pin ∅ to bolt slot ∅	1.905in	48.4mm	.815in	20.7mm	.815in	20.7mm	.815in	20.7mm
R	Alignment pins ∅ to ∅	(Single locating pin)		10.36in	263mm	10.36in	263mm	10.36in	263mm
	Reference Drawing	Medium		Large		Large		Large	