

New concept of CNC system

- Siemens 810D is a innovative concept of knowledge-based CNC system which has capability of various machine applications for the next generation of technical environment.



Siemens 810D Specifications

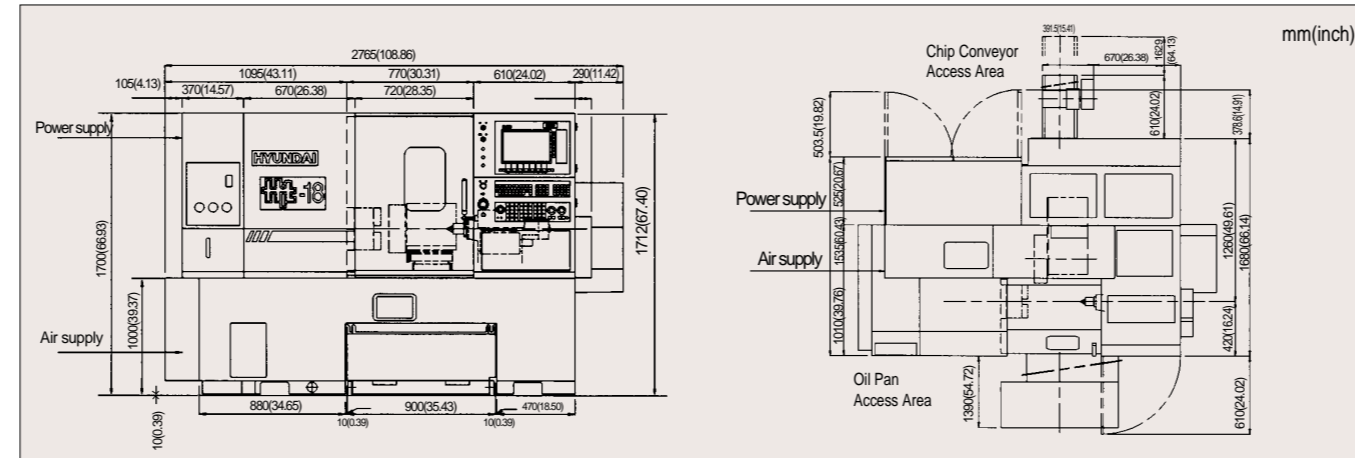
Function	Item	Specifications
Control	Controlled axis	5 axes (Max.)
	Simultaneously controlled axes	4 axes (Max.)
Interpolation	Linear, circular, and helical interpolation	
Movement	Feedrate override	0 - 120 %
	Velocity command	digital
	Automatic acceleration / deceleration are provided	
	Rapid traverse override	FO, 10,50,100% override cancel
Tool management	Tool function	5 - digit
	Length and wear compensation Nose radius compensation	
Compensation	Back-lash & pitch error compensation	
Display	10.4" TFT LCD	
Spindle	Spindle override	50 - 120%
	Spindle orientation Constant surface speed control	
Manual operation	Manual handwheel feed MDI and JOG operating Manual repositioning Home position return	1-st home return
	Spindle control	running stop reverse rotation
	Automatic operation	Automatic machining Automatic acceleration and deceleration NC reset Single block Feed hold Optional block skip Machine lock Dry run Automatic home return Restart operation
	Diagnosis	Alarm display Memory protected
Programming	Programming capacity	part program storage length: 200MB (HDD) 256KB (NC)
		Thread(constant pitch), multiple thread Scaling Inch / metric conversion Absolute / incremental programming Dialog programming(D-PRO) EIA / ISO programming Tool path display Variable program(Macro) Simulation Back ground edit
Safety functions	Emergency stop Over travel (Soft Limit) Stored stroke check Work limitation Contour monitoring Program protect	
Support Automation	Actual speed display Tool life management Workpiece count	
Multitask	Back ground editing	
PLC	No. of DI / DO	total 768, Op. Panel(IN:64, OUT:48)
	User memory	64 kBytes (max. 128KB)
	Programming language	STL
Data transfer	RS232C(V.24) Serial interface	
	2-nd RS232C(V.24) Serial interface	

Special Features
3.5" (1.44MB) Diskette

The Advantage of Siemens 810D

- Perfect digital control system**
Control accuracy is 10 times better than old analogue type. Small, light, and high-reliable structure and noise-free. Monitoring the state of feed and spindle axis. Compensation of errors (back-lash and pitch error, friction compensation).
- Energy saving**
The in-feed and regenerative feed back system results in reducing more than 30% of energy and in avoiding the temperature rising on the power cabinet, compare to old inverter.
- PC-embedded CNC**
PC-embedded CNC system for the next generation. Faster transfer the data and part program by multi-processor system. PC-embedded CNC makes management of the processing and scheduling possible. Hard memory: 200 MBytes (min.)
- Intelligence control and interpolation**
Applying the most advanced functions of look-ahead, jerk limit, and frame, which are not available on the other controller
- Simple and high-level programming**
High-level G-code programming. Perfect graphical Dialog Programming is available(D-PRO).
- Tele-diagnosis (Option)**
It is possible to diagnose and fix the machine problems by the direct electrical connections between A/S center and each machine tool in user site.
- Compact and modular structure**
Lower troubles on the controller because of compact and modular structure.

Machine Dimensions and Required Floor Space



Machine Specifications

	Item	Unit	Specification	
			HIT-15	HIT-18
Capacity	Max. swing	mm (inch)	ø440 (17.32)	ø440 (17.32)
	Max. cutting (diaXlength)	mm (inch)	ø254x500 (10.6x19.69)	ø254x500 (10.0x19.69)
	Max. bar work size	mm (inch)	ø51 (2")	ø70 (2.76")
Spindle	Spindle speed	rpm	Max. 4500	Max. 3600
	Spindle nose	-	A2-6	A2-8
	Spindle drive motor(30min./ continuous)	kW(HP)	15 (20) / 11 (15)	15 (20) / 11 (15)
Travel	Spindle bore	mm (inch)	ø62 (2.44)	ø80 (3.15)
	Travel(X/ Z)	mm (inch)	180/ 510 (7.09/20.08)	180/ 510 (7.09/20.08)
Turret	Rapid traverse(X/ Z)	m/min (ipm)	30/ 30 (1181/ 1181)	30/ 30 (1181/ 1181)
	Turret type		8D 8P	8D 8P
Tailstock	Tool capacity	ea	8	8
	Turret index time (one/ full step)	sec	0.48/ 0.85	0.48/ 0.85
	Diameter of tailstock sleeve	mm (inch)	ø80 (3.15)	ø80 (3.15)
Machine size	Stroke of tailstock sleeve	mm (inch)	130 (5.12)	130 (5.12)
	Taper type		MT # 4	MT # 4
	Stroke of tailstock body	mm (inch)	460 (18.11)	460 (18.11)
Machine size	Bed type	mm (inch)	Flat	Flat
	Floor space (LXW)	mm (inch)	2765 (108.86)X1680(66.14)	
	Machine height	mm (inch)	1712 (67.4)	1712 (67.4)
	Electrical power supply	kVA	34	34.6
	Machine weight	kg (lbs)	4200 (9260)	4300 (9480)

Standard Equipments

- Worklight
- Coolant system
- Chip and coolant splash guarding
- 8" through hole chuck [HIT-15]
- 10" through hole chuck [HIT-18]
- One (1) set of adjusting tool
- Manuals
- Chuck foot switch (Single)
- Door interlock
- Automatic chuck jaw open/ close

Optional Equipments

- Chip conveyor (rear/ side disposal)
- chip bucket
- Automatic front door open/ close (by M - code)
- Chuck jaw open/ close confirmation
- Chuck air blast
- Auto parts catcher
- Patrol light (3 colors)
- Operational end buzzer
- 12 Position drum turret [HIT-15]
- Powerful coolant (750w)
- Chuck foot switch (Double)
- Automatic tool setter
- Automatic tailstock with live center



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