

**F**

# 750B/960B

The Machining Center for Large Work Spaces and Heavy Duty Cutting

HYUNDAI WIA Vertical Machining Center

# Technical Leader

The Vertical Machining Center F750B/F960B, designed by Hyundai WIA with years of expertise and the latest technology, is a heavy duty cutting machine with high precision and productivity.

		F750B	F960B
Table Size (L×W)	mm(in)	1,800x700 (70.9"×27.6")	2,700x950 (106.3"×37.4")
Max. Load Capacity	kg(lb)	2,000 (4,409)	4,500 (9,921)
Spindle Taper	-	BBT50	BBT50
Spindle Speed	r/min	4,500 [8,000] [12,000] [4,500] [8,000]	8,000 [12,000] [8,000]
Sp. Power (Max.)	kW(HP)	18.5 (25) [18.5 (25)] [30 (40)] [30 (40)] [30 (40)]	22 (30) [30 (40)] [27.8 (37)]
No. of Tools	EA	20 [30]	20 [30, 40]
Travel (X/Y/Z)	mm(in)	1,550/750/720 (61"/29.5"/28.3")	2,450/960/850 (96.5"/37.8"/33.5")
Rapid Traverse Rate	m/min	16/16/12	16/16/20

[ ] : Option • HYUNDAI-iTROL

# F

## 750B/960B

Vertical Machining Center for Heavy Duty Cutting

- Main spindle with ultra precision cylindrical roller bearings
- Rigid geared spindle enables powerful, heavy duty cutting
- Box guideways on all axes for superb heavy duty cutting
- 4 Guideways employ 10-face contact design (F960B)
- Air Semi-Rising slideway to decrease feed load
- HYUNDAI-iTROL installation for variety of processing softwares



# 01 BASIC STRUCTURE

Excellent Heavy Duty Cutting Capability & Productivity Vertical Machining Center

### ATC & Magazine

- No. of Tools  
F750B : 20 [30] EA  
F960B : 20 [30, 40] EA
- Tool Shank : BBT50

### High Precision Spindle

- Gear Driven Spindle  
F750B : 4,500 [8,000] rpm  
F960B : 8,000 rpm
- Built-in Spindle  
[12,000 rpm]



F960B

F750B

### Table

Model	Size (X/Y) / Max. Load Capa.
F750B	1,800×700 mm / 2,000 kg (70.9"×27.6" / 4,409 lb)
F960B	2,700×950 mm / 4,500 kg (106.3"×37.4" / 9,921 lb)

# HEAVY DUTY CUTTING & LARGE WORKING AREA

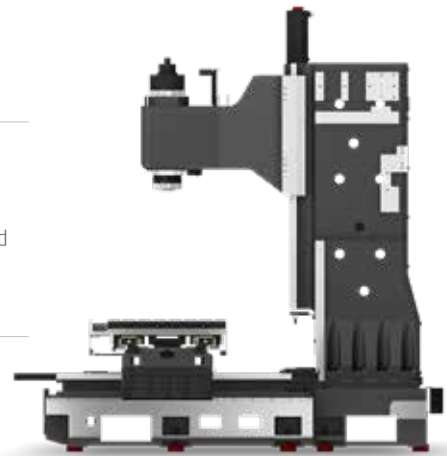
## HIGH-PRECISION STRUCTURE

### Optimal Structural Analysis

F750B/960B is designed to have optimal structure through Hyundai WIA's unique structural analysis. In particular, enhancement of bed and column's rigidity makes excellent performance even in heavy duty cutting.

### One Piece High Column

One piece high column is provided as an option up to z-axis height. This option helps to process bigger products such as rack housing.



F750B/960B  
Vertical Machining Center

04  
+  
05

## GUIDE WAY

### All Axes Box Guideway

Box guideways effectively offset vibration enabling the machining of high precision products. The travel load is spread evenly on the surface of guideways. This enhances stability and rigidity allowing high performance heavy duty cutting.



### Air Semi-Rising Slideway

By applying the air semi-rising slideways, the load on the X/Z-axis slideway is decreased. Therefore, positioning and repeatability accuracy can be maintained for a long time.

### 10-face Contact Y-axis Slideway (F960B)

The table is supported at all times by 10-face contact box guideways. This allows for a maximum table load of 4,500 kg (9,921 lb) without any distortion in the table.

EXPERIENCE  
THE NEW TECHNOLOGY

### Travel (X/Y/Z)

F750B

1,550/750/720 mm (61"/29.5"/28.3")

F960B

2,450/960/850 mm (96.5"/37.8"/33.5")



# 02 HIGH PRECISION SPINDLE

Excellent machining performance with high-precision spindle

## Spindle Specifications

[ ] : Option

Model	Speed r/min	Motor (Max./Cont.)	Torque (Max./Cont.)	Type
F750B	4,500 rpm (FAPIUC)	18.5/15 kW (25/20 HP)	893/732 N·m (658.6/539.9 lbf·ft)	2 Step Gear
	[8,000 rpm (FAPIUC)]	[18.5/15 kW (25/20 HP)]	[657/532 N·m (464.6/392.4 lbf·ft)]	
	[4,500 rpm (iTROL)]	[30/20 kW (40/27 HP)]	[1,449/966 N·m (1,068.7/712.5 lbf·ft)]	
	[8,000 rpm (iTROL)]	[30/20 kW (40/27 HP)]	[1,058/704 N·m (780.3/519.2 lbf·ft)]	
	[12,000 rpm (FAPIUC)]	[30/25 kW (40/33.5 HP)]	[420/238 N·m (309.8/175.5 lbf·ft)]	Built-in
F960B	8,000 rpm (FAPIUC)	22/18.5 kW (30/25 HP)	776/657 N·m (572.3/484.6 lbf·ft)	2 Step Gear
	[8,000 rpm (iTROL)]	[27.8/18.5 kW (37/25 HP)]	[1,316/877 N·m (970.6/646.8 lbf·ft)]	
	[12,000 rpm (FAPIUC)]	[30/25 kW (40/33.5 HP)]	[420/238 N·m (309.8/175.5 lbf·ft)]	Built-in

# HIGH-PERFORMANCE, HIGH-PRECISION SPINDLE

## SPINDLE

### 2 Step Gear Type Spindle

The spindle is designed with cylindrical roller bearings, a thicker spindle nose and an enlarged flange diameter. Also, improved powerful clamping force allows enhanced machining ability.

2 Step Gear Type Spindle provides powerful torque at low speed and stable rotation at high speed, enabling a wide range of machining.



2 Step Gear

### Built-in Spindle

The 12,000rpm built-in spindle can minimize vibration transmitted to the spindle. It allows excellent machining performance in mold and high-precision products.



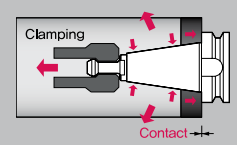
Built-in

### Spindle Cooling

The spindle cooling system minimizes thermal displacement which can happen during lengthy machining operations, and offers continued accuracy based on the thermal stability.

### Dual Contact Spindle

The Big Plus spindle system (BBT50) provides dual contact between the spindle face and the flange face of the tool holder.



- ❖ The increase in standard diameter improves rigidity and ATC repeatability, and Z-axis displacement prevention further extends tool life.

## THROUGH SPINDLE COOLANT OPTION

Through Spindle Coolant is exceedingly useful when drilling deep holes. It helps increase the lifetime of the tool, while decreasing cycle time.



20 bar / 30 bar / 70 bar



F750B/960B

# 03 ATC & TABLE

High Productivity Achieved with High Rigidity, Accuracy Machining

No. of Tools

F750B : 20 [30] <sub>EA</sub>

F960B : 20 [30, 40] <sub>EA</sub>

Max. Tool Length

300 mm (11.8")

Max. Tool Weight

20 kg (44.1 lb)

Max. Tool Dia. (W.T/W.O)

Ø125/Ø240 mm (Ø4.9"/Ø9.4")

Tool Shank

BBT50

[ ] : Option



# HIGH RIGIDITY, TOOL CHANGE SYSTEM

## ATC & MAGAZINE

The tool magazine holds 20 tools as standard with 40 tools as option for F960B and 30 for F750B. Due to the wider selection of tools and the random tool selection method, tool change time has been improved.

The Double Arm ATC provides faster and reliable tool changing to help reduce machining cycle time.



20 Tool Magazine

30 Tool Magazine



## TABLE

Compared to competitive machines, the F750B/960B has a large working capacity to make setup easier and provide convenience to the operator.

Model	Size	Load Capacity
F750B	1,800×700 mm (70.9"×27.6")	2,000 kg (4,409 lb)
F960B	2,700×950 mm (106.3"×37.4")	4,500 kg (9,921 lb)

### NC Rotary Table **OPTION**

The NCRT makes it possible to machine up to 5-axis. Various types of products can be machined.

❖ When ordering a NC Rotary Table, prior consult with hyundai wia's sales person.



F750B/960B

# 04 MOLD PACKAGE

Powerful Mold Package, HYUNDAI-WIA Mold All in One

## MOLD PACKAGE

To enhance mold machining, the "HWM ALL-IN-ONE" is provided as an option feature for F750B/960B.

This ensures accurate and high quality surface finishing and contouring.



# HWM ALL-IN-ONE



- ❶ High Speed Contouring Control (AICC II)
- ❷ Development S/W  
HW-MCS (Selectable Process Conditions), HW-AFC (Adaptive Feed Control)
- ❸ Main Spindle Cooling Device (8-channel) – Maintain spindle temperature (heat sensor)
- ❹ Cutting Air Blow – Cutting air blow is provided for mold machining.
- ❺ Auto Tool Measuring Device – Detects and sets tool length, and attrition (Graphic User Interface included)

## Thermal Displacement Compensation Device

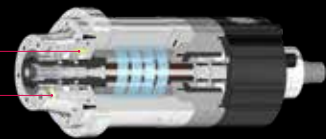
● Cooling system & Lubrication system

Thermal displacement of the spindle is minimized by the use of cooling techniques. This provides high accuracy when machining at high speed.

T.D.C With PT100 Sensor

**Interface**

T.D.C With Disp. Sensor



# MOLD PACKAGE OPTION

1 Package : Standard 2, 3, 4 Package : Option

HWM ALL IN ONE		1 Package	2 Package	3 Package	4 Package
AICC II Package	200 block	•	•		
	600 block			•	
	1,000 block				•
S/W : HW-MCS, HW-AFC		•	•	•	•
Auto Power Off		•	•	•	•
Spindle Heat Distortion Compensation Device		•	•	•	•
Cutting Air Blow		•	•	•	•
Auto Tool Measuring Device (TS27R)		•	•	•	•
Data Server 1GB			•	•	•



# 05 HYUNDAI WIA FANUC – SMART PLUS

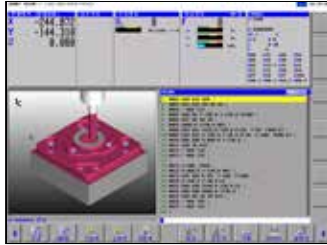
The Compatible All-round Control



**15" Touch-type Monitor as a standard**

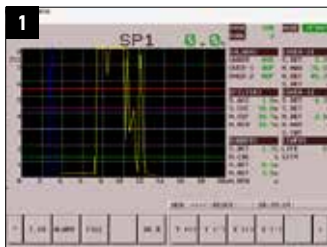
Smart Machine Control	Fast Cycle Time Technology
	Fine Surface Technology
Conversational Program	SmartGuide-i
i-HMI	Machining-aid Function
AI Contour Control	AICC-2 (200 blocks)
Smooth Tolerance Control	0.1µm command and specify tolerance
JERK Control	Diminished vibration by controlling acceleration speed
Machining Condition Selection	Designated machining level based on speed & quality
Machining Quality Control Function	Smooth Tolerance+ integrated support
Part Program Storage	5120M (2MB)
No. of Registerable Programs	1000 EA

# SMART SOFTWARE



## DIALOGUE PROGRAM (Smart Guide-i)

This software offers maximum user convenience through a dialogue program from setup to machining. This includes writing machining programs and simulation checks.



### High-quality Machining S/W

#### 1. Tool Monitoring (HW-TM) **OPTION**

This tool status monitoring software monitors and protects workpiece, tools, and equipment through real-time monitoring of the motor load from machining.

#### 2. Adaptive Feed Control (HW-AFC)

This software improves the lifetime and productivity of tools by automatically controlling the feed to maintain an even machining load.



#### 3. Thermal Displacement Compensation (HW-TDC) **OPTION**

This software improves machining precision by minimizing thermal deformation from changes in external environments and machining.

#### 4. Machining Condition Selection (HW-MCS)

This software automatically optimizes rapid transfer parameters for cutting transfers and workpiece weights depending on the machining type (based on rate/precision /quality)



### Machining Support S/W

#### 1. Machine Guidance (HW-MCG)

This software offers various user convenience functions such as tool manipulation, maintenance, tool monitoring, and a pop-up/status window

#### 2. Tool/Workpiece Measurement (Renishaw GUI) **OPTION**

This user convenience GUI software measures material coordinate systems, tool lengths/diameters/damage to tools (included in Renishaw H/W set)



#### 3. LAUNCHER

This software offers shortcuts for quick access to specialized features and frequently used features.

#### 4. Premium Tool Operation

This software offers premium graphic functions for more intuitive tool operation.



#### 5. Manual Viewer

This software enables users to view electronic manuals right from the tool.

#### 6. Scheduling

This software enables viewing/setting up directly from the tool. This allows such actions as managing customer's tool schedules and schedule notification.

❖ KF5600M, KF6700M : HYUNDAI WIA FANUC - SMART PLUS Non Applicable

# SPECIFICATIONS

## Standard & Optional

● : Standard ○ : Option ☆ : Prior Consultation - : Non Applicable

Spindle		F750B	F960B
4,500rpm (18.5kW [25HP])	FANUC (Gear)	●	-
4,500rpm (30kW [40HP])	ITROL (Gear)	○	-
8,000rpm (18.5kW [25HP])	FANUC (Gear)	○	-
8,000rpm (30kW [40HP])	ITROL (Gear)	○	-
8,000rpm (22kW [29.5HP])	FANUC (Gear)	-	●
8,000rpm (27.8kW [37HP])	ITROL (Gear)	-	○
12,000rpm (30kW [40HP])	FANUC (Built-in)	○	○
Spindle Cooling System		●	●
<b>ATC</b>			
ATC Extension	20	●	●
	30	○	○
	40	-	-
Tool Shank Type	BBT50	●	●
	BCV50	○	○
U-Center	D'andrea	○	○
	45°	●	●
Pull Stud	60°	○	○
	90°	○	○
<b>Table &amp; Column</b>			
T-Slot Table		●	●
NC Rotary Table		☆	☆
High Column	250mm(9.8")	○	-
	200mm(7.8")	-	○
<b>Coolant System</b>			
Std. Coolant (Nozzle)		●	●
Bed Flushing Coolant		●	●
Through spindle coolant*1)	20bar	○	○
	30bar	○	○
	70bar	○	○
Top Cover (Thru coolant applied when necessary)		○	○
Shower Coolant		○	○
Gun Coolant		○	○
Side Oil Hole Coolant		○	○
Air Gun		○	○
Cutting Air Blow		○	○
Tool Measuring Air Blow (Only for TLM)		○	○
Air Blow for Automation		☆	☆
Thru MQL Device (Without MQL)		☆	☆
Coolant Chiller		☆	☆
Power Coolant System (For Automation)		☆	☆
<b>Chip Disposal</b>			
Coolant Tank	470 ℓ	●	-
	690 ℓ	-	●
Interior Screw Chip Conveyor		●	●
Exterior Screw Chip Conveyor		●	-
Chip Conveyor (Hinge/Scraper)	Rear(Right)	○	-
	Left(Rear)	○	-
	Front(Left)	-	○
Chip Conveyor (Hinge)		Front(Right)	-
Special Chip Conveyor (Drum Filter)		☆	☆
Chip Wagon	Standard (180 ℓ)	○	○
	Swing (200 ℓ)	☆	☆
	Large Swing (290 ℓ)	☆	☆
	Large Size (330 ℓ)	☆	☆
	Customized	☆	☆
<b>ETC</b>			
Tool Box		●	●
Customized Color		Need for Munsel No.	☆
CAD&CAM Software		☆	☆
<b>Electric Device</b>			
Call Light	1 Color : ●	●	●
Call Light & Buzzer	3 Color : ●, ●, ●, B	○	○
Work Light		●	●
Electric Cabinet Light		○	○
Remote MPG		●	●
3 Axis MPG	FANUC	○	○
	ITROL	-	-
Work Counter		○	○
Total Counter		○	○
Tool Counter		○	○
Multi Tool Counter	6 EA	○	○
	9 EA	○	○

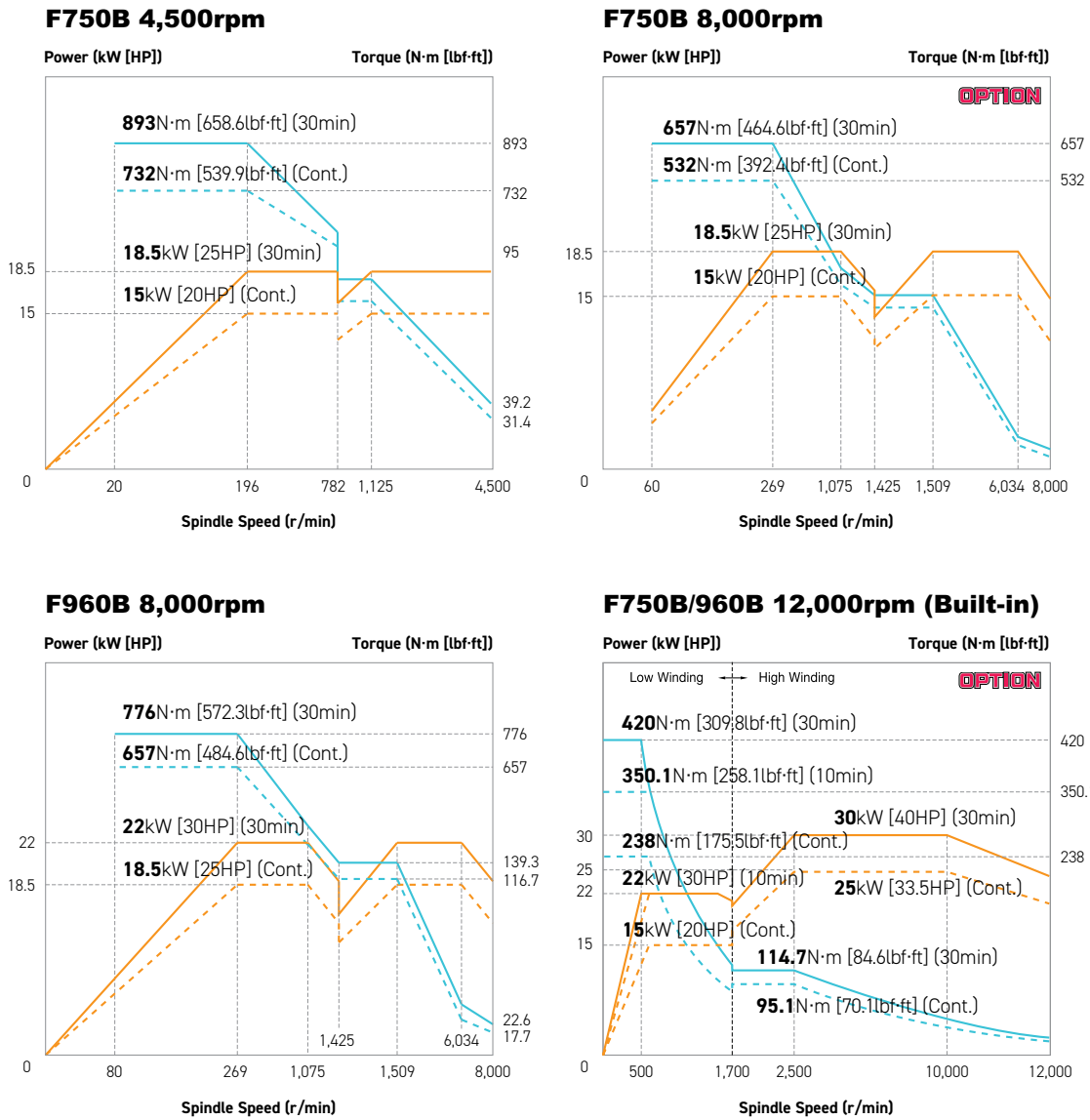
Electric Device		F750B	F960B
Electric Circuit Breaker		○	○
AVR (Auto Voltage Regulator)		☆	☆
Transformer	40kVA	○	-
	45kVA	-	○
Auto Power Off *2)		○	○
Back up Module for Black out		○	○
<b>Measuring Device</b>			
Air Zero	TACO	○	○
	SMC	○	○
Work Measuring Device		○	○
TLM (Marposs/Renishaw/Blum)	Touch	○	○
	Laser	○	○
Tool Broken Detective Device		☆	☆
Linear Scale X/Y/Z Axis		○	○
Coolant Level Sensor (Only for Chip Conveyor, Bladder Type)		☆	☆
<b>Environment</b>			
Air Conditioner		○	○
Dehumidifier		○	○
Oil Mist Collector		☆	☆
Oil Skimmer (Only for Chip Conveyor)		○	○
MQL (Minimal Quantity Lubrication)		☆	☆
<b>Fixture &amp; Automation</b>			
Auto Door	Std.	○	○
	High Speed	☆	☆
Auto Shutter (Only for Automatic System)		-	-
Sub O/P		☆	☆
NC Rotary Table/F	Single	○	○
	Channel	☆	☆
Control of Additional Axis	1Axis	○	○
	2Axis	☆	☆
External M Code 4ea		○	○
Automation Interface		☆	☆
I/O Extension (In & Out)	16 Contact	○	○
	32 Contact	○	○
<b>Hyd. Device</b>			
Std. Hyd. Unit	70bar/13 ℓ (3.4 gal)	-	-
	45bar	○	○
	70bar	○	○
Fixture Hyd. Unit	100bar	☆	☆
	Customized	☆	☆
<b>S/W</b>			
DNC software (HW-eDNC)		○	○
Machine Monitoring System (HW-MMS Cloud/Edge/Remote)		○	○
Machine Monitoring System & Analysis (HW-MMS Edge Plus)		☆	☆
Automation CAM program (HW-ACAM)		○	○
Conversational program (HW-DPRO)		○	○
SmartGuide-1 : FANUC		● (F31i : -)	● (F31i : -)
Tool Monitoring (HW-TM) : FANUC		○	○
Adaptive Feed Control (HW-AFC)		●	●
Thermal Displacement Compensation (HW-TDC)		○	○
Machining Condition Selection (HW-MCS) : FANUC		●	●
Machine Guidance (HW-MCG) : FANUC		●	●
RENISHAW GUI : FANUC		○	○
Spindle Warm up Function (HW-WARMUP) : FANUC		●	●
Energy Saving System (HW-ESS) : FANUC		●	●
Premium Tool Operation : FANUC		● (F31i : -)	● (F31i : -)
Manual Viewer : FANUC		● (F31i : -)	● (F31i : -)
Scheduling : FANUC		● (F31i : -)	● (F31i : -)
Operation Memo : FANUC		● (F31i : -)	● (F31i : -)

\*1 : Please check the filter types with sales representative. / \*2 : 12,000RPM Mold Package Standard  
Specifications are subject to change without notice for improvement.



# SPECIFICATIONS

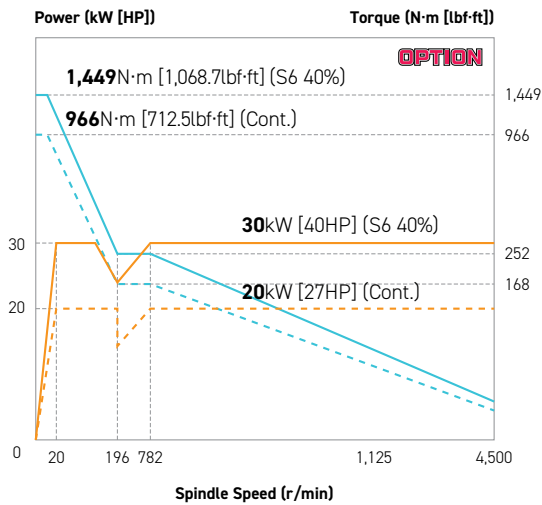
## Spindle Output/Torque Diagram (FANUC)



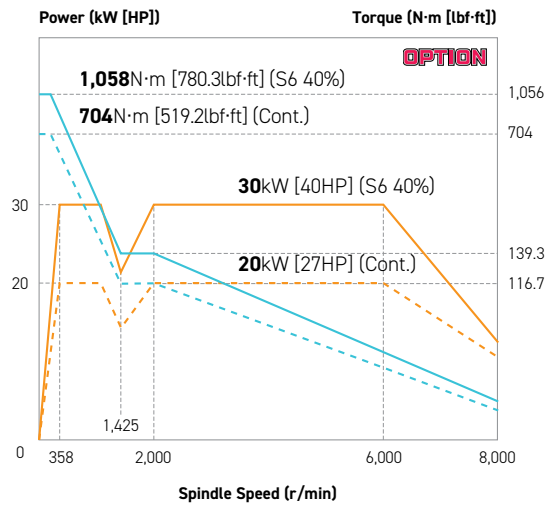
# SPECIFICATIONS

## Spindle Output/Torque Diagram (HYUNDAI-iTROL)

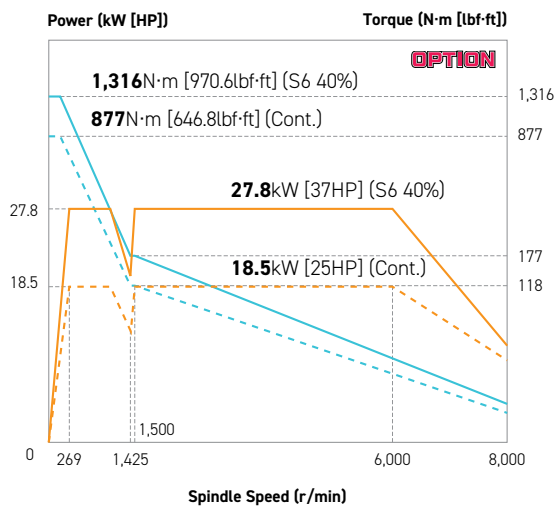
### F750B iTROL 4,500rpm



### F750B iTROL 8,000rpm



### F960B iTROL 8,000rpm

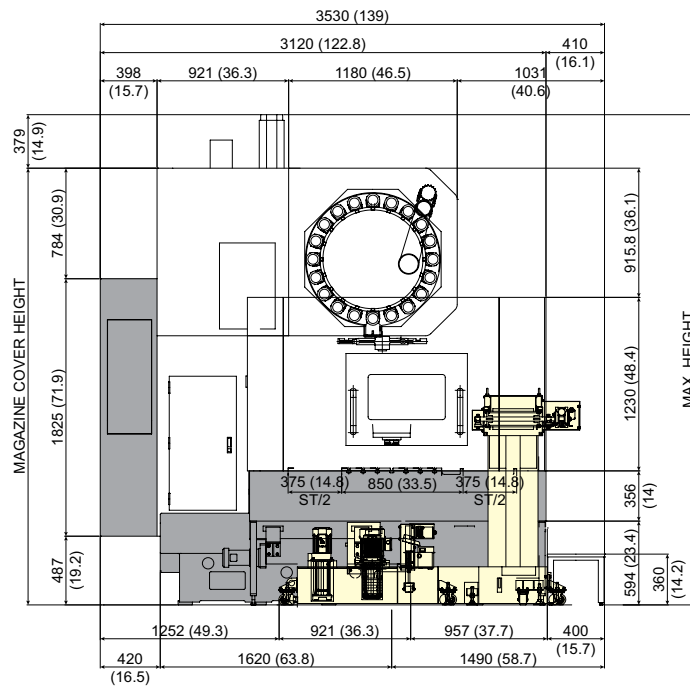
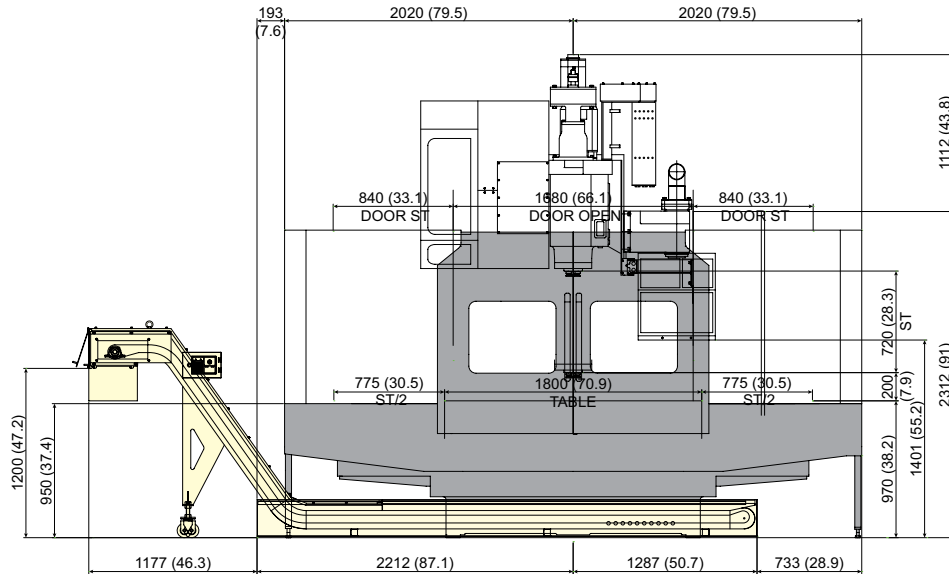


# SPECIFICATIONS

## External Dimensions

unit : mm(in)

### F750B



High Column : 250 mm (9.8")

Height Item	Max. Height	Height to Magazine Cover			Shipping Height	Spindle Motor Height
		20 tool	30 tool	40 tool		
Std. Column	3,475 (136.8)	2,947 (116)	3,045 (119.9)	-	3,475 (136.8)	3,345 (131.7)
High Column	3,725 (146.7)	3,197 (125.9)	3,295 (129.7)	-	3,725 (146.7)	3,595 (141.5)

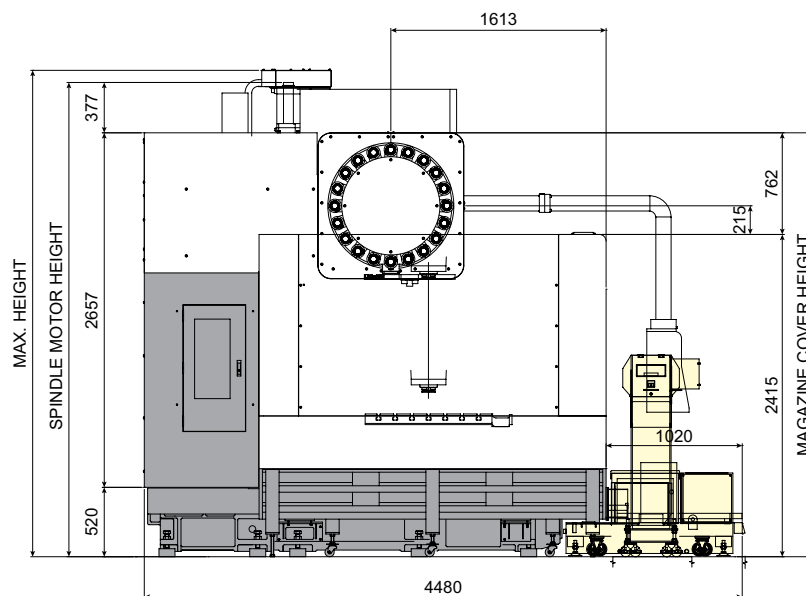
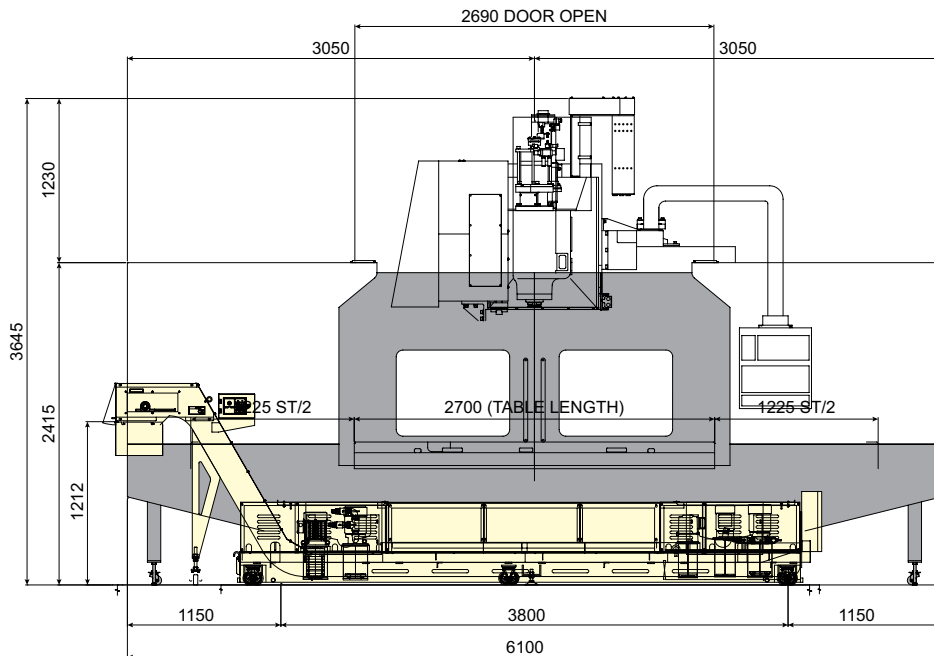


# SPECIFICATIONS

## External Dimensions

unit : mm(in)

### F960B



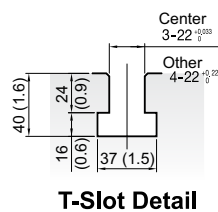
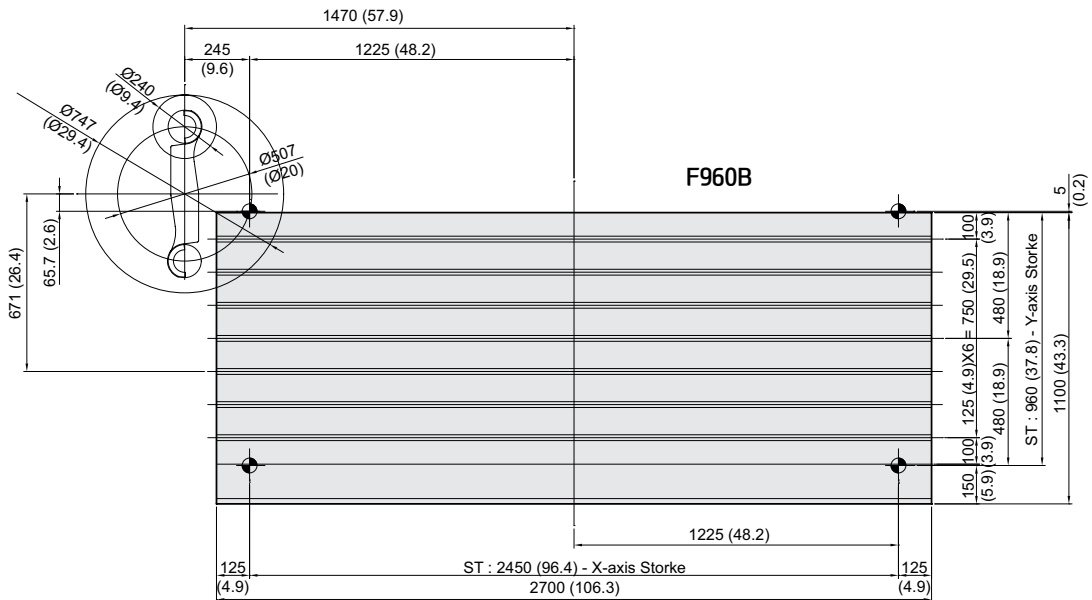
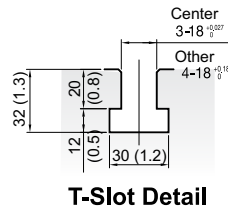
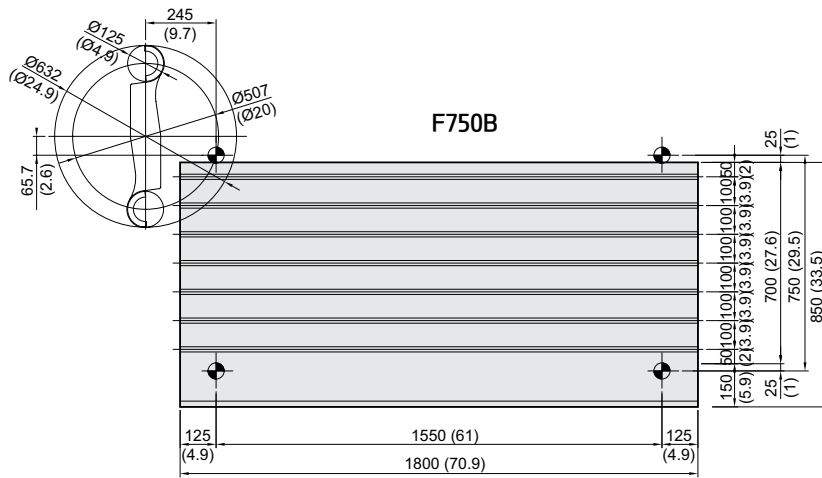
High Column : 200 mm (7.9")

Height Item	Max. Height	Height to Magazine Cover			Shipping Height	Spindle Motor Height
		20 tool	30 tool	40 tool		
Std. Column	3,647 (143.6)	3,177 (125.1)	3,256 (128.2)	3,256 (128.2)	3,554 (139.9)	3,647 (143.6)
High Column	3,847 (151.5)	3,377 (133)	3,456 (136.1)	3,456 (136.1)	3,754 (147.8)	3,847 (151.5)

# SPECIFICATIONS

## Table Dimensions

unit : mm(in)

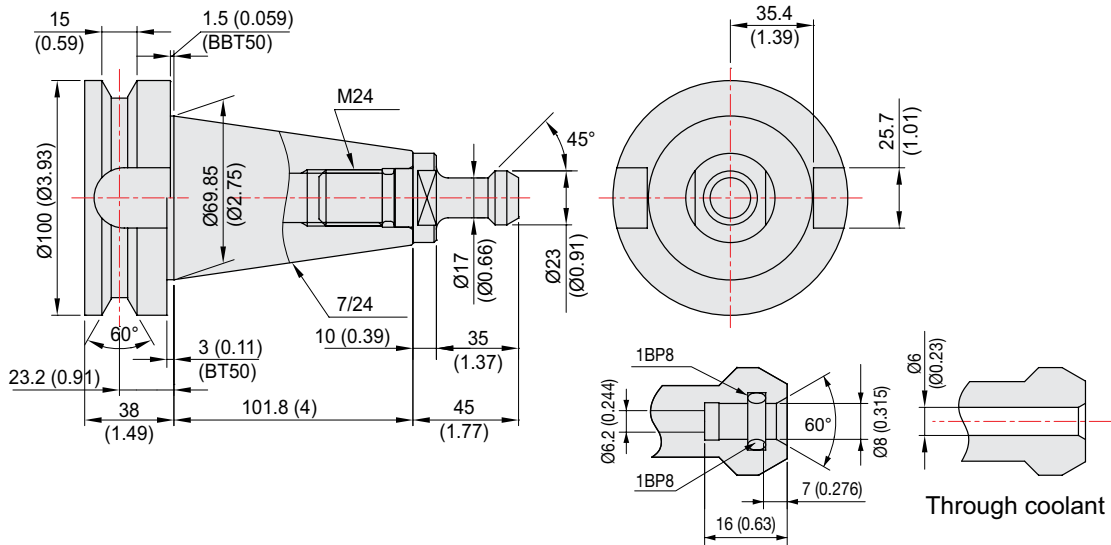


# SPECIFICATIONS

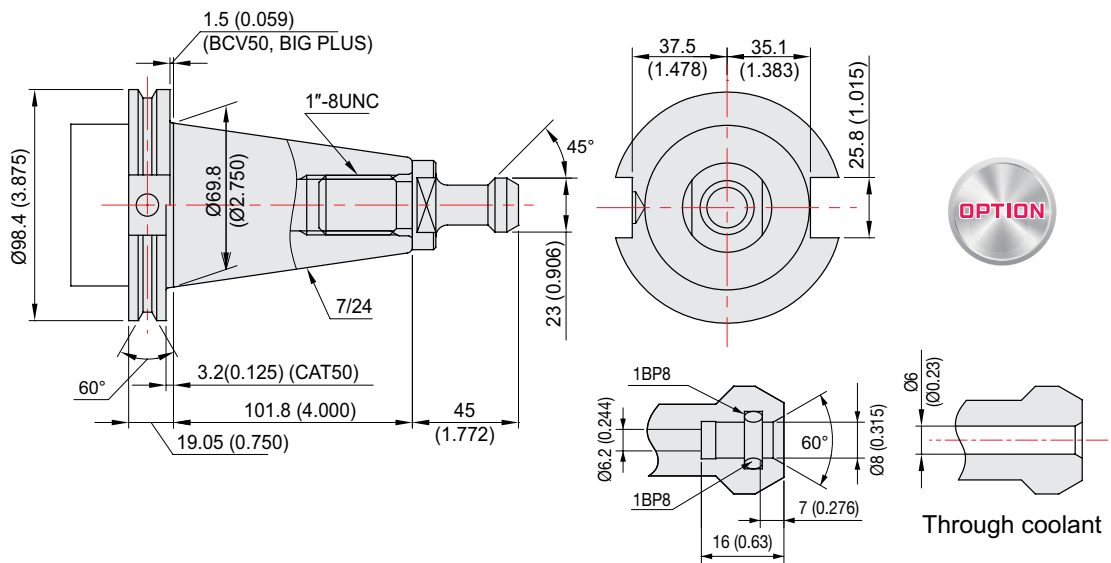
Tool Shank

unit : mm(in)

## BT50/BBT50, BIG PLUS



## CAT-50/BCV50



# SPECIFICATIONS

## Specifications

[ ] : Option

ITEM		F750B	F960B
TABLE	Table Size	mm(in) 1,800x700 (70.9"×27.6")	2,700x950 (106.3"×37.4")
	Maximum Load Capacity	kg(lb) 2,000 (4,409)	4,500 (9,921)
SPINDLE	Spindle Taper	- BBT50 [BCV50]	
	Spindle RPM	r/min 4,500 [8,000] [12,000] [4,500] [8,000]	8,000 [12,000] [8,000]
	Spindle Power Output (Max./Cont.)	kW(HP) 18.5/15 (25/20) [18.5/15 (25/20)] [30/25 (40/33.5)] [30/20 (40/27)] [30/20 (40/27)]	22/18.5 (30/25) [30/25 (40/33.5)] [27.8/18.5 (37/25)]
	Spindle Torque (Max./Cont.)	N·m(lb·ft) 893/732 (658.6/539.9) [657/532 (464.6/392.4)] [420/238 (309.8/175.5)] [1,449/966 (1,068.7/712.5)] [1,058/704 (780.3/519.2)]	776/657 (572.3/484.6) [420/238 (309.8/175.5)] [1,316/877 (970.6/646.8)]
	Spindle Driving Method	- GEAR [GEAR] [BUILT-IN] [GEAR] [GEAR] GEAR [BUILT-IN] [GEAR]	
FEED	Travel (X/Y/Z)	mm(in) 1,550/750/720 (61"/29.5"/28.3")	2,450/960/850 (96.5"/37.8"/33.5")
	Distance from Table Top to SP. Nose	mm(in) 200 ~ 920 (7.9" ~ 36.2") [450~1,170 (17.7" ~ 46.1")]	200 ~ 1,050 (7.9" ~ 41.3") [400~1,250 (15.7"~49.2")]
	Distance from Column to SP. center	mm(in) 790 (31.1")	1,000 (39.3")
	Rapid Traverse Rate (X/Y/Z)	m/min 16/16/12	16/16/20
	Slide Type	- BOX GUIDE	
ATC	Number of Tools	EA 20 [30]	20 [30, 40]
	Tool Shank	- BBT50 [BCV50]	
	Max. Tool Dia. (W.T / W.O)	mm(in) Ø125/Ø240 (Ø4.9"/Ø9.4")	
	Max. Tool Length	mm(in) 300 (11.8")	
	Max. Tool Weight	kg(lb) 20 (44.1)	
	Tool Selection Method	- RANDOM	
	Tool Change Time	T-T	sec 4
C-C		sec 8.5	
TANK CAPACITY	Coolant Tank	ℓ (gal) 470 (124.2)	690 (182.3)
	Lubricating Tank	ℓ (gal) 3.1 (0.8)	4.4 (1.1)
POWER SUPPLY	Air Consumption (0.5MPa)	ℓ /min(gal) 250 (66)	
	Electric Power Supply	kVA 35	40
	Thickness of Power Cable	Sq Over 25	Over 50
	Voltage	V/Hz 220/60 (200/50*)	
MACHINE	Floor Space (L×W)	mm(in) 4,040×3,530 (159"×139")	6,100×4,425 (240.2"×174.2")
	Height	mm(in) 3,475 (136.8")	3,647 (143.6")
	Weight	kg(lb) 13,000 (28,660)	23,500 (51,809)
PC	Controller	- FANUC 31i-B [HYUNDAI WIA FANUC i Series-Smart Plus] [HYUNDAI-iTROL]	

\*) Using 50Hz voltage instead of 60Hz may lower the output of motors. (excluding servo motors and inverter motors)  
Specifications are subject to change without notice for improvement.



# CONTROLLER

## FANUC 31i-B

[ ] : Option ☆ Needed technical consultation

Controlled axis / Display / Accuracy Compensation	
Control axes	3 axes (X, Y, Z) 4 axes (X, Y, Z, B)
Simultaneously controlled axes	3 axes [Max. 4 axes]
Least setting Unit	X, Y, Z axis : 0.001 mm (0.0001 inch) B axis : 1 deg [0.001] deg
Least input increment	X, Y, Z axis : 0.001 mm (0.0001 inch) B axis : 1 deg [0.001] deg
Inch / Metric conversion	G20 / G21
High response vector control	
Interlock	All axes / Each axis
Machine lock	All axes
Backlash compensation	± 0 ~ 9999 pulses (Rapid traverse / Cutting feed)
Position switch	
LCD / MDI	10.4 inch color LCD
Feedback	Absolute motor feedback
Stored stroke check 1	Over travel
Stored pitch error compensation	
Operation	
Automatic operation (Memory)	
MDI operation	
DNC operation	Needed DNC software / CF card
Program restart	
Wrong operation prevention	
Program check function	Dry run, Program check Z axis Machine lock, Stroke check before move
Single block	
Search function	Program Number / Sequence Number
Interpolation functions	
Nano interpolation	
Positioning	G00
Linear interpolation	G01
Cylindrical interpolation	G02, G03
Exact stop mode	Single : G09, Continuous : G61
Dwell	G04, 0 ~ 9999.9999 sec
Skip	G31
Reference position return	1st reference, G28 2nd reference, G27 Ref. position check, G30
Thread synchronous cutting	G33
Helical interpolation	Circular + Linear interpolation 2 axes(max.)
Feed function / Acc. & Dec. control	
Manual feed	Rapid traverse Jog : 0~5,000mm/min (197 ipm) Manual handle : x1, x10, x100 pulses Reference position return
Cutting Feed command	Direct input F code
Feedrate override	0 ~ 200% (10% Unit)
Rapid traverse override	F0% (F1%), F25%, F50%, F100%
Override cancel	
Feed per minute	G94
Feed per revolution	G95
Look-ahead block	40 Block 200 Block (Mold)
Program input	
Tape Code	EIA / ISO
Optional block skip	1 ea
Absolute / Incremental program	G90 / G91
Program stop / end	M00, M01 / M02, M30
Maximum command unit	± 999,999.999 mm (± 99,999.9999 inch)
Plane selection	X-Y, G17 / Z-X, G18 / Y-Z, G19
Workpiece coordinate system	G52, G53, 6 pairs (G54 ~ G59)
Manual absolute	Fixed ON
Programmable data input	G10
Sub program call	10 folds nested
Custom macro	#100 ~ #149, #500 ~ #549
G code system	A
Programmable mirror image	G51.1, G50.1
G code preventing buffering	G4.1
Including Chamfering / Corner R	
Canned cycle	G73, G74, G76, G80 ~ G89
Coordinate rotation	G68, G69

Auxiliary function / Spindle speed function	
Auxiliary function	M 4 digit
Level-up M Code	Multi / Bypass M code
Spindle speed command	S 5 digit, Binary output
Spindle override	0% ~ 150% (10% Unit)
Spindle orientation	M19
FSSB high speed rigid tapping	
Tool function / Tool compensation	
Tool function	Max. T 8 digit
Tool life management	256 pairs ☆
Tool offset pairs	64 pairs
Tool nose radius compensation	G40, G41, G42
Tool nose length compensation	G43, G44, G49
Tool offset memory C	Tool length, diameter, abrasion(length, diameter)
Tool length measurement	Z axis Input C
Editing function	
Part program storage size	640m (256KB)
No. of registerable programs	500 ea
Program protect	
Background editing	
Extended part program editing	Copy, move and change of NC program
Memory card program edit	
Data input / output & Interface	
I/O interface	RS 232C serial port, CF card, USB memory Embedded Ethernet interface
Screen hard copy	
External message	
External key input	
External workpiece number search	
Automatic data backup	
Setting, display and diagnosis	
Self-diagnosis function	
History display	Alarm & Operator message & Operation
Run hour / Parts count display	
Maintenance information	
Actual cutting feedrate display	
Display of spindle speed / T code	
Graphic display	
Operating monitor screen	Spindle / Servo load etc.
Power consumption monitoring	Spindle & Servo
Spindle / Servo setting screen	
Multi language display	Support 20 languages
Display language switching	Selection of 5 optional Languages
LCD Screen Saver	Screen saver
Processing select	Speed/rigidity setting
Option	
Additional optional block skip	9 ea ☆
Fast ethernet	Needed option board
Data server	Needed option board
Protection of data at 8 levels	
Sub Spindle control	
Polar coordinate command	G15, G16
Polar coordinate interpolation	G12.1, G13.1
Cylindrical interpolation	G07.1
One-way positioning	G60
Stored stroke check 2, 3	
Inverse-time feed	G93
Scaling	G50, G51
Manual guide i	Conversational auto program
Handle interrupt	
Manual handle feed	2/3 units
Additional custom macro variables	#100~#199, #500~#999 #100~#199, #500~#999, #98000~#98499
Retraction for rigid tapping	
Tool management function	
Tool offset number	Max. 2000 pair ☆
Program storage capacity	512KB ~ 8MB ☆
Program registration number	Max. 4000 ea ☆
Additional work coordinate	48 pair (G54.1 P1 ~ P48)
AICC II	200 block 400 / 600 / 1000 block ☆

Figures in inch are converted from metric values.

The FANUC controller specifications are subject to change based on the policy of company CNC supplying.

# CONTROLLER

## HYUNDAI WIA FANUC i Series – SMART PLUS

[ ] : Option ☆ Needed technical consultation

Controlled axis / Display / Accuracy Compensation	
Control axes	3 axes (X, Y, Z) 4 axes (X, Y, Z, B)
Simultaneously controlled axes	3 axes [Max. 4 axes]
Least setting Unit	X, Y, Z axis : 0.001 mm (0.0001 inch) B axis : 1 deg [0.001] deg
Least input increment	X, Y, Z axis : 0.001 mm (0.0001 inch) B axis : 1 deg [0.001] deg
Inch / Metric conversion	
High response vector control	
Interlock	All axes / Each axis
Machine lock	All axes
Backlash compensation	± 0 ~ 9999 pulses (Rapid traverse / Cutting feed)
Position switch	
LCD / MDI	15 inch LCD unit (with Touch Panel)
Feedback	Absolute motor feedback
Stored stroke check 1	Over travel
Stored stroke check 2, 3	
Stored pitch error compensation	
Operation	
Automatic operation (Memory)	
MDI operation	
DNC operation	Needed DNC software / CF card
Program restart	
Wrong operation prevention	
Program check function	Dry run, Program check, Z axis Machine lock Stored limit check before move
Single block	
Search function	Program Number / Sequence Number
Handle interruption	
Interpolation functions	
Nano interpolation	
Positioning	G00
Linear interpolation	G01
Circular interpolation	G02, G03
Exact stop mode	Single : G09, Continuous : G61
Dwell	G04, 0 ~ 9999.9999 sec
Skip	G31
Reference position return	1st reference, G28 / 2nd reference, G30 Ref. position check, G27
Single direction positioning	G60
Thread synchronous cutting	G33
Helical interpolation	Circular + Linear 2 axes (Max.)
Feed function / Acc. & Dec. control	
Manual feed	Rapid traverse Jog : 0~2,000mm/min (79 ipm) Manual handle : x1, x10, x100 pulses Reference position return
Cutting Feed command	Direct input F code
Feedrate override	0 ~ 200% (10% Unit)
Rapid traverse override	1%, 25%, 50%, 100%
Override cancel	
Feed per minute	G94
Feed per revolution	G95
Cylindrical interpolation	G07.1
Inverse time feed	G93
Look-ahead block	200 blocks (AI APC)
Program input	
Tape Code	EIA / ISO
Optional block skip	9 ea
Absolute / Incremental program	G90 / G91
Program stop / end	M00, M01 / M02, M30
Maximum command unit	± 999,999.999 mm (± 99,999.9999 inch)
Plane selection	X-Y, G17 / Z-X, G18 / Y-Z, G19
Workpiece coordinate system	G52, G53, 48 pairs (G54.1 P1 ~ 48)
Manual absolute	Fixed ON
Programmable data input	G10
Sub program call	10 folds nested
Custom macro	#100 ~ #199, #500 ~ #999
Programmable mirror image	G51.1, G50.1
G code preventing buffering	G4.1
Optional chamfering corner R	

Program input	
Polar coordinate command	G15, G16
Canned cycle	G73, G74, G76, G80 ~ G89
Scaling	G50, G51
Coordinate system rotation	G68, G69
Conversational Program	SmartGuide-i
Auxiliary function / Spindle speed function	
Level-up M Code	Multi / Bypass M code
Spindle speed function	S & S digit, Binary output
Spindle override	0% ~ 150% (10% Unit)
Spindle orientation	M19
Retraction for rigid tapping	
FSSB high speed rigid tapping	
Tool function / Tool compensation	
Tool function	Max. T8 digit
Tool life management	
Tool offset pairs	400 pairs
Tool nose / radius compensation	G40, G41, G42
Tool length offset	G43, G44, G49
Tool offset memory C	Tool geometry and wear (Cutter and tool length)
Tool length measurement	Z axis Input C
Editing function	
Part program storage size	5,120m (2MB)
No. of registerable programs	1,000 ea
Program protect	
Background editing	
Extended part program editing	Copy, move and change of NC program
Memory card program edit	
Data input / output & Interface	
I/O interface	CF card, USB memory Embedded Ethernet interface
Screen hard copy	
External message	
External key input	
External workpiece number search	
Automatic data backup	
Setting, display and diagnosis	
Self-diagnosis function	
History display & Operation	Alarm & Operator message & Operation
Run hour / Parts count display	
Maintenance information	
Actual cutting feedrate display	
Display of spindle speed / T code	
Graphic display	
Operating monitor screen	Spindle / Servo load etc.
Power consumption monitoring	Spindle & Servo
Spindle / Servo setting screen	
Multi language display	Support 24 languages
Display language switching	Selection of 5 optional Languages
LCD Screen Saver	Screen saver

Option	
Fast ethernet	Needed option board
Data server	Needed option board
Protection of data at 8 levels	
Additional Axis	
Manual handle feed	2/3 units #100 ~ #199, #500 ~ #999, #98000 ~ #98499
Add. Workpiece	Max. 300 pairs (G54.1 P1 ~ P300)
AICC II	400 blocks ☆

Figures in inch are converted from metric values.

The FANUC controller specifications are subject to change based on the policy of company CNC supplying.

# CONTROLLER

## HYUNDAI-iTROL (SIEMENS 828D)

[ ] : Option ☆ Needed technical consultation

Controlled axis / Display / Accuracy Compensation	
Control axes	3 axes (X, Y, Z) [4 axes (X, Y, Z, A)] [5 axes (X, Y, Z, A, C)]
Simultaneously controlled axes	Max. 4 axes
Least setting Unit	X, Y, Z axis : 0.001 mm (0.0001 inch) [A, C (B) axes : 1 deg [0.001] deg]
Least input increment	X, Y, Z axes : 0.001 mm (0.0001 inch) [A, C (B) axes : 1 deg [0.001] deg]
Inch / Metric changeover	G70 (inch) / G71 (metric)
Interlock	All axes / Each axis
Pitch error compensation	
Feedforward control	
LCD / MDI	10.4 inch color LCD [15 inch color LCD (With Touch panel)]
Keyboard	QWERTY full keyboard
Stored stroke check	Over travel
Operation	
Automatic operation	
MDI operation	
Program restart	
Program check function	Dry run / Program check / Machine lock
Single block	
Block search	Block search
Reposition	
Working area limit	Working area limitations
Interpolation functions	
Positioning	G00
Linear interpolation	G01
Circular interpolation	Circular Interpolation CW (G02) Circular Interpolation CCW (G03)
Exact position stop	Single block exact stop (G09) Exact stop G60 (G601, G602, G603)
Dwell	Dwell (G04)
Reference position return	Return to reference point Return to 2nd reference point
Helical interpolation	
Spline interpolation	Non-uniform rational B splines
Compressor for 3-axis machining (Improving machining quality)	CompCAD / CompCURV (Cycle 832)
Feed function / Acc. & Dec. control	
Manual feed	Rapid traverse Jog Manual handle Reference position return
Cutting Feed command	Direct input F code
Feedrate override	0 ~ 200% (10% Unit)
Rapid traverse override	1%, 25%, 50%, 100%
Feed per minute	G94
Feed per revolution	G95
Look-ahead block	300 block 450 block : (SW28X Mold) [600 block]
Program input	
ISO correspondence	G291(ISO)/G290 (SIEMENS) (ISO G Code system-A)
Optional block skip	2
Program stop / end	M00, M01 / M02, M30
Maximum command unit	± 999,999.999 mm, ± 99,999.9999 inch
Plane selection	X-Y : G17, X-Z : G18, Y-Z : G19 G54 ~ G57, G505~G549
Workpiece coordinate system	G500 (Basic frame - settable zero offset) G53 (Work offset non modal) G153 (basic frame non modal)
Sub program call	11 folds nested
G code preventing buffering	STOPRE
Drilling/Milling cycle	Programing (Cycle 82, 83, 84, 840)
User cycle	

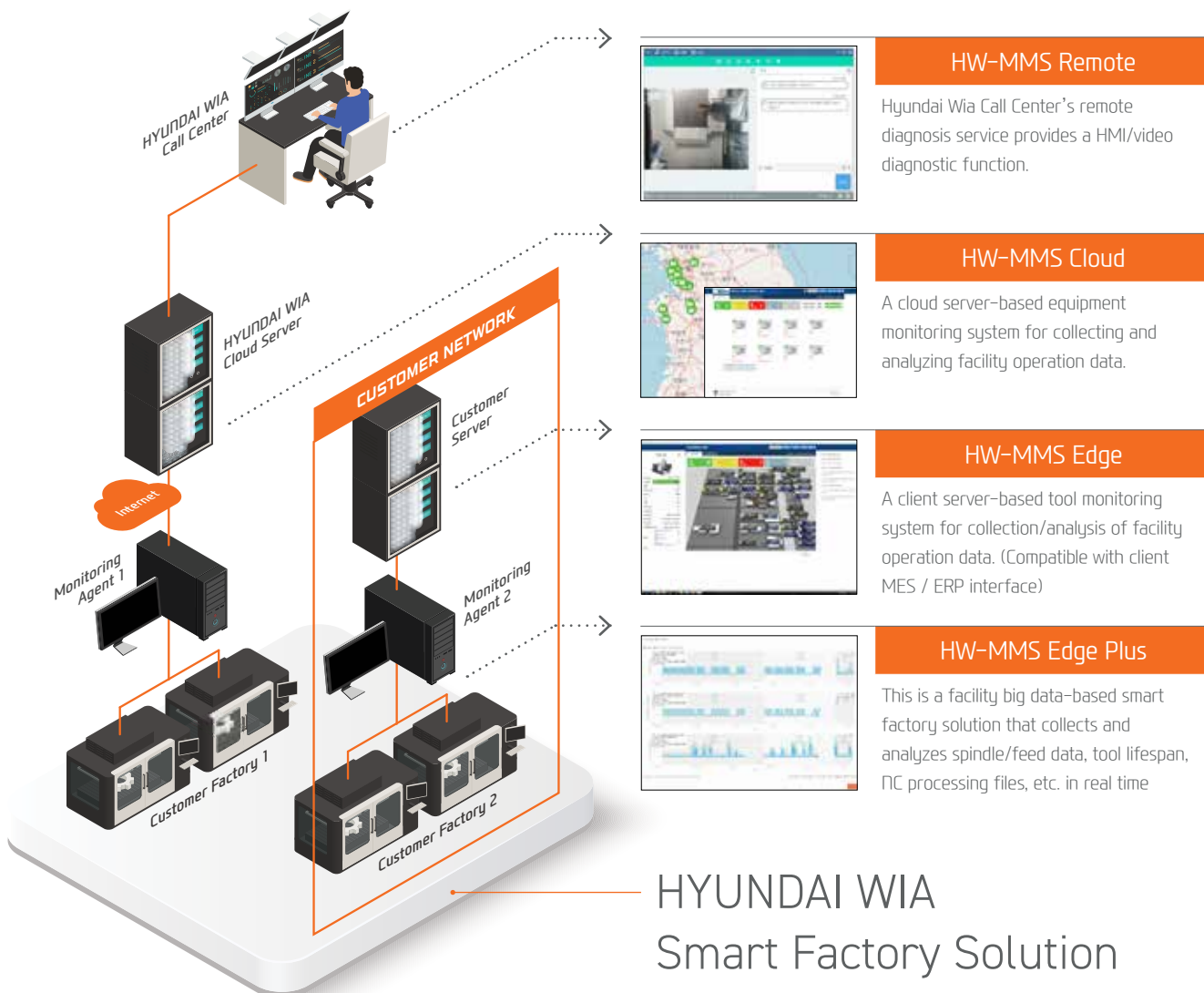
Auxiliary function / Spindle speed function	
Auxiliary function	M Code 4 digit
Spindle speed function	S Code 5 digit
Spindle override	0% ~ 150% (10% Unit)
Spindle orientation	SPOS
Rigid tapping	
Automatic mode Interchange	Spindle / Axis mode
Constant surface speed control	G96, G97
Spindle speed limitation	LIMS
Tool function / Tool compensation	
Tool function	Tool number & Tool name Tool : T + Offset : D
Tool life management	
Tools in tool list	256 ea 768 ea : (SW28X Mold)
Cutting Edges in tool list	512 ea 1,536 ea : (SW28X Mold)
Tool radius compensation	ISO (G40, G41, G42)
Tool length offset	
Geometry / Wear compensation	
Measurement of tool length	
Tool management function	
Editing function	
Part program storage size	5MB 10MB : (SW28X Mold)
No. of registerable programs	750 ea
External Storage devices	Local network, Server, USB, Flash drive
Background editing	
Extended part program editing	Copy, move and change of NC program
Memory card program edit	
Data input / output & Interface	
I/O interface	CF card interface (ONLY 10.4") USB memory interface Embedded Ethernet memory interface
Screenshot	
Setting, display and diagnosis	
Self-diagnosis function	
History display & Operation	Alarm & Operator message & Operation
Run hour / Parts count display	
Maintenance information	
Actual cutting feedrate display	
Display of spindle speed / T code	
Graphic display	
Operating monitor screen	Spindle / Servo load etc. Support 9 languages Chinese (Simplified/Traditional), English, French, German, Italian, Korean, Portuguese, Spanish [☆ 22 Support languages : Inquiry need]
Multi language display	
LCD Screen Saver	Screen saver & Motion sensing
Option	
Additional optional block skip	10 ea
Additional axis control	
Contour handwheel	
3D simulation	
Real time simulation	
ShopMill	Machining step programming for milling

# HW-MMS

HYUNDAI WIA Machine Monitoring System



A manufacturing machine self-developed by Hyundai Wia, HW-MMS is a unique software capable of monitoring the operation status of manufacturing machines in factories, a smart solution to improve manufacturing conditions of customers







F750B/960B  
Movie



YouTube HYUNDAI WIA MT

[www.youtube.com/HYUNDAIWIAMT](http://www.youtube.com/HYUNDAIWIAMT)

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