

KIT4500

HYUNDAI WIA Gang Type CNC Turning Center

Technical Leader

The Gang Type CNC Turning Center **KIT4500**, designed by Hyundai WIA with years of expertise and the latest technology, is a gang tool CNC Turning Center which maximizes productivity through high speed and high performance mechanisms.

KIT4500

[HYUNDAI-ITROL]

Swing Over the Bed	mm(in)	Ø530 (20.9")
Max. Turning Length	mm(in)	300 (11.8")
Chuck Size	inch	6"
Bar Capacity	mm(in)	Ø51 (2")
Spindle Speed	r/min	6,000 [6,000]
Spindle Output	kW(HP)	15/11 (20.1/14.7) [25/10.5 (33.5/14.1)]
Travel (X/Z)	mm(in)	450/300 (17.7"/11.8")
No. of Tools	EA	6



High Speed, Rigidity and Productivity
Economical Gang Type CNC Turning center

KIT4500

- 60° slanted one-piece bed structure with high rigidity
- Stabilized unit structure to minimize thermal displacement
- Reduction of belt damage and spindle vibration through decrease of spindle belt length
- Optimal design for automation
- Compact design suitable for installation in restricted space

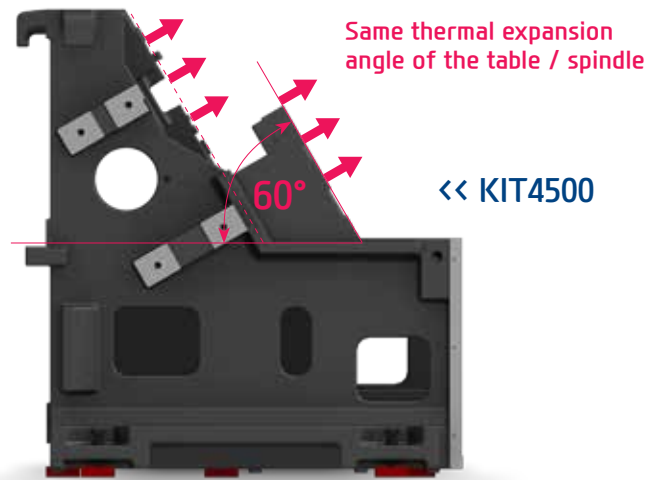
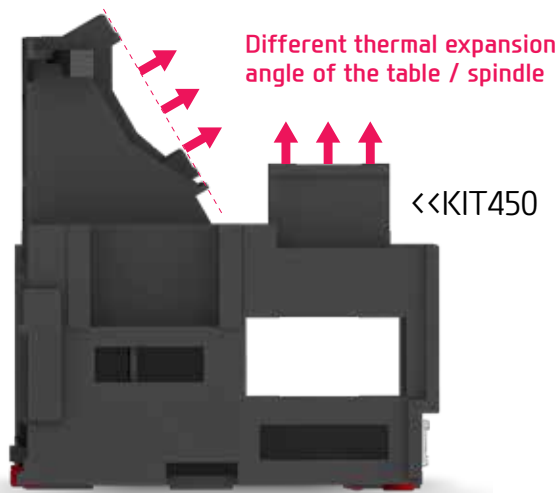


01

KIT4500

Basic Features

The Most Advanced Mechanism,
Revolutionized Productivity & High Performance



01 60° Slant Bed Structure

The application of 60° slant bed ensures excellent chip processing with easy access to the chuck during your tool setting for your increased convenience. Especially, thermal displacement has been greatly improved compared to that of the existing machine as the thermal expansion directions of both the spindle and table are identical according to the thermal displacement of the bed.

40% reduction
of combined thermal displacement

Ball Screw

Thermal displacement on the X axis has been reduced by 50% compared to that of the existing equipment due to improvements on the carriage structure on the X axis. Especially, the supporting capability has been improved as the support bearing of ball screws is expanded from the existing 2 EA to 3 EA on the X axis.

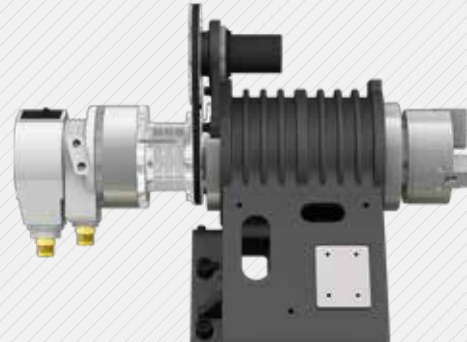
Support Bearing 3EA



⊙ Thermal displacement improvement on the X axis :
50% reduction

Main Spindle

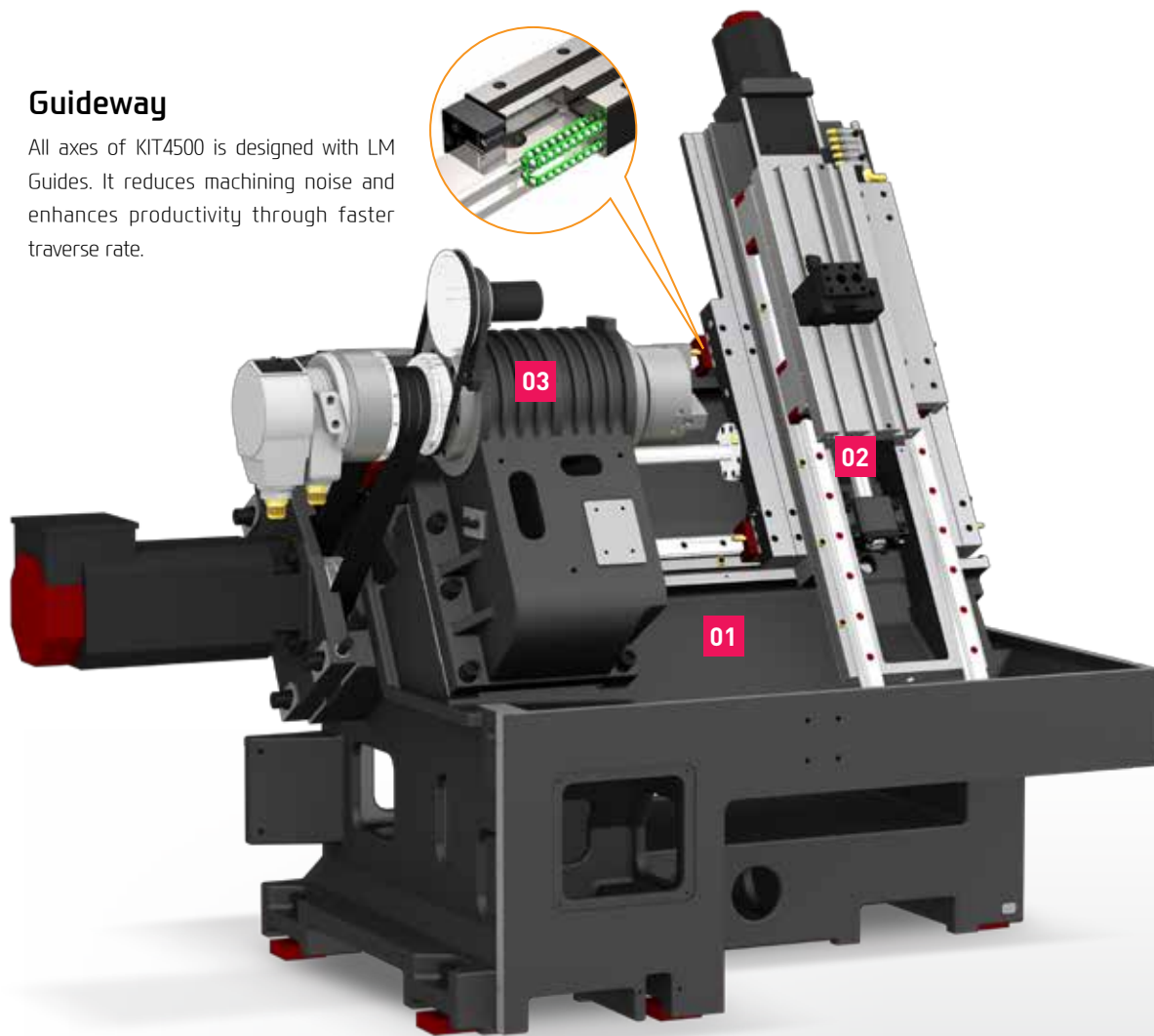
Precise machining can be done even in high speed due to the adoption of high precision angular ball bearings, and vibrations delivered to the main spindle have been minimized with the improved durability of the belt as the driving belt length on the main spindle is shortened.



Basic Features

Guideway

All axes of KIT4500 is designed with LM Guides. It reduces machining noise and enhances productivity through faster traverse rate.



- ⦿ **Rapid Traverse Rate** (X/Z axis) : **30/36** m/min (**1,181/1,417** ipm)
- ⦿ **Travel** (X/Z axis) : **450/300** mm (**17.7"/11.8"**)
- ⦿ **Max. Turning Dia.** : **Ø165** (**Ø6.5"**)
- ⦿ **Max. Turning Length** : **300** mm (**11.8"**)

02
KIT4500

High-Precision Spindle

Design of the main spindle in the high-tech structure for machining in high precision



Main Spindle

The high precision spindle is designed with angular contact ball bearings. The bearings minimize thermal displacement even at high speed.



60° Slant Spindle

The spindle of KIT4500 is attached at the same angle as the gang table to minimize the machining tolerance due to thermal displacement.

In addition, strength has been improved by expanding the attaching area of the spindle rod, compared to the previous model.

- Expansion of Bar Capacity
- Expansion of Spindle Bore

Previous Machine
Ø45 (Ø1.8") *

KIT4500
Ø51 (Ø2")
{Ø6 (Ø0.2") UP}

Previous Machine
Ø53 (Ø2.1")

KIT4500
Ø61 (Ø2.4")
{Ø8 (Ø0.3") UP}

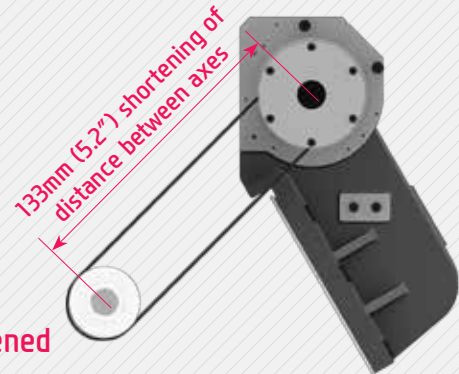
* With a customer's requirement, bar capacity can be replaced by Ø45 (Ø1.8")

Application of V-Ribbed Belt

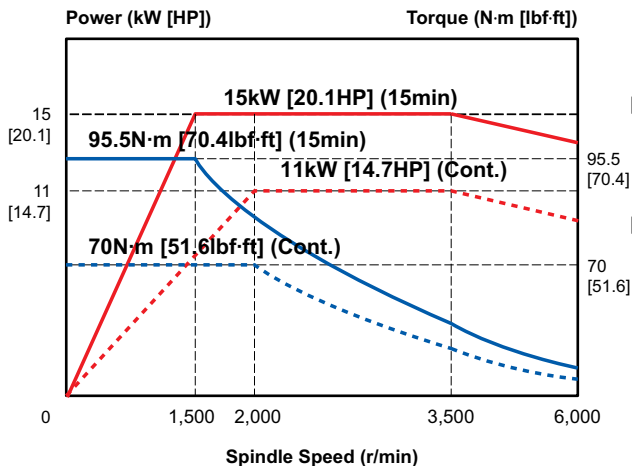
The belt slip is reduced by changing the existing scum belt to the V-ribbed belt. The span between motors in the spindle is optimized to improve spindle vibration and belt life.

Shortened Belt Length

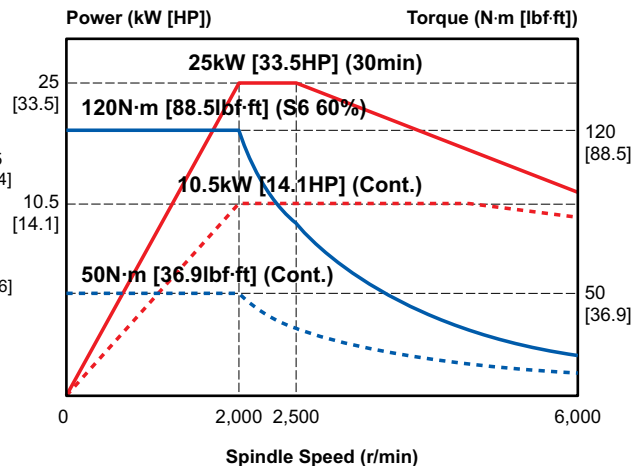
KIT450	1,326 mm (52.2")
KIT4500	1,060 mm (41.7") 266mm (10.5") Shortened



FANUC 6,000rpm



HYUNDAI-iTROL 6,000rpm

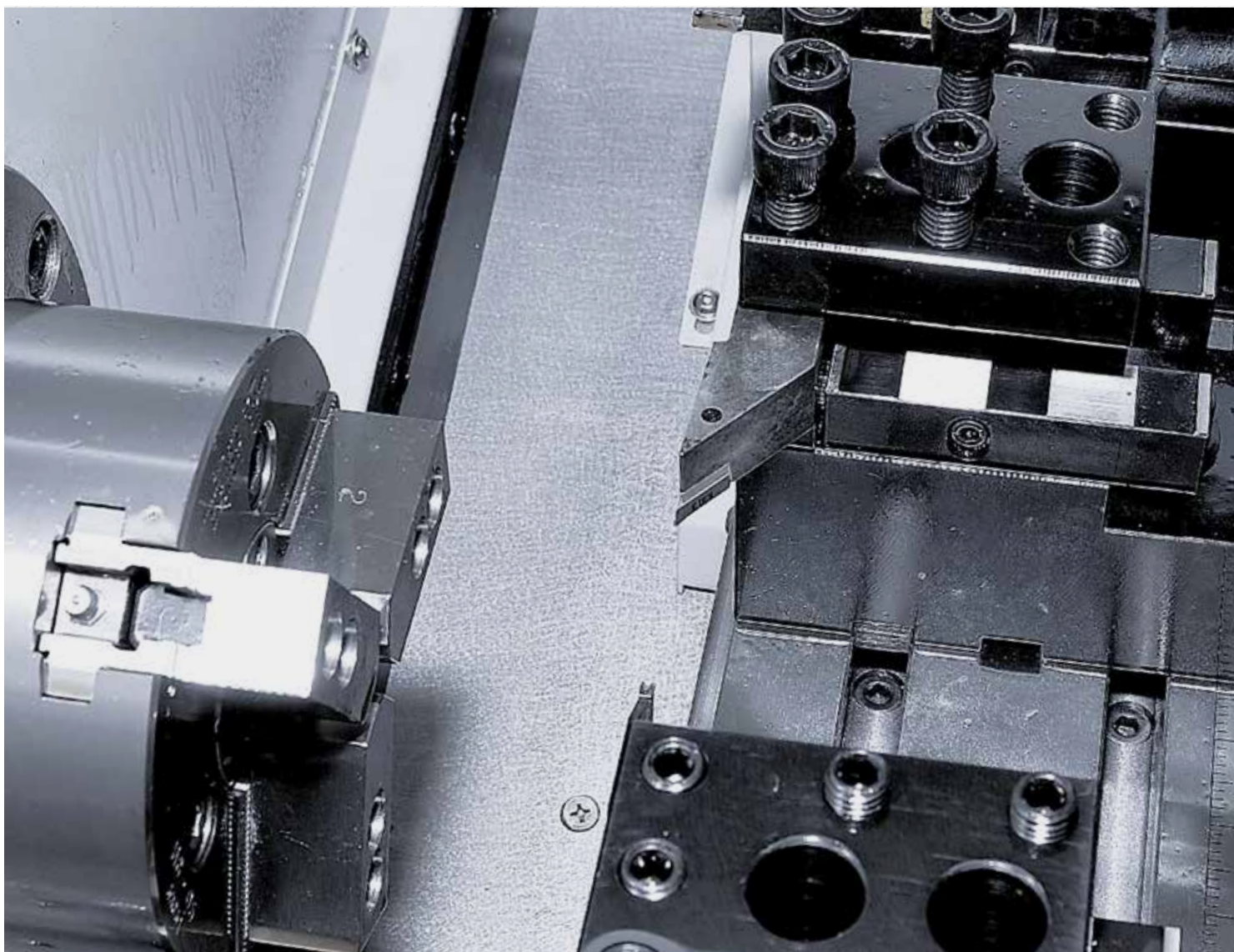


03

KIT4500

Outstanding Productivity

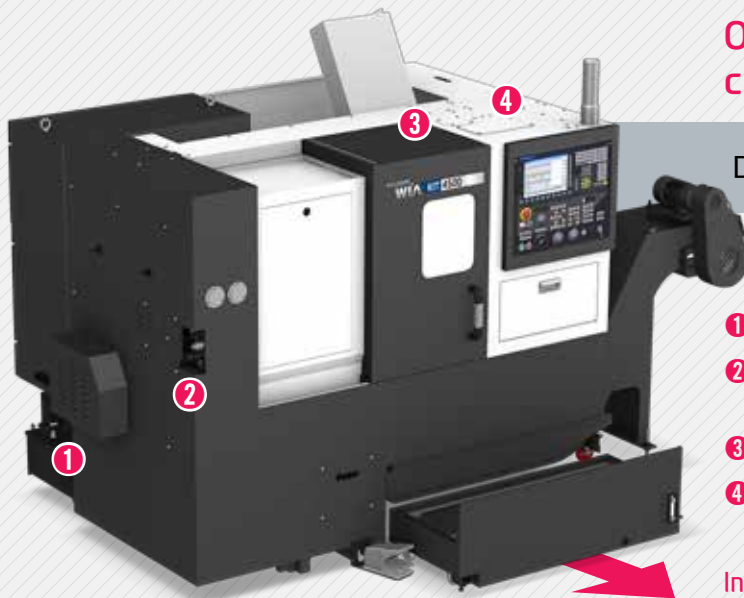
High Precision, Rigid Mechanism
Gang Type CNC Turning Center



Gang Type Block Tool

With Tool-To-Tool time reduced, productivity has been improved in the machining of small sized parts.

- ◉ No. of Tools : 6 EA
- ◉ Tool Size (OD/ID) : □ 20/Ø32 mm (□ 0.8"/Ø1.2")
- ◉ Table Size : 200×550 mm (7.9"×21.7")

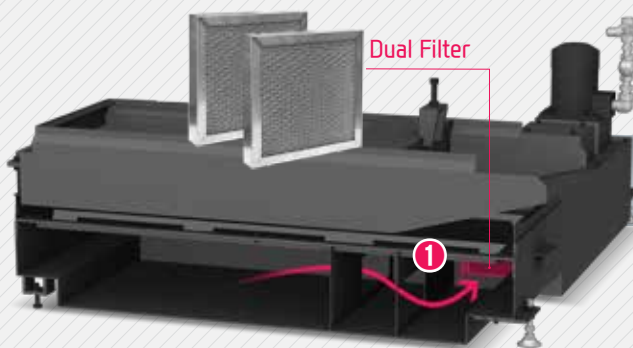


Optimal structure for user convenience

Door opening width : 495mm (19.5")

- ❶ Arrangement of hydraulic unit on the backend
- ❷ 2-directional (front / left side) pressure controller
- ❸ Top hole for the dust collector installation
- ❹ Sockets for piping option such as air tool, hydraulic, etc. (3 points)

Independent separation of only the coolant tank without the separation of chip pan and chip conveyor (common for the side and back)



Coolant tank performance improvement

Coolant Capacity : 120 ℓ (31.7 gal)

{Compared to previous machine 20 ℓ (5.3 gal) UP}

❶ Enhanced coolant filter capability

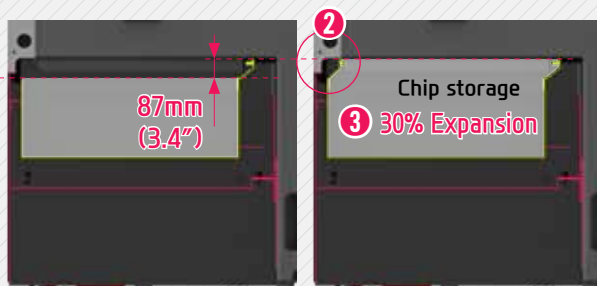
Filter capability has been improved by applying a dual filter in the zigzag filtering partition structure.

❷ Leakage prevention struction

Leak is prevented by tightening the chip box shoot surface close to the bed shoot floor through controlling the chip box height.

❸ Expansion of chip storage space

The chip storage space under the bed has been expanded by 30% compared to the previous model.



N4

KIT4500

Automation System



Automation system for improved process efficiency

Bar Feeder System

Bar Feeder

Bar feeder system enables automation which leads to efficiency improvement.

Long Type	3 m (118.1")
Max Bar Capacity	Ø42 mm (1.7")
Short Type	1.5 m (59.1")
Max Bar Capacity	Ø65 mm (2.6")



Parts Conveyor

The parts conveyor transfers the finished workpiece unloaded by the parts catcher for user convenience.

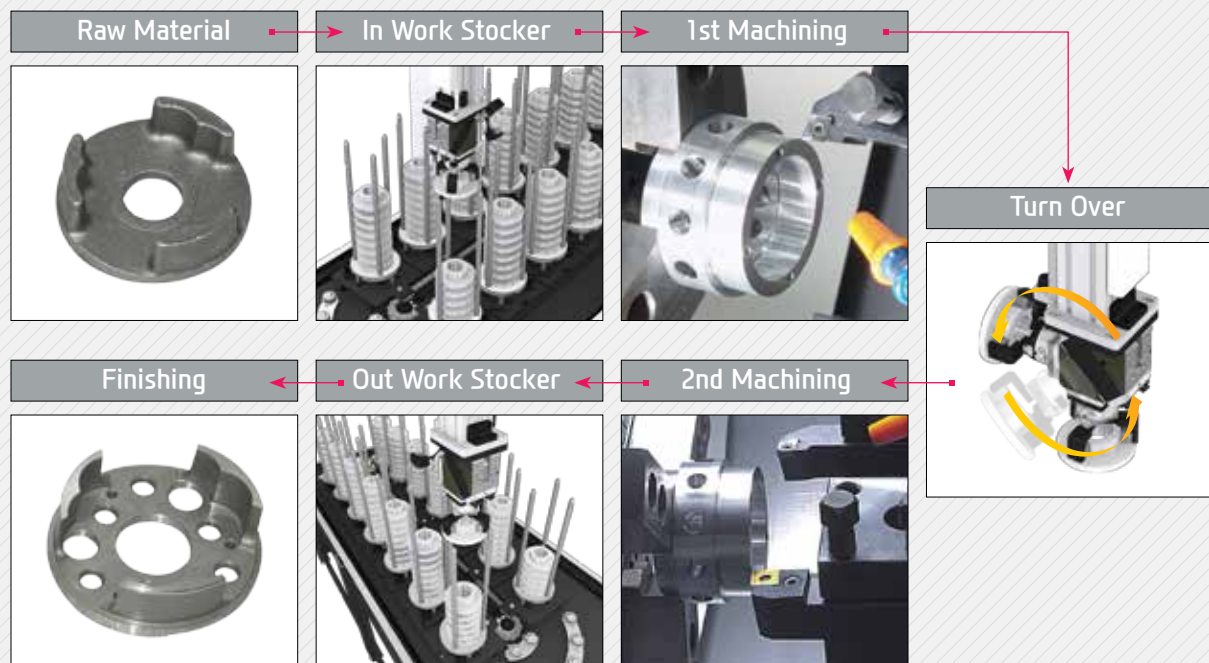


Gantry Loader System



Gantry Loader Machining Process

The high speed gantry loaders and the work stocker allow the implementation of automation cells. This enables machining process flexibility and productivity enhancement.



SPECIFICATIONS

Standard & Optional

Spindle		KIT4500
Main Spindle Hollow Chuck 3 Jaw	6"	●
	8"	○
	10"	-
Main Spindle Solid Chuck 3 Jaw	6"	○
	8"	☆
	10"	-
Standard Soft Jaw (1set)		●
Chuck Clamp Foot Switch		●
2 Steps Hyd. Pressure Device		○
Spindle Inside Stopper		○
5" Index		○
Cs-Axis (0.001")		○
Block Tool		
Tool Holder		●
Boring Sleeve		●
Drill Socket		●
U-Drill Holder		○
U-Drill Holder Sleeve		○
Ø32 (Ø1.3") Boring Holder		●
Rotating Tool Head (X,Z Axis)		☆
Tail Stock & Steady Rest		
Manual Tail Stock		-
Coolant & Air Blow		
Standard Coolant (Nozzle)		●
Chuck Coolant (Upper Chuck)		○
Gun Coolant		○
Through Spindle Coolant (Only for Special Chuck)		☆
Chuck Air Blow (Upper Chuck)		○
Air Gun		○
Through Spindle Air Blow (Only for Special Chuck)		☆
High Pressure Coolant	0.4Bar (5.8 psi)	●
	6Bar (87 psi)	○
Power Coolant System (For Automation)		☆
Coolant Chiller		☆
Chip Disposal		
Coolant Tank	120 ℓ (31.7 gal)	●
	130 ℓ (34.3 gal)	-
Chip Conveyor (Hinge/ Scraper/Screw)	Front (Right)	○
	Front (Rear)	○
Special Chip Conveyor (Drum Filter)		☆
Chip Wagon	Standard (180 ℓ [47.5 gal])	○
	Swing (200 ℓ [52.8 gal])	○
	Large Swing (290 ℓ [76.6 gal])	○
	Large Size (330 ℓ [87.2 gal])	○
	Customized	☆
Safety Device		
Total Splash Guard		●
Chuck hydraulic pressure maintenance interlock		○ (CE: ●)
Electric Device		
Call Light	1Color : ■	○
Call Light	2Color : ■ ■	○
Call Light	3Color : ■ ■ ■	○
Call Light & Buzzer	3Color : ■ ■ ■ B	○

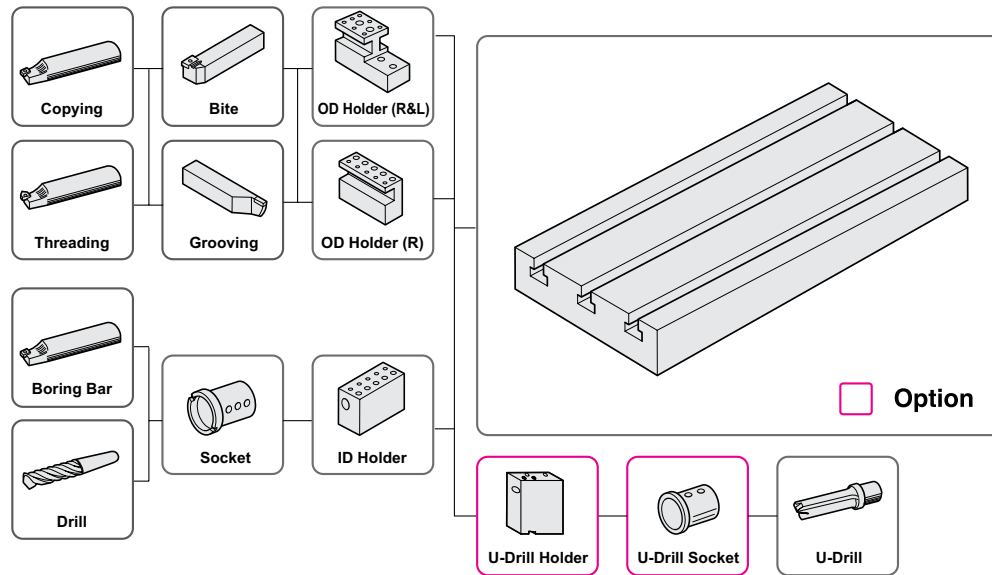
● : Standard ○ : Option ☆ : Prior Consultation - : Non Applicable

Electric Device		KIT4500
Electric Cabinet Light		○
Controller	FANUC	●
	HYUNDAI-ITROL	○
Remote MPG		-
Work Counter	Digital	○
Total Counter	Digital	○
Tool Counter	Digital	○
Multi Tool Counter	Digital	○
Electric Circuit Breaker		○
AVR (Auto Voltage Regulator)		☆
Transformer	20kVA	○
Auto Power Off		○
Measurement		
Q-Setter		-
Work Close Confirmation Device (Only for Special Chuck)	TACO	○
	SMC	○
Linear Scale	X/Z Axis	○
Coolant Level Sensor (Only for Chip Conveyor)		☆
Environment		
Air Conditioner		○
Oil Mist Collector		☆
Oil Skimmer		○
MQL (Minimal Quantity Lubrication)		☆
Fixture & Automation		
Auto Door		○
Auto Shutter (Only for Automatic System)		☆
Sub Operation Pannel		☆
Bar Feeder Interface		○
Extra M-Code 4ea		○
Automation Interface		☆
I/O Extension (IN & OUT)	16 Contact	○
	32 Contact	○
Parts Catcher		○
Parts Conveyor		☆
Semi Automation System (Front)		☆
Hyd. Device		
Standard Hyd. Cylinder	Hollow	●
	35bar (507.6 psi)/ 12 ℓ (3.2 gal)	-
Standard Hyd. Unit	35bar (507.6 psi)/ 15 ℓ (4 gal)	●
S/W		
Machine Guidance (HW-MCG)		☆
Energy Saving System (HW-ESS)		●
Tool Monitoring (HW-TM)		○
DNC software (HW-eDNC)		○
Monitoring of the state of equipment (HW-MMS)		☆
Conversational Program (HW-DPRO)		☆
ETC		
Tool Box		●
Customized Color	Need Munsel No.	☆
CAD & CAM Software		☆

SPECIFICATIONS

Tooling Travel Range

unit : mm(in)



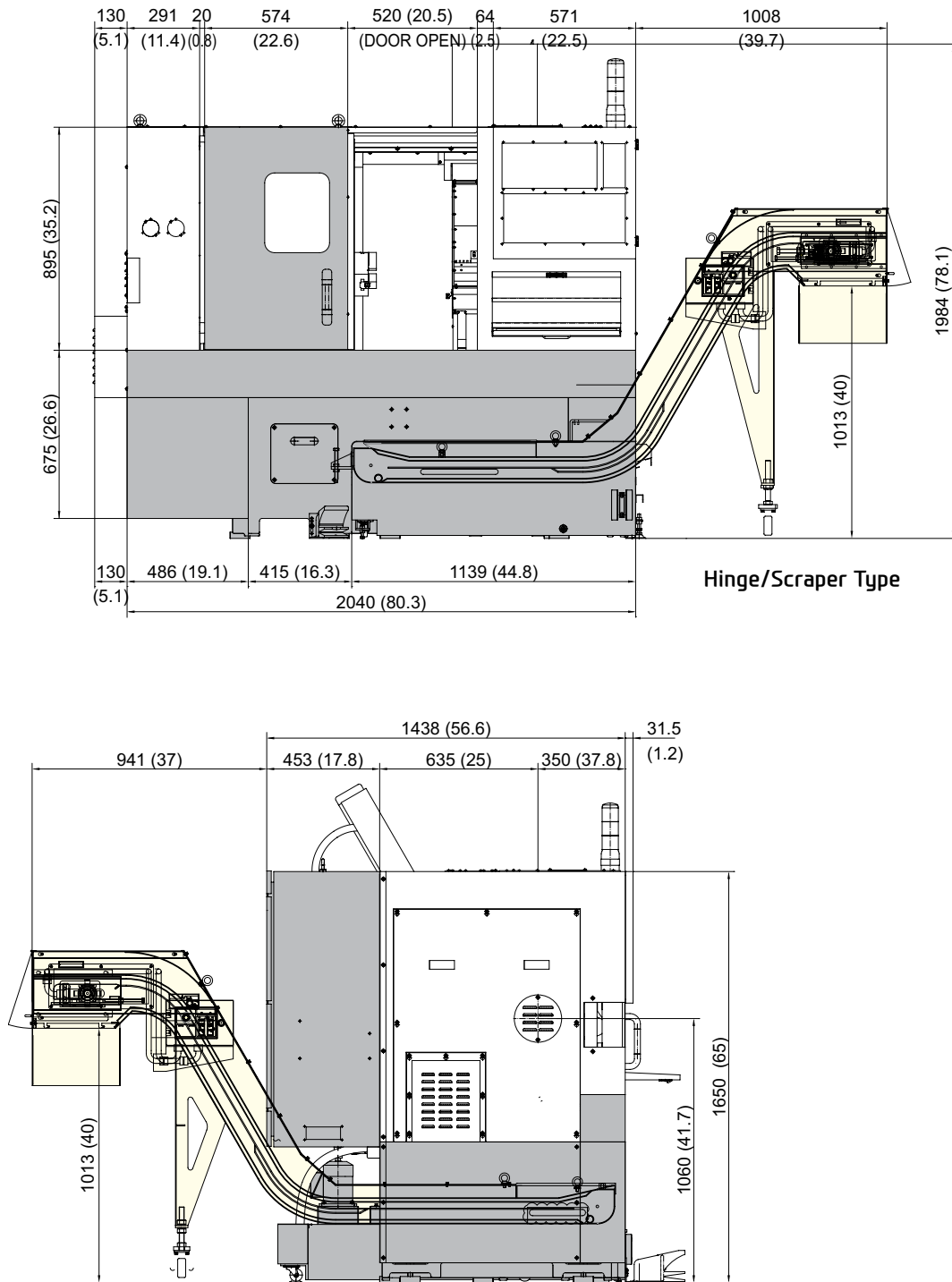
Tooling Parts Detail

ITEM			KIT4500	
			mm Unit	inch Unit
Turning Holder	O.D Holder	Right/Left : ϕ 20 (ϕ 3/4")	2	2
		Right/Left : ϕ 25 (ϕ 1")	Opt	Opt
		Double : ϕ 20 (ϕ 3/4")	1	1
		Double OD : ϕ 25 (ϕ 1")	Opt	Opt
Boring Holder	I.D Holder	Single : Ø32 (Ø1 1/4")	2	2
	U-Drill Holder	Ø20 (Ø3/4")	Opt	Opt
		Ø25 (Ø1")	Opt	Opt
Socket	Boring	Ø8 (Ø5/16")	Opt	Opt
		Ø10 (Ø3/8")	1	1
		Ø12 (Ø1/2")	1	1
		Ø16 (Ø5/8")	1	1
		Ø20 (Ø3/4")	Opt	Opt
		Ø25 (Ø1")	Opt	Opt
	Drill	MT 1	1	1
		MT 2	Opt	Opt
	ER Collet		-	-

SPECIFICATIONS

External Dimensions

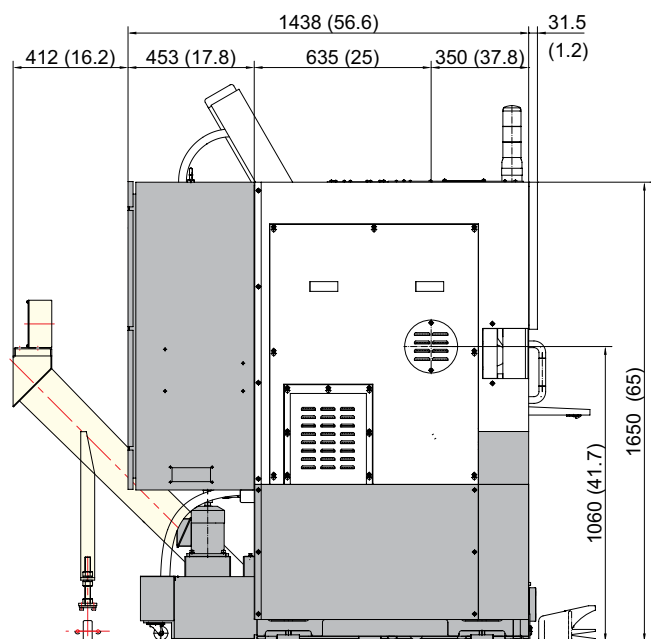
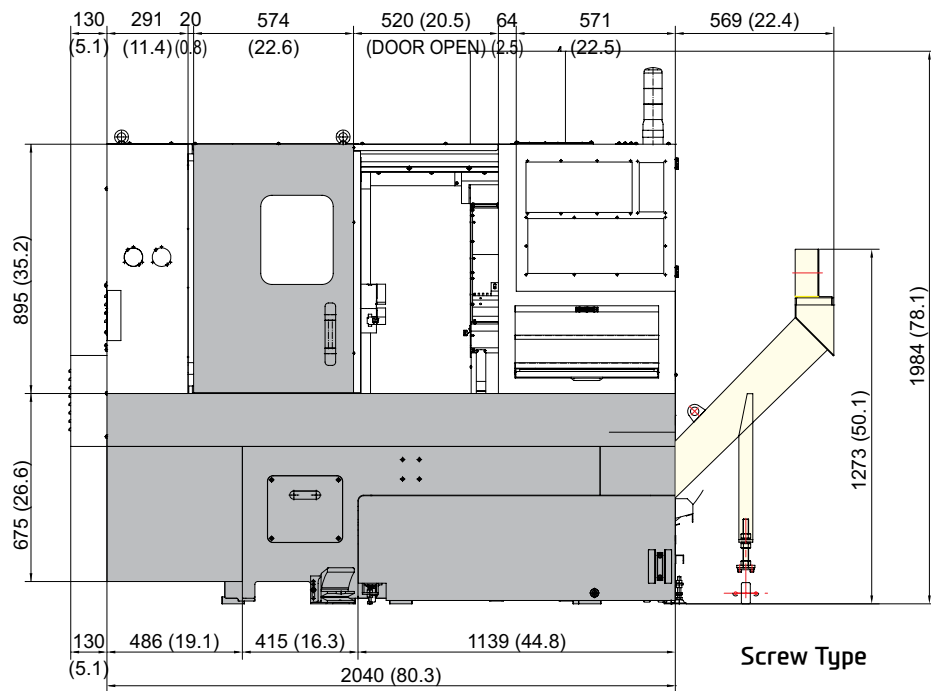
unit : mm(in)



SPECIFICATIONS

External Dimensions

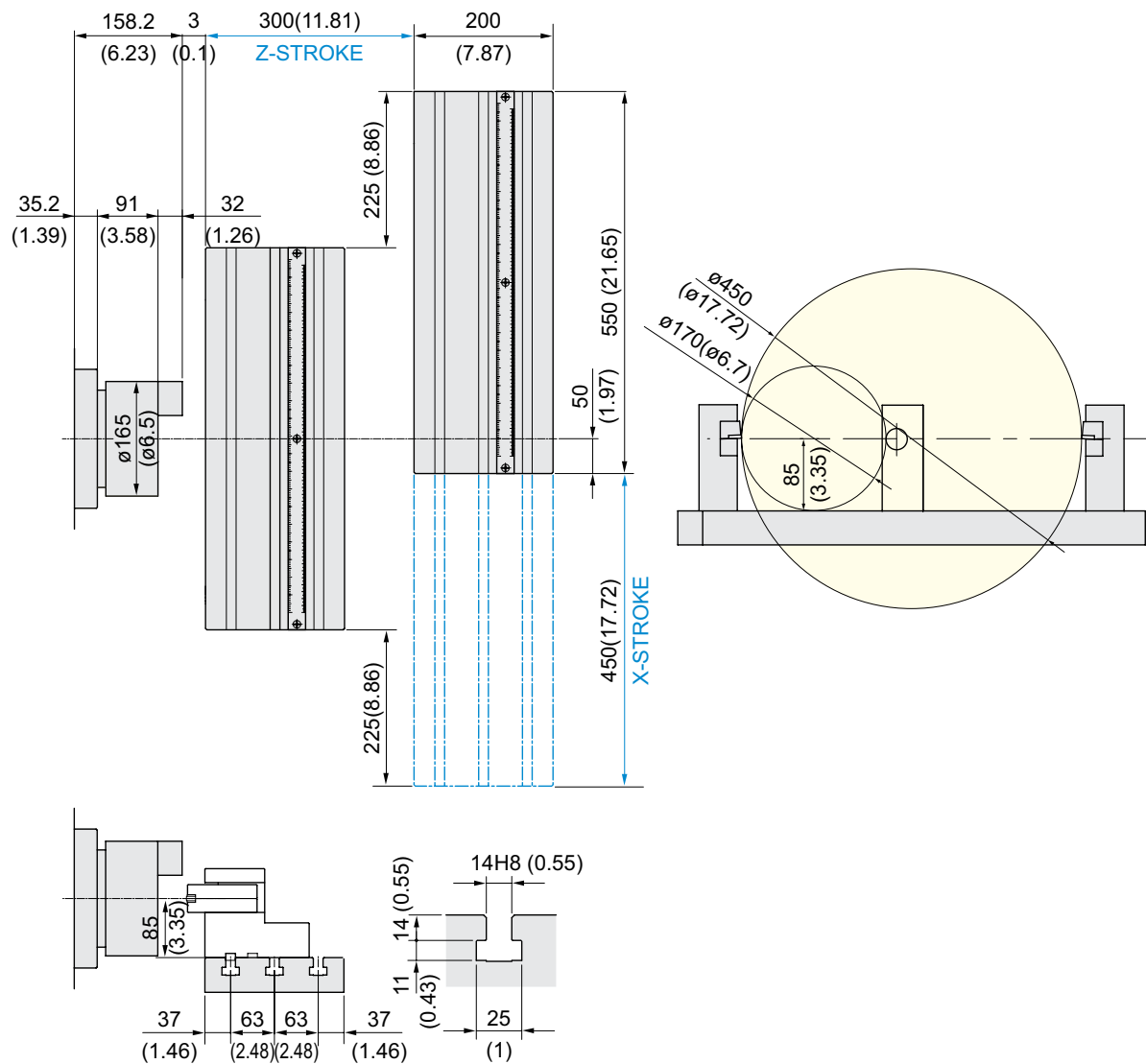
unit : mm(in)



SPECIFICATIONS

The Stroke of Table

unit : mm(in)



SPECIFICATIONS

Specifications

[] : Option

ITEM			KIT4500
CAPACITY	Swing Over the Bed	mm(in)	Ø530 (Ø20.9")
	Max. Turning Dia.	mm(in)	Ø165 (Ø6.5")
	Max. Turning Length	mm(in)	300 (11.8")
	Bar Capacity	mm(in)	Ø51 (Ø2")
SPINDLE	Chuck Size	mm(in)	6"
	Spindle Bore	mm(in)	Ø61 (Ø2.4")
	Spindle Speed (rpm)	r/min	6,000 [6,000]
	Motor (Max/Cont.)	kW(HP)	15/11 (20.1/14.7) [25/10.5 (33.5/14.1)]
	Torque (Max/Cont.)	N·m(lbf·ft)	95.5/70 (70.4/51.6) [120/50 (88.5/36.9)]
	Spindle Type	-	V-RIBBED BELT
	Spindle Nose	-	A2-5
FEED	Travel (X/Z)	mm(in)	450/300 (17.7"/11.8")
	Rapid Traverse Rate (X/Z)	m/min(ipm)	30/36 (1,181/1,417)
	Slide Type	-	LM GUIDE
BLOCK TOOL	No. of Tools	EA	6
	Tool Size	OD	□ 20 (□ 0.8")
		ID	Ø32 (1.2")
TANK CAPACITY	Coolant Tank	ℓ (gal)	120 (31.7)
	Lubricating Tank	ℓ (gal)	1.8 (0.5)
POWER SUPPLY	Electric Power Supply	kVA	17
	Thickness of Power Cable	Sq	OVER 16
	Voltage	V/Hz	220/60 (200/50*)
MACHINE	Floor Space (L×W)	mm(in)	2,170×1,470 (85.4" x 57.9")
	Height	mm(in)	1,984 (78.1")
	Weight	kg(lb)	2,800 (110.2")
PC	Controller	-	HYUNDAI WIA FANUC i Series [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

HYUNDAI-iTROL

Control & Composition	
Number of axis/Spindles	2 axes (X, Z) / 3 axes (X, Z, C)
Number of axis/Spindles, max.	8 axes (Axis + Spindle)
Color display	TFT 10.4" Color (800 x 600)
Keyboard	QWERTY Full Keyboard
Part program storage	1MB, 3MB, 5MB
Addition of part program on CF card	
Transfer Function	
Feedrate override	0% ~ 200%
Transfer value input range	± 999999999
Unlimited rotation of rotation axis	
Acc./Dec. with jerk limitation	
Measuring systems 1 and 2, selectable	
Travel to fixed stop	
Auto servo drive tuning	
Spindle Function	
Spindle override	0% ~ 150%
Spindle speed, max. programmable value range	1000000 ~ 0.0001
Automatic gear stage selection	
Spindle orientation	
Spindle speed limitation	
Rigid tapping	
Spindle control with PLC	
Interpolation	
Linear interpolation axis, max.	4 axis
Circle via center point and end point	
Circle via interpolation point	
Helical interpolation	
Non-uniform rational B splines	
Continuous – path mode with programmable rounding clearance	
Program Function	
Subroutine levels, max.	7
Interrupt routines, max.	2
Number of levels for skip blocks	2
Polar Coordinates	
Dimensions inch/metric, changeover manually or via program	
Dynamic preprocessing memory FIFO	
Look ahead	1
Absolute/Incremental command	G90 / G91
Scaling/Rotation	
Read/Write system variables	
Block search	
Edit background	
Processing program number, max.	750
Using of CF Card, USB	
Basic coordinate number, max.	1
Work coordinate number, max.	100
Basic/Work coordinate programming change	
Scratching function	
Global and Local user data (GUD/LUD)	
Global program user data	
Conversational Cycle Program	
Tool Function	
Tool radius compensations	
Tool offset selection via T/D numbers	
Tools / Cutting edges in tool list	128 / 256, 256 / 512
Monitoring Function	
Working area limit	
Software and Hardware limit	
Zero-speed/Clamping monitoring	
2D/3D protection zones	
Contour monitoring	

Compensation	
Backlash compensation	
Leadscrew error compensation	
Measuring system error compensation	
Feedforward control (Speed control)	
Safety Function	
Safe torque off (STO)	
Safe brake control (SBC)	
Safe stop 1 (SSI)	
Diagnostic Function	
Alarm/Message , Alarm log	
PLC status/LAD online display	
PLC remote connection (Ethernet)	
Automation Support Function	
Actual velocity display	
Tool life management	As time / As amount
Work counter/Cycle time	Embedded
2D simulation	
Manual Operation	
Manual handle/Jog transfer	
Manual measurement of workpiece / tool offset	
Automatic tool/Workpiece measurement	
Automatic/Program reference approach	
Automatic Operation	
Program run as using CF card/USB	
Program control/modification	
Block search	
Reposition	
Preset (Set actual value)	
Data Transmission	
Ethernet network	
USB memory stick & CF card	
Convenience Function	
Processing setting	Coordinate system setting, Auto tool length measurement
Processing support	Tool Monitoring, Spindle overload monitoring
Maintenance	Turret Guidance, I/O monitoring, Manual
Management	Soft MCP, M/G code List
SMART machining	
Energy saving function (ECO)	
Machine Monitoring System (MMS Lite)	
Language	
Standard support language	Chinese Simplified, English, Korean
Option	
Maximum skip block number	10
DRF offset	
MDI program save/load	
Teach-In mode	
3D simulation	Except for working area/Collision check
Real time simulation	
Shop Turn	Conversational Program
Spline interpolation	
Program remote control in network	
Language	Chinese Traditional, French, German, Italian, Portuguese, Spanish

CONTROLLER

HYUNDAI WIA FANUC i Series

[] : Option

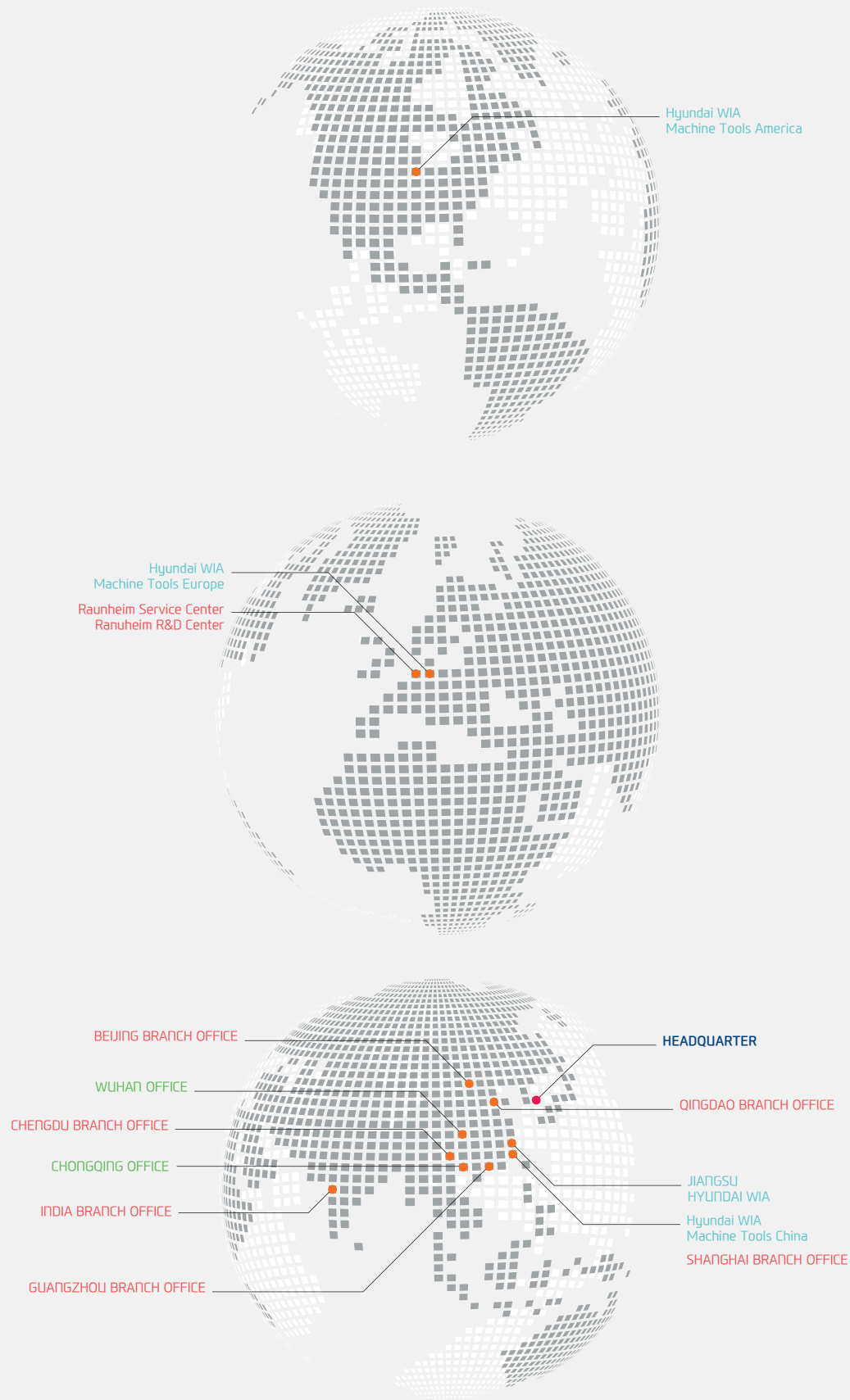
Controlled axis / Display / Accuracy Compensation	
Control axes	2 axes (X, Z) / 3 axes (X, Z, C / X, Z, B) / 4 axes (X, Z, Y, C) 5 axes (X, Z, B, C, A) / 6 axes (X, Z, Y, B, C, A)
Simultaneously controlled axes	2 axes [Max. 4 axes]
Designation of spindle axes	3 axes (1 path) X, Z, Y, B axes : 0.001 mm (0.0001 inch) C, A axes : 0.001 deg
Least setting Unit	X, Z, Y, B axes : 0.001 mm (0.0001 inch) C, A axes : 0.001 deg
Least input increment	G20 / G21
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	8.4 inch / 10.4 inch color LCD
Feedback	Absolute motor feedback
Stored stroke check 1	Over travel
Stored stroke check 2, 3	
PMC axis control	
Operation	
Automatic operation (Memory)	
MDI operation	
DNC operation	Needed DNC software / CF card
Program restart	
Wrong operation prevention	
Program check function	Dry run
Single block	
Search function	Program Number / Sequence Number
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
Thread synchronous cutting	
Thread cutting retract	
Variable lead thread cutting	
Multi / Continuous threading	
Feed function / Acc. & Dec. control	
Manual feed	Rapid traverse Jog : 0~2,000 mm/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	F1%, F5%, F25% / 50%, F100%
Override cancel	
Feed per minute	G98
Feed per revolution	G99
Look-ahead block	1 block
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
Direct drawing dimension program	Including Chamfering / Corner R

Program input	
Multiple repetitive cycles	I, II
Canned cycle for turning	
Auxiliary function / Spindle speed function	
Auxiliary function	M & 4 digit
Level-up M Code	High speed / Multi / Bypass M code
Spindle speed function	S & 4 digit, Binary output
Spindle override	0% ~ 150% (10% Unit)
Multi position spindle orientation	M19
Rigid tapping	
Constant surface speed control	G96, G97
Tool function / Tool compensation	
Tool function	T & 2 digit + Offset 2 digit
Tool life management	
Tool offset pairs	128 pairs
Tool nose radius compensation	G40, G41, G42
Geometry / Wear compensation	
Direct input of offset measured B	
Editing function	
Part program storage size	1280m (512KB)
No. of registerable programs	1000 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 & 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 20 languages
Display language switching	Selection of 5 optional Languages
LCD Screen Saver	Screen saver
Unexpected disturbance torque	BST (Back spin torque limit)
Function for machine type	
Cs contour control (C & A axes)	Mill, MS, Y, SY, LF-Mill, TTMS, TTSY
Polar coordinate interpolation	Mill, MS, Y, SY, LF-Mill, TTMS, TTSY
Cylindrical interpolation	Mill, MS, Y, SY, LF-Mill, TTMS, TTSY
Canned cycle for drilling	Mill, MS, Y, SY, LF-Mill, TTMS, TTSY
Spindle orientation expansion	MS, SY TTS, TTMS, TTSY
Spindle synchronous control	MS, SY TTS, TTMS, TTSY
Torque control	MS, SY TTS, TTMS, TTSY
Y axis offset	Y, SY, TTSY
Arbitrary angular control	Y, SY, TTSY
Composite / Superimposed control	MS, SY TTS, TTMS, TTSY
Balance cutting	MS, SY TTS, TTMS, TTSY
Option	
Optional block skip	9 ea
Fast ethernet	Need board option
Data server	Need board option
Protection of data at 8 levels	
Tool offset pairs	200 pairs
Part program storage size	5120m (2MB)
Polygon turning (2 Spindles)	Mill, MS, Y, SY, LF-Mill, TTMS, TTSY
Helical interpolation	
Manual Guide i	Conversational auto program
Dynamic graphic display	

Figures in inch are converted from metric values.

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

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HEADQUARTER

Changwon Technical Center / R&D Center / Factory

153, Jeongdong-ro, Seongsan-gu, Changwon-si,
Gyeongsangnam-do, Korea (Zip Code : 51533)

TEL : +82 55 280 9114 FAX : +82 55 282 9680

Uiwang Technical Center / R&D Center

37, Cheoldobangmulgwan-ro, Uiwang-si, Gyeonggi-do,
Korea (Zip Code : 16082)

TEL : +82 31 596 8209 Fax : +82 55 210 9804

OVERSEAS OFFICES

HYUNDAI WIA Machine Tools America

265, Spring Lake Drive, Itasca, IL, 60143

TEL : +1 630 625 5600

FAX : +1 630 625 4733

Jiangsu HYUNDAI WIA

Company No.6 Fenghuang Road,
Fenghuang Town, Zhangjiagang City,
Jiangsu province, China

TEL : +86 512 5672 6808

FAX : +86 512 5671 6960

Chengdu Branch Office

NO.508 Room, B Block, AFC Plaza, NO.88
Jiaozi Road, High-tech Zone, Chengdu,
China

TEL : +86 028 8665 2985

FAX : +86 028 8665 2985

HYUNDAI WIA Machine Tools Europe

Kaiserleipromenade 5, 63067 Offenbach,
Germany

TEL : +49 69271 472 701

FAX : +49 69271 472 719

Hyundai WIA Machine Tools China Shanghai Branch Office

1-3F, Bldg6, No.1535 Hongmei Road,
Xuhui District, Shanghai, China

TEL : +86 021 6427 9885

FAX : +86 021 6427 9890

Qingdao Branch Office

Room 1207, Cai Fu Building, 182-6 Haier
Middle Road, Qingdao, China

TEL : +86 532 8667 9334

FAX : +86 532 8667 9338

Raunheim Service Center Raunheim R&D Center

Frankfurter. 63, 65479 Raunheim,
Germany

TEL : +49 6142 9256 111

FAX : +49 6142 9256 100

Beijing Branch Office

Floor 14, Zhonghangji Plaza B, No.15
Ronghua South Road, BDA Dist., Daxing
Dist., Beijing, China 100176

TEL : +86 010 8453 9850

FAX : +86 010 8453 9853

Wuhan Office

306-2, A Tower, Jiayu Gpmggian, No12
Chuangye Road, Economic Development
Zone, Wuhan, Hubei, China

TEL : +86 027 5952 3256

FAX : +86 027 5952 3256

India Branch Office

#4/169, Rajiv Gandhi Salai, (OMR),
Kandanchavadi, Chennai-600 096,
Tamilnadu, India

TEL: +91-44-3290-1719

Guangzhou Branch Office

Room 311, Unit 1-3, POLY TAL TU WUN,
Hanxi Avenue, Panyu District, Guangzhou,
China

TEL : +86 020 8550 6595

FAX : +86 020 8550 6597

Chongqing Office

Room 951, #3, Jinrongcheng T3, Jiangbei,
Chongqing, China

TEL : +86 23 6701 2970



<http://machine.hyundai-wia.com>

Head Office & Factory

153, Jeongdong-ro, Seongsan-gu, Changwon-si, Gyeongsangnam-do **Tel** +82 55 280 9500

Overseas Sales Team

16F, 37, Cheoldobangmulgwan-ro, Uiwang-si, Gyeonggi-do **Tel** +82 31 593 8173

HYUNDAI WIA Machine Tools America

265 Spring Lake Drive, Itasca, IL, 60143 **Tel** +1 (630) 625 5600 **Fax** +1 (630) 625 4733

HYUNDAI WIA Machine Tools Europe

Kaiserleipromenade 5, D-63067 Offenbach, Germany **Tel** +49 69271 472 701 **Fax** +49 69271 472 719

India Branch Office

#4/169, Rajiv Gandhi Salai, (OMR), Kandanchavadi, Chennai-600 096, Tamilnadu, India **Tel** +91 44 3290 1719