

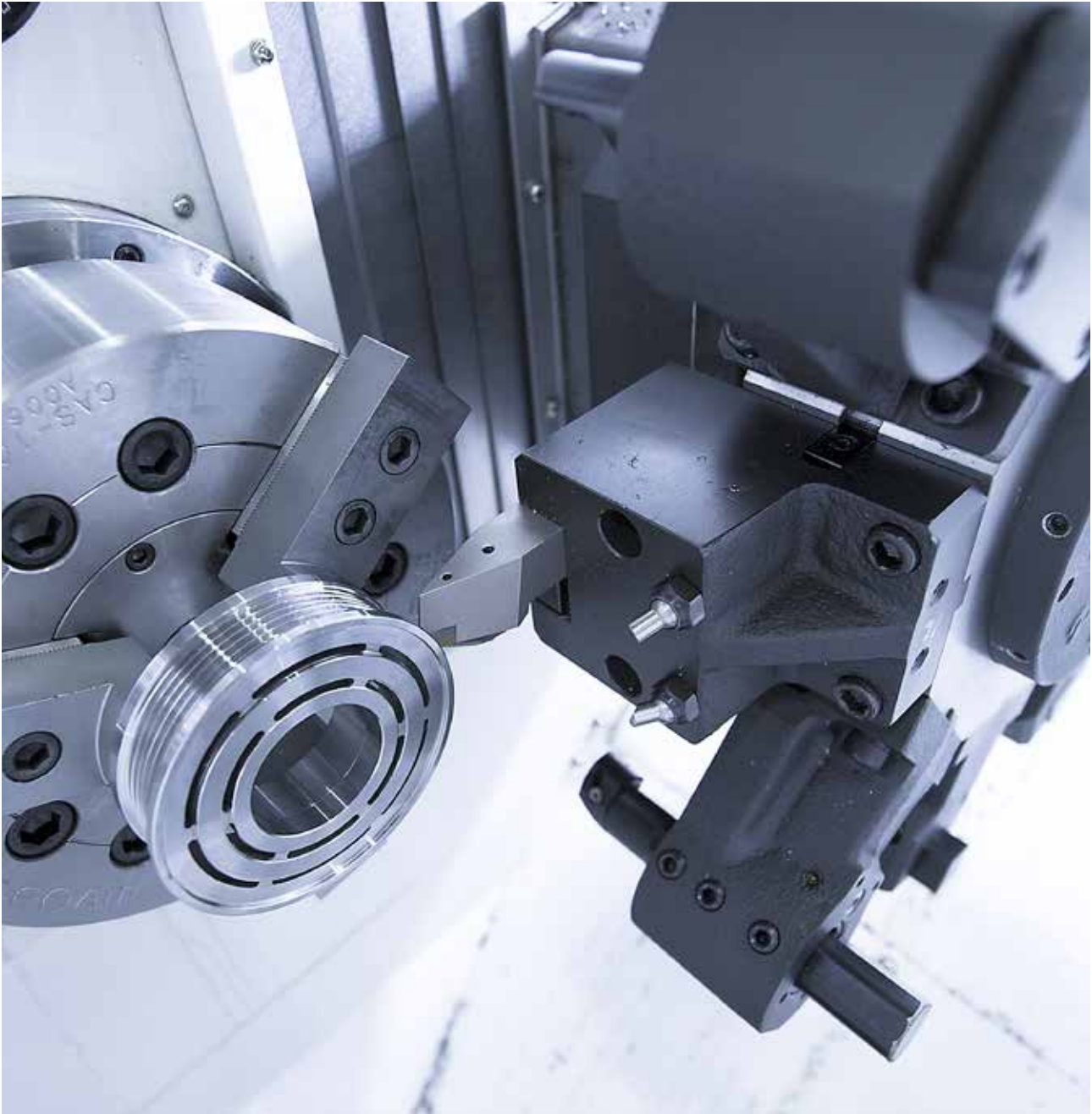
# LF1600 Series

HYUNDAI WIA Front Loading Turning Center



# Technical Leader

The Turning Center LF1600 Series, designed by Hyundai WIA with years of expertise and the latest technology, is a high performance machine designed for efficiency and maximum productivity.



## LF1600 Series

Max. Turning Dia.	mm(in)	Ø260 (10.2")
Max. Turning Length	mm(in)	165 (6.5")
Chuck Size	inch	6"
Bar Capacity	mm(in)	Ø45 (1.8")
Speed (rpm)	r/min	4,500
Motor (Max/Cont.)	kW(HP)	7.5/5.5 (10/7.4)
Travel(X/Z)	mm(in)	140/165 (5.5"/6.5")
No. of Tools	EA	2×10



Twin Spindle Front Loading CNC Turning Center

# LF1600 Series

- High speed gantry loader installation for cycle time reduction
- Vibration minimized through separated bed structure
- Symmetrical heat behavior headstock structure to minimize thermal displacement
- Box guideway for all axes
- High rigidity servo turret

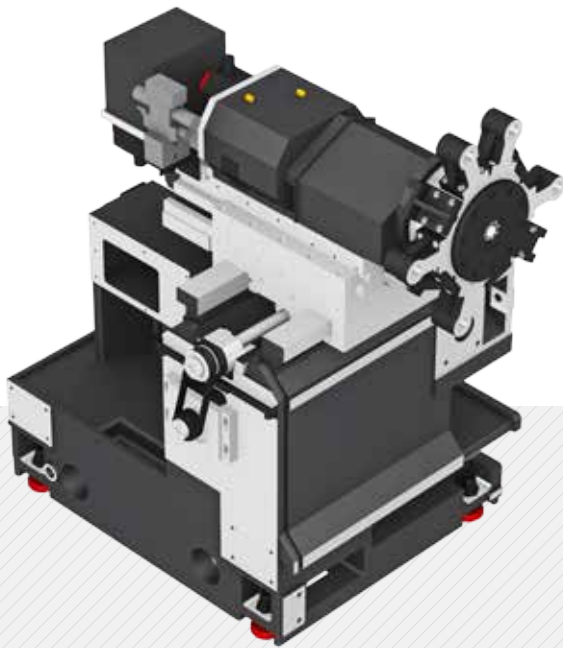


# 01

LF1600  
Series

## Basic Features

Optimized Layout and Design, Twin Spindle  
Front Loading CNC Turning Center



### Box Guideway

All axes of LF1600 Series are designed with box guideways. Box guideways provide unsurpassed long term rigidity and accuracy, even during heavy duty cutting.

### Ball Screw

In order to eliminate thermal growth and increase accuracy, all axes are driven by high precision double anchored ballscrews. The double anchored and pretensioned design provides outstanding positioning and repeatability with minimal thermal growth. Ball screws are connected directly to the servo motor to eliminate backlash.



### Powerful Servo Drives

Powerful servo drives provide quick acceleration and improve productivity by reducing non-cutting time. With the combination of box guideways, high performance can be achieved.

01

### High Precision Separated Bed Structure

The LF1600 series is designed as a separated bed structure, minimizing thermal growth and vibration, ensuring stable cutting capability.

02

### Main Spindle

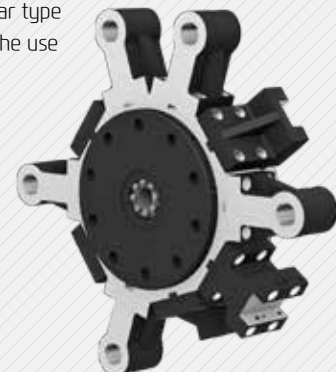
The main spindle has become sturdier by enlarging its diameter and thickness. Rigidity and accuracy are maintained by adoption of high precision angular ball bearing.



03

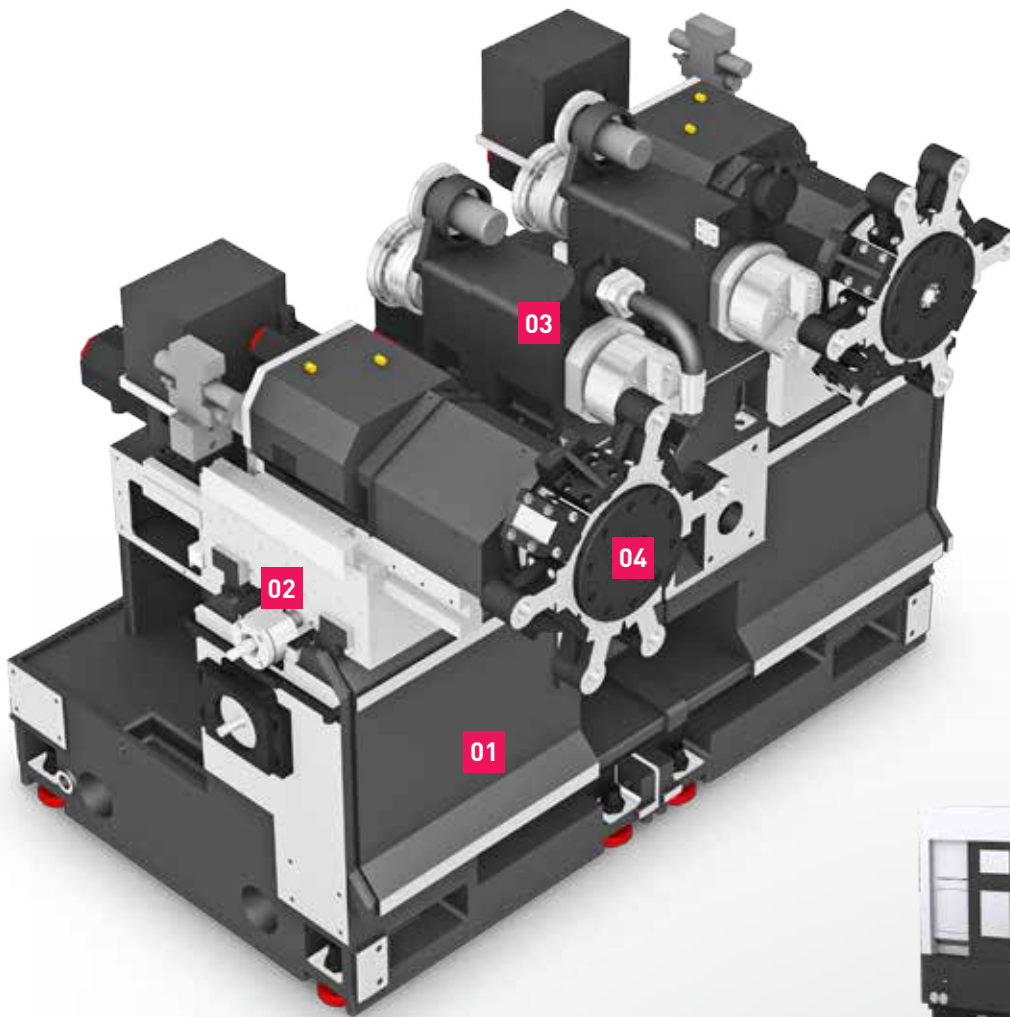
### Turret

The servo motor driven, star type 10-station turret enables the use of variety of tools.



04

## Basic Features



- 01 **Convenient Coolant Tank**  
Front side separation of coolant tank makes maintenance and repairs more convenient.



### Reduction of non-cutting time

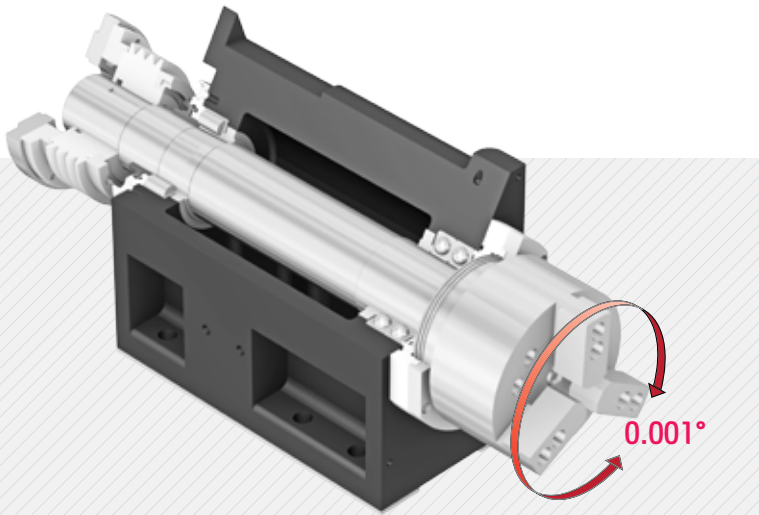
- 02 **Rapid Traverse Rate** (X/Z axis) : **24/24** m/min (**945/945** ipm)
- 03 **Travel** (X/Z axis) : **140/165** mm (**5.5"/6.5"**)
- 04 **Spindle Speed** : **4,500** rpm    05 **Spindle Output** (Max./Cont.) : **7.5/5.5** kW (**10/7.4** HP)
- 06 **Spindle Torque** (Max./Cont.) : **64/47** N·m (**47.2/34.7** lbf·ft)

02  
LF1600  
Series

## High Precision Spindle

Long Lasting High Accuracy & Excellent Performance  
CNC Turning Center





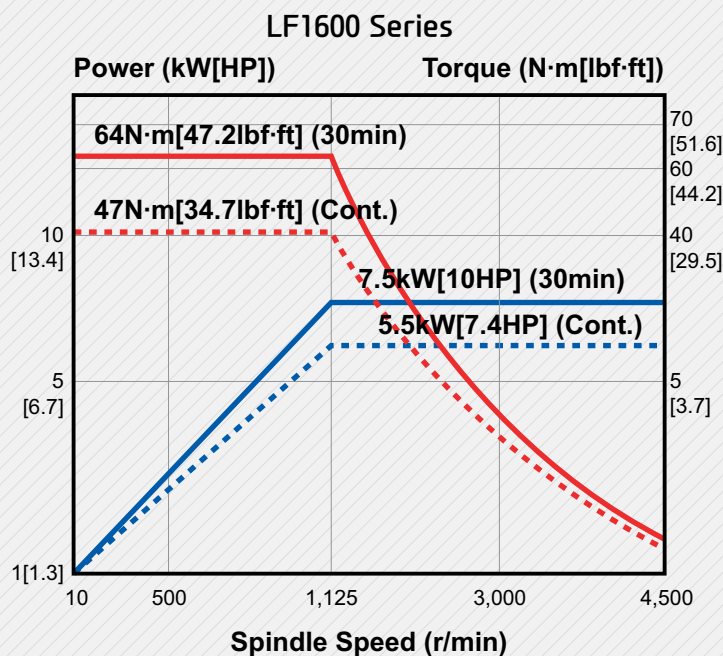
## Main Spindle

Rigidity is significantly improved by enlarging the spindle diameter and thickness. Also, accuracy is increased due to the use of highly reliable bearings.

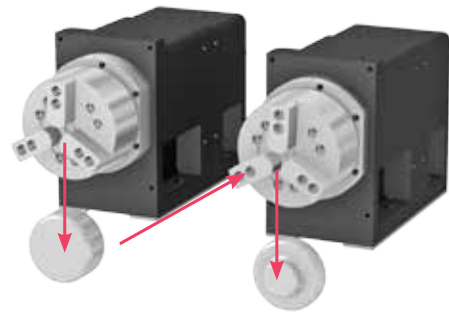
This improves durability and provides a high quality surface finish on every machined part.

## C-Axis Control

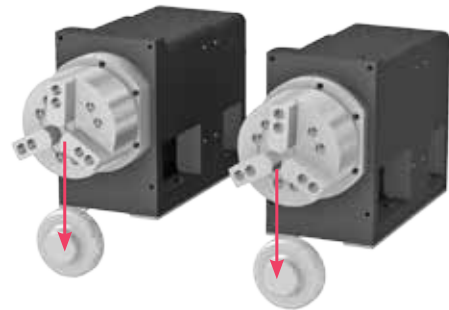
LF1600M/2SP features C-axis 0.001° controls, enabling the machining of various shapes and dimensions.



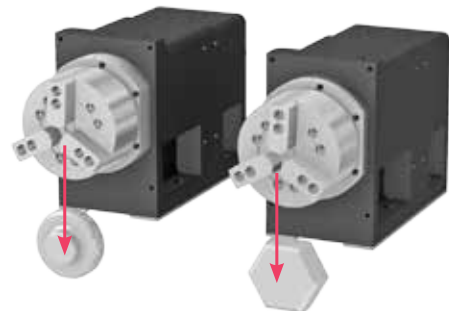
## Spindle Processing Flow



Parts requiring secondary operations are transferred from Z1 spindle to Z2 spindle



Same parts can be processed simultaneously by utilizing both spindles of Z1/Z2-axis with same parts.



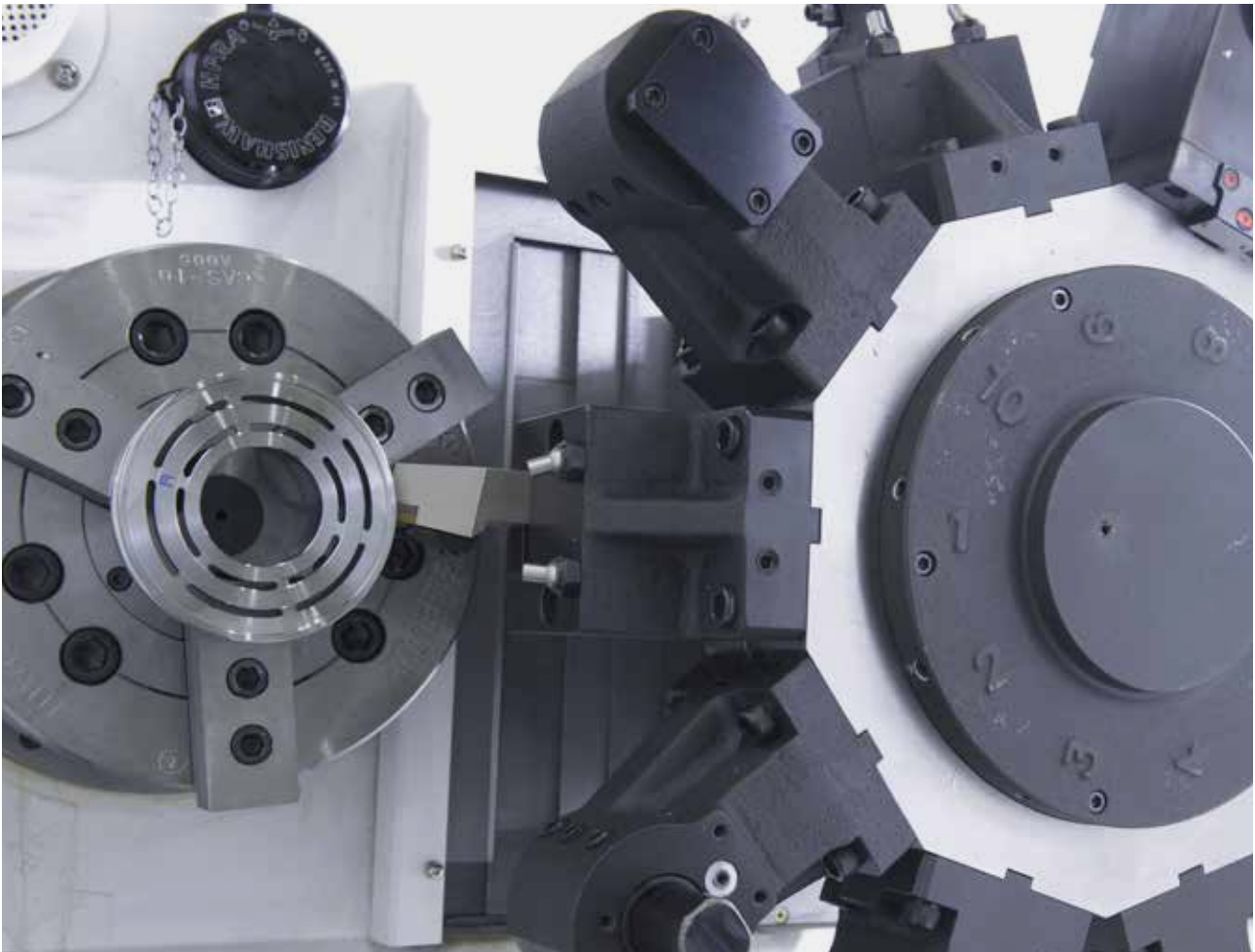
Different parts can be processed simultaneously by utilizing both spindles of Z1/Z2-axis with various parts.

# 03

LF1600  
Series

## Servo Turret

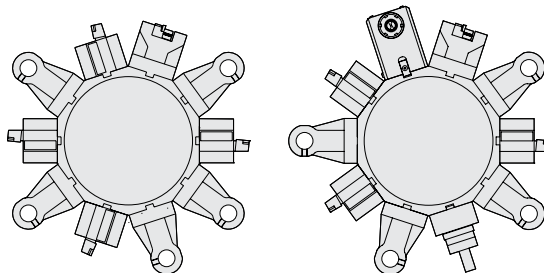
High speed, High Accuracy, Highly Reliable  
Servo Turret



### Turret

LF1600 Series is designed with high performance AC servo motors to enhance process reliability. Especially, 3-piece couplings enable accurate indexing. Also, powerful hydraulic tool clamping minimizes tools tip deviation caused by the load of tools, leading to excellent performance even during heavy duty operations.

- Number of Tools : **2×10** EA
- Tool Size (O.D.) : **□ 20 (□ 0.8")**
- Tool Size (I.D.) : **∅32 (∅1.3")**
- Indexing Time : **0.25** sec/step





## Mill Turret (BMT55P)

BMT turret increases tool performance and rigidity by securing each tool with 4 screws.

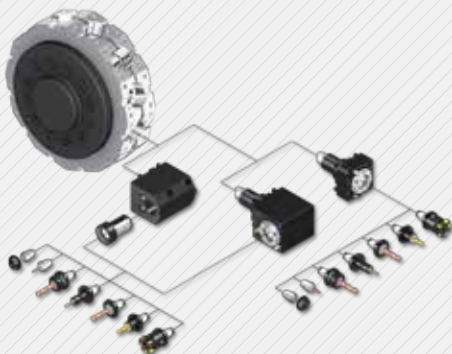
Overall cutting power and capability has improved for all applications.

- ⦿ Output (Max.) : **3.7/2.2 kW (5/3 HP)**
- ⦿ Speed : **4,000 rpm**
- ⦿ Collet Size : **Ø16 (Ø0.6") (ER25)**
- ⦿ Live Tool Type : **BMT55P**

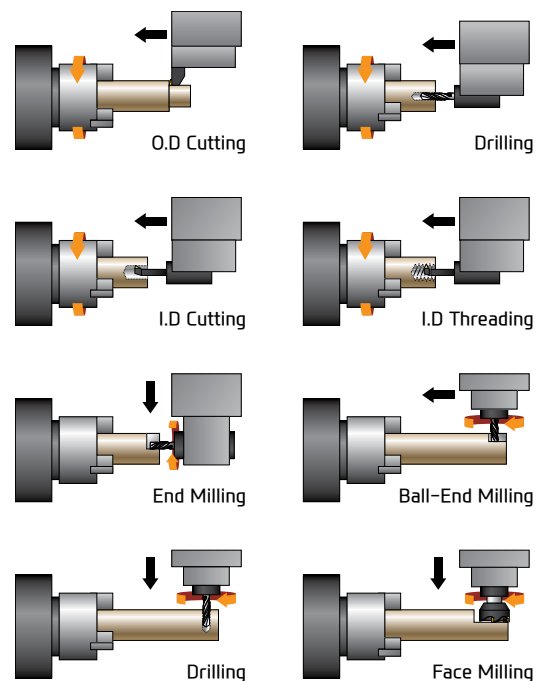
## Mill Tool Holder

Machining capability has increased with the addition of straight milling head tool holder, which can machine workpieces from the side, and angular milling head tool holder, which can perform I.D. operations.

A wide variety of additional tool holders for drilling and tapping can further enhance machining operations.



## Machining Variation



04  
LF1600  
Series

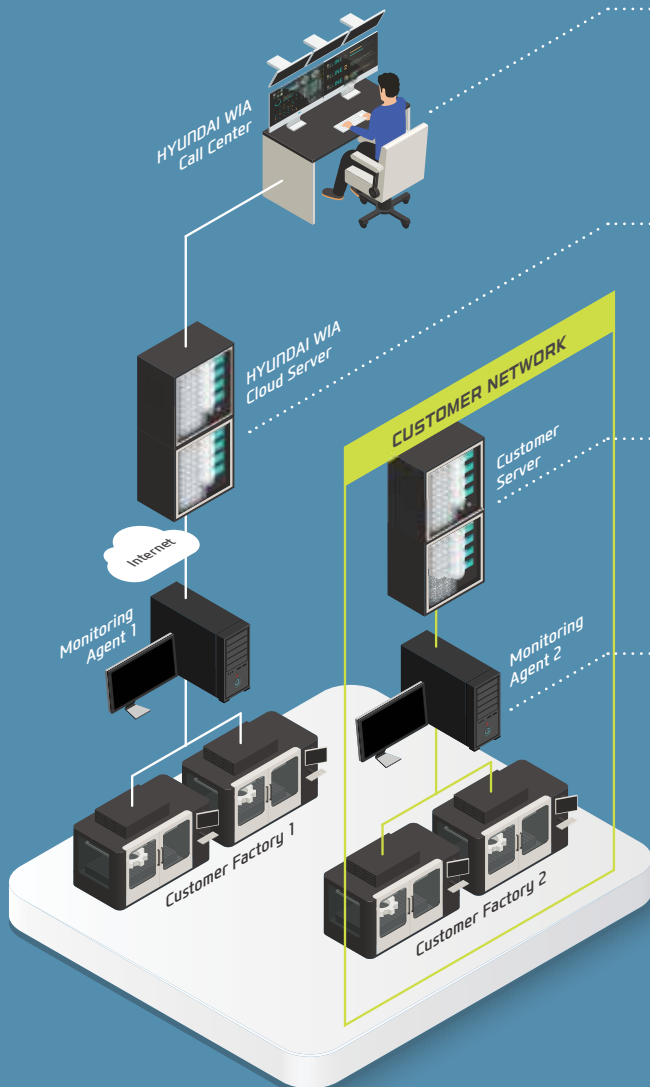
iRiS HYUNDAI WIA  
Smart Factory Solution

integrated Revolution of industrial Solution

## iRiS is HYUNDAI WIA's Smart Factory Solution.

iRiS, HYUNDAI WIA's revolutionary smart factory solution, consists of **Smart Monitoring System** for integrated management of HYUNDAI WIA machines around the world, and the **Smart Machining System** with ease, quality control, productivity and safety of the operator in mind.

## SMART MONITORING



### HW-MMS Remote (Remote service based)

Hyundai Wia Call Center's remote diagnosis service provides a HMI/video diagnostic function.



### HW-MMS Cloud (Cloud server based)

A cloud server-based equipment monitoring system for collecting and analyzing facility operation data.



### HW-MMS Edge (Customer Server Based)

A customer server-based equipment monitoring system for collecting and analyzing facility operation data.



### HW-MMS Collector (Machine data collector)

A dedicated program for collecting CNC data for MES/ERP.

A brand new manufacturing machine 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.

## HW-GLM (HYUNDAI WIA Gantry Loader Manager)

Set the position coordinates and the loader driver support features such as easy and convenient way to provide the user operating the loader to be used to support the software

## SMART MACHINING



**HW-MCG**  
HYUNDAI WIA  
Machine Guidance

Software that offers operation, maintenance, management monitoring and various user friendly features.



**HW-TDC**  
HYUNDAI WIA Thermal  
Displacement Compensation

Software that measures the changes in the external environment as well as heat emission during processing to help reduce thermal displacement.



**HW-TM**  
HYUNDAI WIA  
Tool Monitoring

A tool monitoring software which analyzes the load of the spindle motor to determine and monitor possible damage of tools.



**HW-ESS**  
HYUNDAI WIA  
Energy Saving System

An environmental friendly software that reduces the unnecessarily wasted standby power waiting for an operation.



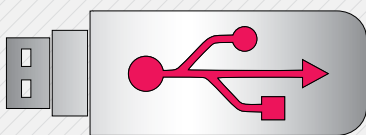
**HW-eDNC**  
HYUNDAI WIA ethernet  
Direct Numerical Control

This software allows transmission of NC data between PC and a machine's CNC. The processing programs can be managed on the PC through the ethernet or serial communication.



**HW-GLM**  
HYUNDAI WIA  
Gantry Loader Manager

Set the position coordinates and the loader driver support features such as easy and convenient way to provide the user operating the loader to be used to support the software



### USB Port

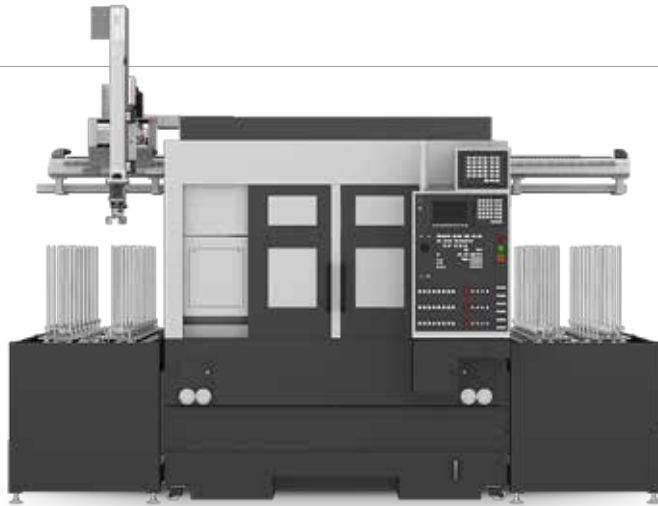
Convenience is increased when inputting and outputting program. The USB port is available in addition to the former input output methods such as CF memort card and LAN.

# 05

LF1600 Series

## Automation System

Various Devices for User Convenience



### Gantry Loader

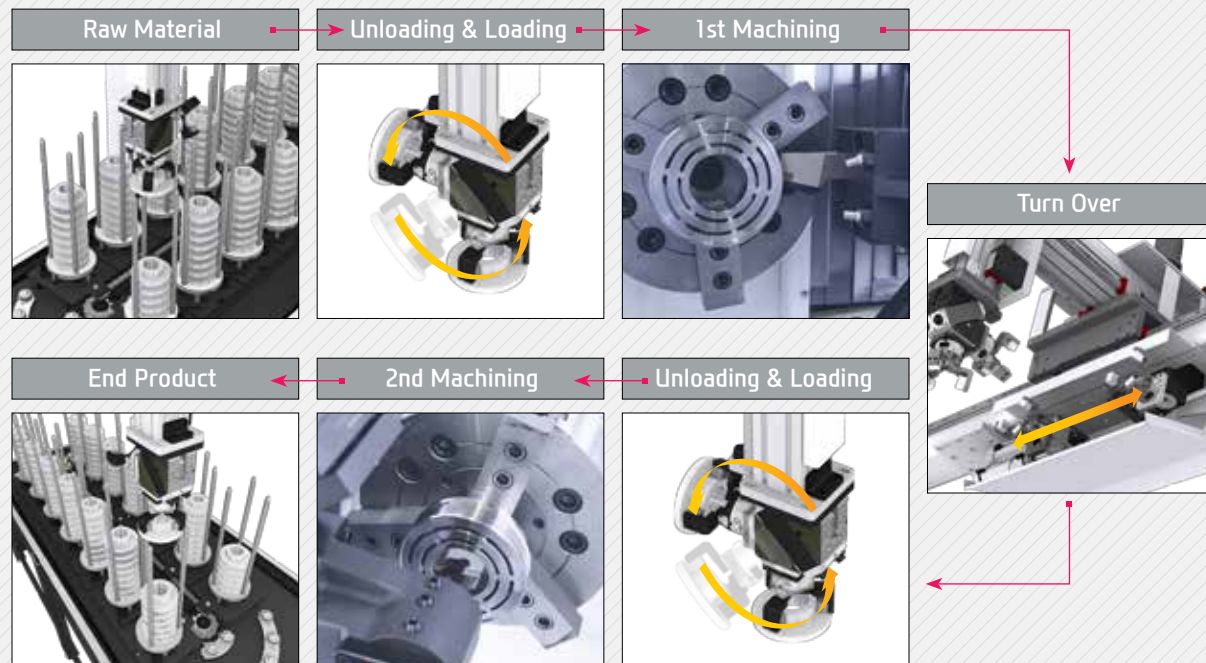
- ◉ Gantry Loader Work Size :  $\varnothing 120 \times 80$  mm ( $\varnothing 4.7'' \times 3.1''$ )
- ◉ Gantry Speed (X/Y/Z) : 150/110/60 m/min
- ◉ Gantry Loader Work Weight : 3 kg (6.6 lb) x 2 ea

### Work Feeder

- ◉ No. of Pallets : 14 Pallets with 3 Bars
- ◉ Pallet Speed : 1.7 m/min (8 sec / 1 pitch)
- ◉ Lifting Speed (Up-Down) : 3 m/min

### Gantry Loader Machining Process

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



# SPECIFICATIONS

## Standard & Optional

Spindle		LF1600/2SP	LF1600M/2SP
Main Spindle	6"	○	○
Hollow Chuck 3 Jaw	8"	☆	☆
Main Spindle	6"	●	●
Solid Chuck 3 Jaw	8"	☆	☆
Standard Soft Jaw (1set)		●	●
Chuck Clamp Foot Switch		●	●
2 Steps Hyd. Pressure Device		○	○
2 Steps Foot Switch		○	○
Spindle Inside Stopper		☆	☆
Chuck Open/Close Confirmation Device		○(CE:●)	○(CE:●)
Main Spindle 5° Index		☆	☆
C-Axis (0.001°)		-	●
<b>Turret</b>			
Turret		●	●
Mill Turret	BMT	-	●
Straight Mill Holder (Radial)	Collet Type,2ea	-	●
Angular Mill Holder (Axial)	Collet Type,2ea	-	●
Straight Mill Holder (Radial)	Adapter Type	-	○
Angular Mill Holder (Axial)	Adapter Type	-	○
Boring Sleeve		●	●
Drill Socket		●	●
U-Drill Holder		○	○
U-Drill Holder Sleeve		○	○
O.D Extension Holder	For Out-Dia	☆	☆
Angle Head		-	☆
<b>Coolant &amp; Air Blow</b>			
Standard Coolant (Nozzle)		●	●
Chuck Coolant (Upper Chuck)		●	●
Gun Coolant		○	○
Through Spindle Coolant (Only Hollow Cylinder & Special Chuck)		☆	☆
Thru Coolant for Live Tool		-	○
Chuck Air Blow (Upper Chuck)		○	○
Tail Stock Air Blow (Upper Tail Stock)		☆	☆
Turret Air Blow		☆	☆
Air Gun		○	○
Through Spindle Air Blow (Only Hollow Cylinder & Special Chuck)		☆	☆
High Pressure Coolant	6Bar (87psi)	●	●
	20Bar (290psi)	-	-
Power Coolant System (For Automation)		☆	☆
Coolant Chiller		☆	☆
<b>Chip Disposal</b>			
Coolant Tank	220 ℓ (58.1 gal)	●	●
Chip Conveyor (Hinge/Scraper)	Front (Rear)	○	○
	Rear (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	☆	☆
<b>Safety Device</b>			
Total Splash Guard		●	●
Chuck hydraulic pressure maintenance interlock		○(CE:●)	○(CE:●)
<b>Electric Device</b>			
Call Light	1Color : ■	●	●
Call Light	2Color : ■ ■	○	○
Call Light	3Color : ■ ■ ■	○	○
Call Light & Buzzer	3Color : ■ ■ ■ B	○	○

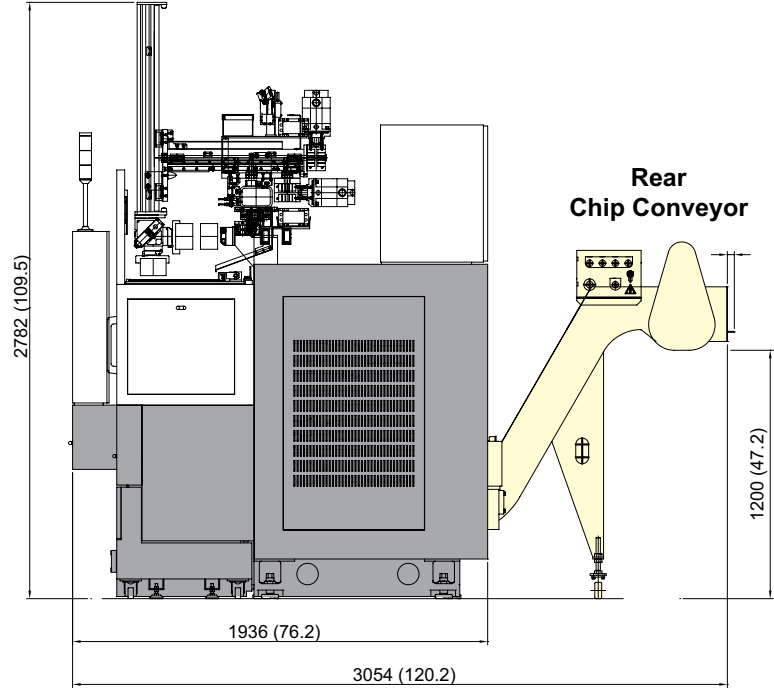
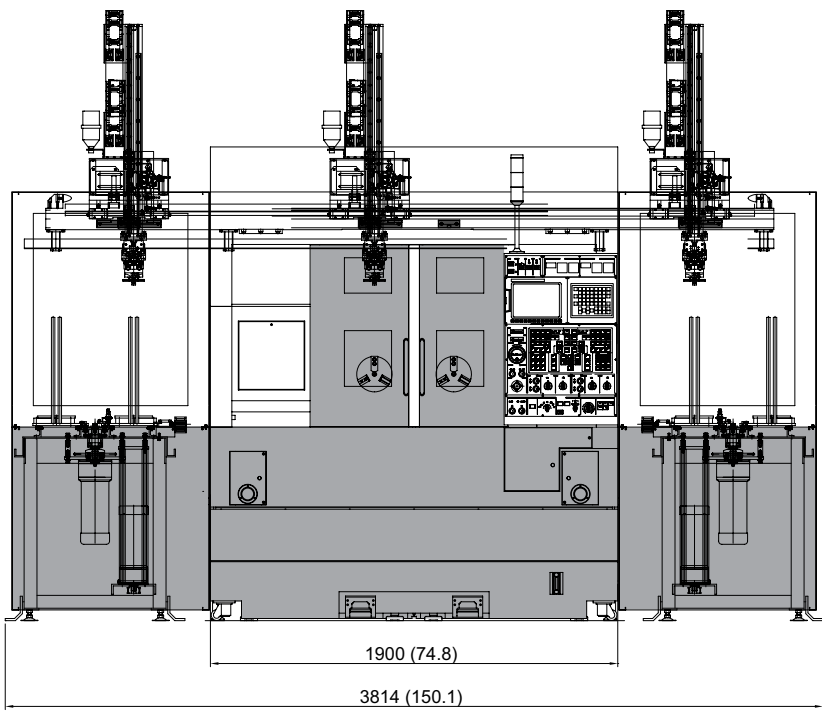
● : Standard ○ : Option ☆ : Prior Consultation - : Non Applicable

Electric Device		LF1600/2SP	LF1600M/2SP
Electric Cabinet Light		○	○
Remote MPG		○	○
Work Counter	Digital	○	○
Total Counter	Digital	○	○
Tool Counter	Digital	○	○
Multi Tool Counter	Digital	○	○
Electric Circuit Breaker		○	○
AVR (Auto Voltage Regulator)		☆	☆
Transformer	30KVA	-	-
	35KVA	○	○
Auto Power Off		○	○
<b>Measurement</b>			
Q-Setter	Removable Type	○	○
Automatic Q-Setter		-	-
Work Close Confirmation Device	TACO	☆	☆
	SMC	☆	☆
Work Setter		☆	☆
Linear Scale	X Axis	○	○
	Z Axis	○	○
Coolant Level Sensor (Only for Chip Conveyor)		☆	☆
Measuring System	For Automation	☆	☆
<b>Environment</b>			
Air Conditioner		○	○
Oil Mist Collector		☆	☆
Oil Skimmer (Only for Chip Conveyor)		☆	☆
MQL (Minimal Quantity Lubrication)		☆	☆
<b>Fixture &amp; Automation</b>			
Auto Door	Standard	☆	☆
	High Speed	☆	☆
Auto Shutter (Only for Automatic System)		●	●
Sub Operation Panel		☆	☆
Bar Feeder Interface		-	-
Bar Feeder (FEDEK)		-	-
Extra M-Code 4ea		○	○
Automation Interface		☆	☆
I/O Extension (IN & OUT)	16 Contact	○	○
	32 Contact	○	○
Turret Work Pusher (For Automation)		☆	☆
GANTRY Automation System		☆	☆
Turn Over Device		☆	☆
In Stocker (Rotary)	8/10/12/14 Pos	☆	☆
OUT Stocker (Rotary)	8/10/12/14 Pos	☆	☆
PG Chute		☆	☆
<b>Hyd. Device</b>			
Standard Hyd. Cylinder	Solid	●	●
Standard Hyd. Unit	35bar (507.6 psi) / 15 ℓ (4 gal)	●	●
<b>S/W</b>			
Machine Guidance (HW-MCG)		●	●
Energy Saving System (HW-ESS)		●	●
Tool Monitoring (HW-TM)		○	○
Spindle Heat Distortion Compensation(HW-TDC)		○	○
DNC software (HW-eDNC)		○	○
Machine Monitoring System (HW-MMS)		○	○
Conversational program (HW-DPRO)		☆	☆
Load Master (HW-GLM : FANUC)		○	○
<b>ETC</b>			
Tool Box		●	●
Customized Color	Need Munsel No.	☆	☆
CAD & CAM		☆	☆

# SPECIFICATIONS

## External Dimensions

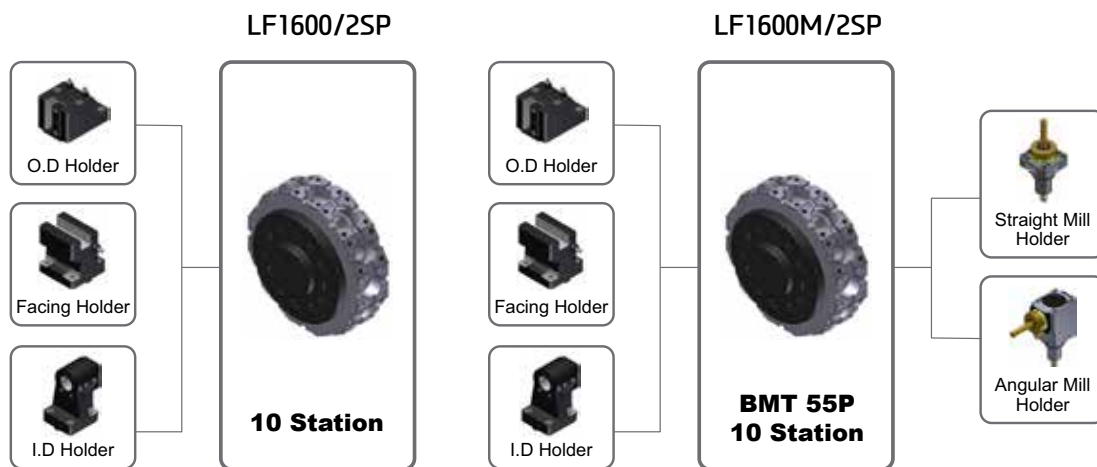
unit : mm(in)



# SPECIFICATIONS

## Tooling System

unit : mm(in)



## Tooling Parts Detail

ITEM			LF1600/2SP		LF1600M/2SP	
			mm Unit	inch Unit	mm Unit	inch Unit
Turning Holder	O.D Holder	Right/Left	8	8	6	6
	Facing Holder		2	2	2	2
Boring Holder	I.D Holder	Single	10	10	8	8
	U-Drill Tool Holder	Tool Holder	-	-	Opt	Opt
Driven Holder	Straight Mill Holder	Standard	-	-	2	2
	Angular Mill Holder	Standard	-	-	2	2
Socket	Boring	Ø8 (Ø5/16")	2	2	2	2
		Ø10 (Ø3/8")	2	2	2	2
		Ø12 (Ø1/2")	2	2	2	2
		Ø16 (Ø5/8")	2	2	2	2
		Ø20 (Ø3/4")	2	2	2	2
		Ø25 (Ø1")	2	2	2	2
	Drill	MT 1 × MT 2	2	2	2	2
		MT2	2	2	2	2
	ER Collet		-	-	2 Set	2 Set

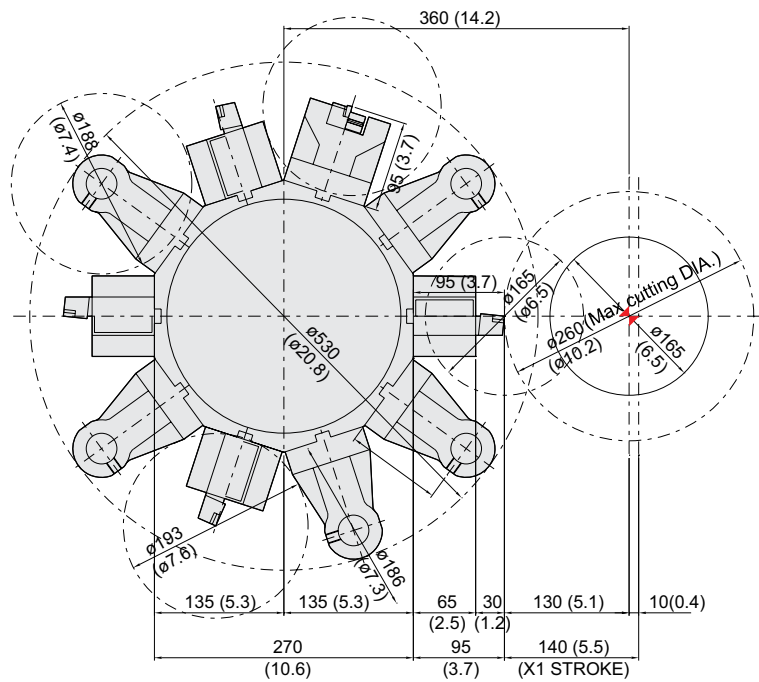
Specifications are subject to change without notice for improvement.

# SPECIFICATIONS

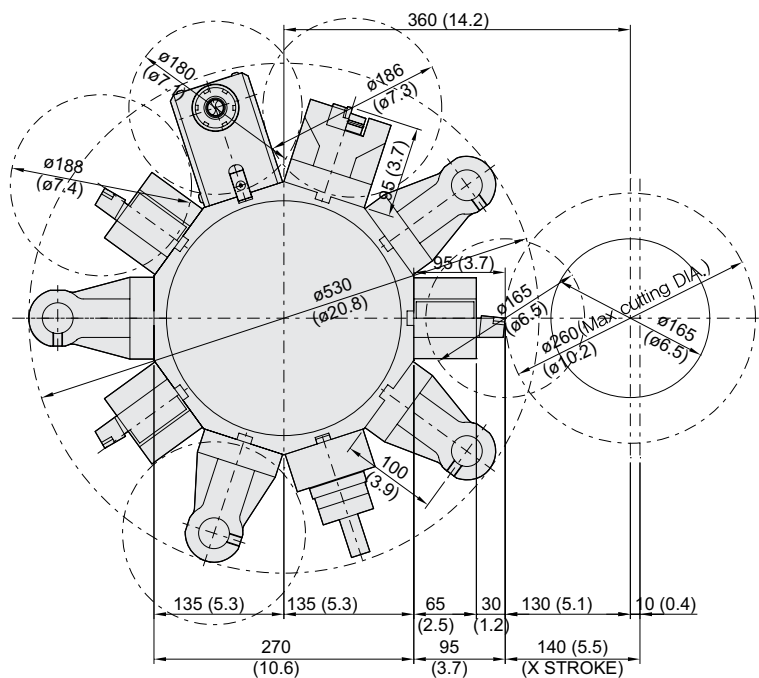
Interference

unit : mm(in)

LF1600/2SP



LF1600M/2SP

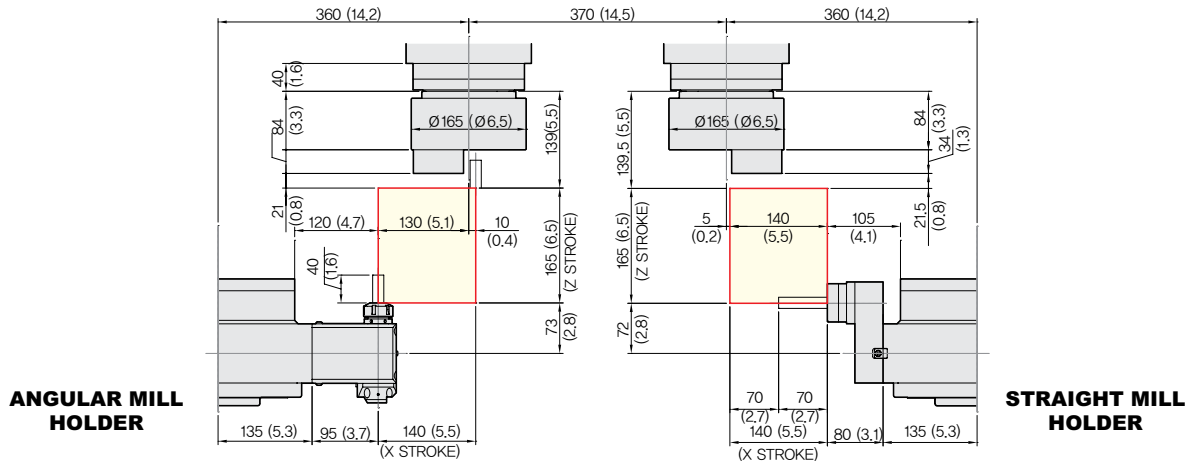
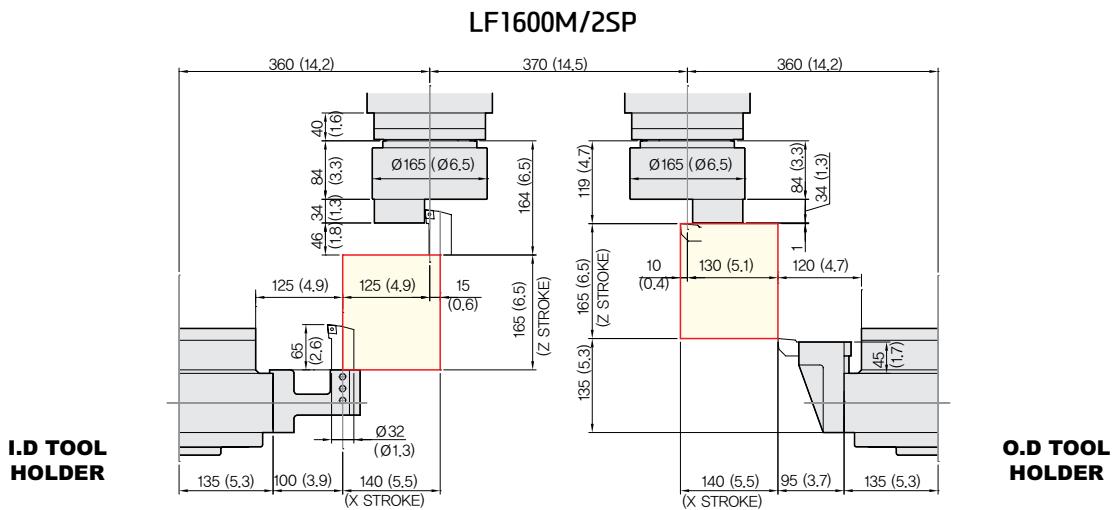
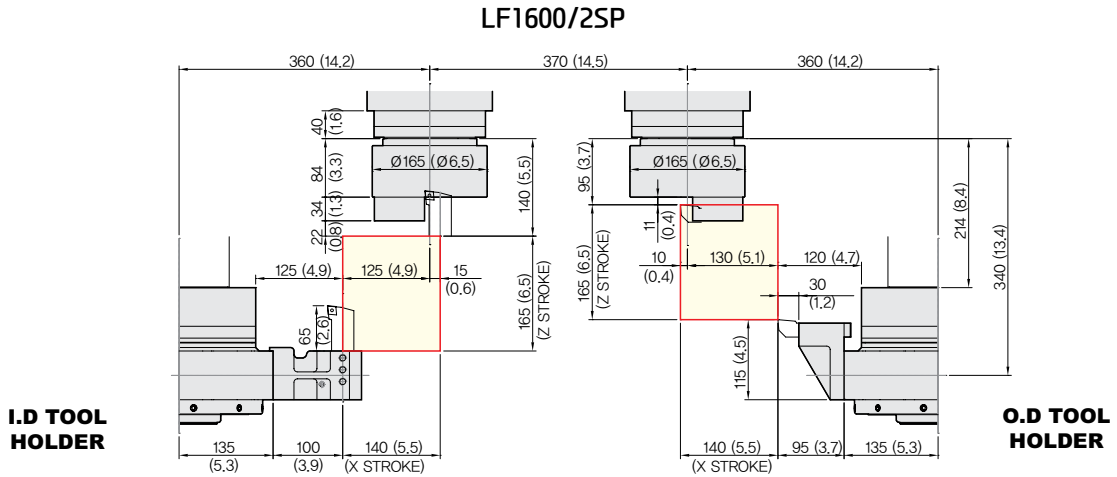




# SPECIFICATIONS

## Tooling Travel Range

unit : mm(in)



# SPECIFICATIONS

## Specifications

[ ] : Option

ITEM			LF1600/2SP	LF1600M/2SP
CAPACITY	Swing Over the Bed	mm(in)	Ø370 (14.6")	
	Max. Turning Dia.	mm(in)	Ø260 (10.2")	
	Max. Turning Length	mm(in)	165 (6.5")	
	Bar Capacity	mm(in)	Ø45 (1.8")	
SPINDLE	Chuck Size	inch	6"	
	Spindle Bore	mm(in)	Ø53 (2.1")	
	Spindle Speed (rpm)	r/min	4,500	
	Motor (Max/Cont.)	kW(HP)	7.5/5.5 (10/7.4)	
	Torque (Max/Cont.)	N·m(lbf·ft)	64/47 (47.2/34.7)	
	Spindle Type	-	BELT	
	Spindle Nose	-	A2-5	
C-axis Indexing	deg	-	0.001°	
FEED	Travel (X/Z)	mm(in)	140/165 (5.5"/6.5")	
	Rapid Traverse Rate (X/Z)	m/min(ipm)	24/24 (945/945)	
	Slide Type	-	BOX GUIDE	
TURRET	No. of Tools	EA	2×10	
	Tool Size	OD	□ 20 (0.8")	
		ID	Ø32 (1.3")	
	Indexing Time	sec/step	0.25	
LIVE TOOL	Motor (Max/Cont.)	kW(HP)	-	3.7/2.2 (5/3)
	Milling Tool Speed (rpm)	r/min	-	4,000
	Torque (Max/Cont.)	N·m(lbf·ft)	-	26.2/14 (19.3/10.3)
	Collet Size	mm(in)	-	Ø16 (0.6") ER25
	Type	-	-	BMT55P
TAIL STOCK	Taper	-	-	
	Quill Dia.	mm(in)	-	
	Quill Travel	mm(in)	-	
	Travel	mm(in)	-	
TANK CAPACITY	Coolant Tank	ℓ (gal)	220 (58.1)	
	Lubricating Tank	ℓ (gal)	4 (1)	
POWER SUPPLY	Electric Power Supply	kVA	25	
	Thickness of Power Cable	Sq	Over 25	
	Voltage	V/Hz	220/60 (200/50*)	
MACHINE	Floor Space (L×W)	mm(in)	1,900×1,936 (74.8"×76.2")	
	Height	mm(in)	2,410 (94.9")	
	Weight	kg(lb)	4,500 (9,921)	
PC	Controller	-	FANUC 31i-B	

\*) 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

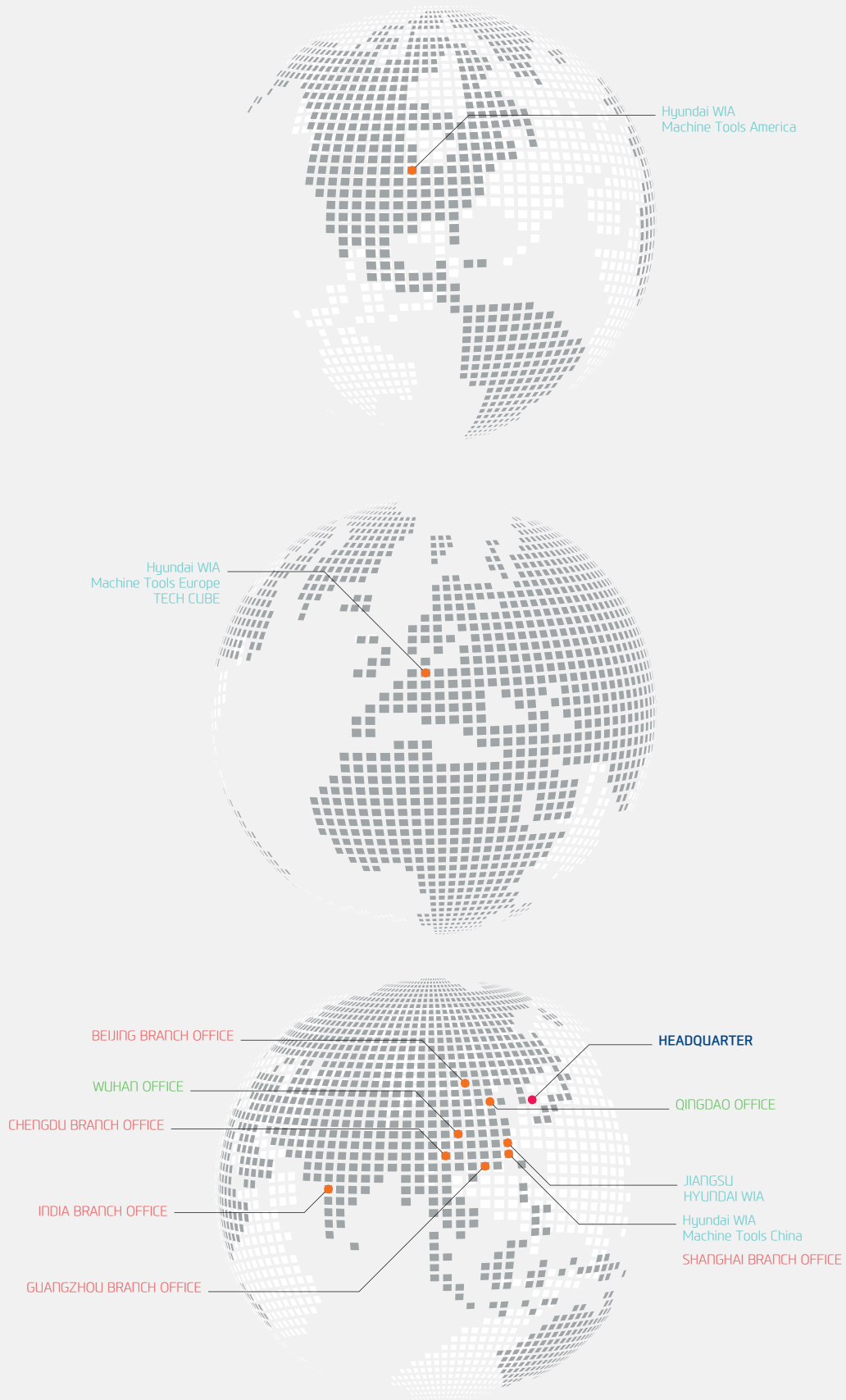
Controlled axis / Display / Accuracy Compensation	
Control axes	4 axes (X, Z, Y, C) / 6 axes (X, Z, Y, B, C, A) 7 axes (X1/Z1, X2/Z2, B2, C1/C2) 8 axes (X1/Z1, X2/Z2, Y1, B2, C1/C2)
Simultaneously controlled axes	2 axes [Max. 4 axes]
Designation of spindle axes	4 axes (1 path), 6 axes (2 path Total)
Least setting Unit	X, Z, Y, B axes : 0.001 mm (0.0001 inch) C, A axes : 0.001 deg
Least input increment	X, Z, Y, B axes : 0.001 mm (0.0001 inch) C, A axes : 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 stroke check 2, 3	
PMC axis control	
<b>Operation</b>	
Automatic operation (Memory)	
MDI operation	
DNC operation	Needed DNC software / CF card
Program restart	
Wrong operation prevention	
Program check function	Dry run, Program check
Single block	
Search function	Program Number / Sequence Number
<b>Interpolation functions</b>	
Piano 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	
<b>Feed function / Acc. &amp; Dec. control</b>	
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%, F25%, 50%, F100%
Override cancel	
Feed per minute	G98
Feed per revolution	G99
Look-ahead block	1 block
<b>Program input</b>	
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
Multiple repetitive cycles I, II	

<b>Program input</b>	
Canned cycle for turning	
Manual Guide i	Conversational auto program
<b>Auxiliary function / Spindle speed function</b>	
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
<b>Tool function / Tool compensation</b>	
Tool function	T 2 digit + Offset 2 digit
Tool life management	
Tool offset pairs	64 pairs
Tool nose radius compensation	G40, G41, G42
Geometry / Wear compensation	
Direct input of offset measured B	
<b>Editing function</b>	
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	
<b>Data input / output &amp; Interface</b>	
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	
<b>Setting, display and diagnosis</b>	
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)
<b>Function for machine type</b>	
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
<b>Option</b>	
Additional optional block skip	9 ea
Fast ethernet	Needed option board
Data server	Needed option board
Protection of data at 8 levels	
Tool offset pairs	99 pairs / 200 pairs
Part program storage size	2560m (1MB) / 5120m (2MB)
Polygon turning (2 Spindles)	Mill, MS, Y, SY, LF-Mill, TTMS, TTSY
Helical interpolation	
Dynamic graphic display	
Direct drawing dimension program	Including Chamfering / Corner R

Figures in inch are converted from metric values.

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

# GLOBAL NETWORK



# GLOBAL NETWORK



## 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 8213      Fax : +82 55 210 9804

## OVERSEAS OFFICES

### HYUNDAI WIA Machine Tools America

450 Commerce Blvd. Carlstadt, NJ 07072

TEL : +1 630 625 5600

### Jiangsu HYUNDAI WIA

Company No.6 Fenghuang Road,  
Fenghuang Town, Zhangjjagang 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 TECH CUBE

Alexander-Fleming-Ring 57, 65428  
Rüsselsheim Germany

TEL: +49 6142 9256 0

FAX: +49 6142 9256 100

### Hyundai WIA Machine Tools China Shanghai Branch Office

2-3F, Bldg6, No.1535 Hongmei Road,  
Xuhui District, Shanghai, China

TEL : +86 021 6427 9885

FAX : +86 021 6427 9890

### Qingdao Office

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

TEL : +86 0532 8667 9334

FAX : +86 0532 8667 9338

### India Branch Office

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

TEL: +91-44-3290-1719

### 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

Room 302, B Tower, Nova Center,  
Dongfeng Three Road, Zhuankou,  
Wuhan, Hubei, China

TEL : +86 027 5952 3256

FAX : +86 027 5952 3256

### 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



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

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**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 31 596 8213

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**HYUNDAI WIA Machine Tools America**

450 Commerce Blvd. Carlstadt, NJ 07072 **Tel** +1 (630) 625 5600

**HYUNDAI WIA Machine Tools Europe TECH CUBE**

Alexander-Fleming-Ring 57, 65428 Rüsselsheim Germany **Tel** +49 6142 9256 0 **Fax** +49 6142 9256 100

**India Branch Office**

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