

**LM**

**2500TTSY II**

Twin Spindle & Turret - Multitasking CNC Turning Center

HYUNDAI WIA CNC Multi Axis Turning Center



Max. Turning Dia.	mm(in)	Upper : Ø390 (15.4") / Lower : Ø300 (11.8")
Max. Turning Length	mm(in)	900 (35.4")
Chuck Size	inch	10"
Bar Capacity	mm(in)	Ø81 (3.2")
Spindle Speed	r/min	4,000 (Built-in)
Sp. Power (Max./Cont.)	kW(HP)	30/22 (40/29.5)
No. of Tools	EA	2×12 [2×24] (BMT65)
Travel	mm(in)	X1/X2/Z1/Z2/Y/ZB : 270/195/920/920/120{±60}/920 (10.6"/17.7"/36.2"/36.2"/14.7"/36.2")
Rapid Traverse Rate	m/min	X1/X2/Z1/Z2/Y/ZB : 24/24/24/24/12/24

[ ] : Option

# LM 2500TTSY II

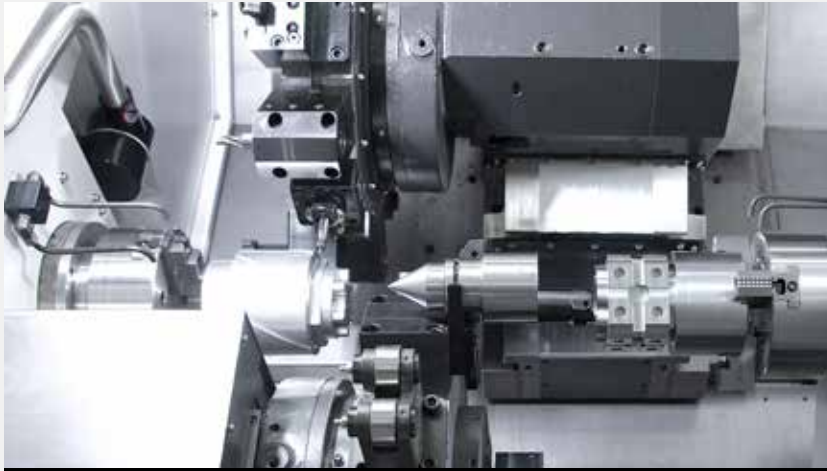
Twin Spindle & Turret  
Multitasking CNC Turning Center



- ① Multitasking Structure
- ② All Axis Box Guideway
- ③ Built-in Spindle (Main/Sub)
- ④ Y-Axis Function
- ⑤ Twin Turret (Upper/Lower)

Highlight

# 01 \_ Multitasking Structure

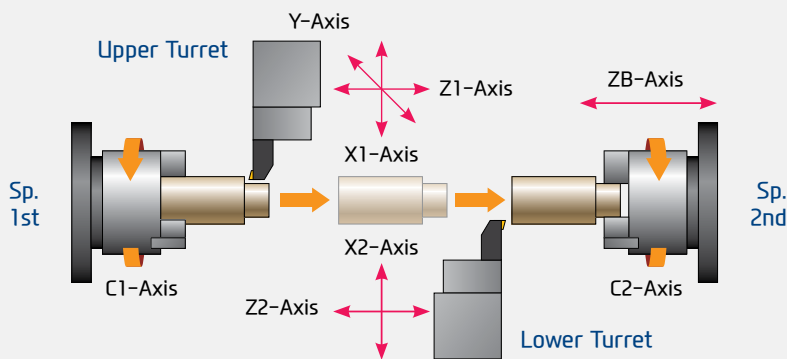


## TWIN SPINDLE AND TWIN TURRET FOR MULTIFLEXIBILITY

LM2500TTSY II demonstrates Hyundai-WIA's technological capability by machining any type of complex parts with twin spindles, twin turrets and additional Y-axis.

### Rear Machining

Upon completion of the external operation, the sub spindle rotates at the same rate as the main spindle and the workpiece is handed over to the sub spindle. Once the workpiece is secured in the sub spindle rear processing is possible.



First and second operations can be performed with a single setup.

Two different operations are possible to machine simultaneously on two spindles.

Multitasking (Turning, Milling Y-Axis Machining)





**Box Guideway**

Highlight

## 02 \_ All Axis Box Guideway



### Box Guideway

All axes on the LM2500TT II is designed with Box Guideways to provide rigidity and accuracy even during heavy duty operations.

### High Performance Ball Screw

World-class ball screws were applied in LM2500TTSY II for accurate positioning, minimization of thermal displacement, and reinforced durability.

The ball screw deformity was especially minimized by applying high-precision pre-load to the bearings placed in multiple rows at both ends of the ball screws.

**Travel** (X1/X2/Z1/Z2/Y/ZB)

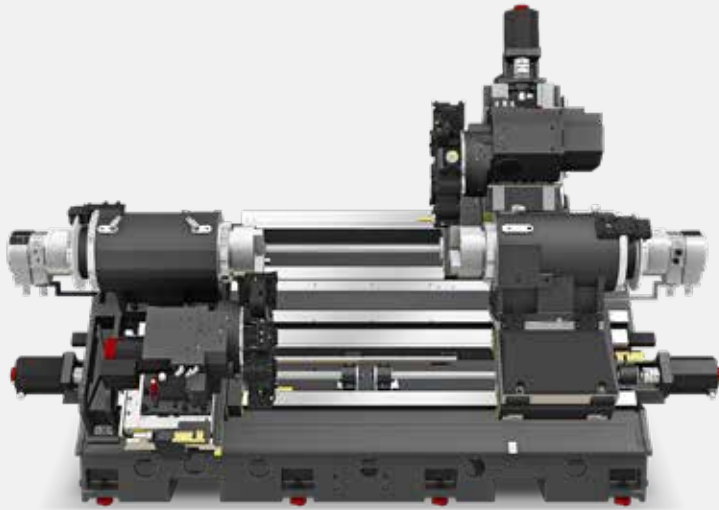
270/195/920/920/120{±60}/920 mm

**Rapid Traverse Rate** (X1/X2/Z1/Z2/Y/ZB)

24/24/24/24/12/24 m/min

Highlight

## 03 \_ Main & Sub Built-in Spindle



### Built-in Spindle

The main and sub spindles with a built-in motor structure can minimize the vibration and heat generated during high-speed rotation, which makes them ideal for high-precision machining. Also, the spindle chiller, installed to minimize thermal displacement of the main and sub spindles, ensures the quality of products despite long machining process.

### Improved Spindle Power for Heavy Duty Cutting machining

The heavy duty machining capability has been improved significantly with the maximum output increased by 15% and the maximum torque increased by 67% compared to the previous model.

Max. Power 26 kW  **30 kW**

Max. Torque 433 N·m  **724 N·m**

### Increased Bar Capacity

The bar capacity has been increased from Ø76mm to Ø81mm.

Chuck	Max. Turning Length	Max. Turning Dia. (UP/LO)
10"	900 mm (35.4")	Ø390/Ø300 mm (Ø15.4"/Ø11.8")





# Y-Axis Multitasking

Highlight

## 03 \_ Y-Axis Function



STANDARD ATTACHMENT OF 12 TOOLS/OPTIONAL ATTACHMENT OF 24 TOOLS →  
VARIOUS TYPES OF MACHINING AVAILABLE

### Wedge Type Y-Axis Structure

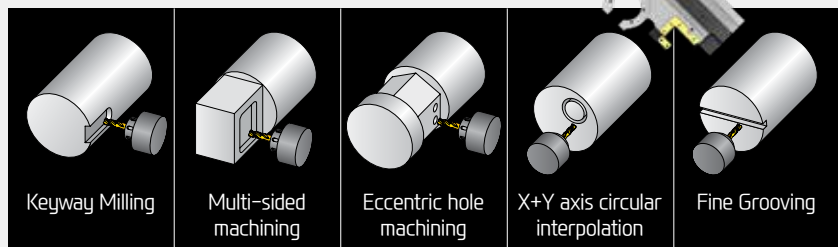
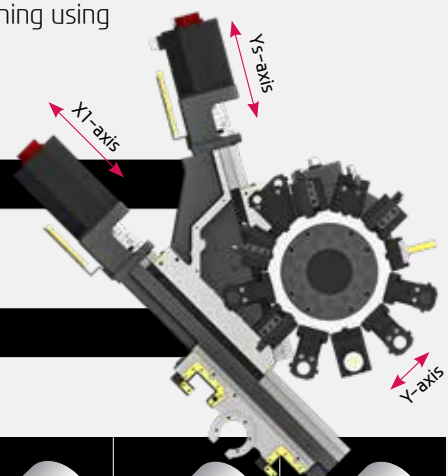
The wedge type Y-axis structure offers superior rigidity and it can maintain stable machining precision even for heavy duty machining. The Y-axis structure especially allows machining at a location away from the center, which allows almost all machining to be performed by a single machine, without secondary machining using a separate machining center.

#### Y-axis Travel

120 {±60} mm (4.7" {±2.3"})

#### Y-axis Rapid Traverse Rate

12 m/min



## Highlight

# 05 \_ Upper/Lower 2 Turrets



### Twin Mill Turret

The upper and the lower turrets are equipped with powerful servo motors, which guarantee high productivity and precision.

In particular, a total of 24 (Option 48) tools can be installed on both turrets, and high speed precision machining of complex products is possible with a single setup.

### Improved Mill Turret Machining Capability

The continuous output, maximum rpm, and torque were improved significantly compared to the previous model.

Max. Speed	4,000 rpm	>	<b>5,000 rpm</b>
Power (Cont.)	2.2 kW	>	<b>3.7 kW</b>
Torque (Max.)	49.1 N·m	>	<b>70 N·m [95.5 N·m]</b>
Torque (Cont.)	19.6 N·m	>	<b>35.4 N·m</b>

[ ] : AMP UP

#### BMT65

Tool Size (O.D/I.D)

Collet Size

□ 25/Ø40 mm (□ 1"/Ø1 1/2")    Ø20mm (Ø3/4") – ER32

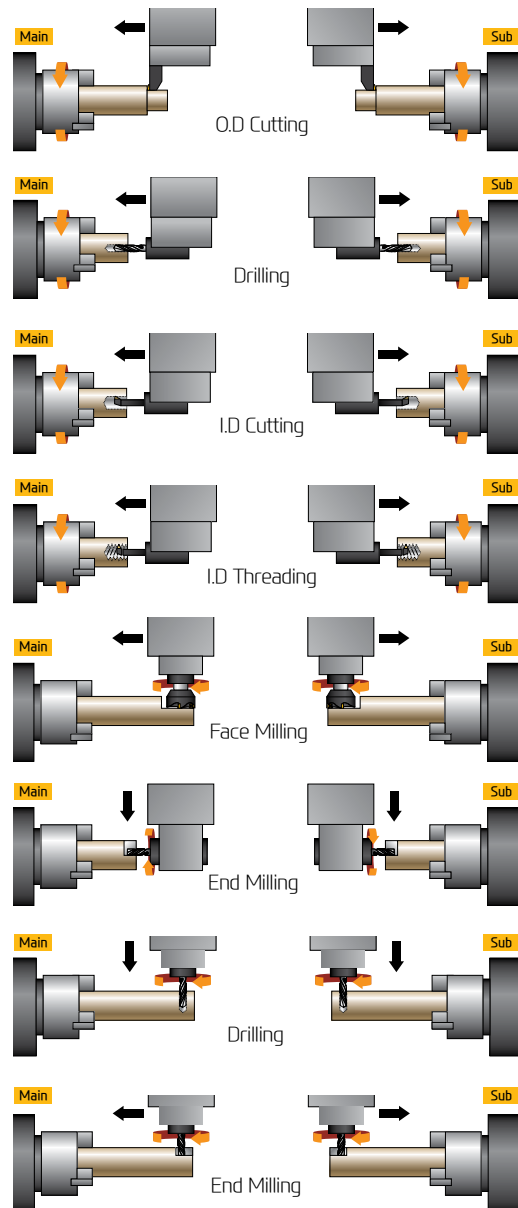


**BMT65 / 5,000rpm**



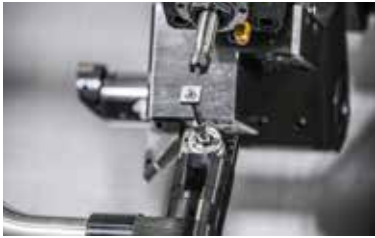
Cutting Possibility

## Machining Application



## Convenience

### High Precision & ECO System



#### Automatic Q-Setter

Cutting tools are calibrated quickly and accurately with the addition of a q-setter. Each tool tip is touched off manually using a sensor that inputs the position automatically.



#### Linear Scale

Linear scales increase positioning accuracy and reduce distortion caused by thermal growth, thus ensuring a more accurate finished part



#### Touch Sensor

Workpiece coordinate values can be set automatically using the optional spindle probe.



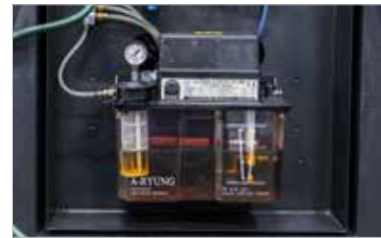
#### Oil Skimmer

An oil skimmer can increase coolant and tool life by removing tramp oil contaminants.



#### Mist Collector

Mist Collector reduces the amount of smoke and oil mist in the air. This helps build a safe and comfortable working environment and improve durability.



#### Lubrication System

By applying lubricant only when the machines axis are moving lubrication consumption is reduced by compared to standard systems.

#### Coolant Tank

Hinge	Chip Type : Roughing Chip, Long Chip, Chip complex	Material : SS41, 45C, Cast Steel
	Highly efficient when disposing a lot of chips. Capable of handling stringy chips.	
Scraper	Chip Type : Finely broken chip blown out	Material : cast Iron, Nonferrous
	Convenient for shortly cut chips.	
❖ Screw	Chip Type : The lower portion of micro-chips	Material : Steel, Casting
	Compresses and ejects chips to reduce chip Trouble.	
❖ Drum Filter	Chip Type : Powder, Micro Chip	Material : AL
	Advantageous in precision, as the chips do not flow in to the coolant nozzle.	

❖ When ordering a screw or drum filter chip conveyor, prior consult with hyundai wia's sales person.

## Automation System



### Robot System

With its know-how and experience, Hyundai WIA is globally recognized in the field of automation. Robot automation features flexible responsive-ness, convenience and maintenance regardless of type for automation construction.

### Bar Feeder System

Bar feeder system enables automation which leads to efficiency improvement.

Long Type	: 3 m (118.1")	Short Type	: 1.5 m (59.1")
Bar Capacity	: $\varnothing 42$ (1.7")	Bar Capacity	: $\varnothing 65$ (2.6")



### Parts Catcher

An optional parts catcher collects finished parts without the need to open the door, adding productivity, especially when a bar feeder is attached.

# Specifications

## Standard & Optional

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

Spindle		LM2500TTSY II
Main Spindle	10"	●
Hollow Chuck 3 Jaw	12"	-
Main Spindle	10"	○
Solid Chuck 3 Jaw	12"	-
Sub Spindle	10"	●
Hollow Chuck 3 Jaw	12"	-
Sub Spindle	10"	○
Solid Chuck 3 Jaw	12"	-
Standard Soft Jaw (1set)		●
Chuck Clamp Foot Switch		●
2 Steps Hyd. Pressure Device		○
Spindle Inside Stopper		☆
5" Index		-
Cs-Axis (0.001")		●
Chuck Open/Close Confirmation Device		●
2 Steps Chuck Foot Switch		☆
Sub Spindle Foot Switch		☆
Turret		
Tool Holder		●
Mill Turret	Radial	●
Straight Milling Head (Radial)	Adapter Type,2ea	●
Angular Milling Head (Axial)	Adapter Type,2ea	●
Boring Sleeve		●
Drill Socket		●
U-Drill Holder		●
Angle Head		☆
Tail Stock & Steady Rest		
Quill Tail Stock (Built-in)		-
Built-in Programmable Tail Stock		-
Manual Type Hyd. Steady Rest		-
Fixed Center		-
Tool Tail Stock		○
2 Steps Tail Stock Pressure System		-
Coolant & Air Blow		
Standard Coolant (Nozzle)		●
Chuck Coolant (Upper Chuck)		○
Gun Coolant		○
Through Spindle Coolant (Only for Special Chuck)		○
Thru Coolant for Live Tool		☆
Chuck Air Blow (Upper Chuck)		●
Sub Spindle Air Blow		●
Tail Stock Air Blow (Upper Tail Stock)		-
Turret Air Blow		☆
Air Gun		○
Through Spindle Air Blow (Only for Special Chuck)		☆
High Pressure Coolant	6Bar	○
	20Bar	○
Power Coolant System (For Automation)		☆
Coolant Chiller		☆
Chip Disposal		
Coolant Tank	230 ℓ (60.8 gal)	●
Chip Conveyor (Hinge/Scraper)	Front (Right)	○
	Front (Rear)	-
Special Chip Conveyor (Drum Filter)		☆
Chip Wagon	Swing (200 ℓ [52.8 gal])	○
	Large Swing (290 ℓ [76.6 gal])	○
	Large Size (330 ℓ [87.2 gal])	○
	Customized	☆
Safety Device		
Back Spin Torque Limiter (BST)		●
Total Splash Guard		●
Chuck Hydraulic Pressure Maintenance Interlock		☆

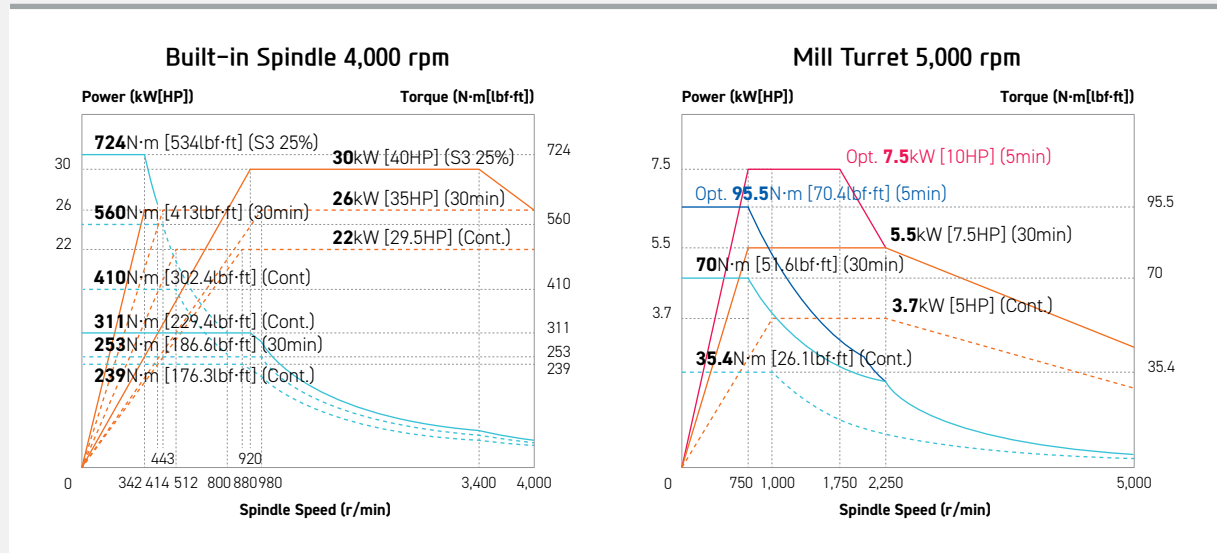
Electric Device		LM2500TTSY II
Call Light	1Color : ●	○
Call Light & Buzzer	3Color : ● ■ ■ B	●
Electric Cabinet Light		○
Remote MPG		●
Work Counter	Digital	○
Total Counter	Digital	○
Tool Counter	Digital	○
Multi Tool Counter	6ea	○
	9ea	○
Electric Circuit Breaker		○
AVR (Auto Voltage Regulator)		○
Transformer	50kVA	-
	80kVA	○
Auto Power Off		○
Measurement		
Automatic Q-Setter		○
Work Close Confirmation Device (Only for Special Chuck)	TACO	○
	SMC	○
Work Setter		☆
Linear Scale	X1 Axis	○
	X2 Axis	○
	Y Axis	○
	Z1 Axis	○
	Z2 Axis	○
Coolant Level Sensor(Only for Chip Conveyor)		☆
Environment		
Air Conditioner		○
Oil Mist Collector		○
Oil Skimmer (Only for Chip Conveyor)		○
MQL (Minimal Quantity Lubrication)		○
MQL (Minimal Quantity Lubrication)		☆
Fixture & Automation		
Auto Door	Standard	○
	High Speed	○
Auto Shutter (Only for Automatic System)		○
Sub Operation Pannel		☆
Bar Feeder Interface		○
Bar Feeder (FEDEK)		☆
Sub Sp. Work Eject (Pneumatic Type)		○
Extra M-Code 4ea		○
Automation Interface		☆
I/O Extension (IIN & OOUT)	16 Contact	○
	32 Contact	○
Parts Catcher	Main SP.	-
	Sub SP.	-
Turret Parts Catcher		○
Parts Unloader (SUB Sp.)		☆
Sub Sp. Work Pusher (Spring Type)		○
Turret Work Pusher (For Automation)		☆
Parts Conveyor		○
Hyd. Device		
Standard Hyd. Cylinder	Hollow	●
Standard Hyd. Unit	35bar/24 ℓ	●
S/W		
Machine Guidance (HW-MCG)		●
Energy Saving System (HW-ESS)		●
Tool Monitoring (HW-TM)		○
Thermal Displacement Compensation (HW-TDC)		○
DNC software (HW-eDNC)		○
Machine Monitoring System (HW-MMS)		○
Conversational program (HW-DPRO)		-
Thermal Displacement Compensation Device		○
ETC		
Tool Box		●
Customized Color	Need Munsel No.	☆
CAD & CAM		☆

❖ TDC(Thermal Displacement Compensation) device is recommended, when more than 6 bar of high pressure coolant is applied, for the high quality machining.

Specifications are subject to change without notice for improvement.

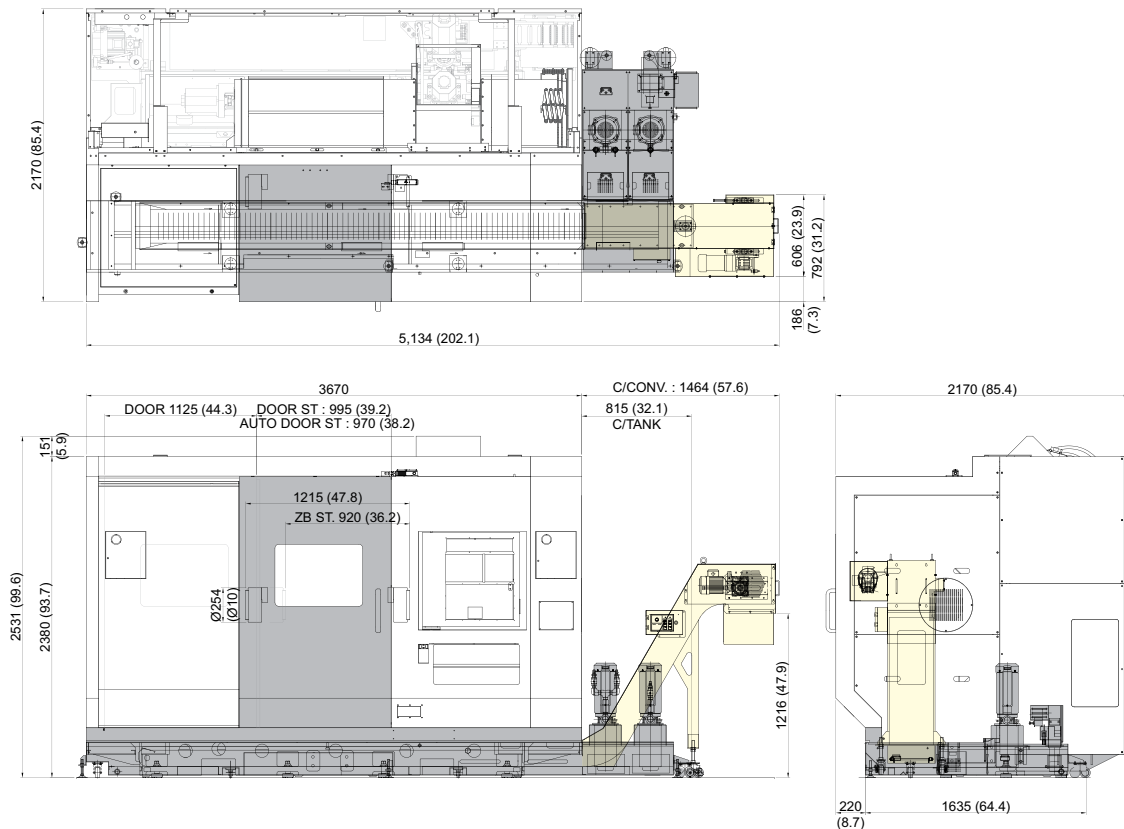
# Specifications

## Spindle Output/Torque Diagram



## External Dimensions

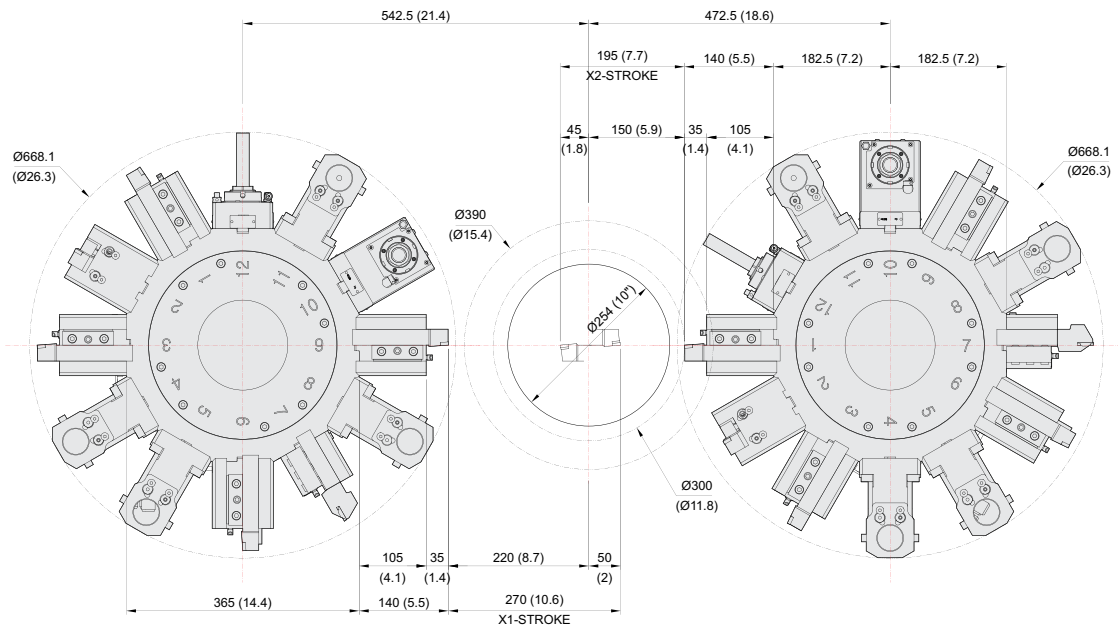
unit : mm(in)



# Specifications

## Interference

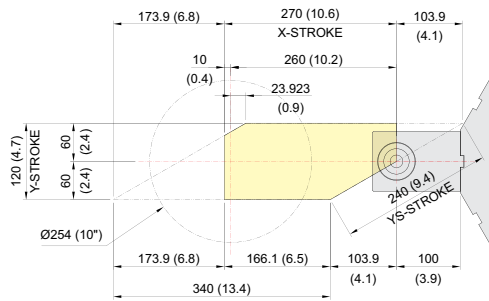
unit : mm(in)



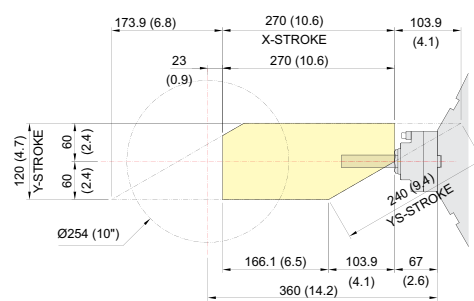
**Upper Tool Post**

**Low Tool Post**

**Angular Mill Y-STROKE**



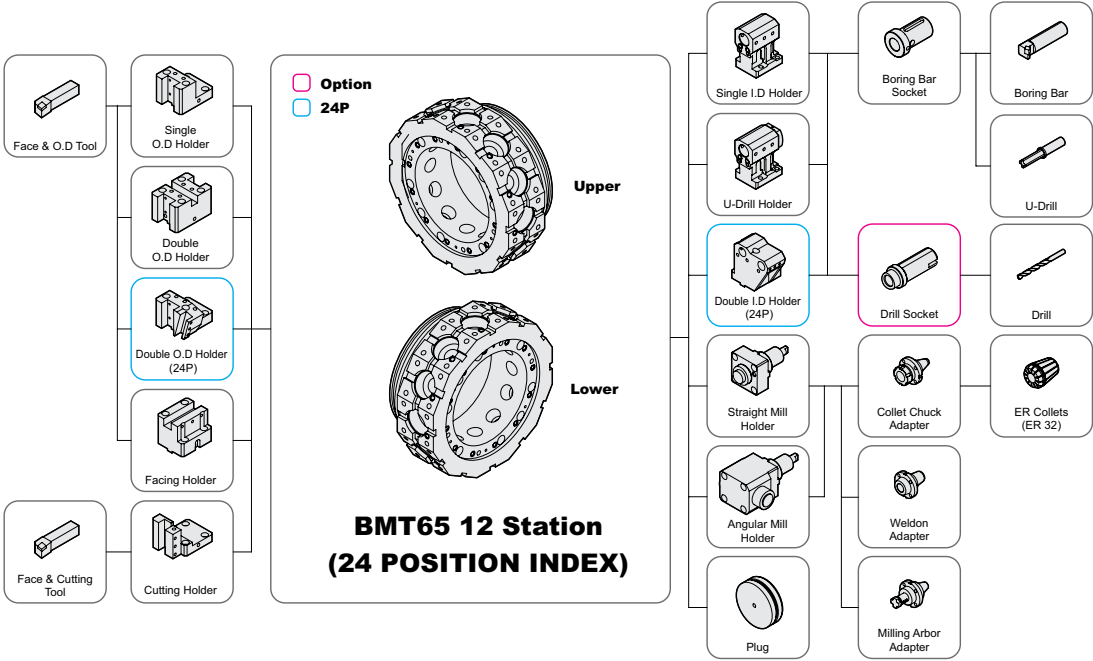
**Straight Mill Y-STROKE**



# Specifications

## Tooling System

unit : mm(in)



## Tooling Parts Detail

24 Station : Option

ITEM			12 Station	
			mm Unit	inch Unit
Turning Holder	외경 홀더	Right/Left	4	4
		Double (Both)	2	2
		Double (24P)	2	2
	페이싱 홀더	2	2	
	커팅 홀더	1	1	
Boring Holder	I.D Holder	Single	5	5
		Double (24P)	2	2
		U-Drill	2	2
Driven Holder	Straight Mill Holder	Standard	2	2
	Angular Mill Holder	Standard	2	2
Socket	Boring	Ø10 (Ø3/8")	2	2
		Ø12 (Ø1/2")	2	2
		Ø16 (Ø5/8")	2	2
		Ø20 (Ø3/4")	2	2
		Ø25 (Ø1")	2	2
		Ø32 (Ø1 1/4")	2	2
	Drill	MT 1	Opt.	Opt.
		MT 2	Opt.	Opt.
		MT 3	Opt.	Opt.
	ER Collet		1 Set	1 Set
Adapter Set		1 Set	1 Set	

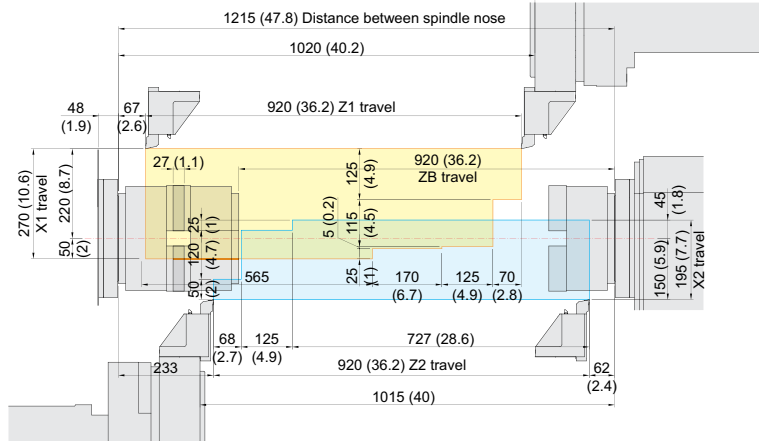
Specifications are subject to change without notice for improvement.

# Specifications

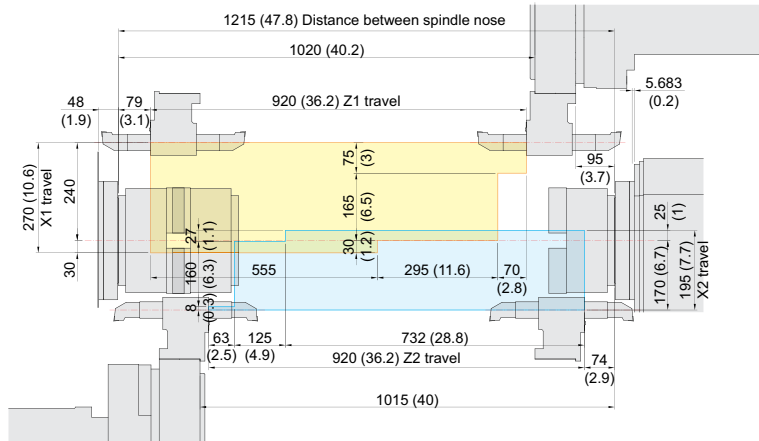
## Tooling Travel Range

unit : mm(in)

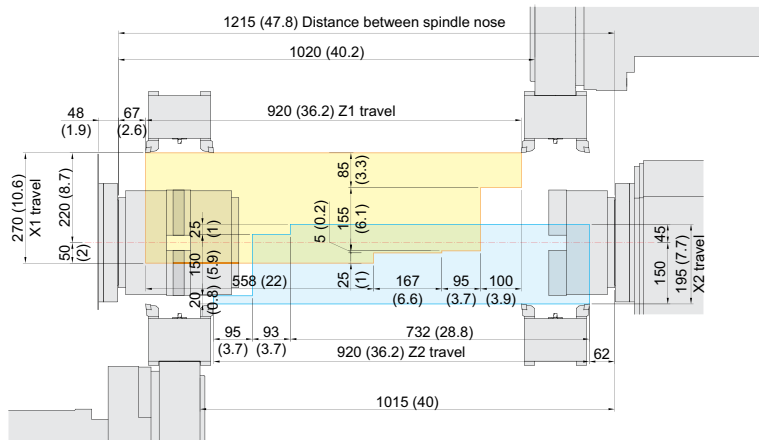
### O.D Tool Holder



### I.D Tool Holder



### Double O.D Tool Holder

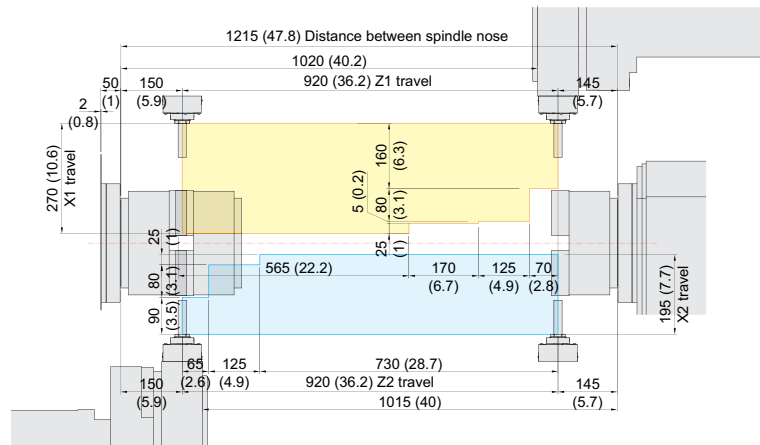




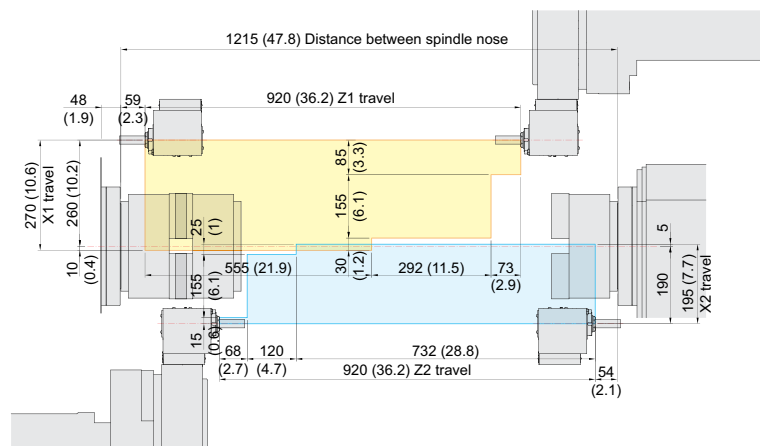
## Tooling Travel Range

unit : mm(in)

### Straight mill Tool Holder



### Angular mill Tool Holder



# Specifications

## Specifications

[ ] : Option

ITEM			LM2500TTSY II	
CAPACITY	Swing Over the Bed	mm(in)	Ø780 (Ø30.7")	
	Swing Over the Carriage	mm(in)	Ø700 (Ø27.6")	
	Max. Turning Dia.	mm(in)	Upper : Ø390 (Ø15.4") / Lower : Ø300 (Ø11.8")	
	Max. Turning Length	mm(in)	900 (35.4")	
	Bar Capacity	Main	mm(in)	Ø81 (Ø3.2")
Sub		mm(in)	Ø81 (Ø3.2")	
SPINDLE	Chuck Size	Main	mm(in)	Ø254 (10")
		Sub	mm(in)	Ø254 (10")
	Spindle Bore	Main	mm(in)	Ø91 (Ø3.6")
		Sub	mm(in)	Ø91 (Ø3.6")
	Spindle Speed (rpm)	Main	r/min	4,000
		Sub	r/min	4,000
	Motor (Max/Cont.)	Main	kW(HP)	30/22 (40/29.5)
		Sub	kW(HP)	30/22 (40/29.5)
	Torque (Max/Cont.)	Main	N·m(lbf·ft)	724/410 (534/302.4)
		Sub	N·m(lbf·ft)	724/410 (534/302.4)
	Spindle Type	Main	-	Built-in Motor
Sub		-	Built-in Motor	
Spindle Nose	Main	-	A2-8	
	Sub	-	A2-8	
C-axis Indexing		deg	0.001°	
FEED	Travel	X1/X2	mm	270/195 (10.6"/7.7")
		Z1/Z2	mm	920/920 (36.2"/36.2")
		Y	mm	120 {±60} (4.7")
		ZB	mm	920 (36.2")
	Rapid Traverse Rate	X1/X2	m/min	24/24
		Z1/Z2	m/min	24/24
		Y	m/min	12
		ZB	m/min	24
Slide Type		-	Box Guide	
TURRET	No. of Tools		ea	2×12 [2×24]
	Tool Size	O.D/I.D	mm(in)	□25/Ø40 (□1"/Ø1 1/2")
	Indexing Time		sec/step	0.2
	Y-Axis Type		-	Wedge Type
LIVE TOOL	Motor (Max/Cont.)		kW(HP)	5.5/3.7 (7.5/5) [7.5/3.7 (10/5)]
	Milling Tool Speed (rpm)		r/min	5,000
	Torque (Max/Cont.)		N·m(lbf·ft)	70/35.4 (51.6/26.1) [95.5/35.4 (70.4/26.1)]
	Collet Size		mm(in)	Ø20 (Ø3/4") : ER32
	Type		-	BMT65
TANK CAPACITY	Coolant Tank		l(gal)	230 (60.8)
	Lubricating Tank		l(gal)	6 (1.6)
POWER SUPPLY	Electric Power Supply		kVA	69
	Thickness of Power Cable		Sq	OVER 50
	Voltage		V/Hz	220/60 (200/50*)
MACHINE	Floor Space (L×W)		mm(in)	3,670×2,170 (144.5"×85.4")
	Height		mm(in)	2,550 (100.4")
	Weight		kg(lb)	11,000 (24,251)
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
Program stop / end	M00, M01 / M02, M30
Maximum command unit	± 999,999,999 mm (± 99,999,999 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.



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