

ISO 9001



KIA TURN 15/21

CNC TURNING CENTER



**SUPER HIGH SPEED
SUPER HIGH ACCURACY
SUPER HIGH PRODUCTIVITY**

 **KIA HEAVY INDUSTRIES**

Taktis

SUPER HIGH SPEED, SUPER HIGH ACCURACY, SUPER HIGH PRODUCTIVITY KIA TURN 15/21 CNC TURNING CENTER



TURRET INDEX/FACE **0.1sec.**

RAPID TRAVERSE

Z= **1181IPM** (30m/min)
X=984 IPM(25m/min)

RAPID TRAVERSE

0.08sec.
0↔1181 IPM (30m/min)

GREAT CHIP DISPOSAL

60° Slant Bed

POWERFUL SPINDLE MOTOR (KIA TURN 21)

20HP (15Kw)

**SUPER HIGH SPEED
KIA TURN 15/21**

■ HIGH SPEED

- X Axis:984 ipm(25m/min)
- Z Axis:1181 ipm(30m/min)
- Turret index time:0.1 sec/face
- Rapid Traverse Acceleration:0.08 sec(0↔1181 ipm)

■ EASY & CONVENIENT OPERATION

- Easy chip disposal (60° slant bed)
- Compact design and easy to move
- Quick set-up "one touch" tailstock

■ HIGH ACCURACY, HIGH RIGID

- High accuracy L.M guide adopted on each axis
- Box type cast iron structure
- Powerful spindle motor:20HP(15kw)

■ THE CONCEPT OF FACTORY AUTOMATION

- Rich assortment of peripheral equipment
- Robot system/auto loader/unloader/bar feeder/parts catcher

MODEL	KIA TURN 15	KIA TURN 21
• CHUCK SIZE	6.5"(165mm)	8.3"(210mm)
• MAX TURNING DIA×LENGTH	φ 10.2"×14.2" (φ 260×360mm)	φ 11.4"×15.4" (φ 290×390mm)
• TOOL NO	12	10
• SPINDLE RPM	50~5,000rpm	25~4,000rpm
• SPINDLE MOTOR	10HP(7.5kw)	20HP(15/11kw)

CNC UNIT SPECIFICATION

■ YASNAC LX 3

Standard Feature	
Controlled Axes	X & Z Axes
Simultaneously Controllable Axes	2 Axes/Liner and Circular
Designation System	Incremental and absolute
Min. Input Increment	X Axis : 0.0001" Dia. Z Axis : 0.0001"
Least Command Increment	X Axis : 0.00005"/P Z Axis : 0.0001"/P
Max. Programmable Dimension	±3937.0078"
Tape Code	EIA RS-244-A/ISO 840
Buffer Storage	Provided
Dwell Time	0.001~99999.999 Sec
Programming	Combined use of Absolute Incremental Programming in the same block of tape
Rapid traverse(G00)	X Axis : 984.25"/min Z Axis : 1181.1"/min
Feed Per Revolution(G99)	0.0001~19.6850"/Rev
Feed Per Minute(G98)	0.01~944.88"/Min
Manual Feed, JOG Feed(20 Steps)	0~787.4"/Min
Threading	0.0001~19.6850"
Automatic Acceleration and Deceleration	Linear for Rapid Traverse, Exponential for Feed
Backlash Compensation	±8191 Pulses
Tool Offset	16 Pairs
CRT. Display, 9" Monochrome	Keyboard type manual data Input(MDI) and CRT Character display
Part Program Storage Length	131 FT.
Rapid Traverse Override	F0, 25, 50, 100%
Feed Override	0~200%
Canned cycle	G90 : Cutting Cycle A G92 : Threading Cycle G94 : Cutting Cycle B
Multiple Canned Cycle	G70, G71, G72, G73, G74, G75, G76
Constant Surface Speed Control	G96
Reference Point Return	G27~G30
Run Hour Display	Provided
Tool Nose R Compensation	Provided
Automatic Coordinate System Setting	Provided
Work Coordinate System Shift	Provided
Manual/Absolute	ON Fixed
Stored Stroke Limit	1, 2, 3(G36~G39)
Offset Value Setting	G10
Thread Cutting	G32
Variable Thread Cutting	G34
Program Check	Dry Run+Spindle Stop +Coolant Stop
Reader/Puncher Interface	RS232C
Block Skip	1EA
Radius Programming for Circular Interpolation	G22, G23
Chamfering and Corner R	Provided
Inch/Metric Conversation	Provided
Memory Protect	Provided
Single Block	Provided
Feed Hold	Provided
Optional Stop	Provided
Decimal Point Input	Provided
Program NO. Search	Provided
Sequence NO. Search	Provided
Label Skip	Provided
Machine Lock	Provided
Dry Run	Provided
Self Diagnosis	Provided
Option Feature	
Run Hour Display B	
Temporary Stop of Thread Cutting	
Multi-Start Thread Cutting	
Additional Part Program Storage(80M, 160M, 320M)	
Registered Program Addition(199EA, 999EA)	
Program Restart	
User Macro	
Optional Block Skip Addition(9EA)	
External Tool Offset compensation	
External Program NO. Search	
External Data Input	
M-Code Lock	
Set-up Point Return	
Restart after Manual Interruption	
Angle Programming for Linear Interpolation	
Multiple Cornering	
Skip Function	
Internal Toggle Switch	
Stored Pitch Error Compensation	
Spindle Index Function	
Stored Stroke Limit Each Tool	
Buffering Function(M CODE)	
Tool Life Management	
Groove Width Offset Compensation	

■ FANUC OT-C

Standard Feature	
Controlled Axes	X,Z Axes
Simultaneously Controllable Axes	2 Axes/Liner and Circular
Designation System	Incremental and Absolute
Least Input Increment	X Axis : 0.0001 Inch Z Axis : 0.0001 Inch
Least Command Increment	X Axis : 0.00005 Inch Z Axis : 0.0001 Inch
Max. Programmable Dimension	+99999.999 Inch
Tape Code	EIA/ISO Automatic Recognition
Buffer Storage	Provided
Dwell Time	99999.999 Inch
Programming	Combined use of Absolute/ Incremental Programming In The Same Block of Tape
Rapid Traverse(G00)	X Axis : 984.25 Inch/Min Z Axis : 1181.1 Inch/Min
Feed Per Revolution(G99)	0.000001~9.999999 Inch/Rev
Feed Per Minute(G98)	0.01~4000.00 Inch/Min
Manual Feed, Jog Feed(20 Step)	0~78.74 Inch/Min
Threading	0.000001~9.999999 Inch
Automatic Acceleration And Deceleration	Linear for rapid Traverse, Exponential for Feed
Backlash Compensation	0~±0.255MM
Tool Offset	16 Pairs
CRT. Display, 9 Inch Monochrome	Key Board Type Manual Data Input(MDI) and Crt Character Display
Part Program Storage Length	65 FT.
Rapid Traverse Override	F0, 25%, 50%, 100%
Feed Override	0~200%
Canned Cycle	G90, G92, G94
Multiple Canned Cycle	G70~G76
Constant Surface Speed Control	G96~G97
Reference Point Return	G27~G28
Run/Hour Display	Provided
Tool Nose R Compensation	Provided
Automatic Coordinate System Shift	Provided
Work Coordinate System Shift	Provided(G50)
Manual Absolute ON/OFF	Provided
Thread Cutting	Provided(G32)
Variable Thread Cutting	Provided(G34)
Stored Stroke Limit 1	Provided
Offset Value Setting	Provided(G10)
Program Check	Dry Run+Spindle Stop+ Coolant Stop
Reader/Puncher Interface	RS-232C
Block Skip	1 EA
Chamfering and Corner R	Provided
Inch/Metric Conversation	Provided(G20/G21)
Memory Protect	Provided
Single Block	Provided
Feed Hold	Provided
Optional Stop	Provided
Decimal Point Input	Provided
Program NO. Search	Provided
Label Skip	Provided
Machine Lock	Provided
Dry Run	Provided
Self Diagnosis	Provided
Option Feature	
☆ Tape Memory(40M, 80M, 120M, 320M)	
☆ Skip function	
☆ X-Axis Mirror image	
☆ Back ground editing	
☆ Tool life Management(Symple type)	
☆ Optional block skip additional(9EA Total)	
☆ Tool Offset additional(32 Pairs)	
☆ Custom macro(100, 200)	
☆ Number of registered program(125, 200)	
☆ Program Restart	
☆ Graphic display(9" BLACK & WHITE)	
☆ External data Input/Output	
☆ Clock function	
☆ Remote buffer interface	
☆ Remote MPG	
☆ Continuous thread cut	
☆ Portable tape reader without reels	
☆ Portable tape reader with reels	