



ACE - HM *Series*

HM 500

HM 630

HM 800



DOOSAN
Doosan Infracore

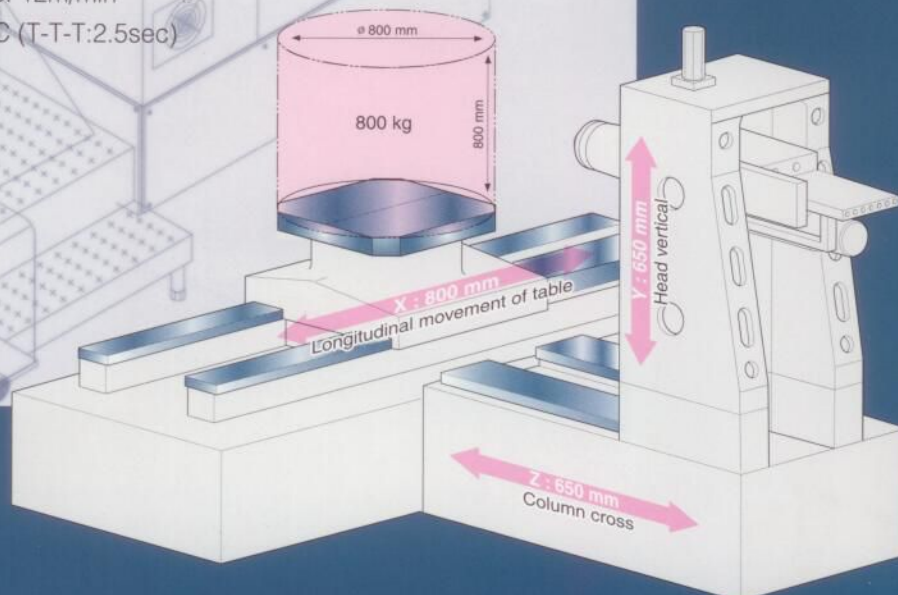
High Power and Precision Designed and Built for Today's Competitive edge.



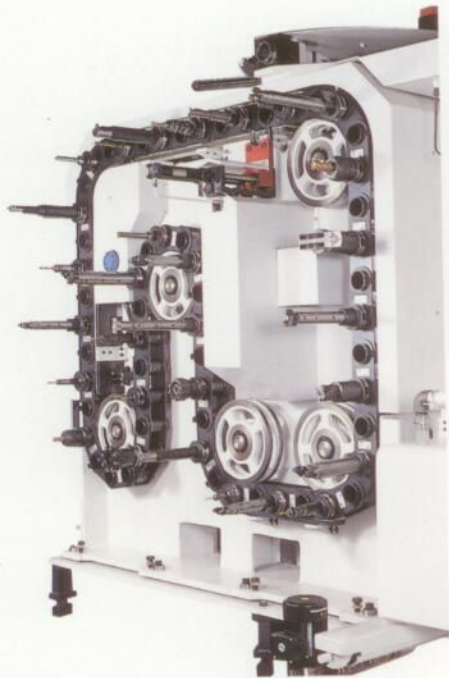
(This machine has optional accessories.)

The ACE-HM500 combines a high torque spindle drive and powerful axis drives for a large chip removal rate. The massive meehanite cast structure and wrap around box guideways provide the rigidity required for both heavy cutting and superb surface finishes. The machine is exceptionally stable and maintains excellent positioning accuracy and repeatability in any environment.

- 3 range high torque spindle drive
- High speed 6,000 rpm spindle
- Solid wrap around wided box guideway construction
- Fast APC with rotary shuttle type
- Rapid-traverse rate: 24m/min (X, Y, Z axes)
- Cutting feedrate: 12m/min
- High speed ATC (T-T-T:2.5sec)

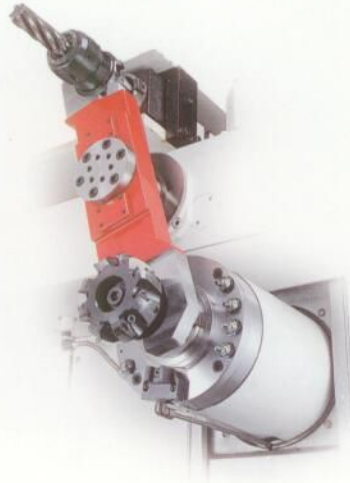
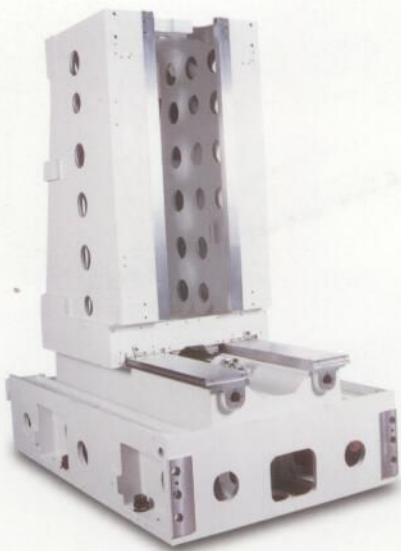


ACE-HM500



① TOOL MAGAZINE

The ATC is composed of tool magazine and change arm. ATC is located separately from the machine in order to prevent adverse effects on accuracy due to vibration or other causes even when the ATC is operated during machining operation. The tools are selected by fixed address method that follows the shorter path. All tools are returned to the pots from which they were originally taken so that collision problems involving large-sized tools need to be considered only once when they are first mounted. A bi-directional magazine takes the shortest path. [std:40tools, opt:60/90/120/180/240tools]



② AUTOMATIC TOOL CHANGER

Sophisticated mechanisms drastically reduce non-cutting time. [Tool-to-tool: 2.5 sec, Chip-to-chip: 8.0 sec]



③ BED AND COLUMN

The machine is designed to build rigidity into a stable body. The construction of the machine was thoroughly examined from the stage of basic design to ensure consistent high-speed and high-accuracy operation. The deformation of the bed when subject to a load at the center was simulated to secure high level rigidity against bending.

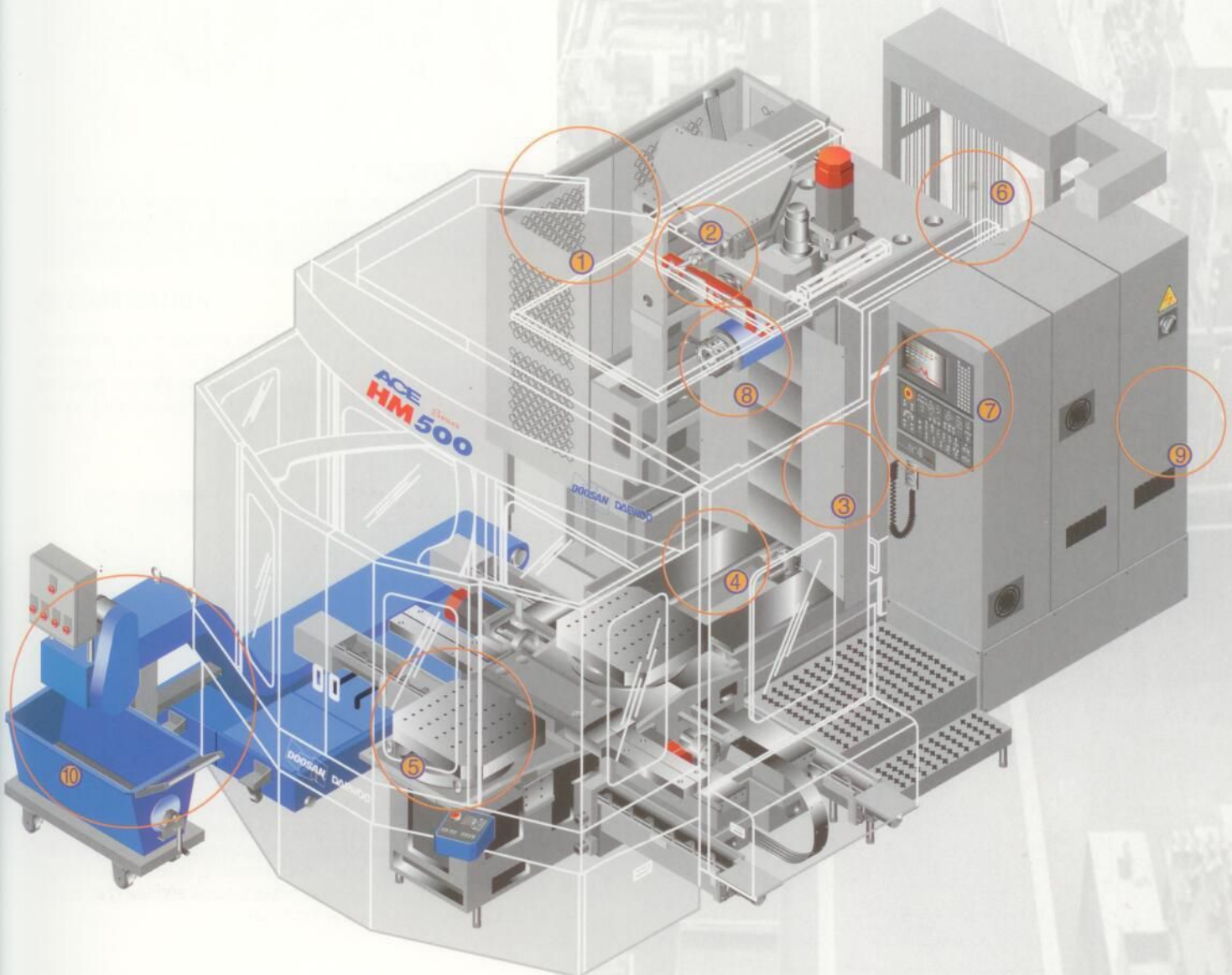
■ Measures against thermal distortion

The machine proper is insulated from heat sources to provide high, stable machining accuracy. Machine-generated heat, such as from the control panel, spindle lubricant temperature controller or hydraulic unit, is more likely than the ambient temperature to distort the bed or column, causing machining accuracy to decline. This is avoided on the ACE-HM500 by covering the back of these units with heat shields and using a fan to radiate heat away from the machine.



④ BALL SCREW & AXIS DRIVES

Doosan Infracore ACE-HM Series machining centers with oversized AC servo drives power through the toughest cuts in the toughest metal. The high torque servos are coupled directly to the ball screws. With no gears there is no risk of backlash or servo drag. The X and Z axes ball screws are center mounted, pretensioned and supported on both ends by high precision angular contact thrust bearings. This pretension design provides outstanding positioning repeatability with minimize thermal growth. In the event of a sudden impact, a flexible coupling on each axis flexes and absorbs the shock.



ACE-HM500



5 AUTOMATIC PALLET CHANGER

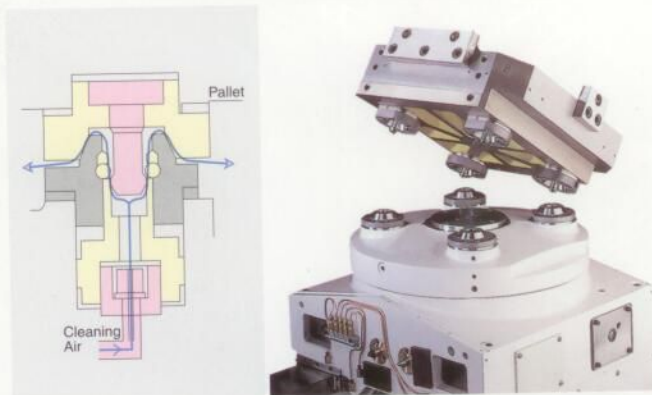
ACE-HM500 machining center is equipped with rotary shuttle type APC(Automatic Pallet Changer) as a standard feature. It provides high reliability and wide working area for easy setup. Rotary shuttle APC provides faster changing time and easy adoption for automated system in small sized machine



6 OIL COOLER

The temperature of the hydraulic oil is regulated by a refrigerated cooling system. It maintains uniform controlled temperature required for high accuracy.

TAPERED CONE CLEANING SYSTEM



The possibility that chips might degrade the meshing accuracy of the pallet positioning mechanism increases at higher machining speeds. On the ACE-HM500 strong jets of air are discharged from the tapered cones when a pallet is changed to clean any chips from the cones and assure accurate pallet positioning.



7 OPERATOR'S PANEL

The newly designed operator's panel provides greater convenience in setting up and operating the machine. Operator's panel is designed for operator ease and convenience.



8 SPINDLE HEAD

A stepped sleeve system is used for the axial fixation of the spindle bearing so that the bearings can be fixed at right angle to the machine. The 3-step spindle drive system provides a wide speeds for high-torque heavy-duty machining. The speed range is 20 to 6,000 rpm. Powerful high-speed and precision spindle configuration [Max 6,000rpm, 15 kW]



9 LUBRICATION

Automatic lubrication is provided to all guideways and ball screws. The way oil is delivered by piston distributors which precisely meter the volume. A low level alarm prevents the machine from restarting.



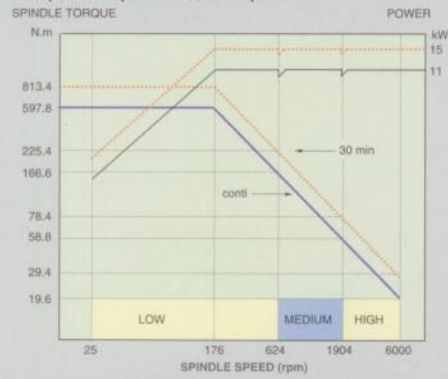
10 CHIP CONVEYOR & COOLANT TANK

Separate chip conveyor and coolant tank provide easy cleaning and maintenance. The completely enclosed ACE-HM500 virtually guarantees the confinement of chips and coolant to the inside of the machining area. Screw conveyors clearly remove the chips out of the machine.

Spindle power-torque diagram

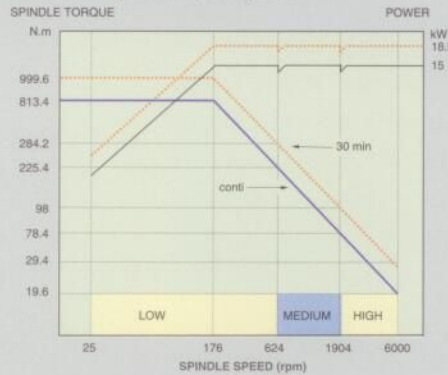
Standard (HM500)

- Spindle motor power : 15kW
- Max.spindle speed : 6,000 rpm

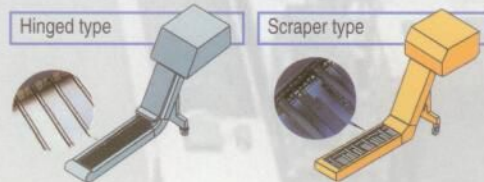


Option (HM500)

- Spindle motor power : 18.5kW
- Max.spindle speed : 6,000 rpm



Chip conveyor outside machine (option)



Specifications	Hinged type	Scraper type
Chip		
Steel	○	×
Cast iron	×	○
Aluminum and nonmetals	×	○
Mixture	×	○

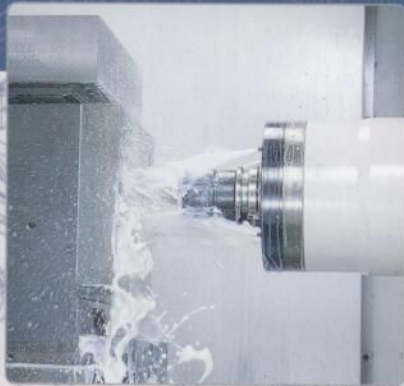
- Chips max. 50 mm in length.
- Chip conveyors are available in various types for handling chips of different shape and material.
- Please contact Doosan for more information.

Designed for your productivity Horizontal Machining Center with Reliability • Flexibility



(This machine has optional accessories.)

Get Reliability and Accuracy
for a wider range of applications
from DOOSAN Infracore Horizontal Machining Centers



ACE Series

HM 630 / HM 800

ACE HMseries are built to world-class standards to assure world-class result. Powerful drive, heavy duty construction, and unsurpassed rigidity provide exceptional precision, high productivity, and years of trouble-free performance.

Superb Productivity

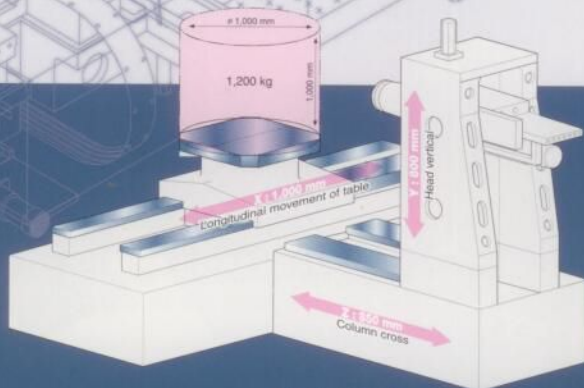
- High speed 6,000rpm spindle drive
- Fast 24m/min rapid traverse
- Powerful 22kW high-torque spindle motor(opt.:26kW)
- High-speed pallet change(2-station rotary type)

Superb Reliability

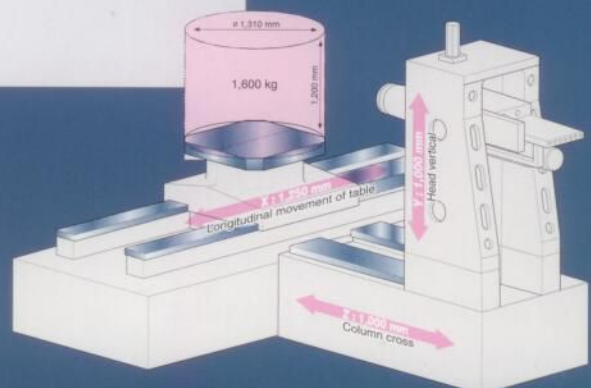
- Massive Meehanite cast-iron bed
- Large diameter pretensioned ball screws
- Fanuc 18i-M controller
- Wide induction hardened & precision box guideways

Superb Design

- Highly rigid bed supports sturdy machine design
- Far fewer parts by advanced technology
- All equipment integrated into a space-saving design

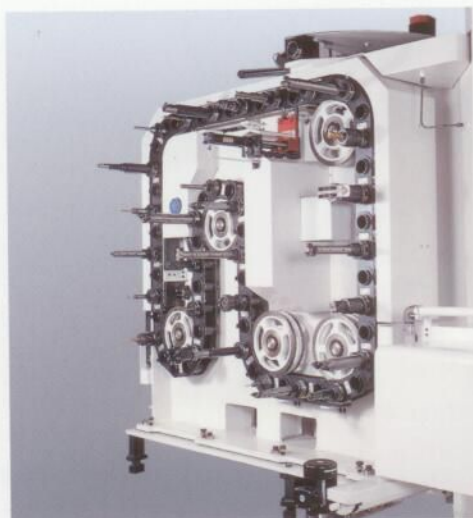


ACE-HM630



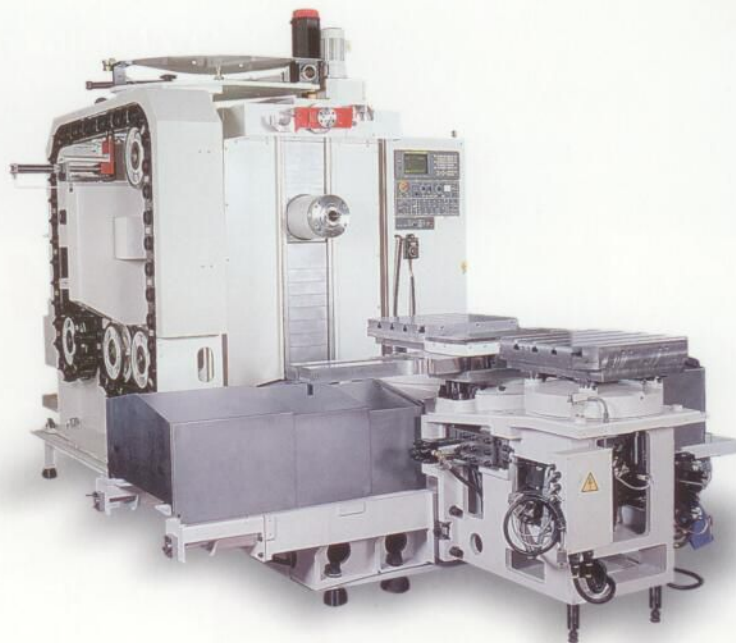
ACE-HM800

ACE-HM630/HM800



① TOOL MAGAZINE

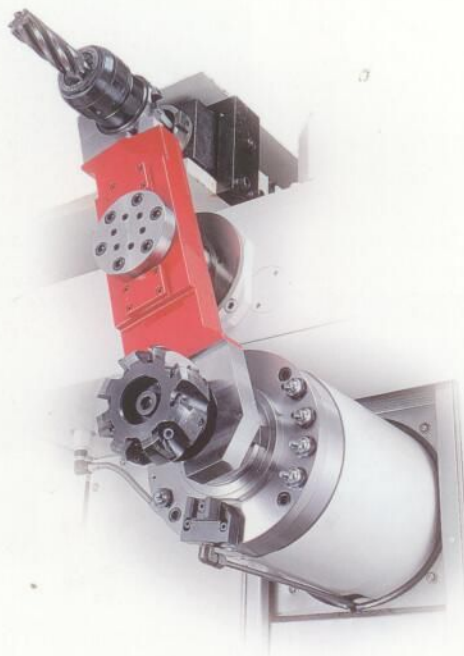
A bi-directional tool magazine takes the shortest path.
[Std.:40 tools, Opt.:60/90/120/180/240 tools]



③ BED AND COLUMN

ACE HM 630/800 are engineered for deeper cuts at faster speeds with no sacrifice to precision or surface finish. It combines high torque spindles, powerful axis drives, rigid castings and solid box ways. The result is machining centers with the muscle to hog off tough metals, the rigidity to produce tenths precision, and the rugged durability to provide years of low-maintenance, trouble-free performance.

The bed and box-type column are rigid, castings that are ribbed to withstand extreme cutting forces. Fine-grained meehanite castings impart excellent dampening characteristics. The column is supported on massive guideways. The pallet is positioned by four cones and a large diameter curvic coupling for superior positioning accuracy. An air-cleaning system removes contaminants such as chips and dust. Automatic tool changers are available with as many as 240 tool stations, and accept 50 taper tools to a maximum weight of 25 kg. The ATC is separated from the machine body, and fully protected from chips and coolant. The fixed pocket design automatically returns tools to their original magazine positions. This reduces the chance of collision when oversize tooling is used. A convenient foot switch releases the tool, making manual loading of the bidirectional magazine quick and easy. Tools in the magazine can be changed safely during operation.



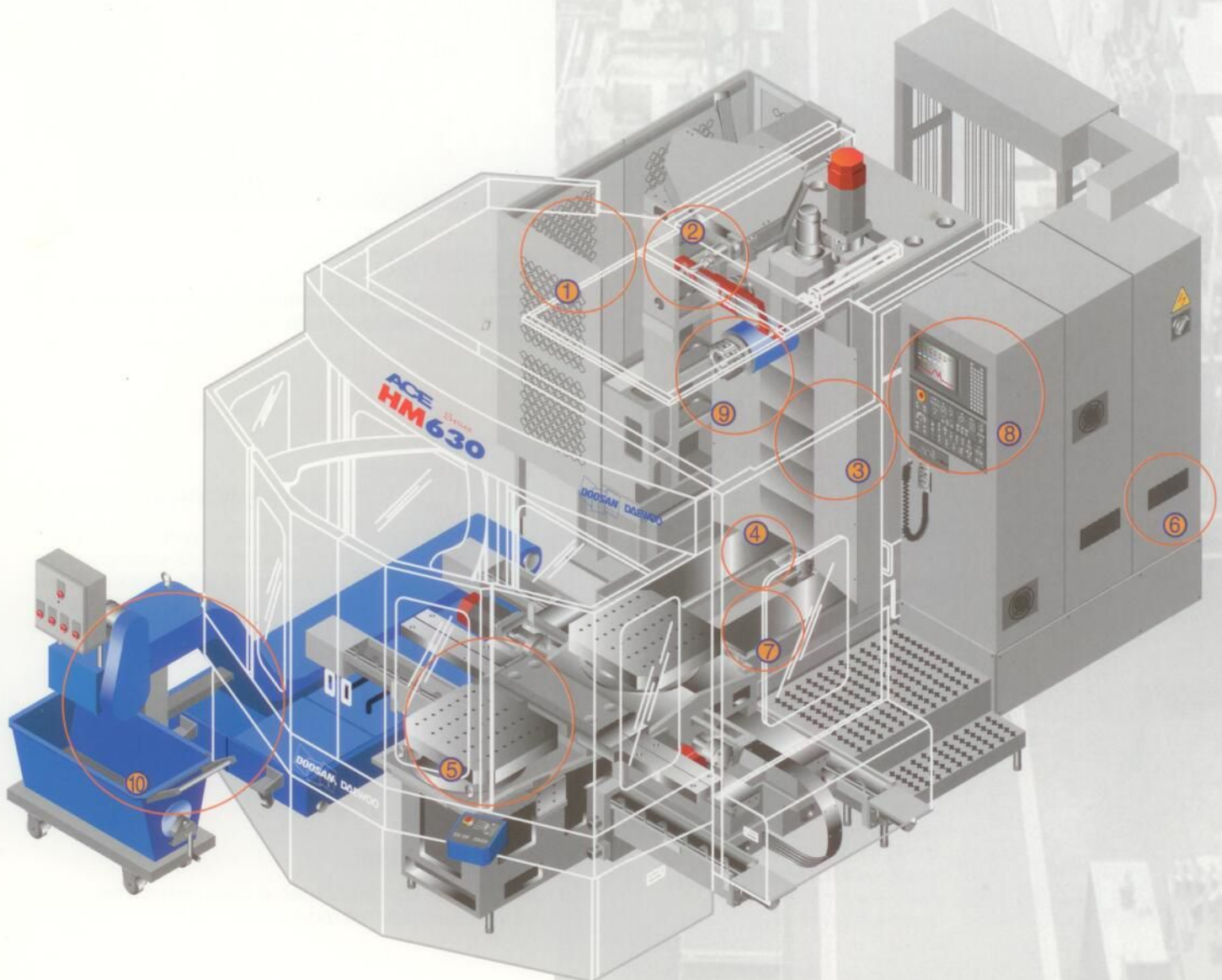
② AUTOMATIC TOOL CHANGER

Sophisticated mechanism drastically reduces non-cutting time. High-speed ATC completes a tool change in just 2.5 seconds (tool-to-tool).



④ BALL SCREWS & AXIS DRIVES

The axis is driven by a high-precision ballscrew that's centered between the guideways. The ballscrews are supported at each end with angular thrust bearings. This double pretension design provides outstanding positioning repeatability with no thermal growth. A 50 mm diameter ball screws connects directly to a powerful Fanuc AC servo drive motor. With no gears or belts, there's no backlash and servo lag.



ACE-HM630/HM800



5 AUTOMATIC PALLET CHANGER

ACE-HM630/HM800 are equipped with rotary shuttle type APC as a standard feature. It provides high reliability and wide working area for easy setup.

Four tapered cones on the table fit securely into tapered holes on the underside of the pallet to provide the high accuracy.

	HM630	HM800
Pallet size	630X630mm	800X800mm
Max.workpiece size	ø1,000XH1,000mm	ø1,310XH1,200mm
Max.workpiece weight	1,200kg	1,600kg



6 LUBRICATION

Automatic lubrication is provided to the guideways, ball screws and spindle gearbox. Way lubrication oil is delivered by piston distributors which precisely meter the volume of oil. A low-level alarm prevents the machine from restarting.



7 BOX GUIDEWAYS

Box guideways provide higher dampening property with best technology for heavy duty applications.

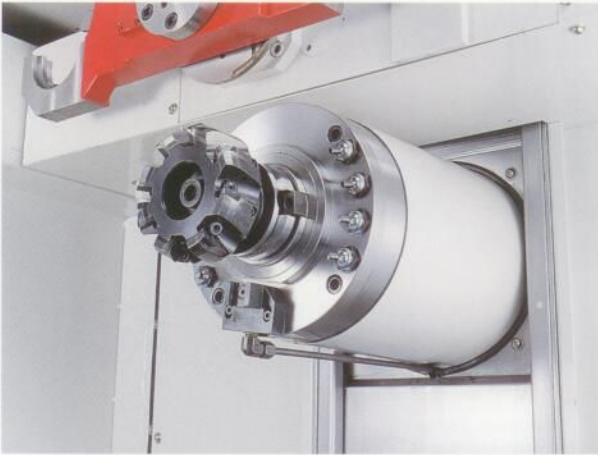


8 OPERATOR'S PANEL

The operator's panel and portable manual pulse generator are designed for operator ease and convenience.

9 SPINDLE HEAD

With a Max. 6,000 rpm and an output 22 kW, the spindle shows excellent performance for a wide range of materials from heavy-duty cutting of steel to high speed cutting of nonferrous materials.



Heavy duty, 50 taper spindles are supported by four, permanently lubricated angular-contact spindle bearings, precision class P4. The bearings are assembled using a stepped sleeve system. This permits precise adjustment, and eliminates the possibility of assembly damage typical of lock nut systems. A 22 kW AC motor delivers power to the three-speed geared head, and provides high speeds and low-end torques for a broad range of applications. An encoder, attached to the spindle, allows rigid tapping in both high and low gear ranges.

Spindle power-torque diagram

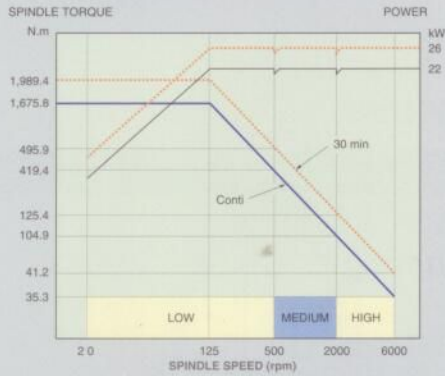
Standard (HM630/HM800)

- Spindle motor power : 22kW
- Max.spindle speed : 6,000rpm



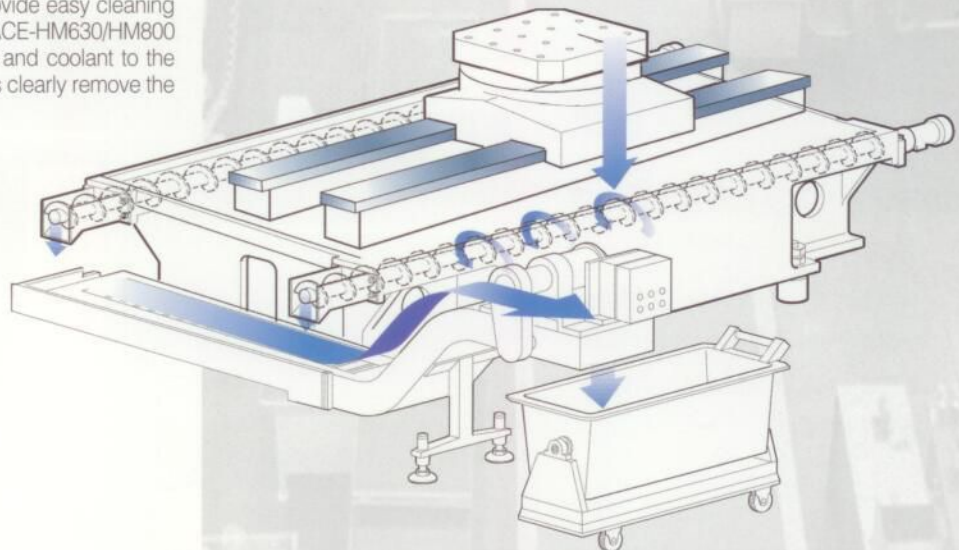
Option (HM630/HM800)

- Spindle motor power : 26kW
- Max.spindle speed : 6,000 rpm



10 CHIP CONVEYOR & COOLANT TANK

Separate chip conveyor and coolant tank provide easy cleaning and maintenance. The completely enclosed ACE-HM630/HM800 virtually guarantees the confinement of chips and coolant to the inside of the machining area. Screw conveyors clearly remove the chips out of the machine.



FLEXIBLE MULTI PALLET SYSTEM

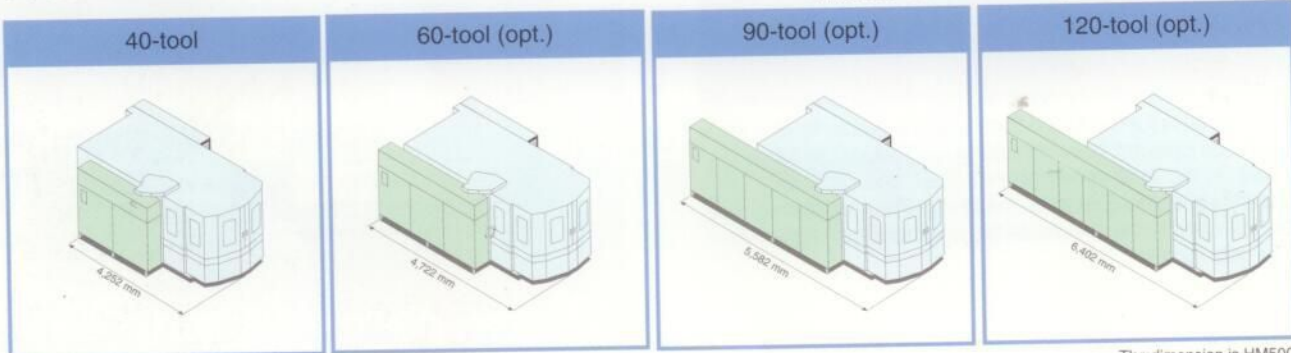
- High Productivity & availability
 - Flexible production solutions
 - High efficiency system
 - Compact designed technology
 - Easy to extend stations
- ACE-HM500 : 7, 9, 11, 13st.
ACE-HM630/HM800 : 6, 8, 10, 12st.



■ 7-Station Round Type Multi Pallet Magazine

TOOL MAGAZINE

Numerous Variations to meet production efficiency needs.



The dimension is HM500

APPLICATION OF MULTI PALLET SYSTEM

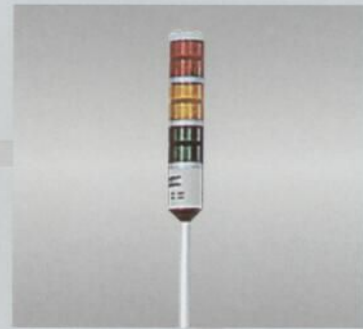
Name	ACE-HM630 (2set)
Number of Setup Station	1
Storage Capacity (630 × 630)	17 Stations

Application technology of Multi-pallet system is the best solution for the high productivity in the machining shop.





Oil cooler & Hyd. unit



Operator call lamp (red/yellow/green)



FANUC 18i-M controller



Portable MPG



Rigid tapping



Work light



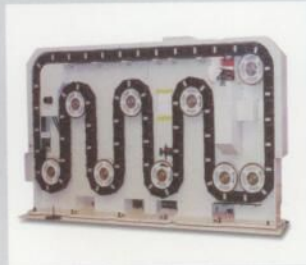
Screw conveyor



Optional Features



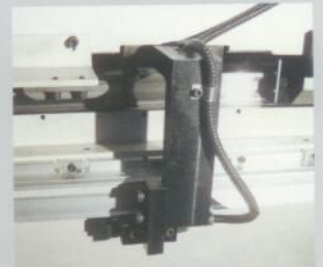
Multi Pallet Magazine



120 Tools



Shower coolant



Linear scale feedback system



Through the spindle coolant system



Chip conveyor / Bucket



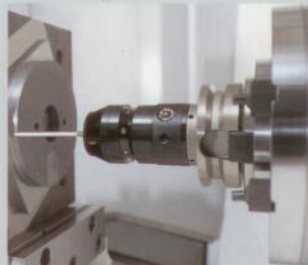
T-slot pallet



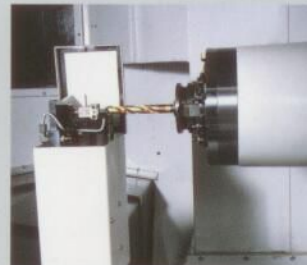
FMS



Built in Rotary Table (0.001°)



Automatic measuring system



Automatic tool length measurement with sensor

- Test bar
- Air gun
- Automatic power off
- Automatic door for APC guard
- Hydraulic line for fixture
- Tool monitoring system
- Oil skimmer
- CE certification

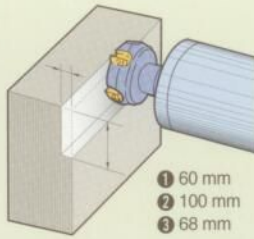


Cutting Performance

ACE-HM500

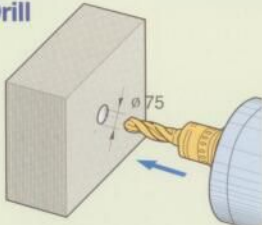
► Face mill

- ① 12 mm
- ② 12 mm
- ③ 8 mm



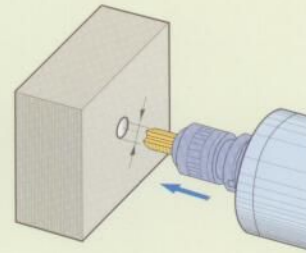
Tool	① ϕ 100 Face mill (6Z)	② ϕ 125 Face mill (8Z)	③ ϕ 100 Face mill (6Z)
Material	Aluminum (AC4B)	Gray casting (GC25)	Carbon steel (SM45C)
Spindle speed (rpm)	1,900	624	624
Feedrate (mm/min)	2,194	638	937
Machining rate (cm ³ /min)	1,580	766	510

► Drill



Tool	ϕ 75 Drill(2Z)
Material	Gray casting(GC25)
Spindle speed(rpm)	137
Feedrate(mm/min)	60

► Rigid tapping (M56 x P6.5)



Workpiece material : Carbon steel (S50C)

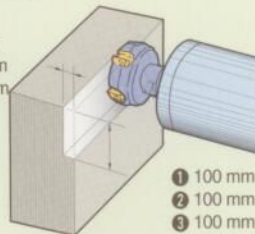
Spindle speed : 56 rpm

Feedrate : 308 mm/min

ACE-HM630/HM800

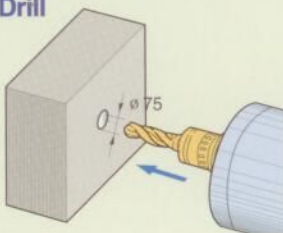
► Face mill

- ① 4 mm
- ② 12 mm
- ③ 12 mm



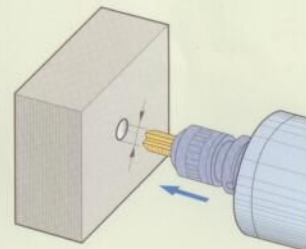
Tool	① ϕ 125 Face mill (8Z)	② ϕ 125 Face mill (8Z)	③ ϕ 125 Face mill (8Z)
Material	Aluminum (AL70)	Gray casting (GC25)	Carbon steel (SM45C)
Spindle speed (rpm)	2,600	334	308
Feedrate (mm/min)	10,500	1,463	1,000
Machining rate (cm ³ /min)	4,200	1,756	1,200

► Drill



Tool	ϕ 75 Drill(2Z)
Material	Gray casting(GC30)
Spindle speed(rpm)	137
Feedrate(mm/min)	72

► Rigid tapping (M56 x P5.5)



Workpiece material : Carbon steel (S50C)

Spindle speed : 56 rpm

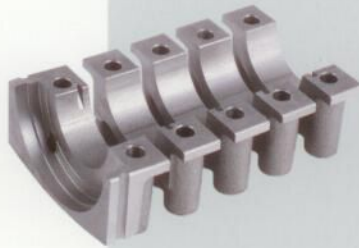
Feedrate : 308 mm/min

- The cutting data results indicated in this catalog are provided as an example. The results indicated in this catalog may not be obtained due to differences in cutting conditions and environmental conditions during measurement.
- The above data is obtain by standard specific machine.

Sample Workpiece



Connecting Rod



Bearing Cap



Intake manifold



Cylinder Block



Cylinder Head



Transmission Case



Brake caliper



Tool Post Body



Turret Disc

Application



Housing



Pump Piston



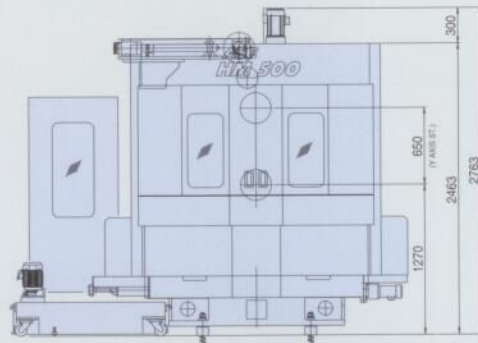
Control Arm

ACE-HM500

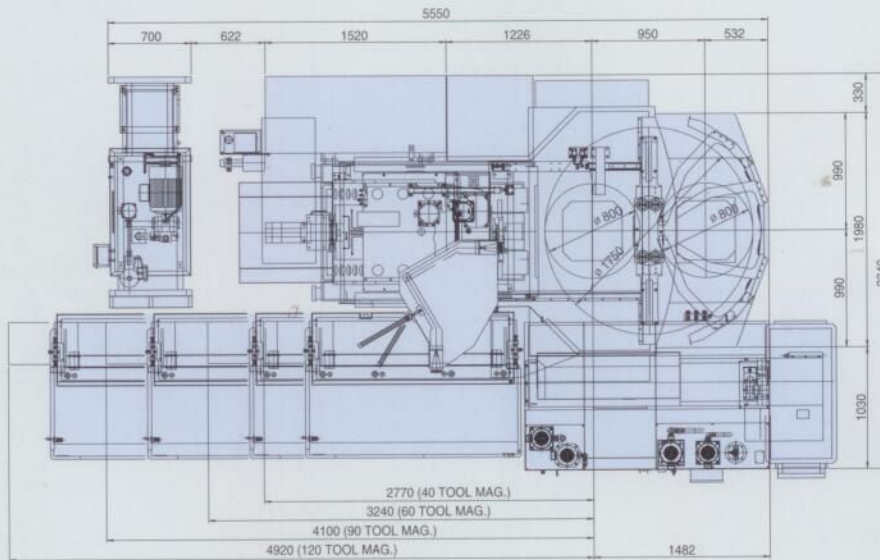
External Dimension

unit : mm

FRONT VIEW



TOP VIEW



SIDE VIEW

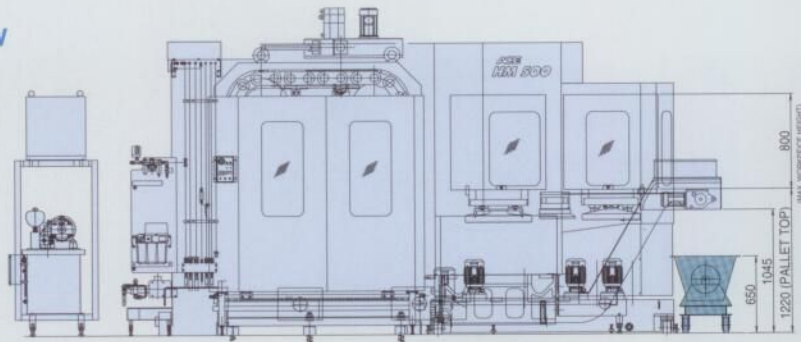
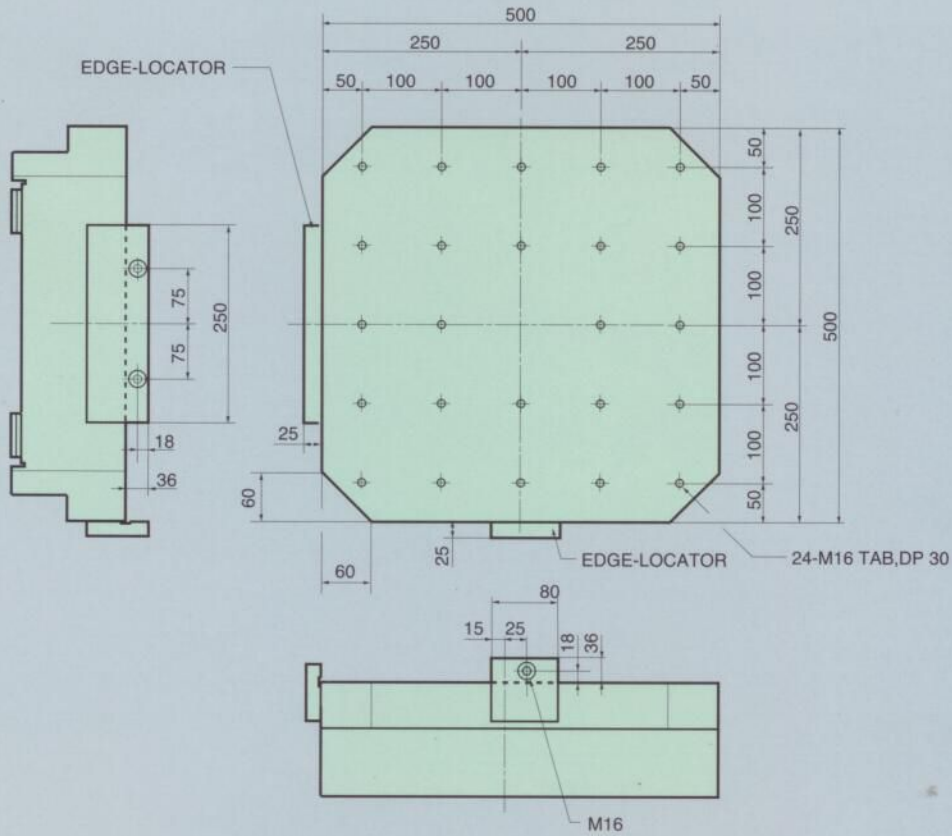


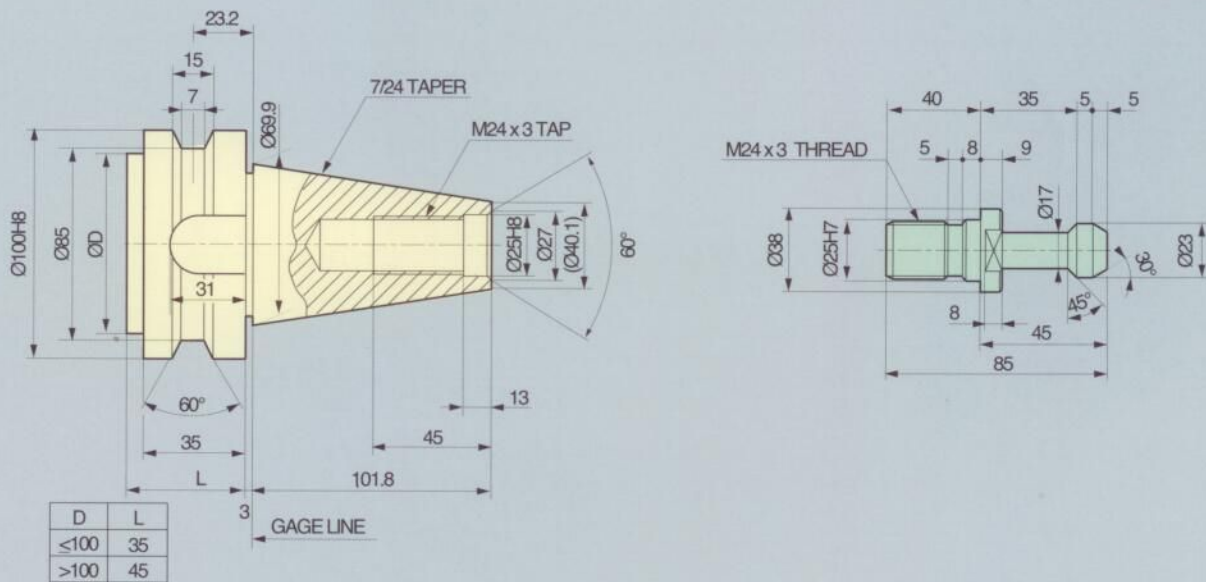
Table Dimension

unit : mm



Tool Shank (BT50 tool) (ACE-HM500/HM630/HM800 : STANDARD)

unit : mm

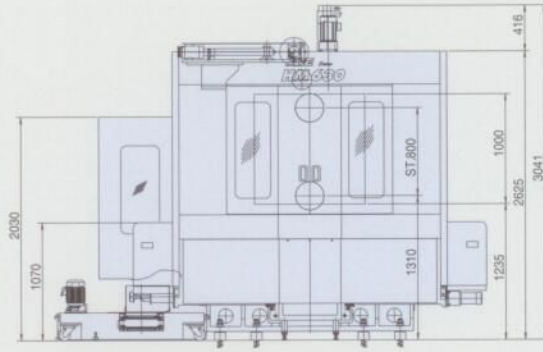


ACE-HM630

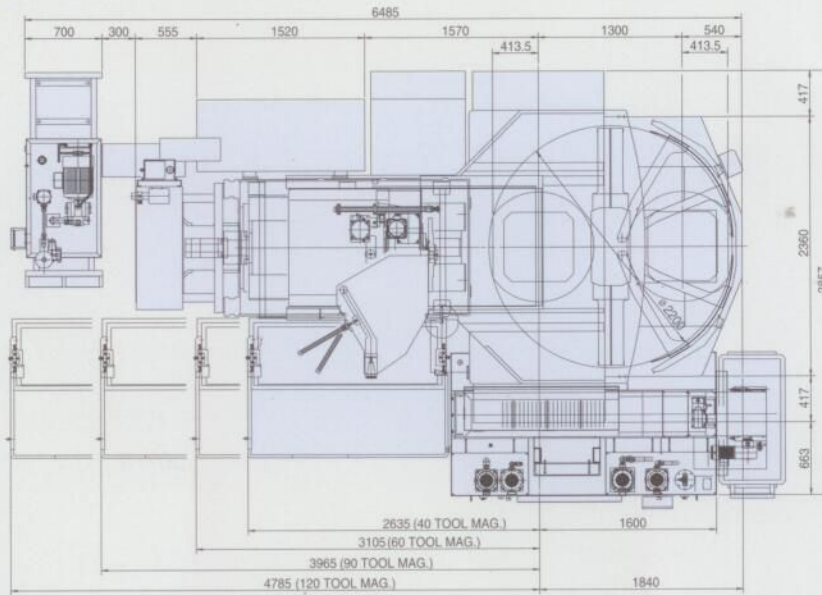
External Dimension

unit : mm

FRONT VIEW



TOP VIEW



SIDE VIEW

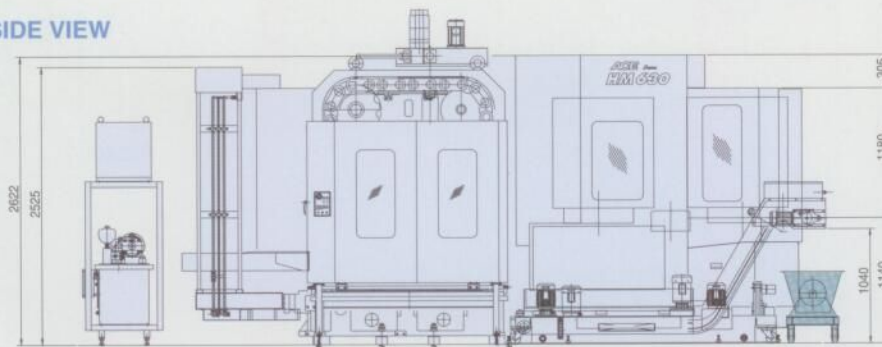
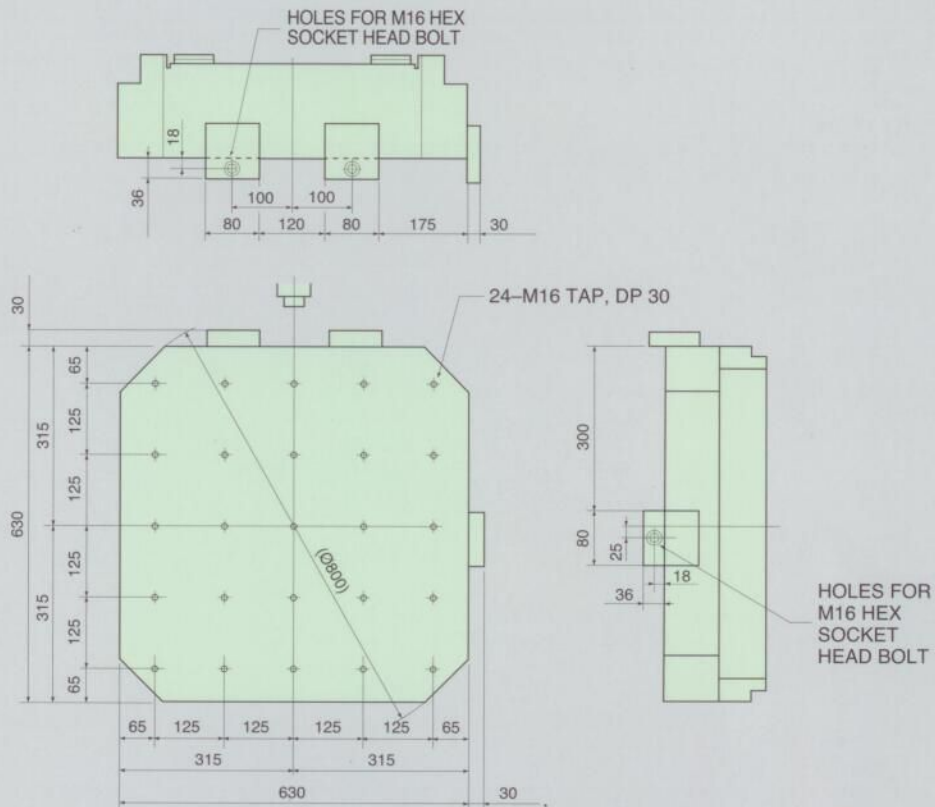


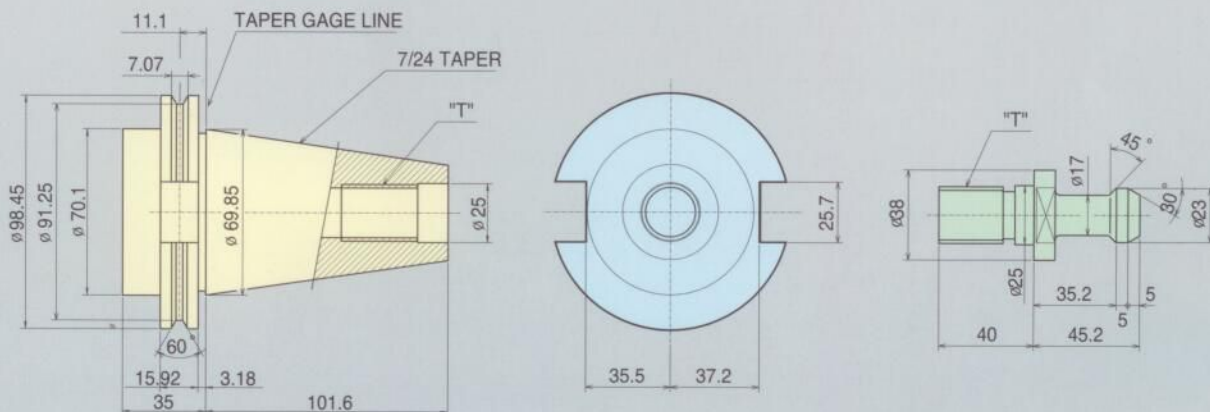
Table Dimension

unit : mm



Tool Shank (CAT50 tool) (ACE-HM500/HM630/HM800 : OPTION)

unit : mm

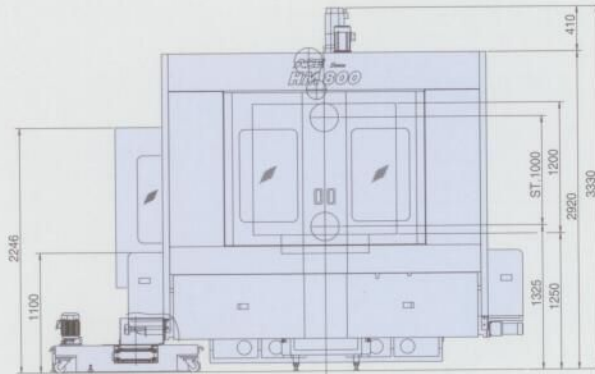


ACE-HM800

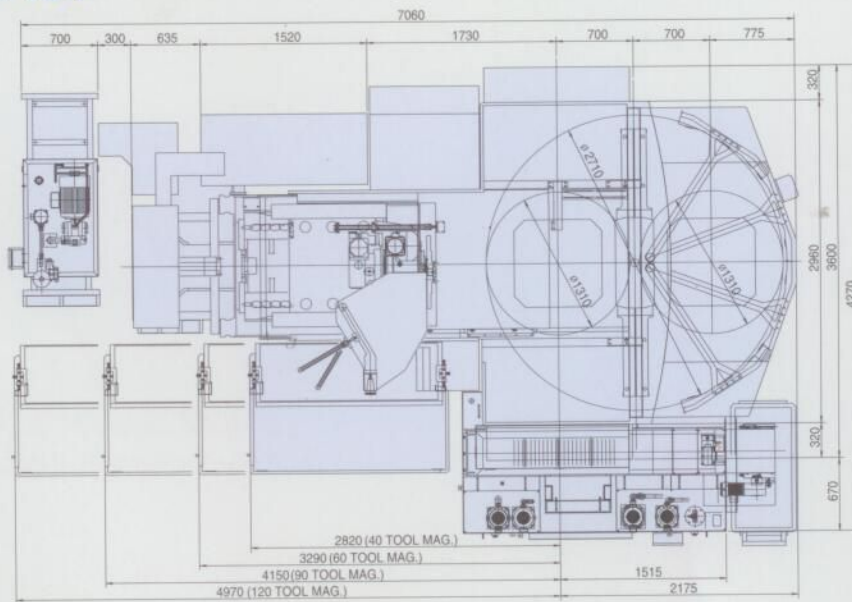
External Dimension

unit : mm

FRONT VIEW



TOP VIEW



SIDE VIEW

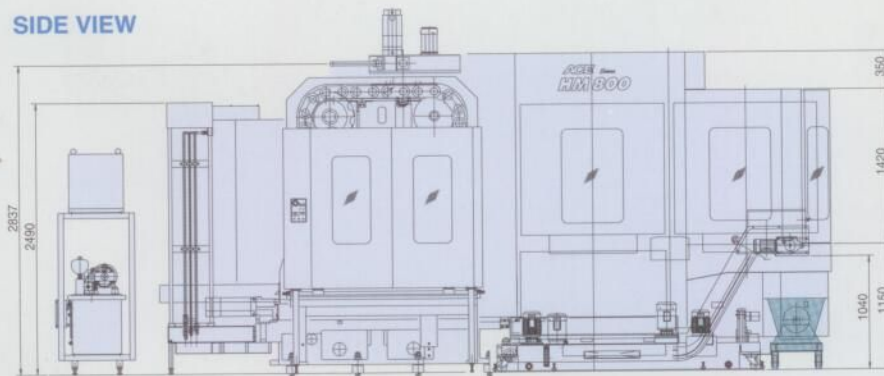
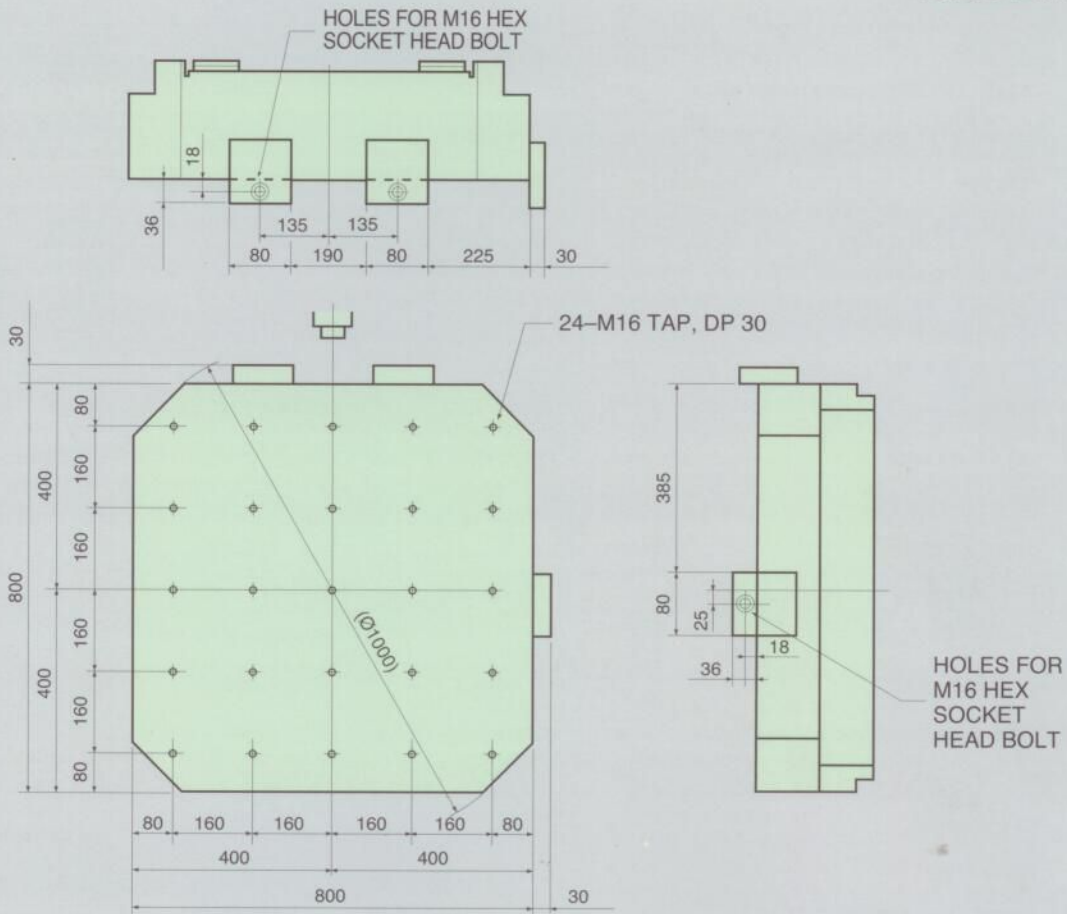


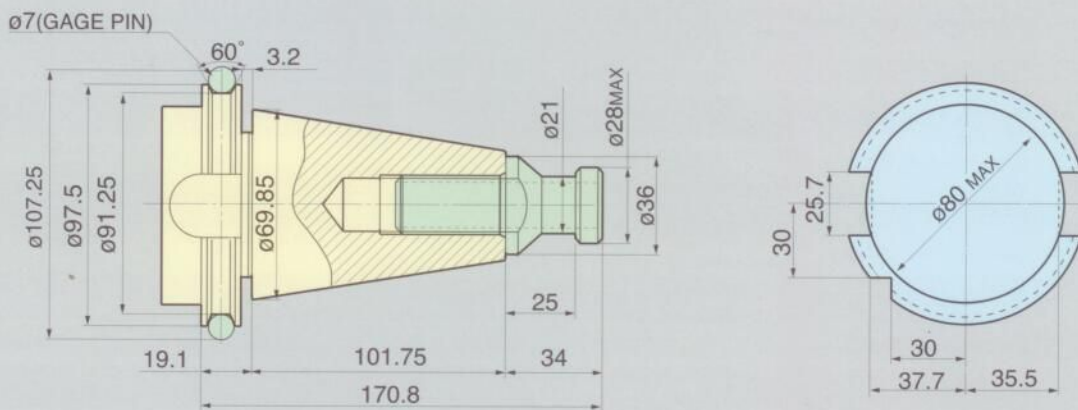
Table Dimension

unit : mm



Tool Shank (DIN50 tool) (ACE-HM500/HM630/HM800 : OPTION)

unit : mm



Features			ACE-HM500	ACE-HM630	ACE-HM800
Travel	X-axis(longitudinal movement of table)	mm	800	1,000	1,250
	Y-axis(head vertical)	mm	650	800	1,000
	Z-axis(column cross)	mm	650	850	1,000
	Distance from spindle center to pallet top	mm	50-700	75-875	75-1,075
	Distance from spindle nose to table center	mm	150-800	150-1,000	200-1,200
Table	Pallet type		24-M16 × P2.0 Tap		
	Indexing degree	deg.	1° (0.001°)		
	Table loading capacity	kg	800	1,200	1,600
	Pallet size	mm	500 × 500	630 × 630	800 × 800
Spindle	Max. spindle speed	rpm	6,000		
	Spindle taper		ISO #50 7/24 Tapper		
	Max. spindle torque	N.m	813.4(999.6)	1,675.8(1,989.4)	
Feedrate	Rapid traverse rate(X,Y,Z)	m/min	24		
	Cutting feedrate	mm/min	1~12,000		
Automatic tool changer	Type of tool shank		MAS 403 BT50 (DIN,CAT)		
	Tool storage capacity		40(60/90/120/180/240)		
	Max. tool diameter	mm	135		
	Max. tool diameter without adjacent tools	mm	250		
	Max. tool length	mm	400	550	
	Max. tool weight	kg	25		
	Max tool moment	N.m	34.3		
	Method of tool selection		Fixed address		
	Tool changing time(tool-to-tool)	sec	2.5		
Automatic pallet changer	Tool changing time(chip-to-chip)	sec	8	8.5	9
	Number of pallets	EA	2		
	Type		Rotary type		
	Pallet change time	sec	14	25	29
Motor	Pallet rotation in loading station		90° Index		
	Spindle drive motor(30 min.)	kW	15(18.5)	22(26)	
Power source	Feed motor(X/Y/Z/B)	kW	3.0/4.0/4.0/1.6	4.0/7.0/7.0/3.0	
	Electrical power supply (Rated capacity)	kVA	43.2	60.7	56.3
Tank capacity	Compressed air supply	MPa	0.54		
	Coolant tank capacity	l	550		
Machine size	Lubrication tank capacity	l	4.3		
	Machine height	mm	2,763	3,041	3,330
	Machine dimensions	mm	5,550 × 3,340	6,485 × 3,857	7,060 × 4,270
	Machine weight	kg	13,500	18,000	20,000

Note : Dimensions in { } are optional.

- Design and specifications subject to change without notice.
- We do not responsible for difference between the information in the catalogue and the actual machine.

NC Unit Specifications (Fanuc 18i-M)

AXES CONTROL

- Controlled axes	4 (X,Y,Z,B)
- Simultaneously controllable axes	
Positioning(G00)/Linear interpolation(G01) :	3 axes
Circular interpolation(G02, G03) :	2 axes
- Backlash compensation	
- Emergency stop / overtravel	
- Follow up	
- Least command increment :	0.001mm / 0.0001"
- Least input increment :	0.001mm / 0.0001"
- Machine lock	all axes / Z axis
- Mirror image	Reverse axis movement (setting screen and M - function)
- Stored pitch error compensation	Pitch error offset compensation for each axis
- Stored stroke check 1	Overtravel controlled by software

INTERPOLATION & FEED FUNCTION

- 2nd reference point return	G30
- Circular interpolation	G02, G03
- Dwell	G04
- Exact stop check	G09, G61(mode)
- Feed per minute	mm / min
- Feedrate override (10% increments)	0 - 200%
- Jog override (10% increments)	0 - 200%
- Linear interpolation	G01
- Manual handle feed(1 unit)	
- Manual handle feedrate	0.1/0.01/0.001mm
- Override cancel	M48 / M49
- Positioning	G00
- Rapid traverse override	F0 (fine feed), 25 / 50 / 100%
- Reference point return	G27, G28, G29
- Skip function	G31

SPINDLE & M-CODE FUNCTION

- M- code function	M 3 digits
- Spindle orientation	
- Spindle serial output	
- Spindle speed command	S5 digits
- Spindle speed override (10% increments)	10 - 150%

TOOL FUNCTION

- Cutter compensation C	G40, G41, G42
- Number of tool offsets	99EA
- Tool length compensation	G43, G44, G49
- Tool number command	T3 digits

PROGRAMMING & EDITING FUNCTION

- Absolute / Incremental programming	G90 / G 91
- Auto. Coordinate system setting	
- Background editing	
- Canned cycle	G73, G74, G76, G80 - G89, G99
- Circular interpolation by radius programming	
- Custom macro B	
- Decimal point input	
- I / O interface	RS - 232C
- Inch / metric conversion	G20 / G21
- Label skip	
- Local / Machine coordinate system	G52 / G53
- Maximum commandable value	±99999.999mm (±9999.9999 inch)
- No. of Registered programs	125 EA
- Optional block skip	
- Optional stop	M01
- Part program storage	80m
- Program number	O4-digits
- Program protect	
- Program stop / end	M00 / M02,M30
- Programmable data input	Tool offset and work offset are entered by G10, G11
- Rigid tapping	G84, G74
- Sub program	Up to 4 nesting
- Tape code	ISO / EIA Automatic discrimination
- Thread cutting	
- Work coordinate system	G54 - G59

OTHERS FUNCTIONS (Operation, Setting & Display, etc)

- Alarm display	
- Alarm history display	
- Clock function	
- Cycle start / Feed hold	
- Display of PMC alarm message	Message display when PMC alarm occurred
- Dry run	
- Ethernet function(Embedded)	
- Graphic display	Tool path drawing
- Help function	
- Loadmeter display	
- MDI / DISPLAY unit	9.5" mono LCD, Keyboard for data input, soft-keys
- Memory card interface	
- Operation functions	Tape / Memory / MDI / Manual
- Operation history display	
- Program restart	
- Run hour and part number display	
- Search function	Sequence NO. / Program NO.
- Self - diagnostic function	
- Servo setting screen	
- Single block	

OPTIONAL SPECIFICATIONS

- 3-dimensional coordinate conversion	
- 3-dimensional tool compensation	
- 3rd / 4th reference return	
- Addition of tool pairs for tool life management	128 / 512 pairs
- Additional controlled axes	max. 6 axes in total
- Additional work coordinate system	G54.1 P1 - 48 (48 pairs)
- Additional work coordinate system	G54.1 P1 - 300 (300 pairs)
- AI HPCC* (High Precision Contour Control) with 64 bit Risc600 block preview	
- Automatic corner override	G62
- Chopping function	
- Coordinate rotation	G68, G69
- Cylindrical interpolation	G07.1
- Tool monitoring system	
- Data server	
- Dynamic graphic display	Machining profile drawing
- Exponential interpolation	
- Extended part program editing	
- EZ Guide i (Conversational Programming Solution)	
- F15 tape format	
- Figure copying	G72.1, G72.2
- Handle interruption	
- Helical interpolation	
- High speed skip function	
- Involute interpolation	G02.2, G03.2
- Look ahead control	08
- Machining time stamp function	
- MDI / DISPLAY	10.4 inch color LCD
- NANO AICC (AI Contour Control)	80 block preview
- No. of Registered programs	200 / 400 / 1,000EA
- Number of tool offsets	200 / 400 / 499 / 999EA
- Optional angle chamfering / corner R	
- Optional block skip addition	9 blocks
- Part program storage	160 / 320 / 640 / 1,280 / 2,560m
- Playback function	
- Polar coordinate command	G15 / G16
- Polar coordinate interpolation	G12.1 / G13.1
- Programmable mirror image	G50.1 / G51.1
- Remote buffer	
- Scaling	G50, G51
- Single direction positioning	G60
- Stored stroke check 2 / 3	
- Tool life management	
- Tool offset memory C	Geometry / Wear and Length / Radius offset memory
- Tool position offset	G45 - G48



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