



# HEIDENHAIN



## **General Catalog**

Linear Encoders  
Length Gauges  
Angle Encoders  
Rotary Encoders  
Contouring Controls  
Touch Probes  
Evaluation Electronics  
Digital Readouts

September 2015

Representante oficial de:



**HEIDENHAIN**

[Argentina – Bolivia – Chile – Colombia - Costa Rica – Ecuador - El Salvador –  
Guatemala – Honduras – Nicaragua – Panamá – Paraguay – Perú -  
República Dominicana – Uruguay – Venezuela.]



Calle 49 N° 5764 - Villa Ballester (B1653AOX) - Prov. de Buenos Aires - ARGENTINA  
Tel: (+54 11) 4768-4242 / Fax: (+54 11) 4849-1212  
Mail: [ventas@nakase.com.ar](mailto:ventas@nakase.com.ar) / Web: [www.nakase.com.ar](http://www.nakase.com.ar)



DR. JOHANNES HEIDENHAIN GmbH develops and manufactures linear and angle encoders, rotary encoders, rotary encoders, evaluation units, and numerical controls. HEIDENHAIN supplies its products to manufacturers of machine tools, and of automated machines and systems, in particular for semiconductor and electronics manufacturing.

HEIDENHAIN is represented in over 50 countries—mainly through its own subsidiaries. Sales engineers and service technicians support the user on-site with technical information and servicing.

This General Catalog offers you an overview of the HEIDENHAIN product program. You will find more products and further information in the documentation for specific products (see page 60) or on the Internet at [www.heidenhain.de](http://www.heidenhain.de). Our sales personnel will be glad to help you personally. See page 62 for addresses and telephone numbers.

The image on the title page shows a workpiece with curved surfaces on both sides, which was milled with diagonal, alternating face-milling movements. The workpiece was machined with a TNC control from HEIDENHAIN on an HSC machining center. Despite the direction reversal during face milling and the lift-off movements of the Z axis, a very high surface quality was attained thanks to the highly dynamic motion control.



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## Fundamentals and processes

The high quality of HEIDENHAIN products depends on special production facilities and measuring equipment. Masters and submasters for scale manufacturing are produced in a clean room with special measures for temperature stabilization and vibration insulation. The copying machines and the machines required for the manufacture and measurement of linear and circular graduations are largely developed and built by HEIDENHAIN.

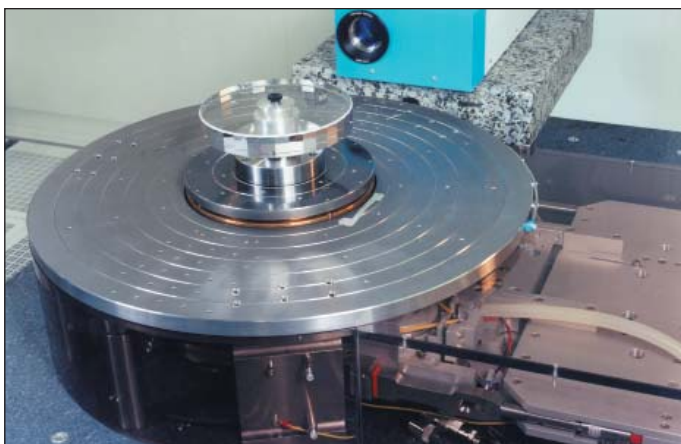


30 m long measuring machine for scale tapes



Vacuum machine for application of chromium layers

Competence in the area of linear and angular metrology is reflected by a large number of customized solutions for users. Among other implementations, they include the measuring and test equipment developed and built for standard laboratories and the angle encoders for telescopes and satellite receiving antennas. Of course, the products in the standard HEIDENHAIN product program profit from the knowledge gained.



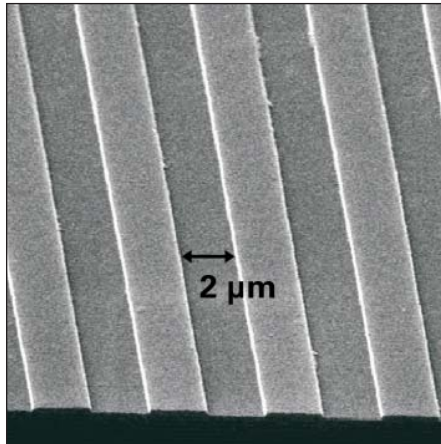
Angle comparator, measuring step approx. 0.001"



ALMA radio telescope, Chajnantor, Chile (photo: ESO)

# Precision graduations—the foundation for high accuracy

The heart of a HEIDENHAIN encoder is its measuring standard, usually in the form of a grating with typical line widths of  $0.25\ \mu\text{m}$  to  $10\ \mu\text{m}$ . These precision graduations are manufactured in a process invented by HEIDENHAIN (e.g. DIADUR or METALLUR) and are a decisive factor in the function and accuracy of encoders. The graduations consist of lines and gaps at defined intervals with very little deviation, forming structures with very high edge definition. These graduations are resistant to mechanical and chemical influences as well as to vibration and shock. All measuring standards have a defined thermal behavior.



Phase grating with approx.  $0.25\ \mu\text{m}$  grating height

## DIADUR

DIADUR precision graduations are composed of an extremely thin layer of chromium on a substrate—usually of glass or glass ceramic. The accuracy of the graduation structure lies within the micron and submicron range.

## AURODUR

AURODUR graduations consist of highly reflective gold lines and matte etched gaps. AURODUR graduations are usually on steel carriers.

## METALLUR

With its special optical composition of reflective gold layers, METALLUR graduations show a virtually planar structure. They are therefore particularly tolerant to contamination.

## Phase gratings

Special manufacturing processes make it possible to produce three-dimensional graduation structures, possessing certain optical characteristics. The structure widths are in the range of a few microns down to quarters of a micron.

## SUPRADUR

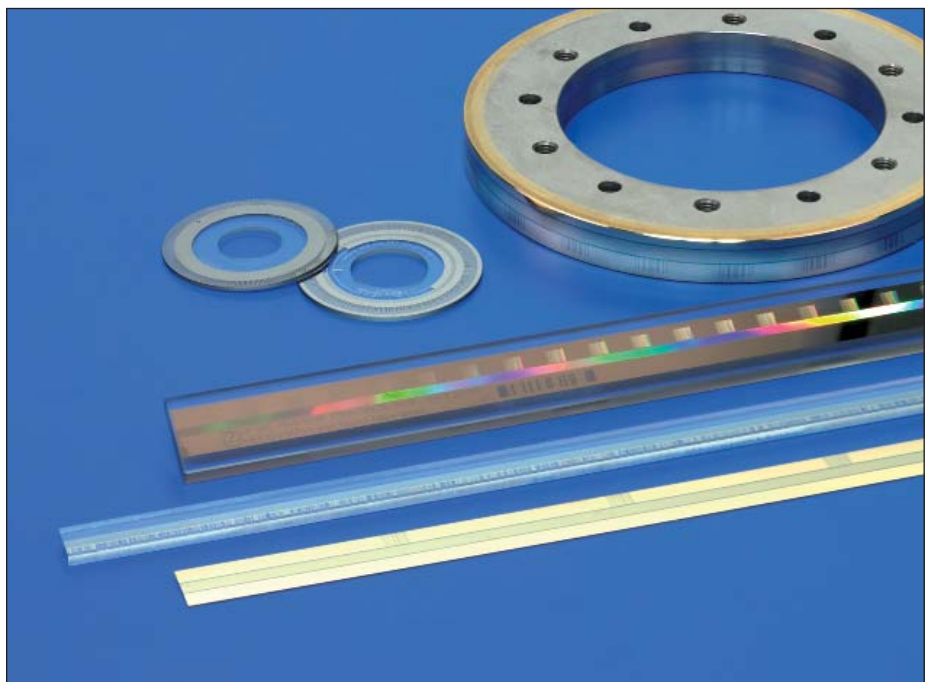
Graduations manufactured with the SUPRADUR process function optically like three-dimensional phase gratings, but they have a planar structure and are therefore particularly insensitive to contamination.

## OPTODUR

The OPTODUR process produces graduation structures with particularly high reflectance. Its composition as an optically three dimensional, planar structure is similar to the SUPRADUR graduation.

## MAGNODUR

Thin magnetically active layers in the micron range are structured for very fine, magnetized graduations.



DIADUR and METALLUR graduations on various carrier materials

# Length measurement

## Sealed linear encoders

Sealed linear encoders from HEIDENHAIN are protected from dust, chips and splash fluids and are ideal for operation on **machine tools**.

- Accuracy grades as fine as  $\pm 2 \mu\text{m}$
- Measuring steps to  $0.001 \mu\text{m}$
- Measuring lengths up to 30 m (to 72 m upon request)
- Fast and simple installation
- Large mounting tolerances
- High acceleration loading
- Protection against contamination

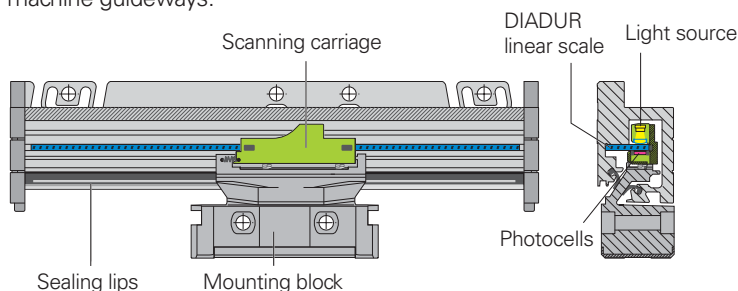


Sealed linear encoders are available with

- **Full-size scale housing**
  - For high vibration loading
  - Up to 30 m measuring length (72 m upon request)
- **Slimline scale housing**
  - For limited installation space
  - Up to 1240 mm measuring length, up to 2040 mm with mounting spar or tensioning elements

The aluminum housing of a HEIDENHAIN sealed linear encoder protects the scale, scanning carriage, and its guideway from chips, dust, and fluids. Downward-oriented elastic lips seal the housing.

The scanning carriage travels along the scale on a low-friction guide. It is connected to the external mounting block by a coupling that compensates unavoidable misalignment between the scale and the machine guideways.



## Exposed linear encoders

Exposed linear encoders from HEIDENHAIN operate with no mechanical contact between the scanning head and the scale or scale tape. Typical areas of application for these encoders include **measuring machines, comparators** and other **precision devices**, as well as **production and measuring equipment**, for example in the semiconductor industry.

- Accuracy grades of  $\pm 0.5 \mu\text{m}$  and better
- Measuring steps to  $0.001 \mu\text{m}$  (1 nm)
- Measuring lengths up to 30 m
- No friction between scanning head and scale
- Small dimensions and low mass
- High traversing speeds



### Length gauges

Length gauges from HEIDENHAIN feature integral guideways for the plunger.

They are used to monitor measuring equipment, in industrial metrology, and as position encoders.

- Accuracy grades as fine as  $\pm 0.1 \mu\text{m}$
- Measuring steps to  $0.005 \mu\text{m}$  (5 nm)
- Measuring lengths up to 100 mm
- High measuring accuracy
- Available with automated plunger drive
- Simple mounting



With **incremental linear encoders**, the current position is determined by starting at a datum and counting measuring steps, or by subdividing and counting signal periods. Incremental encoders from HEIDENHAIN feature reference marks, which must be scanned after switch-on to reestablish the reference point. This process is especially simple and fast with distance-coded reference marks.

**Absolute linear encoders** from HEIDENHAIN require no previous traverse to provide the current position value. The encoder transmits the absolute value through the **EnDat interface** or another serial interface.

The recommended **measuring steps** listed in the table refer primarily to position measurements. Smaller measuring steps, which are attained through higher interpolation factors of sinusoidal output signals, are useful in particular for applications in rotational speed control, e.g. on direct drives.

Under the designation **functional safety**, HEIDENHAIN offers encoders with purely serial data transmission as single-encoder systems for safety-related machines and systems. The two measured values are already formed independently of each other in the encoder, and are transmitted to the safe control via the EnDat interface.

Sealed linear encoders		Series	Page
<b>With full-size scale housing</b>	Absolute position measurement	<b>LC 100</b>	<b>8</b>
	Absolute position measurement and large measuring lengths	<b>LC 200</b>	
	Incremental position measurement	<b>LS 100</b>	
	Very high repeatability	<b>LF 100</b>	
	Typically for manual machines	<b>LS 600</b>	
	Large measuring lengths	<b>LB 300</b>	
<b>With slimline scale housing</b>	Absolute position measurement	<b>LC 400</b>	<b>10</b>
	Incremental position measurement	<b>LS 400</b>	
	Very high repeatability	<b>LF 400</b>	
	Typically for manual machines	<b>LS 300</b>	
<b>Exposed linear encoders</b>	Very high accuracy	<b>LIP, LIF</b>	<b>12</b>
	Two-coordinate encoders	<b>PP</b>	<b>13</b>
	High traversing speed and large measuring lengths	<b>LIDA</b>	<b>14</b>
	Absolute position measurement	<b>LIC</b>	
<b>Length gauges</b>	For measuring stations and multipoint inspection apparatuses	<b>AT, CT, MT, ST</b>	<b>16</b>



# LC, LF, LS, LB sealed linear encoders

## With full-size scale housing

Linear encoders with **full-size scale housing** are characterized particularly by high tolerance to vibration.

Absolute linear encoders of the **LC 100** and **LC 200** series provide the **absolute position value** without any previous traverse required. Depending on the version, incremental signals can be output additionally. The LC 100 can be mounted to the same mating dimensions as the incremental linear encoders of the **LS 100** series and feature the same mechanical design. Because of their high accuracy and defined thermal behavior, LC 100 and LS 100 series linear encoders are especially well suited for use on **numerically controlled machine tools**.

The incremental encoders of the **LF** type feature measuring standards with relatively fine grating periods. This makes them particularly attractive for applications requiring very **high repeatability**.

The **LS 600** series incremental linear encoders are used for simple positioning tasks, for example on **manual machine tools**.

The **LC 200** (absolute) and **LB** (incremental) linear encoders were conceived for very **long measuring lengths**. Their measuring standard—a steel tape with METALLUR or AURODUR graduation—is delivered as a single piece, and after the housing sections have been mounted, is pulled into the housing, drawn to a defined tension and fixed at both ends to the machine casting.

### LC 100 series

- **Absolute position measurement**
- Defined thermal behavior
- High vibration rating
- Two mounting attitudes
- Single-field scanning

### LC 200 series

- **Absolute position measurement for large measuring lengths** up to 28 m
- Defined thermal behavior
- High vibration rating
- Two mounting attitudes
- Single-field scanning

### LS 100 series

- **Incremental position measurement**
- Defined thermal behavior
- High vibration rating
- Two mounting attitudes
- Single-field scanning

### LF 185

- **Very high repeatability**
- Thermal behavior similar to steel or cast iron
- High vibration rating
- Two mounting attitudes
- Single-field scanning

### LB 382

- **For large measuring lengths** up to 30 m<sup>4)</sup>
- Defined thermal behavior
- High vibration rating
- Two mounting attitudes
- Single-field scanning

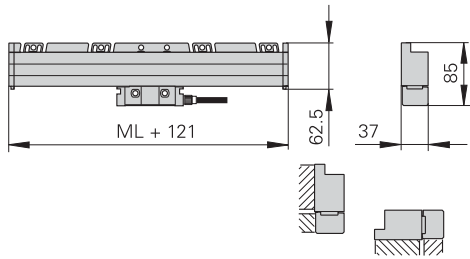
### LS 600 series

- **Typically for manual machines**
- Simple installation

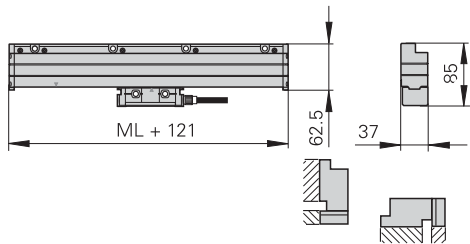
	<b>Absolute</b> LC 115 <sup>1)</sup> /LC 185 LC 195 F/M/S <sup>1)</sup>	LC 211/LC 281 LC 291 F/M
<b>Measuring standard</b>	DIADUR glass scale	METALLUR steel scale
Grating period	20 µm	40 µm
<b>Interface</b>	LC 115: EnDat 2.2 LC 185: EnDat 2.2 with ~ 1 V <sub>PP</sub> LC 195: Fanuc αi/Mitsubishi/ Siemens DRIVE-CLiQ	LC 211: EnDat 2.2 LC 281: EnDat 2.2 with ~ 1 V <sub>PP</sub> LC 291: Fanuc αi/Mitsubishi
Signal period	LC 185: 20 µm	LC 281: 40 µm
<b>Accuracy grade</b>	±5 µm, ±3 µm <sup>3)</sup>	±5 µm
<b>Meas. lengths ML</b>	Up to 4240 mm	Up to 28040 mm
<b>Reference mark</b>	–	

<sup>1)</sup> **Functional safety** upon request

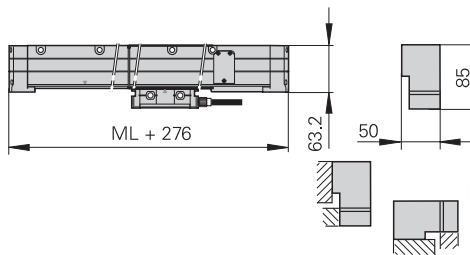
<sup>2)</sup> 5/10/20-fold integrated interpolation



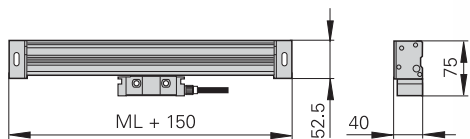
LC 100



LF 185



LC 200



LS 600

Incremental LF 185	LS 187 LS 177	LS 688C LS 628C	LB 382
SUPRADUR phase grating on steel 8 µm	DIADUR glass scale 20 µm	DIADUR glass scale 20 µm	AURODUR steel scale tape 40 µm
~ 1 V <sub>PP</sub>	LS 187: ~ 1 V <sub>PP</sub> LS 177: □TTL <sup>2)</sup>	LS 688C: ~ 1 V <sub>PP</sub> LS 628C: □TTL	~ 1 V <sub>PP</sub>
4 µm	LS 187: 20 µm	LS 688C: 20 µm	40 µm
±3 µm, ±2 µm	±5 µm, ±3 µm	±10 µm	±5 µm
Up to 3040 mm	Up to 3040 mm		Up to 30040 mm <sup>4)</sup>
One or distance-coded; LS 6xxC: distance-coded			

<sup>3)</sup> Up to ML 3040 mm

<sup>4)</sup> Up to ML 72040 mm upon request

# LC, LF, LS sealed linear encoders

## With slimline scale housing

Sealed linear encoders with **slimline scale housing** are primarily used where installation space is limited.

Absolute linear encoders of the **LC 400** series provide the **absolute position value** without any previous traverse required. Like the **LS 400** series incremental linear encoders, their high accuracy and defined thermal behavior make them especially well suited for use on **numerically controlled machine tools**.

The incremental encoders of the **LF** type feature measuring standards with relatively fine grating periods. This makes them particularly attractive for applications requiring very **high repeatability**.

The **LS 300** series incremental linear encoders are used for simple positioning tasks, for example on **manual machine tools**.

### LC 400 series

- **Absolute position measurement**
- Defined thermal behavior
- Single-field scanning

### LS 400 series

- **Incremental position measurement**
- Defined thermal behavior
- Single-field scanning

### LF 485

- **Very high repeatability**
- Thermal behavior similar to steel or cast iron
- Single-field scanning

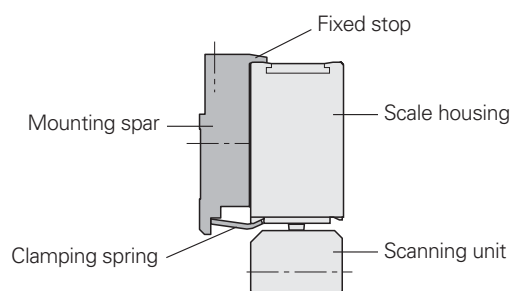
### LS 300 series

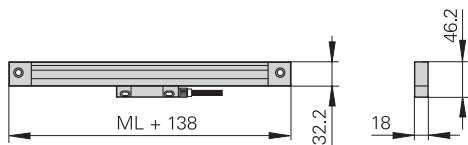
- **Typically for manual machines**

### Simple installation with mounting spar

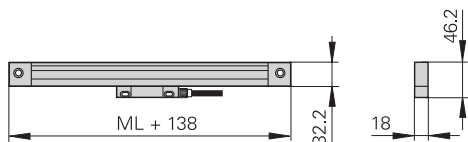
The use of a mounting spar is of great benefit when mounting slimline linear encoders. It can be fastened as part of the machine assembly process. The encoder is then simply clamped on during final mounting. Easy exchange also facilitates servicing.

Moreover, installation with a mounting spar significantly improves the encoder's acceleration behavior.

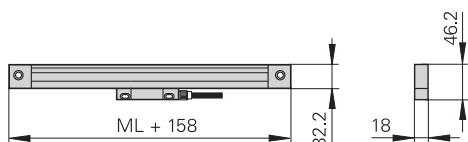




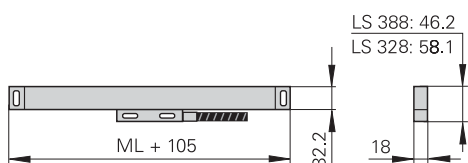
LC 400



LS 400



LF 485



LS 300

	<b>Absolute</b> LC 415 <sup>1)</sup> /LC 485 LC 495F/M/S <sup>1)</sup>	<b>Incremental</b> LF 485	LS 487 LS 477	LS 388C LS 328C
<b>Measuring standard</b>	DIADUR glass scale	SUPRADUR phase grating on steel	DIADUR glass scale	DIADUR glass scale
Grating period	20 µm	8 µm	20 µm	20 µm
<b>Interface</b>	LC 415: EnDat 2.2 LC 485: EnDat 2.2 with ~ 1 V <sub>PP</sub> LC 495: Fancu αi/Mitsubishi/ Siemens DRIVE-CLiQ	~ 1 V <sub>PP</sub>	LS 487: ~ 1 V <sub>PP</sub> LS 477: □□TTL <sup>2)</sup>	LS 388C: ~ 1 V <sub>PP</sub> LS 328C: □□TTL
Signal period	LC 485: 20 µm	4 µm	LS 487: 20 µm	LS 388C: 20 µm
<b>Accuracy grade</b>	±5 µm, ±3 µm	±5 µm, ±3 µm		±10 µm
<b>Meas. lengths ML</b>	Up to 2040 mm <sup>3)</sup>	Up to 1220 mm	Up to 2040 mm <sup>3)</sup>	Up to 1240 mm
<b>Reference mark</b>	–	One or distance-coded		Distance-coded

<sup>1)</sup> **Functional safety** upon request

<sup>2)</sup> Integrated 5/10/20-fold interpolation

<sup>3)</sup> Over ML 1240 mm only with mounting spar or tensioning elements

DRIVE-CLiQ is a registered trademark of SIEMENS AG.

# LIP, LIF exposed linear encoders

For very high accuracy

The exposed linear encoders of the **LIP** and **LIF** types are characterized by small measuring steps together with high accuracy. The measuring standard is a phase grating applied to a substrate of glass or glass ceramic.

**LIP** and **LIF** encoders are typically used for:

- Measuring machines and comparators
- Measuring microscopes
- Ultra-precision machines such as diamond lathes for optical components, facing lathes for magnetic storage disks, and grinding machines for ferrite components
- Measuring and production equipment in the semiconductor industry
- Measuring and production equipment in the electronics industry

Special **vacuum applications in high vacuum** are served by LIF 481V and LIP 481V (for high vacuum, down to  $10^{-7}$  bar) and LIP 481U (for ultrahigh vacuum, down to  $10^{-11}$  bar).

## LIP 300 series

- **Very high resolution** with measuring steps to 1 nm
- Very high repeatability through an extremely fine signal period
- Defined thermal behavior thanks to a measuring standard on Zerodur glass ceramic

## LIP 200 series

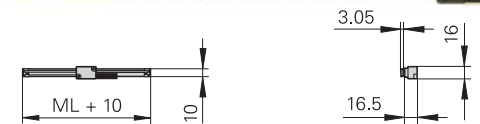
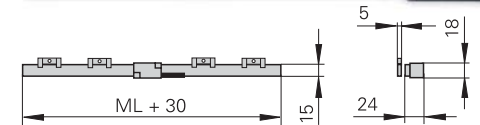
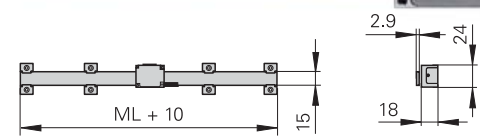
- Measuring lengths up to 3040 mm
- Measuring step down to 1 nm
- Very high repeatability with compact dimensions
- Defined thermal behavior thanks to a measuring standard on Zerodur glass ceramic

## LIP 400 series

- Small dimensions
- Measuring steps as fine as  $0.005 \mu\text{m}$
- Scale available with various thermal expansion coefficients

## LIF 400 series

- **Fast, simple scale fastening** with PRECIMET adhesive film
- Relatively insensitive to contamination thanks to SUPRADUR graduation
- Position detection through limit switches and homing track



	<b>Incremental</b> <b>LIP 382</b> <b>LIP 372</b> <sup>1)</sup>	<b>LIP 281</b> <b>LIP 211</b>	<b>LIP 481</b> <b>LIP 471</b>
<b>Measuring standard</b>	DIADUR phase grating on Zerodur glass ceramic Grating period 0.512 $\mu\text{m}$ Coefficient of linear expansion $\alpha_{\text{therm}} \approx (0 \pm 0.1) \times 10^{-6} \text{K}^{-1}$	OPTODUR phase grating on Zerodur glass ceramic 2.048 $\mu\text{m}$ $\alpha_{\text{therm}} \approx (0 \pm 0.1) \times 10^{-6} \text{K}^{-1}$	DIADUR phase grating on glass or Zerodur glass ceramic 4 $\mu\text{m}$ $\alpha_{\text{therm}} \approx 8 \times 10^{-6} \text{K}^{-1}$ (glass) or $\alpha_{\text{therm}} \approx (0 \pm 0.1) \times 10^{-6} \text{K}^{-1}$ (Zerodur)
<b>Interface</b>	<b>LIP 382:</b> $\sim$ 1 V <sub>PP</sub> <b>LIP 372:</b> $\square$ TTL	<b>LIP 281:</b> $\sim$ 1 V <sub>PP</sub> <b>LIP 211:</b> EnDat 2.2 <sup>2)</sup>	<b>LIP 481:</b> $\sim$ 1 V <sub>PP</sub> <b>LIP 471:</b> $\square$ TTL <sup>3)</sup>
Signal period	<b>LIP 382:</b> 0.128 $\mu\text{m}$	<b>LIP 281:</b> 0.512 $\mu\text{m}$	<b>LIP 481:</b> 2 $\mu\text{m}$
<b>Accuracy grade</b>	$\pm 0.5 \mu\text{m}$	$\pm 1 \mu\text{m}$ $\pm 3 \mu\text{m}$	$\pm 1 \mu\text{m}$ ; $\pm 0.5 \mu\text{m}$
<b>Position error per signal period</b> typically	$\pm 0.001 \mu\text{m}$	$\pm 0.001 \mu\text{m}$	$\pm 0.02 \mu\text{m}$
<b>Meas. lengths ML</b>	70 mm to 270 mm	20 mm to 1020 mm      370 mm to 3040 mm	70 mm to 420 mm
<b>Reference mark</b>	None	One	One

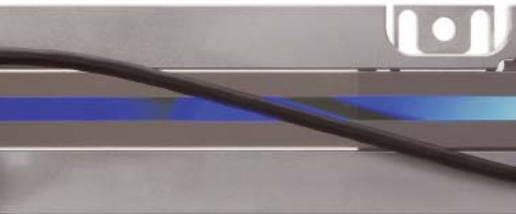
<sup>1)</sup> 32-fold integrated interpolation

<sup>2)</sup> Absolute position value after scanning the reference mark

<sup>3)</sup> 5/10-fold integrated interpolation

# PP exposed linear encoders

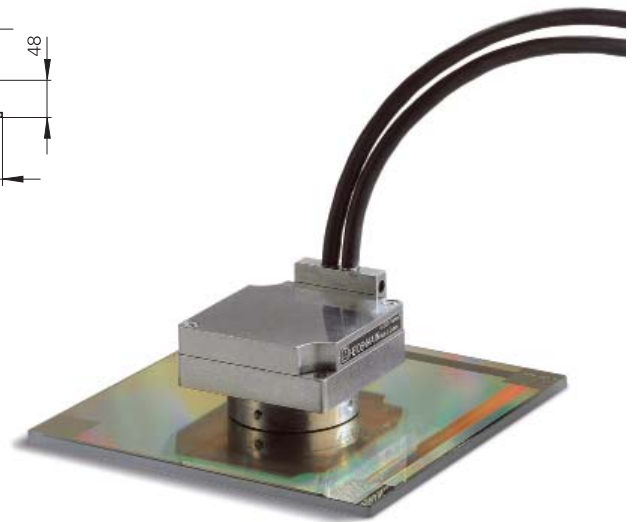
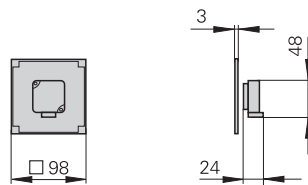
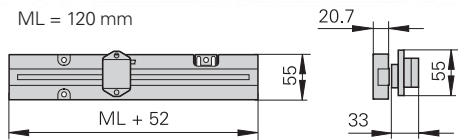
## Two-coordinate encoders



The **PP** two-coordinate encoders feature as measuring standard a planar phase-grating structure on a glass substrate. This makes it possible to measure positions in a plane.

Applications include:

- Measuring and production equipment in the semiconductor industry
- Measuring and production equipment in the electronics industry
- Extremely fast X-Y tables
- Measuring machines and comparators
- Measuring microscopes



LIF 481 LIF 471	
	SUPRADUR phase grating on glass or Zerodur glass ceramic 8 $\mu\text{m}$ $\alpha_{\text{therm}} \approx 8 \times 10^{-6} \text{ K}^{-1}$ (glass) or $\alpha_{\text{therm}} \approx (0 \pm 0.1) \times 10^{-6} \text{ K}^{-1}$ (Zerodur)
	LIF 481: $\sim 1 V_{\text{PP}}$ LIF 471: $\square$ TTL <sup>3)</sup>
	LIF 481: 4 $\mu\text{m}$
	$\pm 1 \mu\text{m}$ (only Zerodur); $\pm 3 \mu\text{m}$
	$\pm 0.04 \mu\text{m}$
	70 mm to 1020 mm (up to 3040 mm upon request)
	One

	Incremental PP 281
<b>Measuring standard</b> Grating period Coefficient of linear expansion	DIADUR phase grating on glass 8 $\mu\text{m}$ $\alpha_{\text{therm}} \approx 8 \times 10^{-6} \text{ K}^{-1}$
<b>Interface</b>	$\sim 1 V_{\text{PP}}$
Signal period	4 $\mu\text{m}$
<b>Accuracy grade</b>	$\pm 2 \mu\text{m}$
<b>Position error per signal period</b> typically	$\pm 0.04 \mu\text{m}$
<b>Measuring range</b>	68 mm x 68 mm, other measuring ranges upon request
<b>Reference mark</b>	One per coordinate

# LIC, LIDA exposed linear encoders

For high accuracy and large measuring lengths

The **LIC** and **LIDA** exposed linear encoders are designed for **high traversing speeds** up to 10 m/s and **large measuring lengths** of up to 30 m.

The **LIC** makes **absolute position measurement** possible over measuring lengths up to 28 m. In their dimensions, they correspond to LIDA 400 and LIDA 200 incremental linear encoders.

On the **LIC** and **LIDA** linear encoders, steel scale tapes typically serve as substrate for METALLUR graduations. With the LIC 41x3 and **LIDA 4x3**, graduation carriers of glass or glass ceramics permit **thermal adaptation** thanks to their different coefficients of linear expansion.

LIC and LIDA exposed linear encoders are typically used for:

- Coordinate measuring machines
- Inspection machines
- PCB assembly machines
- PCB drilling machines
- Precision handling devices
- Position and velocity measurement on linear motors

LIC and LIDA are particularly easy to mount with **various mounting possibilities**:

### LIC 41x3, LIDA 4x3

- Scale of glass or glass ceramic is bonded directly onto the mounting surface.

### LIC 41x5, LIDA 4x5

- One-piece steel scale tape is drawn into an aluminum extrusion and tensioned at its ends.
- The aluminum extrusions can be screwed or bonded onto the mounting surface.

### LIC 41x7, LIC 21x7, LIDA 4x7, LIDA 2x7

- One-piece steel scale-tape is drawn into aluminum extrusions and fixed at center.
- The aluminum extrusions are bonded onto the mounting surface.

### LIC 41x9, LIC 21x9, LIDA 4x9, LIDA 2x9

- One-piece steel scale tape is bonded directly to the mounting surface.

### LIC 4100 series

- **Absolute position acquisition** up to 28 m
- Various mounting options

### LIDA 400 series



- Large **measuring lengths up to 30 m**
- Various mounting options
- Limit switches

### LIC 2100 series

- **Absolute position measurement**
- Large mounting tolerances
- For simple applications

### LIDA 200 series

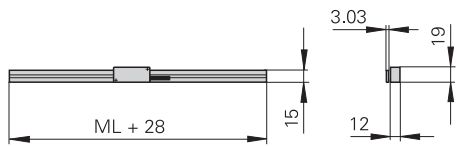
- **Scale tape cut from roll**
- Large mounting tolerances
- For simple applications
- Simple installation through integrated function display

	<b>Absolute</b> LIC 4113 LIC 4193 F/M	LIC 4115 LIC 4195 F/M	LIC 4117 LIC 4197 F/M	LIC 4119 LIC 4199 F/M	<b>Incremental</b> LIDA 483 LIDA 473
<b>Measuring standard</b> Grating period Coefficient of linear expansion	METALLUR graduation on glass ceramic or glass 40 µm $\alpha_{\text{therm}} \approx 8 \times 10^{-6} \text{ K}^{-1}$ (glass) $\alpha_{\text{therm}} \approx (0 \pm 0.1) \times 10^{-6} \text{ K}^{-1}$ (Zerodur glass ceramic)	METALLUR steel scale tape 40 µm <i>LIC 4115</i> : $\alpha_{\text{therm}}$ Same as mounting surface <i>LIC 4117/LIC 4119</i> : $\alpha_{\text{therm}} \approx 10 \times 10^{-6} \text{ K}^{-1}$			METALLUR graduation on glass ceramic or glass 20 µm $\alpha_{\text{therm}} \approx 8 \times 10^{-6} \text{ K}^{-1}$ (glass) $\alpha_{\text{therm}} \approx (0 \pm 0.1) \times 10^{-6} \text{ K}^{-1}$ (Zerodur glass ceramic)
<b>Interface</b>	<i>LIC 411x</i> : EnDat 2.2 <i>LIC 419x</i> : Fanuc $\alpha$ /Mitsubishi				<i>LIDA 48x</i> :  1 V <sub>PP</sub> <i>LIDA 47x</i> :  TTL <sup>1)</sup>
Signal period	–				<i>LIDA 48x</i> : 20 µm
<b>Accuracy grade</b>	±3 µm; ±5 µm	±5 µm	±3 µm <sup>3)</sup> ; ±5 µm <sup>3)</sup> ; ±15 µm	±3 µm; ±15 µm	±1 µm <sup>4)</sup> ; ±3 µm; ±5 µm
<b>Position error per signal period</b> typically	±0.04 µm				±0.2 µm
<b>Meas. lengths ML</b>	240 mm to 3040 mm	140 mm to 28440 mm	240 mm to 6040 mm	70 mm to 1020 mm	240 mm to 3040 mm
<b>Reference mark</b>	–				One or distance-coded

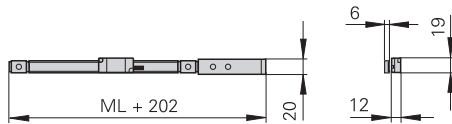
<sup>1)</sup> Integrated 5/10/50/100-fold interpolation

<sup>2)</sup> Integrated 10/50/100-fold Interpolation

<sup>3)</sup> Up to measuring length 1020 mm or 1040 mm



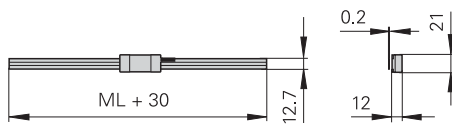
LIC 4113



LIDA 485



LIC 2117



LIDA 279

LIDA 485 LIDA 475	LIDA 487 LIDA 477	LIDA 489 LIDA 479	Incremental LIDA 287 LIDA 277	LIDA 289 LIDA 279	Absolute LIC 2117 LIC 2197 F/M/P	LIC 2119 LIC 2199 F/M/P
METALLUR steel scale tape			Steel scale tape		Steel scale tape	
20 µm LIDA 4x5: $\alpha_{\text{therm}}$ Same as mounting surface LIDA 4x7/LIDA 4x9: $\alpha_{\text{therm}} \approx 10 \times 10^{-6} \text{ K}^{-1}$			200 µm $\alpha_{\text{therm}} \approx 10 \times 10^{-6} \text{ K}^{-1}$		220 µm $\alpha_{\text{therm}} \approx 10 \times 10^{-6} \text{ K}^{-1}$	
			LIDA 28x: $\sim 1 \text{ V}_{\text{PP}}$ LIDA 27x: $\square \square \text{ TTL}^2$		LIC 211x: EnDat 2.2 LIC 219x: Fanuc $\alpha$ /Mitsubishi/ Panasonic	
			LIDA 28x: 200 µm		-	
±5 µm	±3 µm <sup>3</sup> ; ±5 µm <sup>3</sup> ; ±15 µm	±3 µm; ±15 µm	±15 µm		±15 µm	
±0.2 µm			±2 µm		±2 µm	
140 mm to 30040 mm	240 mm to 6040 mm		Scale tape from the roll 3 m/5 m/10 m		120 mm to 3020 mm (larger measuring lengths upon request)	
One			Selectable every 100 mm		-	

<sup>4)</sup> Only for Zerodur glass ceramics up to ML 1640 mm



# AT, CT, MT, ST length gauges

For measuring stations and multipoint inspection apparatuses

HEIDENHAIN length gauges are characterized by high accuracy together with large strokes up to 100 mm. They feature plungers with integral bearings and therefore serve as compact measuring devices.

The **HEIDENHAIN-CERTO** CT length gauges are used predominantly for production quality control of high-precision parts and for the monitoring and calibration of reference standards.

The **HEIDENHAIN-METRO** MT 1200 and MT 2500 length gauges are ideal for precision measuring stations and testing equipment. The ball-bush guided plunger tolerates high radial forces.

The primary applications for the MT 60 and MT 101 are incoming inspection, production monitoring, quality control, but also as high-accuracy position encoders, for example on linear slides or X-Y tables.

Thanks to their very small dimensions, the **HEIDENHAIN-ACANTO** AT and **HEIDENHAIN-SPECTO** ST series length gauges are the product of choice for multipoint inspection apparatus and testing equipment.

## Plunger actuation

The plungers of the length gauges with **motorized** plunger actuation are extended and retracted by an integral motor. They are operated through the associated switch box.

Length gauges with plunger actuation by **coupling** have no plunger drive. The freely movable plunger is connected by a separate coupling with the moving machine element.

The length gauges with plunger actuation **by the measured object** or **with cable-type lifter** feature a spring-loaded plunger that is extended in its resting position.

The MT 1281 and ST 1288 length gauges are available with various gauging forces. Particularly for fragile materials this makes it possible to measure without deformation.

On the length gauges with **pneumatic** plunger actuation, the plunger is retracted by the integral spring at its rest position. It is extended to the measuring position by application of compressed air.

## HEIDENHAIN-ACANTO

- Absolute position measurement
- Compact dimensions
- Plug-in cables
- Measuring ranges up to 30 mm

## HEIDENHAIN-CERTO

- Very high accuracy
- Large measuring range up to 60 mm
- Very high thermal stability

## HEIDENHAIN-METRO

MT 1200 and MT 2500

- High accuracy
- Measuring range up to 25 mm
- High repeatability
- Various gauging force variants are available

## HEIDENHAIN-METRO

MT 60 and MT 101

- Large measuring range up to 100 mm
- High repeatability

## HEIDENHAIN-SPECTO

- Very compact dimensions
- Measuring range up to 25 mm
- Ball-bush guided plunger
- Various gauging force variants are available

	<b>Absolute</b> AT 1218 AT 1217		AT 3018 AT 3017	<b>Incremental</b> CT 2501 CT 2502		CT 6001 CT 6002	MT 1281 MT 1287	MT 1271
<b>Measuring standard</b>	DIADUR glass scale			DIADUR phase grating on Zerodur glass ceramic scale Coefficient of linear expansion: $\alpha_{\text{therm}} \approx (0 \pm 0.1) \times 10^{-6} \text{ K}^{-1}$				
Grating period	188.4 $\mu\text{m}$			4 $\mu\text{m}$		4 $\mu\text{m}$		
<b>Interface</b>	EnDat 2.2			$\sim 11 \mu\text{A}_{\text{PP}}$		$\sim 1 \text{V}_{\text{PP}}$		$\square$ TTL <sup>3)</sup>
Signal period	–			2 $\mu\text{m}$		–		
<b>System accuracy</b>	$\pm 2 \mu\text{m}$			$\pm 0.1 \mu\text{m}^{1)}$ $\pm 0.03 \mu\text{m}^{2)}$	$\pm 0.1 \mu\text{m}^{1)}$ $\pm 0.05 \mu\text{m}^{2)}$	$\pm 0.2 \mu\text{m}$		
<b>Measuring range</b>	12 mm	30 mm		25 mm	60 mm	12 mm		
<b>Plunger actuation</b>	AT xx18: By measured object AT xx17: Pneumatic			CT xx01: With motor CT xx02: By coupling		MT xxx1: Cable-type lifter or free MT xx87: Pneumatic		
<b>Reference mark</b>	–			One		One		

<sup>1)</sup> At 19 °C to 21 °C; permissible temperature fluctuation during measurement:  $\pm 0.1 \text{ K}$

<sup>2)</sup> With linear length-error compensation in the evaluation electronics

<sup>3)</sup> Integrated 5/10-fold interpolation



MT 101 M



CT 6001



MT 2581



AT 3018



ST 3088

MT 2581 MT 2587		MT 2571	MT 60M MT 60K		MT 101M MT 101K		ST 1288 ST 1287		ST 1278 ST 1277		ST 3088 ST 3087		ST 3078 ST 3077	
			DIADUR graduation on glass ceramic scale						DIADUR glass scale					
			10 µm						20 µm					
~ 1 V <sub>PP</sub>		□ TTL <sup>(3)</sup>	~ 11 µA <sub>PP</sub>			~ 1 V <sub>PP</sub>		□ TTL <sup>(3)</sup>		~ 1 V <sub>PP</sub>		□ TTL <sup>(3)</sup>		
2 µm		-	10 µm			20 µm		-		20 µm		-		
			±0.5 µm		±1 µm	±1 µm								
25 mm			60 mm		100 mm	12 mm			30 mm					
			<i>MT xxM</i> : With motor <i>MT xxK</i> : By coupling			<i>ST xxx8</i> : By measured object <i>ST xxx7</i> : Pneumatic								
			One			One								

## Angle encoders

HEIDENHAIN angle encoders are characterized by high accuracy values in the angular second range and better. These devices are used in applications such as rotary tables, swivel heads of machine tools, dividing apparatuses, high-precision angle measuring tables, precision devices in angular metrology, antennas and telescopes.

- Line counts typically 9000 to 180000
- Accuracy from  $\pm 5''$  to  $\pm 0.4''$
- Measuring steps as fine as  $0.00001^\circ$  or  $0.036''$  (incremental) or 29 bits, i.e. approx. 536 million positions per revolution (absolute)



## Rotary encoders

Rotary encoders from HEIDENHAIN serve as measuring sensors for rotary motion, angular velocity and also, when used in conjunction with mechanical measuring standards such as lead screws, for linear motion. Application areas include electrical motors, machine tools, printing machines, woodworking machines, textile machines, robots and handling devices, as well as various types of measuring, testing, and inspection devices.

- Line counts of typically 50 to 5000
- Accuracy grades to  $\pm 10''$  (depending on the line count, corresponding to  $\pm 1/20$  of the grating period)
- Measuring steps to  $0.001^\circ$ .  
Particularly with the photoelectric encoders, the high quality of the sinusoidal incremental signals permits high interpolation factors for digital speed control.



### Mounting variants

In angle encoders and rotary encoders with integral bearing and **stator coupling**, the graduated disk of the encoder is connected directly to the shaft to be measured. The scanning unit is guided on the shaft via ball bearings, supported by the stator coupling. Owing to this, the coupling has to absorb only the torque caused by friction in the bearing, particularly during angular acceleration of the shaft. These angle encoders therefore provide excellent dynamic performance. Thanks to the stator coupling, the system accuracy includes the error of the shaft coupling. Other benefits of the stator coupling are:

- Simple installation
- Short overall length
- High natural frequency of the coupling
- Hollow through shaft is possible

Angle encoders and rotary encoders with integral bearings that are conceived for a **separate shaft coupling** are designed with a solid shaft. The recommended coupling to the measured shaft compensates radial and axial tolerances. Angle encoders for separate shaft couplings permit higher shaft speeds.

Angle encoders and rotary encoders **without integral bearing** operate without friction. The two components—the scanning head and the scale disk, drum, or tape—are adjusted to each other during assembly. The benefits are:

- Requires little space
- Large hollow-shaft diameters
- High shaft speeds possible
- No additional starting torque



With **incremental angle encoders and rotary encoders**, the current position is determined by starting at a datum and counting measuring steps, or by subdividing and counting signal periods. Incremental encoders from HEIDENHAIN feature reference marks to reestablish the reference point.

**Incremental rotary encoders with commutation signals** provide the angular shaft position value—without requiring previous traverse—with sufficient accuracy to correctly control the phases of the rotating field of a permanent-magnet three-phase motor.

**Absolute angle encoders and rotary encoders** require no previous traverse to provide the current position value. **Singleturn encoders** provide the current angular position value within one revolution, while **multiturn encoders** can additionally distinguish between revolutions. The position values are transmitted over an **EnDat, SSI, PROFIBUS-DP, PROFINET or other serial data interface**. The bidirectional EnDat interface, PROFIBUS-DP or PROFINET enable automatic configuration of the higher-level electronics and provide monitoring and diagnostic functions.

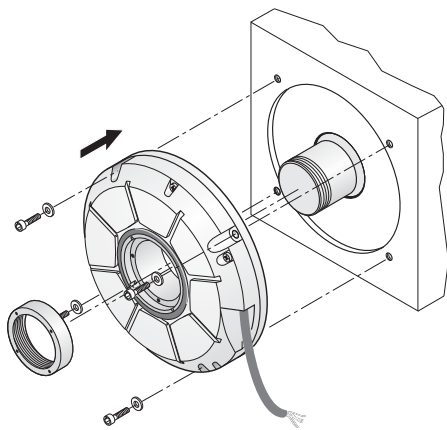
Under the designation **functional safety**, HEIDENHAIN offers encoders with purely serial data transmission as single-encoder systems for safety-related machines and systems. The two measured values are already formed independently of each other in the encoder, and are transmitted to the safe control via the EnDat interface.

Angle encoders		Series	Page
<b>With integral bearing and integrated stator coupling</b>	Absolute (singleturn) Incremental	<b>RCN</b> <b>RON, RPN</b>	<b>20</b>
<b>With integral bearing, for separate shaft coupling</b>	Incremental	<b>ROD</b>	<b>22</b>
<b>Without integral bearing</b>	Incremental	<b>ERP, ERO, ERA</b>	<b>23 – 27</b>
<b>Modular magnetic encoders</b>	Incremental	<b>ERM</b>	<b>28</b>
Rotary encoders			
<b>With integral bearing, for mounting by stator coupling</b>	Absolute (singleturn/multiturn) Incremental	<b>ECN/EQN</b> <b>ERN</b>	<b>30, 32</b>
<b>With integral bearing, for separate shaft coupling</b>	Absolute (singleturn/multiturn) Incremental	<b>ROC/ROQ, RIC/RIQ</b> <b>ROD</b>	<b>34</b>
<b>Without integral bearing</b>	Absolute (singleturn/multiturn) Incremental	<b>ECI/EQI, EBI</b> <b>ERO</b>	<b>36</b>

# RCN, RON, RPN angle encoders

With integral bearing and integrated stator coupling

Because of their high static and dynamic accuracy, the **RCN, RON** and **RPN** angle encoders with integral bearings and integral stator couplings are the preferred units for high-precision applications such as rotary tables and tilting axes. The measuring standard is a circular scale with DIADUR graduation or—with the RPN—a phase grating. For the units with stator coupling, the specified accuracy includes the error caused by the coupling. For angle encoders with separate shaft coupling, the coupling error must be added to find the system accuracy.

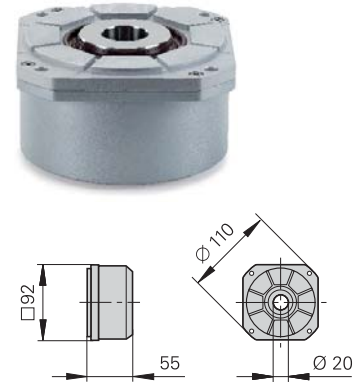


Features of the **RCN 2000, RCN 5000** and **RCN 8000** series angle encoders:

- **Optimized scanning** with large scanning surface for absolute track (serial code structure) and incremental track (single-field scanning and optical filtering)
- **Large mounting tolerances** thanks to optimized stator coupling with improved torsional rigidity and revised shaft seal
- **Plug-in cable with quick disconnect**
- **Scanning and evaluation electronics** for a large power supply range and additional monitoring and diagnostic capabilities

## RCN 2000 and RON 200 series

- **Compact design**
- Sturdy design
- Typically used with rotary tables, tilting tables, for positioning and speed control
- Versions in stainless steel (e.g. for antennas) available on request



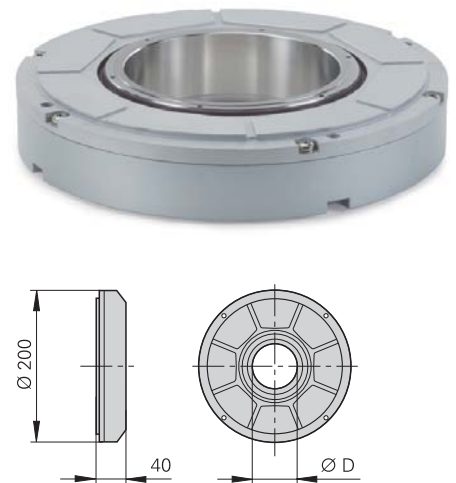
## RCN 5000 series

- **Large hollow shaft and small installation space**
- Stator mounting dimensions compatible with RCN 2000 and RON 200



## RCN 8000, RON 700 and RON/RPN 800 series

- **Large hollow shaft diameters** up to  $\varnothing 100$  mm
- System accuracy  $\pm 2''$  and  $\pm 1''$
- Typically used on rotary and angle measuring tables, indexing fixtures, measuring setups, image scanners



**RCN 8000**  
D = 60 mm or 100 mm  
**RON 786/886, RPN 886**  
D = 60 mm

## RON 905

- **Very high-accuracy angle encoder**
- System accuracy  $\pm 0.4''$
- Used with high-accuracy measuring devices and for the inspection of measuring equipment



	<b>Absolute</b> RCN 2380 RCN 2580		RCN 2310 <sup>1)</sup> RCN 2510 <sup>1)</sup>	RCN 2390 F RCN 2590 F	RCN 2390 M RCN 2590 M	<b>Incremental</b> RON 225 RON 275		RON 285 RON 287
<b>Interface</b>	EnDat 2.2 <sup>2)</sup> with ~ 1 V <sub>PP</sub>		EnDat 2.2 <sup>2)</sup>	Fanuc $\alpha$ i	Mitsubishi	□ TTL		~ 1 V <sub>PP</sub>
Position values/revolution	RCN 23x0: 67 108 864 (26 bits); RCN 25x0: 268 435 456 (28 bits)					–		
Signal periods/rev	16384	–				18000 <sup>3)</sup> 90000/180000 <sup>4)</sup>	18000	
<b>System accuracy</b>	RCN 23x0: $\pm 5''$ ; RCN 25x0: $\pm 2.5''$					$\pm 5''$	$\pm 5''$ ; $\pm 2.5''$	
<b>Mech. permissible speed</b>	$\leq 1500$ rpm					$\leq 3000$ rpm		

	<b>Absolute</b> RCN 5380 RCN 5580		RCN 5310 <sup>1)</sup> RCN 5510 <sup>1)</sup>	RCN 5390 F RCN 5590 F	RCN 5390 M RCN 5590 M
<b>Interface</b>	EnDat 2.2 <sup>2)</sup> with ~ 1 V <sub>PP</sub>		EnDat 2.2 <sup>2)</sup>	Fanuc $\alpha$ i	Mitsubishi
Position values/revolution	RCN 53x0: 67 108 864 (26 bits); RCN 55x0: 268 435 456 (28 bits)				
Signal periods/rev	16384	–			
<b>System accuracy</b>	RCN 53x0: $\pm 5''$ ; RCN 55x0: $\pm 2.5''$				
<b>Mech. permissible speed</b>	$\leq 1500$ rpm				

	<b>Absolute</b> RCN 8380 RCN 8580		RCN 8310 <sup>1)</sup> RCN 8510 <sup>1)</sup>	RCN 8390 F RCN 8590 F	RCN 8390 M RCN 8590 M	<b>Incremental</b> RON 786 RON 886 RPN 886		
<b>Interface</b>	EnDat 2.2 <sup>2)</sup> with ~ 1 V <sub>PP</sub>		EnDat 2.2 <sup>2)</sup>	Fanuc $\alpha$ i	Mitsubishi	~ 1 V <sub>PP</sub>		
Position values/revolution	536870912 (29 bits)					–		
Signal periods/rev	32 768	–	–			18000, 36000	36000	180000
<b>System accuracy</b>	RCN 83x0: $\pm 2''$ ; RCN 85x0: $\pm 1''$					$\pm 2''$	$\pm 1''$	
<b>Mech. permissible speed</b>	$\leq 500$ rpm					$\leq 1000$ rpm		

	<b>Incremental</b> RON 905
<b>Interface</b>	~ 11 $\mu$ A <sub>PP</sub>
Signal periods/rev	36000
<b>System accuracy</b>	$\pm 0.4''$
<b>Mech. permissible speed</b>	$\leq 100$ rpm

- 1) **Functional safety** upon request
- 2) DRIVE-CLiQ via EIB; PROFIBUS-DP via gateway
- 3) Integrated 2-fold interpolation
- 4) Integrated 5/10-fold interpolation

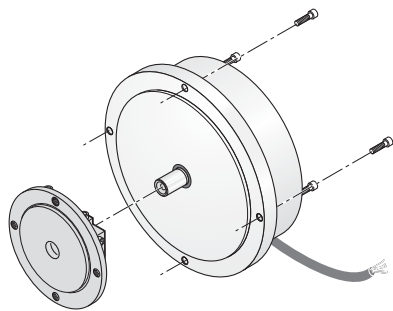
DRIVE-CLiQ is a registered trademark of SIEMENS AG.

# ROD angle encoders

With integral bearing, for separate shaft coupling

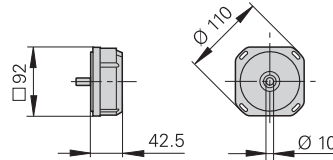
**ROD** angle encoders with solid shaft for separate shaft coupling are particularly attractive for applications where high shaft speeds and large mounting tolerances are required. The precision shaft couplings allow axial motion up to  $\pm 1$  mm.

ROD angle encoders feature a DIADUR circular scale as measuring standard. For angle encoders with separate shaft coupling, the angular measuring error caused by the shaft coupling must be added to determine the system accuracy.



## ROD 200 series

- **Compact design**
- Sturdy design
- Typically used with rotary tables, tilting tables, for positioning and synchronization monitoring

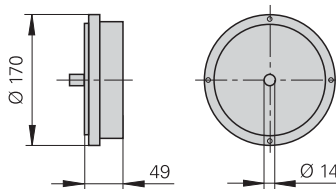


	<b>Incremental ROD 220</b>	<b>ROD 270</b>	<b>ROD 280</b>
<b>Interface</b>	□ TTL	□ TTL	~ 1 V <sub>PP</sub>
Signal periods/rev	18000 <sup>2)</sup>	180000 <sup>3)</sup>	18000
<b>System accuracy<sup>1)</sup></b>	±5"		
<b>Mech. permissible speed</b>	≤ 10000 rpm		

- 1) Without shaft coupling  
 2) Integrated 2-fold interpolation  
 3) Integrated 10-fold interpolation

## ROD 780 and ROD 880

- **High accuracy**  
**ROD 780: ±2"**  
**ROD 880: ±1"**
- Ideal for angle measurement on high-precision rotary tables, dividing apparatuses or measuring machines



	<b>Incremental ROD 780</b>	<b>ROD 880</b>
<b>Interface</b>	~ 1 V <sub>PP</sub>	
Signal periods/rev	18000, 36000	36000
<b>System accuracy<sup>1)</sup></b>	±2"	±1"
<b>Mech. permissible speed</b>	≤ 1000 rpm	

- 1) Without shaft coupling

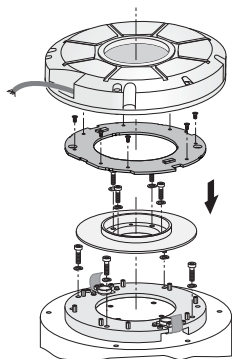
# ERP angle encoders

## Without integral bearing

The HEIDENHAIN **ERP** angle encoders without integral bearing are intended for integration in machine elements or components. They operate without friction and permit high accuracy.

This makes them particularly attractive for high-precision angle measuring tables and precision devices in angular metrology. The **ERP 4080** and **ERP 8080** angle encoders are designed for applications in the clean room.

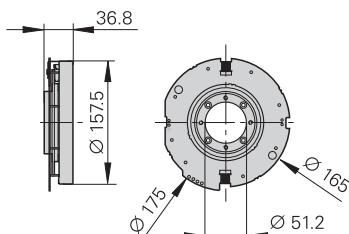
A circular scale with phase grating serves as the basis for the high accuracy of the ERP encoders. The attainable system accuracy depends on the eccentricity of the graduation to the drive shaft bearing, as well as the radial runout and wobble of the bearing.



Mounting the ERP 880

### ERP 880

- **Very high accuracy**
- Very fine grating period
- Low error within one signal period thanks to the interferential scanning principle

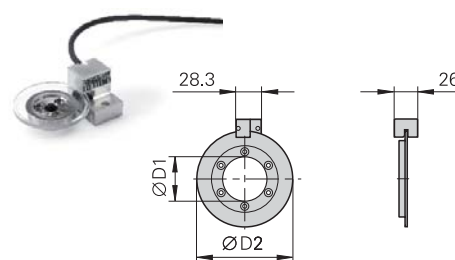


ERP 880 with housing

	<b>Incremental ERP 880</b>
<b>Interface</b>	$\sim 1 V_{PP}$
Signal periods/rev	180000
<b>Accuracy of graduation</b>	$\pm 0.9''$
<b>Mech. permissible speed</b>	$\leq 1000$ rpm

### ERP 4080 and ERP 8080

- **Very high resolution**
- High accuracy
- Very compact dimensions
- Low error within one signal period thanks to the interferential scanning principle



	<b>Incremental ERP 4080</b>	<b>ERP 8080</b>
<b>Interface</b>	$\sim 1 V_{PP}$	
Signal periods/rev	131072	360000
<b>Accuracy of graduation</b>	$\pm 2''$	$\pm 1''$
<b>Diameter D1/D2</b>	8 mm/44 mm	50 mm/108 mm
<b>Mech. permissible speed</b>	$\leq 300$ rpm	$\leq 100$ rpm



# ERO, ERA angle encoders

## Without integral bearing

The **ERO** and **ERA** HEIDENHAIN angle encoders with solid graduation carrier function without integral bearings. They are intended for integration in machine elements or components.

The attainable system accuracy depends on the eccentricity of the graduation to the drive shaft bearing, as well as the radial runout and wobble of the bearing.

The **ERO** angle encoders use a circular glass scale with hub as the graduation carrier. The EROs are primarily characterized by their low weight and compact dimensions. Applications are to be found in metrology, in compact rotary tables and in precise, highly dynamic drives.

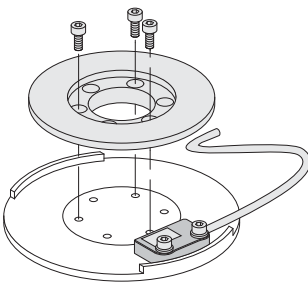
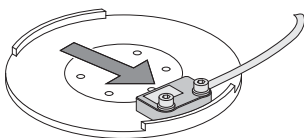
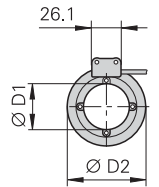
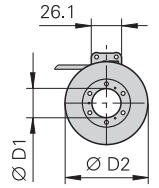
The **ERA** angle encoders feature a sturdy steel scale drum and are suited for high shaft speeds up to 10000 rpm. They are typically found on fast running spindles, on rotary tables and tilting axes.

### ERO 6000 series

- Very flat design
- High system accuracy
- Simple installation

### ERO 6100 series

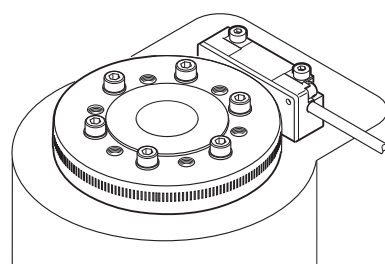
- For dynamic applications with reduced accuracy requirements
- Application examples include printing machines and handling axes.
- Large inside diameter



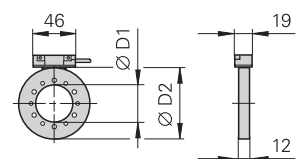
ERO 6000

### ERA 4000 series

- **High shaft speeds** up to 10000 rpm
- Sturdy design with steel scale drum and METALLUR graduation
- Axial motion of measured shaft permissible up to  $\pm 0.5$  mm
- The ERA 4480C is available for larger diameters or versions with protective cover
- Various **drum versions**  
**ERA 4x80C:** Solid design with centering collar for high shaft speeds  
**ERA 4282C:** Solid design with 3-point centering for higher accuracy requirements



ERA 4000



ERA 4000

Interface	
Inside diameter D1	
Outside diameter D2	
Signal periods/rev	ERA 4280C ERA 4480C ERA 4880C
Accuracy of graduation	
Mech. permissible speed	

	<b>Incremental ERO 6070</b>		<b>ERO 6080</b>		<b>ERO 6180</b>
<b>Interface</b>	□□TTL		~ 1 V <sub>PP</sub>		~ 1 V <sub>PP</sub>
<b>Inside diameter D1</b>	25 mm	95 mm	25 mm	95 mm	41 mm
<b>Outside diameter D2</b>	71 mm	150 mm	71 mm	150 mm	70 mm
<b>Signal periods/rev</b>	45000 to 450000 <sup>1)</sup>	90000 to 900000 <sup>1)</sup>	9000	18000	4096
<b>Accuracy of graduation</b>	±3"	±2"	±3"	±2"	±10"
<b>Mech. permissible speed</b>	≤ 1600 rpm	≤ 800 rpm	≤ 1600 rpm	≤ 800 rpm	≤ 3500 rpm

<sup>1)</sup> After integrated 5/10/50-fold interpolation

<b>Incremental</b>									
<b>ERA 4280 C</b> <sup>1)</sup> Signal period 20 μm									
<b>ERA 4480 C</b> Signal period 40 μm									
<b>ERA 4880 C</b> Signal period 80 μm									
~ 1 V <sub>PP</sub>									
40 mm	70 mm	80 mm	120 mm	150 mm	180 mm	270 mm	425 mm	512 mm	
76.75 mm	104.63 mm	127.64 mm	178.55 mm	208.89 mm	254.93 mm	331.31 mm	484.07 mm	560.46 mm	
12000	16384	20000	28000	32768	40000	52000	–	–	
6000	8192	10000	14000	16384	20000	26000	38000	44000	
3000	4096	5000	7000	8192	10000	13000	–	–	
±5"	±3.7"	±3"	±2.5"				±2"		
≤ 10000 rpm	≤ 8500 rpm	≤ 6250 rpm	≤ 4500 rpm	≤ 4250 rpm	≤ 3250 rpm	≤ 2500 rpm	≤ 1800 rpm	≤ 1500 rpm	

<sup>1)</sup> For other drum versions, please refer to our catalog *Angle Encoders without Integral Bearings*

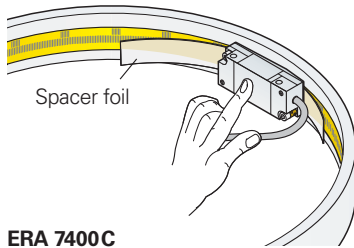
# ERA angle encoders

## Without integral bearing

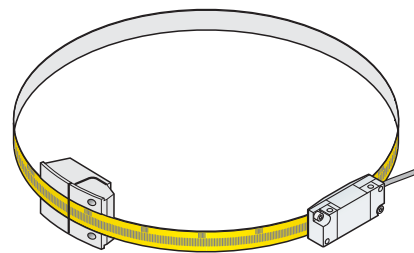
The HEIDENHAIN **ERA** angle encoders with steel scale tape as measuring standard function without integral bearings. They are intended for integration in machine elements or components. They are designed to meet the following requirements:

- Large hollow shaft diameters up to 10 m
- No additional starting torque from shaft seals

The attainable system accuracy depends on the machining accuracy of the scale-tape carrier diameter, on its radial runout and wobble.



ERA 7400C



ERA 8400C

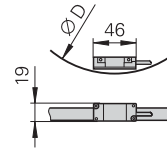
### ERA 7000 and ERA 8000 series

- **For very large diameters** up to 10 m
- METALLUR steel scale tape
- High accuracy even at the junction of the scale-tape ends

#### ERA 7000 series

Scale tape is placed in a slot on the inside circumference of the machine element

- **ERA 7400C:** Full-circle version
- **ERA 7401C:** Segment version

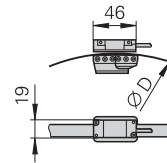


ERA 7481C

#### ERA 8000 series

Scale tape is fastened on the circumference of the machine element

- **ERA 8400C:** Full-circle version
- **ERA 8401C:** Segment version, scale tape secured with tensioning elements
- **ERA 8402C:** Segment version, scale tape secured without tensioning elements



ERA 8480C

	<b>Incremental ERA 7400C</b>		
<b>Interface</b>	~ 1 V <sub>PP</sub> ; signal period 40 μm (on circumference)		
Signal periods/rev	36000	45000	90000
<b>Accuracy of graduation</b>	±3.9"	±3.2"	±1.6"
<b>Accuracy of the scale tape</b>	±3 μm per meter tape length		
<b>Diameter D1</b>	458.62 mm	573.20 mm	1146.10 mm
<b>Mech. permissible speed</b>	≤ 250 rpm		≤ 220 rpm

	<b>Incremental ERA 8400C</b>		
<b>Interface</b>	~ 1 V <sub>PP</sub> ; signal period 40 μm (on circumference)		
Signal periods/rev	36000	45000	90000
<b>Accuracy of graduation</b>	±4.7"	±3.9"	±1.9"
<b>Accuracy of the scale tape</b>	±3 μm per meter tape length		
<b>Diameter D1</b>	458.04 mm	572.63 mm	1145.73 mm
<b>Mech. permissible speed</b>	≤ 50 rpm		≤ 45 rpm

# ERM modular magnetic encoders

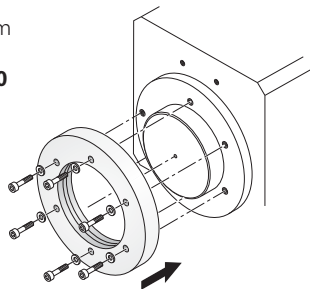
## Without integral bearing

The **ERM** modular encoders from HEIDENHAIN consist of a magnetized scale drum and a scanning unit. Their MAGNODUR measuring standard and the magnetoresistive scanning principle make them particularly tolerant to contamination.

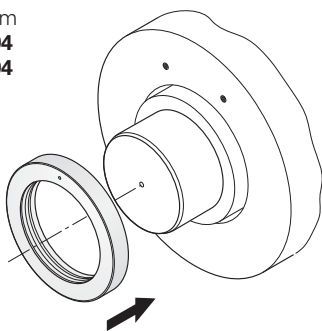
Typical fields of application include machines and equipment with reduced accuracy requirements and **large hollow shaft diameters** in environments with large amounts of airborne particles and liquids, for example:

- Rotary and tilting axes for ERM 2200
- C axes on lathes for ERM 200 and ERM 2410
- Main spindles on milling machines for ERM 2900 and ERM 2400

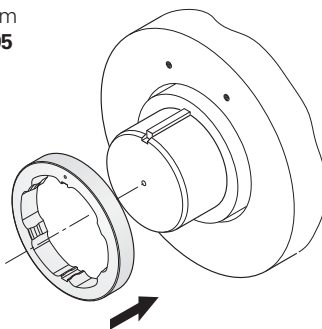
Scale drum  
**ERM 200**  
**ERM 2200**



Scale drum  
**ERM 2404**  
**ERM 2904**

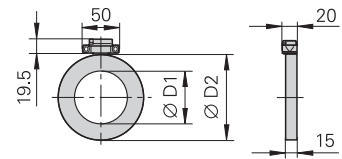


Scale drum  
**ERM 2405**



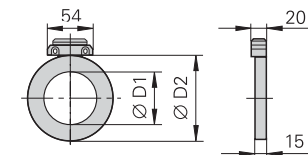
### ERM 2200 series

- High graduation accuracy
- Signal period 200  $\mu\text{m}$  at circumference
- Distance-coded reference marks
- Drum fastening with axial screws



### ERM 200 series

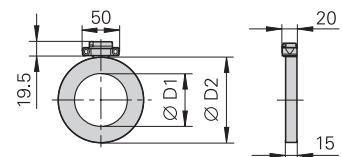
- For large shaft diameters up to 410 mm
- Drum fastening with axial screws



**ERM 200**

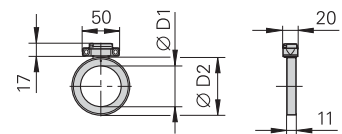
### ERM 2410

- Consists of ERM 2410 scanning head and the ERM 200C scale drum
- Incremental measuring method with distance-coded reference marks
- Integrated counting function for **absolute position-value output**
- Absolute position value after traverse of two reference marks



### ERM 2400 series

- Especially compact dimensions for limited installation space
- High mechanically permissible shaft speeds and therefore particularly well suited for spindles
- **ERM 2484**: Drum fastening by axial clamping
- **ERM 2485**: Drum fastening by axial clamping and feather key as anti-rotation element



**ERM 2484**



### ERM 2984 series

Except for its line count, the ERM 2984 modular encoder shares the same mechanical and electrical features as the ERM 2484.

<b>Incremental ERM 2200</b>						
<b>Interface</b>	~ 1 V <sub>PP</sub>					
Signal period	Approx. 200 µm (at circumference)					
<b>Inside diameter D1</b>	70 mm	80 mm	130 mm	180 mm	260 mm	380 mm
<b>Outside diameter D2</b>	113.16 mm	128.75 mm	176.03 mm	257.50 mm	326.90 mm	452.64 mm
<b>Line count/accuracy of graduation</b>	1800/±7"	2048/±6"	2800/±5"	4096/±3.5"	5200/±3"	7200/±2.5"
<b>Shaft speed<sup>1)</sup></b>	≤ 14500 rpm	≤ 13000 rpm	≤ 9000 rpm	≤ 6000 rpm	≤ 4500 rpm	≤ 3000 rpm
<b>Operating temperature</b>	-10 °C to 60 °C					

<b>Incremental ERM 220 ERM 280 ERM 2410</b>									
<b>Interface</b>	<i>ERM 220:</i> □TTL; <i>ERM 280:</i> ~ 1 V <sub>PP</sub> ; <i>ERM 2410:</i> EnDat 2.2 <sup>2)</sup>								
Signal period	Approx. 400 µm (at circumference); <i>ERM 2410:</i> –								
<b>Inside diameter D1</b>	40 mm	70 mm	80 mm	120 mm	130 mm	180 mm	220 mm	295 mm	410 mm
<b>Outside diameter D2</b>	75.44 mm	113.16 mm	128.75 mm	150.88 mm	176.03 mm	257.50 mm	257.50 mm	326.90 mm	452.64 mm
<b>Line count/accuracy of graduation</b>	600/±11"	900/±8"	1024/±7"	1200/±6"	1400/±5.5"	2048/±4"	2048/±5"	2600/±4"	3600/±3.5"
<b>Shaft speed<sup>1)</sup></b>	≤ 19000 rpm	≤ 14500 rpm	≤ 13000 rpm	≤ 10500 rpm	≤ 9000 rpm	≤ 6000 rpm	≤ 6000 rpm	≤ 4500 rpm	≤ 3000 rpm
<b>Operating temperature</b>	-10 °C to 100 °C								

<b>Incremental ERM 2484 ERM 2485<sup>3)</sup></b>					<b>ERM 2984<sup>4)</sup></b>			
<b>Interface</b>	~ 1 V <sub>PP</sub>							
Signal period	Approx. 400 µm (at circumference)				Approx. 1 mm (at circumference)			
<b>Inside diameter D1</b>	40 mm	55 mm	80 mm	100 mm	40 mm	55 mm	60 mm	100 mm
<b>Outside diameter D2</b>	64.37 mm	75.44 mm	113.16 mm	128.75 mm	58.06 mm	77.41 mm	90.72 mm	120.96 mm
<b>Line count/accuracy of graduation</b>	512/±17"	600/±14"	900/±10"	1024/±9"	192/±68"	256/±51"	300/±44"	400/±33"
<b>Shaft speed<sup>1)</sup></b>	<i>ERM 2484:</i> ≤ 42000 rpm <i>ERM 2485:</i> ≤ 33000 rpm	≤ 36000 rpm ≤ 27000 rpm	≤ 22000 rpm –	≤ 20000 rpm –	≤ 47000 rpm –	≤ 35000 rpm –	≤ 29000 rpm –	≤ 16000 rpm –
<b>Operating temperature</b>	-10 °C to 100 °C							

<sup>1)</sup> Mech. permissible speed

<sup>2)</sup> Through integrated counting function after traverse of two reference marks

<sup>3)</sup> Only with outside diameters D2 64.37 mm and 75.44 mm

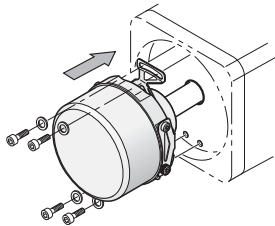
<sup>4)</sup> Additional drum diameters upon request

# ECN, EQN, ERN rotary encoders

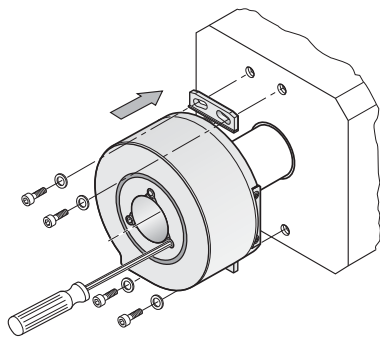
With integral bearing and mounted stator coupling  
Degree of protection IP64

HEIDENHAIN **ECN, EQN** and **ERN** rotary encoders with integral bearings and stator-mounted couplings operate by photoelectric scanning. They are characterized by their simple mounting and short overall length. Possible applications range from simple measuring tasks to position and speed control on servo drives. The hollow shaft of these encoders is slid directly onto and fastened to the shaft to be measured. During angular acceleration of the shaft, the stator coupling must absorb only that torque caused by friction in the bearing. Rotary encoders with stator coupling therefore provide excellent dynamic performance and a high natural frequency.

Some rotary encoders are suitable in a special version for potentially explosive atmospheres in accordance with Directive 94/9/EG (**ATEX**). They comply with Equipment Group II, meet the requirements of Category 2 and can be used for Zones 1 and 21 as well as 2 and 22.



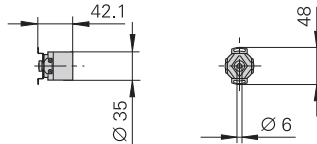
**ECN/EQN/ERN 1000**  
**ECN/EQN/ERN 400**



**ECN/ERN 100**

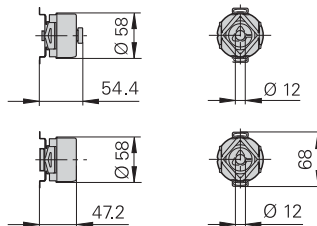
## ECN, EQN, ERN 1000 series

- **Miniaturized version**
- Blind hollow shaft with 6 mm inside diameter
- Housing outside diameter: 35 mm
- Natural frequency of the encoder stator coupling:  $\geq 1500$  Hz
- Mechanically permissible speed:  $\leq 12\,000$  rpm



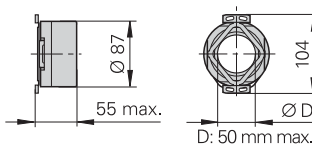
## ECN, EQN, ERN 400 series

- **Compact design**
- Blind hollow shaft or hollow through shaft with 8 mm or 12 mm inside diameter
- Housing outside diameter: 58 mm
- Degree of protection: IP67 at housing (IP66 with hollow through shaft)  
IP64 at shaft inlet (IP66 upon request)
- Natural frequency of the encoder stator coupling:  $\geq 1400$  Hz (cable version)
- Mechanically permissible speed:  $\leq 12\,000$  rpm



## ECN/ERN 100 series

- **For large shaft diameters**
- Hollow through shaft with inside diameters  $D$ : 20, 25, 38, 50 mm
- Housing outside diameter: 87 mm
- Natural frequency of the encoder stator coupling:  $\geq 1000$  Hz
- Mechanically permissible speed:  
 $D \leq 30$  mm:  $\leq 6000$  rpm  
 $D > 30$  mm:  $\leq 4000$  rpm



### Interface

Position values/revolution

Revolutions

Line count

### Voltage supply

### Interface

Position values/revolution

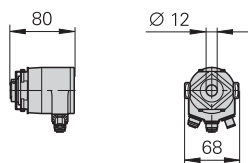
Revolutions

Line count

### Voltage supply

<b>Absolute ECN 1013</b>	<b>EQN 1025</b>	<b>ECN 1023</b>	<b>EQN 1035</b>	<b>Incremental ERN 1020</b>	<b>ERN 1030</b>	<b>ERN 1070</b>	<b>ERN 1080</b>
EnDat 2.2 <sup>1)</sup> with $\sim 1 V_{PP}$ ; SSI		EnDat 2.2 <sup>1)</sup>		$\square$ TTL	$\square$ HTL	$\square$ TTL <sup>2)</sup>	$\sim 1 V_{PP}$
8192 (13 bits)		8388608 (23 bits)		–			
–	4096 (12 bits)	–	4096 (12 bits)	–			
512		–		100 to 3600		1000/2500/3600	100 to 3600
3.6 V to 14 V; 4.75 V to 30 V				5 V	10 V to 30 V	5 V	

<b>Absolute ECN 413<sup>3)</sup></b>		<b>EQN 425<sup>3)</sup></b>		<b>ECN 425<sup>4)</sup> ECN 425 F ECN 425 M ECN 424 S<sup>4)</sup></b>	<b>EQN 437<sup>4)</sup> EQN 437 F EQN 437 M EQN 436 S<sup>4)</sup></b>	<b>Incremental ERN 420<sup>3)</sup> ERN 460</b>	<b>ERN 430<sup>3)</sup></b>	<b>ERN 480<sup>3)</sup></b>
EnDat 2.2 <sup>1)</sup> with $\sim 1 V_{PP}$ ; SSI	PROFIBUS- DP; PROFINET	EnDat 2.2 <sup>1)</sup> with $\sim 1 V_{PP}$ ; SSI	PROFIBUS- DP; PROFINET	EnDat 2.2 <sup>1)</sup> ; Fanuc $\alpha$ i; Mitsubishi; Siemens DRIVE-CLiQ		$\square$ TTL; $\square$ TTL	$\square$ HTL	$\sim 1 V_{PP}$
8192 (13 bits)		8192 (13 bits)		<b>ECN 425:</b> 33554432 (25 bits) <b>ECN 424:</b> 16777216 (24 bits)		–		
–	–	4096 (12 bits)		–	4096 (12 bits)	–		
512 or 2048	–	512 or 2048	–	–		250 to 5000		1000 to 5000
3.6 V to 14 V; 4.75 V to 30 V	9 V to 36 V; 10 V to 30 V	3.6 V to 14 V; 4.75 V to 30 V	9 V to 36 V; 10 V to 30 V	3.6 V to 14 V; 10 V to 28.8 V		5 V; 10 V to 30 V	10 V to 30 V	5 V



PROFIBUS-DP/PROFINET



	<b>Absolute ECN 113</b>	<b>ECN 125</b>	<b>Incremental ERN 120</b>	<b>ERN 130</b>	<b>ERN 180</b>
<b>Interface</b>	EnDat 2.2 <sup>1)</sup> with $\sim 1 V_{PP}$	EnDat 2.2 <sup>1)</sup>	$\square$ TTL	$\square$ HTL	$\sim 1 V_{PP}$
Position values/revolution	8192 (13 bits)	33554432 (25 bits)	–		
Line count	2048	–	1000 to 5000		
<b>Voltage supply</b>	3.6 to 14 V	3.6 to 14 V	5 V	10 V to 30 V	5 V

<sup>1)</sup> Includes EnDat 2.1 command set; PROFIBUS-DP via gateway

<sup>2)</sup> Integrated 5/10-fold interpolation

<sup>3)</sup> ATEX version available (ECN 413/EQN 425 with 5 V power supply and EnDat 2.1)

<sup>4)</sup> **Functional safety** upon request

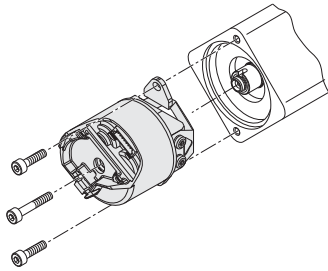
DRIVE-CLiQ is a registered trademark of SIEMENS AG.



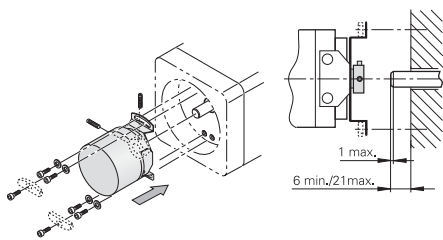
# ECN, EQN, ERN rotary encoders

With integral bearing and mounted stator coupling  
IP40 degree of protection

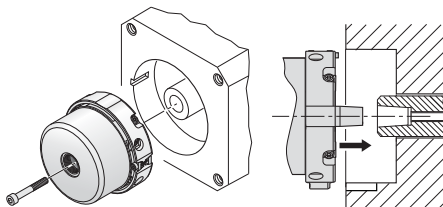
The **ECN, EQN** and **ERN** rotary encoders from HEIDENHAIN with IP40 degree of protection are specially designed for integration in motors. Bearings and mounted stator coupling are integrated. Absolute rotary encoders and versions with commutation tracks are available for synchronous motors. The taper shaft or the blind hollow shaft is fastened directly to the shaft to be measured. This ensures an extremely stiff coupling that permits exceptionally high dynamic performance of the drive. The stator coupling is designed to be fastened on a plane surface or a location hole and permits fast, simple mounting.



ECN/EQN 1100



ERN 1123



ERN/ECN/EQN 1300

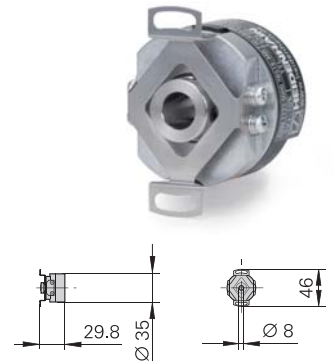
## ECN/EQN 1100 series

- **Miniaturized version**
- Blind hollow shaft  $\varnothing$  6 mm with positive fit element
- Housing outside diameter 35 mm
- Natural frequency of the encoder stator coupling:  $\geq$  1000 Hz
- Mech. permissible speed 12000 rpm
- Fault exclusion of the mechanical coupling for functional safety



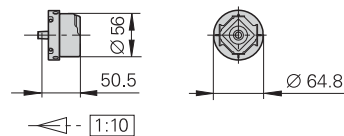
## ERN 1123

- Blind hollow shaft  $\varnothing$  8 mm
- Housing outside diameter 35 mm
- Stator coupling with bolt-hole circle  $\varnothing$  40 mm
- Natural frequency of the stator coupling:  $\geq$  1000 Hz
- Mech. permissible speed 6000 rpm



## ECN, EQN, ERN 1300 series

- **Compact dimensions**
- 1:10 taper shaft with 9.25 mm functional diameter for extremely stiff connection
- Housing outside diameter 56 mm. The stator coupling is suited for location holes with 65 mm inside diameter
- Natural frequency of the encoder stator coupling:  $\geq$  1800 Hz
- Mech. permissible speed  
**ERN/ECN:** 15000 rpm  
**EQN:** 12000 rpm
- IP40 protection when mounted
- Fault exclusion of the mechanical coupling for functional safety



<b>Interface</b>
Position values/revolution
Revolutions
Line count
<b>Commutation signals</b>
<b>Voltage supply</b>
<b>Operating temperature</b>

	<b>Absolute</b>				<b>Incremental</b>
	<b>ECN 1113</b>	<b>EQN 1125</b>	<b>ECN 1123<sup>2)</sup></b>	<b>EQN 1135<sup>2)</sup></b>	<b>ERN 1123</b>
<b>Interface</b>	EnDat 2.2 <sup>1)</sup> with $\sim$ 1 V <sub>PP</sub>		EnDat 2.2 <sup>1)</sup>		$\square$ TTL
Position values/revolution	8192 (13 bits)		8388608 (23 bits)		–
Revolutions	–	4096 (12 bits)	–	4096 (12 bits)	–
Line count	512		–		500 to 8192
<b>Commutation signals</b>	–				Block commutation <sup>3)</sup>
<b>Voltage supply</b>	3.6 to 14 V				5 V
<b>Operating temperature</b>	$\leq$ 115 °C				$\leq$ 90 °C

<sup>1)</sup> Includes EnDat 2.1 command set; PROFIBUS-DP via gateway

<sup>2)</sup> **Functional safety** upon request

<sup>3)</sup> Three block commutation tracks with 90°, 120° or 180° mechanical phase shift

<b>Absolute</b>						<b>Incremental</b>				
<b>ECN 1313</b>	<b>EQN 1325</b>	<b>ECN 1325<sup>4)</sup></b>	<b>EQN 1337<sup>4)</sup></b>	<b>ECN 1324S</b>	<b>EQN 1336S</b>	<b>ERN 1321</b>	<b>ERN 1326</b>	<b>ERN 1381</b>	<b>ERN 1387</b>	
EnDat 2.2 <sup>1)</sup> with $\sim$ 1 V <sub>PP</sub>		EnDat 2.2 <sup>1)</sup>		Siemens DRIVE-CLiQ		$\square$ TTL		$\sim$ 1 V <sub>PP</sub>		
8192 (13 bits)		33554432 (25 bits)		16777216 (24 bits)		–				
–	4096 (12 bits)	–	4096 (12 bits)	–	4096 (12 bits)	–				
512 or 2048		–				1024	2048	4096	512 2048 4096	2048
–						–	Block commutation <sup>2)</sup>	–	Z1 track <sup>3)</sup>	
3.6 to 14 V				10 V to 28.8 V		5 V				
$\leq$ 115 °C						$\leq$ 120 °C; <b>4096 lines</b> : $\leq$ 100 °C				

<sup>1)</sup> Includes EnDat 2.1 command set; PROFIBUS-DP via gateway

<sup>2)</sup> Three block commutation tracks with 90° or 120° mechanical phase shift

<sup>3)</sup> One sine and one cosine signal with one period per revolution of the encoder shaft

<sup>4)</sup> **Functional safety** upon request

DRIVE-CLiQ is a registered trademark of SIEMENS AG.

# ROC, ROQ, ROD, RIC, RIQ rotary encoders

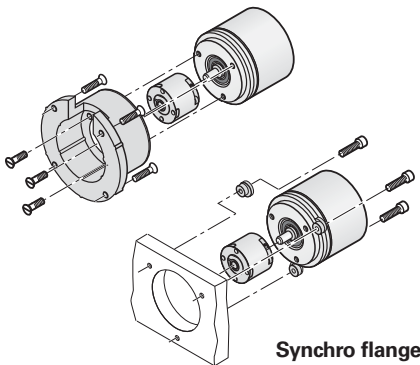
With integral bearing, for separate shaft coupling

## HR handwheel

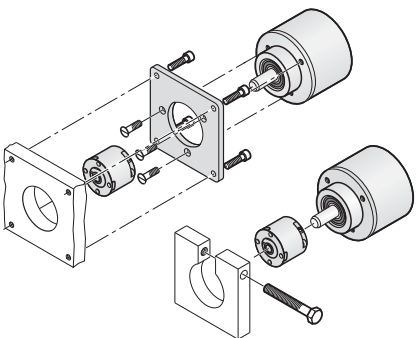
The photoelectric encoders **ROC, ROQ** and **ROD**, as well as the inductive **RIC** and **RIQ** from HEIDENHAIN have integrated bearings and are sealed. The degree of protection is IP64 to IP66, depending on the version. They are robust and compact.

These encoders are coupled by the rotor to the measured shaft through a separate coupling that compensates axial motion and misalignment between the encoder shaft and measured shaft.

Some rotary encoders are suitable in a special version for potentially explosive atmospheres in accordance with Directive 94/9/EG (**ATEX**). They comply with Equipment Group II, meet the requirements of Category 2 and can be used for Zones 1 and 21 as well as 2 and 22.



Synchro flange



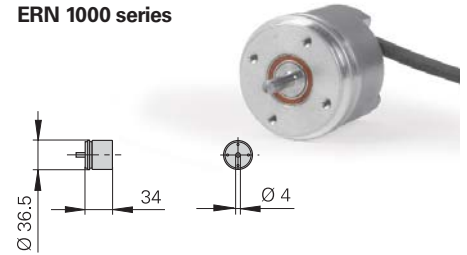
Clamping flange

The **HR** electronic handwheel features an integral bearing and mechanical detent. It was conceived for use in portable or stationary housings, e.g. for positioning units or automation applications.

### ROC, ROQ, ROD 1000 series

- **Miniaturized dimensions** for installation in small devices or in limited installation space
- Mounting by synchro flange
- Shaft diameter 4 mm

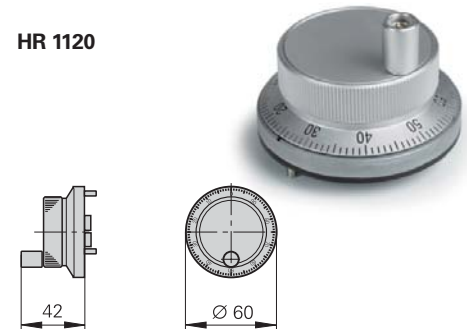
### ERN 1000 series



### HR handwheel

- Compact dimensions
- Sturdy design
- Mechanical detent

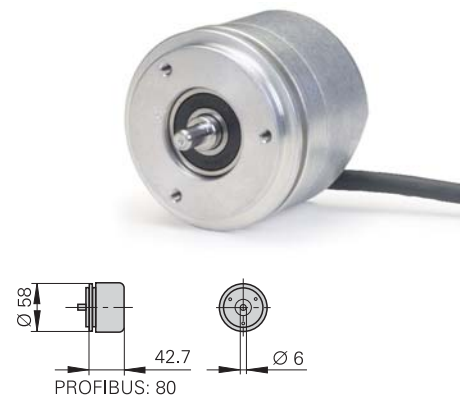
### HR 1120



### ROC/ROQ/ROD 400 series

- **Industrial standard** for dimensions and output signals
- Degree of protection IP67 at housing; IP64 at shaft inlet (IP66 upon request)
- Mounting via synchro flange or clamping flange
- Shaft diameters  
6 mm with synchro flange  
10 mm with clamping flange
- Preferred types with fast delivery (see *Rotary Encoders* brochure or ask HEIDENHAIN)
- Fault exclusion of the mechanical coupling for functional safety

### Series 400 with synchro flange



### RIC/RIQ 400 series

- Inductive scanning principle
- For reduced accuracy requirements up to  $\pm 480''$
- Mechanical design same as ROC/ROQ 400

	<b>Absolute</b>				
<b>Synchro flange</b>	<b>RIC 418</b>	<b>RIQ 430</b>	<b>ROC 413</b>	<b>ROQ 425</b>	<b>ROC 413</b>
<b>Clamping flange</b>					
<b>Interface</b>	EnDat 2.1 with $\sim 1 V_{PP}$		EnDat 2.2 <sup>4)</sup> with $\sim 1 V_{PP}$ ; SSI		PROFIBUS-DP; PROFINET
Position values/revolution	262 144 (18 bits)		8192 (13 bits)		
Revolutions	–	4096 (12 bits)	–	4096 (12 bits)	–
Line count/signal periods	16		512		
<b>Voltage supply</b>	5 V		3.6 V to 14 V; 4.75 V to 30 V		9 V to 36 V; 10 V to 30 V

<sup>1)</sup> ATEX version available (*ROC/ROQ* with 5 V voltage supply and EnDat 2.1)

<sup>2)</sup> **Functional safety** upon request

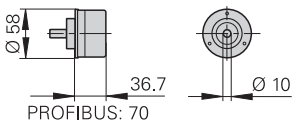
	<b>Absolute</b>				<b>Incremental</b>				
	ROC 1013	ROQ 1025	ROC 1023	ROQ 1035	ROD 1020	ROD 1030	ROD 1070	ROD 1080	HR 1120
<b>Interface</b>	EnDat 2.2 <sup>1)</sup> with $\sim 1$ V <sub>PP</sub> ; SSI		EnDat 2.2 <sup>1)</sup>					$\sim 1$ V <sub>PP</sub>	
Position values/revolution	8192 (13 bits)		8388608 (23 bits)		-				
Revolutions	-	4096 (12 bits)	-	4096 (12 bits)	-				
Line count/signal periods	512		-		100 to 3600		1000/2500/3600	100 to 3600	100
<b>Voltage supply</b>	3.6 V to 14 V; 4.75 V to 30 V		3.6 to 14 V		5 V	10 V to 30 V	5 V		

<sup>1)</sup> Includes EnDat 2.1 command set; PROFIBUS-DP via gateway

<sup>2)</sup> Integrated 5/10-fold interpolation

**Series 400  
with clamping flange**

**PROFIBUS-DP/PROFINET**



ROQ 425	ROC 424S	ROQ 436S	ROC 425 <sup>2)</sup> ROC 425F ROC 425M	ROQ 437 <sup>2)</sup> ROQ 437F ROQ 437M	<b>Incremental</b>			
					ROD 426 <sup>1)</sup>	ROD 466 <sup>1)</sup>	ROD 436 <sup>1)</sup>	ROD 486 <sup>1)</sup>
					ROD 420 <sup>1)</sup>	-	ROD 430 <sup>1)</sup>	ROD 480 <sup>1)</sup>
Siemens DRIVE-CLiQ			EnDat 2.2 <sup>4)</sup> ; Fanuc $\alpha$ ; Mitsubishi					$\sim 1$ V <sub>PP</sub>
16777216 (24 bits)			33554432 (25 bits)		-			
4096 (12 bits)	-	4096 (12 bits)	-	4096 (12 bits)	-			
					50 to 5000 ROD 426/466: Up to 10000 <sup>3)</sup>			1000 to 5000
10 V to 28.8 V			3.6 to 14 V		5 V	10 V to 30 V		5 V

<sup>3)</sup> Signal periods over 5000 are generated through signal doubling in the encoder

<sup>4)</sup> Includes EnDat 2.1 command set; PROFIBUS-DP via gateway

# ECI, EQI, EBI, ERO rotary encoders

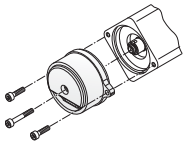
## Without integral bearing

The inductive rotary encoders **ECI/EQI 1100** and **ECI/EQI 1300** are mechanically compatible with the corresponding ExN photoelectric encoders: the shaft is fastened with a central screw. The stator of the encoder fastened in a location hole by several screws.

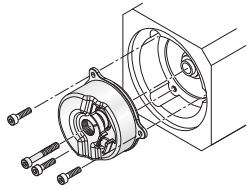
The **ECI/EBI 100** inductive rotary encoders have a particularly small outside diameter with a large shaft opening. It is slid onto the shaft and fastened from behind with axial screws.

The photoelectric **ERO** modular rotary encoders from HEIDENHAIN consist of a graduated disk with hub and a scanning unit. They are particularly well suited for **limited installation space** or for applications for which there must be **no friction**.

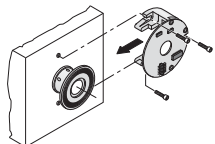
The correct installation of the rotary encoders without integral bearing can be inspected with the HEIDENHAIN PWM 20 measuring and testing device.



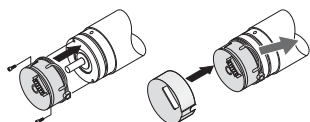
ECI/EQI 1100



ECI/EQI 1300



ERO 1200



ERO 1400

### ECI/EQI/EBI 1100 series

- **Miniature size**
- Simple mounting without adjustment
- Blind hollow shaft  $\varnothing$  6 mm
- **EBI 1135**: Multiturn function via battery-buffered revolution counter
- Version available featuring mounting-compatibility with ECN/EQN 1100
- Fault exclusion of the mechanical coupling for functional safety



### ECI/EQI 1300 series

- **Simple mounting** without adjustment
- Blind hollow shaft
- Version featuring mounting-compatibility with ECN/EQN 1300 with tapered shaft or blind hollow shaft available upon request
- Fault exclusion of the mechanical coupling for functional safety



### ECI/EBI 100 series

- Especially **flat design**
- Hollow through shaft  $\varnothing$  50 mm
- **EBI 135**: Multiturn function via battery-buffered revolution counter



### ERO 1200 series

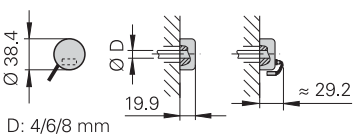
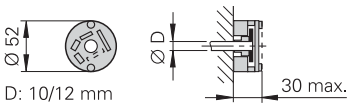
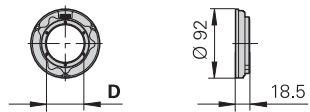
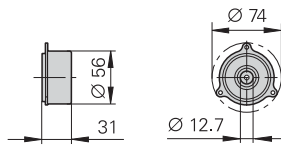
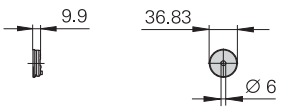
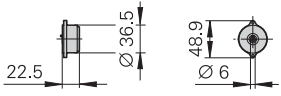
- **Compact design**
- For shaft diameters up to 12 mm



### ERO 1400 series

- **Miniaturized modular rotary encoder** for measured shafts up to  $\varnothing$  8 mm
- Special integral mounting aid
- With cover cap





	<b>Absolute</b> ECI 1119 ECI 1319 <sup>1)</sup>	EQI 1131 EQI 1331 <sup>1)</sup>	EBI 1135
<b>Interface</b>	EnDat 2.2		EnDat 2.2
Position values/revolution	524 288 (19 bits)		262 144 (18 bits)
Revolutions	–	4096 (12 bits)	65 536 (16 bits) <sup>2)</sup>
<b>Mech. permissible speed</b>	≤ 15 000 rpm	≤ 12 000 rpm	
<b>Shaft</b>	Blind hollow shaft		

<sup>1)</sup> **Functional safety** upon request

<sup>2)</sup> Multiturn function via battery-buffered revolution counter

	<b>Absolute</b> ECI 119	EBI 135
<b>Interface</b>	EnDat 2.1 with $\sim 1 V_{PP}$	EnDat 2.2
Position values/revolution	524 288 (19 bits)	
Revolutions	–	65 536 (16 bits) <sup>1)</sup>
Line count	32	–
<b>Mech. permissible speed</b>	≤ 6 000 rpm	
<b>Shaft</b>	Hollow through shaft Ø 30, 38, 50 mm	

<sup>1)</sup> Multiturn function via battery-buffered revolution counter

	<b>Incremental</b> ERO 1225	ERO 1285
<b>Interface</b>	$\square$ TTL	$\sim 1 V_{PP}$
Line count	1024 2048	
<b>Mech. permissible speed</b>	≤ 25 000 rpm	
<b>Shaft diameter D</b>	Ø 10, 12 mm	

	<b>Incremental</b> ERO 1420	ERO 1470	ERO 1480
<b>Interface</b>	$\square$ TTL	$\square$ TTL <sup>1)</sup>	$\sim 1 V_{PP}$
Line count	512 1000 1024	1000 1500	512 1000 1024
<b>Mech. permissible speed</b>	≤ 30 000 rpm		
<b>Shaft diameter D</b>	Ø 4, 6, 8 mm		

<sup>1)</sup> Integrated 5/10/20/25-fold interpolation

# Machine tool control

## Controls for milling and milling-turning machines and machining centers

The TNC controls from HEIDENHAIN cover the whole range of applications: From the simple, compact TNC 128 three-axis straight cut control to the TNC 640 (up to 18 axes plus spindle)—there's a TNC control for nearly every application. They handle simple milling tasks just as reliably as **high speed cutting**—with especially jerk-free path control—or **5-axis machining** with swivel head and rotary table.

HEIDENHAIN TNC controls are versatile: They feature both **shop-floor programming**, and **offline programming**, and are therefore ideal for **automated production**. The TNC 640 is a control for milling machines that are also capable of turning operations.

TNC part programs have long lives because they are **upwardly compatible**. Programs from older TNCs can also run on the new models. When moving up to a more advanced TNC, the user merely builds on what he already knows.

## And this is what the future looks like:

The HEIDENHAIN contouring controls are now undergoing a generational change. As the future high-end control, the TNC 640 stands ready as a powerful and modern control platform. It already features almost the complete range of functions provided by the proven iTNC 530. It also offers the following:

- Functions for milling-turning operations with powerful turning cycles
- Improved motion control for even more precise surfaces and high contour accuracy
- High-resolution graphics with 3-D simulation view in sharp detail
- Well-thought-out, structured color user interface

**The controls from HEIDENHAIN can be used for almost every task. They offer the right programming capability for any job.**

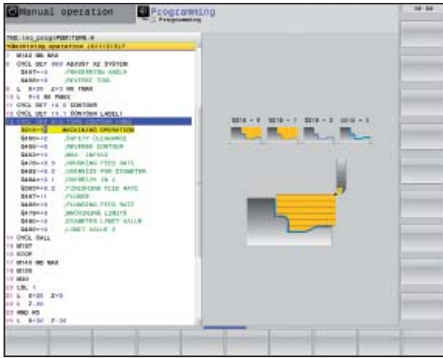
## Programming at the machine

The workshop-oriented design enables the machinist to program directly at the machine.

Thanks to its **HEIDENHAIN conversational programming**, the user need not learn G codes or special programming languages. The control “speaks” with him with easily understandable questions and prompts. Ease of use is also promoted by clear, **unambiguous key symbols** and names. Each key has only one function. With the TNC 640, even complex milling and turning operations can be programmed consistently in plain language.

The **easy-to-read screen** displays plain-language information, dialog guidance, programming steps, graphics, and a soft-key row. All texts are available in **numerous languages**.

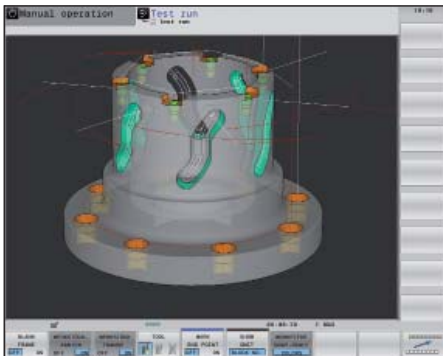




Plain language



Key symbols



Detailed, high-resolution graphics

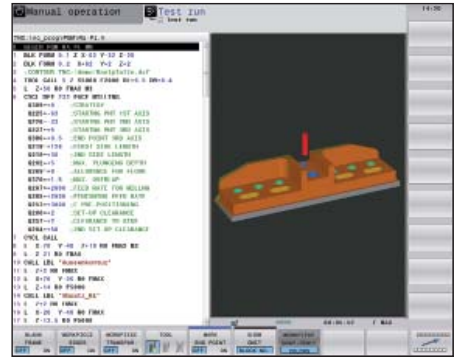
Frequently recurring machining sequences are saved as **fixed cycles**. **Graphic illustrations** simplify programming and provide valuable aid for verifying the program during test runs.

And if you are used to **G-code programming**, then HEIDENHAIN controls are still the right controls for you.

**Positioning with Manual Data Input**  
You can start working with the HEIDENHAIN controls even before writing a complete part program. Simply machine a part step by step—switching as you want between manual operation and automatic positioning.

**Creating programs offline**  
The HEIDENHAIN controls can be programmed remotely just as well—for example on a CAD/CAM system or at a HEIDENHAIN programming station. Their **Ethernet interface** guarantees very short transfer times, even of long programs.

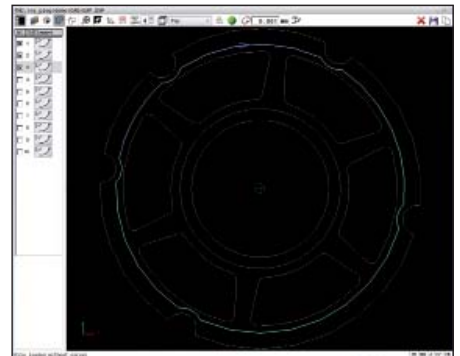
You can open **DXF files** created in a CAD system directly on the TNC 640 and TNC 620 to extract contours and machining positions. Not only does this save time otherwise spent on programming and testing, but you can also be sure that the transferred data are exactly according to the designer's specifications.



Test run



Offline programming



Processing DXF data

HEIDENHAIN controls		Series	Page
<b>Contouring control for milling and milling-turning machines and machining centers</b>	Up to 18 axes and 2 spindles	<b>TNC 640</b>	<b>40</b>
<b>Contouring control for simple milling machines</b>	Up to four axes plus spindle	<b>TNC 320</b>	<b>42</b>
	Up to five axes plus spindle	<b>TNC 620</b>	<b>42</b>
<b>Straight-cut control for simple milling machines</b>	Up to four axes plus spindle	<b>TNC 128</b>	<b>44</b>
<b>Accessories</b>	Electronic handwheels	<b>HR</b>	<b>47</b>
	Programming stations	<b>TNC 620</b>	<b>47</b>
		<b>TNC 640</b>	
<b>TNC 320</b>			



# TNC 640 contouring control

For milling machines, milling-turning machines and machining centers

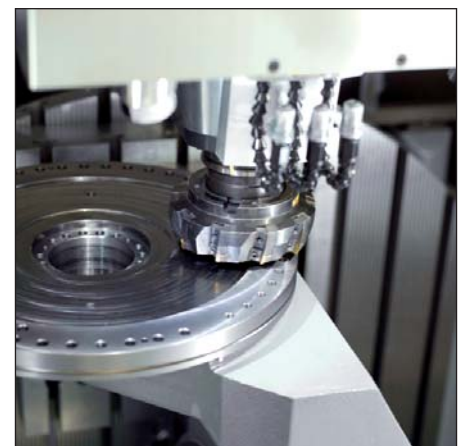
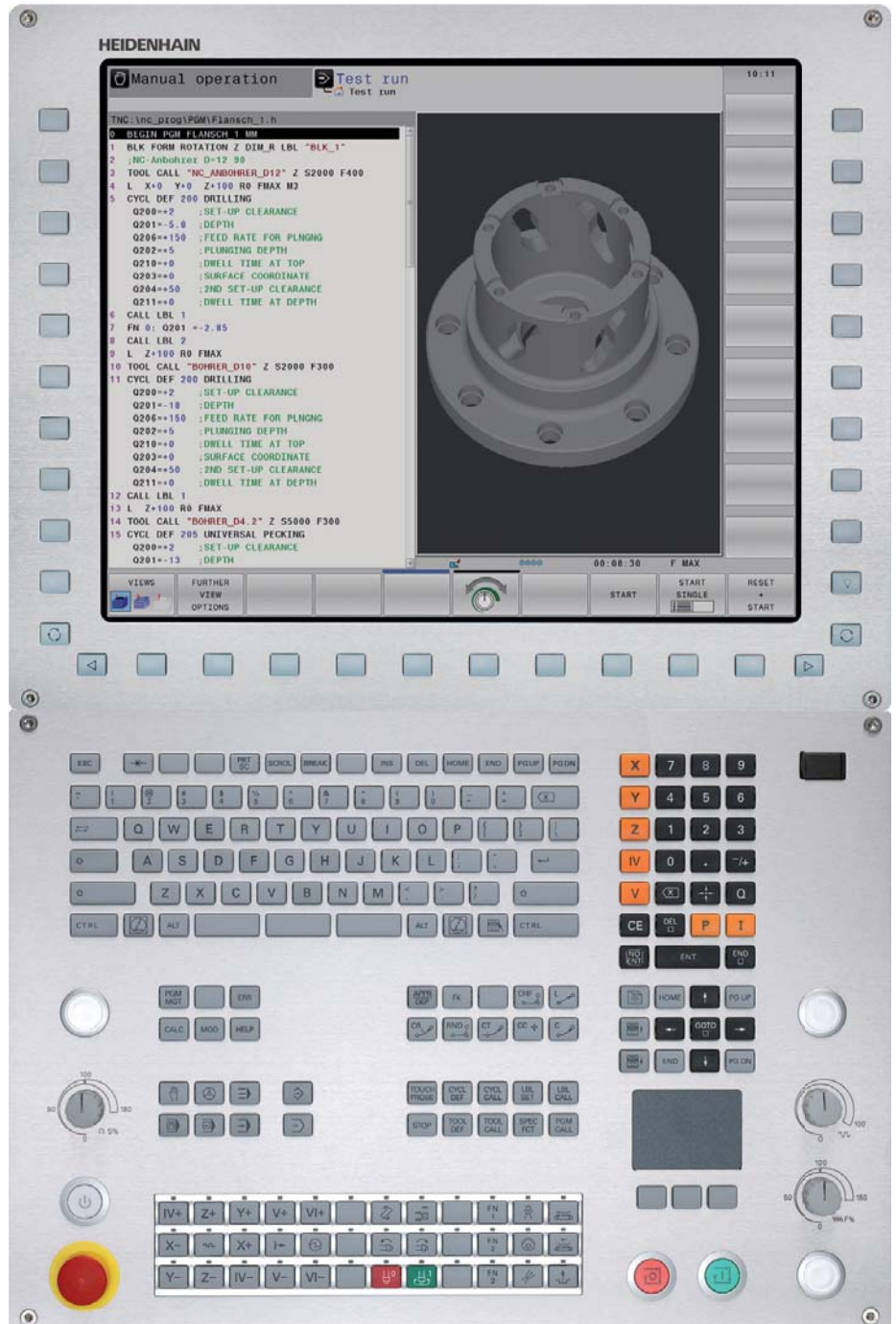
Besides milling, the **TNC 640** from HEIDENHAIN is also capable of combined milling and turning operations. It is particularly well suited for milling-turning, HSC and 5-axis machining on machines with up to 18 axes. The workshop oriented and versatile control features numerous functions. It is especially attractive for the following areas of application:

- Universal milling machines
- Combined milling-turning machines
- High speed milling
- Five-axis machining with swivel head and rotary table
- Five-axis machining on very large machines
- Boring mills
- Machining centers and automated machining

The TNC 640 features **optimized motion control, short block processing times** and special control strategies. Together with its **uniform digital design** and its integrated digital drive control including inverters, it enables you to reach very high machining speeds and the best possible contour accuracy—particularly when machining 3-D contours.

You can program **turning contours** with the TNC 640 in the familiar HEIDENHAIN plain language. Beyond this, you have typical contour elements for turning (recesses, undercuts, thread undercuts) as well as cycles for complex turning operations.

The **optimized user interface** of the TNC 640 gives you a fast overview: various color coding, standardized table editors and smartSelect—the dialog-guided fast selection of functions—aid you at your work.



	<b>TNC 640</b>
<b>Axes</b>	Up to 18 axes and 2 spindles
<b>Interpolation</b>	<ul style="list-style-type: none"> <li>• Linear in max. 5 axes (with Tool Center Point Management)</li> <li>• Circular in max. 3 axes with tilted working plane</li> <li>• Spline interpolation in max. 5 axes</li> <li>• Helical</li> <li>• Cylinder surface<sup>1)</sup></li> <li>• Rigid tapping<sup>1)</sup></li> </ul>
<b>Program entry</b>	HEIDENHAIN conversational, DIN/ISO
<b>Programming support</b>	TNCguide presents user information directly on the control
<b>DXF converter</b> option	Download contours and machining positions from DXF files
<b>Program memory</b>	Hard disk with at least 21 GB
<b>Position entry</b>	Nominal positions in Cartesian or polar coordinates, dimensions absolute or incremental, in mm or inches; actual position capture
<b>Input resolution and display step</b>	To 0.1 µm or 0.0001°; optionally to 0.01 µm or 0.00001°
<b>Block processing time</b>	0.5 ms (3-D straight line without radius compensation at 100 % PLC utilization)
<b>Turning functions</b> option	<ul style="list-style-type: none"> <li>• Turning tool data management</li> <li>• Tool-tip radius compensation</li> <li>• Constant surface speed</li> <li>• Toggling between milling and turning operations</li> </ul>
<b>High speed cutting</b>	Motion control with minimum jerk
<b>FK free contour programming</b>	HEIDENHAIN conversational with graphical support
<b>Coordinate transformation</b>	<ul style="list-style-type: none"> <li>• Datum shift, rotation, mirror image, scaling factor (axis-specific)</li> <li>• Tilting the working plane, PLANE function (option)</li> </ul>
<b>Fixed cycles</b>	For drilling, milling, turning (option), interpolation turning (option), hobbing (option), and cylinder surface machining (option); data input with graphical support
<b>Touch probe cycles</b>	For tool measurement, workpiece alignment, workpiece measurement and workpiece presetting
<b>Graphics</b>	For programming and program verification
<b>Parallel operation</b>	Program run and programming with graphics
<b>Data interface</b>	Ethernet 1000BASE-T; USB 3.0; USB 2.0; RS-232-C/V.24 (max. 115200 baud)
<b>Remote control and diagnosis</b>	TeleService
<b>LCD screen</b>	15-inch or 19-inch color flat-panel display (TFT)
<b>Axis feedback control</b>	<ul style="list-style-type: none"> <li>• Feedforward control or operation with following error</li> <li>• Integrated <b>digital drive control</b> with integrated inverter</li> </ul>
<b>Adaptive feed rate control</b> option	AFC adjusts the contouring feed rate to the spindle power <sup>1)</sup>
<b>DCM collision monitoring</b> option	Dynamic monitoring of the working space for possible collisions with machine components <sup>1)</sup>
<b>Accessories</b>	<ul style="list-style-type: none"> <li>• Electronic handwheel</li> <li>• TS workpiece touch probe <b>and</b> TT or TL tool touch probe</li> </ul>

<sup>1)</sup> This feature must be implemented by the machine tool builder  
For further functions and differences in function, see product documentation

# TNC 320, TNC 620 contouring controls

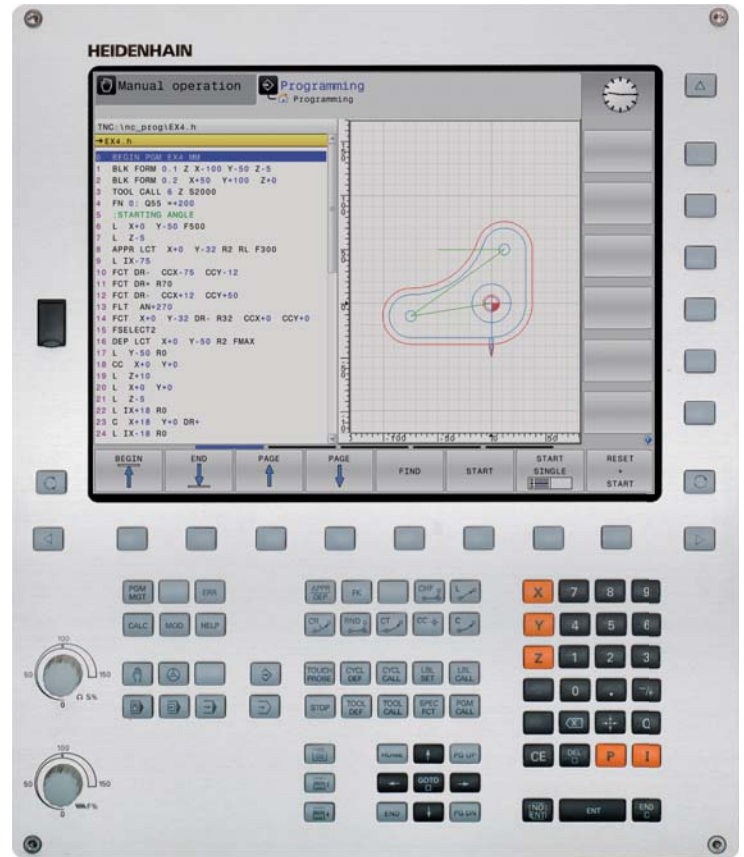
## For milling machines

The HEIDENHAIN **TNC 320** and **TNC 620** controls are compact but versatile contouring controls. Thanks to their flexible operation—workshop-oriented programmability with HEIDENHAIN conversational programming or offline programming—and their scope of features, they are especially suited for use on universal milling, drilling and boring machines for the following:

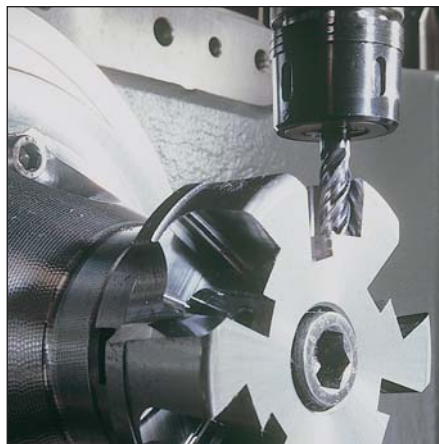
- Series and single-part production
- Tool making
- Machine building
- Research and development
- Prototypes and pilot plants
- Repair departments
- Training and education facilities

Because of its analog outputs that also provide nominal speed values, the **TNC 320** is particularly well suited for retrofitting on machine tools.

Thanks to its **digital design**, the **TNC 620** has control over the machine's entire drive system. Not only does the field-proven digital drive technology from HEIDENHAIN make high contour fidelity and rapid machining at high speeds possible, but also all control components of the TNC 620 are connected via digital interfaces.



TNC 620



	TNC 620	TNC 320
<b>Axes</b>	3 axes plus spindle Optional 4th and 5th axes	3 axes plus spindle Optional 4th and 5th axes (with noncontrolled spindle)
<b>Interpolation</b>	<ul style="list-style-type: none"> <li>• Linear: in 4 axes (optionally 5)</li> <li>• Circular: in 2 (optionally 3) axes</li> <li>• Helical, superimposition of circular and straight paths</li> <li>• Cylinder surface (option)</li> </ul>	<ul style="list-style-type: none"> <li>• Linear in 4 axes</li> <li>• Circular in 2 axes</li> <li>• Helical, superimposition of circular and straight paths</li> <li>• Cylinder surface (option)</li> </ul>
<b>Program entry</b>	<ul style="list-style-type: none"> <li>• HEIDENHAIN conversational</li> <li>• DIN/ISO (program input via soft keys or via external USB keyboard)</li> <li>• FK free contour programming (option on the TNC 620)</li> </ul>	
<b>Programming support</b>	TNCguide presents user information directly on the TNC	
<b>DXF converter</b> option	Download contours and machining positions from DXF files	–
<b>Program memory</b>	1.8 GB	
<b>Position entry</b>	<ul style="list-style-type: none"> <li>• Positions in Cartesian or polar coordinates</li> <li>• Incremental or absolute dimensions</li> <li>• Display and entry in mm or inches</li> <li>• Actual position capture</li> </ul>	
<b>Input resolution and display step</b>	Down to 0.1 µm or 0.0001°; optionally to 0.01 µm or 0.00001°	Down to 0.1 µm or 0.0001°
<b>Block processing time</b>	1.5 ms	6 ms
<b>Coordinate transformation</b>	<ul style="list-style-type: none"> <li>• Datum shift, rotation, mirror image, scaling factor (axis-specific)</li> <li>• Tilting the working plane, PLANE function (option)</li> </ul>	
<b>Fixed cycles</b> (some optional with the TNC 620)	<ul style="list-style-type: none"> <li>• Drilling, tapping, thread cutting, reaming and boring</li> <li>• Cycles for hole patterns, facing of flat surfaces</li> <li>• Pocket clearance and finishing, slots and studs</li> </ul>	
<b>Touch probe cycles</b>	For tool measurement, workpiece alignment, workpiece measurement and datum setting (option with TNC 620)	
<b>Graphics</b>	For programming and program verification (option with TNC 620); graphic support with cycle programming	
<b>Parallel operation</b>	Programming during program run, program-run graphics (option with TNC 620)	
<b>Data interface</b>	<ul style="list-style-type: none"> <li>• Ethernet 1000BASE-T</li> <li>• USB 3.0; USB 2.0</li> <li>• RS-232-C/V.24 and RS-422/V.11 (max. 115200 baud)</li> </ul>	
<b>LCD screen</b>	15-inch color flat-panel display (TFT)	
<b>Axis feedback control</b>	Feedforward control or operation with following error	
	Integrated <b>digital drive control</b> for synchronous and asynchronous motors	–
<b>Interfacing to the machine</b>	Via integrated programmable logic controller (PLC)	
	Inputs/outputs with PL 6000	Inputs/outputs expandable with PL 510
<b>Accessories</b>	<ul style="list-style-type: none"> <li>• HR panel-mounted electronic handwheels</li> <li>• TS workpiece touch probe <b>and</b> TT or TL tool touch probe</li> </ul>	

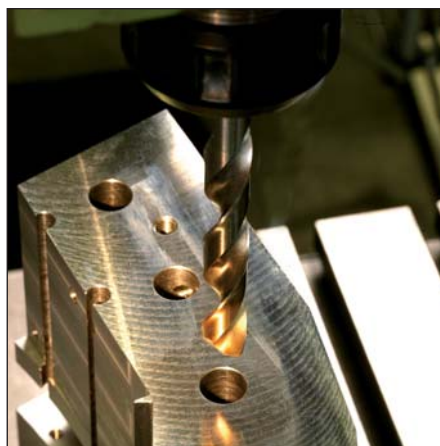
# TNC 128 straight cut control

## For milling machines

The **TNC 128** from HEIDENHAIN is a compact but versatile straight-cut control for three servo axes and servo spindle. A further servo axis is an option. Thanks to its simple operation and scope of features, it is especially well suited for use on universal milling, drilling and boring machines for:

- Series and single-part production
- Machine building
- Prototypes and pilot plants
- Repair departments
- Training and education facilities

Because of its analog output that also provides nominal speed values, the TNC 128 is well suited for retrofitting on machine tools.



	<b>TNC 128</b>
<b>Axes</b>	3 axes plus spindle Optional 4th and 5th axes (with noncontrolled spindle)
<b>Program entry</b>	HEIDENHAIN conversational
<b>Program memory</b>	1.8 GB
<b>Position entry</b>	<ul style="list-style-type: none"> <li>• Positions in Cartesian or polar coordinates</li> <li>• Incremental or absolute dimensions</li> <li>• Display and entry in mm or inches</li> </ul>
<b>Input resolution and display step</b>	Down to 0.1 µm or 0.0001°
<b>Block processing time</b>	6 ms
<b>Coordinate transformation</b>	Datum shift, rotation, mirror image, scaling factor (axis-specific)
<b>Fixed cycles</b>	<ul style="list-style-type: none"> <li>• Drilling, tapping, reaming and boring</li> <li>• Cycles for hole patterns, facing of flat surfaces</li> <li>• Pocket, stud and slot milling</li> </ul>
<b>Touch probe cycles</b>	Touch probe calibration and datum setting
<b>Graphics</b>	For programming and program verification; graphic support with cycle programming
<b>Parallel operation</b>	Program run and programming, program-run graphics
<b>Data interface</b>	<ul style="list-style-type: none"> <li>• Ethernet 1000BASE-T</li> <li>• USB 3.0; USB 2.0</li> <li>• RS-232-C/V.24 (max. 115200 baud)</li> </ul>
<b>LCD screen</b>	12.1-inch color flat-panel display (TFT)
<b>Axis feedback control</b>	Feedforward control or operation with following error
<b>Interfacing to the machine</b>	Via integrated programmable logic controller (PLC); inputs/outputs expandable by PL 510
<b>Accessories</b>	<ul style="list-style-type: none"> <li>• HR panel-mounted electronic handwheels</li> <li>• TS or KT workpiece touch probe <b>and</b> TT tool touch probe</li> </ul>

# Contouring controls

## Digital control design

In the uniformly digital control design from HEIDENHAIN, all components are connected to each other via purely digital interfaces: The control components are connected via **HSCI** (HEIDENHAIN Serial Controller Interface), the real-time protocol from HEIDENHAIN for Fast Ethernet, and the encoders are connected via **EnDat 2.2**, the bidirectional interface from HEIDENHAIN. This achieves a high degree of availability for the entire system. It can be diagnosed and is immune to noise—from the main computer to the encoder. These outstanding properties of the uniformly digital design from HEIDENHAIN guarantee not only very high accuracy and surface quality, but high traverse speeds as well.

### Digital drive control

High surface definition, high contouring accuracy of the finished workpiece, and short machining times—these requirements can be met only with digital control techniques. Here HEIDENHAIN offers NC products with integrated **digital drive control**.

Either compact or modular inverters are available, depending on the type of machine. The **compact inverters** contain the power stage for up to 2 axes, 3 axes, or 4 axes plus spindle with spindle power ratings up to 15 kW. With **modular inverters**, various power modules are available for axes and spindles, and power supply units with 22 kW to 125 kW. The modular inverters are suitable for machines with up to 13 axes and a spindle with maximum power of up to 40 kW.

**Feed motors** of 0.4 Nm to 120 Nm and **spindle motors** of 5.5 kW to 40 kW are available for connection to HEIDENHAIN inverters.

The following HEIDENHAIN controls are available with HSCI and digital drive control:

- TNC 640
- TNC 620
- iTNC 530
- MANUALplus 620
- CNC PILOT 640



**TNC 640**  
With modular inverter and motors

# Accessories

## Electronic handwheels

With the electronic handwheel from HEIDENHAIN, you can use the feed drive to make very precise movements in the axis slides in proportion to the rotation of the handwheel. As an option, the handwheels are available with mechanical detent.

### HR 510, HR 520 and HR 550FS portable handwheels

The axis keys and certain functional keys are integrated in the housing. It allows you to switch axes or set up the machine at any time—and regardless of where you happen to be standing. The **HR 520** also features a display for the position value, the feed rate and spindle speed, the operating mode and other functions, as well as an override potentiometer for feed rate and spindle speed. You can enjoy unlimited freedom of movement with the **HR 550FS** with radio transmission. Its features correspond to those of the HR 520.



HR 550 FS

HR 510

### HR 130 and HR 150 panel-mounted handwheels

Panel-mounted handwheels from HEIDENHAIN can be integrated in the machine operating panel or be installed at another location on the machine. Up to three HR 150 electronic handwheels can be connected through an adapter.



HR 130 for integration in the machine operating panel

## Programming stations

With the TNC 640 and TNC 320/TNC 620 programming stations, you have the capability to program in plain language just as you do at the machine, but away from the noise and distractions of the shop floor.

### Creating programs

Programming, testing and optimizing HEIDENHAIN conversational or ISO programs with the programming station substantially reduces machine idle times. You do not need to change your way of thinking. At the programming station you program on the same keyboard as at the machine.

### Training with the programming station

Because the programming stations are based on the respective control software, they are ideally suited for apprentice and advanced training.

### TNC training in schools

Since they can be programmed in ISO as well as in plain language format, the programming stations can also be used in schools for TNC programming training.





# Tool and workpiece setup and measurement

## Workpiece touch probes

The **TS workpiece touch probes** from HEIDENHAIN help you perform setup, measuring and inspection functions directly on the machine tool.

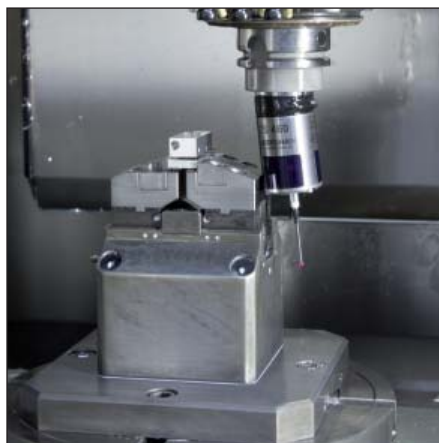
The stylus of a TS touch trigger probe is deflected upon contact with a workpiece surface. At that moment the TS generates a trigger signal that, depending on the model, is transmitted either by cable or over an infrared or radio beam to the control.

The control simultaneously saves the actual position values as measured by the machine axis encoders, and uses this information for further processing. The trigger signal is generated through a wear-free optical sensor that ensures high reliability.

HEIDENHAIN offers probe styli with various ball-tip diameters and stylus lengths. On the **TS 260**, asymmetric probing elements can also be attached through an adapter and exactly aligned with the aid of the screw connection.

### Benefits of HEIDENHAIN touch probes

- High probe repeatability
- High probe velocity
- No wear thanks to contact-free optical switch and high-accuracy pressure sensor.
- High repeatability over a long period
- Noise-free signal transmission by cable, radio or infrared beam
- Optical status indicator
- Integrated flusher/blower on infrared touch probes
- Effective energy saving mode
- With **TS 460**: Collision protection adapter (optional) prevents damage and reduces heating of the TS through the spindle
- With **TS 260**: Direct connection with any subsequent electronics; no interface required



Touch probe with **cable connection for signal transmission** for machines with manual tool change:

- **TS 260**  
Flange socket axial or radial

Touch probe with **radio and infrared transmission** for machines with automatic tool change:

- **TS 460**  
Standard touch probe with compact dimensions, energy-saving mode, optional collision protection and thermal decoupling

Touch probes with **infrared signal transmission** for machines with automatic tool change:

- **TS 444**  
Battery-free voltage supply through integrated air turbine generator over central compressed air supply
- **TS 642**  
Activation by switch in the taper shank
- **TS 740**  
High probing accuracy and repeatability, low probing force

The following transmitter/receiver units are available for wireless signal transmission:

- **SE 540**: For integration in spindle head; only infrared transmission
- **SE 660**: As common SE for TS and TT; radio and infrared transmission
- **SE 642**: Common SE for TS and TT; only infrared transmission

<b>Machine type</b>
<b>Tool change</b>
<b>Signal transmission</b>
<b>Transmitter/receiver unit</b>
<b>Voltage supply</b>
<b>Switching on/off</b>
<b>Interface to control</b> signal levels
<b>Probe repeatability</b>
<b>Probe velocity</b>
<b>Protection</b> EN 60529



SE 540



SE 660



SE 642



TS 460



TS 444



TS 642



TS 740



TS 260

TS 460	TS 444	TS 642	TS 740	TS 260
<b>CNC machine tools for milling, drilling and boring as well as CNC grinding machines or lathes</b>				
<b>Automatic</b>				<b>Manual</b>
Radio and infrared	Infrared			Via cable
SE 540, SE 660, SE 642	SE 540, SE 642			–
Batteries, rechargeable or nonrechargeable	Air turbine generator	Batteries, rechargeable or nonrechargeable		15 V to 30 V
Radio or infrared transmission	By infrared signal	Switch in taper shank	By infrared signal	–
HTL via SE transmitter/receiver unit				HTL
$2\sigma \leq 1\ \mu\text{m}$			$2\sigma \leq 0.25\ \mu\text{m}$	$2\sigma \leq 1\ \mu\text{m}$
$\leq 3\ \text{m/min}$			$\leq 0.25\ \text{m/min}$	$\leq 3\ \text{m/min}$
IP67				

# Tool touch probes

Tool measurement on the machine shortens non-productive times, increases machining accuracy and reduces scrapping and reworking of machined parts. With the tactile TT touch probes and the contact-free TL laser systems, HEIDENHAIN offers two different possibilities for tool measurement.

With their rugged design and high degree of protection, these tool touch probes can be installed directly within the machine tool's work envelope.

Tool measurement is possible at any time: before machining, between two machining steps, or after machining is done.

## Touch probes

The TT 160 and TT 460 are 3-D touch trigger probes for tool measurement and inspection. The disk-shaped probe contact of the TT is deflected during physical probing of a tool. At that moment the TT generates a trigger signal that is transmitted to the control, where it is processed further. The trigger signal is generated through a wear-free optical sensor that ensures high reliability.

### TT 160

- Signal transmission to the NC over **connecting cable**

### TT 460

- Signal transmission over **radio and infrared beam** to transmitter/receiver unit
- The SE 660 is a common transmitter/receiver unit for tool and workpiece touch probes with radio and infrared transmission



TT 160

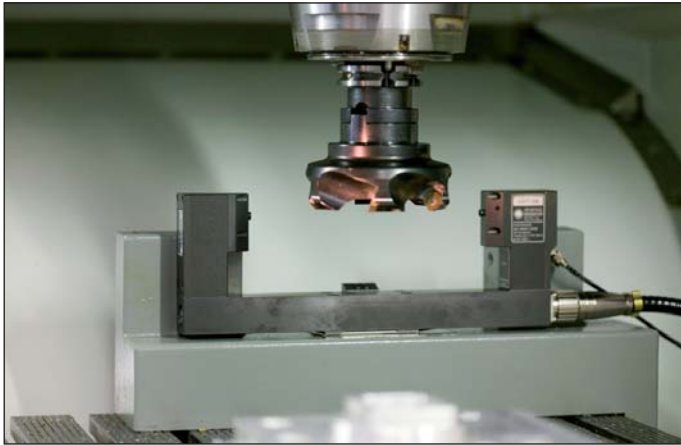


TT 460

	TT 160	TT 460
<b>Probing method</b>	Physical probing in three dimensions: ±X, ±Y, +Z	
<b>Probe repeatability</b>	2 $\sigma$ ≤ 1 $\mu$ m (probing velocity 1 m/min)	
<b>Permissible deflection of probe contact</b>	Approx. 5 mm in all directions	
<b>Voltage supply</b>	10 V to 30 V from the NC	Batteries, rechargeable or nonrechargeable
<b>Interface to control</b> Signal level	HTL	HTL via SE transmitter/receiver unit
<b>Signal transmission</b>	Via cable	Radio wave and infrared transmission with 360° range
<b>Probe contact</b>	Ø 40 mm or Ø 25 mm	
<b>Protection</b> EN 60529	IP67	

### TL laser systems

The TL Micro and TL Nano laser systems can measure tools at the rated speed without making contact. With the aid of the included measuring cycles you can measure tool lengths and diameters, inspect the form of the individual teeth and check for tool wear or breakage. The control automatically saves the results of measurement in the tool table.



	TL Nano	TL Micro 150	TL Micro 200	TL Micro 350
<b>Probing method</b>	Contact-free with laser beam in two dimensions: $\pm X$ (or $\pm Y$ ), $+Z$			
<b>Tool diameter</b> Central measurement	0.03 to 37 mm:	0.03 to 30 mm:	0.03 to 80 mm:	0.03 to 180 mm:
<b>Reproducibility</b>	$\pm 0.2 \mu\text{m}$		$\pm 1 \mu\text{m}$	
<b>Spindle speed</b>	For individual tooth measurement, optimized to standard spindles or HSC spindles ( $> 30000 \text{ rpm}$ )			
<b>Laser</b>	Visible red-light laser with beam focused at center of system; protection class 2 (IEC 825)			
<b>Voltage supply</b>	24 V from the NC			
<b>Interface to control</b> Signal level	HTL			
<b>Protection EN 60529</b>	IP68 (when connected, with sealing air)			
<b>Tool cleaning</b>	Integral blowing unit			

# Measured value acquisition and display

## Evaluation electronics units

Evaluation electronics for metrological applications from HEIDENHAIN serve to visualize and process the values measured with linear encoders, length gauges, rotary encoders or angle encoders. They combine measured value acquisition with intelligent, application-specific further processing. They are used in many metrological applications, ranging from simple measuring stations to complex inspection systems with multiple measuring points.

The evaluation electronics include units with integrated display—which can be used independently—and units that require a PC for operation. They feature interfaces for various encoder signals.



Evaluation electronics for 2-D and 3-D measuring tasks

## Position display units

HEIDENHAIN digital readouts for manually operated machine tools have universal application: In addition to standard tasks on milling, drilling and boring machines and lathes, they also offer ideal solutions for many applications on machine tools, measuring and testing equipment, and special machines—in fact all machines where axis slides are moved manually.

Digital readouts for manual machine tools increase your productivity. You save time, increase the dimensional accuracy of the finished workpiece and enjoy user-friendly operation.

Practice-oriented functions and cycles are available for various applications. The distance-to-go display feature with graphic positioning aid allows you to approach the next nominal position quickly and reliably simply by traversing to a display value of zero. And POSITIP speeds up small-batch production—repetitive machining sequences can be saved as a program.

Precise manufacturing made easy: Together with linear encoders from HEIDENHAIN, the digital readouts measure the axis movements directly. The backlash caused by mechanical transfer elements such as lead screws, racks and gears therefore has no influence.



Evaluation electronics for measuring and testing tasks



### Interface electronics

HEIDENHAIN interface electronics adapt the encoder signals to the interface of the subsequent electronics. They are used when the subsequent electronics cannot directly process the output signals from HEIDENHAIN encoders, or if additional interpolation of the signals is necessary.

Some interface electronics have an integrated counting function. Starting from the last reference point set, an absolute position value is formed when the reference mark is traversed, and is transferred to the subsequent electronics.



### User-friendly environment

Digital readouts and evaluation electronics with integrated display are specially designed for user friendliness. Typical characteristics:

- Optimally readable, graphic flat panel display
- Simple, logically arranged keypad
- Ergonomically designed push-button keys
- Sturdy die-cast housing
- Conversational user guidance with help and graphic functions
- User-friendly functions for easier operation of manual machines and equipment
- Reference mark evaluation for distance-coded and single reference marks
- Problem-free installation, maintenance-free operation
- Fast payback with economical use

Digital readouts from HEIDENHAIN feature a data interface for further processing in the higher-level electronics or simply to print out the measured values.

Evaluation electronics for metrology applications	Series	Page	
For 2-D and 3-D measuring tasks	<b>ND 100 QUADRA-CHEK</b> <b>ND 1000 QUADRA-CHEK</b> <b>QUADRA-CHEK 3000</b> <b>IK 5000 QUADRA-CHEK</b> <b>ND 1200T TOOL-CHEK</b>	<b>54</b>	
For measuring and testing tasks	<b>ND 287</b> <b>ND 1100 QUADRA-CHEK</b> <b>ND 2100 G GAGE-CHEK</b> <b>MSE 1000</b> <b>EIB 700</b> <b>IK 220</b>	<b>56</b>	
<b>Digital readouts for manually operated machine tools</b>			
For milling machines, lathes and positioning devices	<b>ND 500</b> <b>ND 780</b> <b>POSITIP 880</b>	<b>58</b>	
<b>Interface electronics</b>	For signal adjustment	<b>External Interface Box (EIB)</b> <b>IBV, EXE</b> <b>Gateway</b> <b>IDP</b>	<b>59</b>

# Evaluation electronics for metrology applications

## 2-D and 3-D measuring tasks

The evaluation electronics for 2-D and 3-D measuring tasks feature special functions for measured-value acquisition and evaluation. They serve primarily as

- Profile projectors
- Measuring microscopes
- Video measuring machines
- Coordinate measuring machines (manual or with CNC)
- 2-D measuring machines
- Tool presetters

**QUADRA-CHEK** evaluation electronics for profile projectors, measuring microscopes, 2-D and video measuring machines as well as CMMs measure points on **2-D contours**, depending on the version either automatically or manually by crosshairs, by optical edge detection or by video camera with real-time display of the live image and integrated image processing. For **3-D contours**, such as planes, cylinders, cones and spheres, the measurement points are saved by probing with a touch probe. In the optional **CNC version**, they also operate as full-fledged controls for axis positioning and can automatically execute measuring programs.

**TOOL-CHEK** is an evaluation unit with special functions for use on tool presetters.

The **ND** and the **QUADRA-CHEK 3000** are independently operating devices. They feature an integrated screen and sturdy housing.

The **IK 5000 QUADRA-CHEK** universal PC package solution consists of a PC card and the associated software. Together with a PC, they make for a powerful measuring station.



ND 100



ND 1200

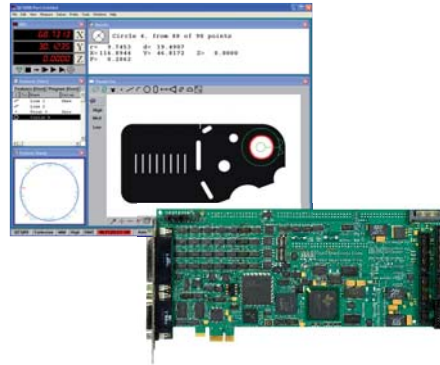
	ND 100 QUADRA-CHEK	ND 1200 QUADRA-CHEK
<b>Application</b>	<ul style="list-style-type: none"> <li>• Profile projectors</li> <li>• Measuring microscopes</li> </ul>	<ul style="list-style-type: none"> <li>• Profile projectors</li> <li>• Measuring microscopes</li> <li>• 2-D measuring machines</li> </ul>
<b>Axes</b>	2 or 3 <sup>1)</sup>	XY, XYQ, XYZ, or XYZQ <sup>1)</sup>
<b>Encoder inputs</b>	□TTL	~ 1 V <sub>pp</sub> or □TTL (other interfaces upon request)
<b>Display</b>	5.7-inch monochrome flat-panel display	
<b>Function</b>	<ul style="list-style-type: none"> <li>• Measurement of 2-D features</li> <li>• Point measurement with crosshairs</li> <li>• Entry of tolerances</li> <li>• Graphic display of measurement results</li> </ul>	<ul style="list-style-type: none"> <li>• Measure Magic function</li> <li>• Creation of measuring programs</li> </ul>
<i>Optional or depending on the version</i>	–	Automatic edge sensing via optical edge detector
<b>Data interfaces</b>	USB	USB; RS-232-C

<sup>1)</sup> Depends on version

<sup>2)</sup> Depends on software option



QUADRA-CHEK 3000



IK 5000

	QUADRA-CHEK 3000	ND 1400 QUADRA-CHEK	IK 5000 QUADRA-CHEK	ND 1202T TOOL-CHEK
	<ul style="list-style-type: none"> <li>• Profile projectors</li> <li>• Measuring microscopes</li> <li>• 2-D measuring machines</li> <li>• Video measuring machines</li> </ul>	<ul style="list-style-type: none"> <li>• Manual coordinate measuring machines</li> </ul>	<ul style="list-style-type: none"> <li>• Profile projectors</li> <li>• Measuring microscopes</li> <li>• Video measuring machines</li> <li>• Coordinate measuring machines</li> <li>• Multi-sensor measuring machines</li> </ul>	<ul style="list-style-type: none"> <li>• Tool presetters</li> </ul>
	XYZQ <sup>2)</sup>	XYZQ	XYQ, XYZ, or XYZQ <sup>1)</sup>	XZ
	12.1-inch color widescreen display (multi-touch screen)	8.4-inch color flat-panel display (touch screen)	By PC screen	5.7-inch monochrome flat-panel display
	<ul style="list-style-type: none"> <li>• Measurement of 2-D features</li> <li>• Point measurement with crosshairs</li> <li>• Entry of tolerances</li> <li>• Graphic display of measurement results</li> <li>• User management</li> <li>• Creation and output of measuring logs</li> </ul>	<ul style="list-style-type: none"> <li>• Measurement of 2-D and 3-D features</li> <li>• Points measured via touch probe, crosshairs or rigid probing element</li> <li>• Entry of tolerances</li> <li>• Graphic display of measurement results</li> <li>• Five coordinate systems can be stored</li> <li>• Touch-probe management</li> </ul>	<ul style="list-style-type: none"> <li>• Measurement of 2-D features</li> <li>• Point measurement with crosshairs</li> <li>• Entry of tolerances</li> <li>• Graphic display of measurement results</li> <li>• Report generator</li> <li>• Import and export functions for CAD and measured data</li> <li>• Nominal-to-actual comparison for 2-D free-form contours from a CAD model</li> </ul>	<ul style="list-style-type: none"> <li>• Point measurement with crosshairs</li> <li>• 99 tool adapters</li> <li>• Memory for 300 tools</li> <li>• Entry of tolerances</li> <li>• Circle and angle measurement</li> <li>• Label printing</li> </ul>
	<p><b>AEI1 software option</b></p> <ul style="list-style-type: none"> <li>• Additional encoder input</li> </ul> <p><b>VED software option</b></p> <ul style="list-style-type: none"> <li>• Video edge detection and live image display</li> <li>• Image archiving</li> <li>• Light control</li> </ul>	–	<ul style="list-style-type: none"> <li>• Measurement of 3-D features</li> <li>• Automatic edge sensing via optical edge detector</li> <li>• Video edge detection and live image display</li> <li>• Image archiving</li> <li>• Point measurement by touch probe (also TP 200)</li> <li>• CNC axis control and autofocus</li> <li>• Zoom and light control</li> </ul>	–
	Ethernet, USB	USB; RS-232-C	PCI (PC interface)	USB; RS-232-C



# Evaluation electronics for metrology applications

## Measuring and testing tasks

Evaluation electronics for measuring and testing tasks are ideal for

- Measurement equipment
- Adjustment and inspection equipment
- SPC inspection stations
- Multipoint inspection apparatuses
- Mobile data acquisition
- Positioning equipment

The **ND** evaluation units are independently operating devices with integrated screen and sturdy housing. They feature special functions for measuring and statistical evaluation of measured values such as sorting and tolerance check mode, minimum/maximum value storage, and measurement series storage. These data make it possible to calculate mean values and standard deviations and graphically display them in histograms or control charts. With the ND 2100G, even complex properties like flatness and volume can be ascertained: its inputs can be assigned and combined as desired with mathematical, trigonometric or statistical formulas.

The **MSE 1000** is a modular electronics unit for multipoint measuring apparatuses for shop-floor metrology. With its modular design and various interfaces, it can be adapted flexibly to a wide variety of applications. Measured values are evaluated and displayed through a higher-level computer system.

The **EIB 700** is ideal for applications requiring high resolution, fast measured-value acquisition, mobile data acquisition or data storage.

The data is transferred over the standard Ethernet interface for evaluation and display in a higher-level computer system.

The **IK 220** is an expansion board for PCs for recording the measured values of two incremental or absolute HEIDENHAIN encoders.



ND 2100G

	ND 287	ND 1100 QUADRA-CHEK
<b>Application</b>	<ul style="list-style-type: none"> <li>• Measurement equipment</li> <li>• Testing devices</li> <li>• SPC inspection stations</li> </ul>	<ul style="list-style-type: none"> <li>• Positioning equipment</li> <li>• Measuring fixtures</li> </ul>
<b>Axes</b> <sup>1)</sup>	1 (optional: 2)	2, 3 or 4
<b>Encoder inputs</b>	$\sim 1 V_{PP}$ , $\sim 11 \mu A_{PP}$ or EnDat 2.2	$\sim 1 V_{PP}$ or $\square$ TTL (other interfaces upon request)
<b>Display</b>	Color flat-panel display	5.7-inch monochrome flat-panel display
<b>Function</b>	<ul style="list-style-type: none"> <li>• Sorting and tolerance checking</li> <li>• Measurement series with min./max. value storage</li> <li>• Functions for statistical process control (SPC)</li> <li>• Graphic display of measurement results</li> <li>• Storage of measured values</li> </ul> <p><i>Optional:</i> Sum/difference display or thermal compensation</p>	<ul style="list-style-type: none"> <li>• Measurement series with min./max. value storage</li> <li>• Touch probe connection for a HEIDENHAIN or Renishaw touch probe</li> </ul>
<b>Data interfaces</b>	USB; RS-232-C; <i>optional:</i> Ethernet	USB; RS-232-C

<sup>1)</sup> Depends on version



MSE 1000



EIB 700



IK 220

ND 2100G GAGE-CHEK	MSE 1000	EIB 700	IK 220
<ul style="list-style-type: none"> <li>• Multipoint inspection apparatuses</li> <li>• SPC inspection stations</li> </ul>	<ul style="list-style-type: none"> <li>• Multipoint inspection apparatuses</li> <li>• PLC testing stations</li> </ul>	<ul style="list-style-type: none"> <li>• Testing stations</li> <li>• Multipoint inspection apparatuses</li> <li>• Mobile data acquisition</li> </ul>	<ul style="list-style-type: none"> <li>• Measuring and testing stations</li> </ul>
4 or 8	Up to 250	4	2
$\sim 1 V_{PP}$ , $\square$ TTL, EnDat 2.2, LVDT or HBT (other interfaces upon request)		$\sim 1 V_{PP}$ EnDat 2.1 or EnDat 2.2 $(\sim 11 \mu A_{PP}$ upon request)	$\sim 1 V_{PP}$ $\sim 11 \mu A_{PP}$ EnDat 2.1 or SSI
5.7-inch color flat-panel display	By PC screen		
<ul style="list-style-type: none"> <li>• Sorting and tolerance checking</li> <li>• Measurement series with min./max. value storage</li> <li>• Functions for statistical process control (SPC)</li> <li>• Graphic display of measurement results</li> <li>• Storage of measured values</li> <li>• Programming of up to 100 parts</li> <li>• Entry of any formulas, combinations and variables</li> <li>• Output of measurement results</li> </ul>	<ul style="list-style-type: none"> <li>• Modular design</li> <li>• Configurable as desired</li> <li>• Various interfaces</li> <li>• Fast communication with higher-level computer system</li> <li>• Universal outputs</li> </ul>	<ul style="list-style-type: none"> <li>• Precise position measurement up to 50 kHz updating rate</li> <li>• Programmable measured-value inputs</li> <li>• Internal and external measured-value triggers</li> <li>• Measured-value memory for approx. 250 000 measured values per channel</li> <li>• Connection over standard Ethernet interface to higher-level computer systems</li> </ul>	<ul style="list-style-type: none"> <li>• Programmable measured-value inputs</li> <li>• Internal and external measured-value triggers</li> <li>• Measured-value memory for 8192 measured values per channel</li> </ul>
	Ethernet		PCI (PC interface)

# Digital readouts for manually operated machine tools

Applications for digital readouts are on manually operated machine tools, e.g.

- Milling machines
- Drilling and boring machines
- Lathes
- Radial drilling machines
- Grinding machines
- Electrical discharge machines

The splash-proof front panel and the sturdy cast-metal housing make digital readouts from HEIDENHAIN impervious to the hardest of workshop conditions.



ND 780



ND 500

	POSITIP 880	ND 780	ND 500
<b>Application</b>	Milling, drilling, boring machines and lathes		
<b>Description</b>	Color flat-panel display, program memory, splash-proof full-travel keyboard	Monochrome flat-panel display, splash-proof full-travel keyboard	Monochrome flat-panel display, membrane keyboard
<b>Axes</b>	Up to 6 axes	Up to 3 axes	2 or 3 axes
<b>Encoder inputs</b>	~ 1 V <sub>PP</sub> or EnDat 2.1	~ 1 V <sub>PP</sub>	□ TTL
<b>Display step</b>	10 μm, 5 μm, 1 μm or finer		5 μm (with LS 328C/LS 628C)
<b>Datums</b>	<i>Milling: 99; turning: 1</i>	10	
<b>Tool data</b>	For 99 tools	For 16 tools	
<b>Programming</b>	Max. 999 program blocks per program	–	
<b>Functions</b>	Contour monitoring with magnify function	Contour monitoring	
For milling, drilling and boring machines	<ul style="list-style-type: none"> <li>• Calculation of positions for hole patterns (circular patterns as well as linear patterns)</li> <li>• Cutting data calculator</li> </ul>		
	Probing functions for reference-point acquisition with the KT edge finder: "Edge", "Centerline" and "Circle center"		–
	Positioning aids for milling and roughing of rectangular pockets	–	
For turning	<ul style="list-style-type: none"> <li>• Radius/Diameter display</li> <li>• Separate or sum display for Z and Z<sub>0</sub></li> <li>• Taper calculator</li> <li>• Freezing the tool position for back-off</li> </ul>		
	<ul style="list-style-type: none"> <li>• Oversize allowances</li> <li>• Cycle for area clearance</li> </ul>	–	
<b>Interfaces</b>	Edge finder, switching functions (option)		–
	RS-232-C/V.24, Centronics	RS-232-C/V.24	USB

# Interface electronics

Interface electronics from HEIDENHAIN serve to adapt the encoder signals to the interface of the subsequent electronics, for example:

Incremental signals

~ 1 V<sub>PP</sub> > □TTL

~ 11 μA<sub>PP</sub> > □TTL

Incremental signals > position values

~ 1 V<sub>PP</sub> > EnDat

~ 1 V<sub>PP</sub> > Fanuc Serial Interface

~ 1 V<sub>PP</sub> > Mitsubishi high speed Interface

Position values

EnDat > DRIVE-CLiQ

EnDat > Yaskawa Serial Interface

EnDat > PROFIBUS-DP

HEIDENHAIN interface electronics are available in various mechanical designs.

## Box design



## Plug design



## Version for integration



## Top-hat rail design



Outputs	Inputs	Design	Interpolation <sup>1)</sup> or subdivision	Type		
□TTL	~ 1 V <sub>PP</sub>	Housing	5/10-fold	<b>IBV 101</b>		
			20/25/50/100-fold	<b>IBV 102</b>		
			Without interpolation	<b>IBV 600</b>		
			25/50/100/200/400-fold	<b>IBV 660B</b>		
	~ 11 μA <sub>PP</sub>	Housing	5/10-fold	5/10/20/25/50/100-fold	<b>APE 371</b>	
				Installation	5/10-fold	<b>IDP 181</b>
				Installation	20/25/50/100-fold	<b>IDP 182</b>
				Installation	5-fold	<b>IDP 101</b>
□TTL/ ~ 1 V <sub>PP</sub> Adjustable	~ 1 V <sub>PP</sub>	Housing	2-fold	<b>IBV 6072</b>		
			5/10-fold	<b>IBV 6172</b>		
			5/10-fold and 20/25/50/100-fold	<b>IBV 6272</b>		
EnDat 2.2	~ 1 V <sub>PP</sub>	Housing	≤ 16384-fold	<b>EIB 192</b>		
		Connector	≤ 16384-fold	<b>EIB 392</b>		
		Housing	≤ 16384-fold	<b>EIB 1512<sup>3)</sup></b>		
DRIVE-CLiQ	EnDat 2.2	Housing	–	<b>EIB 2391 S</b>		
Fanuc Serial Interface	~ 1 V <sub>PP</sub>	Housing	≤ 16384-fold	<b>EIB 192 F</b>		
		Connector	≤ 16384-fold	<b>EIB 392 F</b>		
		Housing	≤ 16384-fold	<b>EIB 1592 F<sup>3)</sup></b>		
Mitsubishi high speed interface	~ 1 V <sub>PP</sub>	Housing	≤ 16384-fold	<b>EIB 192 M</b>		
		Connector	≤ 16384-fold	<b>EIB 392 M</b>		
		Housing	≤ 16384-fold	<b>EIB 1592 M<sup>3)</sup></b>		
Yaskawa Serial Interface	EnDat 2.2 <sup>2)</sup>	Connector	–	<b>EIB 3391 Y</b>		
PROFIBUS-DP	EnDat 2.1; EnDat 2.2	Top hat rail	–	<b>PROFIBUS Gateway</b>		

<sup>1)</sup> Switchable

<sup>2)</sup> Only LIC 4100 with 5 nm measuring step, LIC 2100 with 50 nm and 100 nm measuring steps

<sup>3)</sup> Connections for two scanning heads for digital calculation

## For more information

### Brochures, data sheets and CD-ROMs

The products shown in this General Catalog are described in more detail in separate documentation, including complete specifications, signal descriptions and dimension drawings in English and German (other languages available upon request).

### HEIDENHAIN on the Internet

At our home page on the Internet at [www.heidenhain.de](http://www.heidenhain.de) you will find these brochures in various languages, but also a great deal of further up-to-date information on the company and its products.

Our web site also includes:

- Technical articles
- Press releases
- Addresses
- TNC training programs

## Length measurement



Brochure  
**Linear Encoders**  
*For Numerically Controlled Machine Tools*

Contents:  
Absolute linear encoders  
**LC**  
Incremental linear encoders  
**LB, LF, LS**



Brochure  
**Length Gauges**

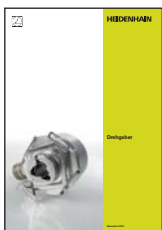
Contents:  
HEIDENHAIN-ACANTO  
HEIDENHAIN-SPECTO  
HEIDENHAIN-METRO  
HEIDENHAIN-CERTO



Brochure  
**Exposed Linear Encoders**

Contents:  
Absolute linear encoders  
**LIC**  
Incremental linear encoders  
**LIP, PP, LIF, LIDA**

## Angle measurement



Brochure  
**Rotary Encoders**

Contents:  
Absolute rotary encoders  
**ECN, EQN, ROC, ROQ**  
Incremental rotary encoders  
**ERN, ROD**



Brochure  
**Angle Encoders with Integral Bearing**

Contents:  
Absolute angle encoders  
**RCN, ECN**  
Incremental angle encoders  
**RON, RPN, ROD**



Brochure  
**Encoders for Servo Drives**

Contents:  
Rotary encoders  
Angle encoders  
Linear encoders



Brochure  
**Angle Encoders without Integral Bearing**

Contents:  
Incremental angle encoders  
**ERA, ERO, ERP**



Brochure  
**Modular Magnetic Encoders**

Contents:  
Incremental encoders  
**ERM**

## Machine tool control



Brochures  
**TNC 128 Straight Cut Control**  
**TNC 320 Contouring Control**  
**iTNC 530 Contouring Control**  
**TNC 620 Contouring Control**  
**TNC 640 Contouring Control**

Contents:  
 Information for the user



OEM brochures  
**TNC 128 Straight Cut Control**  
**TNC 320 Contouring Control**  
**iTNC 530 Contouring Control**  
**TNC 620 Contouring Control**  
**TNC 640 Contouring Control**

Contents:  
 Information for the machine tool builder



Brochures  
**MANUALplus 620 Contouring Control**  
**CNC Pilot 640 Contouring Control**

Contents:  
 Information for the user



OEM brochure  
**MANUALplus 620 Contouring Control**  
**CNC Pilot 640 Contouring Control**

Contents:  
 Information for the machine tool builder

## Setup and measurement



Brochure  
**Touch Probes**

Contents:  
 Tool touch probes  
**TT, TL**  
 Workpiece touch probes  
**TS**



Brochure  
**Evaluation Electronics**  
*For Metrological Applications*

Contents:  
**ND 100, ND 287, ND 1100, ND 1200,**  
**ND 1300, ND 1400 ND 1200T, ND 2100 G**  
**MSE 1000, EIB 700, IK 220, IK 5000**



Brochure  
**Measuring Systems for Machine Tool**  
**Inspection and Acceptance Testing**

Contents:  
 Incremental linear encoders  
**KGM, VM**



Brochure  
**Digital Readouts/Linear Encoders**  
*For Manually Operated Machine Tools*

Contents:  
 Digital readouts  
**ND 280, ND 500, ND 700, POSITIP, ND 1200T**  
 Linear encoders  
**LS 300, LS 600**



Product overview  
**Interface Electronics**



Preliminary Product Information  
**QUADRA-CHEK 3000**

HEIDENHAIN is represented by subsidiaries in all important industrial nations. In addition to the addresses listed here, there are many service agencies located worldwide. For their addresses, please refer to the Internet or contact HEIDENHAIN Traunreut.

## DR. JOHANNES HEIDENHAIN GmbH

Dr.-Johannes-Heidenhain-Straße 5

83301 Traunreut, Germany

☎ +49 8669 31-0

☎ +49 8669 32-5061

E-mail: info@heidenhain.de

www.heidenhain.de

## Germany

### HEIDENHAIN Vertrieb Deutschland

83301 Traunreut, Deutschland

☎ 08669 31-3132

☎ 08669 32-3132

E-Mail: hd@heidenhain.de

### HEIDENHAIN Technisches Büro Nord

12681 Berlin, Deutschland

☎ 030 54705-240

E-Mail: tbn@heidenhain.de

### HEIDENHAIN Technisches Büro Mitte

07751 Jena, Deutschland

☎ 03641 4728-250

E-Mail: tbn@heidenhain.de

### HEIDENHAIN Technisches Büro West

44379 Dortmund, Deutschland

☎ 0231 618083-0

E-Mail: tbw@heidenhain.de

### HEIDENHAIN Technisches Büro Südwest

70771 Leinfelden-Echterdingen, Deutschland

☎ 0711 993395-0

E-Mail: tbsw@heidenhain.de

### HEIDENHAIN Technisches Büro Südost

83301 Traunreut, Deutschland

☎ 08669 31-1345

E-Mail: tbso@heidenhain.de

## Europe

### AT HEIDENHAIN Techn. Büro Österreich

Dr.-Johannes-Heidenhain-Straße 5

83301 Traunreut, Germany

☎ +49 8669 31-1337

www.heidenhain.de

### BE HEIDENHAIN NV/SA

Pamelse Klei 47

1760 Roosdaal, Belgium

☎ +32 54 343158

www.heidenhain.be

### BG ESD Bulgaria Ltd.

G.M. Dimitrov Blvd.,

bl. 60, entr. G, fl. 1, ap 74

Sofia 1172, Bulgaria

☎ +359 2 9632949

www.esd.bg

### BY GERTNER Service GmbH

ul. Zhilunovicha 11, Office 204

220026 Minsk, Belarus

☎ +375 172954875

www.heidenhain.by

### CH HEIDENHAIN (SCHWEIZ) AG

Vieristrasse 14

8603 Schwerzenbach, Switzerland

☎ +41 44 8062727

www.heidenhain.ch

### CZ HEIDENHAIN s.r.o.

Dolnomecholupska ul. 12b

102 00 Praha 10, Czech Republic

☎ +420 272658131

www.heidenhain.cz

### DK TP TEKNIK A/S

Korskildelund 4

2670 Greve, Denmark

☎ +45 70 100966

www.tp-gruppen.dk

### ES FARRESA ELECTRONICA S.A.

Les Corts, 36 bajos

08028 Barcelona, Spain

☎ +34 934092491

www.farresa.es

### FI HEIDENHAIN Scandinavia AB

Nuolitie 2 a 10

01740 Vantaa, Finland

☎ +358 9 8676476

www.heidenhain.fi

### FR HEIDENHAIN FRANCE sarl

2 avenue de la Cristallerie

92310 Sèvres, France

☎ +33 0141143000

www.heidenhain.fr

## The Americas

### AR NAKASE SRL.

Calle 49 Nr. 5764

B1653AOX Villa Ballester,

Provincia de Buenos Aires, Argentina

☎ +54 11 47684242

www.heidenhain.com.ar

### BR DIADUR Indústria e Comércio Ltda.

Rua Sérvia, 329 Socorro, Santo Amaro

04763-070 – São Paulo – SP, Brazil

☎ +55 11 5696-6777

www.heidenhain.com.br

### CA HEIDENHAIN CORPORATION

Canadian Regional Office

11-335 Admiral Blvd., Unit 11

Mississauga, Ontario L5T2N2, Canada

☎ +1 905 670-8900

www.heidenhain.com

### MX HEIDENHAIN CORPORATION MEXICO

Carolina Villanueva de Garcia No. 206

Ciudad Industrial

20290 Aguascalientes, AGS., Mexico

☎ +52 449 9130870

E-mail: info@heidenhain.com

### US HEIDENHAIN CORPORATION

333 East State Parkway

Schaumburg, IL 60173-5337, USA

☎ +1 847 490-1191

www.heidenhain.com

### VE Maquinaria Diekmann S.A.

Av. Humbolt (Prol. Leoncio Martinzes)

Urb. Las Acacias Aptdo. 40.112

Caracas, 1040-A, Venezuela

☎ +58 212 6325410

E-mail: purchase@diekmann.com.ve

## Africa

### ZA MAFEMA SALES SERVICES C.C.

107 16th Road, Unit B3

Tillbury Business Park, Randjespark

1685 Midrand, South Africa

☎ +27 11 3144416

www.heidenhain.co.za

## Australia

### AU FCR Motion Technology Pty. Ltd

Automation Place, Unit 6,

38-40 Little Boundary Road

Laverton North 3026, Victoria, Australia

☎ +61 3 93626800

E-mail: vic-sales@fcrmotion.com

<b>GB</b>	<b>HEIDENHAIN (G.B.) Limited</b> 200 London Road, Burgess Hill West Sussex RH15 9RD, United Kingdom ☎ +44 1444 247711 www.heidenhain.co.uk	<b>NO</b>	<b>HEIDENHAIN Scandinavia AB</b> Orkdalsveien 15 7300 Orkanger, Norway ☎ +47 72480048 www.heidenhain.no	<b>SE</b>	<b>HEIDENHAIN Scandinavia AB</b> Storsåtragränd 5 12739 Skärholmen, Sweden ☎ +46 8 53193350 www.heidenhain.se
<b>GR</b>	<b>MB Milionis Vassilis</b> 38, Scoufa Str., St. Dimitrios 17341 Athens, Greece ☎ +30 210 9336607 www.heidenhain.gr	<b>PL</b>	<b>APS</b> ul. Włodarzewska 47 02-384 Warszawa, Poland ☎ +48 228639737 www.heidenhain.pl	<b>SK</b>	<b>KOPRETINA TN s.r.o.</b> Suvoz 1660 91101 Trenčín, Slovakia ☎ +421 32 7401700 www.kopretina.sk
<b>HR</b>	Croatia → <b>SL</b>	<b>PT</b>	<b>FARRESA ELECTRÓNICA LDA.</b> Rua do Espido, 74 C 4470 - 177 Maia, Portugal ☎ +351 229478140 www.farresa.pt	<b>SL</b>	<b>NAVO d.o.o.</b> Sokolska ulica 46 2000 Maribor, Slovenia ☎ +386 2 4297216 www.heidenhain.si
<b>HU</b>	<b>HEIDENHAIN Kereskedelmi Képviselet</b> Grassalkovich út 255. 1239 Budapest, Hungary ☎ +36 1 4210952 www.heidenhain.hu	<b>RO</b>	<b>HEIDENHAIN Reprezentantă Romania</b> Str. Zizinului, nr. 110, etaj 2, Braşov, 500407, Romania ☎ +40 268 318476 www.heidenhain.ro	<b>TR</b>	<b>T&amp;M Mühendislik San. ve Tic. LTD. ŞTİ.</b> Necip Fazıl Bulvarı, KEYAP Çarşı Sitesi G1 Blok, No. 119/B 34775 Y. Dudullu – Ümraniye-Istanbul, Turkey ☎ +90 216 3141111 www.heidenhain.com.tr
<b>IT</b>	<b>HEIDENHAIN ITALIANA S.r.l.</b> Via Asiago, 14 20128 Milano, Italy ☎ +39 02 27075-1 www.heidenhain.it	<b>RS</b>	Serbia → <b>BG</b>	<b>UA</b>	<b>Gertner Service GmbH</b> Büro Kiev 01133 Kiev, Ukraine bul. L. Ukrainki 14a/40 ☎ +38 044 2357574 www.heidenhain.ua
<b>NL</b>	<b>HEIDENHAIN NEDERLAND B.V.</b> Copernicuslaan 34, 6716 BM Ede, Netherlands ☎ +31 318 581800 www.heidenhain.nl	<b>RU</b>	<b>OOO HEIDENHAIN</b> ul. Goncharnaya, d. 21 115172 Moscow, Russia ☎ +7 495 931-9646 www.heidenhain.ru		

## Asia

<b>CN</b>	<b>DR. JOHANNES HEIDENHAIN (CHINA) Co., Ltd.</b> No. 6, TianWeiSanJie, Area A. Beijing Tianzhu Airport Industrial Zone Shunyi District, Beijing 101312, China ☎ +86 10-80420000 www.heidenhain.com.cn	<b>IN</b>	<b>HEIDENHAIN Optics &amp; Electronics India Private Limited</b> Citilights Corporate Centre No. 1, Vivekanandan Street, Off Mayor Ramanathan Road Chetpet, Chennai 600 031, India ☎ +91 44 3023-4000 www.heidenhain.in	<b>PH</b>	<b>Machinebanks` Corporation</b> 482 G. Araneta Avenue, Quezon City, Philippines 1113 ☎ +63 2 7113751 E-mail: info@machinebanks.com
<b>HK</b>	<b>HEIDENHAIN LTD</b> Unit 2007-2010, 20/F, Apec Plaza 49 Hoi Yuen Road, Kwun Tong Kowloon, Hong Kong ☎ +852 27591920 E-mail: sales@heidenhain.com.hk	<b>JP</b>	<b>HEIDENHAIN K.K.</b> Hulic Kojimachi Bldg 9F 3-2 Kojimachi, Chiyoda-ku Tokyo 102-0083, Japan ☎ +81 (0)3-3234-7781 www.heidenhain.co.jp	<b>SG</b>	<b>HEIDENHAIN PACIFIC PTE LTD.</b> 51, Ubi Crescent Singapore 408593 ☎ +65 6749-3238 www.heidenhain.com.sg
<b>ID</b>	<b>PT Servitama Era Toolsindo</b> GTS Building, Jl. Pulo Sidik Block R29 Jakarta Industrial Estate Pulogadung Jakarta 13930, Indonesia ☎ +62 21 46834111 E-mail: ptset@group.gts.co.id	<b>KR</b>	<b>HEIDENHAIN Korea LTD.</b> 2F Namsung Plaza (9th Ace Techno Tower) 345-30, Gasan-Dong, Geumcheon-Gu, Seoul, Korea, 153-782 ☎ +82 2 2028-7430 www.heidenhain.co.kr	<b>TH</b>	<b>HEIDENHAIN (THAILAND) LTD</b> 88, 90, 4th Floor Anek-Vunnee Building Chaloem Phra Kiat Rama 9 Road Nongbon, Pravate, Bangkok 10250, Thailand ☎ +66 2747 2146-7 www.heidenhain.co.th
<b>IL</b>	<b>NEUMO VARGUS MARKETING LTD.</b> Post Box 57057 34-36, Itzhak Sade St. Tel Aviv 61570, Israel ☎ +972 3 5373275 E-mail: neumo@neumo-vargus.co.il	<b>MY</b>	<b>ISOSERVE SDN. BHD.</b> No. 21, Jalan CJ 3/13-2 Pusat Bandar Cheras Jaya 43200 Balakong, Selangor ☎ +03 9080 3121 E-mail: sales@isoserve.com.my	<b>TW</b>	<b>HEIDENHAIN Co., Ltd.</b> No. 29, 33rd Road Taichung Industrial Park Taichung 40768, Taiwan R.O.C. ☎ +886 4 23588977 www.heidenhain.com.tw
				<b>VN</b>	<b>AMS Co. Ltd</b> 243/9/10 D To Hien Thanh Street, Ward 13, District 10, HCM City, Vietnam ☎ +84 8 3868 3738 E-mail: davidgoh@amsvn.com




# HEIDENHAIN


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**DR. JOHANNES HEIDENHAIN GmbH**

Dr.-Johannes-Heidenhain-Straße 5

**83301 Traunreut, Germany**

 +49 8669 31-0

 +49 8669 32-5061

E-mail: [info@heidenhain.de](mailto:info@heidenhain.de)

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[www.heidenhain.de](http://www.heidenhain.de)

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