



# HEIDENHAIN



## General Catalog

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

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

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 *Further information* on page 68) or on the Internet at [www.heidenhain.de](http://www.heidenhain.de). Our sales personnel will be glad to help you personally. See *Sales and service—worldwide* on page 70 for addresses and telephone numbers.

The image on the title page shows a milled part with curved surfaces that 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, a very high surface quality was attained thanks to the highly dynamic motion control.



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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. HEIDENHAIN develops and builds most of the machines it needs for the production and measurement of linear and circular scales, including the necessary copying equipment.

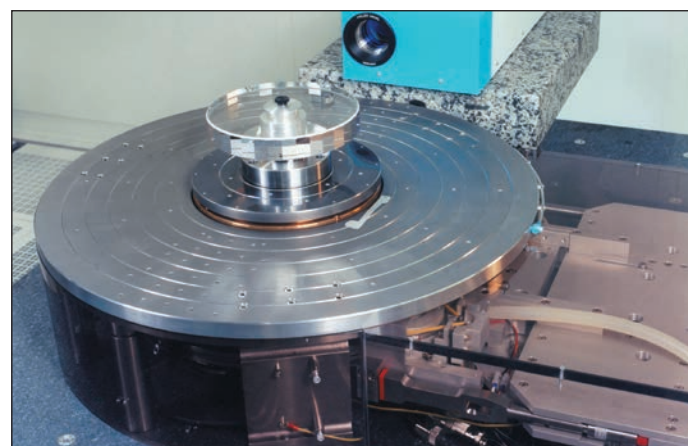


30 m long measuring machine for scale tapes



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 standards 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.

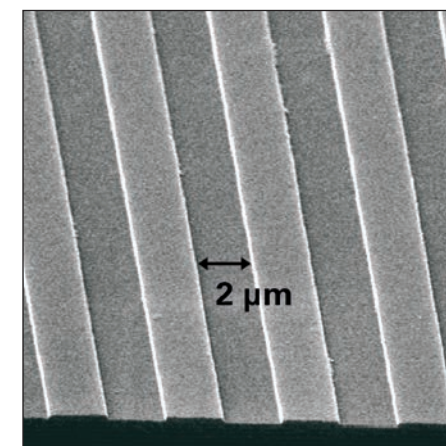


Angle comparator, measuring step approx. 0.001°



ALMA radio telescope in Chajnantor, Chile (photo courtesy of ESO)

The heart of a HEIDENHAIN encoder is its measuring standard, usually in the form of a grating with typical line widths of 0.25 µm to 10 µm. 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 and can tolerate vibration and shock. All measuring standards have a defined thermal behavior.



Phase grating with approx. 0.25 µm 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.

### 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

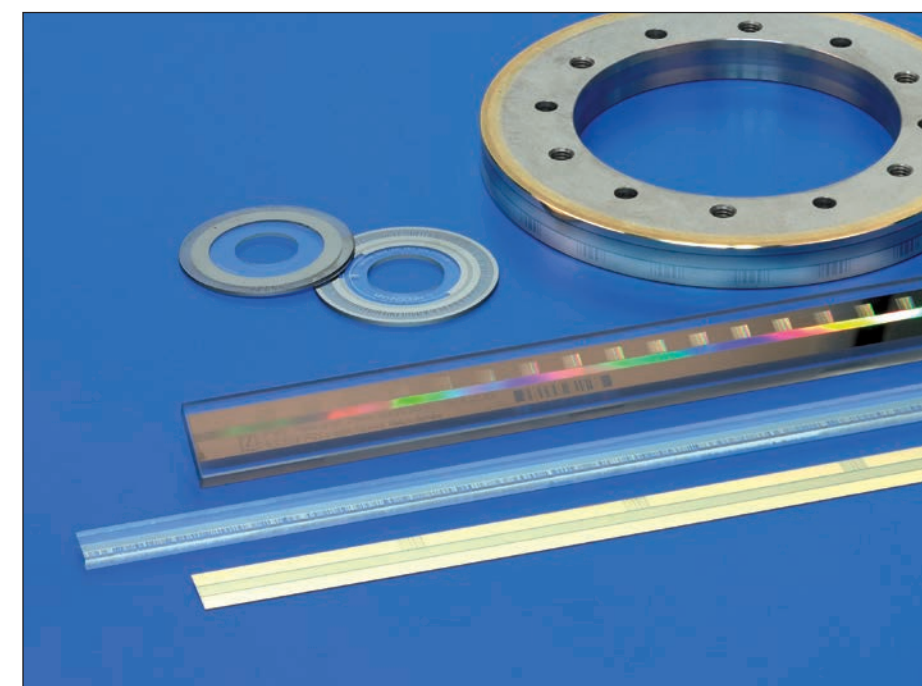
Graduations manufactured with the SUPRADUR process function optically like three-dimensional phase gratings, but they have a planar structure and are therefore particularly insensitive to contamination.

### 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



Sealed linear encoders

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

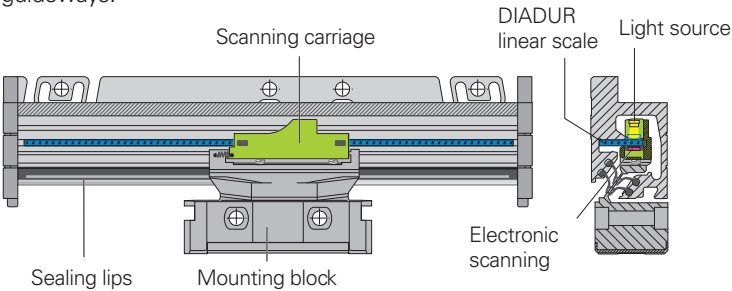
- Accuracy grades as fine as  $\pm 2\text{ }\mu\text{m}$
- Measuring steps of down to  $0.001\text{ }\mu\text{m}$
- Measuring lengths of up to 30 m (72 m upon request)
- Fast and simple installation
- Large mounting tolerances
- High acceleration loading
- Protection against contamination



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
  - Measuring lengths of up to 2040 mm (for measuring lengths starting from 1240 mm, mounting via mounting spar or tensioning elements)

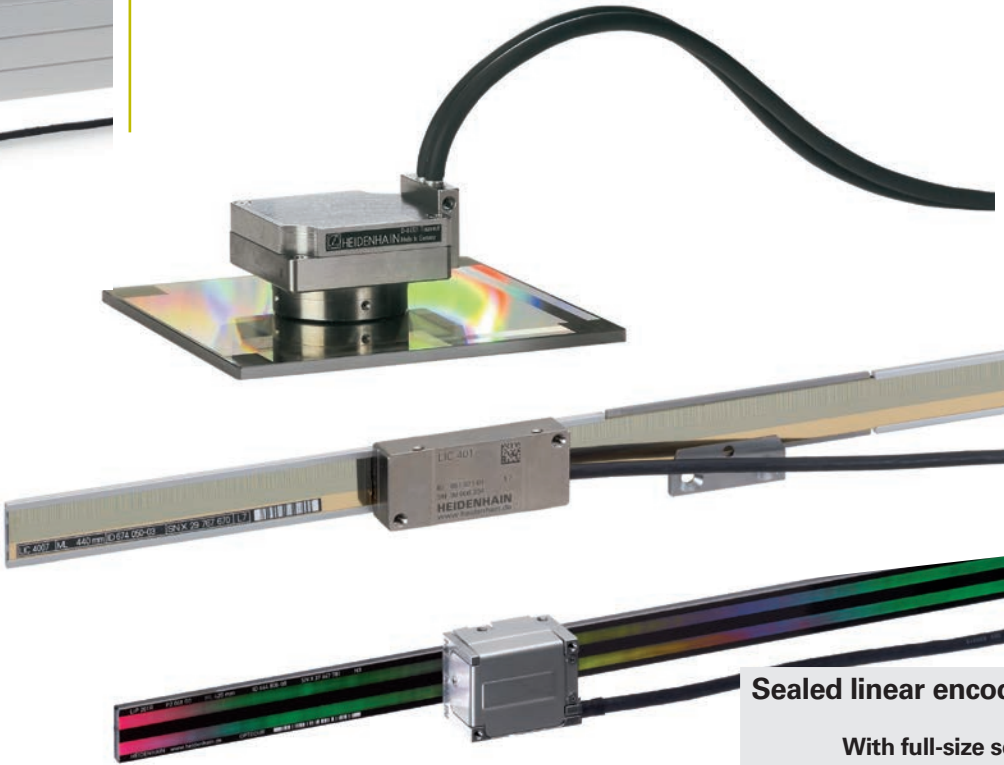
The aluminum housing of a HEIDENHAIN sealed linear encoder protects the scale, scanning carriage, and its guideway from chips, dust, and fluids. Downward-oriented elastic lips seal the housing. The scanning carriage travels along the scale on a low-friction guide. It is connected to the external mounting 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  $\pm 0.5\text{ }\mu\text{m}$  and better
- For measuring steps of down to  $0.001\text{ }\mu\text{m}$  (1 nm)
- Measuring lengths of 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  $\pm 0.1\text{ }\mu\text{m}$
- For measuring steps of down to  $0.005\text{ }\mu\text{m}$  (5 nm)
- Measuring lengths of 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
With full-size scale housing	Absolute position measurement	LC 100	8
	Absolute position measurement and large measuring lengths	LC 200	
With slimline scale housing	Incremental position measurement	LS 100	10
	Very high repeatability	LF 100	
	Typically for manual machines	LS 600	
	Large measuring lengths	LB 300	
Exposed linear encoders	Absolute position measurement	LC 400	12
	Incremental position measurement	LS 400	
	Very high repeatability	LF 400	
	Typically for manual machines	LS 300	
Length gauges	Very high accuracy	LIP	16
	Two-coordinate encoders	LIF, PP	
	For high accuracy and large measuring lengths	LIDA	
	Absolute position measurement	LIC	
For measuring stations and multipoint inspection apparatuses		AT, CT, MT, ST	



# 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 requiring any previous traverse. 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 through the sections, drawn to a defined tension and fixed at both ends to the machine base.

### LC 100 series

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

### LC 200 series

- Absolute position measurement
- For large measuring lengths of up to 28 m
- Defined thermal behavior
- High vibration resistance
- Two mounting attitudes
- Single-field scanning

### LS 100 series

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

### LF 185

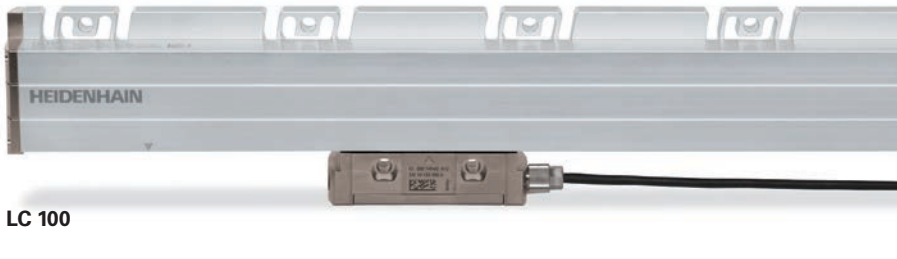
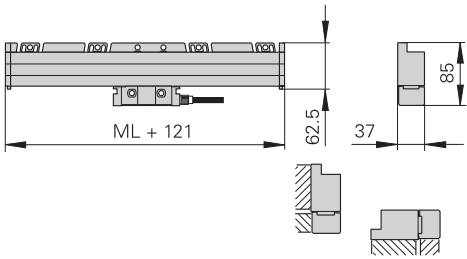
- Incremental position measurement
- Very high repeatability
- Thermal behavior similar to steel or cast iron
- High vibration rating
- Two mounting attitudes
- Single-field scanning

### LB 382

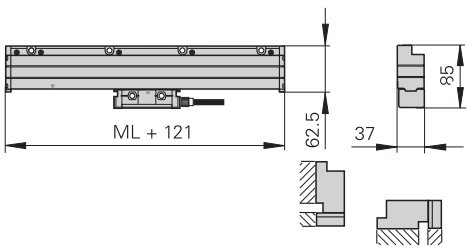
- Incremental position measurement
- For large measuring lengths of up to 30 m<sup>4)</sup>
- Defined thermal behavior
- High vibration resistance
- Two mounting attitudes
- Single-field scanning

### LS 600 series

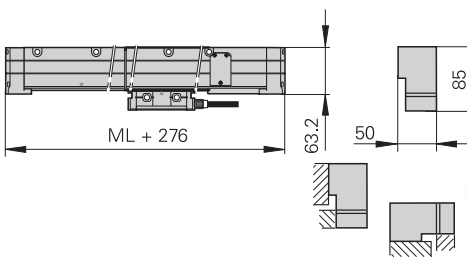
- Incremental position measurement
- Typically for manual machines
- Simple mounting



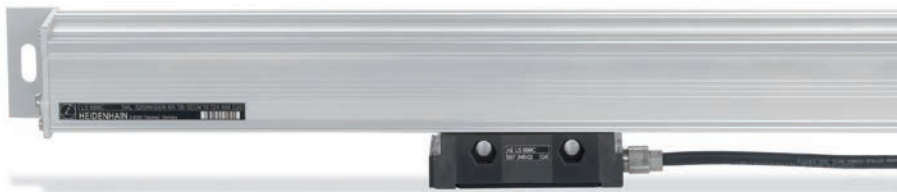
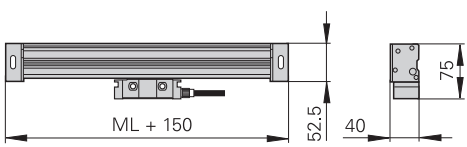
LC 100



LF 185



LC 200



LS 600

	<b>Absolute</b> LC 115 <sup>1)</sup> /LC 185 LC 195F/M/P/S <sup>1)</sup>	LC 211/LC 281 LC 291F/M	<b>Incremental</b> LF 185	LS 187 LS 177	LS 688C LS 628C	LB 382
<b>Measuring standard</b>	DIADUR glass scale	METALLUR steel scale tape	SUPRADUR phase grating on steel	DIADUR glass scale	DIADUR glass scale	AURODUR steel scale tape
Grating period	20 µm	40 µm	8 µm	20 µm	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/ Panasonic/DRIVE-CLiQ	LC 211: EnDat 2.2 LC 281: EnDat 2.2 with ~ 1 V <sub>PP</sub> LC 291: Fanuc αi/Mitsubishi	~ 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>
Signal period	LC 185: 20 µm	LC 281: 40 µm	4 µm	LS 187: 20 µm	LS 688C: 20 µm	40 µm
<b>Accuracy grade</b>	±5 µm, ±3 µm <sup>3)</sup>	±5 µm	±3 µm, ±2 µm	±5 µm, ±3 µm	±10 µm	±5 µm
<b>Measuring lengths ML</b>	Up to 4240 mm	Up to 28 040 mm <sup>5)</sup>	Up to 3040 mm	Up to 3040 mm		Up to 30 040 mm <sup>4)</sup>
<b>Reference mark</b>	—		One or distance-coded; LS 6xxC: distance-coded			

<sup>1)</sup> Also available with functional safety

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

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

<sup>4)</sup> Up to ML 72 040 mm upon request

<sup>5)</sup> Larger measuring lengths with TNC 640 upon request

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# 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 requiring any previous traverse. 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**.

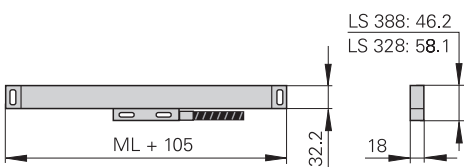
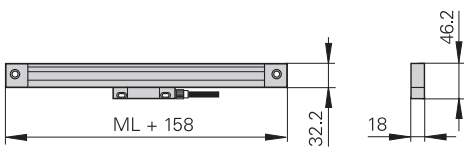
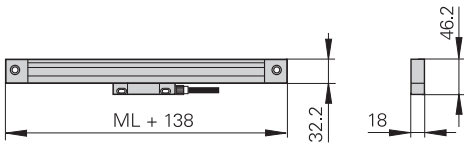
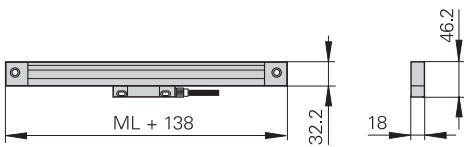
The **LS 300** series incremental linear encoders are used for simple positioning tasks, for example on **manual machine tools**.

- LC 400 series**
- Absolute position measurement
  - Defined thermal behavior
  - Single-field scanning

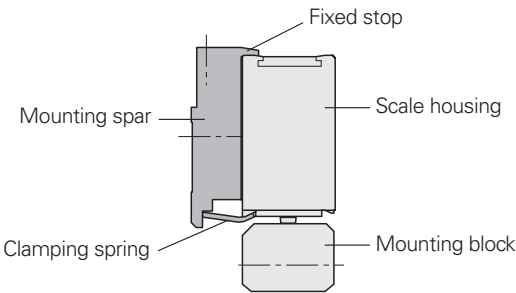
- LS 400 series**
- Incremental position measurement
  - Defined thermal behavior
  - Single-field scanning

- LF 485**
- Incremental position measurement
  - Very high repeatability
  - Thermal behavior similar to steel or cast iron
  - Single-field scanning

- LS 300 series**
- Incremental position measurement
  - 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.



	Absolute LC 415 <sup>1)</sup> /LC 485 LC 495 F/M/P/S <sup>1)</sup>	Incremental LF 485	LS 487 LS 477	LS 388 C LS 328 C
<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: Fanuc αi/ Mitsubishi/ Panasonic/ DRIVE-CLiQ	~ 1 V <sub>PP</sub>	LS 487: ~ 1 V <sub>PP</sub> LS 477: □ □ TTL <sup>2)</sup>	LS 388 C: ~ 1 V <sub>PP</sub> LS 328 C: □ □ TTL
Signal period	LC 485: 20 µm	4 µm	LS 487: 20 µm	LS 388 C: 20 µm
<b>Accuracy grade</b>	±5 µm, ±3 µm	±5 µm, ±3 µm		±10 µm
<b>Measuring 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> Also available with functional safety  
<sup>2)</sup> 5/10/20-fold integrated interpolation  
<sup>3)</sup> Over ML 1240 mm with mounting spar or clamping elements

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# LIP, LIF exposed linear encoders

For very high accuracy

The exposed linear encoders of the **LIP** and **LIF** design 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 481 V and LIP 481 V (for high vacuum, down to 10<sup>-7</sup> bar) and LIP 481 U (for ultrahigh vacuum, down to 10<sup>-11</sup> bar).

## LIP 300 series

- Highest resolutions, with measuring steps of down to < 1 nm
- Very high repeatability through an extremely fine signal period
- Defined thermal behavior thanks to a measuring standard on Zerodur glass ceramic scale

## LIP 200 series

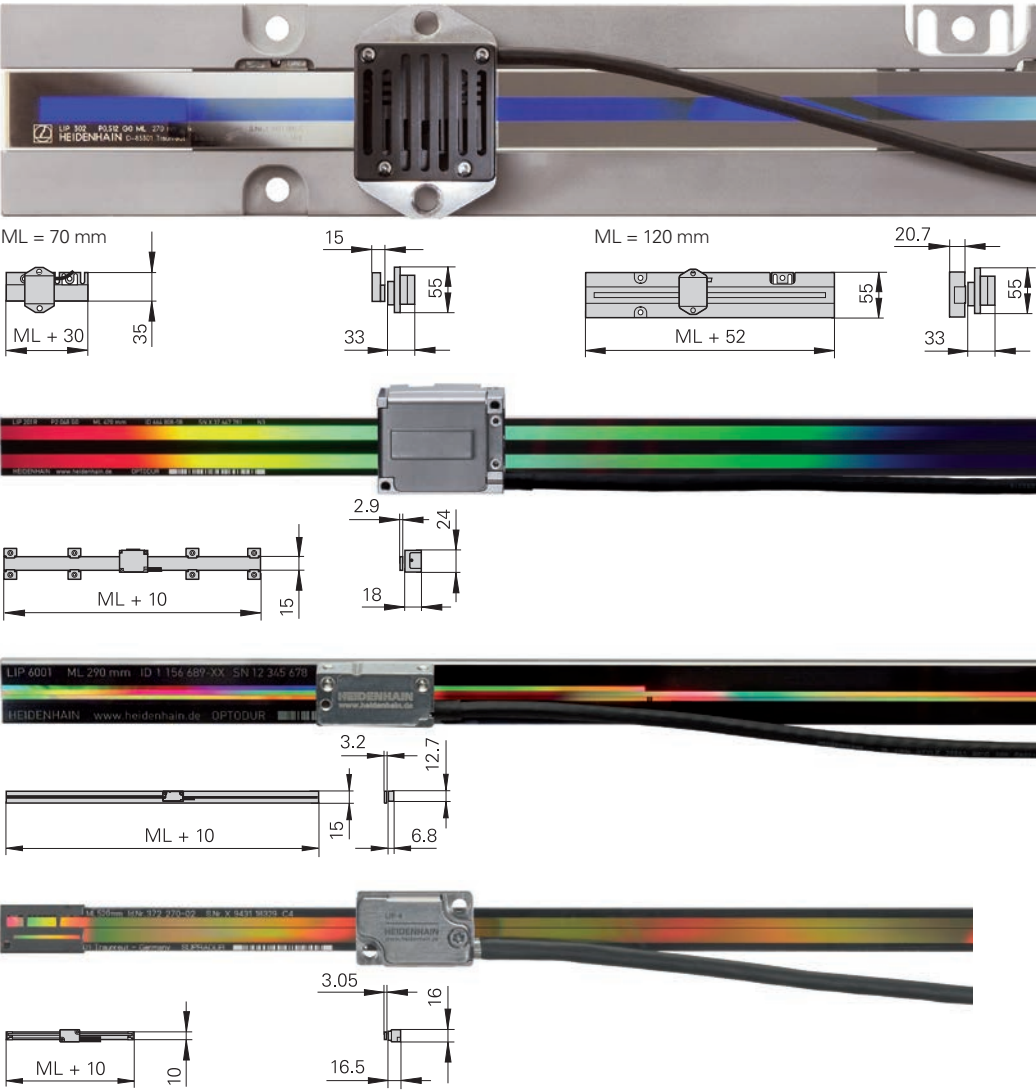
- Very high repeatability with compact dimensions
- Measuring lengths of up to 3040 mm
- Measuring steps of down to < 1 nm
- Defined thermal behavior thanks to a measuring standard on Zerodur glass ceramic scale

## LIP 6000 series

- For highly dynamic applications
- For limited installation space
- Measuring steps of down to 1 nm
- Position detection through limit switches and homing track

## LIF 400 series

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



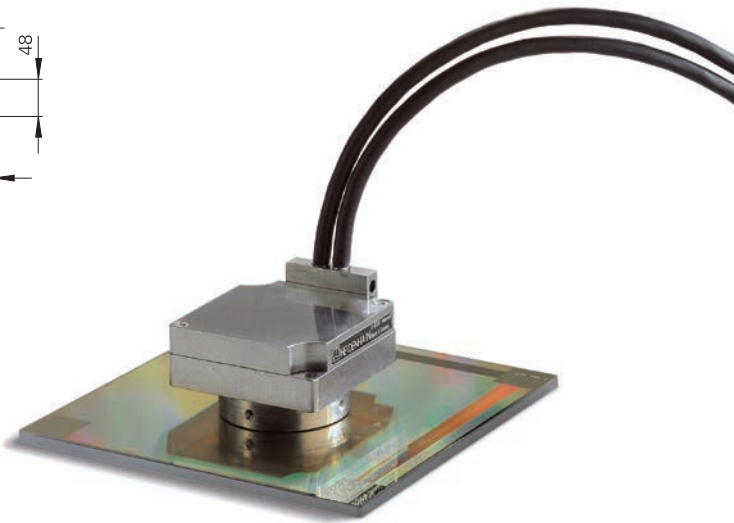
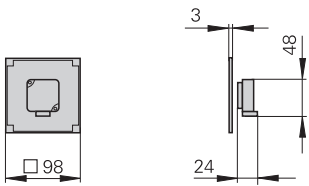
# PP exposed linear encoders

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



	Incremental LIP 382	LIP 281 LIP 211	LIP 6081 LIP 6071	LIF 481 LIF 471
<b>Measuring standard</b>	DIADUR phase grating on Zerodur glass ceramic	OPTODUR phase grating on Zerodur glass ceramic	OPTODUR phase grating on glass or Zerodur glass ceramic	SUPRADUR phase grating on glass or Zerodur glass ceramic
Grating period	0.512 µm	2.048 µm	8 µm	8 µm
<b>Interface</b>	~ 1 V <sub>PP</sub>	LIP 281: ~ 1 V <sub>PP</sub> LIP 211: EnDat 2.2 <sup>1)</sup>	LIP 6081: ~ 1 V <sub>PP</sub> LIP 6071: TTL	LIF 481: ~ 1 V <sub>PP</sub> LIF 471: TTL
Signal period	0.128 µm	LIP 281: 0.512 µm	LIP 6081: 4 µm	LIF 481: 4 µm
<b>Accuracy grade</b>	±0.5 µm	±1 µm    ±3 µm	±1 µm (only for Zerodur)    ±3 µm	±1 µm (only for Zerodur)    ±3 µm
<b>Baseline error</b>	≤ ±0.075 µm/5 mm	≤ ±0.125 µm/5 mm	≤ ±0.175 µm/5 mm	≤ ±0.225 µm/5 mm
<b>Interpolation error</b> <sup>2)</sup>	±0.01 nm	±0.4 nm	±4 nm	±12 nm
<b>Measuring lengths ML</b>	70 mm to 270 mm	20 mm to 1020 mm    370 mm to 3040 mm	20 mm to 1020 mm    20 mm to 3040 mm	70 mm to 1020 mm    70 mm to 1640 mm
<b>Reference mark</b>	None	One	One	One

<sup>1)</sup> Absolute position value after scanning the reference mark

<sup>2)</sup> Only with encoders with 1 V<sub>PP</sub> or EnDat 2.2 interface

	Incremental PP 281
<b>Measuring standard</b>	DIADUR phase grating on glass
Grating period	8 µm
<b>Interface</b>	~ 1 V <sub>PP</sub>
Signal period	4 µm
<b>Accuracy grade</b>	±2 µm
<b>Interpolation error</b>	±12 nm
<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** of up to 10 m/s and **large measuring lengths** of up to 30 m.

The **LIC** encoders make **absolute position measurement** possible over measuring lengths of 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

There are **various possibilities for easy mounting** of the LIC and LIDA encoders:

**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 pulled through aluminum extrusions 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 pulled through aluminum extrusions and fastened 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
- Also available with functional safety

**LIC 4100 series**

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

**LIP 400 series**

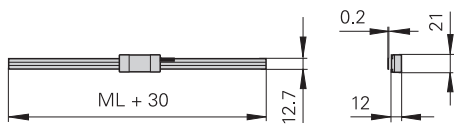
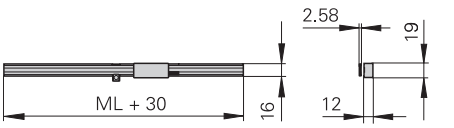
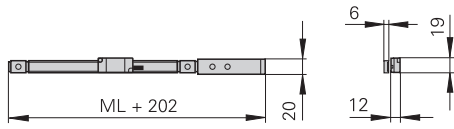
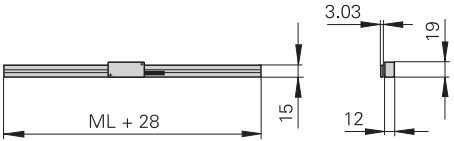
- Large measuring lengths of up to 30 m
- Various mounting options
- Limit switches

**LIC 2100 series**

- Absolute position measurement
- Large mounting tolerance
- For simple applications

**LIP 200 series**

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



	<b>Absolute</b> LIC 4113 LIC 4193	LIC 4115 LIC 4195	LIC 4117 LIC 4197	LIC 4119 <sup>1)</sup> LIC 4199	<b>Incremental</b> LIDA 483 LIDA 473	LIDA 485 LIDA 475	LIDA 487 LIDA 477	LIDA 489 LIDA 479	<b>Incremental</b> LIDA 287 LIDA 277	LIDA 289 LIDA 279	<b>Absolute</b> LIC 2117 LIC 2197	LIC 2119 LIC 2199
<b>Measuring standard</b>	METALLUR graduation on glass ceramic or glass				METALLUR graduation on glass ceramic or glass				Steel scale tape			
Grating period	40 µm				20 µm				200 µm			
<b>Interface</b>	LIC 411x: EnDat 2.2 LIC 419x: Fanuc $\alpha$ /Mitsubishi/Panasonic/Yaskawa				LIDA 48x: $\sim 1 V_{PP}$ LIDA 47x: $\square$ TTL <sup>2)</sup>				LIDA 28x: $\sim 1 V_{PP}$ LIDA 27x: $\square$ TTL <sup>2)</sup>			
Signal period	–				LIDA 48x: 20 µm				LIDA 28x: 200 µm			
<b>Accuracy grade</b>	$\pm 3 \mu\text{m}$ ; $\pm 5 \mu\text{m}$				$\pm 1 \mu\text{m}$ <sup>4)</sup> ; $\pm 3 \mu\text{m}$ ; $\pm 5 \mu\text{m}$				$\pm 15 \mu\text{m}$			
<b>Baseline error</b>	$\leq \pm 0.275 \mu\text{m}/10 \text{ mm}$				$\leq \pm 0.275 \mu\text{m}/10 \text{ mm}$				–			
<b>Interpolation error<sup>5)</sup></b>	$\pm 20 \text{ nm}$				$\pm 45 \text{ nm}$				$\pm 2 \mu\text{m}$			
<b>Measuring lengths ML</b>	240 mm to 3040 mm				240 mm to 3040 mm				Scale tape from the roll 3 m/5 m/10 m			
<b>Reference mark</b>	–				One or distance-coded				Selectable every 100 mm			

<sup>1)</sup> Also available with functional safety      <sup>2)</sup> Up to 100-fold integrated interpolation ( LIDA 47x also 5-fold)  
<sup>3)</sup> Up to measuring length of 1020 mm or 1040 mm

<sup>4)</sup> Only for Robax glass ceramic up to ML 1640 mm

<sup>5)</sup> Only with encoders with 1 V<sub>PP</sub> or EnDat 2.2 interface



# 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 of 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, and quality control. They are also used 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.

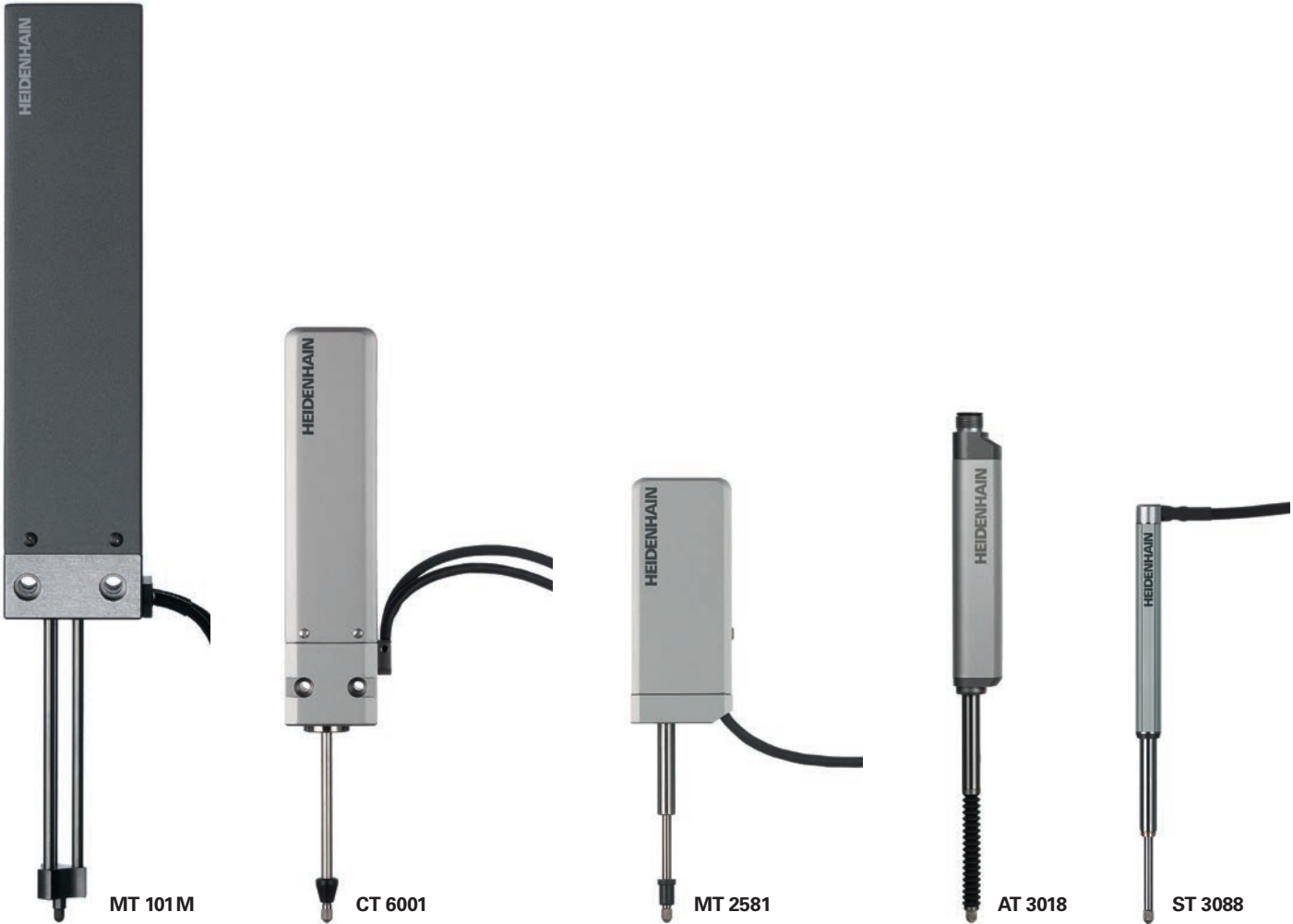
Length gauges with plunger actuation by **coupling** have no plunger drive. The freely movable plunger is connected by a separate coupling with the moving machine element.

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**
- Online diagnostics
  - Protection up to IP67
  - Absolute scanning
- HEIDENHAIN-CERTO**
- For highest accuracy
  - Low thermal expansion through thermally invariant materials
  - High-precision ball bearing guide
- HEIDENHAIN-METRO**  
MT 1200 and MT 2500
- High repeatability
  - Various gauging force variants
  - Various possibilities for plunger actuation
- HEIDENHAIN-METRO**  
MT 60 and MT 101
- Large measuring ranges
  - Plunger actuation by motor or coupling
  - Ball-bush guided plunger
- HEIDENHAIN-SPECTO**
- Exceptionally compact dimensions
  - Protection up to IP67
  - Especially durable ball-bush guide
  - Variant for harsh ambient conditions



	<i>Absolute</i> AT 1218 AT 1217	AT 3018 AT 3017	<i>Incremental</i> CT 2501 CT 2502	CT 6001 CT 6002	MT 1281 MT 1287	MT 1271	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	
Measuring standard	DIADUR glass scale		DIADUR phase grating on Zerodur glass ceramic Coefficient of linear expansion: $\alpha_{\text{therm}} = (0\pm0.1) \cdot 10^{-6} \text{ K}^{-1}$						DIADUR graduation on glass ceramic		DIADUR glass scale				
Grating period	188.4 $\mu\text{m}$		4 $\mu\text{m}$		4 $\mu\text{m}$				10 $\mu\text{m}$		20 $\mu\text{m}$				
Interface	EnDat 2.2		$\sim 11 \text{ }\mu\text{A}_{\text{PP}}$		$\sim 1 \text{ V}_{\text{PP}}$	$\square\text{TTL}^{(3)}$		$\sim 1 \text{ V}_{\text{PP}}$	$\square\text{TTL}^{(3)}$	$\sim 11 \text{ }\mu\text{A}_{\text{PP}}$		$\sim 1 \text{ V}_{\text{PP}}$	$\square\text{TTL}^{(3)}$	$\sim 1 \text{ V}_{\text{PP}}$	$\square\text{TTL}^{(3)}$
Signal period	–		2 $\mu\text{m}$			–	2 $\mu\text{m}$	–	10 $\mu\text{m}$		20 $\mu\text{m}$	–	20 $\mu\text{m}$	–	
System accuracy	$\pm 1 \text{ }\mu\text{m}$	$\pm 2 \text{ }\mu\text{m}$	$\pm 0.1 \text{ }\mu\text{m}^{(1)}$ $\pm 0.03 \text{ }\mu\text{m}^{(2)}$	$\pm 0.1 \text{ }\mu\text{m}^{(1)}$ $\pm 0.05 \text{ }\mu\text{m}^{(2)}$	$\pm 0.2 \text{ }\mu\text{m}$				$\pm 0.5 \text{ }\mu\text{m}$	$\pm 1 \text{ }\mu\text{m}$	$\pm 1 \text{ }\mu\text{m}$				
Repeatability	0.4 $\mu\text{m}$	0.8 $\mu\text{m}$	0.02 $\mu\text{m}$	0.03 $\mu\text{m}$			0.09 $\mu\text{m}$		0.06 $\mu\text{m}$	0.04 $\mu\text{m}$	0.25 $\mu\text{m}$		0.7 $\mu\text{m}$		
Measuring range	12 mm	30 mm	25 mm	60 mm	12 mm			25 mm		60 mm	100 mm	12 mm		30 mm	
Plunger actuation	<i>AT xx18</i> : by measured object <i>AT xx17</i> : pneumatic		<i>CT xx01</i> : with motor <i>CT xx02</i> : by coupling		<i>MT xxx1</i> : cable-type lifter or free <i>MT xx87</i> : pneumatic				<i>MT xxM</i> : with motor <i>MT xxK</i> : by coupling		<i>ST xxx8</i> : by measured object <i>ST xxx7</i> : pneumatic				

<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> 5/10-fold integrated interpolation

Angle encoders

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

- Line counts: typically 9000 to 180000
- Accuracy: from ±5" to ±0.4"
- Measuring steps: as fine as 0.000 01° 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 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, elevators, and handling devices, as well as various types of measuring, testing, and inspection devices.

- Line counts: typically 16 to 5000
- Accuracy grades: to ±10" (depending on the line count, corresponding to ±1/20 of the grating period)
- Measuring steps: as fine as 0.000 01°. Particularly for photoelectric rotary encoders, the high quality of the sinusoidal incremental signals permits high interpolation factors for digital speed control.

Mounting variants

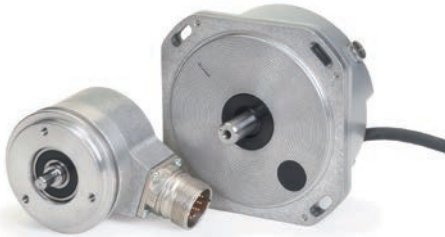
In angle encoders and rotary encoders with integral bearing and **stator coupling**, the graduated disk of the encoder is connected directly to the shaft to be measured. The scanning unit is guided on the shaft via ball bearings, supported by the stator coupling. As a result, during angular acceleration of the shaft, the stator coupling must absorb only that torque resulting from friction in the bearing. 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 mounting
  - Short overall length
  - High natural frequency of the coupling
  - Hollow through shaft is possible

Angle encoders and rotary encoders with integral bearings 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:

- Little space required
- 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 reference point 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, and 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.

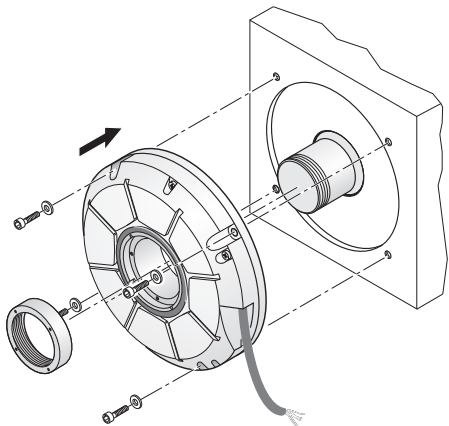
Sealed angle encoders		Series	Page
With integral bearing and integrated stator coupling	Absolute (singleturn)/Incremental	RCN, RON, RPN	20
With integral bearing	Absolute (singleturn)/Incremental	ROC, ROD, RON	22
Angle encoder modules		MRP, SRP	24
Modular angle encoders			
Without integral bearing, with optical scanning	Absolute (singleturn)/Incremental	ECA, ERA, ERO, ERP	26
Without integral bearing, with magnetic scanning	Incremental	ERM	32
Rotary encoders			
With integral bearing, for mounting by stator coupling	Absolute (singleturn/multiturn) Incremental	ECN, EQN ERN	34
With integral bearing, for separate shaft coupling	Absolute (singleturn/multiturn) Incremental	ROC, ROQ ROD	38
Without integral bearing	Absolute (singleturn/multiturn) Incremental	ECI, EQI, EBI ERO	40



# RCN, RON, RPN sealed angle encoders

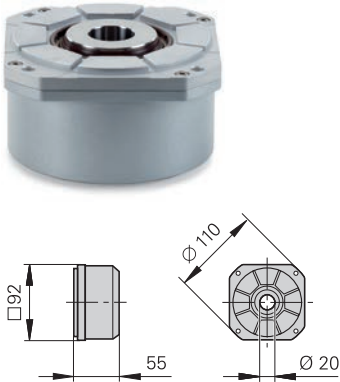
## With integral bearing and integrated stator coupling

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 encoders for high-precision applications such as rotary tables and tilting axes. The measuring standard is usually a circular scale with DIADUR graduation. For the encoders 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.

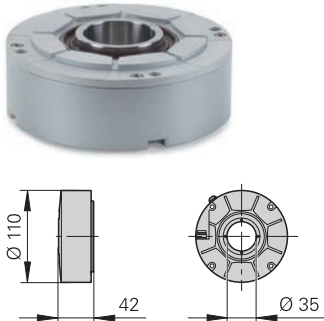


- Features of the **RCN 2000, RCN 5000, RCN 6000,** and **RCN 8000** series of angle encoders:
- **Optimized scanning** with large scanning surface for absolute track (serial code structure) and incremental track (single-field scanning and optical filtering)
  - **Large mounting tolerances** thanks to 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
  - Possibility of mechanical fault exclusion against loosening of the encoder-to-drive connection

- RCN 2000 and RON 200 series**
- Compact dimensions
  - Sturdy design
  - Typically used with rotary tables, tilting tables, for positioning and speed control



- 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 of up to Ø 100 mm
  - System accuracies: ±2" and ±1"
  - Typically used on rotary and angle measuring tables, indexing heads, measuring setups, image scanners, etc.

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



- RCN 6000 series**
- Very large hollow shaft
  - System accuracy: ±2"
  - Typically used with rotary tables, tilting tables, and direct drive motors



	<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 αi	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/revolution	16384	–			18000 <sup>3)</sup> 90000/180000 <sup>4)</sup>	18000
<b>System accuracy</b>	RCN 23x0: ±5"; RCN 25x0: ±2.5"				±5"	±5"; ±2.5"
<b>Mech. permissible speed</b>	≤ 1500 rpm				≤ 3000 rpm	

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

	<b>Absolute</b> RCN 8380 RCN 8580	RCN 8310 <sup>1)</sup> RCN 8510 <sup>1)</sup>	RCN 8390F RCN 8590F	RCN 8390M RCN 8590M	<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/revolution	32 768	–	–	–	18000, 36000
<b>System accuracy</b>	RCN 83x0: ±2"; RCN 85x0: ±1"				±2"    ±1"
<b>Mech. permissible speed</b>	≤ 500 rpm				≤ 1000 rpm

	<b>Absolute</b> RCN 6310 <sup>1)</sup>	RCN 6390F	RCN 6390M
<b>Interface</b>	EnDat 2.2	Fanuc Serial Interface $\alpha$ i interface	Mitsubishi high speed interface
Position values/revolution	268 435 456 (28 bits)		
<b>System accuracy</b>	±2.0"		
<b>Mech. permissible speed</b>	≤ 200 rpm <sup>5)</sup>		

<sup>1)</sup> Also available with functional safety  
<sup>2)</sup> DRIVE-CLiQ via EIB; PROFIBUS DP via Gateway  
<sup>3)</sup> Integrated 2-fold interpolation

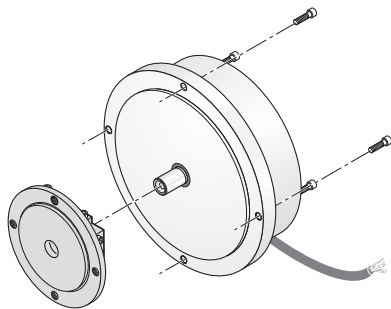
<sup>4)</sup> Integrated 5/10-fold interpolation  
<sup>5)</sup> Higher speeds possible depending on the operating temperature  
DRIVE-CLiQ is a registered trademark of Siemens AG.

# ROC, ROD, RON sealed angle encoders

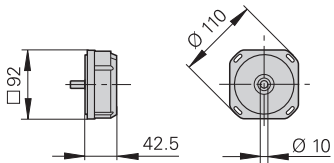
## With integral bearing

**ROC** and **ROD** angle encoders with solid shaft for separate shaft coupling are particularly suited to applications where higher shaft speeds and larger mounting tolerances are required. The precision shaft couplings allow up to ±1 mm of axial motion.

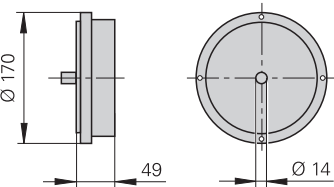
ROC and ROD angle encoders feature a DIADUR circular scale as measuring standard. For angle encoders with separate shaft coupling, the angular measuring error caused by the shaft coupling must be added to determine the system accuracy.



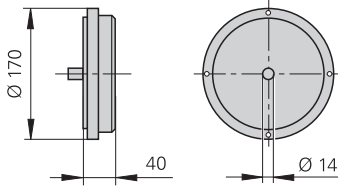
- For separate shaft coupling**  
**ROC 2000 and ROD 200**
- Compact dimensions
  - Sturdy design
  - Typically used with rotary tables, tilting tables, for positioning and synchronization monitoring



- For separate shaft coupling**  
**ROC 7000, ROD 780, and ROD 880**
- High accuracy  
  **ROC 7000, ROD 780: ±2"**  
  **ROD 880: ±1"**
  - Ideal for angle measurement on high-precision rotary tables, indexing heads, or measuring machines

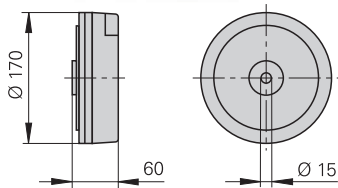


ROD 780, ROD 880



ROC 7000

- For highly accurate applications**  
**RON 905**
- Very high system accuracy of ±0.4"
  - Used with high-accuracy measuring devices and for the inspection of measuring equipment



	Absolute				Incremental		
	ROC 2310	ROC 2380	ROC 2390F	ROC 2390M	ROD 220	ROD 270	ROD 280
Interface	EnDat 2.2 <sup>4)</sup>	EnDat 2.2 <sup>4)</sup> ~ 1 V <sub>PP</sub>	Fanuc $\alpha$ i	Mitsubishi	TTL	TTL	~ 1 V <sub>PP</sub>
Signal periods/revolution	16384				18000 <sup>2)</sup>	180000 <sup>3)</sup>	18000
System accuracy <sup>1)</sup>	±5"						
Mech. permissible speed	≤ 3000 rpm				≤ 10000 rpm		

<sup>1)</sup> Without shaft coupling  
<sup>2)</sup> 2-fold integrated interpolation  
<sup>3)</sup> 10-fold integrated interpolation  
<sup>4)</sup> DRIVE-CLiQ via EIB; PROFIBUS via Gateway

	Absolute				Incremental	
	ROC 7310	ROC 7380	ROC 7390F	ROC 7390M	ROD 780	ROD 880
Interface	EnDat 2.2 <sup>2)</sup>	EnDat 2.2 <sup>2)</sup> ~ 1 V <sub>PP</sub>	Fanuc $\alpha$ i	Mitsubishi	~ 1 V <sub>PP</sub>	
Signal periods/revolution	16384				18000, 36000	36000
System accuracy <sup>1)</sup>	±2"				±2"	±1"
Mech. permissible speed	≤ 3000 rpm				≤ 1000 rpm	

<sup>1)</sup> Without shaft coupling  
<sup>2)</sup> DRIVE-CLiQ via EIB; PROFIBUS via Gateway

	Incremental
	RON 905
Interface	~ 11 $\mu$ A <sub>PP</sub>
Signal periods/revolution	36000
System accuracy	±0.4"
Mech. permissible speed	≤ 100 rpm



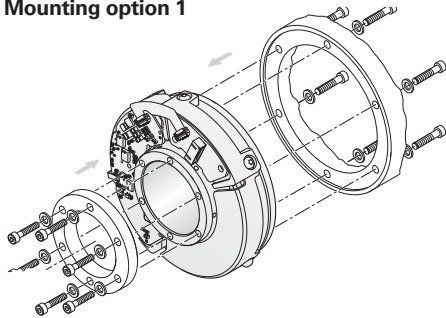
# MRP, SRP angle encoder modules

## Assemblies for high-precision rotary axes

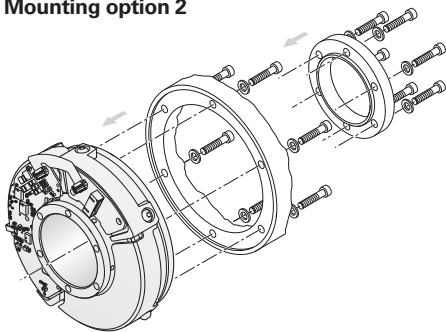
### MRP angle encoder module: combination of angle encoder and bearing

Angle encoder modules from HEIDENHAIN are optimally matched combinations of angle encoders and high-precision bearings. They boast high measuring and bearing accuracy, very high resolution, exceptional repeatability, and low starting torque for smooth motion. Their self-contained design with tested and pre-specified characteristics simplifies handling and mounting.

Mounting option 1



Mounting option 2



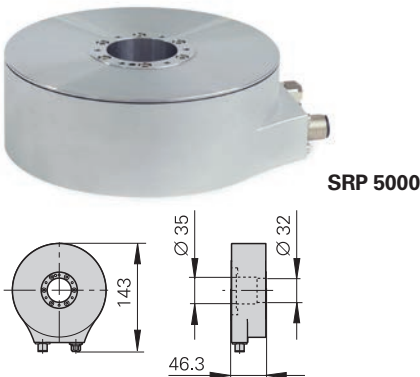
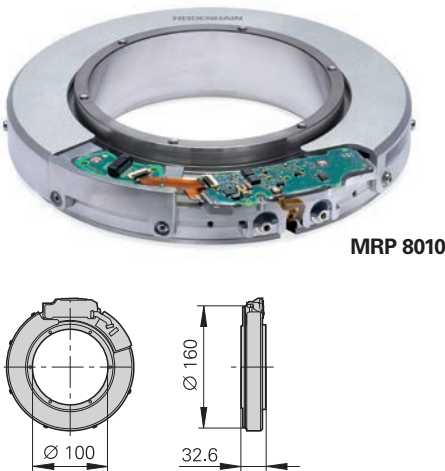
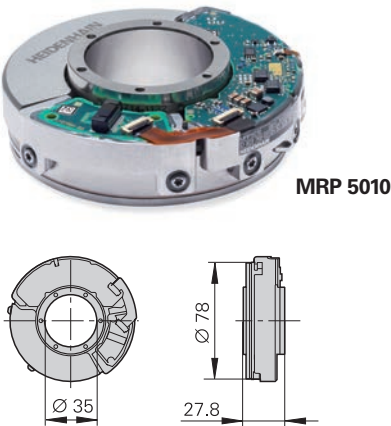
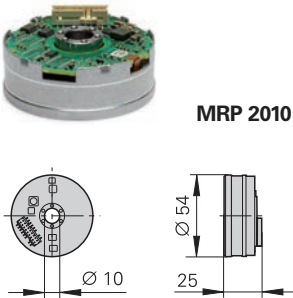
### SRP angle encoder module: combination of angle encoder, bearing and motor

SRP angle encoder modules are additionally equipped with an integrated torque motor. They combine a motor, precision bearing, and encoder with very high accuracy in one compact system. The torque motor with its very low cogging torque enables extraordinarily smooth motion control. Neither disruptive cogging torques nor radial forces impair the high guideway accuracy of the bearing.

### MRP 2000 series

Angle encoder modules with integrated encoder and bearing

- Particularly compact dimensions
- High measuring and bearing accuracy
- Hollow shaft Ø 10 mm



### MRP 5000 series

Angle encoder modules with integrated encoder and bearing

- Compact dimensions
- High measuring and bearing accuracy
- Hollow shaft Ø 35 mm

### MRP 8000 series

Angle encoder modules with integrated encoder and bearing

- Compact dimensions
- High measuring and bearing accuracy
- Hollow shaft Ø 100 mm

### SRP 5000 series

Angle encoder modules with integrated encoder, bearing, and torque motor

- Compact dimensions
- Torque motor with low cogging torque
- Peak torque: 2.70 Nm
- Rated torque: 0.385 Nm

	Incremental MRP 2080	Absolute MRP 2010
Interface	$\sim 1 V_{PP}$	EnDat 2.2
Signal periods/revolution	2048	
System accuracy	$\pm 7''$	
Maximum permissible axial load	50 N (centered load, purely static, without additional vibrations or shock loading)	
Radial guideway accuracy	Measured at distance h = 52 mm from the ball race: $\leq 0.60 \mu m$	
Wobble of the axis	2.5''	

	Incremental MRP 5080	Absolute MRP 5010
Interface	$\sim 1 V_{PP}$	EnDat 2.2
Signal periods/revolution	30 000	16 384
System accuracy	$\pm 2.5''$ or $\pm 5''$	
Maximum permissible axial load	200 N (centered load, purely static, without additional vibrations or shock loading)	
Radial guideway accuracy	Measured at distance h = 55 mm: $\leq 0.20 \mu m$ (without load)	
Wobble of the axis	0.7''	

	Incremental MRP 8080	Absolute MRP 8010
Interface	$\sim 1 V_{PP}$	EnDat 2.2
Signal periods/revolution	63 000	32 768
System accuracy	$\pm 1''$ or $\pm 2''$	
Maximum permissible axial load	300 N (centered load, purely static, without additional vibrations or shock loading)	
Radial guideway accuracy	Measured at distance h = 124 mm: $\leq 0.15 \mu m$	
Wobble of the axis	0.5''	

	Incremental SRP 5080	Absolute SRP 5010
Interface	$\sim 1 V_{PP}$	EnDat 2.2
Signal periods/revolution	30 000	16 384
System accuracy	$\pm 2.5''$ or $\pm 5''$	
Maximum permissible axial load	200 N (centered load, purely static, without additional vibrations or shock loading)	
Radial guideway accuracy	Measured at distance h = 55 mm: $\leq 0.20 \mu m$ (without load)	
Wobble of the axis	0.7''	

# ERP, ERO modular angle encoders

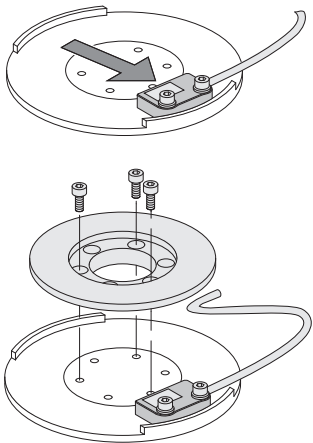
## Without integral bearing, with optical scanning

The HEIDENHAIN **ERP** and **ERO** angle encoders without integral bearing operate without friction and use a circular glass scale with hub as the graduation carrier. They are characterized by their low weight and compact dimensions. They thus permit high accuracies and are designed 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 interferential scanning principle serves as the basis for the high accuracy of the **ERP** encoders. This makes them particularly attractive for high-precision angle measuring tables and precision devices in angular metrology. Additionally, the HSP 1.0 signal stabilization feature makes the encoders highly resistant to environmental factors.

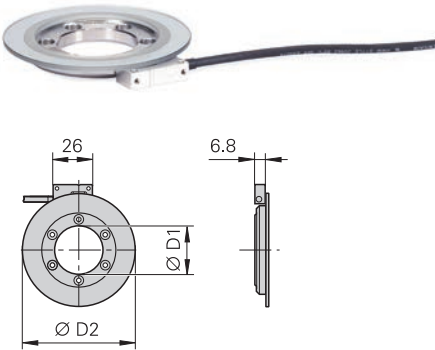
Applications for the **ERO** are found in metrology, in compact rotary tables, and in precise, highly dynamic drives.



ERO 6000

### ERP 1000 series

- Very high resolution and accuracy
- Small mass, low mass moment of inertia
- Very flat design
- Circular scale available as full circle or segment



### ERO 2000 series

- Very compact dimensions
- Small mass, low mass moment of inertia
- For highly dynamic applications



### ERO 6000 series

- Very flat design
- High system accuracy
- Simple mounting



### ERO 6100 series

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



	Incremental ERP 1070 ERP 1080			
Interface	ERP 1070: □ TTL; ERP 1080: ~ 1 V <sub>PP</sub>			
Signal periods/revolution	23 000	30 000	50 000	63 000
Accuracy of graduation	±4"	±3"	±1.8"	±1.5"; ±0.9"
Inside diameter D1	13 mm	32 mm	62 mm	104 mm
Outside diameter D2	57 mm	75 mm	109 mm	151 mm
Mech. permissible speed	≤ 2600 rpm	≤ 2000 rpm	≤ 1200 rpm	≤ 950 rpm

	Incremental ERO 2080	ERO 6070 ERO 6080		ERO 6180
Interface	~ 1 V <sub>PP</sub>	ERO 6070: □ TTL; ERO 6080: ~ 1 V <sub>PP</sub>		~ 1 V <sub>PP</sub>
Signal periods/revolution	4096	9000	18000	4096
Accuracy of graduation	±8"	±3"	±2"	±10"
Inside diameter D1	5 mm	25 mm	95 mm	41 mm
Outside diameter D2	30 mm	71 mm	150 mm	70 mm
Mech. permissible speed	≤ 14 000 rpm	≤ 1600 rpm	≤ 800 rpm	≤ 3500 rpm



# ECA, ERA modular angle encoders

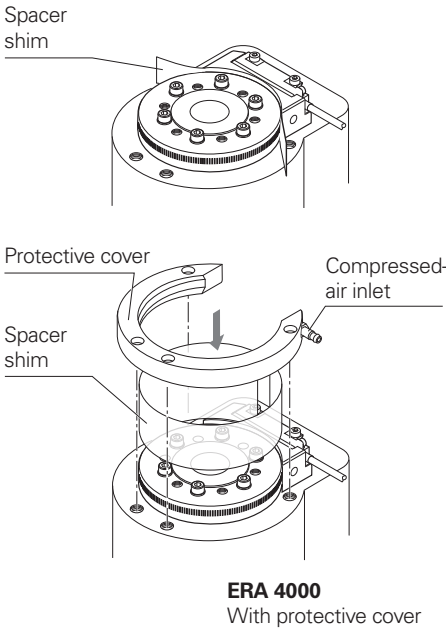
## Without integral bearing, with optical scanning

The **ECA** 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.

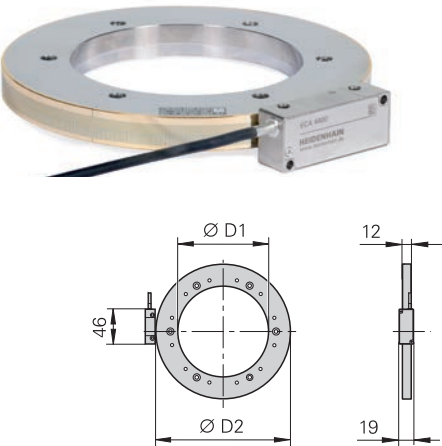
The **ECA** and **ERA** angle encoders feature a sturdy steel scale drum and are suited for high shaft speeds of up to 10 000 rpm. They are typically found on fast running spindles, rotary tables, and tilting axes.

The ECA 4000 V angle encoders are suitable for vacuum applications in high vacuum (down to 10<sup>-7</sup> bar).



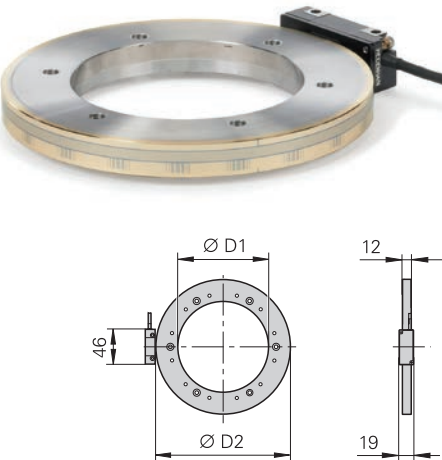
### ECA 4400 series

- High accuracy
- Sturdy design with steel scale drum and METALLUR graduation
- Various drum versions
  - ECA 4xx0*: with centering collar
  - ECA 4xx2*: with 3-point centering



### ERA 4000 series

- High shaft speeds of up to 10000 rpm
- Sturdy design with steel scale drum and METALLUR graduation
- Axial motion of measured shaft permissible up to ± 0.5 mm
- The ERA 4480 C is available with larger diameters or as versions with protective cover
- Various drum versions
  - ERA 4xx0*: with centering collar
  - ERA 4xx2*: with 3-point centering



	<b>Absolute</b> <b>ECA 4412</b> <sup>1)</sup> <b>ECA 4492 F</b> <b>ECA 4492 M</b> <b>ECA 4492 P</b>								
<b>Interface</b>	<i>ECA 4412</i> : EnDat 2.2; <i>ECA 4492 F</i> : Fanuc $\alpha$ i; <i>ECA 4492 M</i> : Mitsubishi; <i>ECA 4492 P</i> : Panasonic								
Signal periods/revolution	8195	10010	11 616	14003	16379	19998	25993	37994	44000
<b>Accuracy of graduation</b>	±3"	±2.5"	±2.8"	±2"	±1.9"	±1.8"	±1.7"	±1.5"	±1.5"
<b>Inside diameter D1</b>	70 mm	80 mm	120 mm	120 mm	150/185 mm	180/210 mm	270 mm	425 mm	512 mm
<b>Outside diameter D2</b>	104.63 mm	127.64 mm	148.2 mm	178.55 mm	208.89 mm	254.93 mm	331.31 mm	484.07 mm	560.46 mm
<b>Mechanically permissible speed</b>	≤ 8500 rpm	≤ 6250 rpm	≤ 5250 rpm	≤ 4500 rpm	≤ 4250 rpm	≤ 3250 rpm	≤ 2500 rpm	≤ 1800 rpm	≤ 1500 rpm

<sup>1)</sup> Also available with functional safety

	<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								
<b>Interface</b>	~ 1 V <sub>PP</sub>								
Signal periods/revolution	<i>ERA 4280 C</i> 12000 6000 3000	16384 8192 4096	20000 10000 5000	28000 14000 7000	32768 16384 8192	40000 20000 10000	52000 26000 13000	– 38000 –	– 44000 –
<b>Accuracy of graduation</b>	±5"	±3.7"	±3"	±2.5"				±2"	
<b>Inside diameter D1</b>	40 mm	70 mm	80 mm	120 mm	150 mm	180 mm	270 mm	425 mm	512 mm
<b>Outside diameter D2</b>	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
<b>Mechanically permissible speed</b>	≤ 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 brochure *Angle Encoders without Integral Bearings*

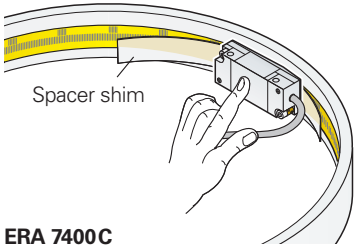
# ERA modular angle encoders

## Without integral bearing, with optical scanning

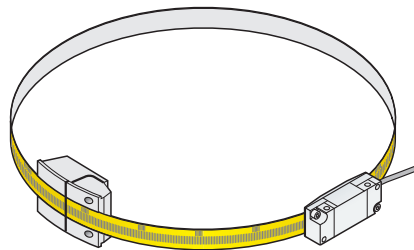
The HEIDENHAIN **ERA** angle encoders with steel scale tape as measuring standard function without integral bearings. They are intended for integration in machine elements or components. They are designed to meet the following requirements:

- Large hollow shaft diameters of up to 10 m
- No additional starting torque caused by rotary 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



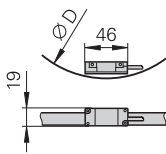
ERA 8400C

**ERA 7000 and ERA 8000 series**

- For very large diameters of up to 10 m
- METALLUR steel scale tape

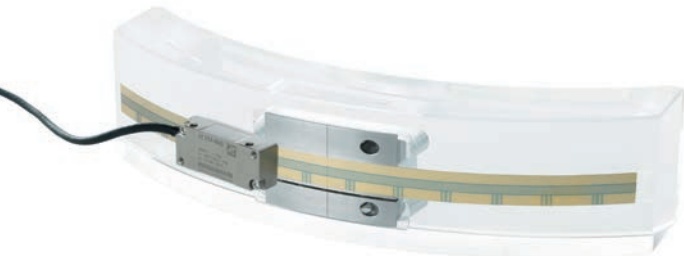
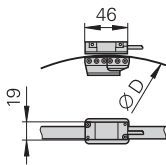
**ERA 7000 series**  
Scale tape is placed in a slot on the inside circumference of the machine element

- **ERA 7400C**: full-circle version
- **ERA 7401C**: segment version



**ERA 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



	Incremental ERA 7400C		
Interface	~ 1 V <sub>PP</sub> ; signal period 40 µm (on circumference)		
Signal periods/revolution	36 000	45 000	90 000
Accuracy of graduation	±3.9"	±3.2"	±1.6"
Accuracy of the scale tape	±3 µm per meter tape length		
Diameter D1	458.62 mm	573.20 mm	1146.10 mm
Mech. permissible speed	≤ 250 rpm		≤ 220 rpm

	Incremental ERA 8400C		
Interface	~ 1 V <sub>PP</sub> ; signal period 40 µm (on circumference)		
Signal periods/revolution	36 000	45 000	90 000
Accuracy of graduation	±4.7"	±3.9"	±1.9"
Accuracy of the scale tape	±3 µm per meter tape length		
Diameter D1	458.04 mm	572.63 mm	1145.73 mm
Mech. permissible speed	≤ 50 rpm		≤ 45 rpm



# ERM modular angle encoders

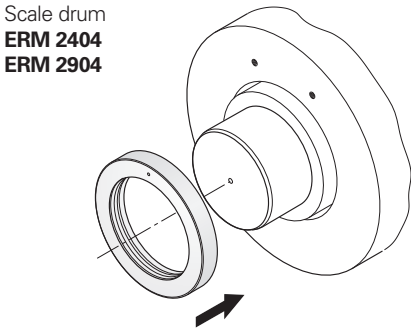
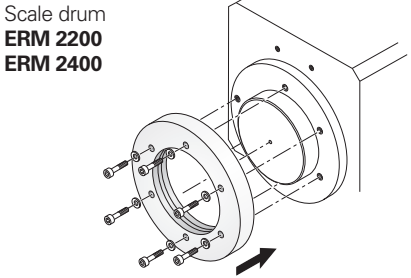
## Without integral bearing, with magnetic scanning

The **ERM** modular encoders from HEIDENHAIN with magnetic scanning 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.

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.

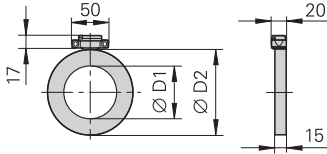
Typical fields of application include machines and equipment with **large hollow shaft diameters** in environments with large amounts of airborne particles and liquids, for example:

- Rotary and tilting axes for ERM 2280
- C axes on lathes for ERM 2410, ERM 2420 and ERM 2480
- Main spindles on milling machines for ERM 2484, ERM 2485 and ERM 2984



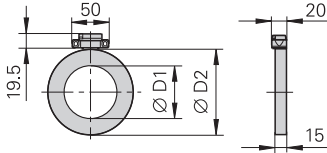
### ERM 2200 series

- High graduation accuracy
- Distance-coded reference marks
- Drum fastening with axial screws
- **ERM 2283**: small interpolation error, no reversal error



### ERM 2400 series

- Distance-coded reference marks are possible
- Drum fastening with axial screws
- Large selection of drum diameters

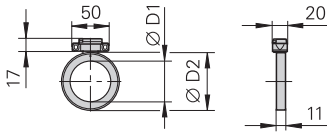


ERM 2480



### ERM 2484 and ERM 2984 series

- Especially compact dimensions for limited installation space
- High mechanically permissible shaft speeds and therefore particularly well suited for spindles
- Drum fastening by axial clamping



	<b>Incremental</b> <b>ERM 2280</b> (grating period $\approx 200\ \mu\text{m}$ ) <b>ERM 2283</b>								
Interface	$\sim 1\ \text{V}_{\text{PP}}$								
Signal periods/revolution	1200	1440	1800	2048	2400	2800	4096	5200	7200
Accuracy of graduation ERM 2280 ERM 2283	$\pm 10''$ $\pm 6.5''$	$\pm 8.5''$ $\pm 5.5''$	$\pm 7''$ $\pm 4.5''$	$\pm 6''$ $\pm 4''$	$\pm 5.5''$ $\pm 3.5''$	$\pm 5''$ $\pm 3''$	$\pm 3.5''$ $\pm 2''$	$\pm 3''$ $\pm 1.5''$	$\pm 2.5''$ —
Inside diameter D1	40 mm	55 mm	70 mm	80 mm	105 mm	130 mm	180 mm	260 mm	380 mm
Outside diameter D2	75.44 mm	90.53 mm	113.16 mm	128.75 mm	150.88 mm	176.03 mm	257.5 mm	326.9 mm	452.64 mm
Mech. permissible speed	$\leq 19\,000$ rpm	$\leq 18\,500$ rpm	$\leq 14\,500$ rpm	$\leq 13\,000$ rpm	$\leq 10\,500$ rpm	$\leq 9\,000$ rpm	$\leq 6\,000$ rpm	$\leq 4\,500$ rpm	$\leq 3\,000$ rpm

	<b>Incremental</b> <b>ERM 2410</b> (grating period $\approx 400\ \mu\text{m}$ ) <b>ERM 2420</b> <b>ERM 2480</b>								
Interface	ERM 2410: EnDat 2.2; ERM 2420: $\square$ TTL; ERM 2480: $\sim 1\ \text{V}_{\text{PP}}$								
Signal periods/revolution	600	720	900	1024	1200	1400	2048	2600	3600
Accuracy of graduation	$\pm 11''$	$\pm 10''$	$\pm 8''$	$\pm 7''$	$\pm 6''$	$\pm 5.5''$	$\pm 4''$	$\pm 3.5''$	$\pm 3''$
Inside diameter D1	40 mm	55 mm	70 mm	80 mm	105 mm	130 mm	180 mm	260 mm	380 mm
Outside diameter D2	75.44 mm	90.53 mm	113.16 mm	128.75 mm	150.88 mm	176.03 mm	257.5 mm	326.9 mm	452.64 mm
Mech. permissible speed	$\leq 19\,000$ rpm	$\leq 18\,500$ rpm	$\leq 14\,500$ rpm	$\leq 13\,000$ rpm	$\leq 10\,500$ rpm	$\leq 9\,000$ rpm	$\leq 6\,000$ rpm	$\leq 4\,500$ rpm	$\leq 3\,000$ rpm

	<b>Incremental</b> <b>ERM 2484</b> (grating period $\approx 400\ \mu\text{m}$ )				<b>ERM 2984</b> (grating period $\approx 1000\ \mu\text{m}$ )			
Interface	$\sim 1\ \text{V}_{\text{PP}}$							
Signal periods per rev.	512	600	900	1024	192	256	300	400
Accuracy of graduation	$\pm 17''$	$\pm 14''$	$\pm 10''$	$\pm 9''$	$\pm 68''$	$\pm 51''$	$\pm 44''$	$\pm 33''$
Inside diameter D1	40 mm	55 mm	80 mm	100 mm	40 mm	55 mm	60 mm	100 mm
Outside diameter D2	64.37 mm	75.44 mm	113.16 mm	128.75 mm	58.06 mm	77.41 mm	90.72 mm	120.96 mm
Mech. permissible speed	$\leq 42\,000$ rpm	$\leq 36\,000$ rpm	$\leq 22\,000$ rpm	$\leq 20\,000$ rpm	$\leq 47\,000$ rpm	$\leq 35\,000$ rpm	$\leq 29\,000$ rpm	$\leq 16\,000$ rpm

For other drum versions, please refer to our brochure *Modular Angle Encoders with Magnetic Scanning*

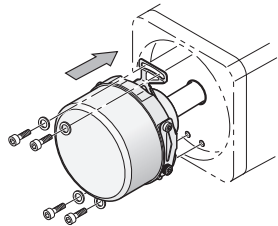
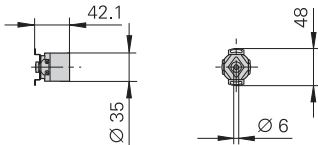
ECN, EQN, ERN rotary encoders

With integral bearing and mounted stator coupling  
IP64 protection

HEIDENHAIN **ECN**, **EQN**, and **ERN** rotary encoders with integral bearing and stator-mounted coupling 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 resulting from friction in the bearing. Rotary encoders with stator coupling therefore provide excellent dynamic performance and a high natural frequency.

ECN/EQN/ERN 1000 series

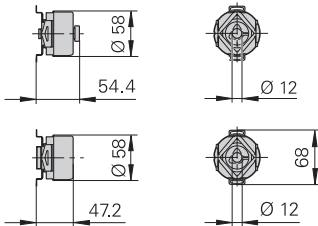
- Miniaturized version
- Blind hollow shaft with 6 mm inside diameter
- Housing outside diameter: 35 mm
- Typical natural frequency  $f_N$  of the encoder coupling: 1500 Hz
- **ERN 1023**: 1000 Hz
- Mechanically permissible speed:  $\leq 12000$  rpm



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

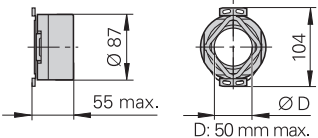
ECN/EQN/ERN 400 series

- Compact dimensions
- Blind hollow shaft or hollow through shaft with 8 mm, 10 mm, or 12 mm inside diameter
- Housing outside diameter: 58 mm
- Protection:  
IP67 at housing (IP66 with hollow through shaft)  
IP64 at shaft inlet (IP66 upon request)
- Typical natural frequency  $f_N$  of the encoder coupling: 1400 Hz (cable version)
- Mechanically permissible speed:  $\leq 12000$  rpm
- Fault exclusion of the mechanical coupling for functional safety available



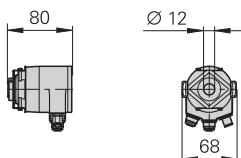
ECN/ERN 100 series

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



	Absolute ECN 1013	EQN 1025	ECN 1023 ECN 1023 S	EQN 1035 EQN 1035 S	Incremental ERN 1020	ERN 1030	ERN 1070	ERN 1080
Interface	EnDat 2.2 <sup>1)</sup> with $\sim 1$ V <sub>PP</sub> ; SSI		EnDat 2.2 <sup>1)</sup> ; DRIVE-CLiQ					$\sim 1$ V <sub>PP</sub>
Position values/revolution	8192 (13 bits)		8388608 (23 bits)		–			
Revolutions	–	4096 (12 bits)	–	4096 (12 bits)	–			
Line count	512		–		100 to 3600		1000/2500/3600	100 to 3600
Supply voltage	DC 3.6 V to 14 V; DC 4.75 V to 30 V		DC 3.6 V to 14 V; DC 10 V to 28.8 V		DC 5 V	DC 10 V to 30 V	DC 5 V	

	Absolute ECN 413	EQN 425		ECN 425 <sup>3)</sup> ECN 425 F ECN 425 M ECN 424 S <sup>3)</sup>	EQN 437 <sup>3)</sup> EQN 437 F EQN 435 M EQN 436 S <sup>3)</sup>	Incremental ERN 420 ERN 460	ERN 430	ERN 480
Interface	EnDat 2.2 <sup>1)</sup> with $\sim 1$ V <sub>PP</sub> ; SSI	PROFIBUS DP; PROFINET	EnDat 2.2 <sup>1)</sup> with $\sim 1$ V <sub>PP</sub> ; SSI	PROFIBUS DP; PROFINET	EnDat 2.2 <sup>1)</sup> ; Fanuc $\alpha$ i; Mitsubishi; DRIVE-CLiQ			$\sim 1$ V <sub>PP</sub>
Position values/revolution	8192 (13 bits)	8192 (13 bits)		<i>ECN 425, EQN 437:</i> 33554432 (25 bits) <i>ECN 424, EQN 436:</i> 16777216 (24 bits) <i>EQN 435:</i> 8388608 (23 bits)		–		
Revolutions	–	4096 (12 bits)		–	4096 (12 bits)	–		
Line count	512 or 2048	–	512 or 2048	–	–	250 to 5000		1000 to 5000
Supply voltage	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



	Absolute ECN 113	ECN 125	Incremental ERN 120	ERN 130	ERN 180
Interface	EnDat 2.2 <sup>1)</sup> with $\sim 1$ V <sub>PP</sub>	EnDat 2.2 <sup>1)</sup>			$\sim 1$ V <sub>PP</sub>
Position values/revolution	8192 (13 bits)	33554432 (25 bits)	–		
Line count	2048	–	1000 to 5000		
Supply voltage	DC 3.6 V to 14 V	DC 3.6 V to 14 V	DC 5 V	DC 10 V to 30 V	DC 5 V

<sup>1)</sup> Includes EnDat 2.1 command set; PROFIBUS DP via gateway  
<sup>2)</sup> 5/10-fold integrated interpolation  
<sup>3)</sup> Also available with functional safety

DRIVE-CLiQ is a registered trademark of SIEMENS AG.

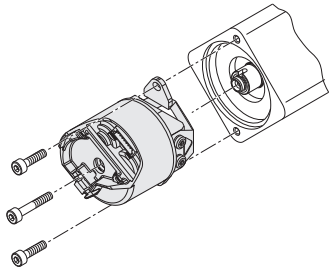


# ECN, EQN, ERN rotary encoders

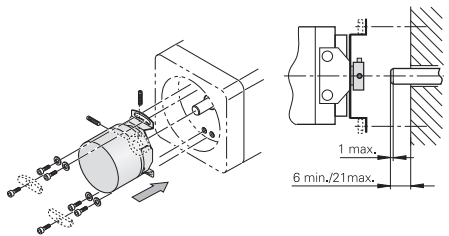
## With integral bearing and mounted stator coupling

### IP40 protection

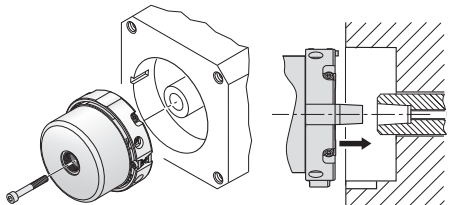
The **ECN, EQN**, and **ERN** photoelectric rotary encoders from HEIDENHAIN with IP40 protection are specially designed for integration in motors. Bearings and mounted stator coupling are integrated. Absolute rotary encoders and versions with commutation tracks are available for synchronous motors. The 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



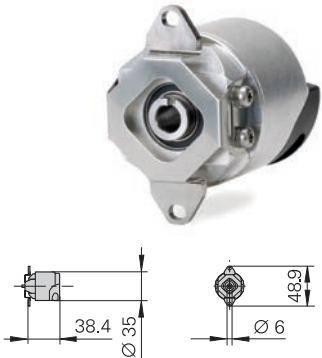
ERN 1123



ECN/EQN/ERN 1300

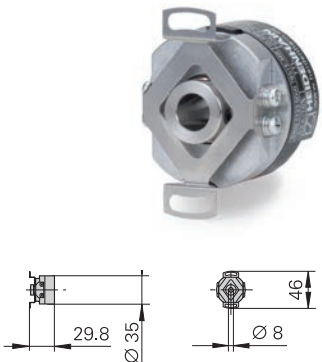
#### ECN/EQN 1100 series

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



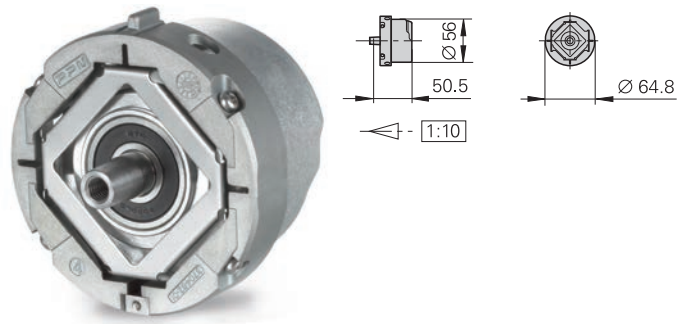
#### ERN 1123


- Blind hollow shaft  $\varnothing$  8 mm
- Housing outside diameter 35 mm
- Stator coupling with bolt-hole circle  $\varnothing$  40 mm
- Typical natural frequency  $f_N$  of coupling: 1000 Hz
- Mech. permissible speed: 6000 rpm
- IP00 protection






#### 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
- Typical natural frequency  $f_N$  of the encoder coupling: 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 available



	<i>Absolute</i> ECN 1113	EQN 1125	ECN 1123 <sup>2)</sup> ECN 1123 S <sup>2)</sup>	EQN 1135 <sup>2)</sup> EQN 1135 S <sup>2)</sup>	<i>Incremental</i> ERN 1123
Interface	EnDat 2.2 <sup>1)</sup> with $\sim 1\text{ V}_{\text{PP}}$		EnDat 2.2 <sup>1)</sup> ; DRIVE-CLiQ		 TTL
Position values/revolution	8192 (13 bits)		8388608 (23 bits)		–
Revolutions	–	4096 (12 bits)	–	4096 (12 bits)	–
Line count	512		–		500 to 8192
Commutation signals	–				Block commutation <sup>3)</sup>
Supply voltage	DC 3.6 V to 14 V		ECN 1123, EQN 1135: DC 3.6 V to 14 V; ECN 1123 S, EQN 1135 S: DC 10 V to 28.8 V		DC 5 V
Operating temperature	$\leq 115\text{ °C}$		ECN 1123, EQN 1135: $\leq 115\text{ °C}$ ; ECN 1123 S, EQN 1135 S: $\leq 95\text{ °C}$		$\leq 90\text{ °C}$

- <sup>1)</sup> Includes EnDat 2.1 command set; PROFIBUS DP via gateway  
<sup>2)</sup> Also available with functional safety  
<sup>3)</sup> Three block commutation tracks with 90°, 120°, or 180° mech. phase shift

	<b>Absolute</b> ECN 1313EQN 1325ECN 1325 <sup>4)</sup> EQN 1337 <sup>4)</sup> ECN 1324 S <sup>4)</sup> EQN 1336 S <sup>4)</sup>						<b>Incremental</b> ERN 1321ERN 1326ERN 1381ERN 1387			
Interface	EnDat 2.2 <sup>1)</sup> with  1 V <sub>PP</sub>		EnDat 2.2 <sup>1)</sup>		DRIVE-CLiQ				 1 V <sub>PP</sub>	
Position values/ revolution	8192 (13 bits)		33554432 (25 bits)		16777216 (24 bits)		–			
Revolutions	–	4096 (12 bits)	–	4096 (12 bits)	–	4096 (12 bits)	–			
Line count	512 or 2048		–				102420484096	512 2048 4096	2048	
Commutation signals	–						–	Block com- mutation <sup>2)</sup>	–	Z1 track <sup>3)</sup>
Supply voltage	DC 3.6 V to 14 V				DC 10 V to 28.8 V		DC 5 V			
Operating temperature	≤ 115 °C				≤ 100 °C		≤ 120 °C; <i>4096 lines</i> : ≤ 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° mech. phase shift  
<sup>3)</sup> One sine and one cosine signal with one period per revolution of the encoder shaft  
<sup>4)</sup> Also available with functional safety

DRIVE-CLiQ is a registered trademark of Siemens AG.

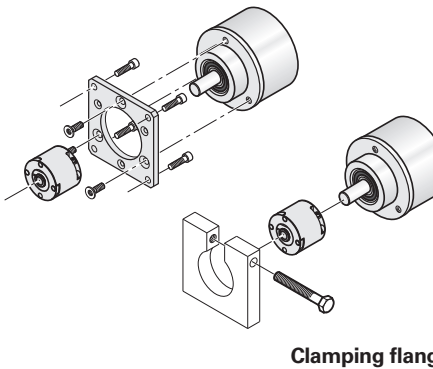
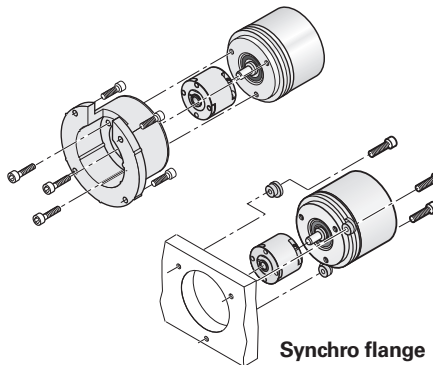
# ROC, ROQ, ROD rotary encoders

## With integral bearing, for separate shaft coupling

### HR handwheel

The **ROC, ROQ,** and **ROD** photoelectric rotary encoders 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.

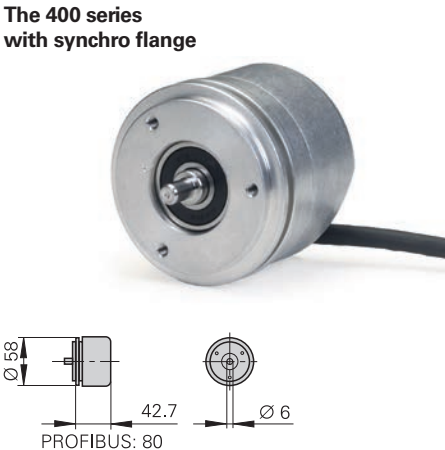
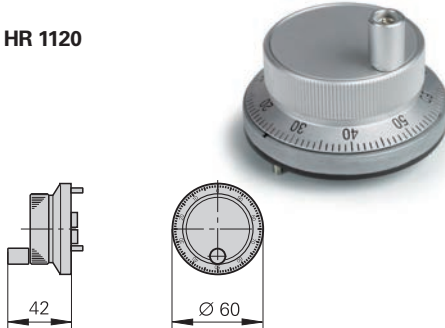
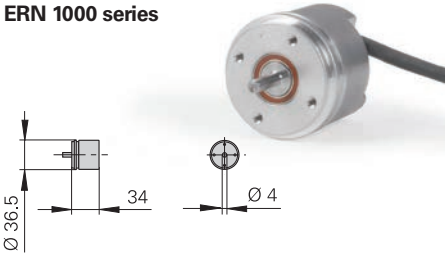


The **HR** electronic handwheel features an integral bearing and mechanical detent. It was conceived for use in portable or stationary housings, e.g. for positioning units or automation applications.

- 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

- HR handwheel**
- Compact dimensions
  - Sturdy design
  - Mechanical detent

- ROC/ROQ/ROD 400 series**
- Industrial standard regarding dimensions and output signals
  - IP67 protection at housing, IP64 at shaft inlet (IP66 upon request)
  - Mounting via synchro flange or clamping flange
  - Shaft diameter 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 available

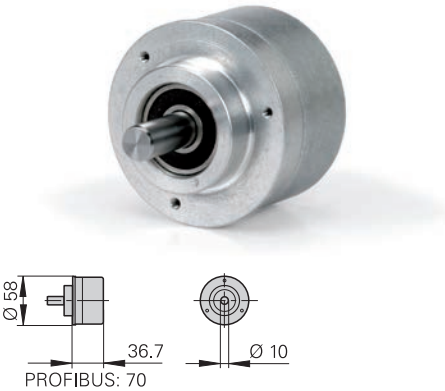


	Absolute				Incremental				
	ROC 1013	ROQ 1025	ROC 1023 ROC 1023 S	ROQ 1035 ROQ 1035 S	ROD 1020	ROD 1030	ROD 1070	ROD 1080	HR 1120
Interface	EnDat 2.2 <sup>1)</sup> with $\sim 1\text{ V}_{\text{PP}}$ ; SSI		EnDat 2.2 <sup>1)</sup> ; DRIVE-CLiQ					$\sim 1\text{ V}_{\text{PP}}$	
Position values/ revolution	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
Supply voltage	DC 3.6 V to 14 V; DC 4.75 V to 30 V		DC 3.6 V to 14 V; DC 10 V to 28.8 V		DC 5 V	DC 10 V to 30 V	DC 5 V		

<sup>1)</sup> Includes EnDat 2.1 command set; PROFIBUS DP via gateway  
<sup>2)</sup> 5/10-fold integrated interpolation

DRIVE-CLiQ is a registered trademark of Siemens AG.

The 400 series  
with clamping flange



PROFIBUS DP/PROFINET



Synchro flange	Absolute ROC 413	ROQ 425	ROC 413	ROQ 425	ROC 424S <sup>1)</sup>	ROQ 436S <sup>1)</sup>	ROC 425 <sup>1)</sup> ROC 425F ROC 425M	ROQ 437 <sup>1)</sup> ROQ 437F ROQ 435M	Incremental ROD 426	ROD 466	ROD 436	ROD 486
	Clamping flange								ROD 420	–	ROD 430	ROD 480
Interface	EnDat 2.2 <sup>2)</sup> with $\sim 1\text{ V}_{\text{PP}}$ ; SSI		PROFIBUS DP; PROFINET		DRIVE-CLiQ		EnDat 2.2 <sup>2)</sup> ; Fanuc $\alpha$ i; Mitsubishi					$\sim 1\text{ V}_{\text{PP}}$
Position values/ revolution	8192 (13 bits)				16777216 (24 bits)		33554432 (25 bits) <b>ROQ 435:</b> 8388608 (23 bits)		–			
Revolutions	–	4096 (12 bits)	–	4096 (12 bits)	–	4096 (12 bits)	–	4096 (12 bits)	–			
Line count/ signal periods	512		–						50 to 5000 <b>ROD 426/466:</b> up to 10000 <sup>3)</sup>		1000 to 5000	
Supply voltage	DC 3.6 V to 14 V; DC 4.75 V to 30 V		DC 9 V to 36 V; DC 10 V to 30 V		DC 10 V to 28.8 V		DC 3.6 V to 14 V		DC 5 V	DC 10 V to 30 V		DC 5 V

<sup>1)</sup> Also available with functional safety  
<sup>2)</sup> Includes EnDat 2.1 command set; PROFIBUS DP via gateway

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

DRIVE-CLiQ is a registered trademark of Siemens AG.



# ECI, EQI, EBI, ERO rotary encoders

## Without integral bearing

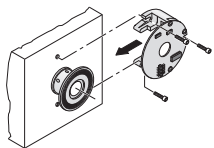
The photoelectric **ERO** modular rotary encoders from HEIDENHAIN consist of a graduated disk with hub and a scanning unit. They are particularly well suited for **limited installation space** or for applications where there must be **no friction**.

Compared with optical rotary encoders without integral bearings, inductive rotary encoders are particularly robust and have large mounting tolerances.

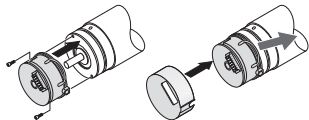
The inductive rotary encoders **ECI/EQI/EBI 1100** and **ECI/EQI 1300** are mechanically compatible with the corresponding ExN photoelectric encoders: the shaft is fastened with a central screw. The stator of the encoder is fastened by several screws.

The **ECI/EBI 100** and **ECI/EBI 4000** inductive rotary encoders have a particularly small outside diameter with a large shaft opening. The encoders were conceived for simple axial mounting.

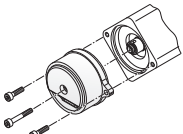
The correct installation of the rotary encoders without integral bearing can be inspected with the HEIDENHAIN PWM 21 or PWT 101 measuring and testing devices.



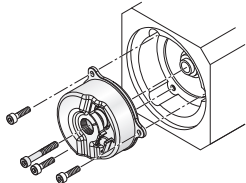
ERO 1200



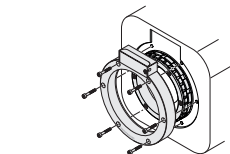
ERO 1400



ECI/EQI/EBI 1100



ECI/EQI/EBI 1300



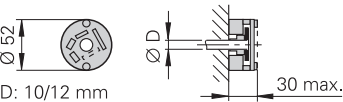
ECI/EBI 4000

### ERO 1200 series

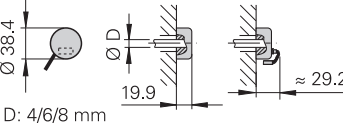
- Compact dimensions
- For shaft diameters of up to 12 mm



### ERO 1200 series



### ERO 1400 series



### ERO 1400 series

- Miniaturized modular rotary encoders for measured shafts of up to Ø 8 mm
- Special integral mounting aid
- With cover cap

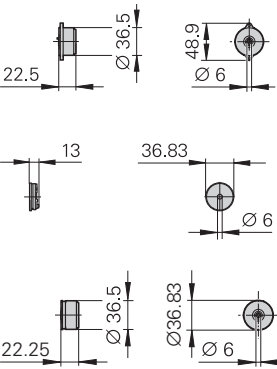


### ECI/EQI/EBI 1100 series

- Miniature size
- Simple mounting without adjustment
- Blind hollow shaft Ø 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
- Synchro flange for variable mounting



### ECI/EQI/EBI 1100 series

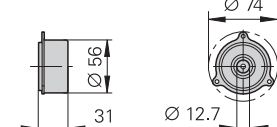


### ECI/EQI/EBI 1300 series

- Simple mounting without adjustment
- Blind hollow shaft
- **EBI 1335**: multiturn function via battery-buffered revolution counter
- 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/EQI/EBI 1300 series

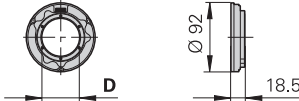


### ECI/EBI 100 series

- Especially flat design
- Hollow through shaft Ø 30, 38, 50 mm
- **EBI 135**: multiturn function via battery-buffered revolution counter

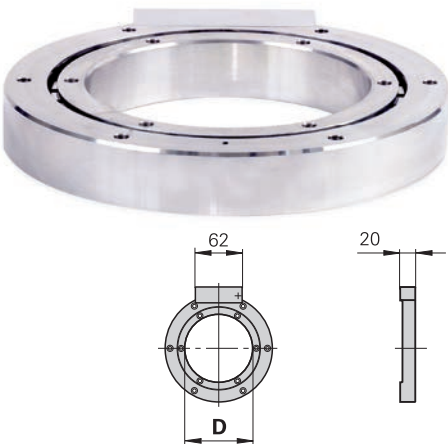


### ECI/EBI 100 series



### ECI/EBI 4000 series

- Flat design
- Hollow through shaft Ø 90, 180 mm
- **EBI 4010**: multiturn function via battery-buffered revolution counter



	<b>Absolute</b> <b>ECI 119</b>		<b>EBI 135</b>	<b>ECI 4010<sup>1)</sup></b>	<b>EBI 4010<sup>1)</sup></b>	<b>ECI 4090 S<sup>1)</sup></b>
<b>Interface</b>	EnDat 2.1 with ~ 1 V <sub>PP</sub>		EnDat 2.2			
<b>Position values/revolution</b>	524 288 (19 bits)		1 048 576 (20 bits)			
<b>Revolutions</b>	–		65 536 (16 bits) <sup>2)</sup>	–	65 536 (16 bits) <sup>2)</sup>	–
<b>Line count</b>	32		–			
<b>Mech. permissible speed</b>	≤ 6000 rpm					
<b>Shaft</b>	Hollow through shaft Ø 30, 38, 50 mm		Hollow through shaft Ø 90, 180 mm			

<sup>1)</sup> Also available with functional safety  
<sup>2)</sup> Multiturn function via battery-buffered revolution counter

	<b>Incremental</b> <b>ERO 1225</b>	<b>ERO 1285</b>
<b>Interface</b>	TTL	~ 1 V <sub>PP</sub>
<b>Line count</b>	1024 2048	
<b>Mech. permissible speed</b>	≤ 25 000 rpm	
<b>Shaft diameter D</b>	10 mm, 12 mm	

	<b>Incremental</b> <b>ERO 1420</b>	<b>ERO 1470</b>	<b>ERO 1480</b>
<b>Interface</b>	TTL	TTL <sup>1)</sup>	~ 1 V <sub>PP</sub>
<b>Line count</b>	512 1000 1024	1000 1500	512 1000 1024
<b>Mech. permissible speed</b>	≤ 30 000 rpm		
<b>Shaft diameter D</b>	4 mm, 6 mm, 8 mm		

<sup>1)</sup> 5/10/20/24-fold integrated interpolation

	<b>Absolute</b> <b>ECI 1119<sup>1)</sup></b> <b>ECI 1319<sup>1) 3)</sup></b> <b>ECI 1118</b>	<b>EQI 1131<sup>1)</sup></b> <b>EQI 1331<sup>1) 3)</sup></b>	<b>EBI 1135</b> <b>EBI 1335</b>
<b>Interface</b>	EnDat 2.2		EnDat 2.2
<b>Position values/revolution</b>	524 288 (19 bits) <b>ECI 1118</b> : 262 144 (18 bits)		524 288 (19 bits) <b>EBI 1135</b> : 262 144 (18 bits)
<b>Revolutions</b>	–	4096 (12 bits)	65 536 (16 bits) <sup>2)</sup>
<b>Mech. permissible speed</b>	≤ 15 000 rpm	≤ 12 000 rpm	≤ 12 000 rpm
<b>Shaft</b>	Blind hollow shaft		

<sup>1)</sup> Also available with functional safety  
<sup>2)</sup> Multiturn function via battery-buffered revolution counter  
<sup>3)</sup> Also available with DRIVE-CLiQ interface

Controls for milling machines

With its TNC controls, HEIDENHAIN offers a complete product line for all common types of machines in the area of milling: from a simple three-axis CNC milling machine to a highly complex machine with up to 23 axes—a TNC control is always the right choice. Thanks to their flexible operational design and practical functions, the TNCs are particularly suitable for the following applications:

- Simple milling, drilling, and boring operations
- Machining in a tilted working plane
- Complex 5-axis operations
- HSC operations
- Milling-turning operations

TNC controls are versatile and offer the right programming function for any task. Thanks to its **HEIDENHAIN Klartext** format, 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. Even if you are used to **G-code programming**, however, the TNC is still the right control—you can enter G-code address letters simply over soft keys.

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

Controls for lathes

Lathe controls from HEIDENHAIN have been proving themselves for years both on standard and complex lathes as well as on turning centers.

Many shop-compatible functions support you optimally during:

- Conventional lathe operations
- Operations with driven tools
- Machining with the C and Y axes
- Full-surface machining with dual spindles
- Machining with the B axis

HEIDENHAIN lathe controls are extremely flexible: whether you need only single cycles, short program sequences, or complete NC programs—you only need to select the appropriate operating mode.

Program creation with **smart.Turn** is particularly easy and convenient. The straightforward fillable-form input provides graphical support, meaningful dialogs, and a logical check of entries.

You can also reuse NC programs of older HEIDENHAIN lathe controls, such as the CNC PILOT 4290, on the CNC PILOT 640. With a convenient import filter you can simply load the programs into the new control, and then continue using them on the CNC PILOT 640.

Quickly and easily to the finished part

The operational design of the milling and lathe controls is tailored to the needs of the user and therefore offers you the greatest possible flexibility in program creation. When **programming at the machine**, all required inputs are guided by practice-oriented prompts and questions while highly expressive help images support you. Standard operations and even complex applications are on call as a large variety of **cycles** for real-world machining, coordinate transformations, or for setup.

The HEIDENHAIN controls can be **programmed remotely** just as well—for example on a CAD/CAM system or at a HEIDENHAIN programming station.

You can also open **DXF files** that were created on a separate CAD system directly on the control and extract contours and machining positions from them. This not only saves time otherwise spent on programming and testing, but you can also be sure that the adopted data is exactly in accordance with the design engineer’s specifications.

User-friendly and practical

Thanks to the robust design optimized for the application, HEIDENHAIN controls are ideally suited for a harsh work-day environment. The clear-cut screen displays informational notes, questions, prompts, program steps, graphics, and soft-key rows. All texts are available in numerous languages. **Graphic illustrations** simplify programming and provide valuable aid for verifying the program during simulation.

High quality and productivity

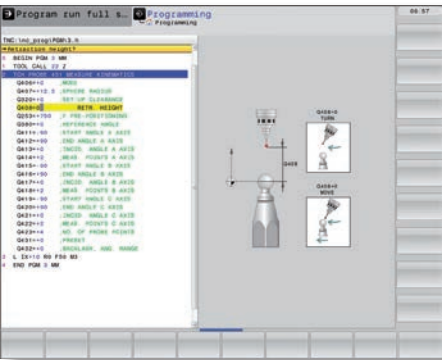
Thanks to intelligent motion control, HEIDENHAIN controls enable short machining times with perfect workpiece surfaces and very high workpiece accuracy. The bottom line is an increase in productivity: unit costs are reduced without affecting accuracy and surface quality.

Automating manual operations

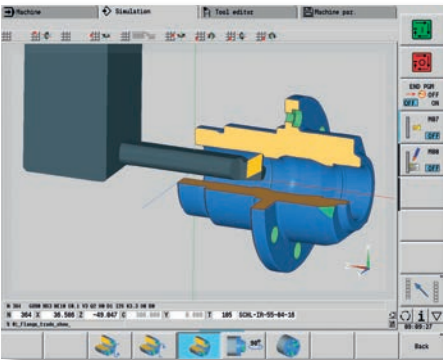
You can start working with the HEIDENHAIN controls even before writing a complete part program. Simply machine a part step by step—switching as you want between manual operation and automatic positioning.

Manufacturing complex components precisely

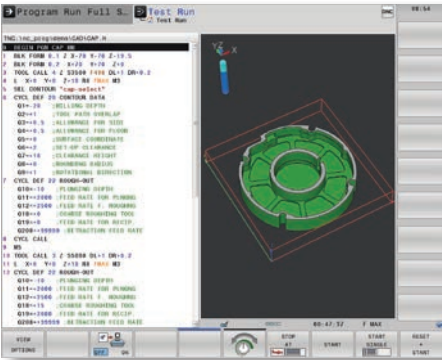
Regardless of whether the workpieces are simple or complex—HEIDENHAIN controls offer the appropriate functions. With them, neither are operations in a tilted plane a challenge, nor are multi-side or full-surface machining. Simultaneous machining with up to five axes is an especially strong point of HEIDENHAIN controls. With special control strategies, functions for process monitoring, and compensation of production-induced disturbances, you can also manufacture components with complex geometries exactly, with process reliability, and efficiently.



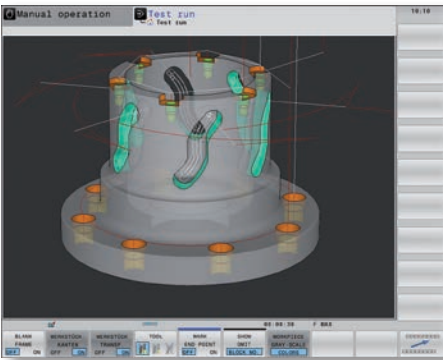
Klartext conversational input on a TNC



High-resolution graphics of lathe controls



NC program simulation



High-resolution graphics of milling controls



TNC 640



CNC PILOT 640

HEIDENHAIN controls		Series	Page
Controls for milling machines	Contouring control for up to 24 control loops	TNC 640	44
	Contouring control for up to 8 control loops	TNC 620	46
	Contouring control for up to 6 control loops	TNC 320	46
	Straight cut control for up to 6 control loops	TNC 128	48
Controls for lathes	Contouring control for up to 24 control loops	CNC PILOT 640	50
	Contouring control for up to 10 control loops	MANUALplus 620	52
Accessories	Electronic handwheels	HR	56
	Programming stations	TNC 640/TNC 620/TNC 320 DataPilot MP 620/CP 640	56
	StateMonitor		57
Tool and workpiece setup and measurement	Workpiece touch probes	TS	58
	Tool touch probes	TT	60
	Transceivers	SE	61



# TNC 640 contouring control

For milling machines, milling-turning machines, and machining centers

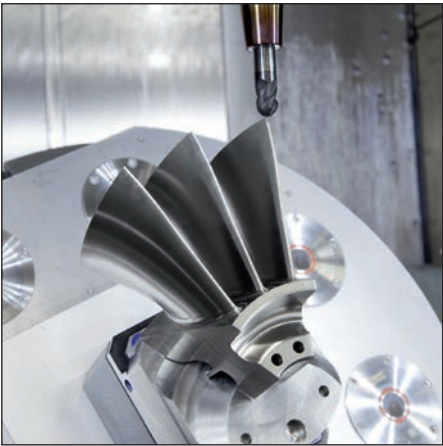
Besides milling, the **TNC 640** from HEIDENHAIN is also capable of combined milling and turning operations. It is particularly well suited for milling, turning, HSC machining, and 5-axis machining. The shop-oriented and versatile control features numerous functions. It is especially attractive for the 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 closed-loop 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 Klartext format. 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 codes, standardized table editors, and smartSelect—the dialog-guided fast selection of functions—assist you while you work.



	TNC 640
Axes	24 control loops (22 with functional safety), of which up to 4 can be configured as spindles
Interpolation	<ul style="list-style-type: none"><li>• Linear in up to 5 axes with Tool Center Point Management (TCPM)</li><li>• Circular in up to 3 axes with tilted working plane</li><li>• Helical</li><li>• Cylinder surface<sup>1)</sup></li><li>• Rigid tapping<sup>1)</sup></li></ul>
Program entry	HEIDENHAIN Klartext conversational format, ISO (G codes)
Programming support	TNCguide presents user information directly on the control
CAD import <sup>2)</sup>	Loading of contours from 3-D models
Program memory	HDR hard disk or SSDR solid state disk, at least 21 GB
Position entry	Nominal positions in Cartesian or polar coordinates, dimensions absolute or incremental, in mm or inches; actual position capture
Input resolution and display step	To 0.1 µm or 0.0001°; optionally to 0.01 µm or 0.00001°
Block-processing time	0.5 ms (3-D straight line without radius compensation at 100 % PLC utilization)
Turning functions <sup>2)</sup>	<ul style="list-style-type: none"><li>• Turning tool data management</li><li>• Tool-tip radius compensation</li><li>• Constant cutting speed</li><li>• Toggling between milling and turning operations</li></ul>
High-speed cutting	Motion control with minimum jerk
FK free contour programming	HEIDENHAIN Klartext conversational format with graphical support
Coordinate transformation	<ul style="list-style-type: none"><li>• Shifting, rotating, mirroring, scaling (axis specific)</li><li>• Tilting the working plane, PLANE function<sup>2)</sup></li></ul>
Canned cycles	For drilling, milling, turning <sup>2)</sup> , interpolation turning <sup>2)</sup> , grinding <sup>2)</sup> , hobbing <sup>2)</sup> , and for cylinder surface machining <sup>2)</sup> ; data input with graphical support
Touch probe cycles	For tool measurement, workpiece alignment, workpiece measurement, and presetting
Graphics	For programming and program verification
Parallel operation	Program run and programming with graphics
Data interface	Ethernet 1000BASE-T; USB 3.0; USB 2.0; RS-232-C/V.24 (max. 115200 bauds)
Remote control and diagnosis	TeleService
Screen	15-inch or 19-inch screen with operating keys; 19-inch or 24-inch screen for multitouch operation
Axis feedback control	<ul style="list-style-type: none"><li>• Feedforward control or operation with following error</li><li>• Integrated digital drive control including inverter</li></ul>
Adaptive feed control <sup>2)</sup>	AFC adjusts the contouring feed rate to the spindle power
Dynamic collision monitoring (DCM) <sup>2)</sup>	Dynamic monitoring of the working space for possible collisions with machine components <sup>1)</sup>
Accessories	<ul style="list-style-type: none"><li>• HR electronic handwheels</li><li>• TS workpiece touch probe and TT tool touch probe</li></ul>

<sup>1)</sup> This function requires adaptation by the machine tool builder

<sup>2)</sup> Software option

For further functions and differences in function, see the product documentation



TNC 620,TNC 320 contouring controls
For milling machines

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

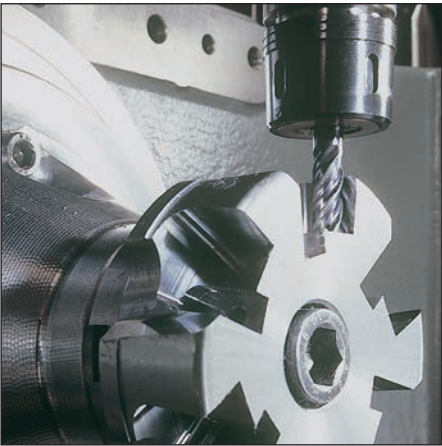
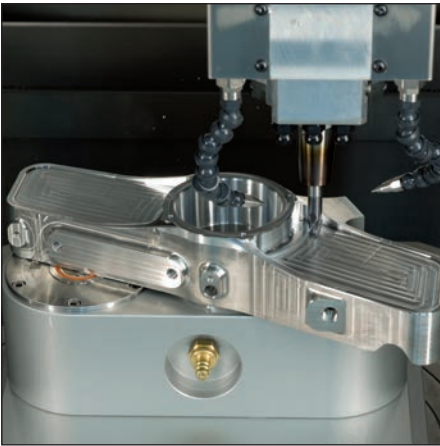
- Series and single-part production
- Tool making
- Machine building
- Research and development
- Prototypes and pilot plants
- Repair departments
- Training and education facilities

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. The TNC 620 is available in a touch-screen version as well as in a screen and keyboard version.

Because of its analog outputs (which also provide nominal speed values), the TNC 320 is well suited for retrofitting on machine tools.



TNC 620 touch screen version (only for TNC 620)



	TNC 620	TNC 320
Axes	8 control loops, of which up to 2 are configurable as spindles	6 control loops, of which up to 2 are configurable as spindles
Interpolation	<ul style="list-style-type: none"><li>• Linear: in 4 (optionally 5) main axes</li><li>• Circular: in 2 (optionally 3) axes</li><li>• Helical, superimposition of circular and straight paths</li><li>• Cylinder surface<sup>1)</sup></li></ul>	<ul style="list-style-type: none"><li>• Linear in 4 main axes</li><li>• Circular in 2 axes</li><li>• Helical, superimposition of circular and straight paths</li><li>• Cylinder surface<sup>1)</sup></li></ul>
Program entry	<ul style="list-style-type: none"><li>• HEIDENHAIN Klartext conversational format</li><li>• ISO (G codes: input via soft keys or via external USB keyboard)</li><li>• FK free programming of contours (software option on the TNC 620)</li></ul>	
Programming support	TNCguide presents user information directly on the TNC	
CAD import <sup>1)</sup>	Loading of contours from 3-D models	
Program memory	1.8 GB CFR memory card	
Position entry	<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>	
Input resolution and display step	To 0.1 µm or 0.0001° optionally to 0.01 µm or 0.00001°	To 0.1 µm or 0.0001°
Block processing time	1.5 ms	6 ms
Coordinate transformation	<ul style="list-style-type: none"><li>• Shifting, rotating, mirroring, scaling (axis specific)</li><li>• Tilting the working plane, PLANE function<sup>1)</sup></li></ul>	
Canned cycles (some are software options on 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>• Clearance and finishing of pockets, slots, and studs</li></ul>	
Touch probe cycles	For tool measurement, workpiece alignment, workpiece measurement, and workpiece presetting (software option on the TNC 620)	
Graphics	For programming and program verification (software option on the TNC 620); graphic support with cycle programming	
Parallel operation	Programming during program run, program-run graphics (software option on the TNC 620)	
Data interface	Ethernet 1000BASE-T; USB 3.0; USB 2.0; RS-232-C/V.24, and RS-422/V.11 (max. 115200 bauds)	
Screen	15-inch screen with operating keys or 19-inch screen for multitouch operation (portrait)	15-inch screen with operating keys
Axis feedback control	Feedforward control or operation with following error	
	Integrated digital drive control for synchronous and asynchronous motors	–
Interfacing to the machine	Via integrated programmable logic controller (PLC)	
	Inputs/outputs with PL 6000	Inputs/outputs expandable with PL 510
Accessories	<ul style="list-style-type: none"><li>• HR electronic handwheels</li><li>• TS workpiece touch probe and TT tool touch probe</li></ul>	

<sup>1)</sup> Software option

# TNC 128 straight-cut control

## For milling machines

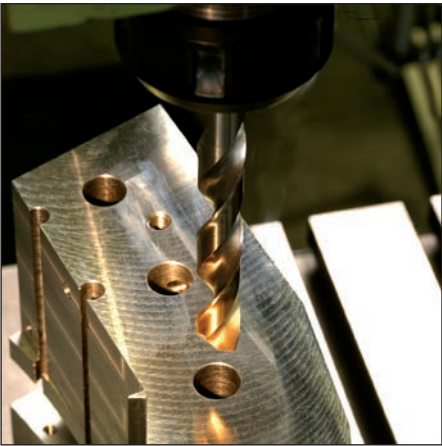
The **TNC 128** from HEIDENHAIN is a compact but versatile straight-cut control for three servo axes and servo spindle. A further servo axis is an option. Thanks to its simple operation and scope of features, it is especially well suited for use on universal milling, drilling, and boring machines for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

- 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.



	TNC 128
Axes	6 control loops, of which up to 2 are configurable as spindles
Program entry	HEIDENHAIN Klartext conversational format
Program memory	1.8 GB CFR memory card
Position entry	<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>
Input resolution and display step	To 0.1 µm or 0.0001°
Block processing time	6 ms
Coordinate transformation	Shifting, rotating, mirroring, scaling (axis specific)
Fixed cycles	<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>
Touch probe cycles	Touch probe calibration and presetting
Graphics	For programming and program verification; graphic support for cycle programming
Parallel operation	Program run and programming, program-run graphics
Data interface	<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 bauds</li></ul>
Screen	12.1-inch screen with operating keys
Axis feedback control	Feedforward control or operation with following error
Interfacing to the machine	Via integrated programmable logic controller (PLC); inputs/outputs expandable with PL 510
Accessories	<ul style="list-style-type: none"><li>• HR electronic handwheels</li><li>• TS or KT workpiece touch probe and TT tool touch probe</li></ul>





# CNC PILOT 640 contouring control

## For lathes and turning-milling machines

The **CNC PILOT 640** offers you the right support thanks to its flexible design and versatile programming capabilities — regardless of whether you are manufacturing single parts or batches, simple or complex workpieces. The CNC PILOT 640 is characterized by its simple operation and programming. It is quickly learned and requires minimum training time.

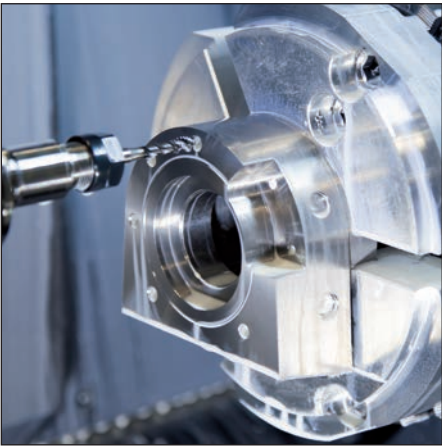
The CNC PILOT 640 was designed for CNC lathes and is ideal for both horizontal and vertical lathes as well as for vertical boring and turning mills.

The CNC PILOT 640 supports lathes with main and counter spindle, one slide (X and Z axis), C axis or positionable spindle, driven tools, and machines with Y and B axes.

Regardless of whether you are turning simple parts or complex workpieces, the CNC PILOT 640 provides you with the benefits of graphical contour input and convenient programming with smart.Turn. With the TURN PLUS software option, you can even create an NC program at the touch of a button. You only need to describe the contour, the material, and the clamping fixtures beforehand. TURN PLUS does everything else automatically.

If you program with variables, control special machine components, or use externally created programs, etc., simply switch to DIN PLUS. With DIN PLUS you'll find the fitting solution for your special tasks.

The CNC PILOT 640 also supports multi-channel machining. Different machining steps can then be performed simultaneously using multiple slides.



	CNC PILOT 640
Axes	Up to 24 control loops (22 with functional safety)
Interpolation	<ul style="list-style-type: none"><li>• Straight line: in 2 principal axes, optional in 3 principal axes</li><li>• Circle: in 2 axes, optional additional linear interpolation in the third axis</li><li>• C1/C2 axis: interpolation of X and Z linear axes with the C1/C2 axis<sup>1)</sup></li><li>• B axis: 5-axis interpolation between X, Z, Y, B, and C axes<sup>1)</sup></li></ul>
Program entry	smart.Turn, DIN PLUS, Teach-In mode
Programming aids	TURNguide presents user information directly on the control
DXF import <sup>1)</sup>	Loading of DXF contours
Program memory	1.8 GB CFR memory card
Position entry	Nominal positions in Cartesian or polar coordinates, absolute or incremental dimensions, in mm or inches; actual position capture
Input resolution and display step	X axis: 0.5 µm, diameter: 1 µm U, V, W, Y, Z axes: 1 µm B, C1/C2 axes: 0.001°
Block processing time	1.5 ms (3-D straight line without radius compensation at 100 % PLC utilization)
Setup functions	<ul style="list-style-type: none"><li>• Setting the workpiece datum</li><li>• Defining the tool change point</li><li>• Defining the protection zone</li></ul>
Interactive Contour Programming ICP	Contour definition with graphic support
Canned cycles	Stock removal, recessing, recess turning, engraving, thread cutting, helical slot milling, boring, drilling, tapping, deburring, trochoidal milling, hobbing, eccentric and non-circular turning
Touch-probe cycles <sup>1)</sup>	For tool and workpiece measurement as well as presetting
Graphics	For programming and program verification
Parallel operation	Program run and programming with graphics
Data interface	Ethernet 1000BASE-T; USB 3.0; USB 2.0; RS-232-C/V.24 (max. 115200 bauds)
Remote control and diagnosis	TeleService
Screen	15.6-inch or 19-inch screen for multitouch operation
Axis feedback control	<ul style="list-style-type: none"><li>• Feedforward control or operation with following error</li><li>• Integrated digital drive control including inverter</li></ul>
Multi-channel capability	<ul style="list-style-type: none"><li>• Up to three channels for asynchronous multi-slide machining</li></ul>
Accessories	<ul style="list-style-type: none"><li>• HR electronic handwheels</li><li>• TS workpiece touch probe and TT tool touch probe</li></ul>

<sup>1)</sup> Software option  
For further functions and differences in function, see the product documentation



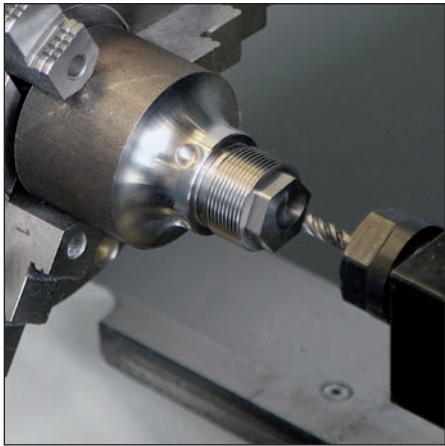
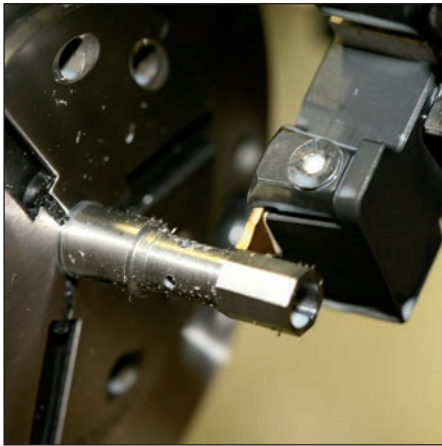
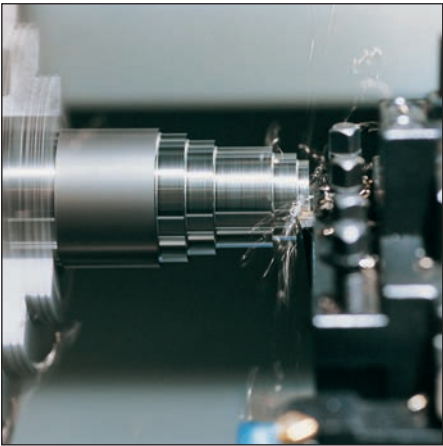
# MANUALplus 620 contouring control

## For CNC and cycle lathes

The **MANUALplus 620** is a compact and versatile contouring control that is particularly well suited for cycle-controlled lathes. The MANUALplus 620 optimally combines the ease of use of conventional lathes with the advantages of CNC-controlled machines.

Regardless of whether you are manufacturing single parts or batches or whether your workpieces are simple or complex, the control adapts to the needs of your company. The MANUALplus 620 is characterized by its simple operation and programming. It is quickly learned and requires minimum training time.

The MANUALplus 620 supports lathes with main and counter spindle, one slide (X and Z axis), C axis or positionable spindle, and driven tools, as well as machines with Y and B axes.



	MANUALplus 620
Axes	10 control loops
Interpolation	<ul style="list-style-type: none"><li>• Straight line: in 2 principal axes, optional in 3 principal axes</li><li>• Circle: in 2 axes, optional additional linear interpolation in the third axis</li><li>• C1/C2 axis: interpolation of X and Z linear axes with the C1/C2 axis<sup>1)</sup></li></ul>
Program entry	Teach-In mode, smart.Turn <sup>1)</sup> , DIN PLUS
Programming aids	TURNguide presents user information directly on the control
DXF import <sup>1)</sup>	Loading DXF contours
Program memory	1.8 GB CFR memory card
Position entry	Nominal positions in Cartesian or polar coordinates, dimensions absolute or incremental, in mm or inches; actual position capture
Input resolution and display step	X axis: 0.5 µm, diameter: 1 µm U, V, W, Y, Z axes: 1 µm B, C1/C2 axes: 0.001°
Block processing time	3 ms
Setup functions	<ul style="list-style-type: none"><li>• Setting the workpiece datum</li><li>• Defining the tool change point</li><li>• Defining the protection zone</li></ul>
Interactive Contour Programming ICP	Contour definition with graphic support
Canned cycles	Stock removal, recessing, recess turning, engraving, thread cutting, helical slot milling, boring, drilling, tapping, deburring, trochoidal milling, hobbing, eccentric and non-circular turning
Touch-probe cycles <sup>1)</sup>	For tool and workpiece measurement as well as presetting
Graphics	For programming and program verification
Parallel operation	Program run and programming with graphics
Data interface	Ethernet 1000BASE-T; USB 3.0; USB 2.0; RS-232-C/V.24 (max. 115200 bauds)
Remote control and diagnosis	TeleService
Screen	15.6-inch screen for multitouch operation (with virtual operating panel)
Axis feedback control	<ul style="list-style-type: none"><li>• Feedforward control or operation with following error</li><li>• Integrated digital drive control including inverter</li></ul>
Accessories	<ul style="list-style-type: none"><li>• HR electronic handwheels</li><li>• TS workpiece touch probe and TT tool touch probe</li></ul>

<sup>1)</sup> Software option  
For further functions and differences in function, see the product documentation



# Contouring controls

## Digital control design

Control packages from HEIDENHAIN are perfectly matched systems consisting of the following components:

- Software
- Control hardware and real-time hardware
- Drive electronics
- Motors
- Encoders

In this uniformly digital control solution, all components are connected over purely digital interfaces: the control components over **HSCI** (HEIDENHAIN Serial Controller Interface), which is the HEIDENHAIN real-time protocol for Fast Ethernet, and the encoders over **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. The outstanding characteristics of the uniform digital solution from HEIDENHAIN guarantee very high accuracy and surface definition together with high traversing speeds.

**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

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

- TNC 640
- TNC 620
- CNC PILOT 640
- MANUALplus 620

**Motors for axis and spindle drives**  
HEIDENHAIN offers various motors for axis and spindle drives as accessories to its controls with integrated inverters:

- Feed motors with a stall torque of 1.5 Nm to 120 Nm and a power rating ranging from 0.5 kW to 14.4 kW.
- Spindle motors with a power rating ranging from 5.5 kW to 40 kW.

**Inverter systems**  
Either compact or modular inverters are available, depending on the type of machine. The **compact inverters** include power electronics for up to five axes plus spindle with a rated output of the total system up to 22 kW. For the **modular inverters**, supply units from 22 kW to 125 kW as well as various power modules for axes and spindles are available. Modular inverters are suited for machines with up to 24 axes, of which up to four can be configured as spindles.

**Gen 3 drives**  
With the new Gen 3 components, HEIDENHAIN is offering a complete system that is based on highly innovative and future-oriented technologies. You profit from state-of-the-art interface technology, improved performance data, and increased controller performance. This makes the Gen 3 drive technology an important key component for machines that must fulfill stringent requirements regarding availability, surface quality, and machining time.

Gen3



**TNC 640**  
With modular inverters, motors, and position encoders



Accessories

Electronic handwheels and programming stations

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 550 FS portable handwheels

The axis keys and certain functional keys are integrated in the housing. This way you can 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, the spindle speed, the operating mode, and other functions, as well as override potentiometers for the feed rate and spindle speed. You can enjoy unlimited freedom of movement with the **HR 550 FS** 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. An adapter permits connection of up to three HR 150 electronic panel-mounted handwheels.



HR 130 for integration in the machine operating panel

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

Creating programs

The programming, testing, and optimizing of HEIDENHAIN Klartext or G-code 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 with G codes as well as in Klartext conversational format, the programming stations can also be used in schools for TNC programming training.



StateMonitor

Collect, evaluate, and visualize machine data. With the smart analysis tool **StateMonitor**, the status of your machines is always at your fingertips.

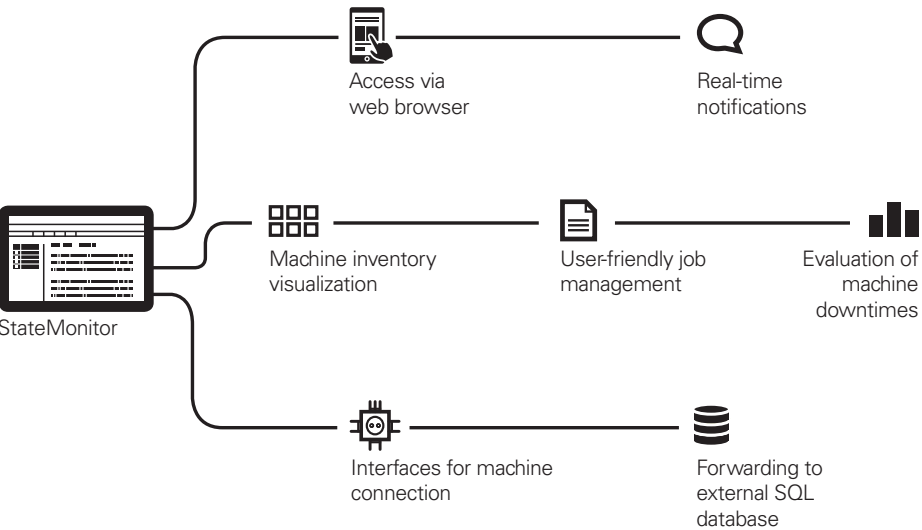
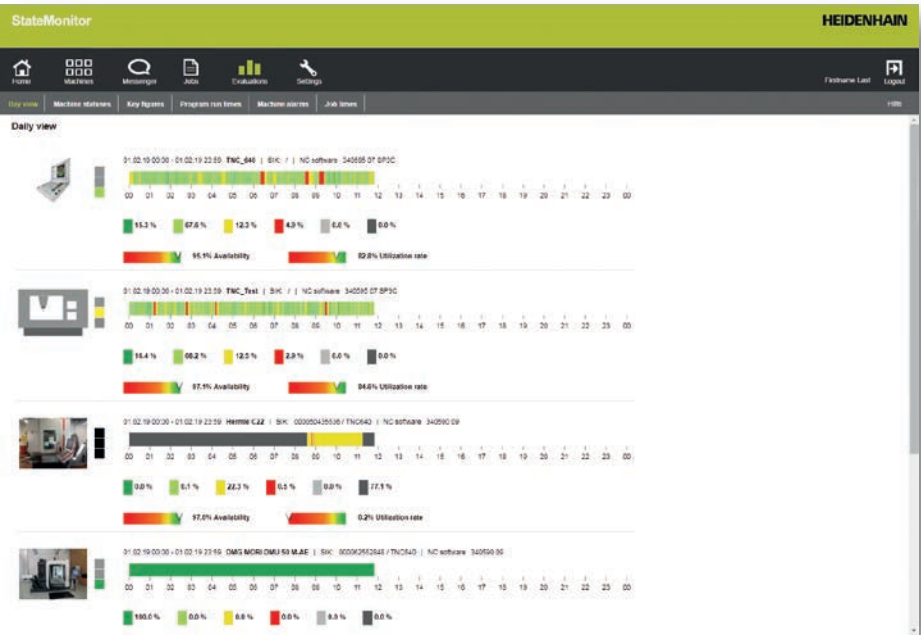
StateMonitor collects and visualizes the following information from the networked machines:

- Operating modes
- Override positions (spindle, rapid traverse, feed rate)
- Program status and program name, as well as subprograms if applicable
- Program run time
- SIK number and software number
- Machine messages

Active support for production planning with an extensive range of functions for job data collection:

- Create and assign jobs
- Start and terminate jobs
- Plan setup times and interruptions
- Store additional job data (such as quantities produced)

StateMonitor even lets you connect machines with different controls and supports the following protocol types: HEIDENHAIN DNC, OPC UA, MTConnect, and Modbus TCP.





# Tool and workpiece setup and measurement

## TS workpiece touch probes

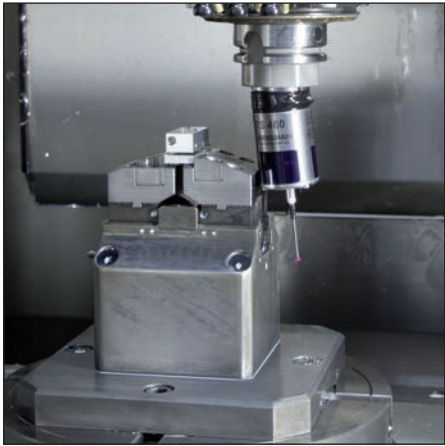
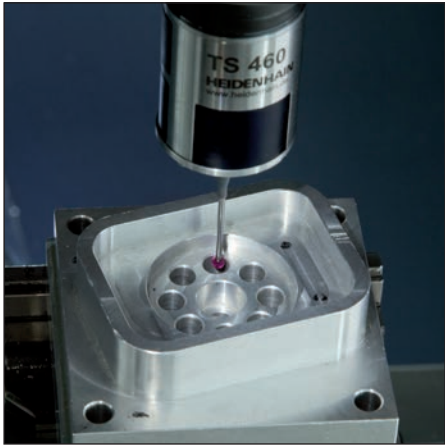
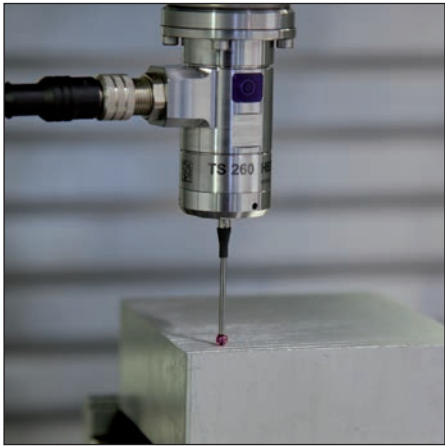
The **TS workpiece touch probes** from HEIDENHAIN help you perform setup, measuring, and inspection functions directly on the machine tool.

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 probing repeatability
  - High probing speed
  - 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 **radio and infrared transmission** for machines with automatic tool change:

- **TS 460**: standard touch probe  
Compact dimensions, energy-saving mode, optional collision protection and thermal decoupling

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

- **TS 642**: touch probe for retrofitting  
Activation by switch in the taper shank
- **TS 740**: highly accurate touch probe  
High probing accuracy and repeatability, low probing force

Probe system with **cable-bound signal transmission** for machines with manual tool change, e.g. grinding, turning and milling machines:

- **TS 150**: cable-bound touch probe  
Radial or axial cable connection
- **TS 260**: cable-bound touch probe  
Radial or axial cable connection
- **TS 248**: cable-bound touch probe  
Radial cable connection, with reduced deflection forces



	TS 460	TS 642	TS 740	TS 260 TS 248	TS 150
Machine type	CNC machine tools for milling, drilling, and boring as well as lathes			CNC grinding machine or lathes	
Signal transmission	Radio and infrared	Infrared		Via cable	
Transceiver unit	SE 540: infrared SE 642: infrared SE 660: radio/infrared SE 661: radio/infrared	SE 540: infrared SE 642: infrared		–	
Power supply	Rechargeable or nonrechargeable batteries			DC 15 V to 30 V	Via UTI 150 interface electronics
Switching on/off	Radio or infrared transmission	Switch in taper shank	By infrared signal	–	
Interface to control Signal level	HTL via SE transceiver unit			HTL	
Probe repeatability	2 σ ≤ 1 μm		2 σ ≤ 0.25 μm	2 σ ≤ 1 μm	
Probe velocity	≤ 3 m/min		≤ 0.25 m/min	≤ 3 m/min	
Protection EN 60529	IP68				

TT tool touch probes

Tool measurement on the machine shortens non-productive times, increases machining accuracy, and reduces the scrapping and reworking of machined parts. The tactile TT touch probes allow you to measure your tools efficiently and reliably.

Due to 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 the tactile probing of a tool. In that instant, the TT generates a trigger signal that is transmitted to the control, where it is then 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 transceiver unit
  - The SE 660 is a common transceiver unit for tool and workpiece touch probes with radio and infrared transmission



TT 160



TT 460

	TT 160	TT 460
Probing method	Physical probing in three dimensions: ±X, ±Y, +Z	
Probe repeatability	2 σ ≤ 1 μm (probing speed 1 m/min)	
Permissible deflection of probe contact	≈ 5 mm in all directions	
Supply voltage	DC 10 V to 30 V via NC	Rechargeable or nonrechargeable batteries
Interface to control Signal level	HTL	SE 642: infrared SE 660: radio/infrared SE 661: radio/infrared
Signal transmission	Via cable	Radio wave and infrared transmission with 360° range
Probe contact	Ø 40 mm or Ø 25 mm	
Protection EN 60529	IP67	

SE transceiver units

- The following transceiver units are available for **wireless signal transmission**:
- **SE 540**: for integration in spindle head; only infrared transmission
  - **SE 642**: shared SE for TS and TT; only infrared transmission
  - **SE 660**: shared SE for TS and TT; radio and infrared transmission
  - **SE 661**: shared SE for TS and TT; radio and infrared transmission, EnDat interface for touch probes

With wireless signal transmission these touch probes are also suited for use on machines with automatic tool changer.

The SE 661 transceiver unit and the TS 460 and TT 460 touch probes are available with the EnDat interface. The EnDat interface from HEIDENHAIN is a digital, bidirectional interface that transmits the trigger status as well as diagnostic information and additional data from the touch probe. Thanks to the interface's serial transmission method, multiple items of data can be transmitted simultaneously.



SE 660



SE 661



SE 540



SE 642

	SE 660	SE 661	SE 540	SE 642
TS 460	Radio/infrared		Infrared	
TS 642	Infrared	–	Infrared	
TS 740	–		Infrared	
TT 460	Radio/infrared		Infrared	

Signal transmission types and combinations of TS, TT, and SE

Evaluation electronics units

Evaluation electronics for metrology 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 measuring and testing tasks

Digital readouts

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 and special machines—in fact all machines where axis slides are moved manually. This includes radial drilling machines and rapid radial drilling machines

Digital readouts for manual machine tools increase your productivity. They save time and increase the dimensional accuracy of the finished workpiece while offering very 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.



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 when additional interpolation of the signals is necessary.



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
- Intuitive operation using touchscreen or keyboard (depending on the product)
- All-in-one device with compact outside dimensions
- Sturdy aluminum housing
- Reference mark evaluation for distance-coded and single reference marks
- Problem-free installation, maintenance-free operation
- Fast payback with economical use

Evaluation electronics and 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 measuring and testing tasks	ND 287 GAGE-CHEK 2000 ND 2100 G GAGE-CHEK EIB 700 IK 220	64
Digital readouts for manually operated machine tools		
For milling machines, lathes, and positioning devices	POSITIP 8000 ND 7000 ND 5000	66
Interface electronics, inspection and test equipment		67



# 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 2100 G, 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 **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 287	GAGE-CHEK 2000	ND 2100 G GAGE-CHEK	EIB 700	IK 220
Application	<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>	<ul style="list-style-type: none"><li>• Multipoint inspection apparatuses</li><li>• SPC inspection stations</li></ul>	<ul style="list-style-type: none"><li>• Inspection stations</li><li>• Multipoint inspection apparatuses</li><li>• Mobile data acquisition</li></ul>	<ul style="list-style-type: none"><li>• Measuring and inspection stations</li></ul>
Axes <sup>1)</sup>	1 (optional 2)	3	4 or 8	4	2
Encoder inputs	$\sim 1 V_{PP}$ , $\sim 11 \mu A_{PP}$ , or EnDat 2.2	$\sim 1 V_{PP}$ , $\sim 11 \mu A_{PP}$ , EnDat 2.2 or $\square$ TTL	$\sim 1 V_{PP}$ , $\square$ TTL, EnDat 2.2, LVDT, or HBT (other interfaces upon request)	$\sim 1 V_{PP}$ , EnDat 2.1, EnDat 2.2, or $\sim 11 \mu A_{PP}$	$\sim 1 V_{PP}$ , $\sim 11 \mu A_{PP}$ , EnDat 2.1, or SSI
Display	Screen	7-inch screen for multitouch operation	5.7-inch screen	By PC screen	
Function	<ul style="list-style-type: none"><li>• Sorting and tolerance checking</li><li>• Measurement series with minimum and maximum value recording</li><li>• Functions for statistical process control (SPC)</li><li>• Graphic display of measurement results</li><li>• Storage of measured values</li></ul> <p>Optional: Sum/difference display or thermal compensation</p>	<ul style="list-style-type: none"><li>• Measurement series with minimum and maximum value recording</li><li>• Touch probe connection for a HEIDENHAIN or Renishaw touch probe</li><li>• Manual, continuous, or touch-probe-triggered data transfer</li><li>• User administration</li><li>• Dial gage for a graph of the measured value</li><li>• Diameter/radius display</li><li>• Relative measurement</li><li>• Probing functions</li></ul>	<ul style="list-style-type: none"><li>• Sorting and tolerance checking</li><li>• Measurement series with minimum and maximum value recording</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>• Precise position measurement; updating rate of up to 50 kHz</li><li>• Programmable measured-value inputs</li><li>• Internal and external measured-value triggers</li><li>• Measured-value memory for typically 250 000 measured values per channel</li><li>• Standard Ethernet interface connection 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>
Data interfaces	USB; RS-232-C; optional: Ethernet	Ethernet, USB, RS-232-C <sup>2)</sup>	USB; RS-232-C	Ethernet	PCI (PC interface)

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

<sup>2)</sup> Possible with RS-232 adapter connection over USB port

# 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

HEIDENHAIN offers the appropriate digital readout for each of these machine types. The splash-proof front panel and the sturdy cast-metal housing make digital readouts from HEIDENHAIN impervious to the harshest of everyday shop conditions.



POSITIP 8000



ND 7000

	POSITIP 8000	ND 7000	ND 5000
Application	Milling, drilling, and boring machines and lathes		
Description	12.1-inch screen for multitouch operation, program memory, switching inputs and outputs (digital and analog)	7-inch screen for multitouch operation, switching inputs and outputs (digital and analog, depending on the version)	7-inch screen with operating keys
Axes	6, two of them as software option	3	3
Encoder inputs	$\sim 1 V_{PP}$ , $\sim 11 \mu A_{PP}$ , or EnDat 2.2	$\sim 1 V_{PP}$ , $\sim 11 \mu A_{PP}$ , or EnDat 2.2	TTL
Display step	10 $\mu m$ , 5 $\mu m$ , 1 $\mu m$ , or finer		5 $\mu m$ (with LS 328C/628C), 1 $\mu m$ (with LS 378C)
Presets	100		10
Tool data	For 100 tools		For 16 tools
Programming	Yes	No	
Functions	<ul style="list-style-type: none"><li>• Manual and MDI operation, graphical positioning aid, variable font size for display of position values</li><li>• User administration and data management</li></ul>		
	<ul style="list-style-type: none"><li>• Touch probe connection</li><li>• ACTIVE version: NC control of up to three axes (point to point), as software option</li></ul>	Touch probe connection	–
For milling or boring operation	<ul style="list-style-type: none"><li>• Hole patterns (circular and linear patterns)</li><li>• Roughing of rectangular pockets</li><li>• Probing functions for reference-point acquisition</li><li>• Switching functions</li></ul>		<ul style="list-style-type: none"><li>• Circle pattern, linear pattern</li><li>• Diagonal and arc milling</li></ul>
	ACTIVE version: controlling the spindle speed	I/O version: controlling the spindle speed	–
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>• Freezing tool position for back-off/taper calculator</li><li>• Switching functions</li></ul>		
	ACTIVE version: constant cutting speed	I/O version: constant cutting speed	–
Data interfaces	Ethernet, USB		USB

# Interface electronics, inspection and testing devices

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

Incremental signals  
 $\sim 1 V_{PP}$  >  $\square$  TTL  
 $\sim 11 \mu A_{PP}$  >  $\square$  TTL

Incremental signals > position values  
 $\sim 1 V_{PP}$  > EnDat  
 $\sim 1 V_{PP}$  > Fanuc Serial Interface  
 $\sim 1 V_{PP}$  > Mitsubishi high speed Interface

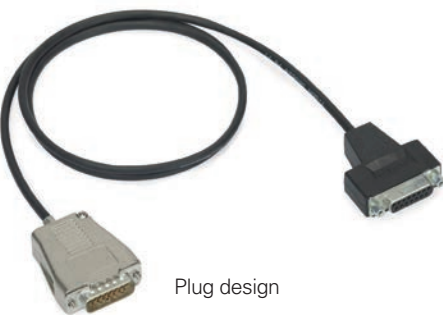
Position values  
EnDat > DRIVE-CLiQ  
EnDat > Yaskawa Serial Interface  
EnDat > PROFIBUS DP  
EnDat > PROFINET

The interface electronics perform signal conversion and interpolate the sinusoidal encoder signals. This permits finer measuring steps, resulting in higher control quality and superior positioning behavior.

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

HEIDENHAIN interface electronics are available in various mechanical designs:

- Box design
- Plug design
- Version for integration
- Top-hat rail design



Plug design

**Inspection and testing devices from HEIDENHAIN**  
HEIDENHAIN encoders provide all of the information needed for commissioning, monitoring, and diagnostics. HEIDENHAIN offers the appropriate PWM inspection devices and PWT testing devices for encoder adjustment and analysis. The PWM inspection devices can be used universally. They have low measuring tolerances and can be calibrated.

Testing devices have larger measuring tolerances, fewer available functions, and cannot be calibrated.

HEIDENHAIN encoders can usually be connected directly or via interface electronics to a number of different subsequent electronics.

HEIDENHAIN therefore offers encoders and interface electronics with various interfaces. The testing and inspection devices from HEIDENHAIN also support various interfaces, which makes their application more flexible (see overview for the PWM 21 and PWT 101).

Encoder input	PWM 21	PWT 101
EnDat 2.1	✓	✓
EnDat 2.2	✓	✓
DRIVE-CLiQ	✓	–
Fanuc Serial Interface	✓	✓
Mitsubishi high speed interface	✓	✓
Yaskawa Serial Interface	✓	✓
Panasonic Serial Interface	✓	✓
SSI	✓	–
1 V <sub>PP</sub> /TTL/11 $\mu A_{PP}$	✓	✓
1 V <sub>PP</sub> with Z1 track	✓	✓
HTL (via signal adapter)	✓	–



PWM 21 inspection device with included ATS adjusting and testing software



PWT 101 testing device for mobile application

DRIVE-CLiQ is a registered trademark of SIEMENS AG.



## Brochures, data sheets, and CD-ROMs

The products shown here 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 [www.heidenhain.de](http://www.heidenhain.de) you will find not only these brochures in various languages, but also a great deal of further up-to-date information on the company and its products.

Our website 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  
**Exposed Linear Encoders**

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



Brochure  
**Length Gauges**

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

## 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  
**Modular Angle Encoders**  
*With Optical Scanning*

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



Brochure  
**Modular Angle Encoders**  
*with Magnetic Scanning*

Contents:  
Incremental encoders  
**ERM**



Brochure  
**Angle Encoder Modules**

Contents:  
Angle encoder modules  
**MRP 2000/MRP 5000/MRP 8000**  
Angle encoder modules with integrated torque motor  
**SRP 5000, AccurET**

## 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



Brochures  
**MANUALplus 620 Contouring Control**  
**CNC PILOT 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



OEM brochures  
**MANUALplus 620 Contouring Control**  
**CNC PILOT 640 Contouring Control**

Contents:  
Information for the machine tool builder

## Measured value acquisition and display



Brochure  
**Evaluation Electronics**  
*For Metrology Applications*

Contents:  
**ND, QUADRA-CHEK, EIB, IK**



Product Overview  
**Interface Electronics**



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

Contents:  
Digital readouts  
**ND, POSITIP**  
Linear encoders  
**LS**

## Setup and measurement



Brochure  
**Touch Probes**

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



Brochure  
**Measuring Devices For Machine Tool**  
**Inspection and Acceptance Testing**

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

## Connecting encoders and touch probes



Brochure  
**Cables and Connectors**

Contents:  
Technical properties, cable overviews, and cable lists

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