

WY-250L

NAKAMURA-TOME
PRECISION INDUSTRY CO.,LTD.

Ideal for Long
Workpieces

Innovative
Technology

~ Creating new values ~

WY-250L

A multitasking machine with opposed twin spindles, featuring a Y-axis on both upper and lower turrets as standard.

Cycle times are reduced by utilizing simultaneous machining on the L/R spindles with the upper and lower turrets.

Long bed specifications with an 8-inch class chuck. It accommodates a wide range of machining operations, including long workpieces.

- Milling and Y-axis standard equipped on upper and lower turrets
- Milling motor 5.5/3.7kW(op.)
- Milling spindle speed 6,000min⁻¹
- Tool capacity of up to 48 tools
- Cycle times are reduced by utilizing simultaneous machining on the L/R spindles with the upper and lower turrets.
- Large variety of software

S×2
Twin Spindle

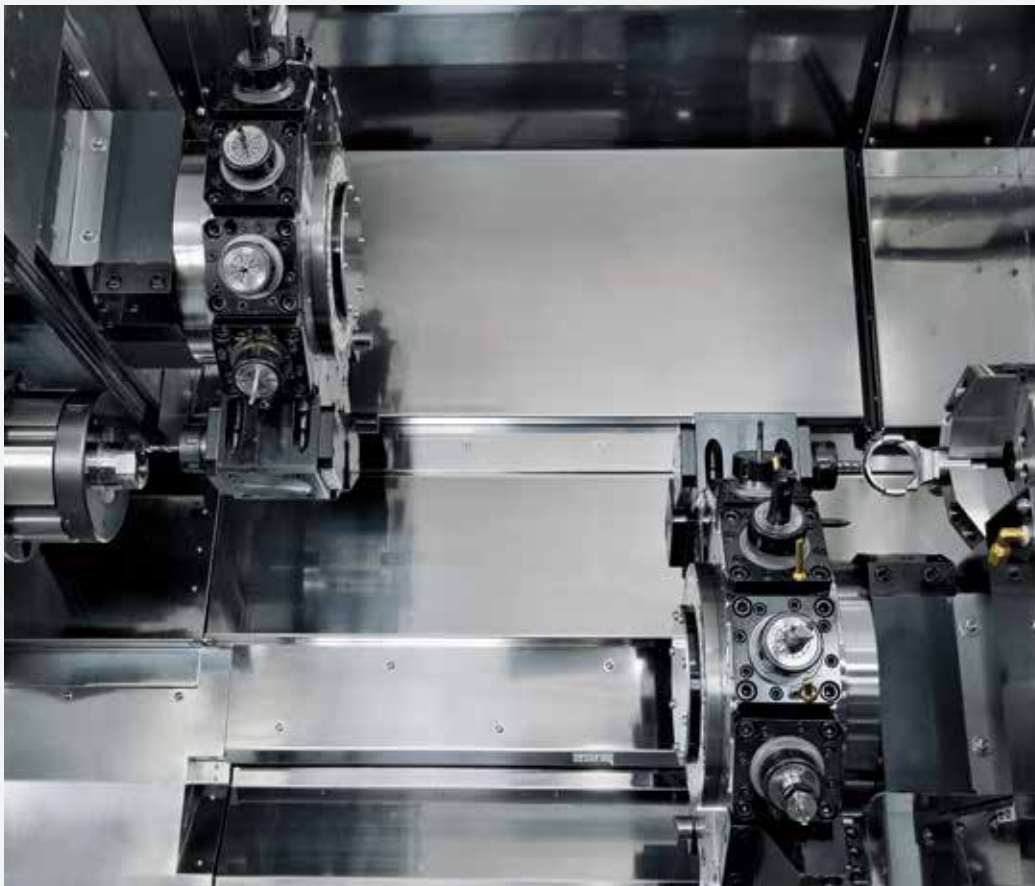
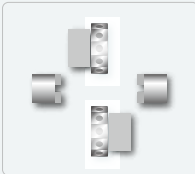
M×2
Milling Motor

B₂
R-spindle

C×2
C-axes

Y×2
Y-axes

T×2
Double Turrets



Long Bed Design Ideal for Long Workpieces

L-spindle

Bar capacity $\phi 65\text{mm}$	
Standard	Option
Spindle motor	Spindle motor
18.5/11kW	26/22kW ^{*1}
4,500min ⁻¹	4,500min ⁻¹

Bar capacity $\phi 71\text{mm}$	
Option	Option
Spindle motor	Spindle motor
18.5/11kW	26/22kW ^{*1}
4,000min ⁻¹	4,000min ⁻¹

Bar capacity $\phi 80\text{mm}$	
Option	Option
Spindle motor	Spindle motor
18.5/11kW	26/22kW ^{*1}
3,500min ⁻¹	3,500min ⁻¹

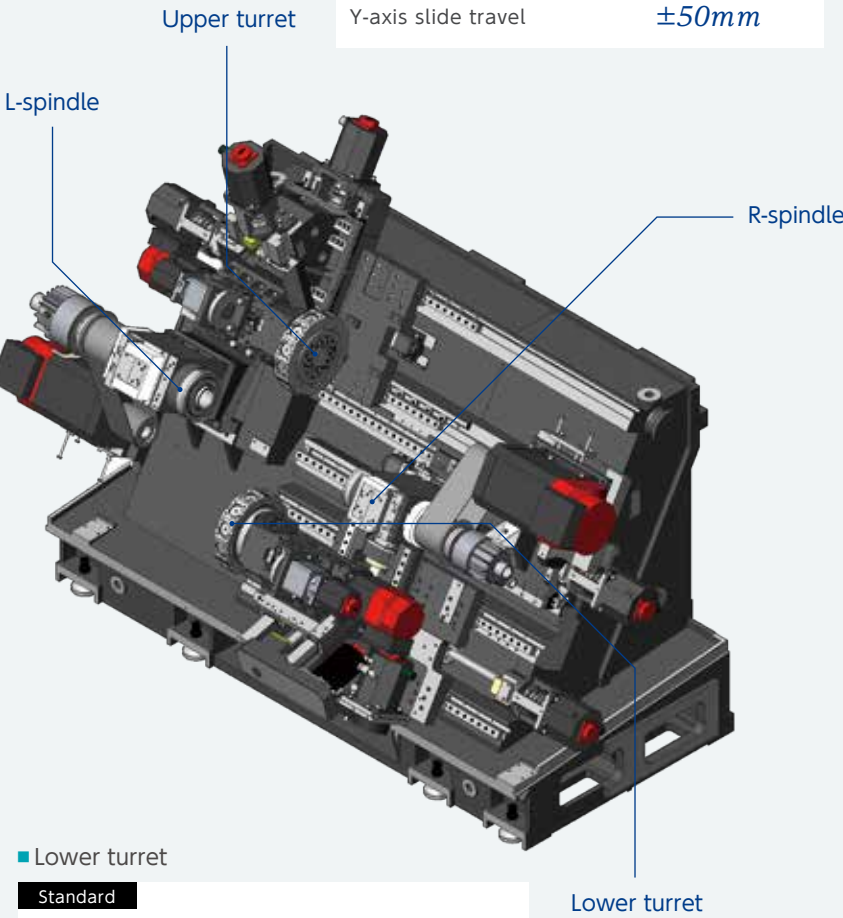
^{*1} R-spindle is automatically upgraded to 18.5/15kW

Milling and Y-axis standard
equipped on upper and lower turrets



Upper turret

Standard	
Type of turret head	Dodecagon
Number of milling stations / Number of indexing positions	12/24
Milling motor	5.5/3.7kW
	6,000min ⁻¹
Y-axis slide travel	$\pm 50\text{mm}$



Lower turret

Standard	
Type of turret head	Dodecagon
Number of milling stations / Number of indexing positions	12/24
Milling motor	5.5/3.7kW
	6,000min ⁻¹
Y-axis slide travel	-50, +20mm

Large window for
easy viewing of
the machining area

The door windows are
equipped with wipers
that keep the windows
clean.



Tool setter(op.)



NT SmartX
19 inch touch screen

With a movable operation
panel, the angle can now be
adjusted by the operator.



R-spindle

Bar capacity $\phi 51\text{mm}$	
Standard	Option
Spindle motor	Spindle motor
15/11kW	18.5/15kW ^{*2}
5,000min ⁻¹	5,000min ⁻¹

Bar capacity $\phi 65\text{mm}$	
Option	Option
Spindle motor	Spindle motor
15/11kW	18.5/15kW ^{*2}
4,500min ⁻¹	4,500min ⁻¹

^{*2} L-spindle is automatically upgraded to 26/22kW



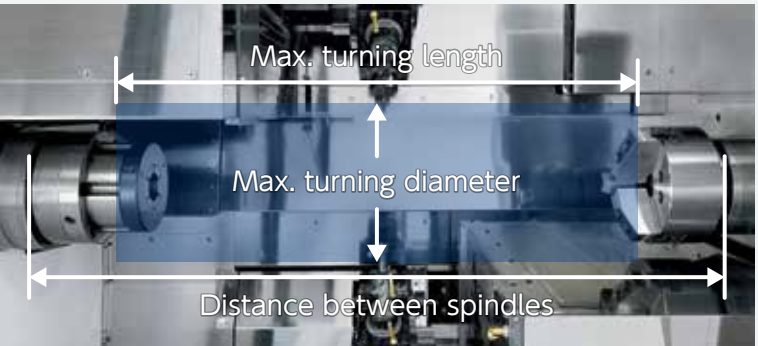
Max. turning length 910mm

Max. turning diameter $\phi 225\text{mm}$

^{*}L-spindle: $\phi 65$, $\phi 71$ specifications

Bar capacity(L) $\phi 65\text{mm}$
(op. $\phi 71$, $\phi 80$)

Distance between spindles Max. 1,200mm
Min. 255mm



■ Capacity	φ51	φ65	φ71(op.)	φ80(op.)
Max. turning diameter	225mm			180mm
Max. turning length	910mm			
Distance between spindles	max. 1,200mm / min. 255mm			
Bar capacity	L	-	φ65mm	φ71mm(op.)
	R	φ51mm	φ65mm(op.)	-
Chuck size	L	-	8"	8"
	R	6"	6"	-

■ Axis travel

X1-axis slide travel	160.5mm	143.5mm
X2-axis slide travel	165mm	
Z1-axis slide travel	910mm	
Z2-axis slide travel	910mm	
Y1-axis slide travel	±50mm	
Y2-axis slide travel	-50mm, +20mm	
B2-axis slide travel	945mm	

■ Rapid feed

X-axis rapid feed rate	18m/min
Z-axis rapid feed rate	40m/min
Y-axis rapid feed rate	10m/min
B2-axis rapid feed rate	40m/min

■ L-spindle

Spindle speed	-	4,500min ⁻¹	4,000min ⁻¹	3,500min ⁻¹
Spindle speed range	-	Stepless	Stepless	Stepless
Spindle nose	-	A2-6	A2-6	A2-8
Hole through spindle	-	80mm	80mm	90mm
I.D. of front bearing	-	110mm	110mm	120mm
Hole through draw tube	-	66mm	72mm	81mm

■ R-spindle

Spindle speed	5,000min ⁻¹	4,500min ⁻¹	-	-
Spindle speed range	Stepless	Stepless	-	-
Spindle nose	A2-5	A2-6	-	-
Hole through spindle	63mm	80mm	-	-
I.D. of front bearing	90mm	110mm	-	-
Hole through draw tube	52mm	66mm	-	-

■ C-axis

Least input increment	0.001°
Least command increment	0.001°
Rapid speed	600min ⁻¹
Cutting feed rate	1-4,800° /min
C-axis clamp	Disk clamp
C-axis connecting time	1.5s

■ Upper/Lower turret	φ51	φ65	φ71(op.)	φ80(op.)
Type of turret head	Dodecagonal drum turret			
Number of indexing positions	24			
Tool size (square shank)	□25mm			
Tool size (round shank)	φ32mm			

■ Milling

Rotary system		Individual rotation
Milling spindle speed		6,000min ⁻¹
Spindle speed range		Stepless
Number of milling stations		12
Holder type and Tool size	Straight holder	φ1mm ~ φ16mm
	Cross holder	φ1mm ~ φ16mm

■ Drive motor

L-spindle	18.5/11kW
	26/22kW (op. R-spindle is automatically upgraded to 18.5/15kW)
R-spindle	15/11kW
	18.5/15kW (op. L-spindle is automatically upgraded to 26/22kW)
Milling	5.5/3.7kW

■ General

Height	2,395mm
Floor space (W × D)	4,620mm × 2,593mm
Machine weight (incl. control)	13,000kg

■ Power supply

Power supply	52.9kVA
Air supply	400NL/min, 0.5 ~ 0.7MPa

● Safety quality specifications

Various interlocks, such safety fences, auto extinguisher devices, and other safety related equipment may be required. These have to be selected during the configuration of the machine.

- ① Safety devices include electromagnetic door lock, chuck interlock, hydraulic pressure switch, air pressure switch, short circuit breaker and quill interlock. (Door interlock and chuck interlock are standard equipment.)
- ② In case of automation, various safety fences may be required, such as work stocker safety fences, robot safety fences, ...etc.

During the configuration of machine specifications, please discuss these requirements with the Nakamura-Tome machine sales representative.

● Precautions on the use of cutting fluids and lubricating oils

- Some types of cutting fluids (coolant) are harmful to machine components, causing damages such as peeling of paint, cracking of resin, expanding of rubber, corrosion and rust build up on aluminum and copper.
To avoid causing damage to the machine, never use synthetic coolants, or any coolants containing chlorine. In addition, never use coolants and lubricating oils which contain organic solvents such as butane, pentane, hexane and octane.



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