### MACHINING CENTER

- **YBM640V**
  - 3-ɿ890 2-ɿ610 2-ɿ065 3-ɿ160
  - 2-ɿ880
  - 3-ɿ9291 2-ɿ350
  - 2-ɿ081

- **YBM950V**
  - 3-ɿ635 2-ɿ295

- **YBM9150V**
  - 2-ɿ081

- **YBM1218V**
  - 3-ɿ8442 2-ɿ8442

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**YASDA**

YASDA PRECISION TOOLS Inc. (USA) Division Office

- **MOLDEDIE MILLER**
  - YBM640V
  - YBM950V
  - YBM9150V
  - YBM1218V

**YASDA CNC JUBIER**

YASDA PRECISION TOOLS America Corporation

- **CNC JUBIER**
  - YBM640V
  - YBM950V
  - YBM9150V
  - YBM1218V
YASDA’s mission: Uncompromising spirit going for higher precision machining.
Our know-how and skill based on long experience creates innovative and state-of-the art technologies.

- YASDA V-series has achieved wide range of machining, from heavy-duty cutting to highly accurate finish cutting at the highest accuracy level achievable in the market. YASDA Prescut self-adjusting system ensures high probability of machining all the time.
- YASDA V-series has Thermal distortion stabilising system as standard (as option for additional machine components) and it helps sustain the highest accuracy of the machine performance all the time.
- YASDA V-series has high speed machining function RAS-3 (Highly Accurate and Speedy machining system) RAS-3 together with careful manufacturing process of the machine; it becomes possible to finish the final machined work pieces exactly reflecting the program from CNC control.
Outstanding high speed and high precision die and mold machining and high productivity with compact machine design

YASDA CNC JIGBORER

**YBM 640V Ver. II**
MOLD& DIE MILLER

YBM640V provides the highest accuracy and profitability available in market, showing excellent performance in hard milling of die & mold, highly accurate mold base machining and other versatile purposes.

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YASDA CNC JIGBORER

**YBM 950V Ver. II**
MOLD & DIE MILLER

YBM950V has larger capacity than 640V and responds to a broad range of customer needs. YASDA designed options for automation like PLS (Preload Stand) ensures highest accuracy with multiple applications.
YASDA’s classical accuracy with larger work area

YASDA CNC JIGBORER
YBM 9150V
MOLD&DIE MILLER

YBM 9120V has excellent performance in mold base application. Its high performance will help reduce total manufacturing time and its process cost a lot.

YASDA CNC JIGBORER
YBM 1218V
MOLD&DIE MILLER

YBM 1218V has BT50 preload self-adjusting system spindle and promise highest accuracy for large size of components. Excellent mechanical design supports stability of the highest accuracy all the time.

Mechanical construction of YBM640Vver.Ⅲ and YBM950Vver.Ⅲ
Most rigid bridge type construction with symmetric design

Ideal base structure drawing versatile machining performance with highest accuracy

Weight of spindle head and saddle units are improved for higher responsibility.

Highly rigid box and roller guide ways straightness within 2μm with high surface roughness.

Bridge type symmetric construction with minimum thermal deformation. Improved its rigidity by employing one unit solid cast iron construction, by which column and top beam are formed together for higher rigidity.

Highly rigid feed drive with big diameter ball screws, supporting high accuracy and high response for precise die and mold machining.

YASDA guide ways are assembled horizontally on top beam, promising highest accuracy all the time due to the two main reasons:

1. This design is easier to adjust mechanical accuracy.
2. The center of gravity stays in the top beam, preventing torsion movement of the top beam, and minimizing its posture distortion.
YASDA's classical accuracy with larger work area

**YASDA CNC JIGBORER**

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MOLD&DIE MILLER

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**YASDA CNC JIGBORER**

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MOLD&DIE MILLER

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---

**Mechanical construction of YBM640V Ver.II and YBM950V Ver.II**

Most rigid bridge type construction with symmetric design

Ideal base structure drawing versatile machining performance with highest accuracy

- Weight of spindle head and saddle units are improved for higher responsibility.
- Highly rigid box and roller guide ways straightness within 2μm with high surface roughness.
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Mechanical construction of YBM 1218V

Highly rigid construction helps sustain the highest accuracy available in market with BT50 spindle

Improved rigidity of spindle related units, employing YASDA hybrid (box & roller) guide ways

Z-axis travel mechanism together with cross rail unit
In order to sustain the highest accuracy in large size working area, Z-axis mechanism is moved with the cross rail unit, which is different from ram-type head stock seen in market, which has reduced spindle rigidity.

YASDA hybrid (box & roller) guide ways
Excellent combination of slide surface and roller units ensures superb damping capability in high speed and high precision machining. Also high surface roughness on the guide ways ensures high response in 3 dimensional machining.

One unit solid bridge construction
Solid bridge with symmetric design is mounted on hand scraped surface of the machine bed. Outstandingly stiff machine construction supports heavy duty machining with BT50 spindle stable, draws the best performance of cutting tools and helps save total running cost.

YASDA’s original mechanism to ensure high precision rotation for full range of its spindle rotation

Preload self-adjusting system
(Model: SA type)
Yasda’s exclusive preload self-adjusting system technology provides a large preload at low speed and reduces the preload according to the heat generated by higher speed. This mechanism creates a clearer advantage over the conventional fixed type preload system.

1. An appropriate preload for full range of the spindle speed achieves both heavy-duty cutting at low rpm, and highly accurate finish cutting at high rpm precisely all the time.
2. Spindle unit and Spindle motor are connected coaxially by a diaphragm coupling, in order to achieve high precision rotation of the spindle throughout the full speed range of the spindle.
3. YASDA spindle performs at the best machining condition regardless of various cutting resistances like high hex angle cutting with ball end mill or back face machining.

Spindle motor
YASDA spindle motor employs a two coil changeover type winding, and helps high torque drive at both of high and low spindle speeds.

Thermal deformation control system in the spindle head
Spindle head and saddle of the machine contain the largest exothermic parts such as spindle, spindle motor and feed motor. This is why machining centers suffer from thermal distortion which can easily result in inconsistent machining accuracy. YASDA’s design prevents such distortion by circulating heat exchange fluid throughout the spindle head, controlling the temperature of spindle head following the sensor for reference room temperature.
Mechanical construction of YBM 1218V

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Advanced thermal control system

Thermal distortion stabilizing system
Temperature-controlled (±0.2°C to reference room temperature) heat exchanged fluid circulates throughout the main structure, bridge saddle and spindle head, of the machine. This system is equipped in the spindle head and the saddle unit as standard, and in the bridge as an option.
Die and Mold samples created by YASDA CNC JIGBORER V SERIES

Hard milling: Machining from solid blocks and finishing high precision dies and molds. This results in saving total processing time and cost as well as improving profitability.
The state of the art: YASDA mechanical construction supporting highest accuracy

- Carefully finished hardened guide ways are mounted precisely on the hand scraped machine base. YASDA commits itself with skilled know-how to finishing perfectly smooth and precise guide ways, and mounting these on the carefully hand-scraped machine base. Guide ways are through hardened and carefully lapped after grinding process to increase its surface roughness.

![Diagram of measuring points and measured values](Image)

Positioning accuracy

<table>
<thead>
<tr>
<th>Measured value</th>
<th>0.0001mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>0-500</td>
<td>0.0000</td>
</tr>
<tr>
<td>500-1000</td>
<td>0.0000</td>
</tr>
<tr>
<td>1000-1500</td>
<td>0.0000</td>
</tr>
<tr>
<td>1500-2000</td>
<td>0.0000</td>
</tr>
<tr>
<td>2000-2500</td>
<td>0.0000</td>
</tr>
</tbody>
</table>

YASDA CNC Jig Borer shows error of positioning accuracy 1μm or less in 10μm step feed. This accuracy performance proves that each axis is smoothly controlled without stick slip and that the performance of the machines is outstandingly reliable. Longer tool life and smooth finished surface of die and mold components are expected from this excellent result.

- Pallet chucking mechanism

YASDA pallet chucking system is designed with highly rigid pallet of 120mm thickness (in case of tapped holes surface) and it is supported by a large diameter curvic coupling mechanism (for YBM640Vnx, YBM950Vnx).

- Top surface of the pallet, made of high quality cast iron, is precisely hand-scraped ensuring highest accuracy. The bottom of the pallet is flat and flexible to use with transporting system like automatic warehouse or FMS systems.

- Curvic coupling with large diameter is employed for pallet chucking system of YBM640Vnx. This curvic coupling system has 72 teeth with 30 degree engagement angle. When these teeth are engaged, the center of the curvic coupling is automatically located. By this design, high repeatability and rigidity of pallet change is assured.

- Ball screw bracket

Brackets mating faces for ball screws are carefully hand scraped in order to maintain the ultimately right angle to the guide ways when the ball screws are assembled. By this process, high rigidity of thrust bearings are maintained and ensures outstanding performance with highest accuracy and reliability.

- Optical scale feedback

YASDA employs specially ordered optical scales for highly accurate positioning. These optical scales have minimum increment of 0.0001mm.

![Diagram of YBM640Vnx, YBM950Vnx, YBM9150V, YBM1218V](Images)
The state of the art: YASDA mechanical construction supporting highest accuracy

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---

**YBM640V**
- TABLE: 600 x 600
- 340 x 340
- 160 x 160
- 80 x 80

**YBM950V**
- TABLE: 700 x 700
- 340 x 340
- 160 x 160
- 80 x 80

**YBM9150V**
- TABLE: 1000 x 1000
- 340 x 340
- 160 x 160
- 80 x 80

**YBM1218V**
- TABLE: 1200 x 1200
- 340 x 340
- 160 x 160
- 80 x 80
ATC (Automatic Tool Changer)

YBM640V

Simple and armless changing system
Reliable armless tool changing system is employed for NT no. 40 tool change. Tools are changed directly with the stroke of tool magazine itself. Tool magazine is stored inside the machine behind the spindle, and automatic ATC door prevents chips and foreign objects coming to the tool magazine and putting on tool holders.

YBM218V

Big tool capacity in a compact size
Maximum 240 tools are possible to store (option), ensuring enough capability in automation like pallet changing system.

YASDA employs large diameter curvic coupling for APC and ensure highest repeatability in pallet changing all the time, which is vital for automatic pallets management.

PLS (Preload Stand) is designed for easier work setting, and enables managing more works automatically with the same high accuracy.

YBM950V

Space saving but more tools with high efficiency
For tools capacity 108 to 180 tools, fixed pot type vertical panel magazines are employed in order to save floor space. This system supports complex parts machining as well as ability to manage different kinds of works in a short process time.
**ATC (Automatic Tool Changer)**

**YBM640Vnr/950Vnr**

**Simple and armless changing system**
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**YBM1218V**

**Big tool capacity in a compact size**
Maximum 240 tools are possible to store (option), ensuring enough capability in automation like pallet changing system.

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**APC**

**PLS**

**YBM640Vnr.3**

**YBM640Vnr.5**

**YBM950Vnr.3**

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For tools capacity 108 to 180 tools, fixed pot type vertical panel magazines are employed in order to save floor space. This system supports complex parts machining as well as ability to manage different kinds of works in a short process time.
### SPECIFICATIONS

<table>
<thead>
<tr>
<th>1. Standard specifications of base machines</th>
<th>YBM640V</th>
<th>YBM950V</th>
<th>YBM915V</th>
<th>YBM1218V</th>
</tr>
</thead>
</table>

#### 1) Travel

<table>
<thead>
<tr>
<th>Axis</th>
<th>Travel (mm)</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>X-axis</td>
<td>600</td>
<td>900</td>
</tr>
<tr>
<td>Y-axis</td>
<td>400</td>
<td>500</td>
</tr>
<tr>
<td>Z-axis</td>
<td>350</td>
<td>350</td>
</tr>
</tbody>
</table>

#### 2) Table

<table>
<thead>
<tr>
<th>Description</th>
<th>YBM640V</th>
<th>YBM950V</th>
<th>YBM915V</th>
<th>YBM1218V</th>
</tr>
</thead>
<tbody>
<tr>
<td>Table working surface (mm)</td>
<td>700x450</td>
<td>1,000x500</td>
<td>1,800x900</td>
<td>1,800x1,200</td>
</tr>
<tr>
<td>Table surface configuration</td>
<td>Width:18mm, pitch:125mm</td>
<td>Width:18mm, pitch:150mm</td>
<td>Width:18mm, pitch:150mm</td>
<td>Width:22mm, pitch:150mm</td>
</tr>
</tbody>
</table>

#### 3) Spindle

<table>
<thead>
<tr>
<th>Description</th>
<th>YBM640V</th>
<th>YBM950V</th>
<th>YBM915V</th>
<th>YBM1218V</th>
</tr>
</thead>
<tbody>
<tr>
<td>Type</td>
<td>SA40-24000-18.5</td>
<td>SA40-24000-18.5</td>
<td>SA40-24000-18.5</td>
<td>SA50-10000-22</td>
</tr>
<tr>
<td>Spindle speed range (min&lt;sup&gt;-1&lt;/sup&gt;)</td>
<td>100—24,000</td>
<td>100—24,000</td>
<td>100—24,000</td>
<td>50—10,000</td>
</tr>
<tr>
<td>Number of spindle speed ranges</td>
<td>Direct drive</td>
<td>Direct drive</td>
<td>Direct drive</td>
<td>Direct drive</td>
</tr>
<tr>
<td>Spindle drive motor</td>
<td>AC18.5/23kW (cont.,15min. rating)</td>
<td>AC18.5/23kW (cont.,15min. rating)</td>
<td>AC18.5/23kW (cont.,15min. rating)</td>
<td>AC22kW (30min. rating)</td>
</tr>
<tr>
<td>Spindle nose taper</td>
<td>N.T.No.40</td>
<td>N.T.No.40</td>
<td>N.T.No.40</td>
<td>N.T.No.50</td>
</tr>
<tr>
<td>Spindle bearing inner diameter (mm)</td>
<td>65</td>
<td>65</td>
<td>65</td>
<td>100</td>
</tr>
</tbody>
</table>

#### 4) Feedrate

<table>
<thead>
<tr>
<th>Description</th>
<th>YBM640V</th>
<th>YBM950V</th>
<th>YBM915V</th>
<th>YBM1218V</th>
</tr>
</thead>
<tbody>
<tr>
<td>Rapid traverse rate</td>
<td>X-axis 20,000mm/min</td>
<td>X-axis 20,000mm/min</td>
<td>X-axis 20,000mm/min</td>
<td>X-axis 18,000mm/min</td>
</tr>
<tr>
<td>Feedrate</td>
<td>1—5,000mm/min</td>
<td>1—5,000mm/min</td>
<td>1—5,000mm/min</td>
<td>1—5,000mm/min</td>
</tr>
</tbody>
</table>

#### 5) Automatic tool changer (ATC)

<table>
<thead>
<tr>
<th>Description</th>
<th>Tool number</th>
<th>Type of tool shank</th>
<th>Type of pull stud</th>
<th>Max. dia. of tool (mm)</th>
<th>Max. length of tool (mm)</th>
<th>Max. mass of tool (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tool number</td>
<td>30 tools</td>
<td>MAS BT40</td>
<td>MAS P40T-1-145deg</td>
<td>100</td>
<td>250</td>
<td>7</td>
</tr>
<tr>
<td>Type of tool shank</td>
<td>30 tools</td>
<td>MAS BT40</td>
<td>MAS P40T-1-145deg</td>
<td>100</td>
<td>250</td>
<td>7</td>
</tr>
<tr>
<td>Type of pull stud</td>
<td>60 tools</td>
<td>MAS BT40</td>
<td>MAS P40T-1-145deg</td>
<td>100</td>
<td>250</td>
<td>7</td>
</tr>
<tr>
<td>Max. dia. of tool</td>
<td>32 tools</td>
<td>MAS BT50</td>
<td>MAS P45T-1-145deg</td>
<td>100</td>
<td>240</td>
<td>20</td>
</tr>
<tr>
<td>Max. length of tool</td>
<td>250mm</td>
<td>300mm</td>
<td>350mm</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Max. mass of tool</td>
<td>7kg</td>
<td>7kg</td>
<td>7kg</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

#### 6) Spindle head cooling system

<table>
<thead>
<tr>
<th>Description</th>
<th>Capacity (W)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Coolant capacity</td>
<td>6,000</td>
</tr>
</tbody>
</table>

#### 7) Cutting unit

<table>
<thead>
<tr>
<th>Description</th>
<th>YBM640V</th>
<th>YBM950V</th>
<th>YBM915V</th>
<th>YBM1218V</th>
</tr>
</thead>
<tbody>
<tr>
<td>Y-axis</td>
<td>6,000W</td>
<td>6,000W</td>
<td>6,000W</td>
<td>6,000W</td>
</tr>
</tbody>
</table>
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### OUTLINE

<table>
<thead>
<tr>
<th>Model</th>
<th>VBM640V</th>
<th>VBM950V</th>
<th>VBM9150V</th>
<th>VBM1218V</th>
</tr>
</thead>
<tbody>
<tr>
<td>STAND..</td>
<td>APPL..</td>
<td>STAND..</td>
<td>APPL..</td>
<td>APPL..</td>
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<td></td>
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</tr>
</tbody>
</table>

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- **YASDA PRECISION TOOLS K.K.**
  - URL: [http://www.yasda.co.jp](http://www.yasda.co.jp)

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  - Address: 3600 York Street, West Chester, OH 45069

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- **YASDA PRECISION TOOLS (MILAN)**
  - Address: Via della Catena 36/38, 20122 Milan, Italy

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  - Address: Rua São Bento, 1109, São Paulo, SP, Brazil

- **YASDA PRECISION TOOLS (TOKYO)**
  - Address: 1-chome, Ichigaya, Chiyoda-ku, Tokyo, 110-8501, Japan

- **YASDA PRECISION TOOLS (COPENHAGEN)**
  - Address: Vejlevej 108, 2750 Hørsholm, Denmark

- **YASDA PRECISION TOOLS (CHANDIGARH)**
  - Address: Unit 1, 2nd Floor, Jai Bhoom, Phase 1, Sector 17, Mohali, Punjab 160020, India

- **YASDA PRECISION TOOLS (MADRID)**
  - Address: Calle de Castilla, 7, 28001 Madrid, Spain

- **YASDA PRECISION TOOLS (BOLOGNA)**
  - Address: Via della Catena 36/38, 40122, Bologna, Italy

- **YASDA PRECISION TOOLS (STUTTGART)**
  - Address: Meßst他是 Strasse 1, 70176 Stuttgart, Germany

- **YASDA PRECISION TOOLS (OSAKA)**
  - Address: 2-11-8, Tani-cho, Abeno-ku, Osaka 545-8588, Japan

### Higher accuracy produces greater profitability