

WT-150V

NAKAMURA-TOME
PRECISION INDUSTRY CO.,LTD.

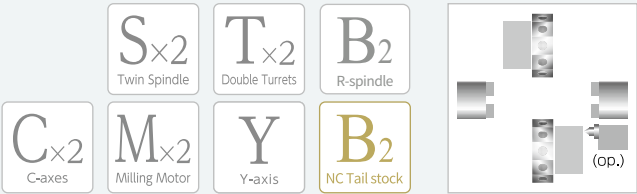
Faster than
the fastest

Innovative
Technology

~Creating new values~

WT-150V

A Nakamura-Tome standard machine equipped with upper and lower turrets and an opposed dual-spindle configuration. Cycle times are shortened through simultaneous machining with the L/R spindles and upper/lower turrets. A large variety of software and a compact installation footprint meet a wide range of production requirements.



30% Reduction in Cycle Time

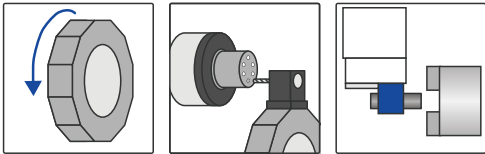
* Reduction time varies depending on the shape of the workpiece and cutting conditions.

Starting with the implementation of "ChronoCut" to reduce processing idle time, numerous new technologies have been incorporated to enhance production speed.

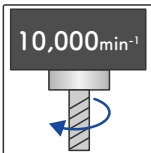


ChronoCut

A unique function by Nakamura-Tome designed to reduce idle time. This new software minimizes idle time during manufacturing without compromising accuracy, even without any changes to the cutting conditions.

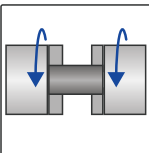


- High-speed indexing
- High-speed spindle synchronization
- Execution of multiple M-codes within the same block
- High-speed rigid tapping
- Reduction of PC-G unloading time, etc.



UP Machining conditions

By improving the machining capabilities of the milling speed, torque, and more, the machine achieves high performance under demanding conditions.



UP Acceleration / Deceleration

The acceleration and deceleration during starting and stopping have been improved, enabling quick attainment to the maximum speed.

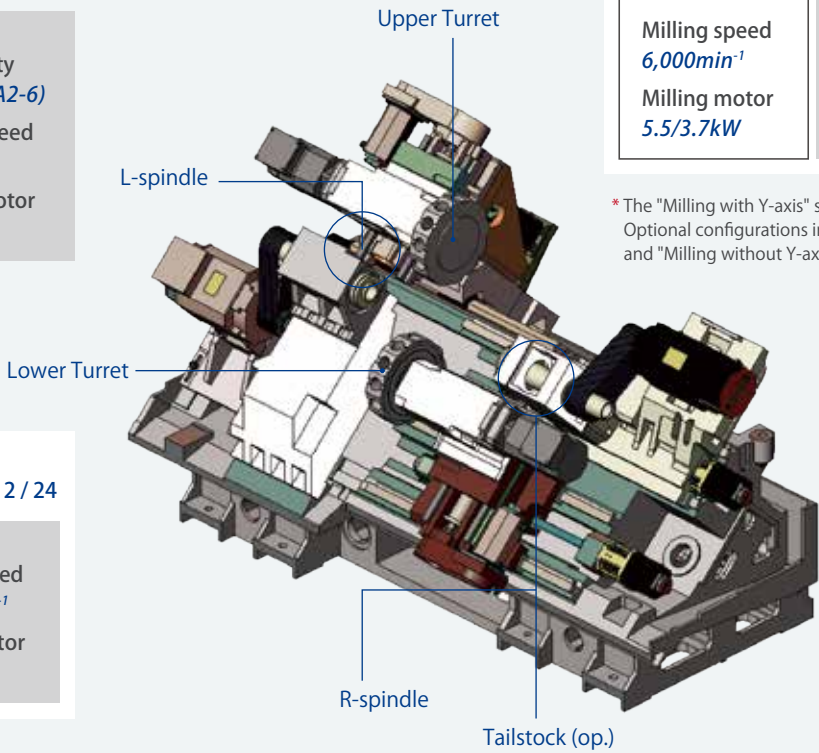
Cycle Times are Faster Thanks to Simultaneous Machining with the L/R Spindles and Upper/Lower Turrets.

L-spindle	
Standard	Option
Bar capacity φ51mm (A2-5)	Bar capacity φ65mm (A2-6)
Spindle speed 5,000min ⁻¹	Spindle speed 4,500min ⁻¹
Spindle motor 15/11kW	Spindle motor 15/11kW

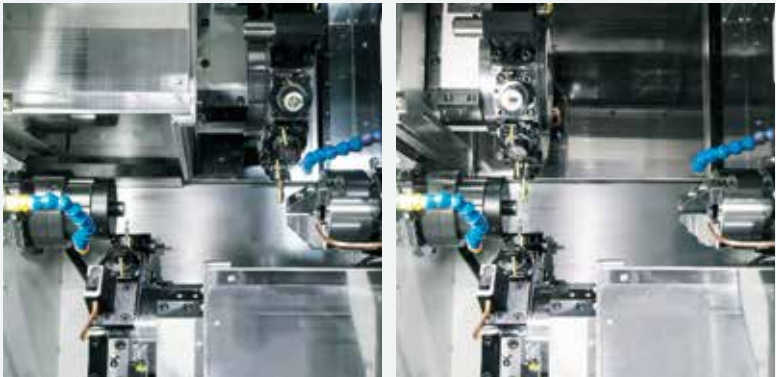
Lower turret	
Number of milling stations / Number of indexing positions 12 / 24	
Standard	Option
Milling speed 6,000min ⁻¹	Milling speed 10,000min ⁻¹
Milling motor 5.5/3.7kW	Milling motor 5.5/3.7kW

Upper turret	
Number of milling stations / Number of indexing positions 12 / 24	
Standard	Option
Y-axis slide travel ±35mm	
Standard	Option
Milling speed 6,000min ⁻¹	Milling speed 10,000min ⁻¹
Milling motor 5.5/3.7kW	Milling motor 5.5/3.7kW

* The "Milling with Y-axis" specification is standard. Optional configurations include "Without Milling" and "Milling without Y-axis."



Greater Machining Flexibility with Upper and Lower Turrets
Balancing left/right machining, reducing cycle times, and optimizing processes—we deliver the ideal machining performance our customers envision.



Tailstock (op.)	
Option	
Driving system	NC control servo-driven type
Quill taper	MT-3 (Built-in center) / MT-4 (Rotating center)
Range of thrust force	— 3.9kN

Stable cutting capacity ensured

Upper Turret	
L-spindle	
Cutting sectional area	3.6mm ²
Cutting depth	6mm
Feed	0.6mm/rev
Spindle speed	1,270min ⁻¹
Material	S45C (JIS)
R-spindle	
Cutting sectional area	2mm ²
Cutting depth	5mm
Feed	0.4mm/rev
Spindle speed	1,270min ⁻¹
Material	S45C (JIS)

Lower Turret	
L-spindle	
Cutting sectional area	3.3mm ²
Cutting depth	6mm
Feed	0.55mm/rev
Spindle speed	1,270min ⁻¹
Material	S45C (JIS)
R-spindle	
Cutting sectional area	2mm ²
Cutting depth	5mm
Feed	0.4mm/rev
Spindle speed	1,270min ⁻¹
Material	S45C (JIS)

* These data may change depending on actual cutting and environmental conditions.

High rigidity Y-axis slide

The Upper machine-structure was designed with the Y-axis in mind. High rigidity of the machine ensures maximum stability during heavy duty turning and milling with full power.



Parts Catcher Type A (op.)



Parts Catcher Type G		Option	
		φ51	φ65
Method		Swing / Gripper	
Part size	Diameter (mm)	φ12~51	φ12~65
	Length (mm)	12~150	
	Weight (kg)	3.0	
Ejecting method		Belt conveyor & Chute	

Capacity	φ51	φ65 (op. only L)
Max. turning diameter	190mm	
Standard turning diameter	170mm	
Distance between spindles	max.800mm / min.200mm	
Max. turning length	515mm	
Bar capacity	φ51mm	φ65mm
Chuck size	6", 8" *1	

Axis travel

X1 / X2 axis slide travel	167.5mm / 167.5mm	152.5mm / 167.5mm
Z1 / Z2 axis slide travel	515mm / 515mm	
Y-axis slide travel *2	±35mm	
B2-axis slide travel	600mm	
X-axis rapid feed rate	20m/min	
Z-axis rapid feed rate	40m/min	
B2-axis rapid feed rate	40m/min	
Y-axis rapid feed rate *2	6m/min	

L/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 *2

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

Type of turret head	Dodecagonal drum turret
Number of indexing positions	24
Tool size (square shank)	□25mm
Tool size (round shank)	φ32mm

*1 There are limitations on tooling.

*2 The "Milling with Y-axis" specification is standard.
Optional configurations include "Without Milling"
and "Milling without Y-axis."

Milling *2

Rotary system	Individual rotation	
Milling spindle speed	6,000min ⁻¹ / 10,000min ⁻¹ (op.)	
Spindle speed range	Stepless	
Number of milling stations	12	
Collet size	AR25	
Holder type and Tool size	Straight	φ1mm- φ16mm
	Cross	φ1mm- φ16mm

Tailstock (op.)

Driving system	NC control servo-driven type
Travel	600mm
Rapid feed rate	24m/min
Quill taper	MT-3(Built-in center) / MT-4(Rotating center)
Ball screw diameter / Ball screw pitch	32mm / 8mm
Range of thrust force	- 3.9kN

Drive motor

L-spindle	15/11kW
R-spindle	11/7.5kW
Milling	5.5/3.7kW

General

Height	1,858.5mm
Floor space (W × D)	3,675mm×2,258.2mm
Machine weight (incl. control)	9,000kg

Power supply

Power supply	37.9kVA
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Safety quality specifications

Various interlocks, such as 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 the 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, expansion 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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