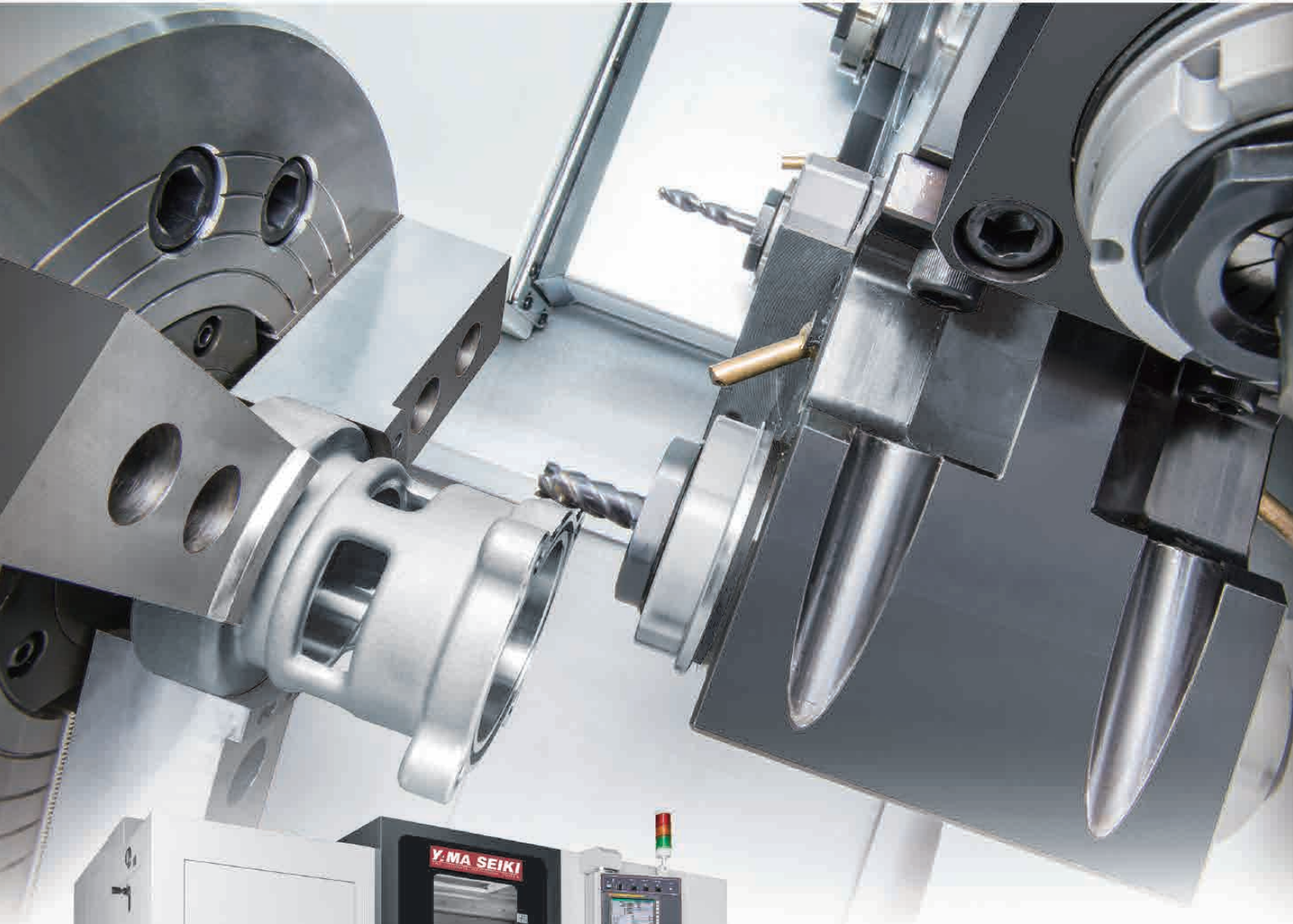


# GLS-3000 SERIES

High Speed CNC Turning Center

[www.YAMASEIKI.com](http://www.YAMASEIKI.com)



**YMA SEIKI**  
TURNING CENTERS by **GOODWAY**

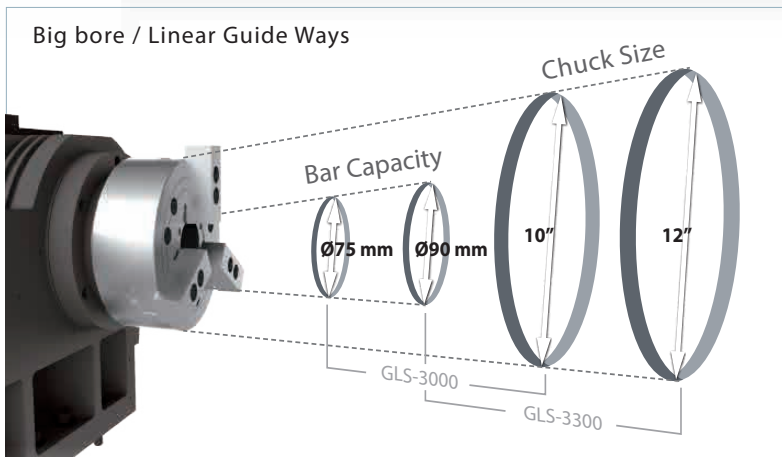
# HIGH SPEED CNC TURNING CENTERS

With the latest machine tools technology and high quality components, YAMA SEIKI brings you the new GLS-3000 series high speed CNC turning center. This series is based on high precise linear guide ways and featured big bore, high power, fast cut and more to provide you machining solution with high efficiency cutting power. Besides, The GLS-3000 series equipped with an optional live tooling turret, C-axis, Y-axis and sub-spindle, G.LINC 350 intelligent control system and various automation equipment to reach a complete series and easily meet your machining needs of today and tomorrow.



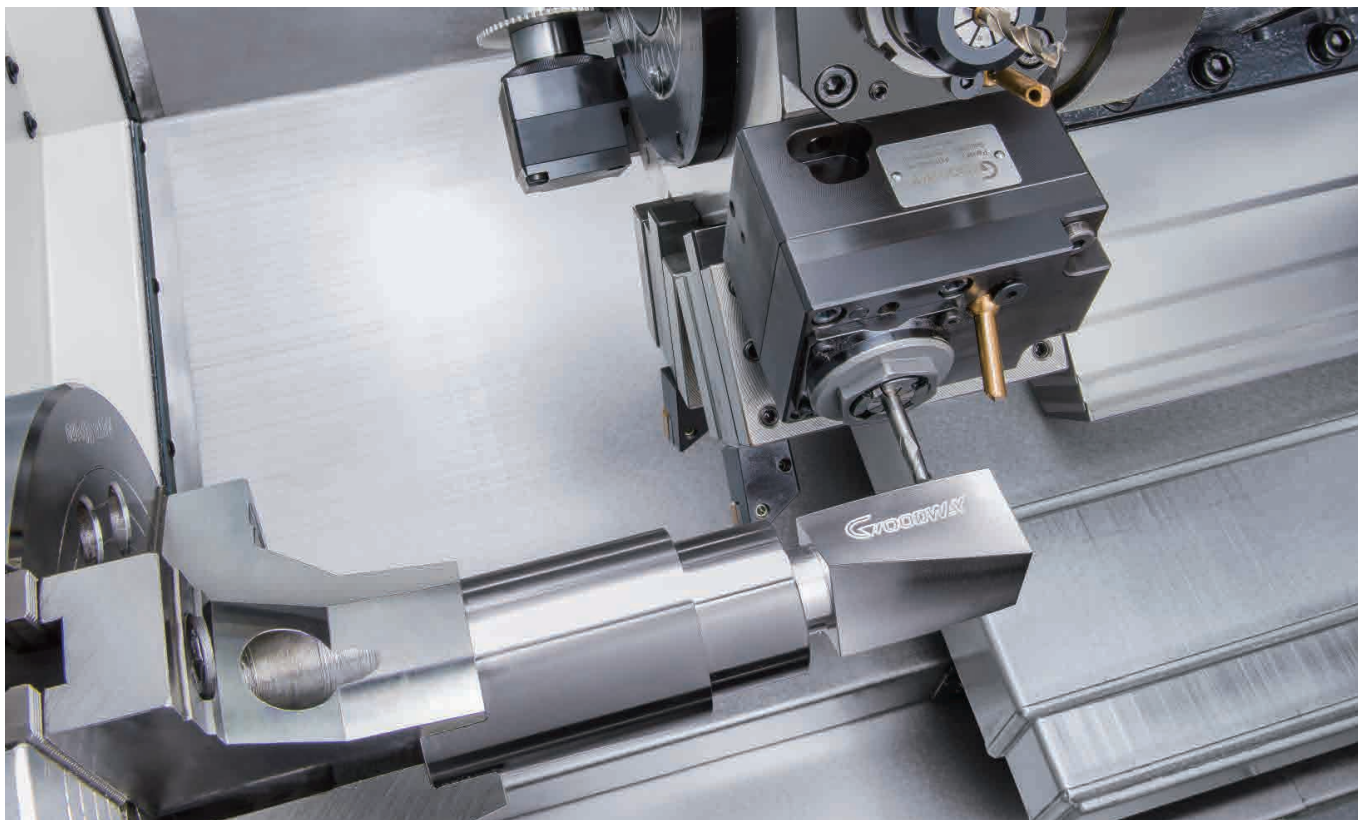
( GLS-3000 model shown )

## YAMA SEIKI HIGH SPEED CUTTING SERIES

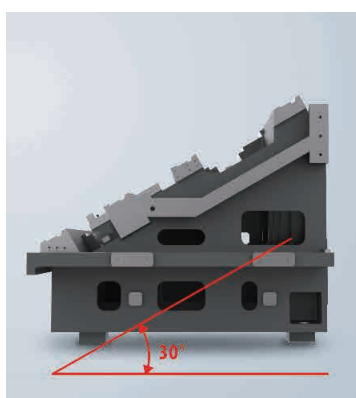


MODEL	CHUCK SIZE	BAR CAPACITY
GLS-1500	6" ( Big bore )	Ø 2"
GLS-2000	8" ( Big bore )	Ø 2.55"
GLS-3000	10"	Ø 3.07"
GLS-3300	12"	Ø 3.54"

Please contact YAMA SEIKI for detailed information.



Equipped with an optional live tooling turret, C-axis, Y-axis and sub-spindle and other advanced features allows GLS-3000 can work on turning, milling, drilling, tapping and off-center milling tasks. The machining capability equals the integration of turning center and machining center, which significantly lowers machining cycle time and manpower, and also prevent accuracy error of switching work-piece to another machine.



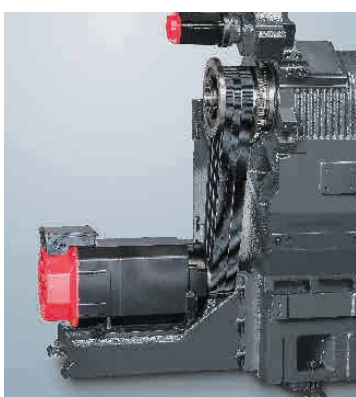
### TRUE SLANT BED STRUCTURE

The 30° true slant bed design provides superior support and heavy cutting ability, also excellent chips removal and convenient loading process.



### HIGH SPEED LINEAR GUIDE WAYS

X / Z axes and Y-axis ( opt. ) utilize the high speed high precise linear guide way design to provide the optimal motion and efficiency.



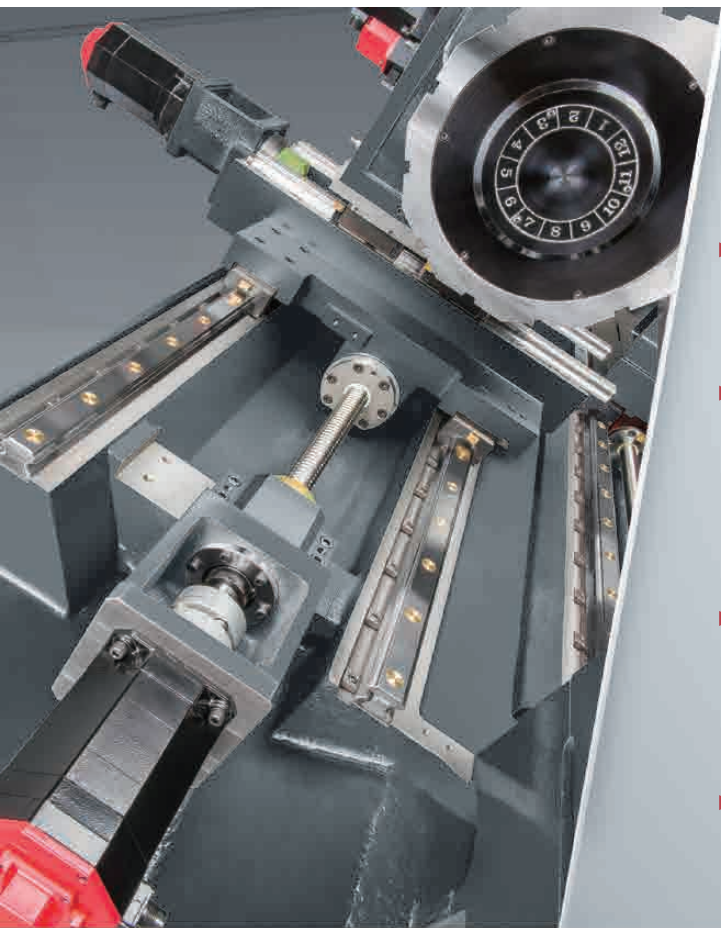
### HIGH POWER SPINDLE

18.5 kW high power motor ( GLS-3300 ) with spindle torque output up to 757 N-m, which can easily overcome all kinds of different materials.



### INTELLIGENT SYSTEM (OPT.)

Advanced YAMA SEIKI G.LINC 350 intelligent system combines high class hardware and complete intelligent assisting features which can make machine smarter.



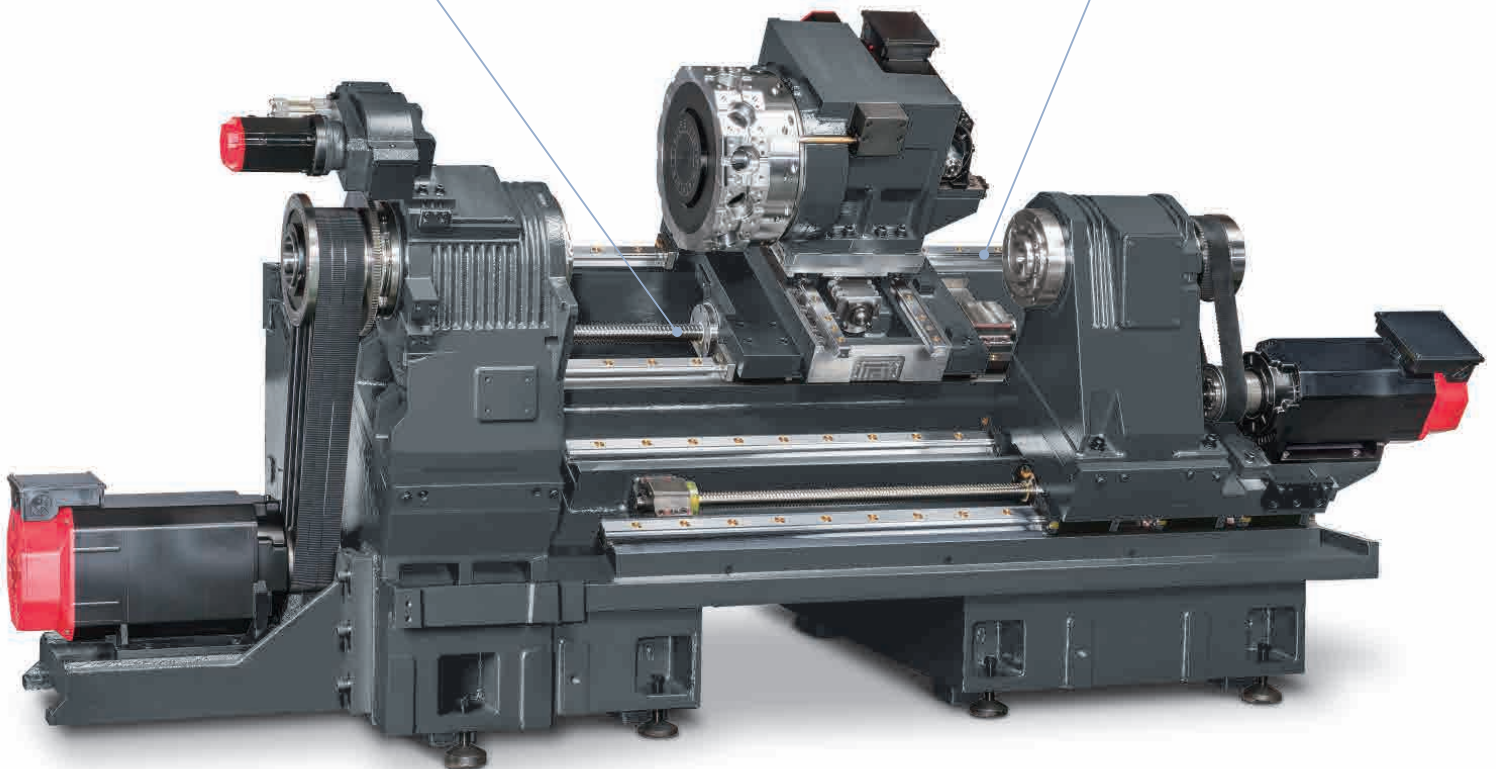
## SUPER RIGIDITY STRUCTURE

- ▶ Major structural components have been combined into one solid platform. The low center of gravity 30° slant bed design provides the most rigid foundation possible for the headstock, turret, and tailstock.
- ▶ Built to withstand years and years of rigorous high production turning, the heavily ribbed, one-piece, thermally balanced bed and casting parts are of "MEEHANITE" casting, which can provide more efficient anti-damping and decrease lower deformation to allow much longer lasting and stand out among others.
- ▶ All casting structure are detected by using Finite Element Analysis ( FEA ) to optimize the intensity, which can efficiently lower the deformation and strengthen the machine rigidity to ensure stable positioning and repeatability accuracy.
- ▶ X / Z axes adopt the higher level FANUC  $\alpha$  i series absolute servo motor that can provide rapid acceleration/deceleration and powerful thrust, which can efficiently lower the machining cycle time.

- ▶ C3 class hardened and precision ground ball screws ensure the highest accuracy and durability possible.

- 1 Ball screws are through per-compaction to eliminate backlash.
- 2 Ball screws are through precise detection to ensure the parallelism with linear guide ways.

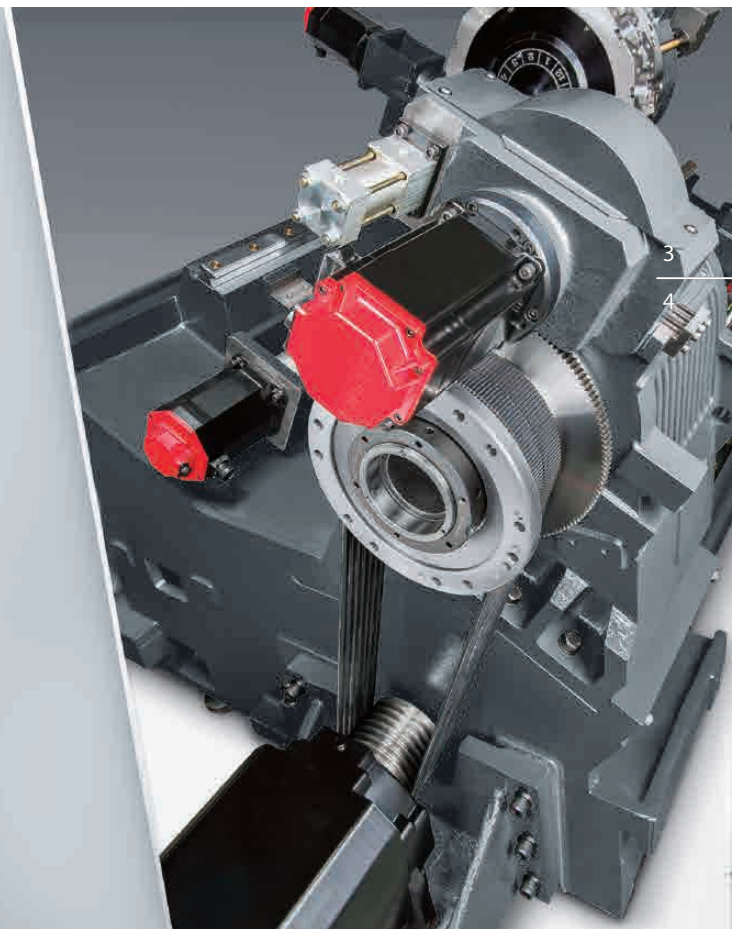
- ▶ X & Z axes utilize high performance ball type linear guide way design which provides high precision high speed and low abrasion advantages.  
( Roller type linear guide ways are available for option )



( Casting structure of GLS-3000 model shown )

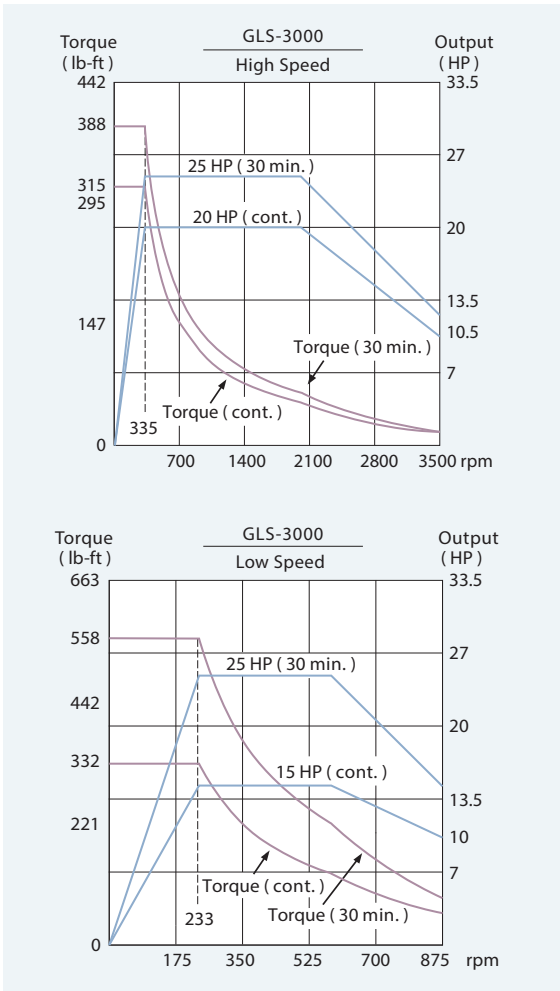
# ULTIMATE TURNING POWER

- ▶ The heavy-duty headstock is one-piece casting reinforced with heat dispending fins, which can fasten heat radiation, minimize thermal displacement and lower accuracy error of thermal deformation.
- ▶ P4 grade ( Class 7 ) super-high precision bearings are directly assembled for maximum level of support and precision. Bearing configuration adopts optimal 2-point support design for heavy-duty cutting with stable performance and long term high accuracy durability.
- ▶ Specialized high performance V type belt driven spindle motor can lower the effects of heat generated by motor. Pulley ratios has been adjusted to tune the motor's maximum speed to match the spindle's maximum speed, which result in full output at the lowest speed and maximize torque.

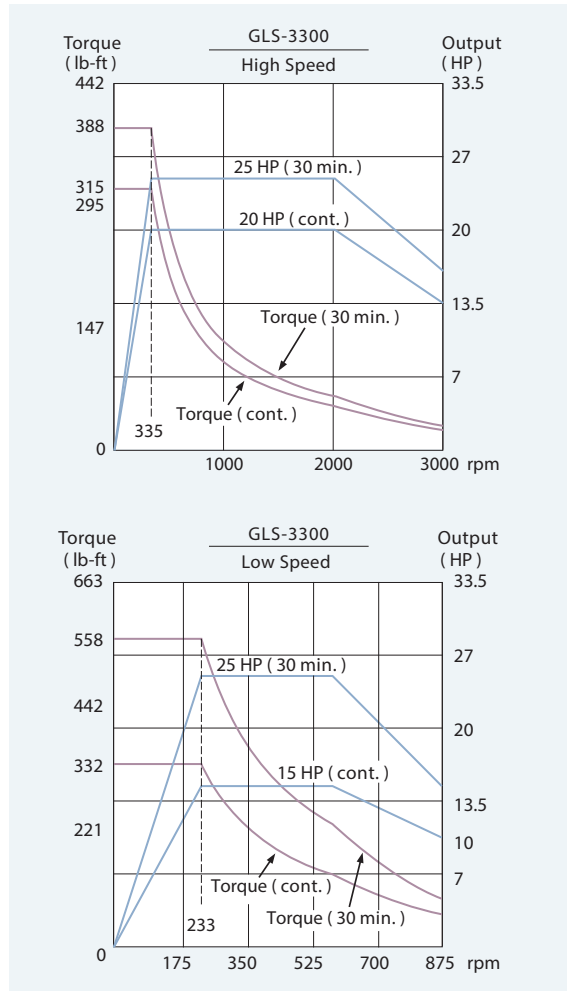


## Spindle Output

【 GLS-3000 】

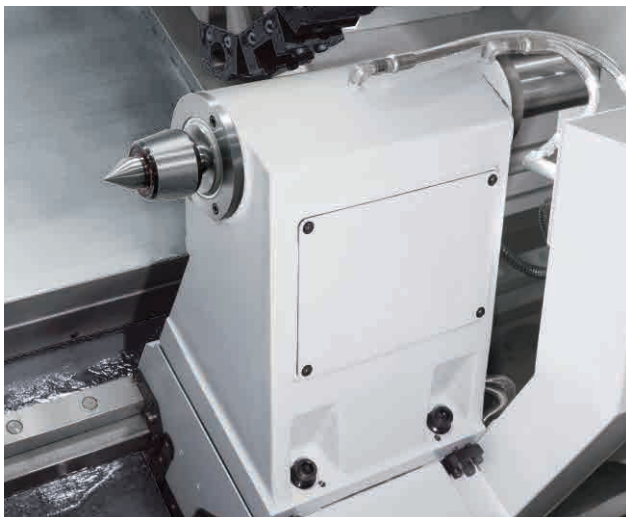
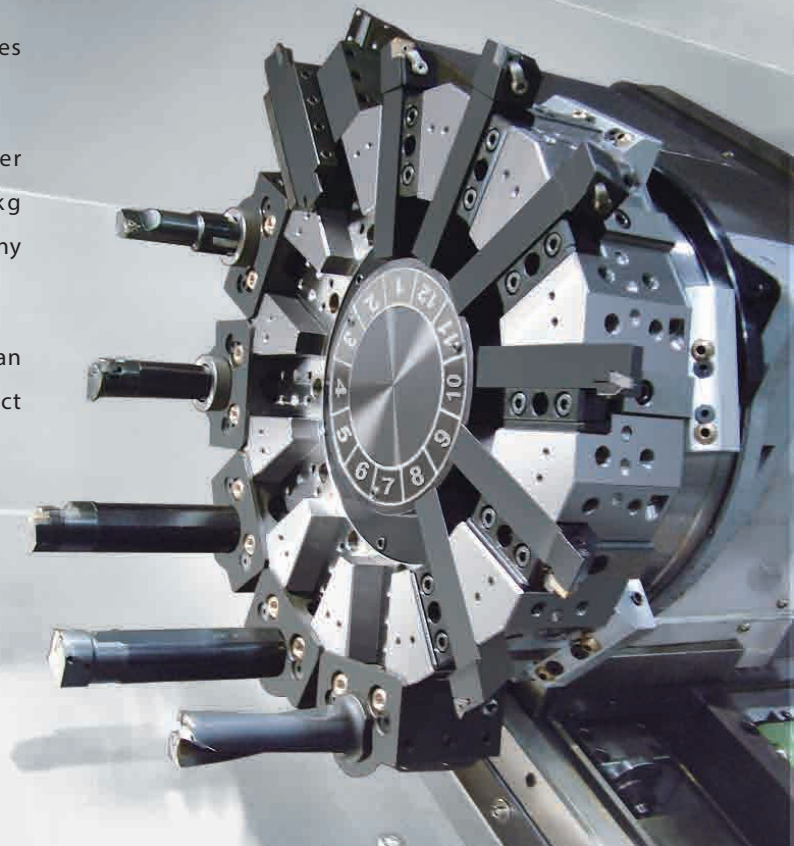
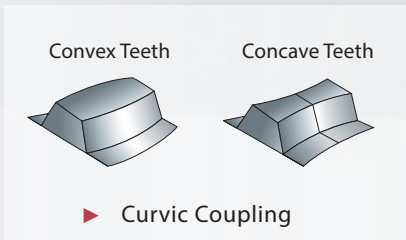


【 GLS-3300 】



# ADVANCED TURRET TECHNOLOGY

- ▶ Heavy load servo motor tool indexing system provides 10 or 12-station turret with a 0.3 second indexing time.
- ▶ High precision curvic couplings with large diameter  $\varnothing$  250 mm positioning tool plate. With 6,400 kg clamping force, it makes sure the rigidity of turret in any machining conditions.
- ▶ The curvic couplings provide auto-centering, auto-clean and a large contact area which are designed to distinct from traditional couplings.



## SUPER RIGIDITY TAILSTOCK

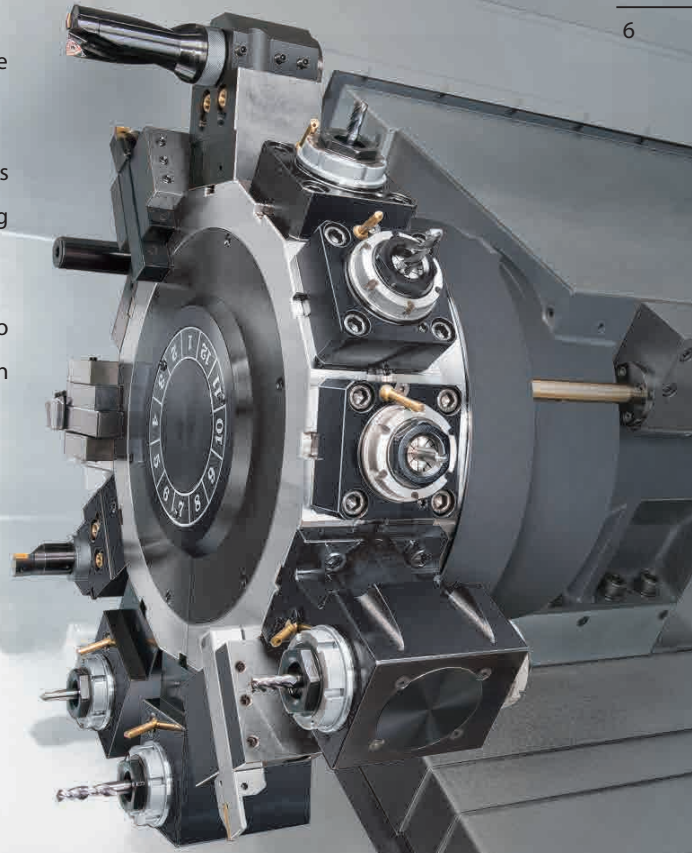
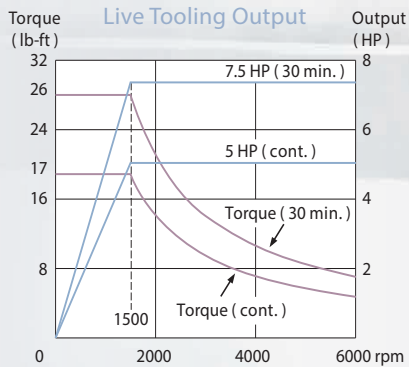
- ▶ Programmable base tailstock can efficiently achieve tough machining tasks, and it has been simplified through use of custom software interface. Z-axis carriage automatically locks on to the base of the tailstock and drags it to the desired position.
- ▶ The adjustment of the quill ( MT#4 ) is programmable and thrust can be adjusted by hydraulic.

- ▶ Core components such as spindles, turrets, tailstocks are precisely developed by YAMA SEIKI in a constantly temperature controlled A/C system to achieve the strict accuracy requirements and the best quality.



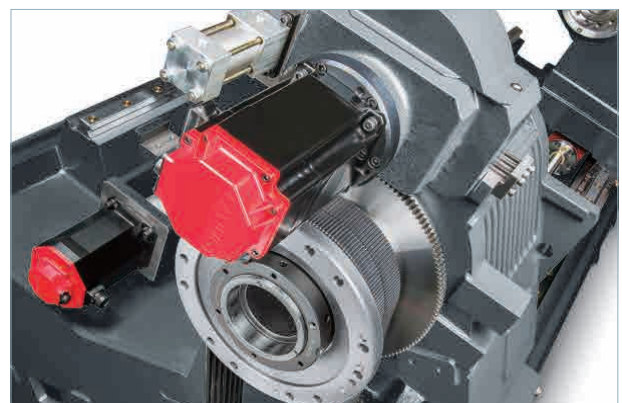
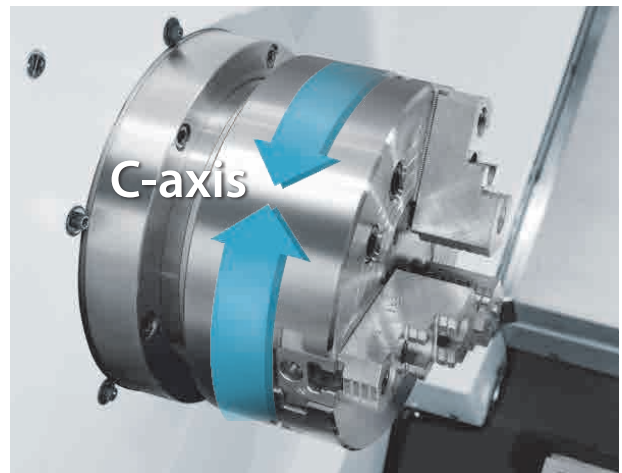
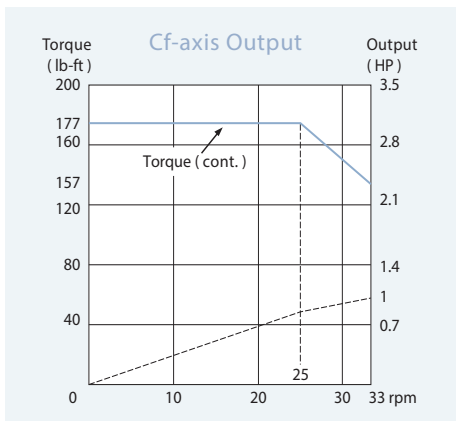
# POWERFUL LIVE TOOLING TURRETS

- ▶ Super rigidity 3-piece curvic coupling design, turret can remain the same place during indexing to achieve the faster indexing.
- ▶ The 12-station YAMA SEIKI live tooling turret offers 12 stations available for live tooling ( live tooling tools rotate in working position only ) and features a non-lifting turret disk.
- ▶ With the latest technology, live tooling is driven by an AC servo motor to provide ample power, in the form of torque. Now, even the toughest of jobs may be tackled without a sweat.



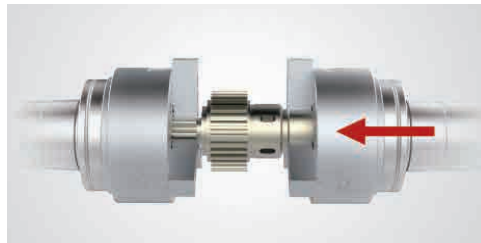
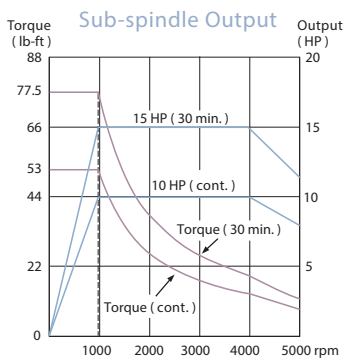
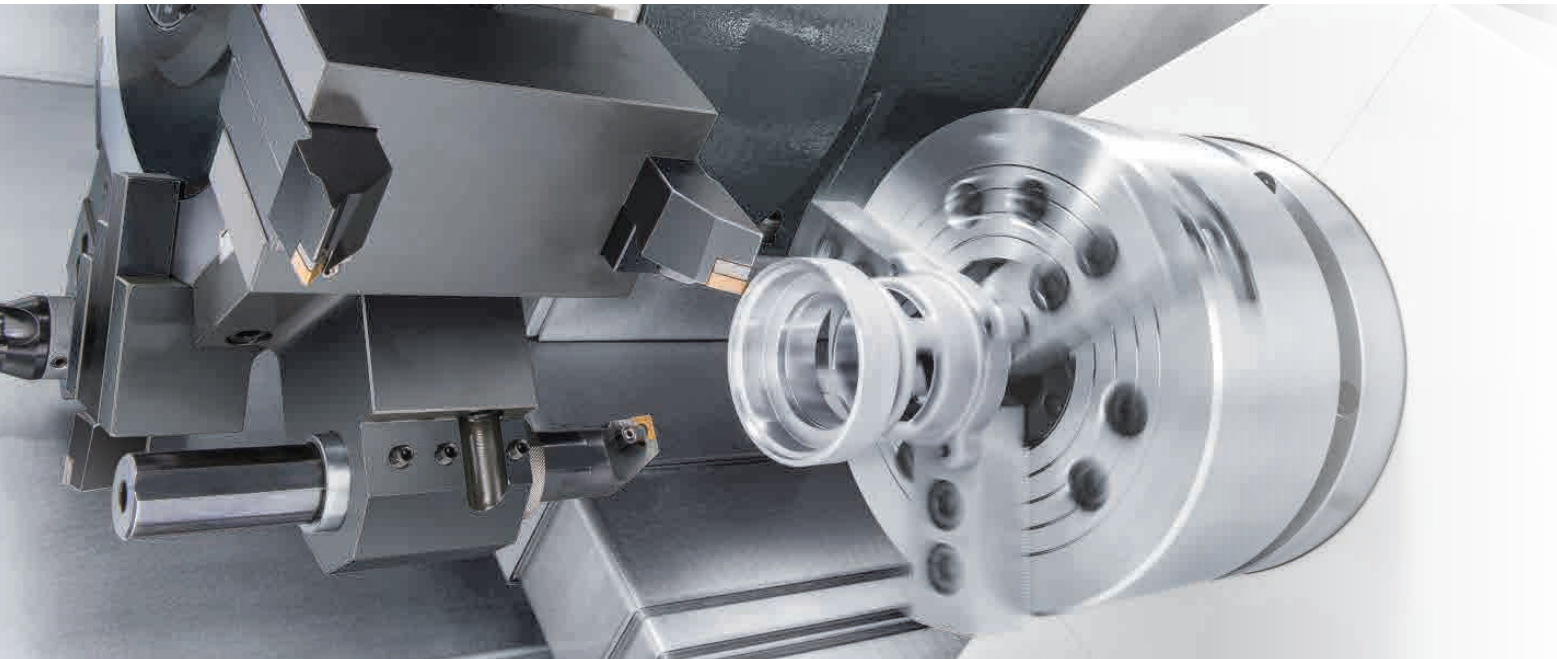
## HIGH PRECISE C-AXIS

- ▶ C-axis adopts super rigidity Cf-axis with disk brake system, and with the FANUC servo motor generating 240 N-m ( cont. ) of torque it offers excellent surface finishes and accuracy. Plus, dynamic accuracy is within  $\pm 0.02^\circ$  even under heavy cutting condition.



# BACK-END MACHINING CAPABILITY

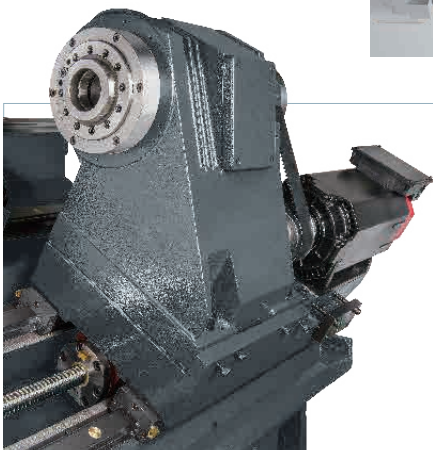
All series could select the optional sub-spindle to machine the back-end after receiving the part.  $\varnothing$  51 mm bar capacity adopts 8" chuck featuring ejector, which allow the finished parts can smoothly drop on parts catcher successfully. All the processes from loading the parts can all be done in one machine without a pause.



Automatic part transfer of work piece from main spindle to sub-spindle saves manpower and cycle time, while reducing accuracy lost, which will occur if manually handling the part from machine to machine.



The sub-spindle configuration is also ideal for machining long work pieces such as small diameter shafts. Both ends of the work piece can be supported by the main and sub spindles, allowing the middle section(s) to be accurately machined.



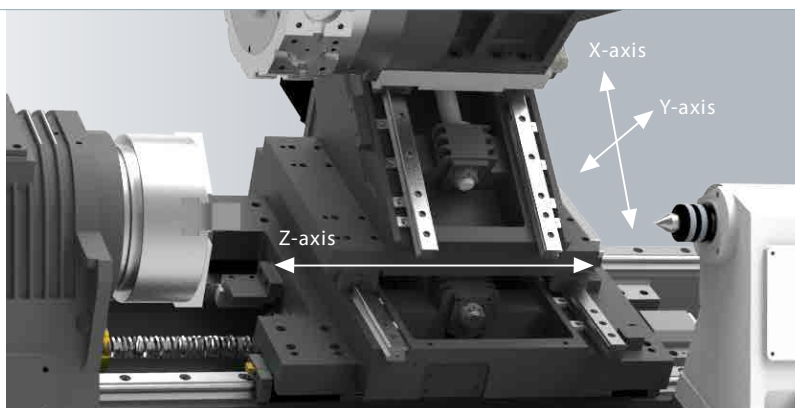
- ▶ Sub-spindle can be controlled by Cs-axis to achieve back-end machining, which allows conveniently operating, fast positioning, and higher accuracy.
- ▶ Z<sub>2</sub>-axis adopts high performance linear guide way design, which is driven by FANUC direct driven motor, provides the optimal axial accuracy.



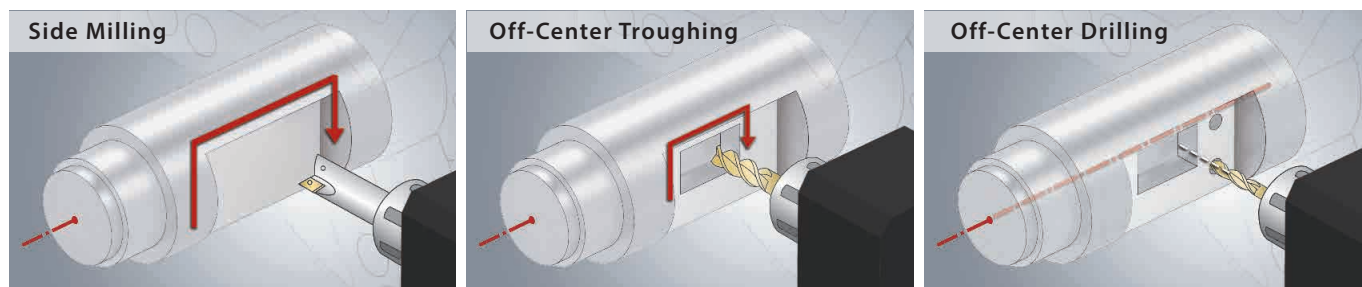
# Y-AXIS CONTROL CAPABILITY

The optional Y-axis control can achieve X, Y, Z, C axes simultaneously machining, which allow the series can work on Y-axis 100 mm off-center milling ( off-center  $\pm 50$  mm ), drilling, and tapping as well as improving the machining accuracy from a regular 3 axes simultaneously machining processes.

The fictitious axis and X-axis saddle adopt 30° included angle design that efficiently lower the center of gravity, and lighten the Y-axis mechanism loads. Meanwhile, the center of gravity of turret lays on the proper range of saddle to make sure the overall structural rigidity.

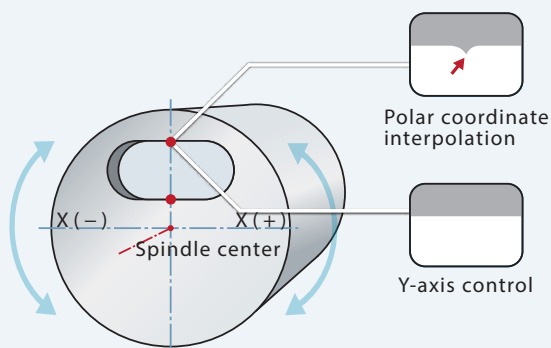


## UNIQUE Y-AXIS MACHINING CAPABILITY



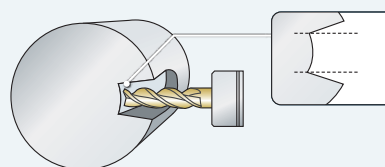
## HIGH PRECISION Y-AXIS MACHINING CAPABILITY

### Polar coordinate interpolation **V.S** Y-axis control

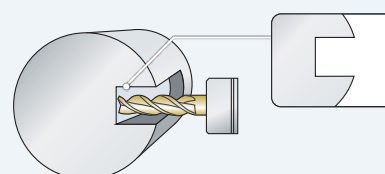


- ▶ The polar coordinate interpolation can work on troughing or contouring. X-axis reverses at cross point of the center point of workpiece and contour, which makes tool not able to be completely contouring and remains worse accuracy.
- ▶ With Y-axis control, it can avoid the situation above and remain better accuracy.

### O.D. Troughing



- ▶ Not Featuring Y-axis, width of troughs are not perfectly parallel with worse accuracy.



- ▶ Featuring Y-axis, width of trough remains parallel with better accuracy.

# NC INTELLIGENCE

Advanced hardware combined with intelligent software, makes your machine smarter



## G.LINC 350

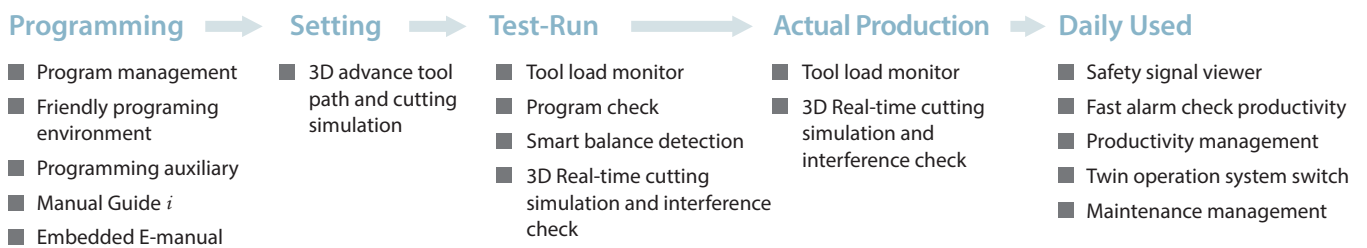
- Advanced Hardware
- Outstanding Operability
- Streamlined Programming
- High Security and Shortened Machining Setting
- Reliable Continuous Operation
- Shortened Troubleshooting Time
- Improved Utilization Rate

### Significant Production Efficiency



The 3D simulation inspection can greatly reduce test-run time and improve overall utilization rate

### Comprehensive Functions



# STANDARD / OPTIONAL FEATURES

## Standard Features



### CHIP CONVEYOR

The standard chip conveyor features adjustable timers that allow the operator to set operation intervals according to the amount of chips generated by the machine. Thus, reducing coolant loss to a minimum.



### 3-JAW CHUCK w/soft jaws x 1 set



### TRI-COLOR STATUS LIGHT

## Optional Features

**LOAD MONITOR SETTING**

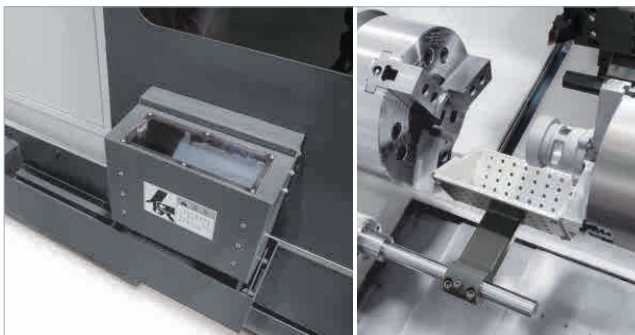
GROUP	NO.	MEAS	THRESH	THRESH	LOAD	STATUS
1	SP1	40	60	0	SP1/2/3:	NORMAL
	X	30	35	0		NORMAL
	C	20	25	0		NORMAL
2	SP2	55	60	0	X:	NORMAL
	Y	30	40	0		NORMAL
	Z	40	55	0		NORMAL
3	SP2	20	33	0	Z:	NORMAL
	X	60	66	0		NORMAL
	Z	30	50	0		NORMAL
4	SP1	40	45	0	C:	NORMAL
	Y	50	55	0		NORMAL
	Z	33	40	0		NORMAL
5	SP1	44	50	0	Y:	NORMAL
	C	95	101	0		NORMAL
	Y	80	88	0		NORMAL
6	SP1	10	20	0	Y:	NORMAL
	X	15	20	0		NORMAL
	Y	30	45	0		NORMAL

MDI \*\*\*\*\* 13:22:42 S1 0T0006

TECH MONI CAN RESET EX IT

### LOAD MONITORING

The load monitoring function is used to detect abnormal load of tools by monitoring the variation in spindle motor and servo motor loads during the cutting process. When abnormal loads are detected, the machine will stop at program end ( M30 ) or immediately ( feed hold status ) according to tool life value or tool break value respectively.



### PARTS CATCHER

The optional parts catchers can be programmed to catch finished parts after cut-off. Part conveyor systems are also available.

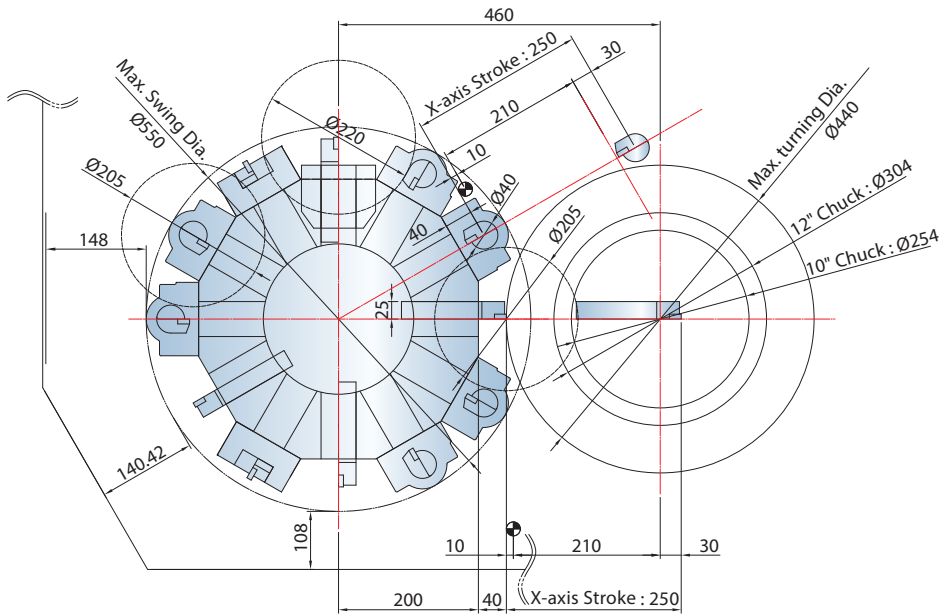


### TOOL PRESETTER

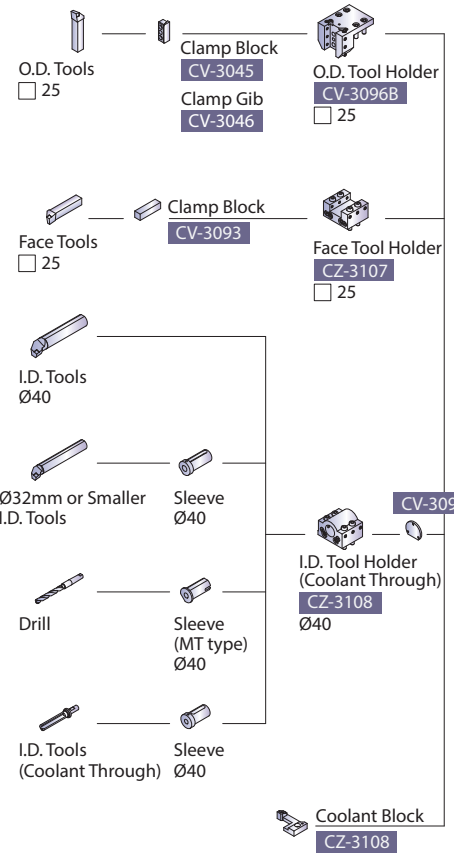
The optional RENISHAW HPM tool presetter allows tool check task easier.

## Interference Diagram

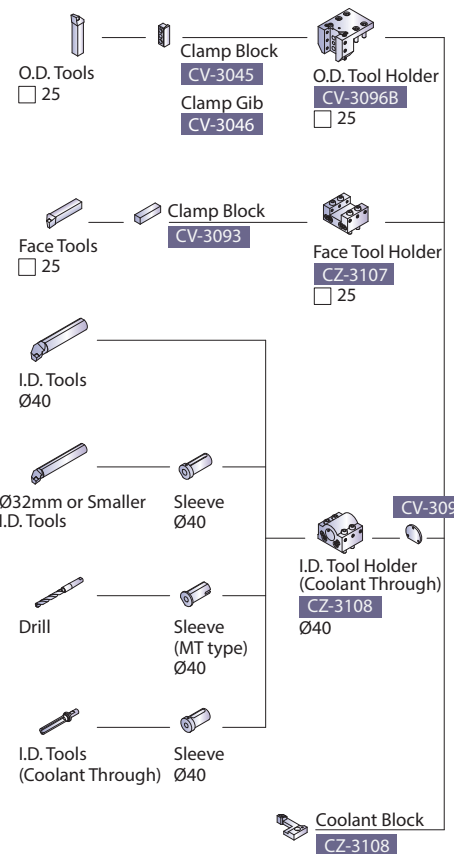
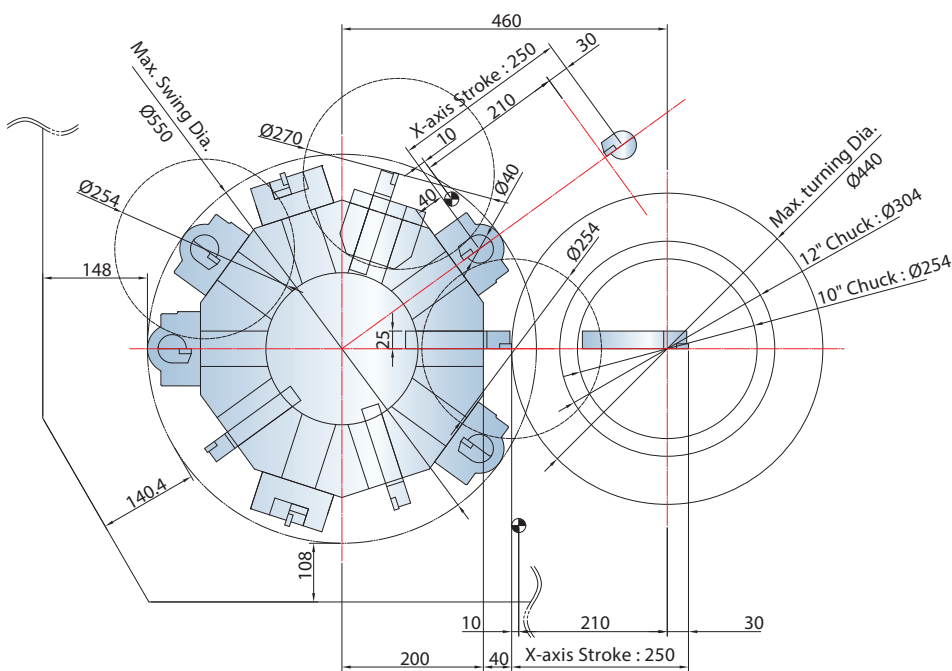
### [ 12-Stations Turret ]



## Tooling System



### [ 10-Stations Turret ]

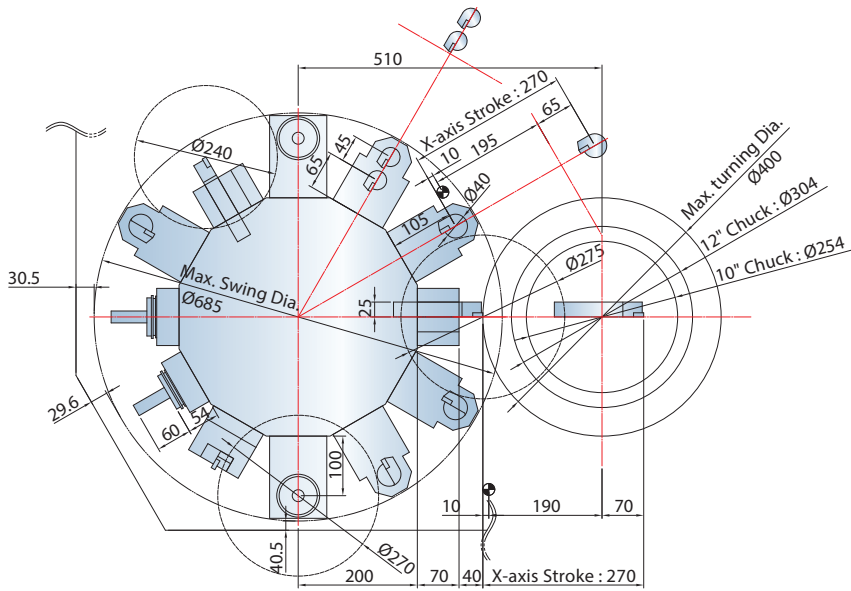


Unit : mm

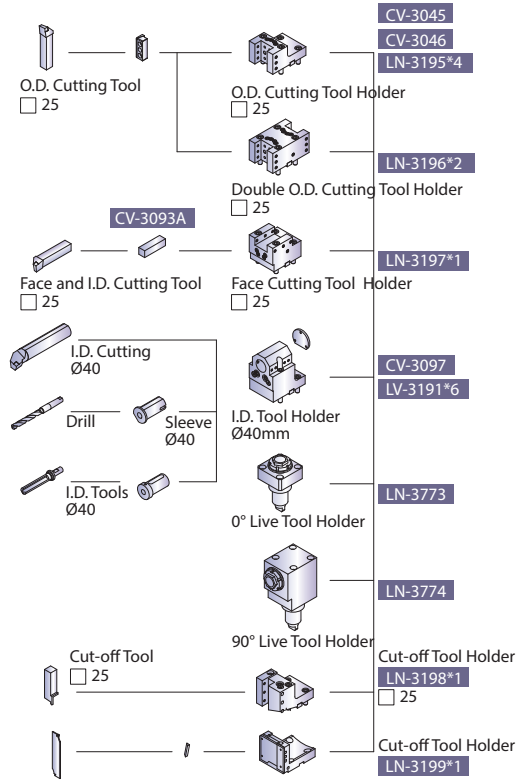
## Interference Diagram

[ 12-Stations Live Tooling Turret ] / [ Y-axis ]

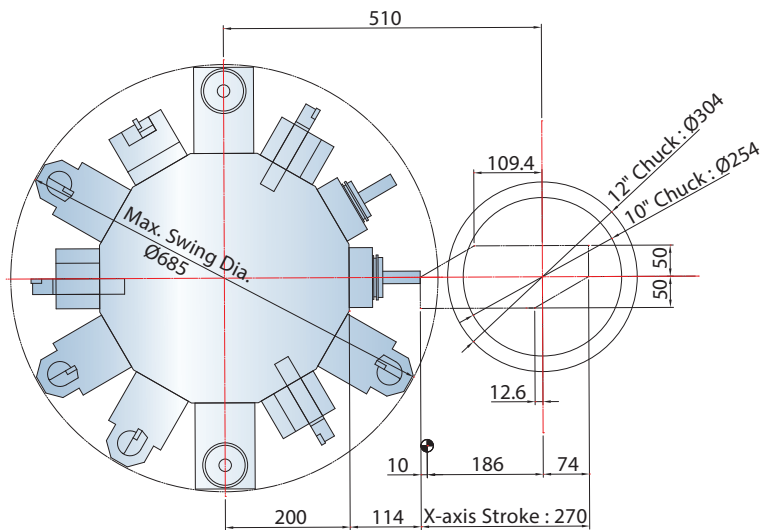
### Turning Tool



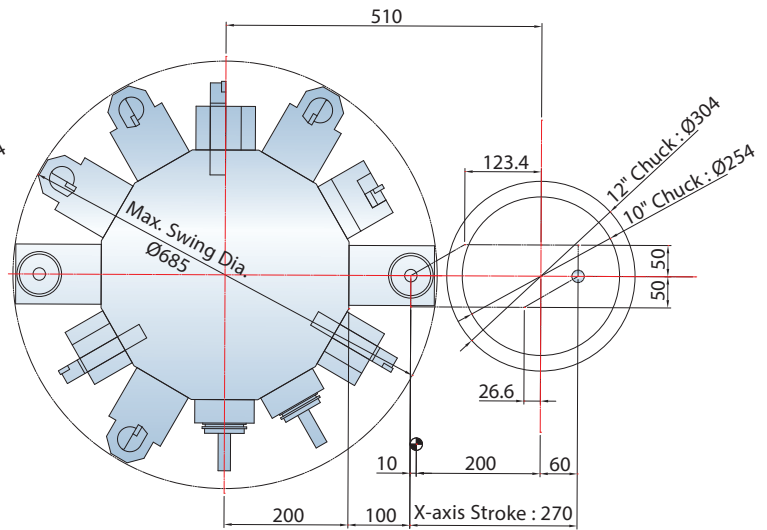
## Tooling System



### 0° Live Tool

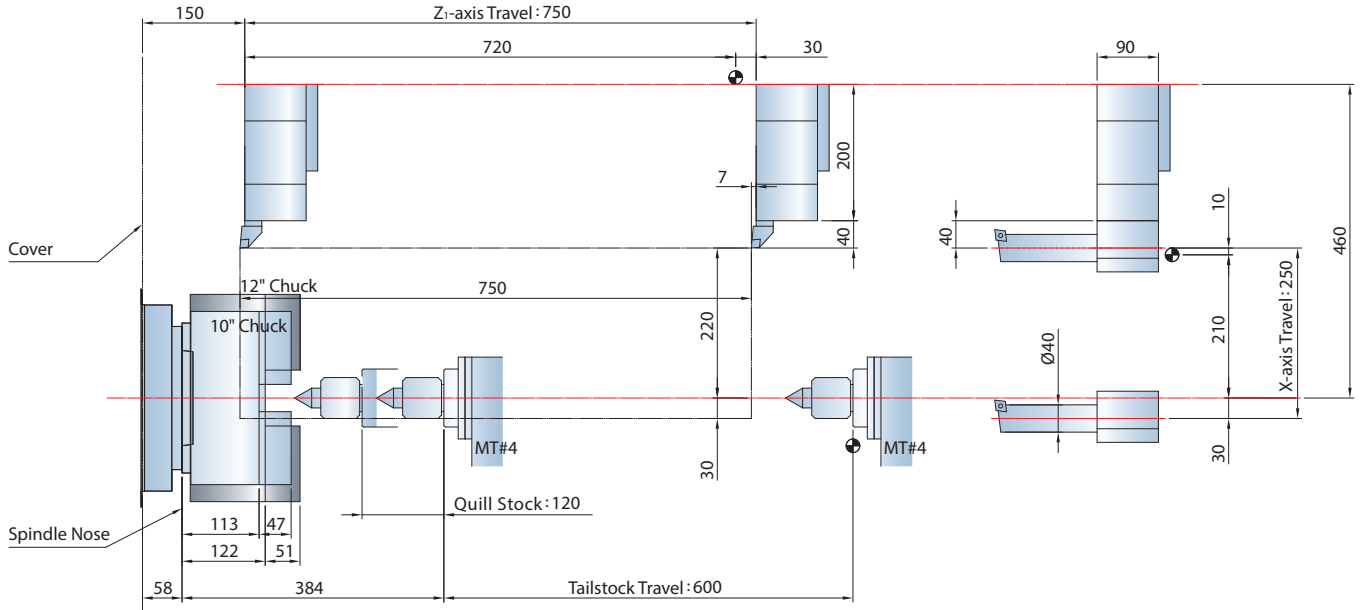


### 90° Live Tool

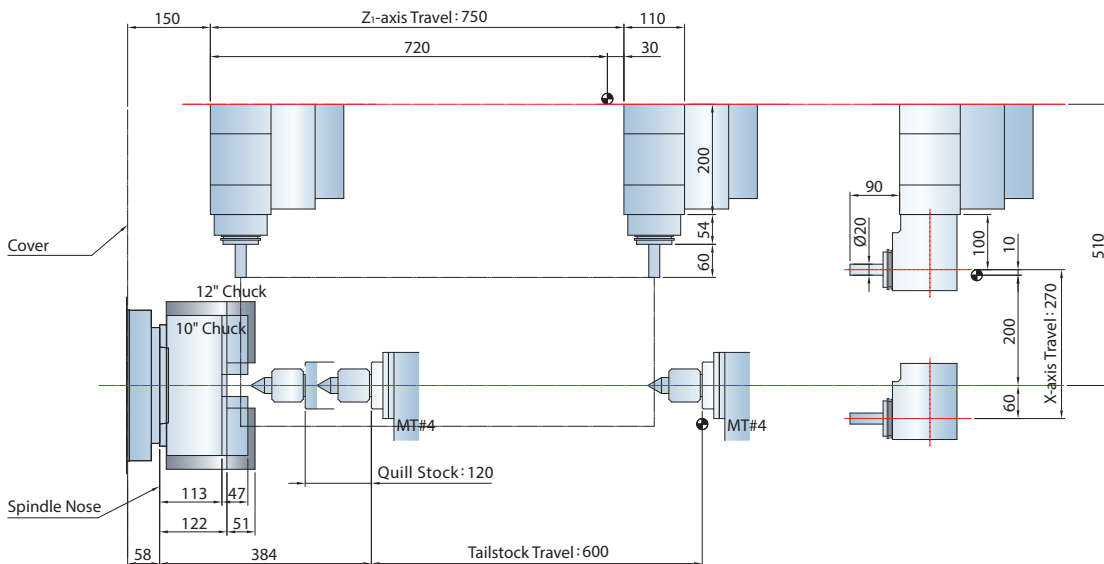
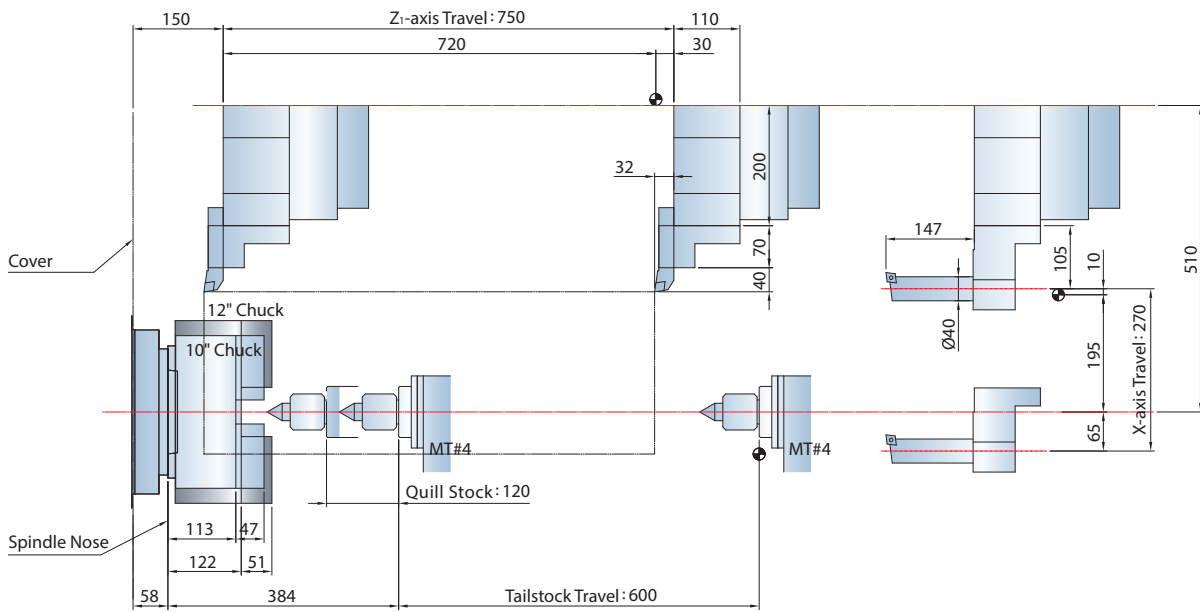


Work Range

[ 12-Stations Turret / 10-Stations Turret ]

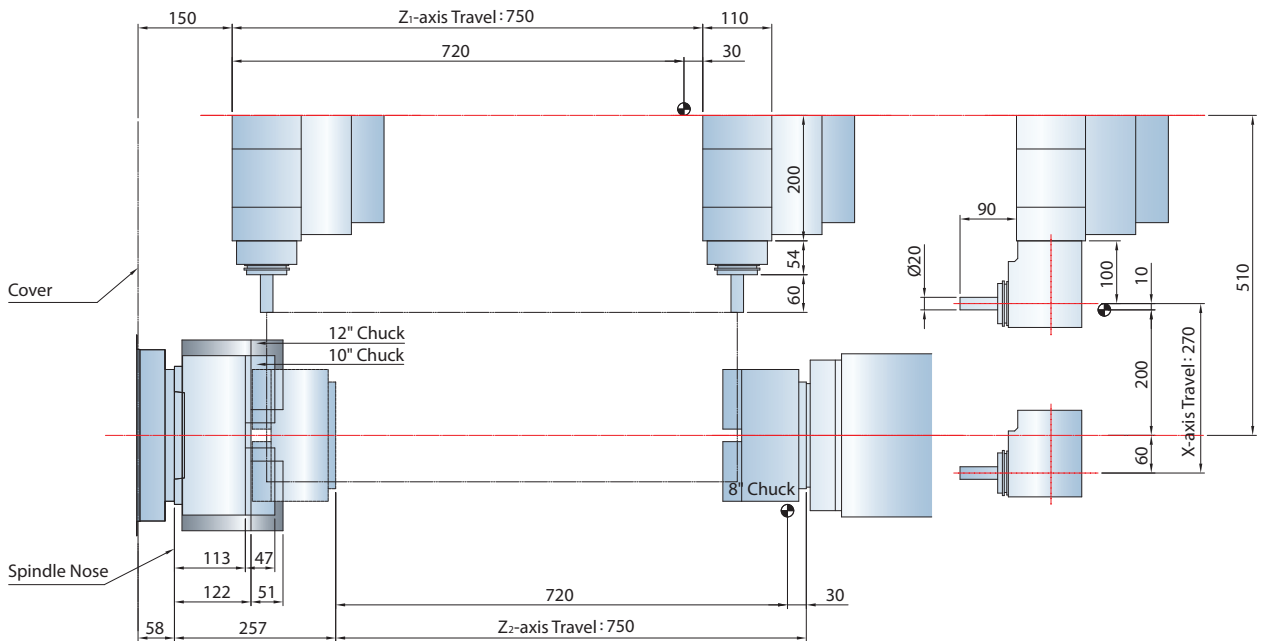
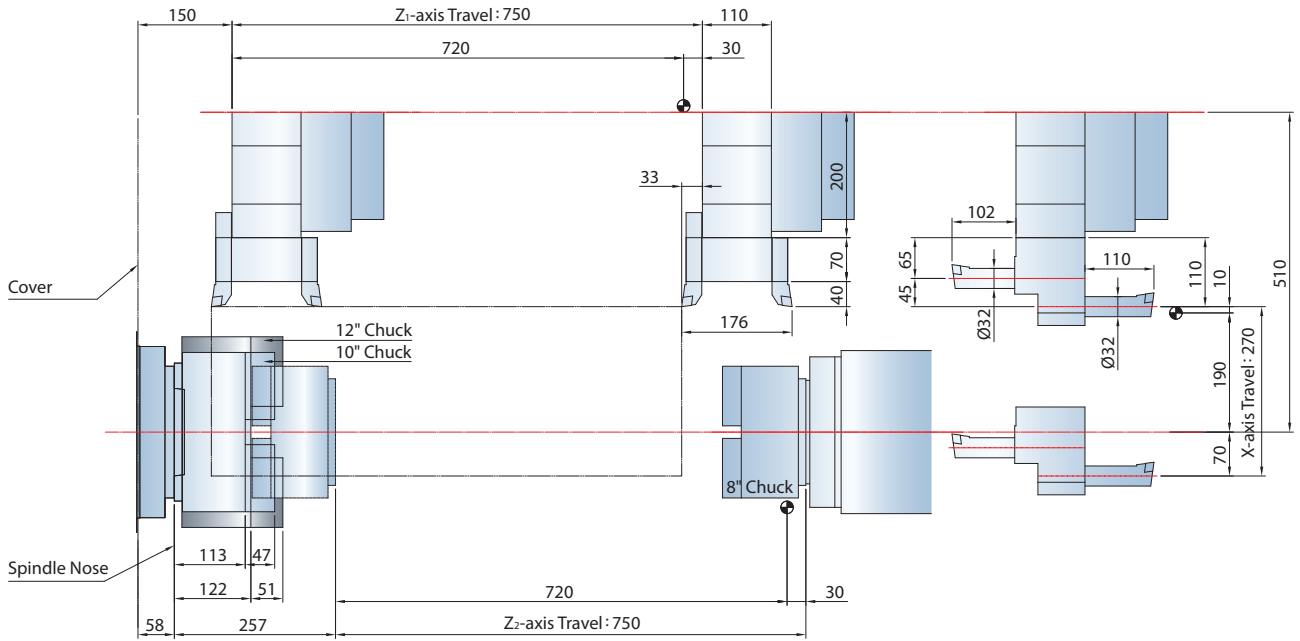


[ 12-Stations Live Tooling Turret ]



Work Range

[ 12-Stations Live Tooling Turret + Sub-spindle ]



# FEATURES

S : Standard      O : Option  
 - : Not Available      C : Contact YAMA SEIKI

		GLS-3000	GLS-3300
<b>SPINDLE</b>			
Main spindle motor configuration	Belt driven	S	S
Rigid tapping & spindle orientation		S	S
Spindle disk brake		O	O
Cf-axis & spindle disk brake*1		O	O
Sub-spindle & 8" hydraulic cylinder		O	O
<b>WORK HOLDING</b>			
Hydraulic hollow cylinder for chuck	10"	S	-
	12"	-	S
Hydraulic hollow 3-jaw chuck	10"	S	-
	12"	-	S
Hard jaws		O	O
Collet chuck		O	O
Special work holding chuck		C	C
In spindle work stopper		O	O
Spindle liner ( guide bushing )		O	O
Foot switch for chuck operation		S	S
Quill hydraulic tailstock		O	O
MT#4 live center		O	O
Foot switch for tailstock operation		O	O
Two-stage programmable pressure	Chuck clamping	O	O
	Tailstock thrust	O	O
<b>TURRET</b>			
10-station turret		S	S
12-station turret		O	O
12-station live tooling turret		O	O
Tool holder & sleeve package		S	S
Live tooling tool holders ( 0°x2, 90°x2 )*1		O	O
<b>MEASUREMENT</b>			
RENISHAW HPMA tool presetter		O	O
<b>COOLANT</b>			
Coolant pump	3 kg/cm <sup>2</sup>	S	S
	5 kg/cm <sup>2</sup>	O	O
	10 kg/cm <sup>2</sup>	O	O
High-pressure coolant system	20 kg/cm <sup>2</sup>	C	C
Roll-out coolant tank		S	S
Oil skimmer		O	O
Coolant flow switch		O	O
Coolant level switch		O	O
Coolant intercooler system		O	O
<b>CHIP DISPOSAL</b>			
Chip conveyor with auto timer	Right discharge	S	S
	Rear discharge	C	C
Chip cart with coolant drain		O	O
Chuck air blow		O	O
Tailstock air blow		O	O
Coolant gun		O	O
Oil mist collector		O	O
<b>AUTOMATIC OPERATION SUPPORT</b>			
Parts catcher		O	O
Work-piece transport conveyor		O	O
Bar feeder		O	O
Bar feeder interface		O	O
Gantry-type loader / unloader		O	O
Auto door		O	O
Extra M-code output	4 sets ( 8 )	O	O
	8 sets ( 16 )	O	O
<b>SAFETY</b>			
Fully enclosed guarding		S	S
Door interlock ( incl. Mechanical lock )		S	S
Impact resistant viewing window		S	S
Tailstock stroke out - end check		S	S
Chuck cylinder stroke out - end check		S	S
Chuck cylinder check valve		S	S
Low hydraulic pressure detection switch		S	S
Over travel ( soft limit )		S	S
Load monitoring function*2		O	O

		GLS-3000	GLS-3300
<b>OTHERS</b>			
Tri-color operation status light tower		S	S
Florescent work light		S	S
External work light		O	O
Electrical cabinet	Heat exchanger	S	S
	A/C cooling system	O	O
Complete hydraulic system		S	S
Advanced auto lubrication system		S	S
Foundation leveling & maintenance tool kit		S	S
Emergency maintenance electrical part package		S	S
Operation & maintenance manuals		S	S
		Oi-TF	3Ti
<b>FANUC CONTROL FUNCTIONS</b>			
Display	8.4" color LCD	S	O
	10.4" color LCD	-	S
Graphic function	Standard	S	S
	Dynamic	O	O
Part program storage size	512K bytes	S	-
	1M bytes	-	S
	2M bytes	O	O
	4M bytes	-	O
	8M bytes	-	O
Registerable programs	400	S	-
	1,000	O	S
	4,000	-	O
	99	-	S
	128	S	-
Tool offset pairs	200	O	O
	400	-	O
	499	-	O
	999	-	O
	2000	-	O
Servo HRV control	HRV 3	S	S
Automatic data backup		S	S
Synchronous / Composite control		O	O
Inch / metric conversion		S	S
Polar coordinate interpolation		S	S
Cylindrical interpolation		S	S
Multiple repetitive cycle		S	S
Rigid tapping		S	S
Unexpected disturbance torque detection function		S	S
Spindle orientation		S	S
Constant surface speed control		S	S
Spindle speed fluctuation detection		S	S
Embedded macro		O	O
Spindle synchronous control		S	S
Background editing		S	S
Tool radius / Tool nose radius compensation		S	S
Multi-language display		S	S
Cs contouring control		S	S
Polygon turning		S	S
Helical interpolation		O	O
Direct drawing dimension programming		S	S
Thread cutting retract		S	S
Variable lead threading		S	S
Multiple repetitive cycle II		S	S
Canned cycles for drilling		S	S
Tool nose radius compensation		S	S
Chamfering / Corner R		S	S
AI contour control I		O	S
Multi part program editing*3		S	S
Manual handle retrace		O	O
Manual intervention and return		S	O
External data input		S	S
Addition of custom macro		S	S
Increment system C		S	S
Run hour & parts counter		S	S
Auto power-off function		S	S
RS-232 port		S	S
Memory card input / output ( CF + USB )		S	S
Ethernet		S	S

\*1 Available for live tooling turret or Y-axis model.

\*2 Available for Oi-TF controller.

\*3 10.4" color LCD option needed.



# MACHINE SPECIFICATIONS

CAPACITY		GLS-3000	GLS-3300
Max.swing diameter		Ø 760 mm ( Ø 29.92" )	
Swing over saddle		Ø 450 mm ( Ø 17.71" )	
Max. turning diameter		Ø 440 mm ( Ø 17.32" )	
Standard turning diameter		Ø 254 mm ( Ø 10.00" )	
Max. turning length		710 mm ( 27.95" )	675 mm ( 26.57" )
Hydraulic chuck		10"	12"
Bar capacity		Ø 78 mm ( Ø 3.07" )	Ø 90 mm ( Ø 3.54" )
SPINDLE			
Hole through spindle		Ø 90 mm ( Ø 3.54" )	Ø 101 mm ( Ø 3.97" )
Spindle bearing diameter		Ø 130 mm ( Ø 5.11" )	Ø 140 mm ( Ø 5.51" )
Hydraulic cylinder		10"	12"
Spindle nose		A2-8	A2-8
Motor output ( cont. / 30 min. )	High	15 / 18.5 kW ( 20 / 25 HP )	
	Low	11 / 18.5 kW ( 15 / 25 HP )	
Motor full output speed		750 RPM	575 RPM
Spindle drive system		Direct Belt Drive	
Spindle drive ratio		7 : 12	7 : 12
Spindle speed range		3,500 RPM	3,000 RPM
Spindle full output speed		438 RPM	335 RPM
C-AXIS SPINDLE ( OPTIONAL )			
Cf-axis drive motor		FANUC AC Servo motor	
Min. spindle indexing angle		± 0.001°	
Dynamic accuracy		± 0.002°	
X & Z AXES			
X-axis travel		250 mm ( 9.84" )	
Z-axis travel		750 mm ( 29.52" )	
X / Z axes rapids		30 m/min. ( 1,181 IPM )	
Slide way type		Linear Guide Way	
Feed rates		1~ 4,800 mm/min. ( 1 ~ 189 IPM )	
X-axis servo motor		AC 2.7 kW ( 3.6 HP )	
Z-axis servo motor		AC 2.7 kW ( 3.6 HP )	
X-axis ball screw Ø / pitch		Ø 36 mm ( Ø 1.41" ) / Pitch 8	
Z-axis ball screw Ø / pitch		Ø 40 mm ( Ø 1.57" ) / Pitch 8	
X / Z axes thrust ( cont. )		961 kgf ( 2,118 lbf )	
TURRET			
Stations		12 / 10	
Indexing drive		FANUC AC Servo motor	
Indexing speed		0.3 sec. Adjacent / 0.5 sec. 180 degrees ( Single step )	
Accuracy		Positioning : ± 0.00069°, Repeatability : ± 0.00027°	
O.D. tool shank size		□ 1"	
I.D. tool shank size		Ø 1-1/2"	

Specifications are subject to change without notice.

# MACHINE SPECIFICATIONS

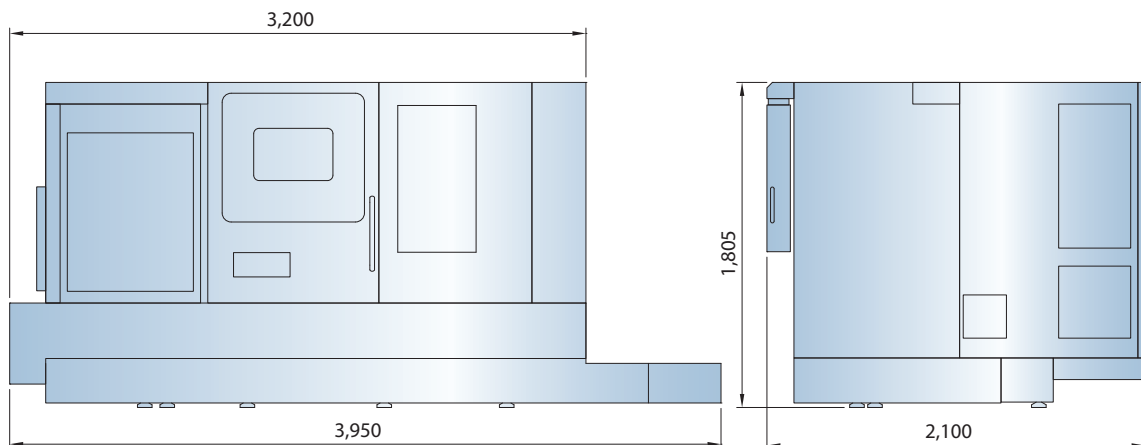
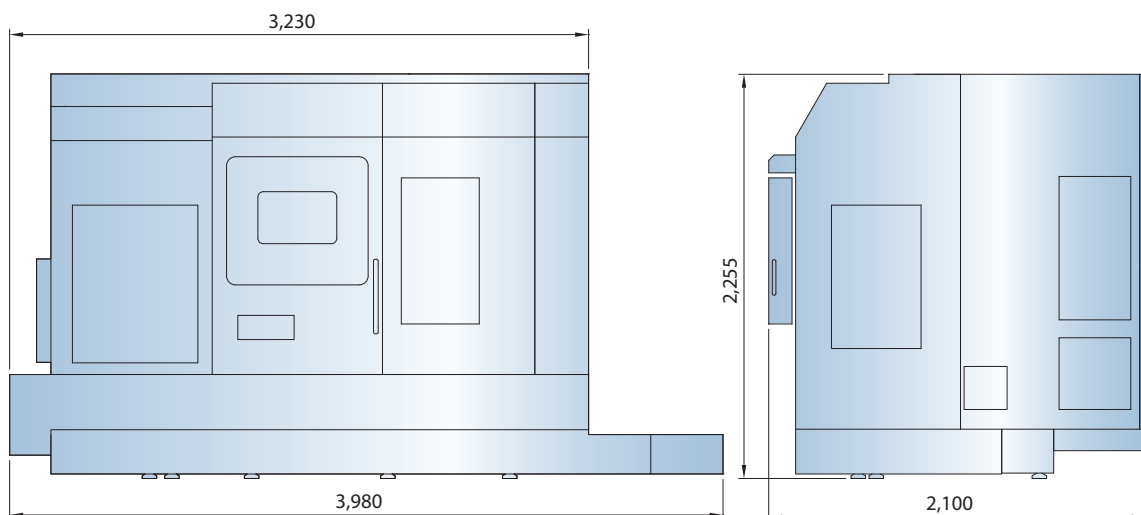
LIVE TOOLING TURRET ( OPT. )	GLS-3000	GLS-3300
Max. turning length	680 mm ( 26.77" )	
Stations	12	
Live tooling stations	12 ( Live tooling tools rotate in working position only. )	
Live tooling drive motor ( cont. / 30 min. )	3.7 / 5.5 kW ( 5 / 7.5 HP )	
Live tooling torque ( cont. )	23.5 N-m ( 17.33 lb-ft )	
Index speed	0.3 sec. Adjacent / 0.5 sec. 180 degrees ( Single step )	
O.D. tool shank size	□ 1"	
I.D. tool shank size	Ø 1-1/2"	
Live tooling shank size	ER32 ( Ø 3/4" )	
Live tooling RPM range	6,000 RPM	
Y-AXIS ( OPT. )		
Max. turning diameter	Ø 400 mm ( Ø 15.74" )	
Max. turning length	680 mm ( 26.77" )	
Max. Y-axis travel	100 ( -50 , +50 ) mm / 3.93" ( -1.96" , +1.96" )	
Y-axis axes rapids	12 m/min. ( 472 IPM )	
Slide way type	Linear Guide Way	
Feed rates	1 ~ 4,800 mm/min. ( 1 ~ 189 IPM )	
Y-axis servo motor	AC 2.7 kW ( 3.6 HP )	
Y-axis ball screw Ø / pitch	Ø 36 mm ( Ø 1.41 ) / Pitch 8	
Y-axis thrust ( cont. )	961 kgf ( 2,118 lbf )	
TAILSTOCK ( OPT. )		
Quill center taper	MT#4 ( Live center )	
Quill diameter / travel	Ø 70 mm ( Ø 2.75" ) / 150 mm ( Ø 5.90" )	
Tailstock base travel	600 mm ( 23.62" )	
Programmable quill / base	Yes / Yes	
Programmable base type	Positioned by Z-axis carriage	
SUB-SPINDLE ( OPT. )		
Hole through spindle	Ø 66 mm ( 2.59" )	
Bar capacity	Ø 51 mm ( 2.00" )	
Spindle bearing diameter	Ø 100 mm ( 3.93" )	
Spindle nose	A2-6	
Motor output ( cont. / 30 min. )	7.5 / 11 kW ( 10 / 15 HP )	
Spindle drive system	Direct Belt Drive	
Spindle drive ratio	2 : 3	
Spindle speed range	5,000 RPM	
Spindle full output speed	1,000 RPM	
Spindle torque ( cont. / 30 min. )	72 / 105 N-m ( 53.1 / 77.4 lb-ft )	
Z2-axis travel	750 mm ( 29.5" )	
Z2-axis rapids	30 m/min. ( 1,181 IPM )	
Slide way type	Linear Guide Way	
Z2-axis ball screw Ø / pitch	Ø 36 mm ( Ø 1.41" ) / Pitch 8	
Z2-axis thrust ( cont. )	881 kgf ( 1,942 lbf )	

Specifications are subject to change without notice.

**GENERAL**

Positioning accuracy	$\pm 0.003 \text{ mm } (\pm 0.00012")$
Repeatability	$0.015 \text{ mm } (0.00059")$
Standard CNC control	FANUC Oi-TF ( opt. 31i )
Voltage / Power requirement	AC 200 / 220 +10% to -15% 3 phase / 30 kVA
Hydraulic capacity	30 L ( 8 gal )
Coolant tank capacity	350 L ( 92 gal )
Coolant pump / pressure	0.5 kW ( 3/4 HP , 60 Hz ) rated at 3 bar ( 43.5 PSI )
Machine weight	6,000 Kg ( 13,227 lb )
Dimensions L x W x H	Machine : 3,230 x 2,100 x 1,810 mm ( 128" x 83" x 72" ) Machine w / Y-axis : 3,230 x 2,100 x 2,252 mm ( 128" x 83" x 89" )

Specifications are subject to change without notice.

**Machine Dimensions****[ GLS-3000 ]****[ Y-Axis Model ]**

Unit : mm



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