

SPEEDIO

R450Xd1

R650Xd1

Pallet Changing Compact Machining Center



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Pallet changer model continues machining even during setup time

Equipped with a "QT table," Brother's original pallet changer that avoids lift-up motion, new CNC, and tool magazine with up to 40-tool capacity to improve productivity at every production site.

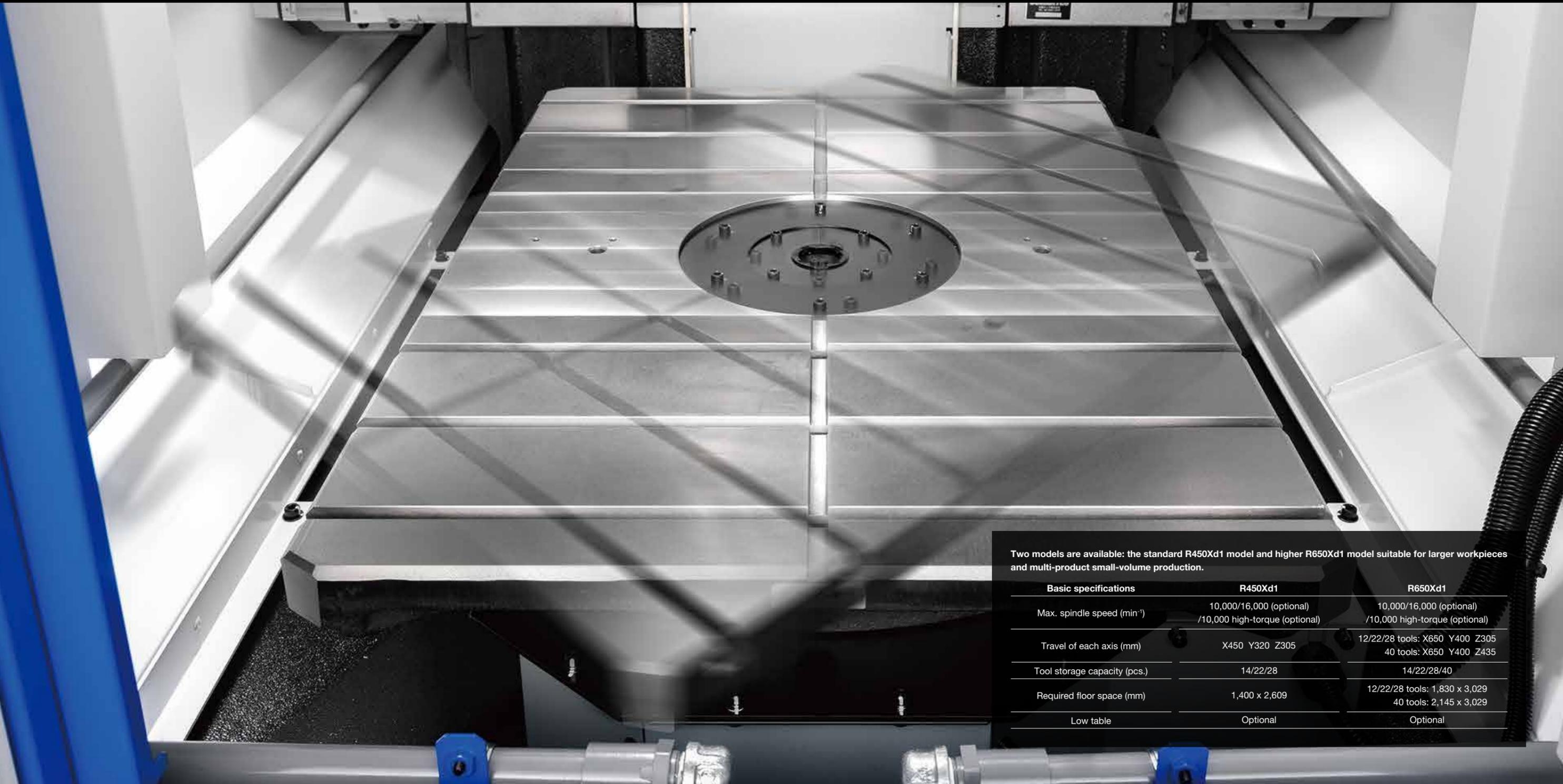
Cutting Out the Waste *SPEEDIO*



R450Xd1



R650Xd1



Two models are available: the standard R450Xd1 model and higher R650Xd1 model suitable for larger workpieces and multi-product small-volume production.

Basic specifications	R450Xd1	R650Xd1
Max. spindle speed (min ⁻¹)	10,000/16,000 (optional) /10,000 high-torque (optional)	10,000/16,000 (optional) /10,000 high-torque (optional)
Travel of each axis (mm)	X450 Y320 Z305	12/22/28 tools: X650 Y400 Z305 40 tools: X650 Y400 Z435
Tool storage capacity (pcs.)	14/22/28	14/22/28/40
Required floor space (mm)	1,400 x 2,609	12/22/28 tools: 1,830 x 3,029 40 tools: 2,145 x 3,029
Low table	Optional	Optional

Provides high productivity with a broad range of applications from mass production to multi-product small-volume production

While maintaining the SPEEDIO's high-speed performance and usability, extensive magazine specifications and a pallet changer provide high productivity for customers in various industries.

Automobile



Aluminum wheel
Aluminum alloy
Size: ø550 x 200

Precision equipment



Watch/clock plate
Brass
Size: ø25 x 2.6



L-shaped bracket
Stainless steel
Size: 95 x 85 x 35



Plate
Stainless steel
Size: 65 x 50 x 8



EV frame
Aluminum alloy
Size: 430 x 220 x 150



ABS valve housing
Aluminum si<3%
Size: 90 x 70 x 30

Valve



Gas control valve
Stainless steel
Size: 75 x 35 x 35



Chemical control valve
PFA resin
Size: 200 x 55 x 75



Hot-water supply valve
Brass
Size: 150 x 120 x 90



Brake caliper
Cast iron
Size: 120 x 65 x 220



Yoke
Carbon steel
Size: 44 x 30 x 69

QT table achieves high productivity, eliminating waste in workpiece change time

The QT table is Brother's original high-speed 2-face pallet changer. With a wide jig area and a high degree of reliability, the QT table enables non-stop machining to achieve high productivity.

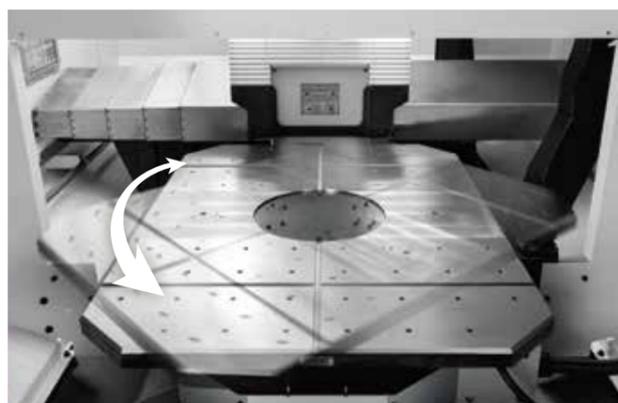
High-speed pallet change

The QT (Quick Turn) table is a turntable type high-speed 2-face pallet changer. Optimized acceleration/deceleration control achieves much faster pallet change.

Pallet change time	R450Xd1	2.9s ▶ 2.7s
	R650Xd1	3.4s ▶ 3.1s

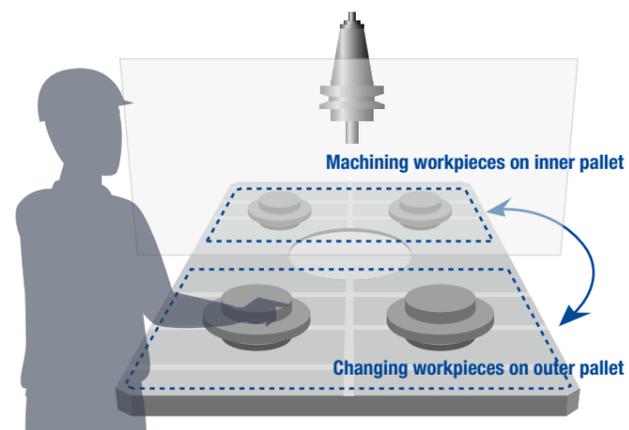
High reliability

To ensure high reliability, effects by chips etc. are minimized by a turntable that avoids lift-up motion and has a sealed structure, and positioning accuracy is maintained by the stopper mechanism.



Non-stop machining

Workpieces on one pallet can be changed while machining workpieces on the other pallet. Waste in workpiece change time is eliminated, enabling non-stop machining.

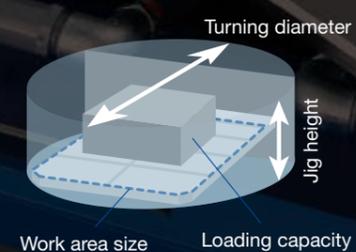
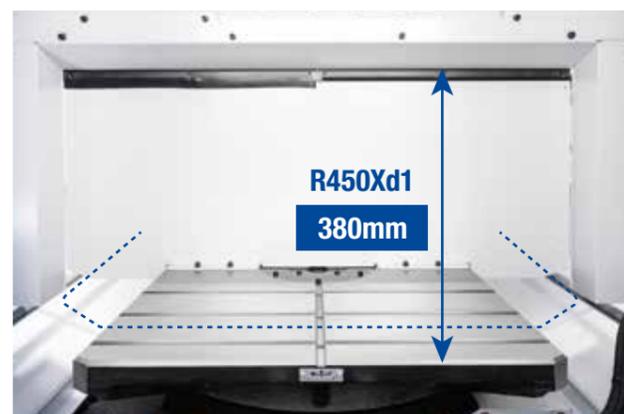


Large jig area

Even if the jig protrudes from the table, it can be mounted as long as it is within the pallet turning diameter. The jig area can be further expanded by selecting a low table option that increases the jig height or a turning diameter enlargement option that increases the jig space.

Low table (optional) increases jig height

Max. jig height	R450Xd1	350 ▶ 380	R650Xd1	420 ▶ 450
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	R450Xd1	R650Xd1
Work area size (mm)	600 x 300	800 x 400
Max. turning diameter (mm) *1	1100 (1020)	1300 (1250)
Max. jig height (mm) *2	380 (300)	450 (350)
Max. loading capacity (kg/face) *3	200 (120)	300 (200)

*1: When a turning diameter enlargement option is selected *2: When a low table option is selected
*3: Parameter needs to be adjusted. *4: Values in brackets () indicate values for standard specifications.

QT table achieves efficient production, utilizing advantages of pallet changer

The QT table eliminates various types of waste generated at production sites, achieving stable and efficient production. The QT table ensures both productivity and quality, and enables flexible automation.

Advantages of QT table

1. Stable production

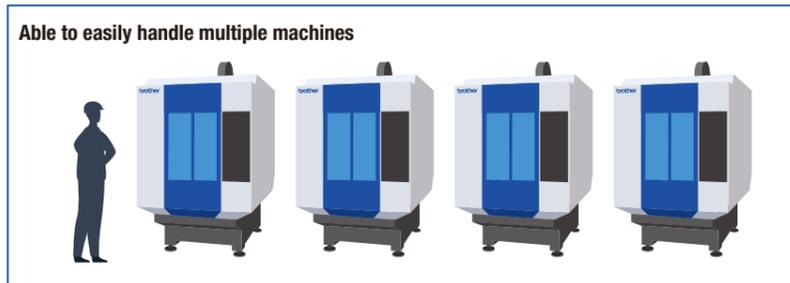
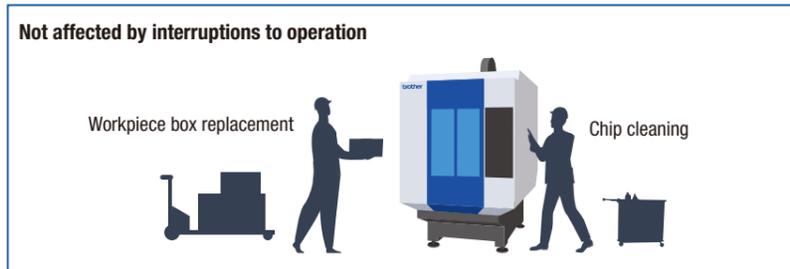
As workpieces are changed while machining workpieces on the inner pallet, stable production volume can be secured without being affected by any fluctuation in workpiece change time.

2. Interruptions to operation

Effects on production are minimized even if interruptions to operation occur during production, such as workpiece box replacement and chip cleaning.

3. Handling multiple machines

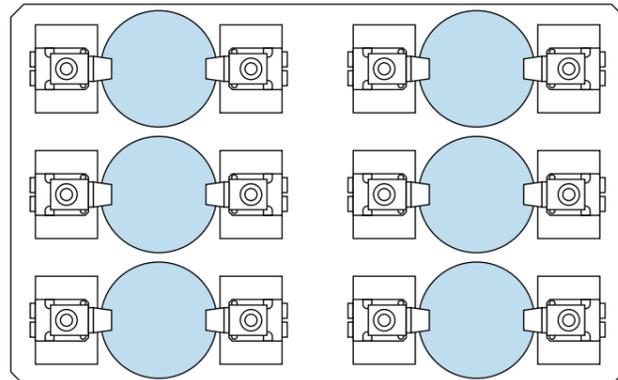
One operator can change workpieces for multiple machines without suspending production. This means one operator can handle multiple machines easily, leading to streamlining of production sites.



Cases of streamlined production

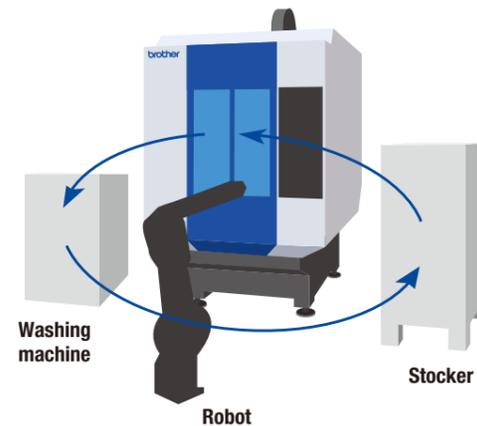
Case 1: Long workpiece change time

High productivity can be maintained even when workpiece change takes time, such as in multi-part machining or when jig washing takes time to minimize effects of chips. Both the productivity and quality can be improved.



Case 2: Automation

Productivity is not affected even if workpiece setting or jig washing takes time. In addition, a flexible robot cycle, including peripheral equipment, can be configured.



Magazines with extensive variation

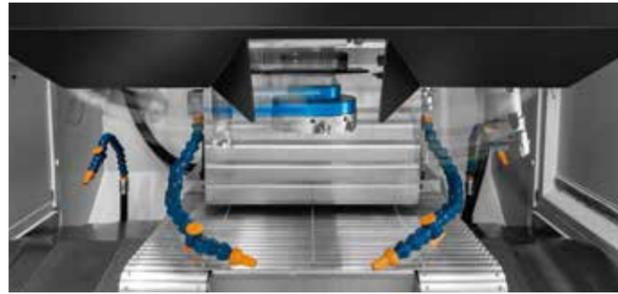
Overwhelming high productivity through machine/controller integrated development

Including a newly developed 28-tool magazine, a 40-tool magazine with a maximum storage capacity is available in response to a variety of machining needs.

Overwhelming high productivity is achieved by utilizing advantages of machine/controller integrated development, including optimized and faster simultaneous operation and tool change operation.

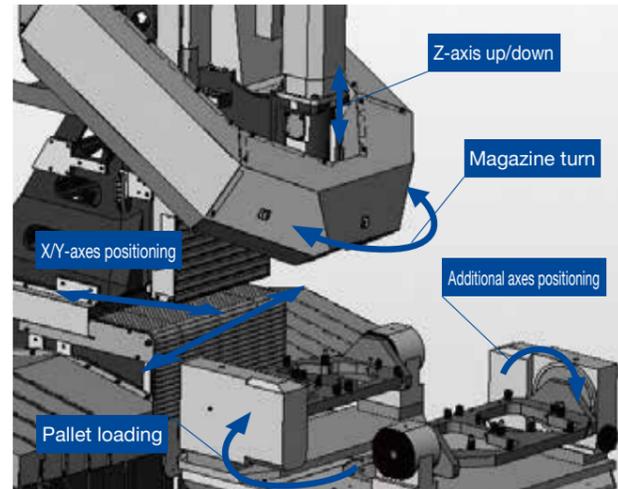
28-tool magazine

A new compact turret type 28-tool magazine has been developed with high-speed tool change performance maintained. This expands the range of target machining parts and promotes process integration.



Simultaneous operation

Equipped with a simultaneous operation control that simultaneously performs tool change, QT table turn, and positioning of X/Y and additional axes. This avoids any wasted pallet change time.



40-tool magazine (R650Xd1)

In addition to 14/22/28-tool magazines, a 40-tool magazine is available. This promotes process integration, taking advantage of a 2-face pallet changer, and encourages productivity improvement.



High acceleration/deceleration spindle

Using a low inertia and high acceleration/deceleration spindle motor enables the spindle to start or stop in an extremely short time.

Spindle start/stop time 0.15s or less * High-torque specifications

For the 40-tool magazine, the machining room is separated from the tool stocker by a shutter type door. This prevents chips entering the magazine.



Pot shutter closed

Pot shutter open



High-speed tool change

Shorter tool change time has been achieved by faster and optimized spindle start/stop, Z-axis up/down, and magazine operation.

Magazine capacity	Chip-Chip	Tool-Tool
14 tools (*1)	1.3s	0.6s
28 tools (*1)	1.5s	0.7s
40 tools (*2)	2.5s	0.9s

(*1) Values for the R450Xd1 (*2) Values for the R650Xd1

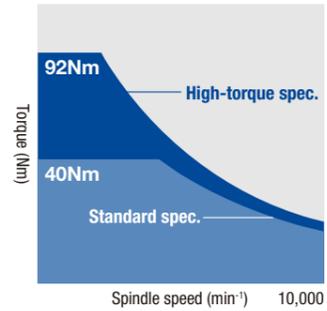
Provides broad cutting performance from high-speed and highly efficient machining to heavy-duty machining

High rigidity based on a special design and use of a high-torque spindle motor achieves stable machining while demonstrating high machining capability.

From heavy-duty machining to high-speed and highly efficient machining

A spindle motor with high torque in the medium- and high-speed range is used to achieve high-speed and highly efficient machining. In addition, the high-torque spec. (optional) machine greatly improves torque in the low-speed range. The machine provides excellent performance in heavy-duty machining of iron.

Motor torque characteristics



High-torque spec. (optional)	Standard spec.
Max. torque 92Nm	Max. torque 40Nm
Max. output 26.2kW	Max. output 18.9kW

7 MPa Coolant Through Spindle (CTS) (optional)

The CTS option can be selected from 3 MPa or 7 MPa. With this option, the machine can operate to its fullest potential in high-speed drilling or peck drilling.



High-speed and highly accurate three-dimensional machining

In addition to the highly responsive servomotor, the servo processing speed and resolution have been greatly improved. Enhanced performance of original three-dimensional machining control, including a great increase in look-ahead blocks and improved surface quality by the smooth path offset function, achieves high-speed and highly accurate three-dimensional machining.



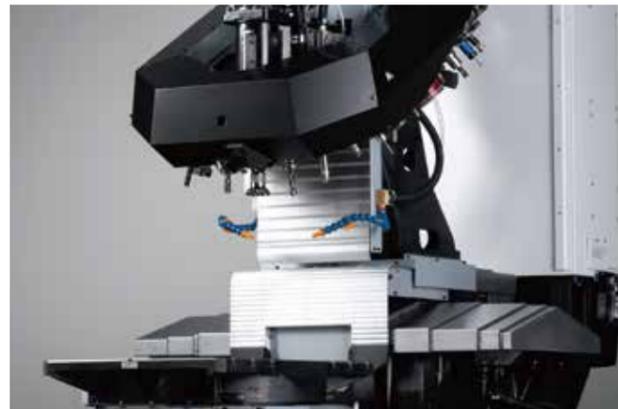
Simple setting for high accuracy mode

Machining accuracy/surface quality parameters can be adjusted by simple operation. This helps achieve high-quality machining easily.

High accuracy mode BI	Look-ahead 160 blocks
High accuracy mode BII (optional)	Look-ahead 1000 blocks

Highly rigid structure

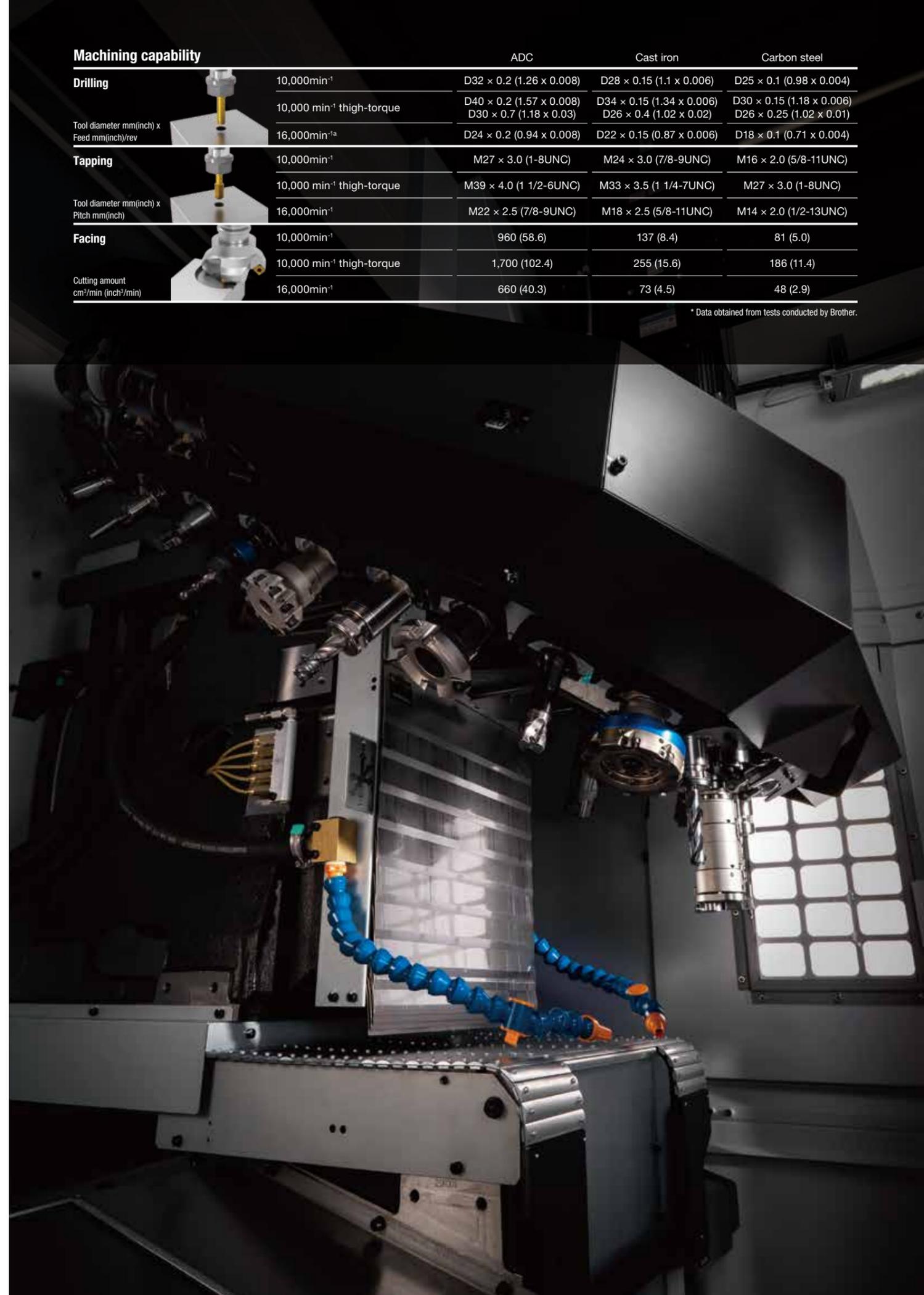
Based on accumulated technical analysis data, a highly rigid machine structure with minimal vibration has been achieved to provide excellent cutting performance.



Machining capability

		ADC	Cast iron	Carbon steel
Drilling	10,000min ⁻¹	D32 × 0.2 (1.26 × 0.008)	D28 × 0.15 (1.1 × 0.006)	D25 × 0.1 (0.98 × 0.004)
	10,000 min ⁻¹ thigh-torque	D40 × 0.2 (1.57 × 0.008)	D34 × 0.15 (1.34 × 0.006)	D30 × 0.15 (1.18 × 0.006)
	Tool diameter mm(inch) x Feed mm(inch)/rev	D30 × 0.7 (1.18 × 0.03)	D26 × 0.4 (1.02 × 0.02)	D26 × 0.25 (1.02 × 0.01)
Tapping	16,000min ^{-1a}	D24 × 0.2 (0.94 × 0.008)	D22 × 0.15 (0.87 × 0.006)	D18 × 0.1 (0.71 × 0.004)
	10,000min ⁻¹	M27 × 3.0 (1-8UNC)	M24 × 3.0 (7/8-9UNC)	M16 × 2.0 (5/8-11UNC)
	10,000 min ⁻¹ thigh-torque	M39 × 4.0 (1 1/2-6UNC)	M33 × 3.5 (1 1/4-7UNC)	M27 × 3.0 (1-8UNC)
Facing	16,000min ⁻¹	M22 × 2.5 (7/8-9UNC)	M18 × 2.5 (5/8-11UNC)	M14 × 2.0 (1/2-13UNC)
	Tool diameter mm(inch) x Pitch mm(inch)			
	10,000min ⁻¹	960 (58.6)	137 (8.4)	81 (5.0)
	10,000 min ⁻¹ thigh-torque	1,700 (102.4)	255 (15.6)	186 (11.4)
	16,000min ⁻¹	660 (40.3)	73 (4.5)	48 (2.9)
Cutting amount cm ³ /min (inch ³ /min)				

* Data obtained from tests conducted by Brother.

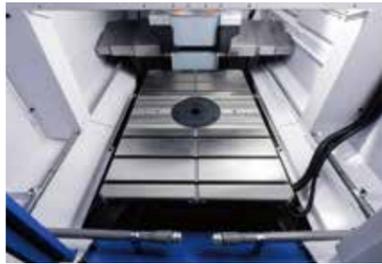


Accessibility and operability have been enhanced to make pallet changer more access-friendly and setup easier

Accessibility and operability from the front and side of the machine have been enhanced so that operators can easily perform setup, such as workpiece change and tool change.

Front setup accessibility

An access-friendly table is used so that operators can easily perform setup, including workpiece change.



Front wide opening width

A wide door opening width is secured to make workpiece change easier.



Opening width	
R650Xd1:	845mm
R450Xd1:	655mm

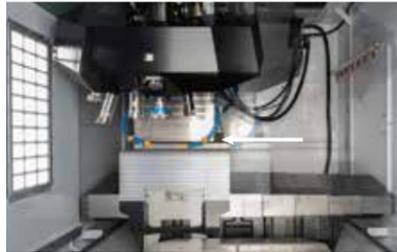
Side door for easy setup

The R450Xd1 (22/28 tools) and R650Xd1 are standard equipped with a side door.



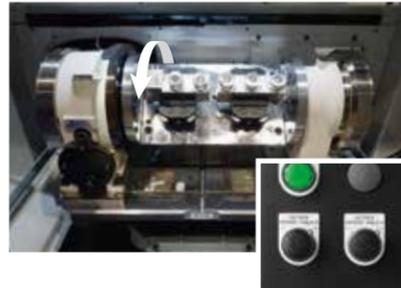
Column movement when changing tools

Equipped with a function that moves the column to a position where tools can be changed easily.



Outside rotary table switch

The outside rotary table can be operated by this switch.



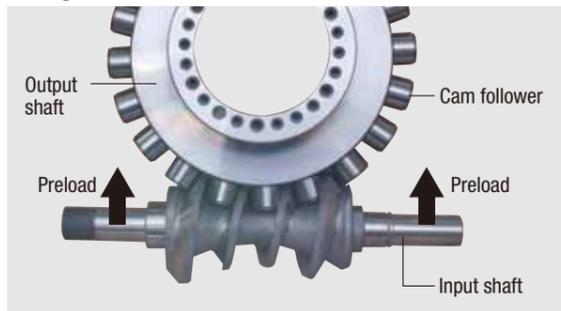
Rotary table T-200Ad

Roller gear cam mechanism is used. A wider jig area can be secured due to the thin body. Using a support table (optional) enables a trunnion jig to be used.



High productivity High accuracy Extended service life

Roller gear cam mechanism



0 to 180-deg. indexing time

Clamp mode	1.02s
Unclamp mode	0.45s





Equipped with new “CNC-D00” controller Enhanced usability with 15-inch LCD touch panel

Intuitive operation is possible with new apps and vertical touch panel screen. Relevant functions are grouped according to purpose, such as setup and machining, leading to efficient operation. Production and operation states are visualized, allowing faster understanding. Waste-free operation is possible in setup, machining adjustment, production, and recovery process, leading to improved work efficiency and operating rate.

Home screen

Information required for production, such as workpiece counter and tool life, is collected on the home screen. Shortcut keys are provided for screens frequently used so you can open them by one touch.



Remaining/Elapsed machining time

Workpiece counter

Support apps/
Shortcut keys

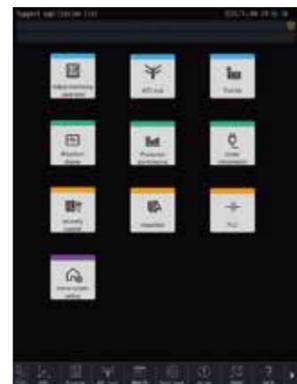
Screen keys

Program

Tool life

New user interface

Usability has been greatly improved by grouping relevant functions, creating new support apps that are intuitive with improved operability and visibility, providing useful accessories (calculator, notebook, file viewer etc.), and making operation on conventional screens possible on the touch panel.



List of support apps



Conventional screen (position screen)

Setup support

Equipped with functions to easily perform setup, such as an ATC tool app that enables all magazine tool settings to be performed on one screen, menu programming that enables you to create NC programs by following instructions on the screen, and an on-screen help function.



ATC tool app

Machining adjustment support

Equipped with functions to easily perform optimal machining adjustment to improve productivity, such as a machining parameter adjustment app that enables you to easily adjust parameters according to machining details and a machining load waveform display/saving function.



Waveform display app

Production support

Equipped with functions to improve the operating rate, such as real time tool monitoring to eliminate defects, displaying production performance, power consumption etc. as a graph, and PLC/network functions to meet peripheral equipment and automation requirements.



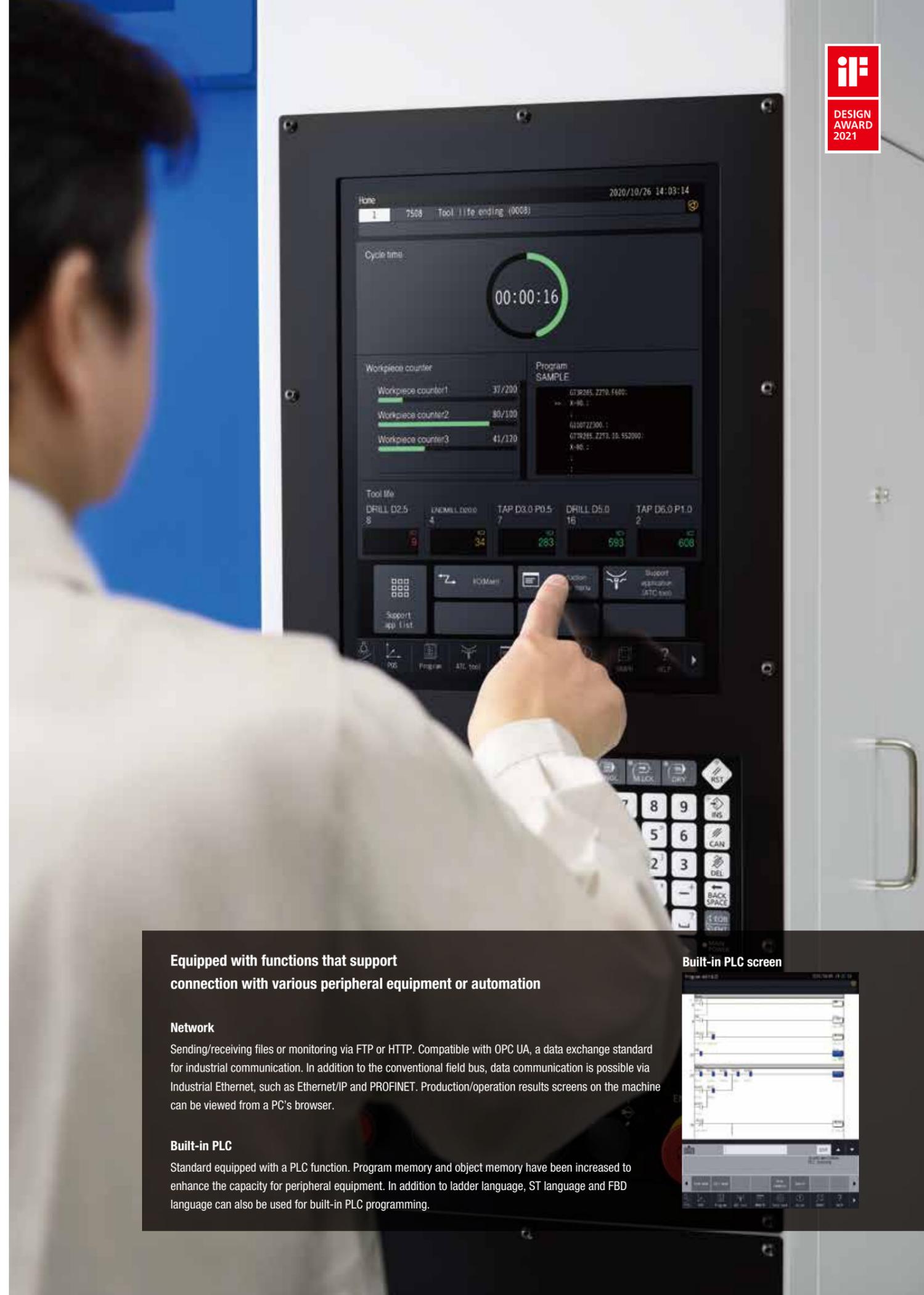
Production performance app

Recovery support

Equipped with functions to prevent failure or ensure quick recovery, such as maintenance time notice, displaying details when an alarm occurs, and guidance for recovery/check work.



Recovery support app



Equipped with functions that support connection with various peripheral equipment or automation

Network

Sending/receiving files or monitoring via FTP or HTTP. Compatible with OPC UA, a data exchange standard for industrial communication. In addition to the conventional field bus, data communication is possible via Industrial Ethernet, such as Ethernet/IP and PROFINET. Production/operation results screens on the machine can be viewed from a PC's browser.

Built-in PLC

Standard equipped with a PLC function. Program memory and object memory have been increased to enhance the capacity for peripheral equipment. In addition to ladder language, ST language and FBD language can also be used for built-in PLC programming.

Built-in PLC screen



Reliability maintains high productivity

Measures for chips, including a center trough structure, and enhanced maintenance functions prevent machine failure.

Problem-free operation is ensured by reducing machining defects.

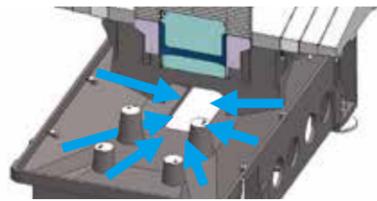
Avoiding machine stoppage maintains high productivity at production sites.

Prevention of chip related problems

In response to increase in chips due to process integration, problems possibly caused by chips are prevented by thoroughly evacuating/removing chips, leading to improved reliability.

Center trough structure

A new center trough structure is used under the QT table. Chips slide down the inclined base and are discharged to the outside of the machine. Chip evacuation performance has been improved by almost two-fold.



Chip conveyor tank, coolant tank with chute (optional)

Two types of coolant tanks are available: hinge and scraper type chip conveyor tank and coolant tank with chute where chips are flushed by coolant. Either can be selected depending on the purpose. Using these tanks can reduce chip cleaning frequency.



Reliable maintenance functions

Equipped with a variety of maintenance functions to prevent defects that may occur at production sites or to assist recovery from problems.

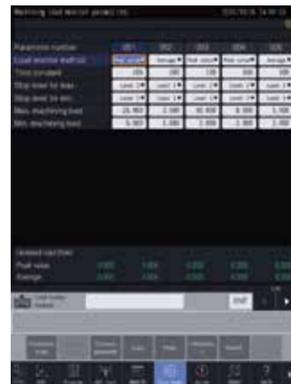
ATC tool monitoring

The presence of a spindle tool, tool holder mis-clamp, tool key position deviation etc. are checked before and after tool change without using a sensor.



Machining load monitoring

Machining load applied to the spindle is monitored to issue an alarm when the load is not within the preset range.



Maintenance notice

Issues maintenance related notices in advance, such as greasing time.



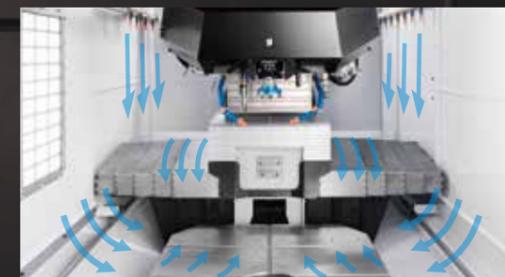
Alarm log

Displays alarm log details to help identify the cause.



Chip shower (optional)

In response to a wide machining area, the R650Xd1 is equipped with two chip shower pumps to greatly increase the flow rate. Piping is added to the top face to improve chip evacuation performance.



Tool washing, air-assisted type (optional)

Air-assisted high discharge pressure and discharge amount steadily remove chips attached to the spindle taper. This prevents the filter becoming clogged, ensuring stable washing performance. Expanding the pump capacity is not necessary, leading to higher energy saving.



Striving to create earth-friendly machines

Our efforts to improve environmental performance and effects of high productivity greatly reduce power consumption, contributing to the carbon neutrality of plants.

Low power consumption

In addition to the low inertia spindle and highly efficient spindle motor, the machine is equipped with various energy saving functions to lower power consumption.

Power regeneration system

Reuses the energy generated when the servomotor decelerates.

Power consumption app

Current and past power consumption can be checked.



Highly efficient spindle motor

Energy-saving pump

LED work light

Energy-saving NC functions

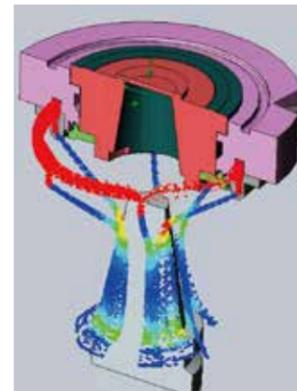
- Automatic coolant off
- Automatic work light off
- Standby mode
- Automatic power off

Low air consumption

Air related functions have been reviewed and optimized to eliminate any waste, leading to reduction in air consumption.

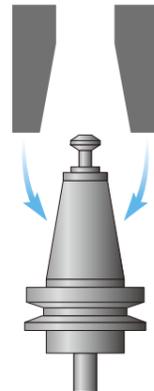
Air purge

A highly airtight structure achieved through repeated flow rate analysis reduces the amount of air used.



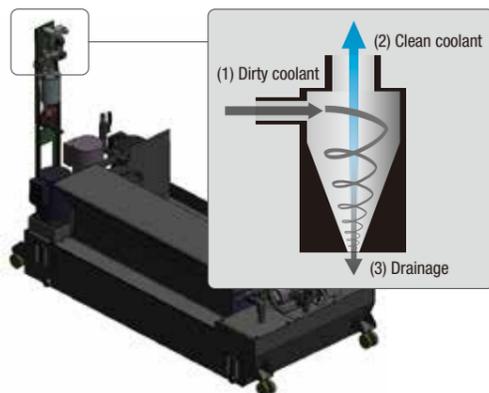
Spindle air blow

Amount of air used is reduced by discharging three times the conventional volume of air only when required.



Tank with cyclone filter and no consumables (special option for CTS)

Clean coolant is returned to the clean tank through another tank with a cyclone filter that removes fine chips. Coolant is kept clean this way to reduce the filter change frequency and extend the service life of the pump.



Automatic oil/grease lubricator that optimizes consumption (optional)

Consumption amount and timing are optimized by the automatic oil/grease lubricator. Oil mixing with coolant can be minimized.

Automatic oil lubricator



Automatic grease lubricator

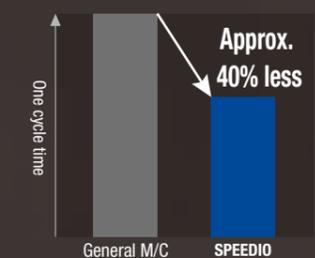


Efforts for carbon neutrality

Brother will contribute to achieve a sustainable society through the development and sales of products with less environmental load and energy consumption.

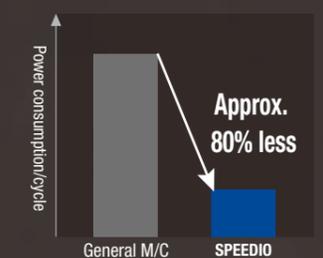
Reduction in machining time

Compared to general M/Cs, machining time has been greatly reduced.



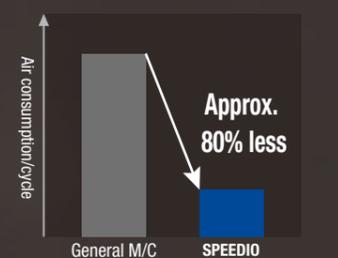
Reduction in power consumption

Compared to general M/Cs, power consumption has been greatly reduced.



Reduction in air consumption

Compared to general M/Cs, air consumption has been greatly reduced.





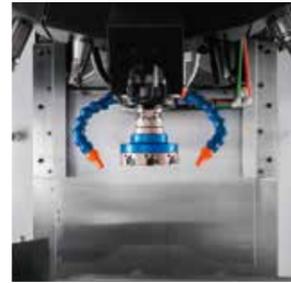
Coolant tank
Two types are available: coolant tank with chute and hinge + scraper type chip conveyor tank. (The photo shows coolant tank with chute, 250L)



Coolant Through Spindle (CTS)
Can be selected from 3.0 MPa or 7.0 MPa. Pump and tank are not included.



Column coolant nozzle
Powerfully removes chips on and around the workpiece to prevent chips building up. * Cannot be selected for the 40-tool magazine spec.



Head coolant nozzle
Coolant can reliably be applied to the machining section as the tool and nozzles are set in place.



Automatic oil lubricator
Regularly applies oil to all lubricating points on the tree axes.



Automatic grease lubricator
Regularly applies grease to all lubricating points on the three axes. *Manual greasing is required for the standard specification model.



Automatic door with switch panel 10 holes
A motor-driven door is used, achieving smooth operation.



Area sensor
Optical area sensors are used. Use area sensors to prevent operators being caught in the automatic door.



Chip shower
Chip shower pipes are located at the upper section inside the machine for more efficient flow, and flexible shower nozzles can be directed to the side of the machine cover or sections where chips tend to accumulate.



Tool washing, air-assisted type
High discharge pressure and flow rate efficiently remove chips attached to the holder. Equipped with a filter clog warning function.



Fixture shower valve unit
Consists of jig washing valves and pipes to the ceiling of the machine. Pipes from the machine to the required location must be prepared by customers.



Cleaning gun
Helps clean the workpiece or chips inside the machine after machining.



Switch panel (8 holes or 10 holes)
Various switches, such as automatic door open/close switches, are set in specific locations. The switch panel (8 holes) is also available so that the position of the manual pulse connector can be changed.



Manual pulse generator
A cable is provided for the manual pulse generator, making setup easier. Equipped with emergency stop and enable switches.



Tool breakage detector, touch type
A touch switch type tool breakage detector is available.



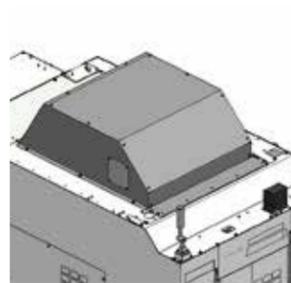
Rotary table T-200Ad
Reduction in the body width secures a wider jig area. Use of the roller gear cam mechanism achieves high productivity, high accuracy, and extended service life.



Hydraulic rotary joint (4 ports)
Pneumatic relay box (12 ports)
12 pneumatic ports and 4 hydraulic ports have been prepared so that jigs that use pneumatic or hydraulic pressure can be mounted easily. * For the R450Xd1, the Y-axis travel decreases when a hydraulic rotary joint is used.



Turning diameter enlargement (R450Xd1: ø1,100, R650Xd1: ø1,300)
A wider jig area can be secured by enlarging the QT table turning diameter.



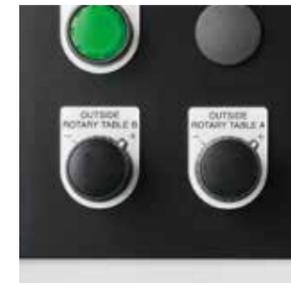
Top cover
Shutting the opening on the top prevents coolant or chips splashing outside of the machine. A hole for the mist collector is provided.



Side door with transparent window
Makes setup or tool change from the side easier. The machining room can be checked through the window. * Standard for the R450Xd1 with 22/28-tool magazine and the R650Xd1.



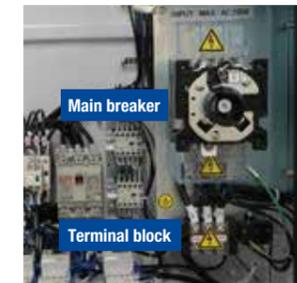
Spindle override
Spindle speed can be changed without changing the program.



Outside rotary table switch
The outside rotary table can be operated by this switch. * A switch panel (8 holes or 10 holes) is required separately.



Master on circuit
Master on circuit and switch can be attached. * A switch panel (8 holes or 10 holes) is required separately.



Power supply expansion 50A
The capacity of the main breaker has been increased from 30A to 50A. The size of the relevant wiring has also been increased. A terminal block for external equipment power supply is provided under the main breaker.



Side cover with transparent window
External light is drawn in to make the inside of the machine brighter and improve visibility. * For the R650Xd1, this option is installed on the right side when viewed from the front of the machine.



Work light (1 or 2 lamps)
LED lamps are used to extend lamp life and save energy. * For the R450Xd1, the 1st lamp is installed on the right side, and the 2nd lamp on the left side. For the R650Xd1, the 1st and 2nd lamps are both installed on the left side.



Table light
Brightens the setup room. LED lamps are used to extend lamp life and save energy.



Signal light (1, 2, or 3 lamps)
LED lamps are used. No maintenance required. Can be tilted to improve visibility.

- Coolant tank <R450Xd1>
 - Coolant tank with chute, 150L
 - Coolant tank with chute, 150L for 1.5 MPa CTS pump with cyclone filter
 - Coolant tank with chute, 200L for 1.5 MPa CTS pump with cyclone filter
- Coolant tank with chute, 250L
- Coolant tank with chute, 250L for 1.5 MPa CTS pump with cyclone filter
- Chip conveyor tank, 390L
- Chip conveyor tank, 390L for 1.5 MPa CTS pump with cyclone filter
- Coolant through spindle (CTS) piping, Max. 3.0 MPa
- Coolant through spindle (CTS) piping, Max. 7.0 MPa
- Column coolant nozzle
- Head coolant nozzle
- Chip shower
- Tool washing, air-assisted type
- Fixture shower valve unit
- Cleaning gun
- Mesh basket for collecting chips
- Hydraulic rotary joint (4 ports)

- Pneumatic relay box (12 ports)
- Turning diameter enlargement (R450Xd1: ø1,100, R650Xd1: ø1,300)
- Top cover
- Side door with transparent window, right side * R450Xd1 only
- Side cover with transparent window (R450Xd1: Left side, R650Xd1: Right side)
- Work light (1 or 2 lamps)
- Table light
- Signal light (1, 2, or 3 lamps)
- Automatic oil lubricator
- Automatic grease lubricator
- Automatic door with switch panel 10 holes
- Area sensor
- Switch panel (8 holes or 10 holes)
- Front switch panel (10 holes) * R650Xd1 only
- Manual pulse generator with enable switch
- Connector and hook for manual pulse generator with enable switch
- Tool breakage detector, touch type
- Rotary table T-200Ad
- Additional axis cable (for 1 axis, 2 axes, 3 axes, or 4 axes)
- RS232C 25-pin connector at control box
- Spindle override
- Outside rotary table switch (for 1 axis or 2 axes)
- Side magazine switch * R450Xd1 only

- Outside start switch on the side * R650Xd1 only
- Master on circuit
- Data protection switch, key type
- Grip cover for 14/21/28-tool magazine
- Folding door (two-door)
- Parts name sticker set
- Origin alignment mark
- Outlet in control box (100V)
- Power supply expansion 50A
- Transformer box
- Specified color
- EXIO board assembly
 - 1) EXIO board, input 32/output 32, additional #1
 - 2) EXIO board, input 32/output 32, additional #2
- PLC programming software for D00
- Industrial network
 - 1) CC-Link, master station
 - 2) CC-Link, remote device station
 - 3) PROFIBUS DP, slave
 - 4) DeviceNet, slave
 - 5) PROFINET, slave
 - 6) EtherNet/IP, slave
- Memory expansion 3 Gbytes

Machine Specifications

Item	R450Xd1/R450Xd1 RD *12		R650Xd1/R650Xd1 RD *12	
			14/22/28 tool magazine	40-tool magazine
CNC Unit	CNC-D00		CNC-D00	
Travels	X axis	mm(inch)	450 (17.7)	650 (25.6)
	Y axis	mm(inch)	320 (12.6) *7	400 (15.7)
	Z axis	mm(inch)	305 (12.0)	305 (12.0) 435 (17.1)
	Distance between table top and spindle nose end	mm(inch)	200~505 (7.9~19.9)[280~585 (11.0~23.0) *8]	250~555 (9.8~21.8) [350~655 (13.8~25.8) *8] 250~685 (9.8~27.0) [350~785 (13.8~30.9) *8]
Table	Work area size	mm(inch)	One face 600 x 300 (23.6 x 11.8)	One face 800 x 400 (31.5 x 15.7)
	Max. loading capacity (uniform load)	kg(lbs)	One face 120 (265) [200(441) *6]	One face 200 (441) [300 (661) *6]
	Position time	sec.	2.7 *11	3.1 *11
Spindle	Spindle speed	min ⁻¹	10,000min ⁻¹ specifications: 1~10,000 16,000min ⁻¹ specifications(optional): 1~16,000 10,000min ⁻¹ high-torque specifications(optional): 1~10,000	10,000min ⁻¹ specifications: 1~10,000 16,000min ⁻¹ specifications(optional): 1~16,000 10,000min ⁻¹ high-torque specifications(optional): 1~10,000
	Speed during tapping	min ⁻¹	MAX. 6,000	MAX. 6,000
	Tapered hole		7/24 tapered No.30	7/24 tapered No.30
	BT dual contact system(BIG-PLUS)		Optional	Optional
	Coolant Through Spindle(CTS)		Optional	Optional
Feed rate	Rapid traverse rate(XYZ-area)	m/min(inch/min)	50 x 50 x 50 (1,969 x 1,969 x 1,969)	50 x 50 x 50 (1,969 x 1,969 x 1,969)
	Cutting feed rate	mm/min(inch/min)	X, Y, Z axis : * 9 ~30,000 (0.04~1,181) *9	X, Y, Z axis: 1~30,000 (0.04~1,181) *9
ATC unit	Tool shank type		MAS-BT30	MAS-BT30
	Pull stad type *4		MAS-P30T-2	MAS-P30T-2
	Tool storage capacity	pcs.	14 / 22 / 28	14 / 22 / 28 40
	Max. tool length	mm(inch)	200 (7.9)	200 (7.9) 250 (9.8)
	Max. tool diameter	mm(inch)	80 (3.1)	80 (3.1) 55 (2.1) / 125 (4.9) No adjacent tool
	Max. tool weight *1	kg(lbs)	3.0 (6.6) <total tool weight: 25 (55.1) for 14-tool, 40 (88.2) for 22/28 tool>	3.0 (6.6) <total tool weight: 25 (55.1) for 14-tool, 40 (88.2) for 22/28 tool> 4.0 (8.8) <total tool weight: 80 (176.3) >
	Tool selection method		Random short cut method	Random short cut method Double arm method (random closet path)
Tool change time	Tool To Tool	sec.	0.6 / 0.7 (14-tool / 22 or 28 tool)	0.6 / 0.8 (14-tool / 22 or 28 tool) 0.9
	Chip To Chip	sec.	1.3 / 1.5 (14-tool / 22 or 28 tool)	1.4 / 1.5 (14-tool / 22 or 28 tool) 2.5
Electric motor	Main spindle motor (10min/continuous) *2	kW	10,000min ⁻¹ specifications: 10.1 / 7.0 16,000min ⁻¹ specifications: 7.4 / 5.1 10,000min ⁻¹ high-torque specifications: 12.8 / 9.2	10,000min ⁻¹ specifications: 10.1 / 7.0 16,000min ⁻¹ specifications: 7.4 / 5.1 10,000min ⁻¹ high-torque specifications: 12.8 / 9.2
	Axis feed motor	kW	X, Y axis: 1.0 Z axis: 1.8	X, Y axis: 1.0 Z axis: 1.8
Power source	Power supply		AC200V±10%, 50/60Hz±1Hz	AC200V±10%, 50/60Hz±1Hz
	Power capacity (continuous)	kVA	10,000min ⁻¹ specifications: 9.5 16,000min ⁻¹ specifications: 9.5 10,000min ⁻¹ high-torque specifications: 10.4	10,000min ⁻¹ specifications: 9.5 16,000min ⁻¹ specifications: 9.5 10,000min ⁻¹ high-torque specifications: 10.4
	Air supply	Regular air pressure MPa Required flow L/min	0.4~0.6 (recommended value : 0.5MPa *10) 45	0.4~0.6 (recommended value: 0.5MPa *10) 45 100
Machining dimensions	Height	mm(inch)	2,584 (101.7)	2,704 (106.5)
	Required floor space *13 (with control unit door open)	mm(inch)	1,400 x 2,609 [3,448] (55.1 x 102.7 [135.7])	1,830 x 3,029 [3,868] (72.0 x 119.3 [152.3]) 2,145 x 3,029 [3,868] (84.4 x 119.3 [152.3])
	Weight	kg(lbs)	2,750 (6,063)	3,550 (7,826) 4,150 (9,149)
Accuracy *3	Accuracy of bidirectional axis positioning(SO230-2: 1988)	mm(inch)	0.006~0.020 (0.00024~0.00079)	0.006~0.020 (0.00024~0.00079)
	Repeatability of bidirectional axis positioning(SO230-2: 2014)	mm(inch)	Less than 0.004 (0.00016)	Less than 0.004 (0.00016)
Front door			2doors	2doors
Standard accessories	Instruction Manual (DVD 1 set), leveling bolts (4 pcs.) [R650Xd1: 5 pcs.], leveling plate (4 pcs.) [R650Xd1: 5 pcs.]			

*1 Actual tool weight differs depending on the configuration and center of gravity. The figures shown here are for reference only. *2 Spindle motor output differs depending on the spindle speed. *3 Measured in compliance with ISO standards and Brother standards. Please contact your local distributor for details. *4 Brother specifications apply to the pull studs for CTS. *5 Measured in compliance with JIS B6336-9 and MAS011-1987. *6 Can be increased up to R450Xd1: 200kg, R650Xd1: 300kg (one face) by changing the parameter. Please consult us separately. *7 When using the hydraulic rotary joint, the Y-axis travel becomes 290 mm. *8 Values when the low-floor table is selected. *9 When using high accuracy mode B. *10 Regular air pressure varies depending on the machine specifications, machining program details, or use of peripheral equipment. Set the pressure higher than the recommend value. *11 When table loading on one face is R450Xd1: 120kg, R650Xd1: 200kg. *12 The machine needs to be equipped with a relocation detection device depending on the destination. Machines equipped with a relocation detection device come with "RD" at the end of the model name. *13 The value does not include the coolant tank or chip conveyor. *14 When the turning diameter enlargement option is selected.

Quick turn table specifications

Item	R450Xd1	R650Xd1
Type	0 deg./180 deg. turntable system	0 deg./180 deg. turntable system
Table dimension	mm(inch)	mm(inch)
Table dimension	One face 600 x 420 (23.6 x 16.5)	One face 800 x 535 (31.5 x 21.1)
Max. turning diameter	mm(inch)	mm(inch)
Max. turning diameter	D1,020 (40.2) [D1,100 (43.3)] *14	D1,250 (49.2) [D1,300 (51.2)] *14
Max. jig height	mm(inch)	mm(inch)
Max. jig height	300 (11.8) [380 (15.0)] *8	350 (13.8) [450 (17.7)] *8
Table work area size	mm(inch)	mm(inch)
Table work area size	One face 600 x 300 (23.6 x 11.8)	One face 800 x 400 (31.5 x 15.7)
Max. loading capacity	kg (lbs)	kg (lbs)
Max. loading capacity	One face 120 (265) [200 (441)] *6	One face 200 (441) [300 (661)] *6
Rated table load inertia for turning axis	kg·m ²	kg·m ²
Rated table load inertia for turning axis	One face 14.2 [23.5] *6	One face 35.8 [53.7] *6
Table turning system	AC servo motor(1kW) Worm gear(total speed reduction ratio:1/50)	AC servo motor(0.82kW) Worm gear(total speed reduction ratio:1/60)
Table position time	sec	sec
Table position time	2.7 *11	3.1 *11
Table change repeatability	mm(inch)	mm(inch)
Table change repeatability	0.005 (0.0002) (in the X,Y, and Z axes directions 270(10.6) from the center of rotation)	0.005 (0.0002) (in the X,Y, and Z axes directions 335(13.2) from the center of rotation)

*Quick Turn table is a turntable type 2-face pallet changer.

NC functions

Operation	Dry run		Maintenance	Tap return function	Functions limited to NC language	Menu programming
	Machine lock			Status log		Local coordinate system
	Program restart			Alarm log		Expanded workpiece coordinate system
	Rapid traverse override			Operation log		One-way positioning
	Cutting feed override			Motor insulation resistance measurement		Inverse time feed
	Background editing			Tool washing filter with filter clogging detection		Programmable data input
	Screen shot			Brake load test		Tool length compensation
	Operation level			Automatic / Computer remote		Cutter compensation
	External input signal key			Network		Scaling
	<Optional>			Auto notification		Mirror image
Programming	Spindle override		Built-in PLC (LD/ST/FBD)	External sub program call	Macro	
	Absolute / Incremental		<Optional>	Operation in tape mode	Multiple skip function	
	Inch / Metric		CC-Link, master station	<Optional>	Submicron command *2	
	Coordinate system setting		CC-Link, remote device station	Interrupt type macro	Rotary fixture offset	
	Corner C / Corner R		PROFIBUS DP, slave	Fixture coordinates setting *3	Involute interpolation	
	Rotational transformation		DeviceNet, slave	Operation program	Schedule program	
	Synchronized tap		PROFINET, slave	Automatic tool selection	Automatic cutting condition setting	
	Subprogram		EtherNet/IP, slave	Automatic tool length compensation setting	Automatic cutter compensation setting	
	Graphic display		Energy saving	Automatic calculation of unknown number input	Machining order control	
	Automatic power off		Automatic workpiece measurement *1	Standby mode	Standby mode	
Measurement	Tool length measurement		Automatic coolant off	Automatic work light off	Chip shower off delay	
	High speed and high accuracy		Machining parameter adjustment	Adjust machine parameters	ATC tool	
	High-accuracy mode All		High-accuracy mode All	Tool life	Waveform display	
	High-accuracy mode BI (look-ahead 160 blocks)		Backlash compensation	Production performance	Power consumption	
	<Optional>		<Optional>	Recovery support	Inspection	
	High accuracy mode BII (Look-ahead 1,000 blocks, smooth path offset)		High accuracy mode BII (Look-ahead 1,000 blocks, smooth path offset)	PLC	File viewer	
	Monitoring	Machining load monitoring		Monitoring	Notebook	Calculator
		ATC monitoring		Overload prediction	Register shortcut	Display off
		Waveform display / Waveform output to memory card		Waveform display / Waveform output to memory card		
		Heat expansion compensation system II (X, Y, and Z axes)		Production performance display		
Production performance display			Tool life / Spare tool			

*1. Measuring instrument needs to be prepared by users.
*2. When the submicron command is used, changing to the conversation program is disabled.
*3. There are some restrictions on axes configurations.

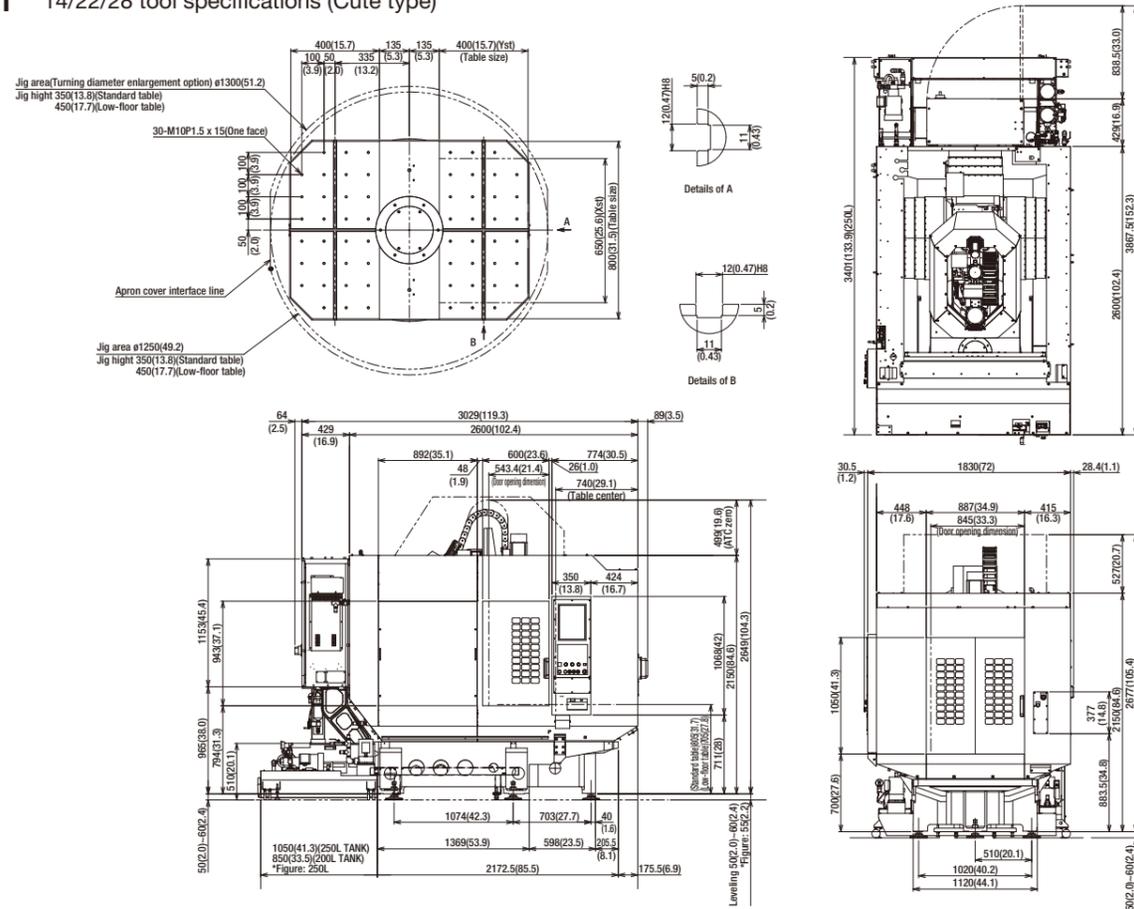
NC unit specifications

CNC model	CNC-D00
Control axes	7 axes (X, Y, Z, four additional axes)
Simultaneously controlled axes	Positioning 5 axes (X, Y, Z, A, B) Interpolation Linear: 4 axes (X, Y, Z, one additional axis) Circular: 2 axes Helical/Conical: 3 axes (X, Y, Z)
Least input increment	0.001 mm, 0.0001 inch, 0.001 deg.
Max. programmable dimension	±999999.999 mm, ±99999.999 inch
Display	15-inch color LCD touch display
Memory capacity	500 Mbytes, 3 Gbytes (optional) (Total capacity of program and data bank)
External communication	USB memory interface, Ethernet, RS232C (optional)
No. of registrable programs	4,000 (Total capacity of program and data bank)
Program format	NC language, conversation (changed by parameter) Conversation from conversation program to NC language program available

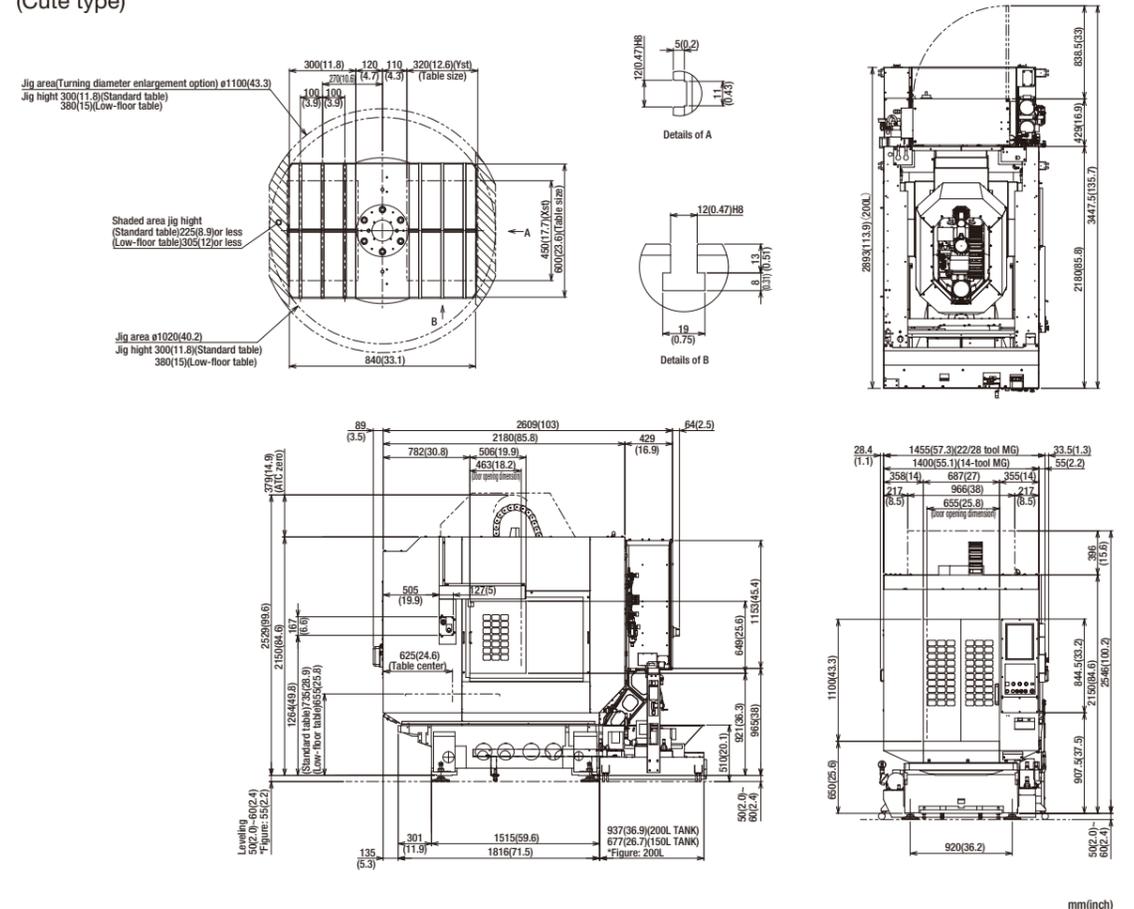
* Number of "control axes" and/or "simultaneously controlled axes" are the maximum number of axes, which will differ depending on the destination country and the machine specifications.
* Ethernet is a trademark or registered trademark of XEROX in the United States.

- Please read the instruction manuals and safety manuals before using Brother products for your own safety. When using oil-based coolant oil or when machining the materials which can cause a fire (ex. Magnesium, resin material), customers are requested to take thoroughgoing safety measures against fire. Depending on the types of cutting material, cutting tools, coolant oil, lubrication oil, it may have an influence on the machine lifecycle. Further questions, please contact our sales representative in charge.
- Leave 700 mm between machines as a maintenance space.
- When exporting our machine together with additional 1-axis rotary table or compound rotary table (including case that a rotary table is scheduled to be installed overseas), the machine is deemed to be included in the "applicable listed items" controlled by the Foreign Exchange and Foreign Trade Law of Japan. When exporting the machine, please obtain required permissions, including an export license, from the Ministry of Economy, Trade and Industry (METI) or Regional Bureaus of Economy, Trade and Industry before shipment. When re-selling or re-exporting the machine, you may need to obtain permissions from METI, and the government of the country where the machine is installed.
- When exporting our machine together with compound rotary table (including case that a rotary table is scheduled to be installed overseas), as a machine conforming to Row 2 of Appended Table 1 of Export Trade Control Order, a relocation detection device is installed on the machine depending on the destination country. After relocating the machine with the detection device, the machine is locked and any operation is temporarily impossible. Please inform your local distributor of machine relocation in advance and apply to perform the release operation of relocated machine.
- In order to operate our machine with an additional axis rotary table installed separately overseas after exporting the machine, the procedure to activate the axis of rotary table is needed. Please inform your local distributor of these processes in advance, because the predetermined procedure is required to perform the activation. In addition, for export to some countries and regions other than "Group A countries", it is not possible to install a compound rotary table separately overseas after exporting the machine. Please make sure to obtain the export license of the machine together with compound rotary table before shipment.

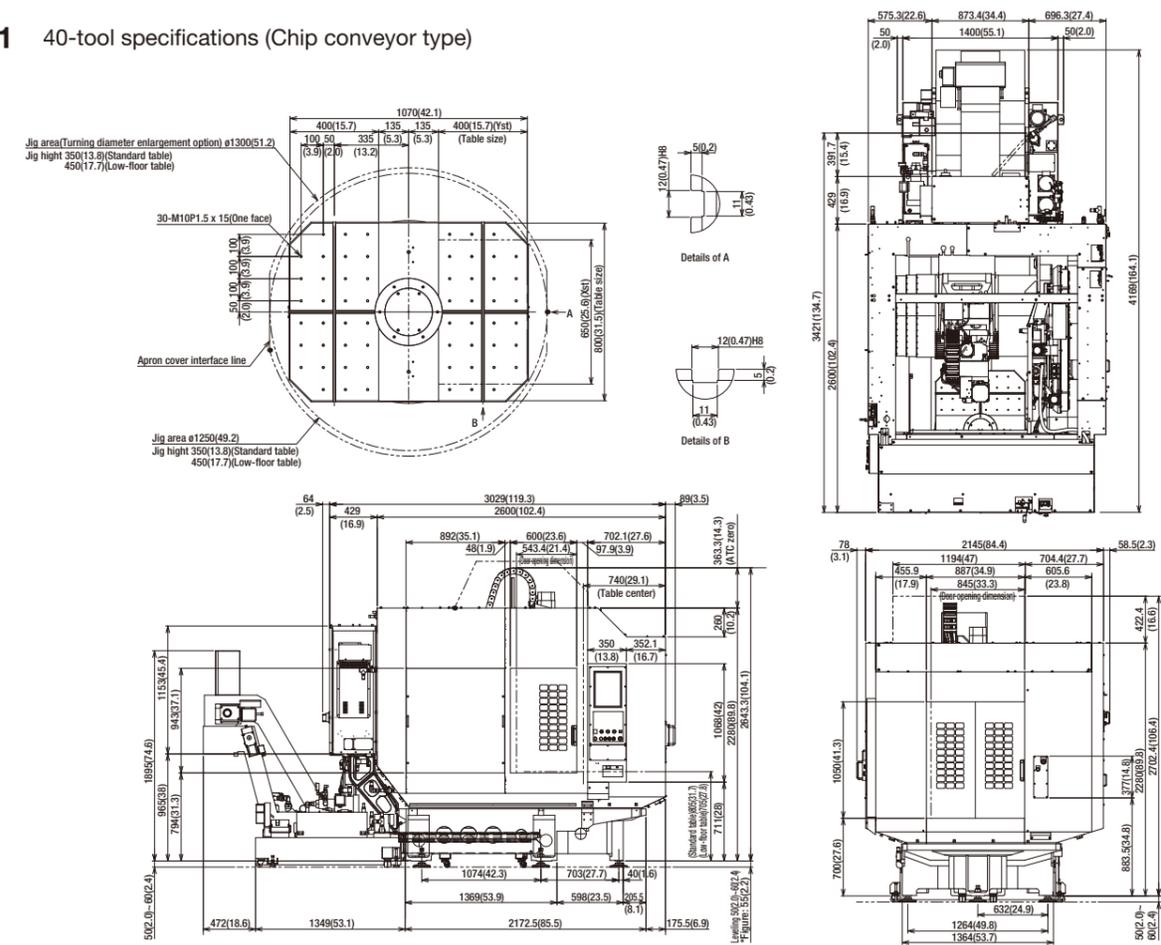
R650Xd1 14/22/28 tool specifications (Cute type)



R450Xd1 (Cute type)

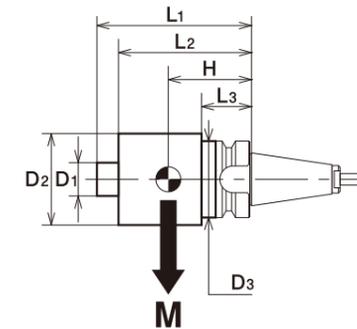


R650Xd1 40-tool specifications (Chip conveyor type)



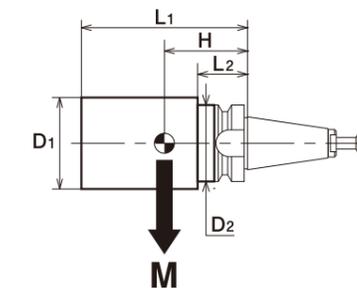
Tool Dimensions

14/22/28 tool specifications



Max Spindle Rotation Speed	10000min ⁻¹ / 16000min ⁻¹	
Spindle Taper	7 / 24 No.30	
Tool Shank	MAS-BT	
Retension Knob	MAS-P30T-2(30°)	
Total in Magazine	M total 25kg (14Tools) / 40kg (22/28 Tools)	
Limitation of Tool	D1 ≤ 40mm L1 ≤ 200mm D2 ≤ 80mm L2 ≤ 160mm D3 ≤ 46mm L3 ≤ 30mm M ≤ 3kg MxH ≤ 180kg-mm	D1 ≤ 40mm L1 ≤ 200mm D2 ≤ 55mm L2 ≤ 160mm D3 ≤ 46mm L3 ≤ 30mm M ≤ 2kg MxH ≤ 100kg-mm
	Limitation of Tool Balance	100g-mm
Limitation Spindle Rotation Speed	10000min ⁻¹	16000min ⁻¹

40-tool specifications



Max Spindle Rotation Speed	10000min ⁻¹ / 16000min ⁻¹	
Spindle Taper	7 / 24 No.30	
Tool Shank	MAS-BT	
Retension Knob	MAS-P30T-2(30°)	
Total in Magazine	M total 80kg (40Tools)	
Limitation of Tool	D1 ≤ 125mm L1 ≤ 250mm D2 ≤ 46mm L2 ≤ 30mm M ≤ 4kg MxH ≤ 180kg-mm	D1 ≤ 55mm L1 ≤ 250mm D2 ≤ 46mm L2 ≤ 30mm M ≤ 2kg MxH ≤ 100kg-mm
	Limitation of Tool Balance	100g-mm
Limitation Spindle Rotation Speed	10000min ⁻¹	16000min ⁻¹

mm(inch)
Secure 700 mm(27.6 inch) between machines as maintenance space.

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Figures in brackets () are the country codes.

Specifications may be subject to change without any notice.

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