



# VARIAXIS J

S E R I E S

500

500/5X

600

600/5X

# Advanced features of the MAZATROL Smooth CNC

Touch screen operation  
—Operate similar to your smart phone / tablet

PC with Windows® 8 embedded OS

Fastest CNC in the world—Latest hardware and software for  
unprecedented speed and precision

Easy conversational programming of multiple surface machining

Smooth user graphical interface and support functions  
for unsurpassed ease of operation

MTConnect® - Convenient networking

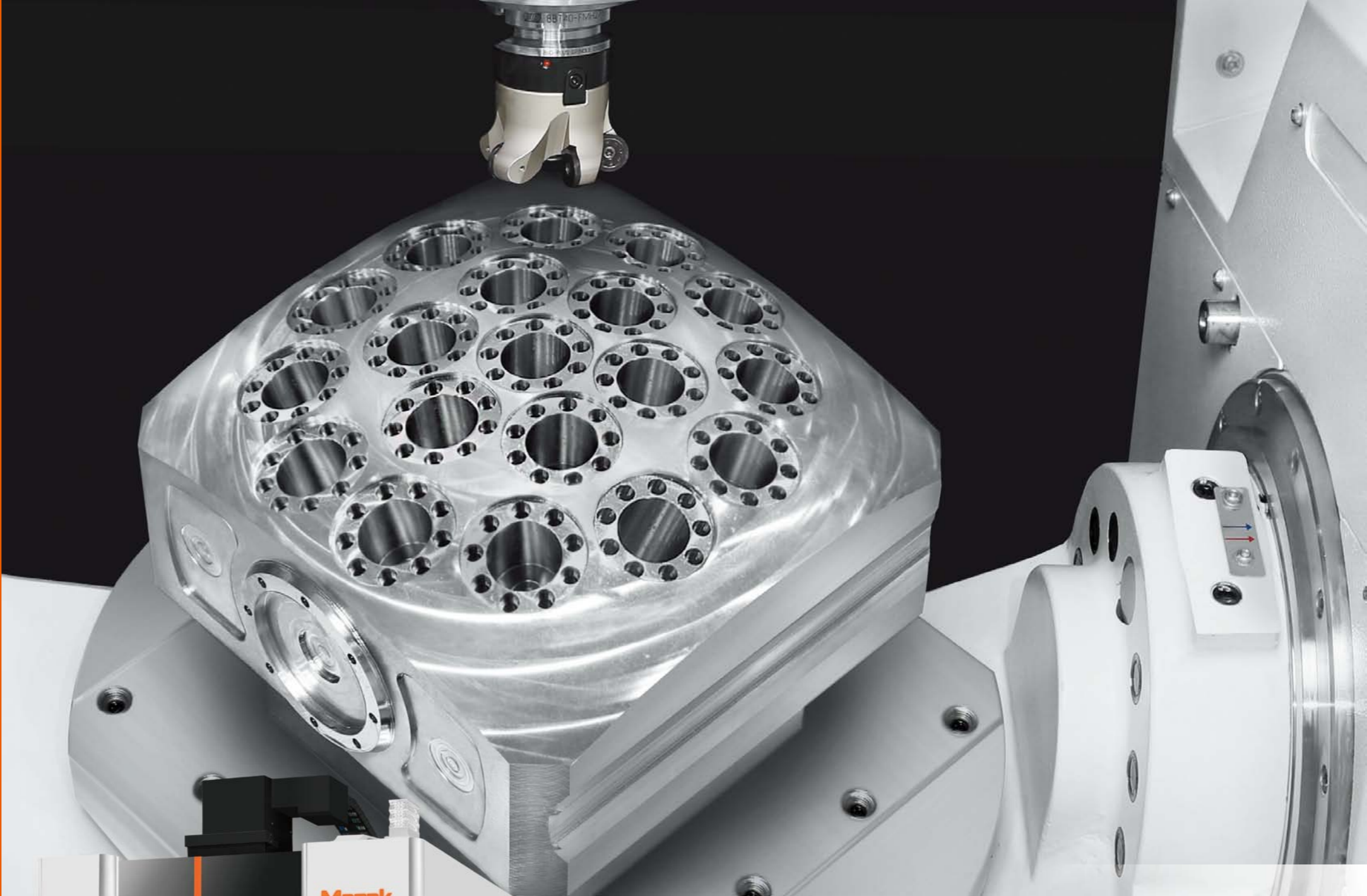
Easily configure machine parameters for different workpiece  
materials and applications requirements

Windows is a registered trademark of Microsoft Corporation  
in the United States and other countries.  
MTConnect is a registered trademark of AMT in the United States  
and other countries.



MAZATROL  
**SMOOTHX**  
MAZATROL  
**SMOOTHG**

Standard CNC varies by market.



High-accuracy multiple-surface machining center

## VARIAXIS J SERIES

- Rigid trunnion table design supports table on both sides for heavy-duty machining
- 0.0001° indexing increment for a variety of multiple-surface machining (simultaneous 4-axis + A-axis (B-axis) indexing) (VARIAXIS j-500, 600)
- Machining of complex contours thanks to simultaneous 5-axis control [500/5X, 600/5X]
- Linear roller guides on linear axes and roller gear cams on the rotary table axes ensure stable machining accuracy over long periods of operation
- Ease of operation thanks to excellent access to table and magazine in front of machine

VARIAXIS j-600/5X  
Shown with optional status light and 30-tool magazine

# Machine Design

Designed to provide you the maximum value



VARIAXIS j-500 shown

## Linear roller guides utilized on the X-, Y-, and Z-axes

The linear roller guides on the X-, Y- and Z-axes utilized by the VARIAXIS j series provide high-accuracy positioning. Additionally, with their high rigidity and considerably lower friction, high speed feedrates can be used over a wide range of machining, from heavy-duty to high-speed cutting.

## High rigidity table

High rigidity tilting rotary table for high-speed and high-accuracy machining

## Rotary axes equipped with roller gear cams

Elimination of backlash ensures high accuracy and high efficiency machining.

# Extensive Series Range

Two table sizes and multi-surface machining / 5-axes simultaneous machining

## VARIAXIS j-500 series

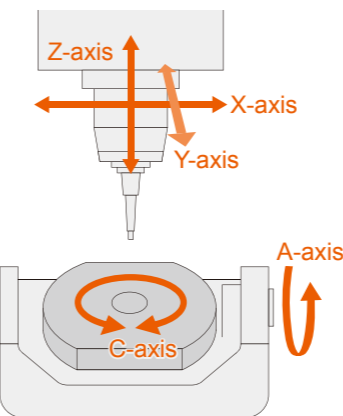


Table size :  $\Phi 500 \text{ mm} \times 400 \text{ mm}$  ( $\Phi 19.69" \times 15.75"$ )  
Max. workpiece :  $\Phi 500 \text{ mm} \times 350 \text{ mm}$  ( $\Phi 19.69" \times 13.78"$ )

Spindle : 12000 rpm  
Output : 11 kW (15 HP) (40% ED / 30 min. rating) Torque : 65 N·m (48 ft·lbs) (40% ED / 30 min. rating)  
: 18000 rpm **OPTION**  
Output : 15 kW (20 HP) (40% ED / 30 min. rating) Torque : 59.7 N·m (44 ft·lbs) (40% ED / 30 min. rating)



Multi-surface machining

VARIAXIS j-500  
(CNC: MAZATROL SmoothG)



Simultaneous 5-axis machining

VARIAXIS j-500/5X  
(CNC: MAZATROL SmoothX)



## VARIAXIS j-600 series

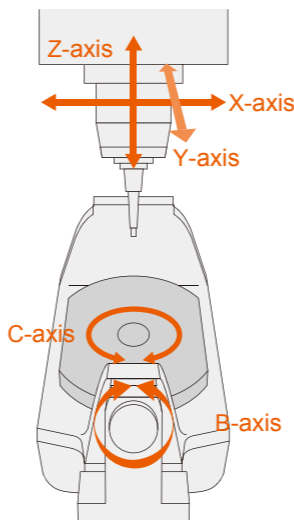


Table size :  $\Phi 600 \text{ mm} \times 500 \text{ mm}$  ( $\Phi 23.62" \times 19.69"$ )  
Max. workpiece :  $\Phi 730 \text{ mm} \times 450 \text{ mm}$  ( $\Phi 28.74" \times 17.72"$ )

Spindle : 12000 rpm  
Output : 11 kW (15 HP) (40% ED / 30 min. rating) Torque : 65 N·m (48 ft·lbs) (40% ED / 30 min. rating)  
: 18000 rpm **OPTION**  
Output : 15 kW (20 HP) (40% ED / 30 min. rating) Torque : 59.7 N·m (44 ft·lbs) (40% ED / 30 min. rating)



Multi-surface machining

VARIAXIS j-600  
(CNC: MAZATROL SmoothG)



Simultaneous 5-axis machining

VARIAXIS j-600/5X  
(CNC: MAZATROL SmoothX)

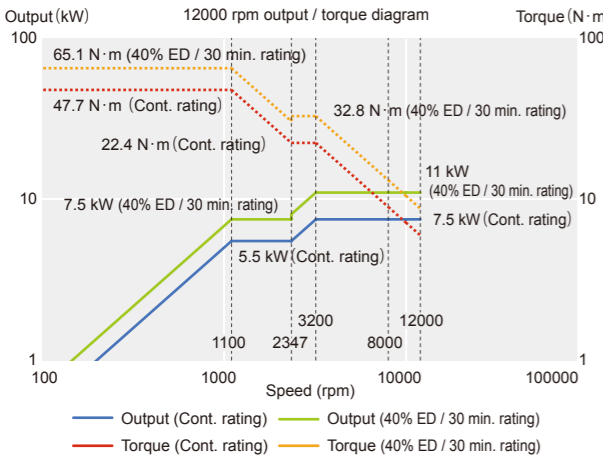


# Higher Productivity

## Spindle

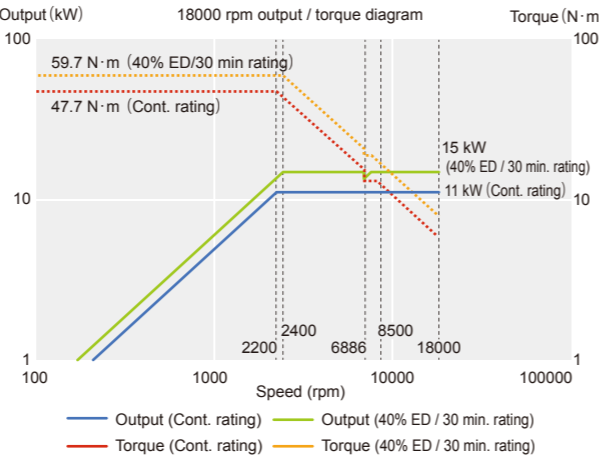
12000 rpm 11 kW,  
#40 taper spindle

Max. spindle speed	12000 rpm
Spindle output	11 kW (15HP) (40% ED / 30 min. rating)
Max. torque	65 N·m (48 ft·lbs) (40% ED / 30 min. rating)



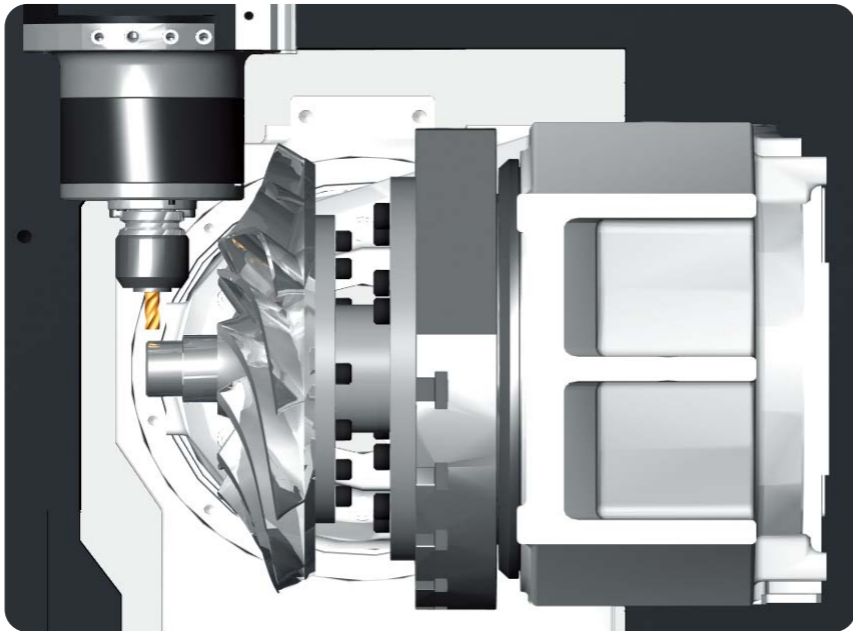
18000 rpm 15kW,  
high-speed spindle OPTION

Max. spindle speed	18000 rpm
Spindle output	15 kW (20 HP) (40% ED / 30 min. rating)
Max. torque	59.7 N·m(44 ft·lbs)(40% ED / 30 min. rating)



Compact spindle cartridge  
minimizes workpiece  
interference

Large machining area and compact spindle  
cartridge allows short tools to be used for  
high-accuracy machining.



## Table

High rigidity table

The A-axis features a trunnion design to provide high rigidity for high accuracy machining.

Tilting rotary table for 5-axis machining

Tilting rotary table can be indexed in 0.0001° for simultaneous 5 axis machining of complex workpieces (Simultaneous 4 axis (X,Y,Z,C) + A-axis [ B-axis ] indexing for VARIAXIS j-500,600)

Change tool without returning table  
to home position

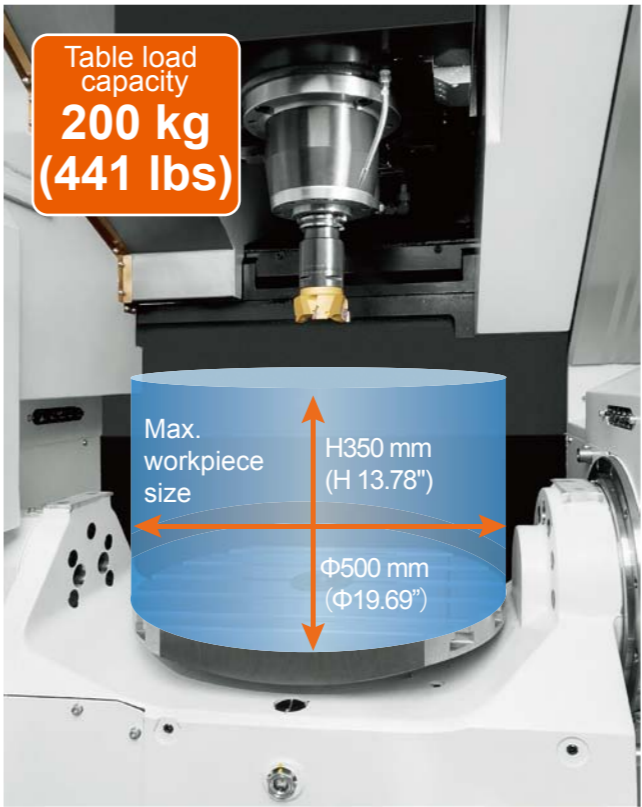
Since it is not necessary to return the VARIAXIS j series table to the home position to change tools, the machining cycle time is reduced.



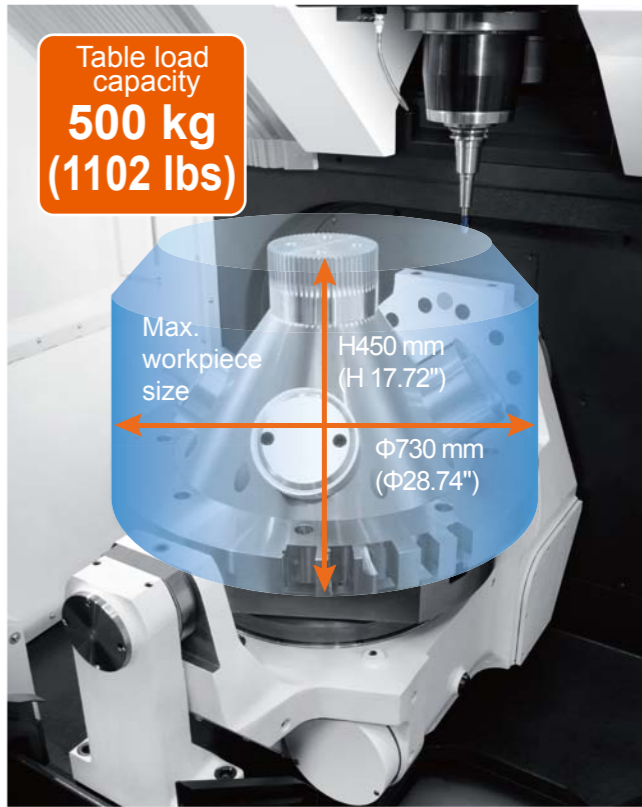
T-slot pallet (option) shown.

## Large, heavy maximum workpiece capacity

VARIAXIS j-500, j-500/5X



VARIAXIS j-600, j-600/5X



# Ergonomics

## Designed for convenient accessibility

### Tool magazine

The tool magazine door is located at the front of the machine for convenient tool loading and unloading.

### Excellent accessibility

The operator has excellent access to the table from the front of the machine for convenient workpiece loading/unloading and machine setup.



VARIAXIS j-600 shown



VARIAXIS j-500 shown

### Maintenance area

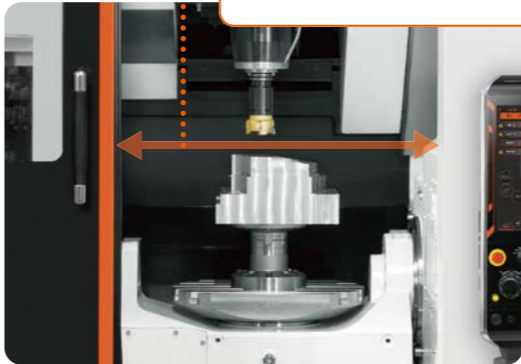
Items requiring frequent access for machine maintenance are arranged in one central location.



### Convenient operation when using an overhead crane

The large top opening is designed for convenient workpiece loading/unloading.

Opening section  
750 mm (29.53") (j-500, j-500/5X)  
1050 mm (41.34") (j-600, j-600/5X)



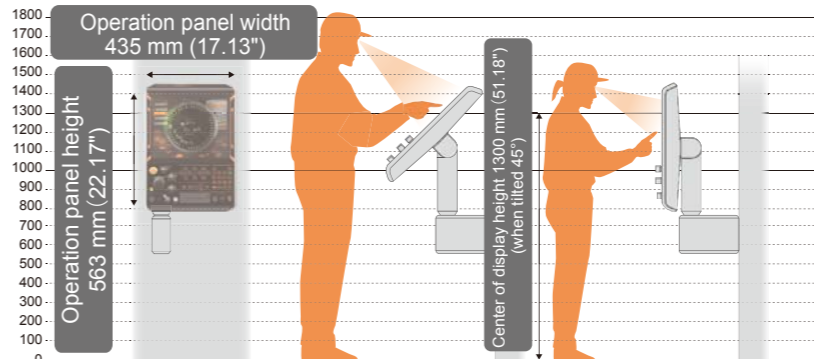
### Large window

The large front door window allows workpiece machining to be easily monitored by the operator.



### Touch panel adjustable to be comfortable for all operators

The tilting operation panel allows optimum positioning of the touch panel for any height operator to ensure ease of operation.



# Automation

## 2 pallet changer OPTION

The next workpiece can be setup during the machining of the current workpiece for higher productivity.



VARIAXIS j-500/5X 2 pallet changer

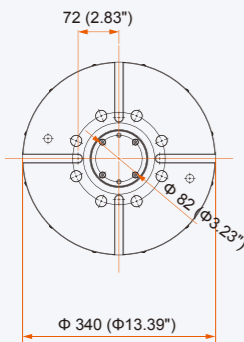


VARIAXIS j-600/5X 2 pallet changer

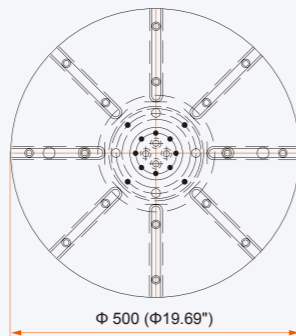


## Preparation for hydraulic fixtures OPTION

Hydraulic power is supplied through the pallet for hydraulic fixtures.



VARIAXIS j-500  
VARIAXIS j-500/5X  
Table dimensions



VARIAXIS j-600  
VARIAXIS j-600/5X  
Table dimensions

unit : mm (inch)

# DONE IN ONE



## Large reduction of total production time

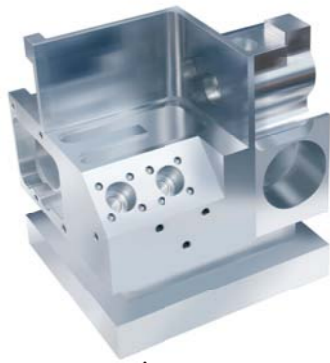
The "DONE-IN-ONE" concept incorporates all machining processes from raw material input through final machining -in just one machine. It provides the ability to reduce production lead time, improve machining accuracy, reduce floor space and initial cost, lower operating expenses, reduce operator requirements and to improve the work environment. As a result, the concept not only streamline production, it also improves overall management.



Automotive component



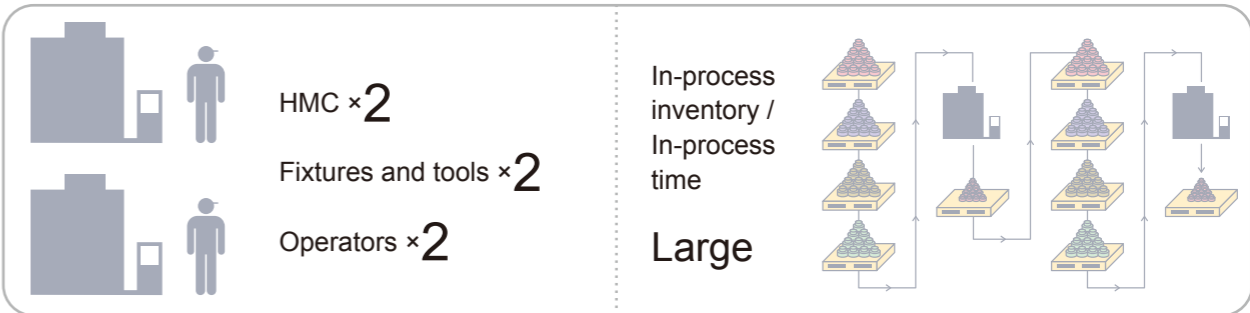
General machinery component



Aerospace component

DONE IN ONE example ■ Reduction of production lead time ■ Improved machining accuracy  
■ Lower investment ■ Lower labor expense ■ Minimized manual finishing

Previous production method



VARIAXIS j-500





Yamazaki Mazak has developed a variety of functions for the improvement of productivity, high accuracy machining and operator support. A variety of unique technologies has been developed that incorporate the expertise of experienced machine operators that realizes unsurpassed productivity and higher accuracy machining.



## Advanced Intelligent<sup>+</sup> Functions

A variety of Intelligent<sup>+</sup> Functions provides incomparable operator support for exceptional ease of operation and the optimum machine efficiency.

### Machining



Convenient Parameter Setting and Fine Tuning Function  
**SMOOTH MACHINING CONFIGURATION**

Machining time, finished surface smoothness and machining shape can be adjusted for improved productivity



Variable Acceleration Control Function  
**VARIABLE ACCELERATION CONTROL**

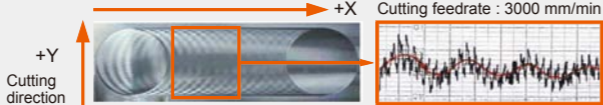
Variable acceleration control is a new function which permits the faster acceleration capability of linear axes to be used whenever possible. The slower acceleration of the rotary axes is not used for all program commands, resulting in faster machining cycle times.



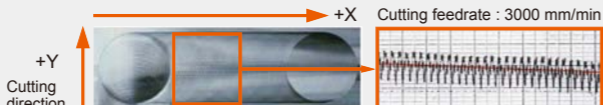
Minimized Vibration  
**ACTIVE VIBRATION CONTROL**

Machine vibration can be reduced to perform excellent machining accuracy and high-speed machining.

Without ACTIVE VIBRATION CONTROL



With ACTIVE VIBRATION CONTROL



Seamless Corner Control  
**SMOOTH CORNER CONTROL**

Improved finished surfaces and reduced cycle times by optimized acceleration/deceleration when machining corners.

Other systems

Move to next command position after reaching current command position



**SMOOTH CORNER CONTROL**

Move to next command position within tolerance band



Heat Displacement Control  
**INTELLIGENT THERMAL SHIELD**

The INTELLIGENT THERMAL SHIELD is an automatic compensation for room temperature changes, which realizes enhanced continuous machining accuracy. MAZAK has performed extensive testing in a variety of environments in a temperature controlled room and has used the results to develop a control system that automatically compensates for temperature changes in the machining area. Changes in the room temperature and compensation data are shown visually.



Temperature and compensation is displayed on screen. Operator can adjust compensation by looking at the data

### Set up



Verbal Message System  
**MAZAK VOICE ADVISER**

Verbal support for machine setup and safe conditions confirmation



Machine Interference Prevention  
**INTELLIGENT SAFETY SHIELD**

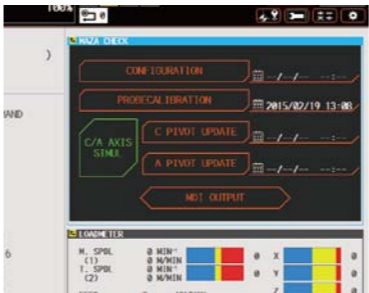
When an operator manually moves the machine axes for setup, tool measurement or changing inserts, the CNC shows a synchronized 3D model on the display for checking machine interference. If any machine interference occurs, the machine motion automatically stops. This function is also effective during automatic operation.

### Maintenance



High-Accuracy 5-Axis Calibration  
**INTELLIGENTMAZA-CHECK**

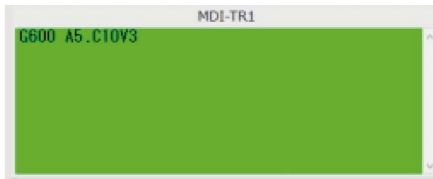
Position misalignment and incline of the rotary axes can automatically be measured and compensated to realize high-accuracy 5-axis machining. The centers of rotation of both the C and B (A) axes can be automatically measured and compensated.



▲ Measurement item selection



▲ Measurement information setting



▲ Automatic measurement program generation  
Convenient screen display assists measurement operation.



Comprehensive Spindle Monitoring  
**INTELLIGENT PERFORMANCE SPINDLE**

The INTELLIGENT PERFORMANCE SPINDLE monitors a variety of properties such as temperature with sensors housed in the spindle and provides useful information to the operator. Thanks to this monitoring, production loss due to machine down time can be minimized.



▲ Condition check  
Temperature as well as the motor load can be displayed.



▲ Running recorder  
Operation status of milling spindle (rpm / motor load) can be recorded for up to one year.



Comprehensive Maintenance Monitor  
**INTELLIGENT MAINTENANCE SUPPORT**

Useful information for improved preventative maintenance to prevent unexpected machine downtime.



# MAZATROL CNC SYSTEM

The seventh generation MAZATROL CNC system  
— the core of Smooth Technology

## MAZATROL *SMOOTHX* MAZATROL *SMOOTHG*

From setup to machining  
— designed for unsurpassed ease of operation

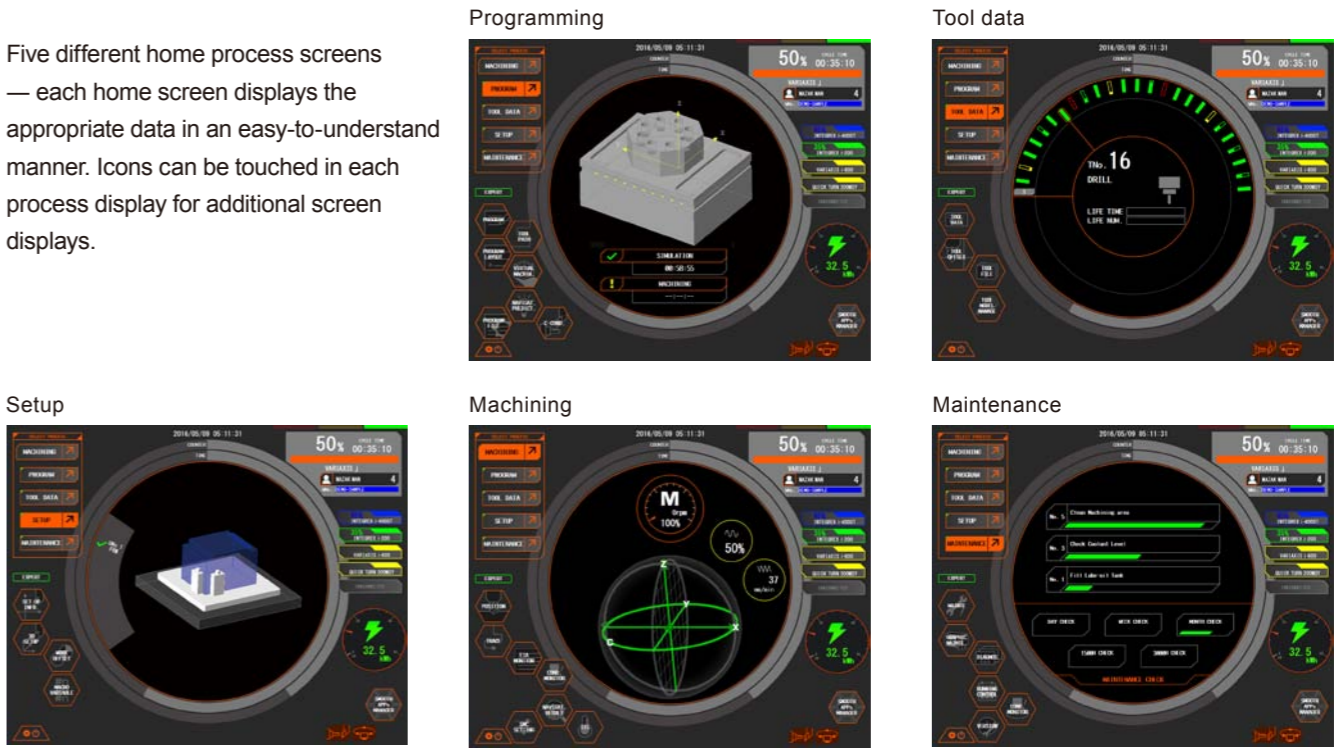


- Three color status indicator (SmoothX only)  
Machining status is indicated by three colors.  
Green: automatic operation mode  
Yellow: Machining completion  
Red: Alarm
- 19" touch panel  
Touch panel operation  
— similar to your smartphone or tablet
- USB port  
Interface for peripheral equipment of  
USB-1.0+2.0 standard
- SD card slot  
Transfer program and tool data
- Operation switches  
Large switches  
— color changes from orange to green  
when turned on
- Dials  
For frequently-used axes selection and  
feedrate changes.

New interface with touch operation ensures convenient data processing  
— programming, confirmation, editing, and tool data registration

### Process home screens

Five different home process screens  
— each home screen displays the  
appropriate data in an easy-to-understand  
manner. Icons can be touched in each  
process display for additional screen  
displays.



### Pop-up windows

Values and items can easily be input/selected on pop-up windows.



# Ease of Programming

## Easy programming

### Multiple-surface machining

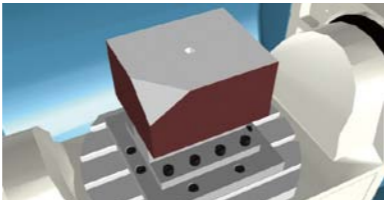
Easy programming of multiple-surface machining which normally requires complex machining programs.

UNo.	UNIT	ADD. WPC	X	Y	th	Z	C	A
1	MPC	1	-315.	-315.	0.	-400.	0.	0.
UNo.	UNIT	TURN POS X	TURN POS Y	TURN POS Z	ANGLE C	ANGLE A		
2	INDEX			0.	0.	0.		

Setting Coordinate

Setting Index Angle

The same home position and coordinate system can be used for the top surface and angled surfaces without requiring any complicated programming for the angled surfaces.



### Program origin automatic calculation workpiece coordinate shift

Program origin automatic calculation workpiece coordinate shift

UNo.	UNIT	TURN POS X	TURN POS Y	TURN POS Z	ANGLE C	ANGLE A		
4	INDEX				135.	-45.		
UNo.	UNIT	SHIFT-X	SHIFT-Y	SHIFT-Z	SHIFT-C	SHIFT-A	COORD. th	
5	MPCSHIFT	-150.	-100.	0.	135.	-45.	0.	

Setting Index Angle

Coordinate Shift

No complicated calculations required when changing program coordinate system.

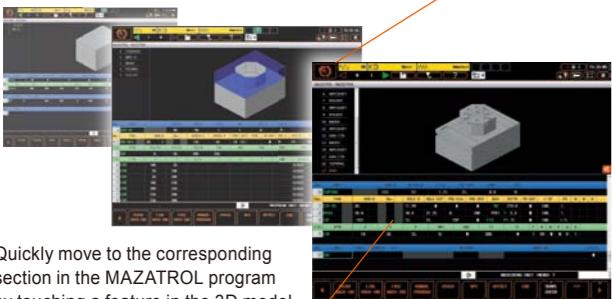


ANGLE C	ANGLE A
135.	-45.
TOOL	NOM-Ø
DRILL	6.

## QUICK MAZATROL

MAZATROL program, unit list and 3D workpiece shape are linked to each other. After defining a machining unit in a MAZATROL program, the 3D shape is immediately displayed to easily and quickly check for any programming error.

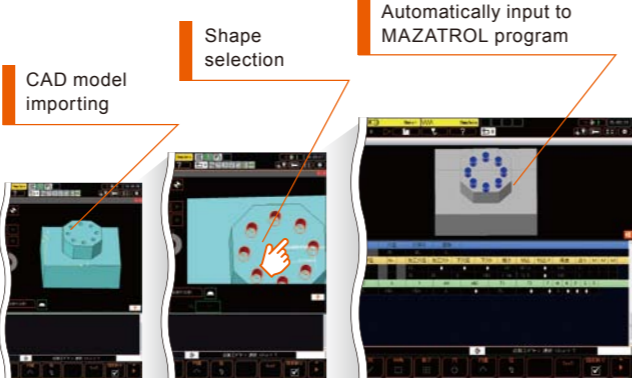
3D model in the process list is displayed with updated programming in real time.



Quickly move to the corresponding section in the MAZATROL program by touching a feature in the 3D model.

## 3D assist

Workpiece coordinates data can be imported from 3D CAD data to a MAZATROL program. No coordinate value inputs are required. Can reduce input errors and time for program checking.



CAD model importing

Shape selection

Automatically input to MAZATROL program

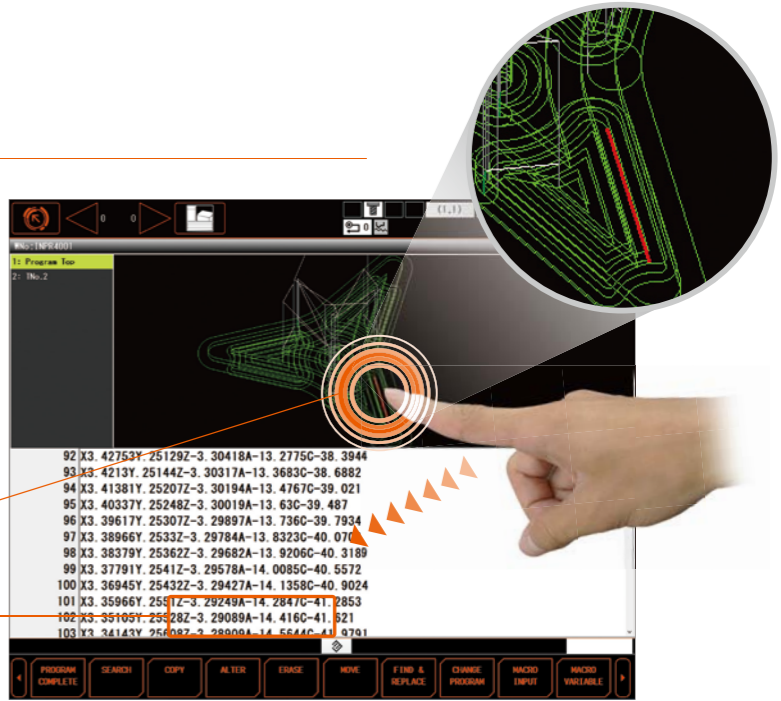
## Visible programming screen

## QUICK EIA

Program, process list and 3D tool path display are linked to each other. Visible search on touch screen can reduce the time for program checking.

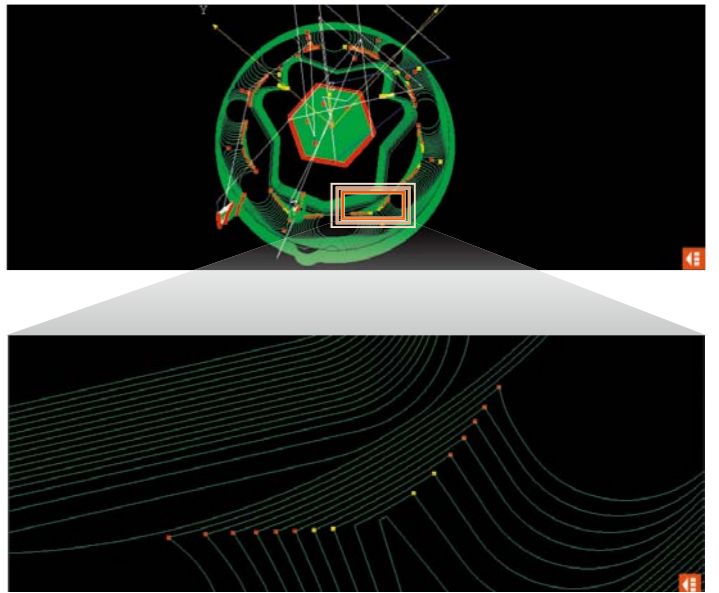
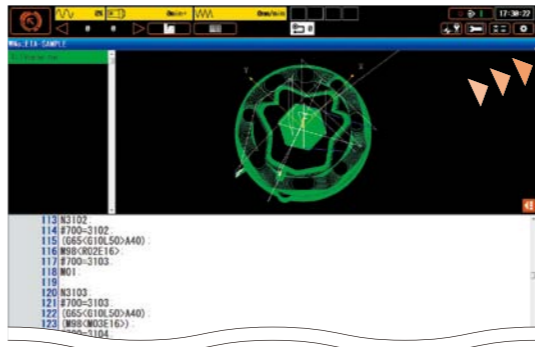
Selecting tool path by touching the screen.

Moving to the corresponding EIA program line.



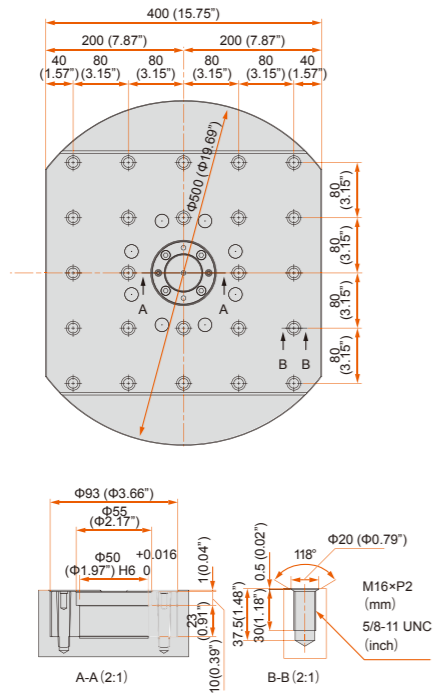
## VIEW SURF

By analyzing the tool path, any predictable failure on the finished surface can be visualized. Program modification can be done before machining to minimize the time for test cutting.

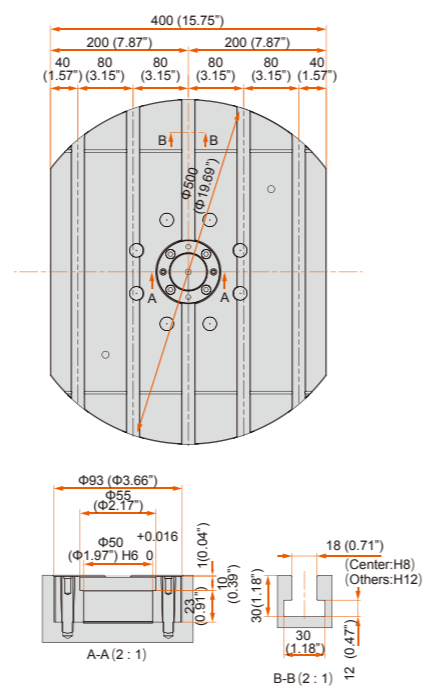


## VARIAXIS j-500, j-500/5X

Tapped pallet with location bore ( standard )

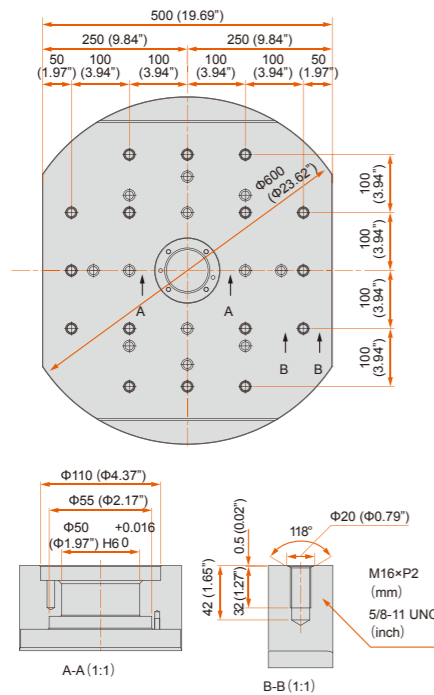


T-slot pallet with location bore ( option )

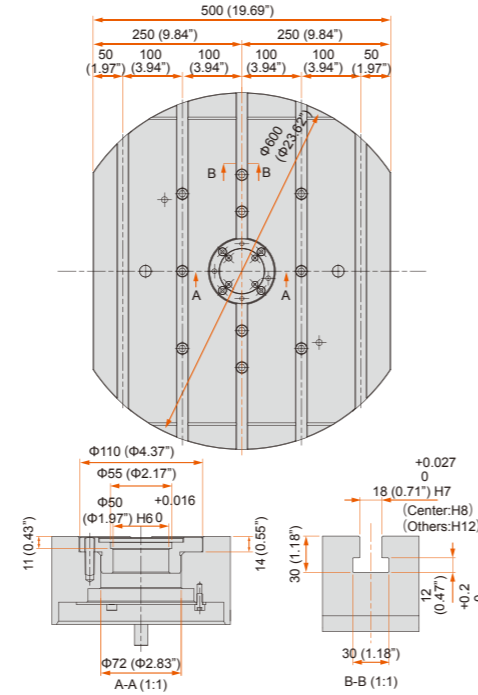


## VARIAXIS j-600, j-600/5X

Tapped pallet with location bore ( standard )

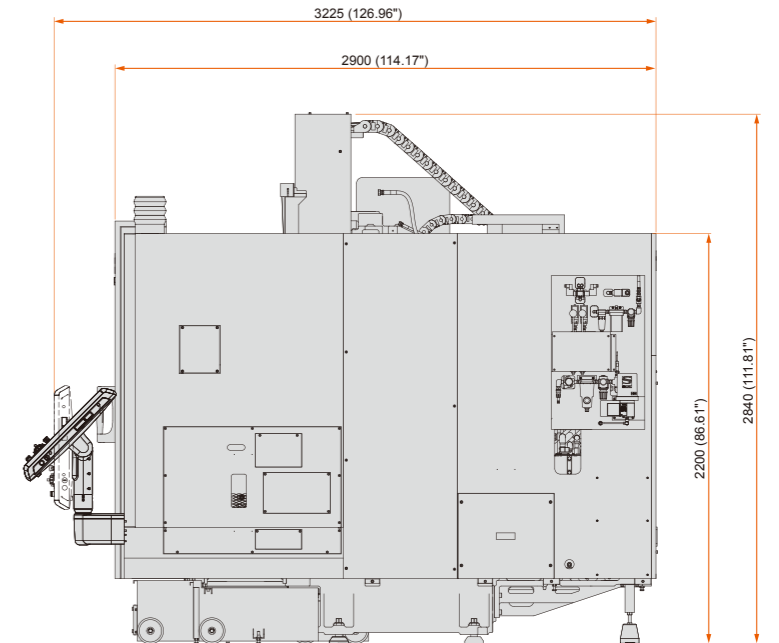
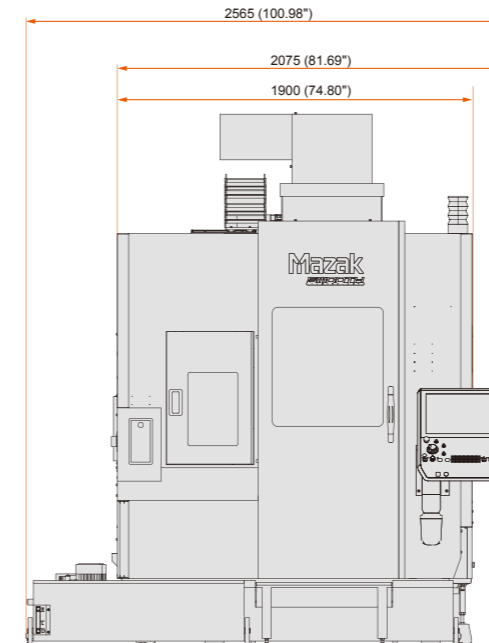


T-slot pallet with location bore ( option )

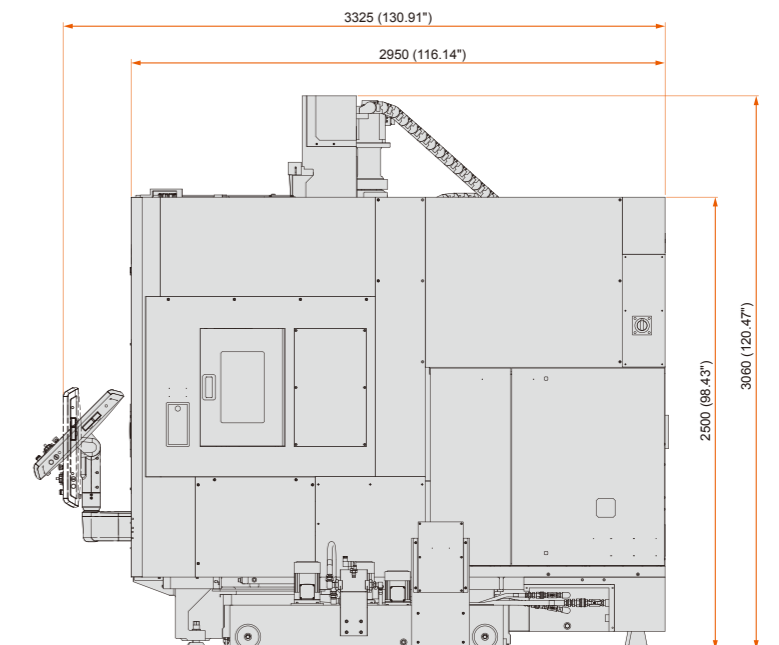
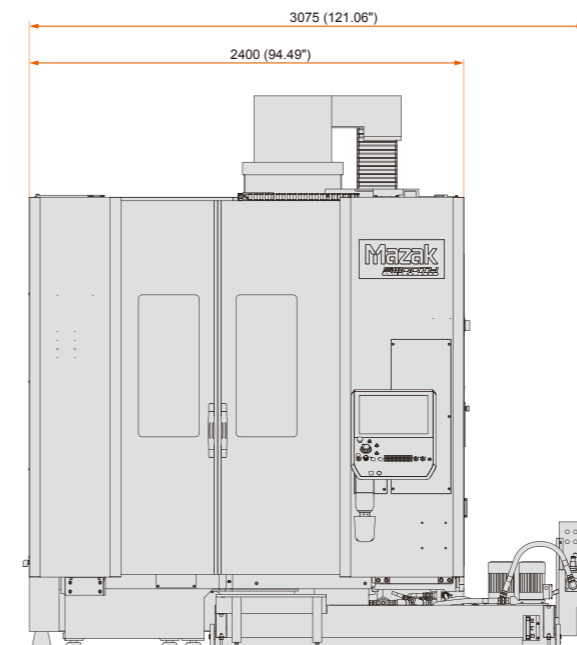


## Machine Dimensions

■ VARIAXIS j-500, j-500/5X



■ VARIAXIS j-600, j-600/5X



Standard Machine Specifications

		VARIAXIS j-500	VARIAXIS j-500/5X	VARIAXIS j-600	VARIAXIS j-600/5X
Stroke	X-axis travel (spindle head left / right)	350 mm (13.78")		850 mm (33.46")	
	Y-axis travel (spindle head back / forth)	550 mm (21.65")			
	Z-axis travel (spindle head up / down)	510 mm (20.08")			
	A-axis travel (table tilt)	-120 ~ +30°		-	
	B-axis travel (table tilt)	-		-120 ~ +90°	
	C-axis travel (table rotation)	360°			
	Table	Distance from table top to spindle nose	50 ~ 560 mm (1.97" ~ 22.05") (table horizontal)		70 ~ 580 mm (2.76" ~ 22.83") (table horizontal)
Table size		Φ500 mm × 400 mm (Φ19.69" × 15.75")		Φ600 mm × 500 mm (Φ23.62" × 19.69")	
Max. workpiece size		Φ500 mm × 350 mm (Φ19.69" × 13.78")		Φ730 mm × 450 mm (Φ28.74" × 17.72")	
Table load capacity (evenly distributed)		200 kg (441 lbs)		500 kg (1102 lbs)	
Table surface configuration		M16 × P2 (5/8-11 UNC) tap 24		M16 × P2 (5/8-11 UNC) tap 24	
Spindle	Max. spindle speed	12000 rpm			
	Spindle taper	No. 40			
	Spindle bearing ID	Φ70 mm (Φ2.76")			
Feedrate	Rapid traverse rate (X-,Y-,Z-axis/A-axis)	30m/min (1181 IPM) / 30 rpm		-	
	Rapid traverse rate (X-,Y-,Z-axis/B-axis)	-		30m/min (1181 IPM) / 30 rpm	
	Rapid traverse rate (X-,Y-,Z-axis/C-axis)	30m/min (1181 IPM) / 30 rpm			
	Cutting feedrate (X-,Y-,Z-axis / C-axes)	30m/min (1181 IPM) / 30 rpm			
	Simultaneously controlled axes	4(A-axis only indexing)	5-axis	4 (B-axis only indexing)	5-axis
	Min. indexing increment (A-axis)	0.0001°		-	
	Min. indexing increment (B-axis)	-		0.0001°	
	Min. indexing increment (C-axis)	0.0001°			
	Indexing time(A-axis)	0.6 sec / 90°		-	
	Indexing time(B-axis)	-		0.6 sec / 90°	
Automatic tool changer	Tool shank configuration	No.40			
	Tool storage capacity	18			
	Max. tool diameter /length (from gauge line) / weight	Φ90 mm / 300 mm / 8 kg (Φ3.54" / 11.81" / 17.6 lbs)			
	Max. tool diameter with adjacent toolpockets empty	Φ130 mm (Φ5.12")			
	Tool selection method	Random selection, shortest path			
	Tool change time (chip-to-chip)	6.2 sec			
Motors	Spindle motor (40 % ED / 30 min.rating /Cont. rating)	11 kW (15 HP) / 7.5 kW (10 HP)			
	Electrical power requirement (40 % ED / 30 min.rating /Cont. rating)	29.0 kVA / 24.0 kVA	29.5 kVA / 24.5 kVA	29.4 kVA / 24.5 kVA	35.4 kVA / 30.5 kVA
	Air supply	0.5 MPa ~ 0.9 MPa (73 PSI ~ 131 PSI) 200 NL/min (7.06 ft³/min)			
Machine size	Height	2840 mm (111.81"), 2905 mm (114.37") (Consep)		3060 mm (120.47")	
	Floor space	1900 mm × 3225 mm (74.80" × 126.97")		2400 mm × 3325 mm (94.49" × 130.91")	
	Machine weight	7000 kg (15432 lbs)		11000 kg (24250 lbs)	
CNC		MAZATROL SmoothG	MAZATROL SmoothX	MAZATROL SmoothG	MAZATROL SmoothX

\*1 Requires 80 mm (3.15") chamfer on top edge of workpiece.

Standard and Optional Equipment

		● : Standard ○ : Option - : N/A			
		j-500	j-500/5X	j-600	j-600/5X
Table	Φ500 mm × 400 mm (Φ19.69" × 15.75") tapped table	●	●	-	-
	Φ500 mm × 400 mm (Φ19.69" × 15.75") T-slot table	○	○	-	-
	Φ300 mm (Φ11.81") tapped table	○	○	-	-
	Φ600 mm × 500 mm (Φ23.62" × 19.69") tapped table	-	-	●	●
	Φ600 mm × 500 mm (Φ23.62" × 19.69") T-slot table	-	-	○	○
ATC	ATC 18 tool magazine	●	●	●	●
	ATC 30 tool magazine	○	○	○	○
Spindle	12000 rpm spindle (#40)	●	●	●	●
	18000 rpm spindle (#40)	○	○	○	○
Factory automation	Absolute position detection	●	●	●	●
	Mazak monitoring system B (RMP600)	○	○	○	○
	Preparation for Mazak monitoring system B (RMP600)	○	●	○	●
	Automatic power on / off and warm-up operation	●	●	●	●
	Status light (3 colors)	○	○	○	○
	Visual tool ID / preparation for data management	○	○	○	○
	Auto tool length measurement and tool breakage detection	●	●	●	●
	Remote manual pulse generator	○	○	○	○
	Front door auto open / close	○	○	-	-
	Preparation for hydraulic power supply for fixture clamping	○	○	○	○
High accuracy	2 pallet changer	○	○	○	○
	Ball screw core cooling (X, Y, Z-axes)	●	●	●	●
	Scale feedback (X, Y, Z-axes)	○	○	○	○
	Scale feedback (A, C-axes)	○	○	-	-
	Scale feedback (B, C-axes)	-	-	○	○
Coolant	Coolant temperature control	○	○	○	○
	Hand held coolant nozzle	○	○	○ *1	○*1
	Flood coolant 1.5 kgf/cm² (21 PSI), 30 L/min (7.93 gal/min)	●	●	●	●
	Coolant through spindle 5 kgf/cm² (70 PSI)	○	○	○	○
	Workpiece washing coolant	○	○	○	○
	High pressure coolant through spindle 15 kgf/cm² (21 PSI)	○	○	○	○
	SUPER FLOW coolant system	○	○	○	○
Chip disposal	Workpiece air blast	○	○	○	○
	Chip conveyor (Hinge type / ConSep)	○	○	○	○
	Chip bucket (swing type / fixed type)	○	○	○	○
Working environment	Top cover (Y-axis cover)	●	●	●	●
	Additional worklight	○	○	○	○
	Oil skimmer	○	○	○	○
	Mist collector	○	○	○	○
Others	INTELLIGENT MAZA-CHECK	○	●	○	●

\*1 Not available on 2 pallet changer

Above specifications are for North American market.  
Standard and optional equipment vary by market.

MAZATROL SmoothG Specifications (VARIAXIS j-500, j-600)

	MAZATROL	EIA
Number of controlled axes	Simultaneous 2 ~ 4 axes	
Least input increment	0.0001 mm , 0.00001", 0.0001°	
High speed, high precision control	Shape error designation, Smooth corner control, Rapid traverse overlap, Rotational-shape correction	Shape error designation, Smooth corner control, Rapid traverse overlap, Rotational-shape correction, High-speed machining mode, High-speed smoothing control function
Interpolation	Positioning (Linear interpolation), Positioning (Independent interpolation), Linear interpolation, Circular interpolation, Cylindrical coordinate interpolation, Polar coordinate interpolation, Synchronized milling spindle tapping *	Positioning (Linear interpolation), Positioning (Independent interpolation), Linear interpolation, Circular interpolation, Spiral interpolation, Helical interpolation, Cylindrical coordinate interpolation *, Fine spline interpolation *, NURBS interpolation *, Polar coordinate interpolation *, Synchronized milling spindle tapping *
Feedrate	Rapid traverse, Cutting feed, Cutting feed (per minute), Cutting feed (per revolution), Dwell (specified time, specified number of rotation), Cutting feed override, G0 speed variable control, Feedrate clamp, Variable acceleration / deceleration control, Constant control for G0 tilting *	Rapid traverse, Cutting feed, Cutting feed (per minute), Cutting feed (per revolution), Inverse time feed, Dwell (specified time, specified number of rotation), Rapid traverse override, Cutting feed override, G0 speed variable control, Feedrate clamp, Time constant changing for G1, Variable acceleration / deceleration control, Constant control for G0 tilting *
Program registration	Max. number of programs : 960, Program storage : 2 MB, Program storage expansion : 8 MB*, Program storage expansion : 32 MB*	
Control display	Display : 19" touch panel, Resolution : SXGA	
Spindle functions	S code output, Spindle speed clamp, Spindle speed override, Spindle speed reaching detection, Multiple position orient, Constant surface speed, Spindle speed command with decimal digits, Synchronized spindle control, Max. speed control for spindle	
Tool functions	Tool offset pairs : 4000, T code output for tool number, Tool life monitoring (time), Tool life monitoring (number of machined workpieces)	Tool offset pairs : 4000, T code output for tool number, T code output for group number, Tool life monitoring (time), Tool life monitoring (number of machined workpieces)
Miscellaneous functions	M code output, Simultaneous output of multiple M codes	
Tool offset functions	Tool position offset, Tool length offset, Tool diameter / tool nose R offset, Tool wear offset	
Coordinate system	Machine coordinate system, Work coordinate system, Local coordinate system, Additional work coordinates (300 set)	
Machine functions	—	Angled surface cutting, Hobbing *, Shaping function *, Dynamic compensation II*, Tool nose point control *, Tool diameter compensation for 5-axis machining *, Workpiece positioning error compensation *
Machine compensation	G0 / G1 independent backlash compensation, Pitch error compensation, Geometric deviation compensation, Volumetric compensation *	
Protection functions	Emergency stop, Interlock, Stroke check before travelling, Retraction function for the vertical axis, INTELLIGENT SAFETY SHIELD (manual mode), INTELLIGENT SAFETY SHIELD (automatic mode), MAZAK VOICE ADVISER	
Automatic operation mode	Memory operation	Memory operation 、Tape operation 、MDI operation 、Ethernet operation *
Automatic operation mode	Optional stop, Dry run, Automatic handle control, MDI control, TPS, Restart, Machine lock	Optional block skip, Optional stop, Dry run, Automatic handle control, MDI control, TPS, Restart, Restart2, Collation stop, Machine lock
Manual measuring functions	Tool length and tip teach, Touch sensor coordinates measurement, Workpiece offset measurement, WPC coordinate measurement, Measurement on machine	Tool length and tip teach, Tool offset teach, Touch sensor coordinates measurement, Workpiece offset measurement, WPC coordinate measurement, Measurement on machine
Automatic measuring functions	WPC coordinate measurement, Automatic tool length measurement, Touch sensor orientation confirmation, Tool breakage detection, External tool breakage detection *	Automatic tool length measurement, Touch sensor orientation confirmation, Tool breakage detection, External tool breakage detection *
MDI measurement	Partial auto tool length measurement, Auto tool length measurement, Coordinate measurement	
Interface	PROFIBUS-DP *, EtherNet I/P*, CC-Link*, USB	
Card interface	SD card interface	
EtherNet	10 M / 100 M / 1 Gbps	

MAZATROL SmoothX Specifications (VARIAXIS j-500/5X, j-600/5X)

	MAZATROL	EIA
Number of controlled axes	Simultaneous 2 ~ 4 axes	Simultaneous 2 ~ 4 axes, Simultaneous 5 axes
Least input increment	0.0001 mm , 0.00001", 0.0001°	
High speed, high precision control	Shape error designation, Smooth corner control, Rapid traverse overlap, Rotational-shape correction	Shape error designation, Smooth corner control, Rapid traverse overlap, Rotational-shape correction, High-speed machining mode, High-speed smoothing control function, 5-axis spline
Interpolation	Positioning (Linear interpolation), Positioning (Independent interpolation), Linear interpolation, Circular interpolation, Cylindrical coordinate interpolation, Polar coordinate interpolation, Synchronized milling spindle tapping *	Positioning (Linear interpolation), Positioning (Independent interpolation), Linear interpolation, Circular interpolation, Spiral interpolation, Helical interpolation, Cylindrical coordinate interpolation *, Fine spline interpolation *, NURBS interpolation *, Polar coordinate interpolation *, Synchronized milling spindle tapping *
Feedrate	Rapid traverse, Cutting feed, Cutting feed (per minute), Cutting feed (per revolution), Dwell (specified time, specified number of rotation), Cutting feed override, G0 speed variable control, Feedrate clamp, Variable acceleration / deceleration control, Constant control for G0 tilting *	Rapid traverse, Cutting feed, Cutting feed (per minute), Cutting feed (per revolution), Inverse time feed, Dwell (specified time, specified number of rotation), Rapid traverse override, Cutting feed override, G0 speed variable control, Feedrate clamp, Time constant changing for G1, Variable acceleration / deceleration control, Constant control for G0 tilting *
Program registration	Max. number of programs : 960, Program storage : 2 MB, Program storage expansion : 8 MB*, Program storage expansion : 32 MB*	
Control display	Display : 19" touch panel, Resolution : SXGA	
Spindle functions	S code output, Spindle speed clamp, Spindle speed override, Spindle speed reaching detection, Multiple position orient, Constant surface speed, Spindle speed command with decimal digits, Synchronized spindle control, Max. speed control for spindle	
Tool functions	Tool offset pairs : 4000, T code output for tool number, Tool life monitoring (time), Tool life monitoring (number of machined workpieces)	Tool offset pairs : 4000, T code output for tool number, T code output for group number, Tool life monitoring (time), Tool life monitoring (number of machined workpieces)
Miscellaneous functions	M code output, Simultaneous output of multiple M codes	
Tool offset functions	Tool position offset, Tool length offset, Tool diameter / tool nose R offset, Tool wear offset	
Coordinate system	Machine coordinate system, Work coordinate system, Local coordinate system, Additional work coordinates (300 set)	
Machine functions	—	Rotary axis pre-filter, Angled surface cutting, Hobbing *, Shaping function *, Dynamic compensation II*, Tool nose point control*, Tool diameter compensation for 5-axis machining *, Workpiece positioning error compensation *
Machine compensation	G0 / G1 independent backlash compensation, Pitch error compensation, Geometric deviation compensation, Volumetric compensation *	
Protection functions	Emergency stop, Interlock, Stroke check before travelling, Retraction function for the vertical axis, INTELLIGENT SAFETY SHIELD (manual mode), INTELLIGENT SAFETY SHIELD (automatic mode), MAZAK VOICE ADVISER	
Automatic operation mode	Memory operation	Memory operation、Tape operation、MDI operation、Ethernet operation *
Automatic operation mode	Optional stop, Dry run, Automatic handle control, MDI control, TPS, Restart, Machine lock	Optional block skip, Optional stop, Dry run, Automatic handle control, MDI control, TPS, Restart, Restart2, Collation stop, Machine lock
Manual measuring functions	Tool length and tip teach, Touch sensor coordinates measurement, Workpiece offset measurement, WPC coordinate measurement, Measurement on machine	Tool length and tip teach, Tool offset teach, Touch sensor coordinates measurement, Workpiece offset measurement, WPC coordinate measurement, Measurement on machine
Automatic measuring functions	WPC coordinate measurement, Automatic tool length measurement, Touch sensor orientation confirmation, Tool breakage detection, External tool breakage detection *	Automatic tool length measurement, Touch sensor orientation confirmation, Tool breakage detection, External tool breakage detection *
MDI measurement	Partial auto tool length measurement, Auto tool length measurement, Coordinate measurement	
Interface	PROFIBUS-DP *, EtherNet I/P*, CC-Link*, USB	
Card interface	SD card interface	
EtherNet	10 M / 100 M / 1 Gbps	
*Option		



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