

CITIZEN

Cincom

B12/16E

Sliding Headstock Type CNC Automatic Lathe



Cincoms B series - A worldwide best selling, low cost model now in 16mm capacity

The B series having been very popular worldwide is now revamped with 16mm capacity. Renowned for its speed, accuracy and high reliability at extremely low running cost it retains the same tool layout as before.

The rigidity of the back headstock has been improved and preprocessing of the control gives shortest cycle times.

Citizen's famous ease of use has been catered for with our program check function via the handwheel.

Preprocessing

Running the calculations in NC programs in advance shortens the processing time during operation, which helps to cut cycle times.

Tool layout compensating for thermal displacement

Virtual XY axis control is used to achieve a tool layout that is not too focused on the ball screw axis. This suppresses the effects of thermal displacement and makes it possible to maintain high accuracy during continuous machining.

On-machine program check function

This is for running a program in the forward or reverse direction using the manual pulse handle while checking the machine operations. NC programs can be checked intuitively and in an easy-to-understand manner.

Full NC functions

A wealth of functions generally treated as options, like canned cycle drilling, direct input of drawing dimensions, and user macros, are featured as standard NC functions.

A range of optional accessories

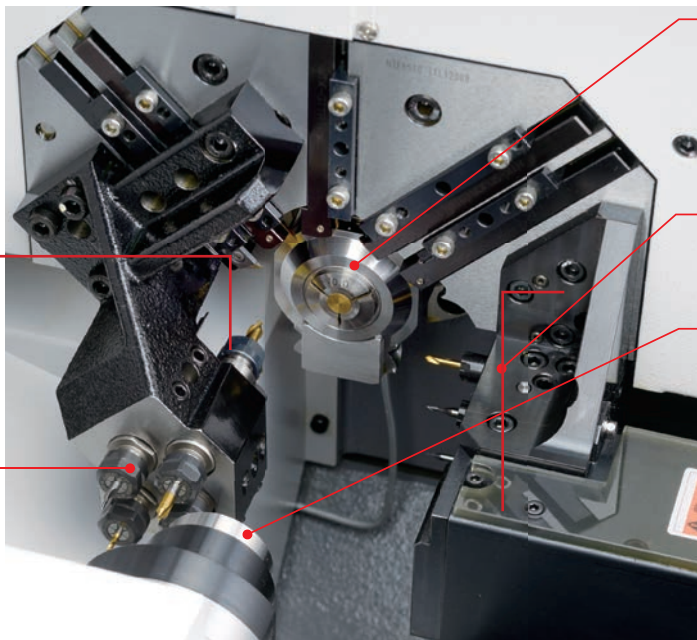
A wide range of optional accessories are available, means that you can change the specifications according to your needs.

Power tool upgrade

The power tool unit has been upgraded to 3 spindles with rigid tapping now standard.



B16E type VI tooling example



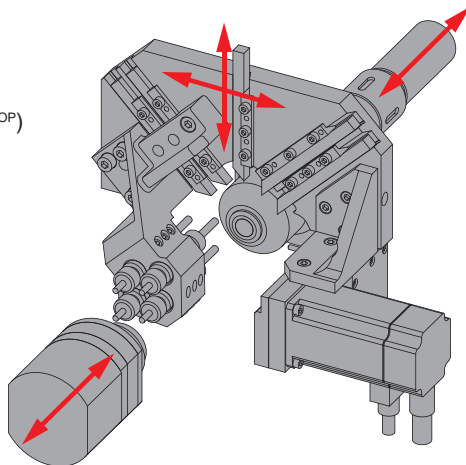
Drill Sleeve Holder
This holder can mount four drilling tools as standard. 19.05^{OP} and 20 gauges are available.

- Front Spindle**
B12E Max. spindle speed: 12,000min⁻¹
When using an RGB: 8,000min⁻¹
B16E Max. spindle speed: 10,000min⁻¹
When using an RGB: 8,000min⁻¹
Max. drilling diameter: 6mm
- Rotary Tools:**
Max. rotational speed: 4,500min⁻¹
Max. drilling diameter: 5mm
- Back Spindle:**
Max. spindle speed: 6,000min⁻¹
Max. drilling diameter: 5mm

Tooling patterns

B12/16E type VI

- Turning tools :5¹⁰
- Rotary tools on the gang tool post :2 (3^{OP})
- Front drilling tools :4
- Back drilling tools :4



NC program transfer

NC programs can be input and output via USB memory stick, CompactFlash card or RS232 connection.



Product chute

The back spindle retracts and ejects the workpiece into the chute, which drops it to the product receiver box.



Chip receiver box

The chip receiver box is easily drawn out for efficient cleaning.



Coolant tank

The coolant tank has a large capacity of 117 liters and can be moved easily when carrying out maintenance.

Machine specification

Item	B12E	B16E	Standard accessories
	VI(B12E-1F6)		
Maximum machining diameter (D)	12mm	16mm	Main spindle chucking device
Maximum machining length (L)	135 mm/1 chucking (60mm/1 chucking with RGB)		Back spindle chucking device *only V & VI
(tap, die)	20mm		Workpiece separator *only I & II
Spindle through-hole diameter			Coolant device (with level detector)
Main spindle speed	12,000min ⁻¹ (8,000min ⁻¹ with RGB)	10,000min ⁻¹ (8,000min ⁻¹ with RGB)	Lubricating oil supply unit (with level detector)
Spindle speed of the gang rotary tool	4,500min ⁻¹	4,500min ⁻¹	2 Gang rotary tool driving devices *only II & VI
Max. chuck diameter of back spindle	12mm	16mm	Machine relocation detector
Max. protrusion length of the			Door lock function
back spindle workpiece	30mm	30mm	Special accessories
Maximum protrusion length	135mm	135mm	Fixed guide bushing device
Back spindle speed	6,000min ⁻¹	6,000min ⁻¹	Rotary guide bushing device
Number of tools to be mounted	15	15	Coolant flow rate detector
Turning tools on the gang tool post	5	5	Signal lamp
Cross rotary tools	2 (3 ^{OP})	2 (3 ^{OP})	Lighting
Tools for front drilling	4	4	End-face rigid tapping device *only I & II
Tools for back drilling	4	4	Back spindle long workpiece
Tool size			device *only V & VI
Tool (gang tool post)	10x120mm or 60mm		Knock-out jig for through-hole
Sleeve	20mm (19.05mm ^{OP})		workpiece *only V & VI
Chuck and bushing			Standard NC functions
Main spindle collet chuck	F16	F20	NC unit dedicated to the B1216E series
Back spindle collet chuck	F16	F20	8.4 inch colour liquid crystal display (LCD)
Rotary tool collet chuck	ER8	ER8	Operating time display
Chuck for drill sleeves	ER8□ER11		Preparation functions
Guide bushing	B212	B238	Main spindle speed change detector
Rapid feed rate			Corner chamfering/ rounding function
X and Y axes	21m/min		Canned drilling cycle
Z axis	15m/min		Nose R compensation function
A2 axis	15m/min	15m/min	Direct input of on-drawing dimensions
Motors			Main spindle constant surface speed control
Spindle drive	2.2/3.7kW		Program storage capacity : 40m (approx.16KB)
Tool spindle drive	0.5kW	0.5kW	Tool offset pairs : 64 pairs
Back spindle drive	1.0kW	1.0kW	Product counter indication (up to 8 digits)
Coolant oil	0.18kW		Automatic power-off function
Centre height	1000mm		Multiple repetitive cycle
Rated power consumption	5.2kVA	5.2kVA	User macro
Full-load current	20A	20A	Continuous threading function
Main braker capacity	30A		On-machine program check function
Air pressure and air flow rate for			Program prior analysis function
pneumatic devices	0.5MPa-30NI/min (Max.50NI/min)		
Weight	1150kg	1150kg	Special NC functions
			Program storage capacity 2500m (approx.1MB)
			Sub-micron command function
			Front end-face rigid tapping function
			Tool spindle rigid tapping function *only II & VI
			Tool spindle end-face rigid tapping function *only I & II
			Hobbing and polygon machining function (A) *only I & II
			Hobbing and polygon machining function (B) *only II & VI
			Front-back simultaneously machining function *only V & VI
			Main spindle indexing at 1°intervals *only II & VI
			Simplified Z-A2 axes synchronization function *only V & VI
			Tool life management

CITIZEN

CITIZEN MACHINERY CO., LTD.

Japan Citizen Machinery Co Ltd
4017-6 Miyota, Miyota-machi, Kitasaku-gun,
Nagano-ken, 389-0206, Japan

Europe - Germany Citizen Machinery Europe GmbH
Mettinger Strasse 11, D-73728 Esslingen, Germany

Europe - UK Citizen Machinery UK Ltd
1 Park Avenue, Bushey, WD23 2DA, UK

Tel: 81-267-32-5901 Fax: 81-267-32-5908

Tel: 49-711-3906-100 Fax: 49-711-3906-106

Tel: 44-1923-691500 Fax: 44-1923-691599

www.citizenmachinery.co.uk

All specifications are subject to change without prior notice. This product is an export control item subject to the foreign exchange and foreign trade act. Thus, before exporting this product, or taking it overseas, contact your CITIZEN machine dealer. Please inform your CITIZEN machine dealer in advance of your intention to re-sell, export or relocate this product. For the avoidance of doubt products includes whole or part, replica or copy, technologies and software. In the event of export, proof of approval to export by government or regulatory authority must be evidenced to CITIZEN. You can operate the machines after the confirmation of CITIZEN. CITIZEN is a registered trademark of Citizen Holdings Co., Japan.