

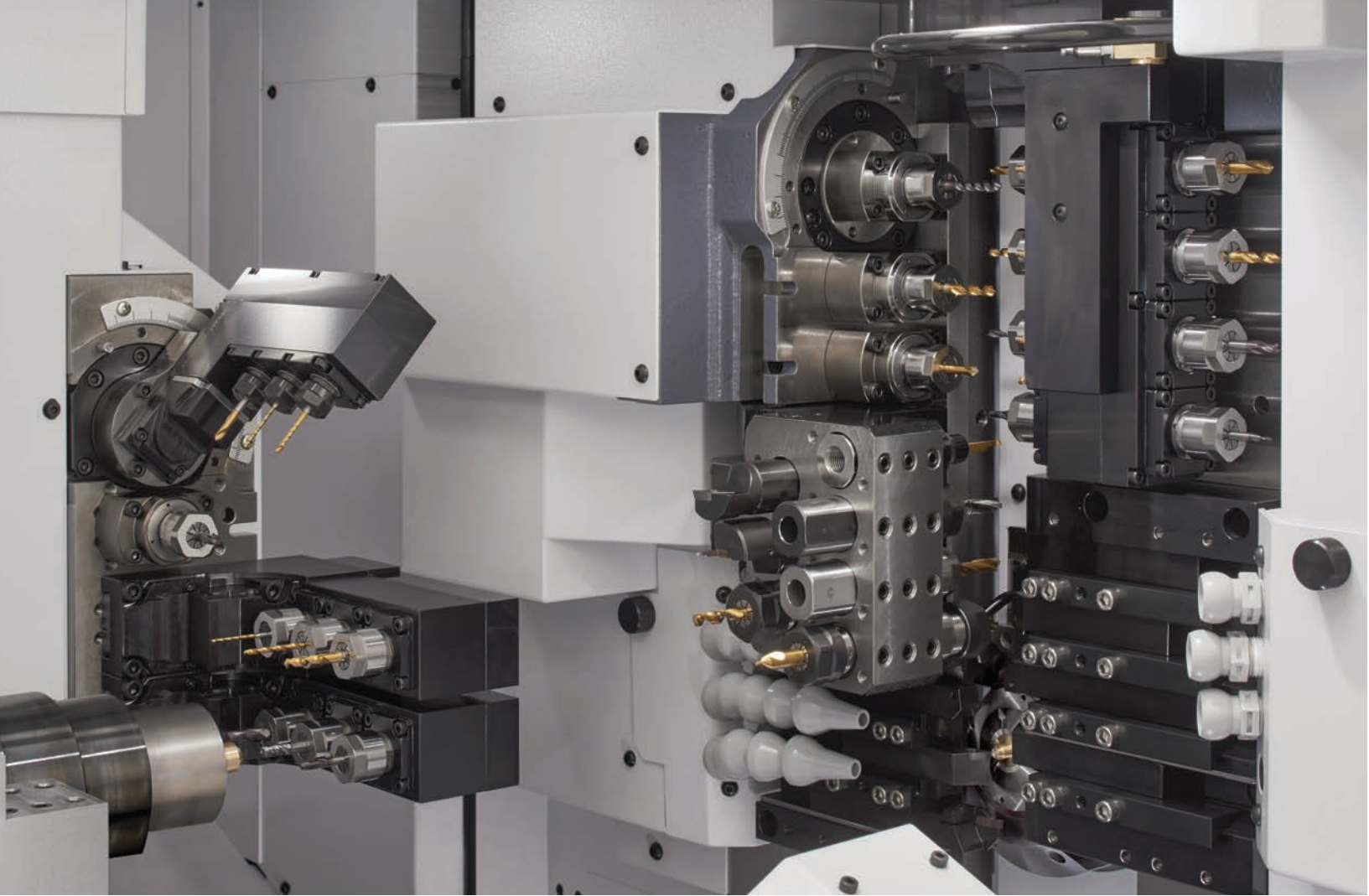
CITIZEN

Cincom

D25

Sliding Headstock Type CNC Automatic Lathe





Introducing Citizen's newest development, the D25, equipped with double gang tool posts and B axis (Type VIII). The double gang layout enables short cycle times for high productivity at low part cost.

The large number of tools, for both main and sub spindle, provides cost effective production of complex workpieces.

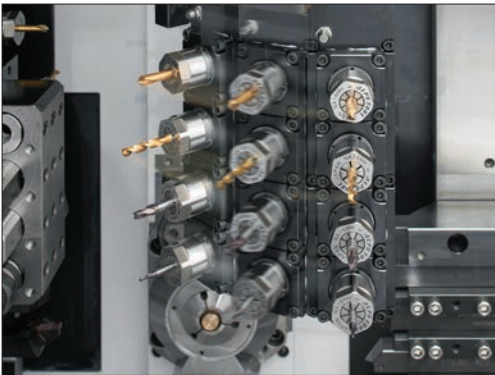
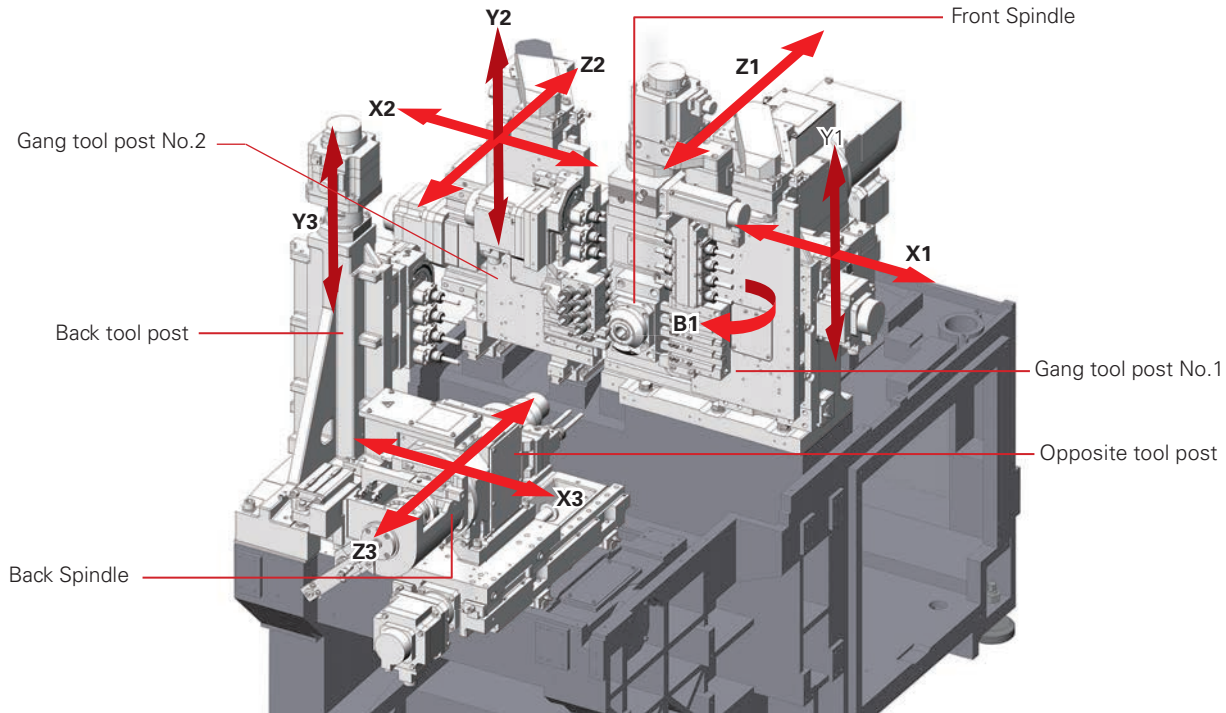


- Next generation CNC system with touch screen and qwerty keyboard. Easy set up with on screen graphical prompts. 3 × Y axis, 3 × Z axis
- B axis (Type VIII) for front-back machining
- Independent adjustable angle rotary tools to sub spindle
- Power and speed: 5.5 kW and 10,000 rpm
- With/without guide bushing – switchable operation

Axis Structure and Tool Layout

Z2 axis to second gang for opposed balance cutting to first gang and for simultaneous rough and finish machining. Back tool post (Y3 axis) accepts radial or face modular fixed/rotary tools and is

equipped with adjustable rotary tool for face, radial or angle machining. B axis is on the first gang for complex machining on main and sub spindles.



Tooling	Code	Description
Turning holder	DTF116	4 Tools (5/8" sq./ cut-off: 3/4" sq.)
	DTF216	3 Tools (5/8" sq.)
Sleeve holder	DDF101	4 Front + 7 Back (1" dia.)
Gang rotary tool	U31B(S4)	3 Modular stations 1 Adjustable rotary tool (0-90 deg.: option) is available on the top position
	U32B(S3)	4 x double ended spindles, rotary tools B-axis (0-135 deg.)
Back rotary tool	U151B(S5)	4 Modular stations
Opposite tool post	U120B	2 Fixed tools (3/4" dia.)

B Axis

4 x double ended spindles, 0-135 deg, usable for both main and sub spindles.

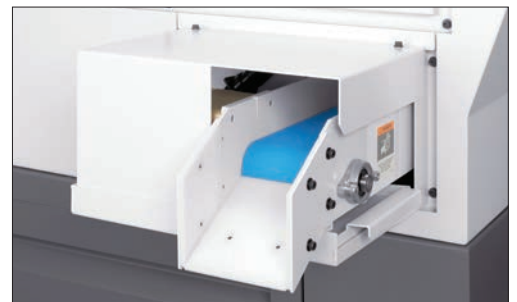


Variety of Interface Choices

USB Memory, SD Card, RS232, Ethernet



15 inch Touch Panel



Workpiece Conveyor (standard)

Machine Specifications

Item	D25 Type VIII (D25-1M8)
Max. machining diameter (D)	1" dia.
Max. machining length (L)	
With guide bushing	250 mm
Guide bushing less	2.5 D
Spindle speed	Max. 10,000 rpm
Spindle speed of the gang rotary tool	Max. 9,000 rpm
Max. chuck diameter of back spindle	1" dia.
Max. part length for ejection to standard parts chute	120 mm
Back spindle speed	Max. 10,000 rpm
Chuck and Bushing	
Main and back spindle collet	TF30
Guide Bushing	CD25
Tool size	
Tool (gang)	5/8" sq. , 3/4" sq. (cut off)
Sleeve	1" dia., 3/4" dia.
Rapid feed rate	
X1, X2, Z2 axes	24 m/ min
Others	32 m/ min
Motor	
for spindle drive	3.7/ 5.5 kW
for rotary tool on the gang tool post	2.2 kW
for back spindle drive	2.2/ 3.7 kW
Back tool post rotary drive	1.0 kW
Rated power consumption	13.2 kVA
Center height	1,050 mm
Weight	7,606 lbs.

Standard accessories

Main Spindle Chucking Unit	Door Lock
Back Spindle Chucking Unit	Cut-Off Tool Breakage Detector
Rotary Guide Bushing Unit	Workpiece Separator and Conveyor
Rotary Tool Driving Unit On Gang Tool Post	Spindle Oil Chiller
Back Tool Post Rotary Unit	Work Light; Handling Tool
Coolant Unit (with Level Detector)	Thermal Displacement Correction Device
Lubricating Oil Supply Unit	RS232 Interface
Pneumatics Ejection Device	
Cap Nut For NGB Mode	

Optional accessories

Knock-Out Jig for Through-Hole Workpiece	Coolant Flow Rate Detector
Chip Conveyor	Signal Lamp
	3-Color Signal Tower

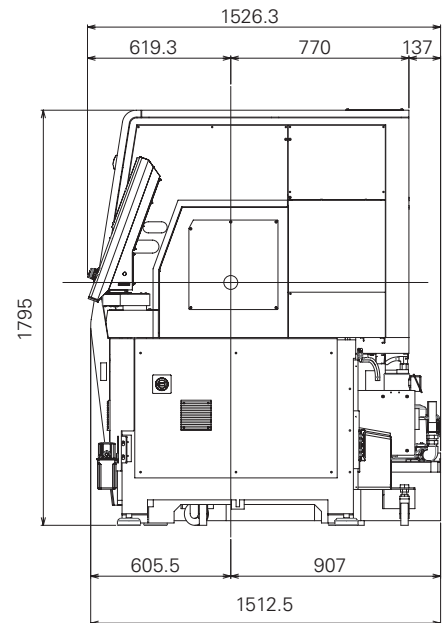
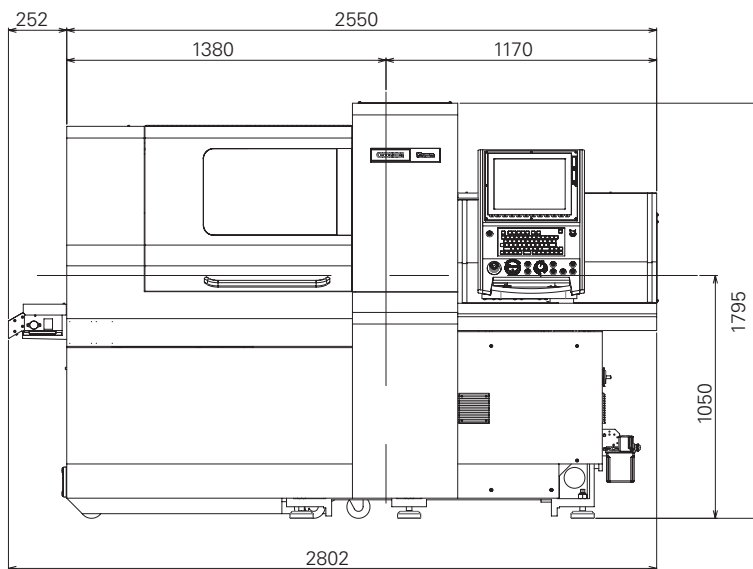
Standard NC functions

CINCOM SYSTEM M850W (Mitsubishi)	Main-Back C-Axis
Display: 15 inch Touch Panel	Differential Speed Synchronous Tapping
Sub inch: 0.00001" Minimum Increment	Hobbing/Polygon during Spindle Synchronization
Hi-Speed Program Check	Milling Interpolation
Main-back Constant Surface Speed Control	Helical Interpolation
Variable Lead Threading	Slant Helical Interpolation
Circular Threading	Tool Life Management I and II
Corner Chamfering/Rounding	Program Storage 160m
User Macro	Tool Offset 99 Pairs
Canned Cycle for Drilling	8 bits B-Code output
Synchronous Tapping with Phasing Function	Optional Block Skip 9 sets
	External Memory Running
	Network I/O

Optional NC functions

Program Storage Capacity: 320 / 600 / 1200 / 2400 / 4800m

External view



Marubeni Citizen-Cincom Inc.

40 Boroline Road
Allendale, NJ 07401
201-818-0100

2316 Touhy Avenue
Elk Grove Village, IL 60007
847-364-9060

17815 Newhope Street, Suite P
Fountain Valley, CA 92708
714-434-6224

68 Moylan Lane
Agawam, MA 01001
413-786-6655

www.marucit.com

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