

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. Citizens famous ease of use have 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

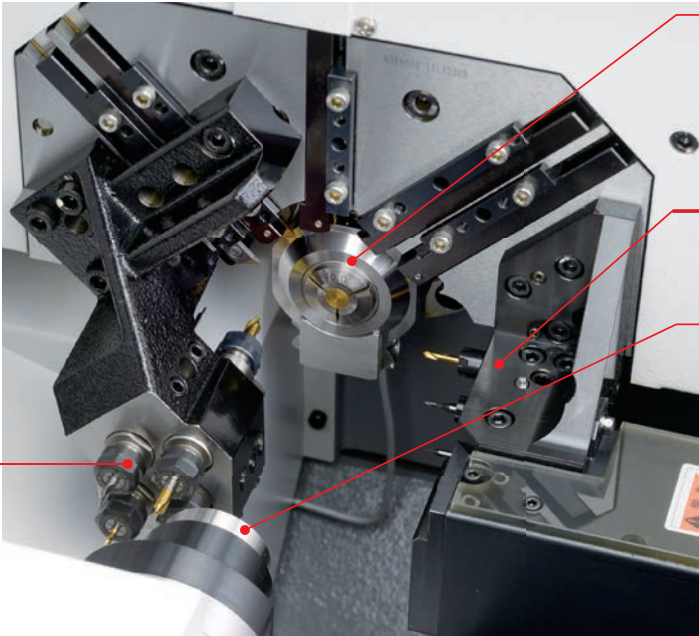
A wide range of optional accessories are available, means that you can change the specifications according to your needs.

Power tool upgrade

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



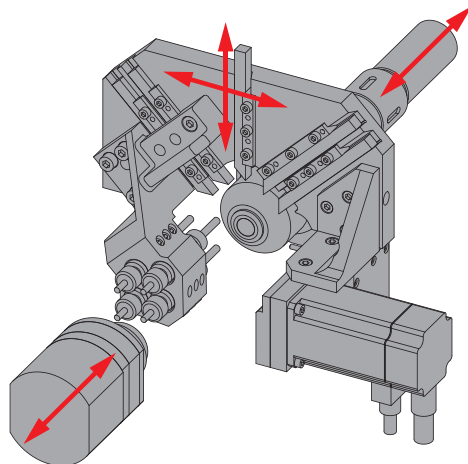
B16E type VI tooling example



Drill Sleeve Holder
This holder can mount four drilling tools as standard.
Ø19.05OP and Ø20 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	: Ø6mm
Rotary Tools	
Max. rotational speed	: 4,500min ⁻¹
Max. drilling diameter	: Ø5mm
Back Spindle	
Max. spindle speed	: 6,000min ⁻¹
Max. drilling diameter	: Ø5mm

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. By reversing the product receiver box, it can be used as an oil bath.



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

	B12E-1F6	B16E-1F6
Max. machining diameter (D)	12mm	16mm
Max. machining length (L)	135 mm/1 chucking (60mm/1 chucking with RGB)	
(tap, die)	20mm	
Spindle through-hole diameter		
Main spindle speed	12,000min ⁻¹ (8,000min ⁻¹ with RGB)	10,000min ⁻¹ (8,000min ⁻¹ with RGB)
Spindle speed of the gang rotary tool	4,500min ⁻¹	
Max. chuck diameter of back spindle	12mm	16mm
Max. protrusion length of the back spindle workpiece	30mm	
Maximum protrusion length	135mm	
Back spindle speed	6,000min ⁻¹	
Number of tools to be mounted	15	
Turning tools on the gang tool post	5	
Cross rotary tools	2 (3 ^{OP})	
Tools for front drilling	4	
Tools for back drilling	4	
Tool size		
Tool (gang tool post)	10×120mm or 60mm	
Sleeve	20mm (19.05mm ^{OP})	
Chuck and bushing		
Main spindle collet chuck	F16	F20
Back spindle collet chuck	F16	F20
Rotary tool collet chuck	ER8	
Chuck for drill sleeves	ER8/ER11	
Guide bushing	B212	
Rapid feed rate		
X and Y axes	21m/min	
Z axis	15m/min	
A2 axis	15m/min	
Motors		
Spindle drive	2.2/3.7kW	
Tool spindle drive	0.5kW	
Back spindle drive	1.0kW	
Coolant oil	0.18kW	
Centre height	1000mm	
Rated power consumption	5.2kVA	
Full-load current	20A	
Air pressure and air flow rate for pneumatic devices	0.5MPa-30Nl/min (Max50Nl/min)	
Weight	1150kg	1150kg

Standard Accessories

Spindle chucking device
Back spindle chucking device *only V & VI
Workpiece separator *only I & II
Coolant device (with level detector)
Lubricating oil supply unit (with level detector)
2 Gang rotary tool driving devices *only II & VI
Machine relocation detector
Door lock function

Special Accessories

Fixed guide bushing device
Rotary guide bushing device
Coolant flow rate detector
Signal lamp
Lighting
End-face rigid tapping device *only I & II
Back spindle long workpiece device *only V & VI
Knock-out jig for through-hole workpiece *only V & VI

Standard NC Functions

NC unit dedicated to the B1216E series
8.4 inch colour liquid crystal display (LCD)
Operating time display
Preparation functions
Main spindle speed change detector
Corner chamfering/ rounding function
Canned drilling cycle
Nose R compensation function
Direct input of on-drawing dimensions
Main spindle constant surface speed control
Program storage capacity : 40m (approx16kB)
Tool offset pairs : 64 pairs
Product counter indication (up to 8 digits)
Automatic power-off function
Multiple repetitive cycle
User macro
Continuous threading function
On-machine program check function
Program prior analysis function

Special Additional NC Functions

Program storage capacity 2500m (approx1MB)
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 synchronisation function *only V & VI
Tool life management

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