

CITIZEN

Miyano

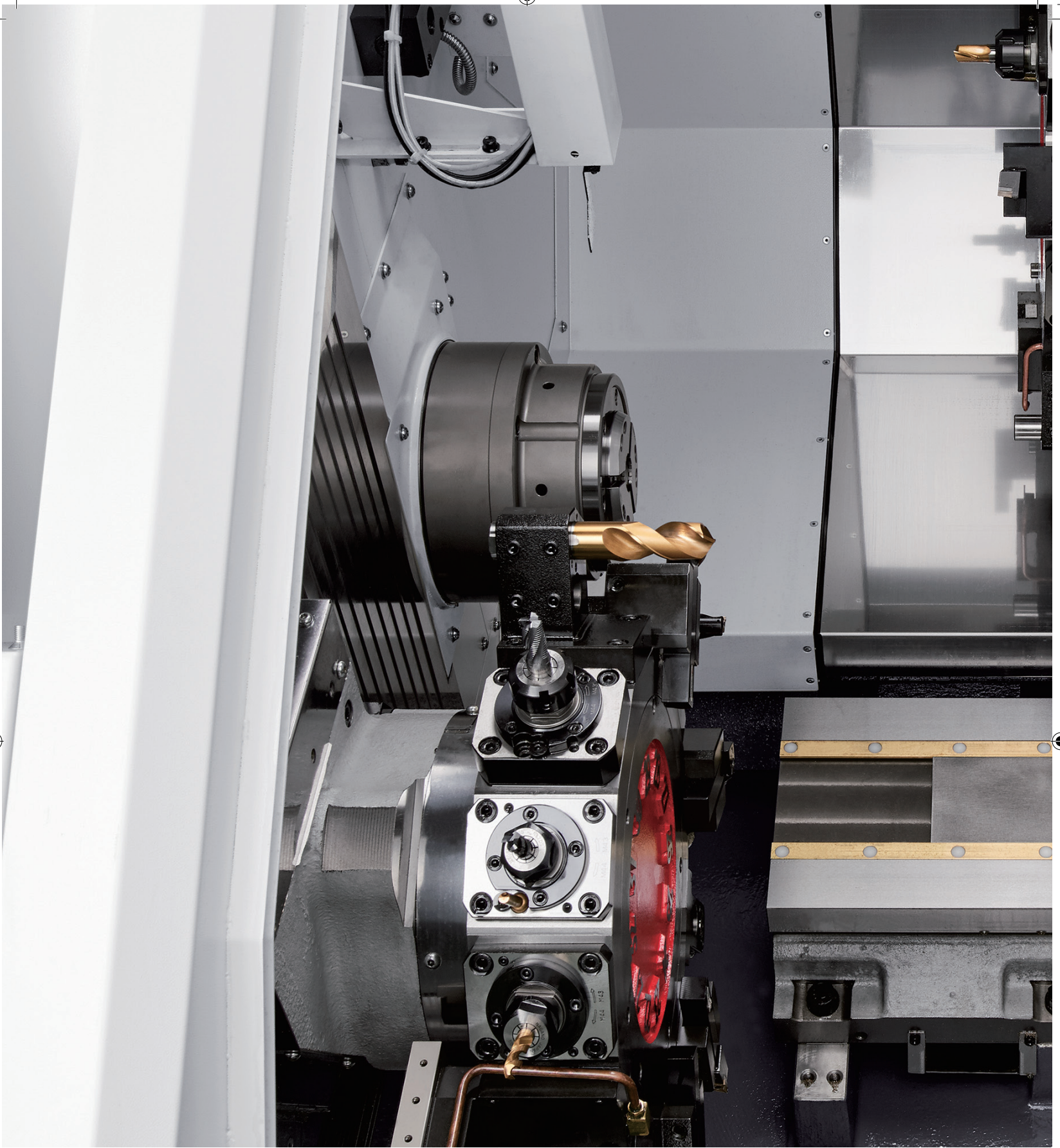
BNE-51 MYY

BNE-65 MYY ATC

Fixed Headstock Type CNC Automatic Lathe



EcoBalance Machine



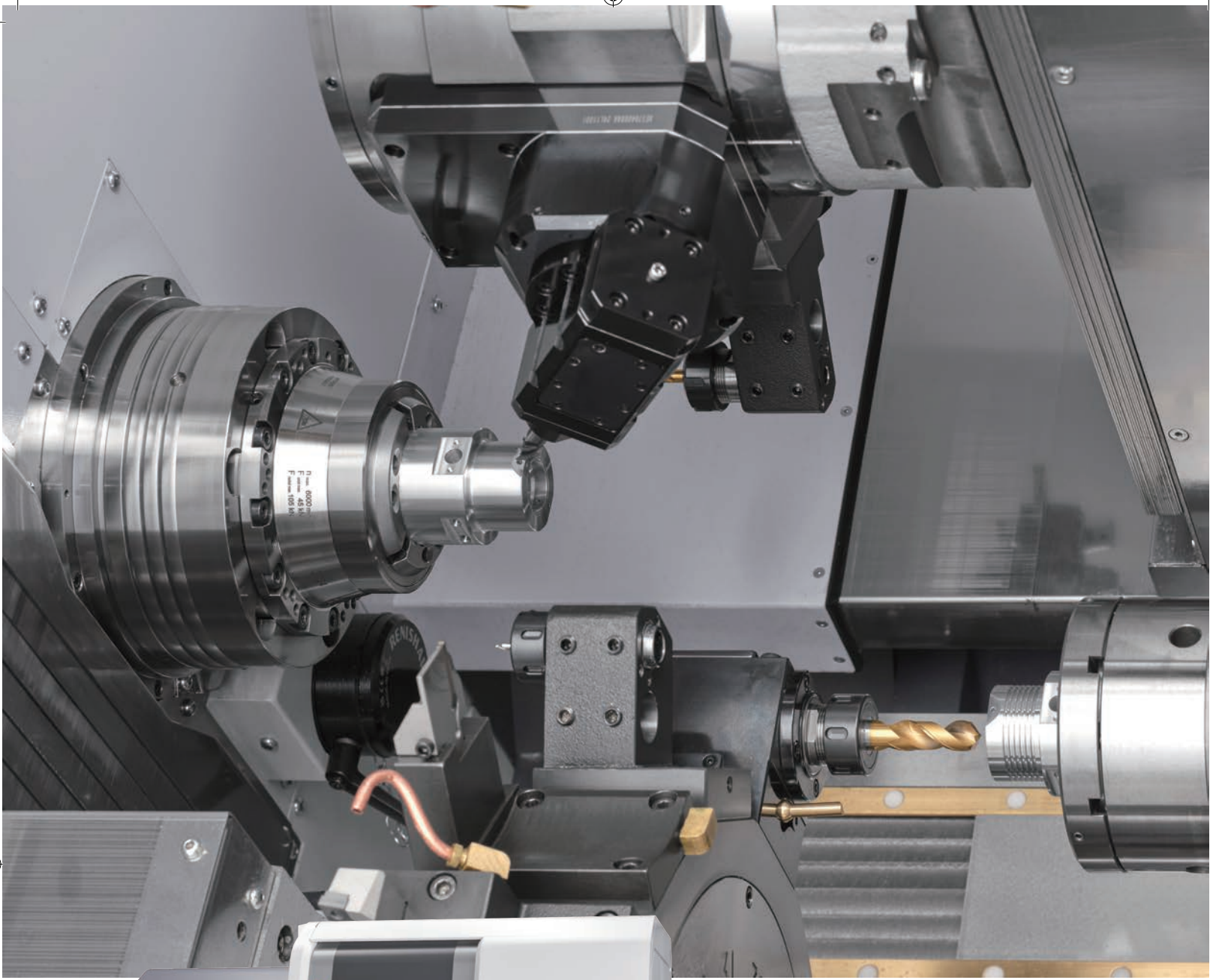
Equipped with twin Y axes and a B axis. New BNE series models: Improved superimposed machining

These four new BNE Series models, developed from the existing BNE range have inherited the characteristics of high rigidity and precision for which the BNE Series has been greatly praised. Made up of MYY models with a Y axis equipped to both upper and lower turrets, and MSB models that are also equipped with a B axis on the upper turret.



BNE65MY

The cover has been completely redesigned with a large window to provide excellent visibility. It has also been equipped with a new HMI (Human Machine Interface). Use of a touch panel for ease of operation, and its use with the new NC units also improves productivity.



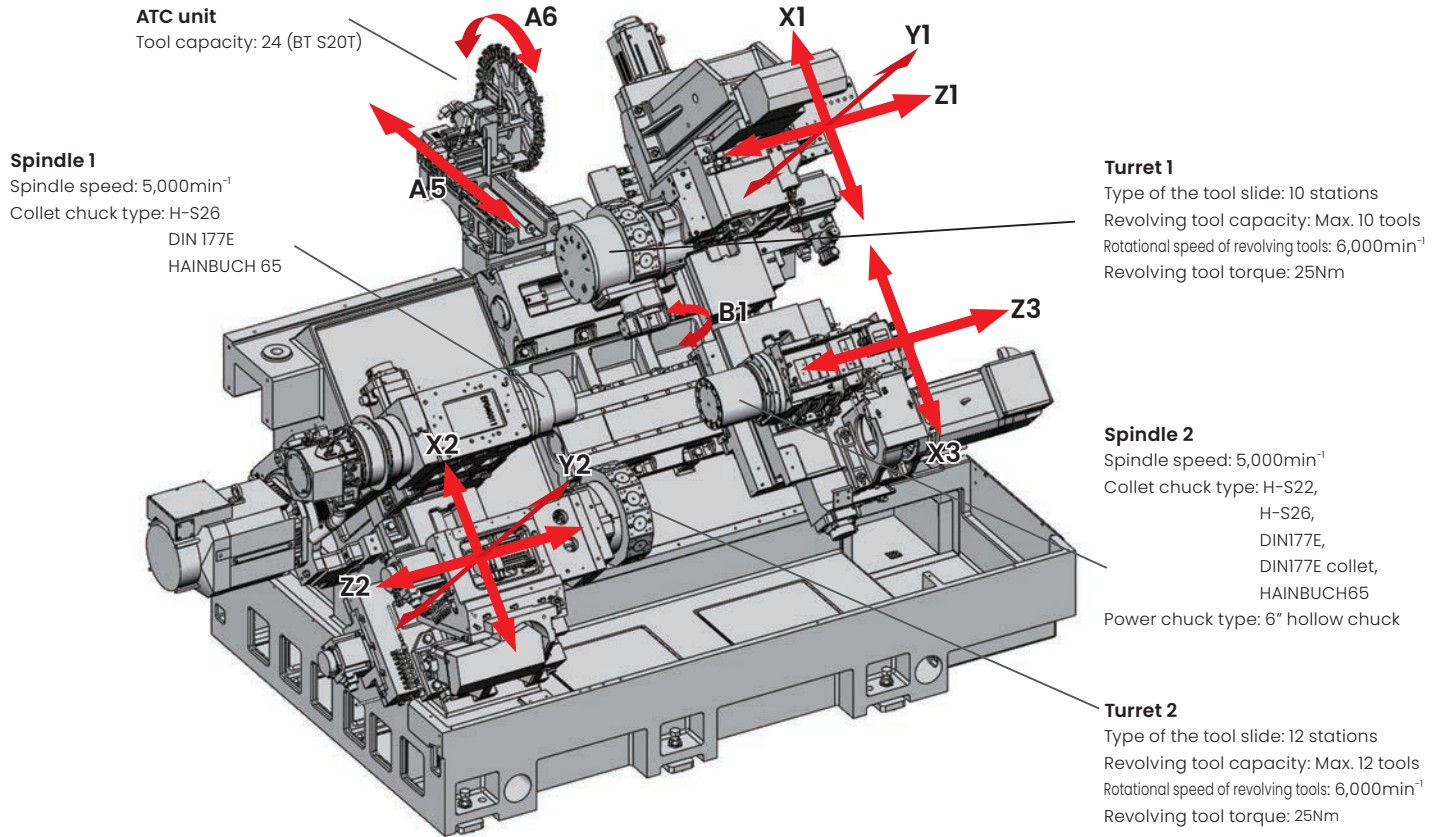
EcoBalance Machine

CITIZEN MACHINERY aims to create a sustainable society by innovating customers' manufacturing workflow with a focus on their future issues as well as their current ones. We work to continuously enhance corporate value through "sustainable management" that takes into account social issues such as human rights and the global environment throughout the value chain, while at the same time promoting the provision of sustainable products such as our proprietary technologies, which include LFV (low-frequency vibration cutting) technology, the "FA-friendly" robot system, and "alkappliesolution" utilising ICT technology, centering on the Cincom and Miyano brands.

65-ATC

The BNE65ATC is a high-performance machine, packing two spindles, two turrets, an ATC unit and a B-axis tool spindle into a small footprint. With simultaneous 5-axis machining, it rapidly and accurately machines multiple faces and complex-shaped workpieces with turning operations at the core.

Basic Construction

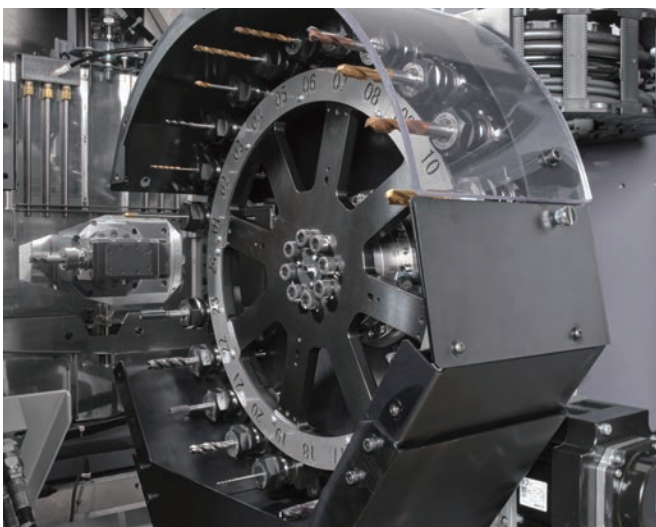


ATC unit

An ATC unit that can accommodate 24 tools enables continuous operation of multiple programs after a single setup.

The ATC unit is compatible with S20T BT shanks, allowing a variety of tools to be mounted, including drills, end mills, and face mills.

Tool change time: 8.9 sec (chip-to-chip)

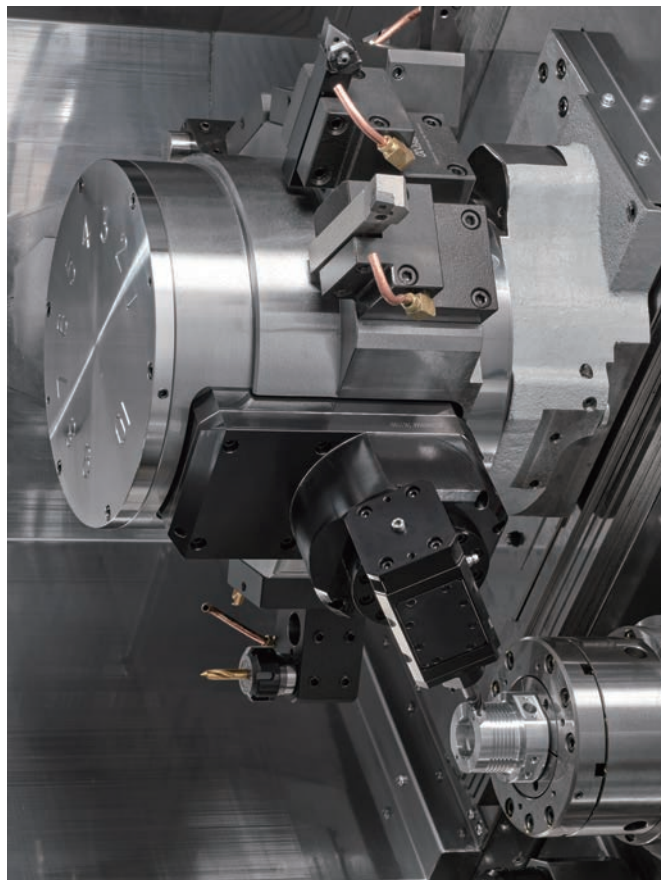


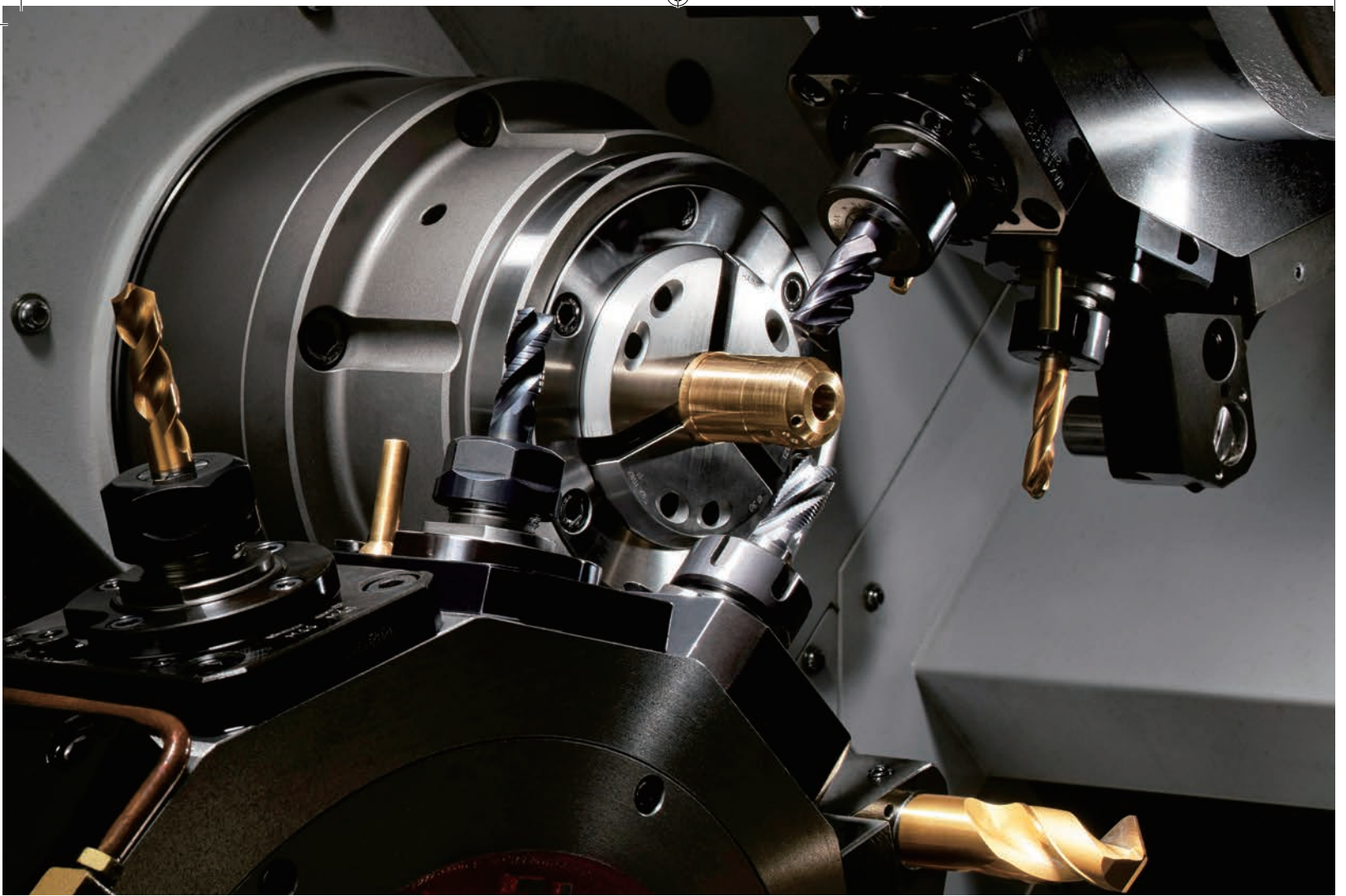
B-axis spindle

Turret 1 is equipped with a tool spindle that can be indexed in the B-axis direction.

This enables stable 5-axis machining with rigidity.

Using the B axis, it is also possible to drill and tap at any required angle, and this in combination with the 24 tools accommodated in the ATC unit dramatically expands the range of workpiece shapes that can be handled.





Upper/Lower Y-axis machining

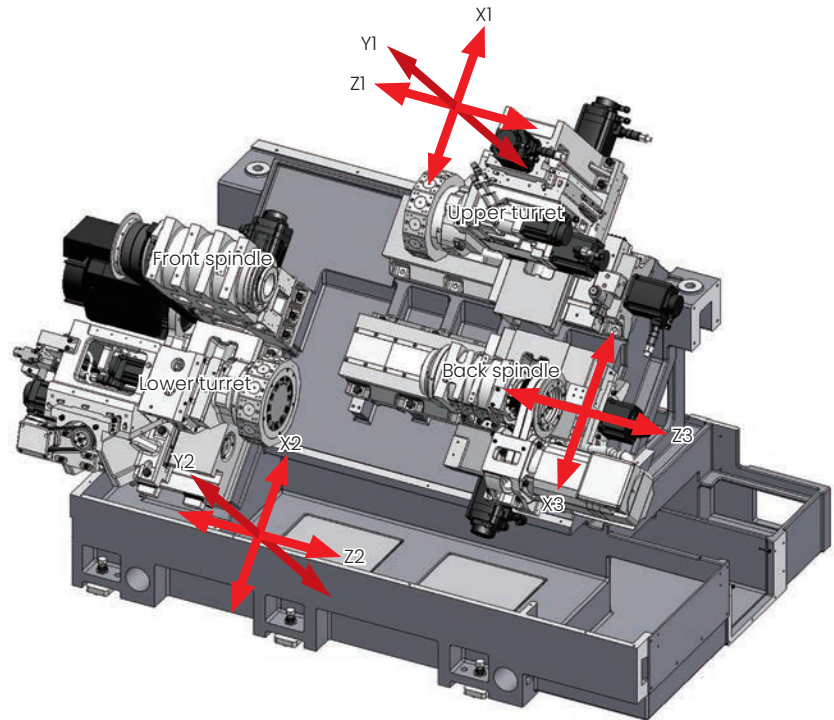


MY Y

The upper and lower turrets of the BNE-51MY and BNE-65MY are equipped with a Y axis. Operating with the same capabilities, these two 12-station turrets complete tooling flexibility thus maximising balanced machining operations.

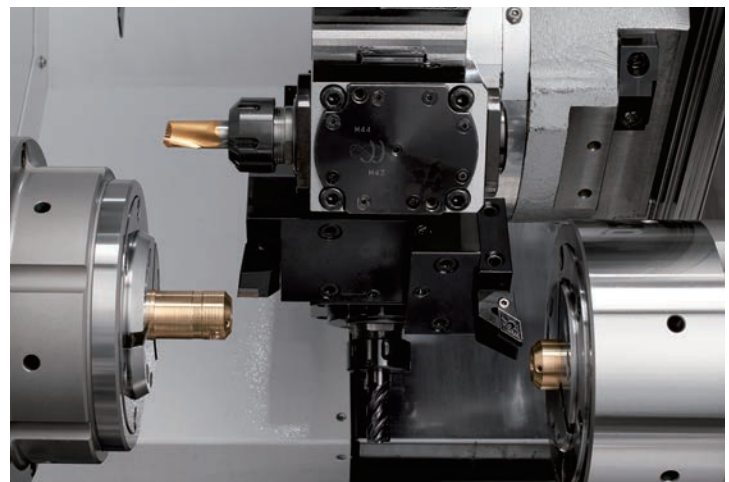
Basic structure and axis configuration

These new models have inherited the slide structure of the BNE that makes it easy swarf to drop away. Rectangular lapped slides have been adopted for all slides except for the X3 axis. The sliding contact between surfaces provides excellent rigidity and damping performance, enabling heavy metal removal, while also helping to extend cutting tool life.



Reduced cycle times with high-efficiency machining

The two turrets equipped with a Y axis, on rigid construction, serve to reduce cycle times by enabling highly efficient machining. Utilising simultaneous and superimposed machining.




Superimposed machining

New HMI (Human Machine Interface) operating panel

A new HMI (Human Machine Interface) equipped operating panel with a 15-inch touchscreen has been added to improve ease of use for the machine operator.

Consideration has been given to the different ways colours are perceived in order to ensure that information is provided in a manner that is readily visible and easily understood by anyone.



 **MUD** ※ Certified by the Media Universal Design (MUD) Association.

Machine Specification

Item		BNE-51MY	BNE-65MY	BNE-65ATC
Machining capacity				
Max. machining length		195 mm		190 mm
Max. machining diameter		51 mm dia.	65 mm dia.	65 mm dia.
Max. drilling diameter	SP1	25 mm dia.		
	SP2	20 mm dia.		
Max. tapping diameter	SP1	M22 × 2.5		
	SP2	M20 × 2.0		
Spindles				
Number of spindles		2		
Main spindle speed	SP1 & SP2	Max. 5,000 min ⁻¹		
Main spindle collet chuck	SP1 & SP2	Hardinge S22 DIN 177E	Hardinge S26 DIN 185E	Hardinge S26 DIN 177E
		HAINBUCH 51	HAINBUCH 65	HAINBUCH 65
Power chuck type	SP1	6" 3-claw chuck, 6" 2-claw chuck		-
	SP2	6" 3-claw chuck, 6" 2-claw chuck		6" hollow chuck
Travel distance				
Slide travel distance	X axis	X1: 205 mm, X2: 205 mm, X3: 155 mm		
	Z axis	Z1: 380 mm, Z2: 175 mm, Z3: 500 mm		
	Y axis	Y1: +60/- 40mm, Y2: ±40 mm		
Tool posts				
Number of tool posts		2		
Type of tool post	HD1	12 ST.		
	HD2	12 ST.		
Dimensions of tools used		20 mm		
Dimensions of tool post holes		25 mm dia.		
Rotary tools				
Number of installed rotary tools	HD1	Max12		
	HD2	Max12		
Type of rotary tool drive		Independent clutch drive		
Rotating speed of rotary tools		6,000 min ⁻¹		
Machining capacities	Drill	16 mm dia.		
	Tap	M12 × 1.75		
	Drill	10 mm dia.		
	Tap	M6 × 1.0		
		Max. M8x1.25 for BSBM		
Feed rate				
Rapid feed rate	X1, Z1, X3, Z3 axes	20 m/ min		
	X2, Z2 axes	18 m/ min		
	Y1, Y2 axes	12 m/ min		
Slide thrust	X1, Z1, X3 axes	85 kN		
	X2 axis	11.3 kN		
	Z2, Y1 axes	6.6 kN		
	Z3 axis	5 kN		
	Y2 axis	5.8 kN		
Motors				
Spindle motor	SP1	18.5/ 15 kW (30min/ cont.)		
	SP2	11/ 7.5 kW (15min/ cont.)		
Rotary tools motor	SP1 & SP2	4.0 kW		
Required power source				
Power supply		AC 200 ± 10%		
Power supply capacity		47 KVA		
Air pressure source		0.5 MPa		
Air pressure flowrate		120 NL/min. (When using air blower for 1 sec. in 3 locations)		
Tank capacity				
Hydraulic oil tank capacity		18 L		
Lubricating oil tank capacity		5 L		
Coolant tank capacity		350 L		
Machine dimensions				
Machine height		2,070 mm		
Floor space		W 2,860 × D 2,190 mm		
Machine weight		8,080 kg	8,130 kg	
Option				
Spindle brake, Air blow, Work ejector, Automatic fire extinguisher, Automatic power shut-off, Chip box				
Parts conveyor, Coolant level switch, High pressure coolant, Inner high pressure coolant & air blow				
Turret high pressure & air blow, Tool setter, Parts Catcher, Parts Box, Chuck system, Chip conveyor				
Signal tower, Filler tube, Spindle inner bushing, Bar feeder inner bushing, Cut-off confirmation, Parts carrier				
Left over catcher, Thermal displacement correction function				

NC specifications

NC units	MITSUBISHI M830W
Command specified axes	HD1 X1, Z1, Y1
	HD2 X2, Z2, Y2
	SP1 C1
	SP2 C2
	SP2 Slide X3, Z3
Auxiliary axes	HD1 Rotary tool S3
	HD1 Index T1
	HD2 Rotary tool S4
	HD2 Index T2
Control axis groups	3 groups
Input code	ISO
Command input system	Incremental and absolute
Number of tool offsets	99
Feed command system	Per rotation feed and per minute
Override function	Rapid feeding/Cut feeding 0 to 100%
Zero return function	Manual zero return
On-machine program check function	Manual pulse generator
Program operation storage capacity	960 Kbyte (2400 m)
Input/Output interface	SD card slot and USB memory slot
Spindle C-axis function	0.001°

Standard function

Zero return function, On-machine program check function, Manual feed function

Manual data input (MDI) function, Back up function, Operation time display, Product counter display

Eco display, Cycle time check function, Automatic screen off function

4-Group simultaneous spindle speed command, 3-group simultaneous M command, Superimposition of freely selected axis function

BNE-MYY-dedicated macros, Optional block skip, Optional stop

Cut-off check function, Corner chamfering/ Radius function, Arc radius specification, Canned cycle for threading

Rotary tool synchronous tap function, Spindle synchronising control function, Multiple canned cycles for turning, Canned cycle for drilling

Milling interpolation, Helical interpolation, Inch/Millimeter switching function, Safety monitoring

Program parameters input

Standard operating functions

Start position automatic return, Waiting point automatic return, Back spindle retract return, Turret retract return

Automatic cut-off machining function, Tool set function, Spindle speed set function, Tool select function

Check adjustment function, Auxiliary manual operation function (AUX), Jog function, Handle operation function

Zeroing operation function

Editing support functions

Calculator function, Code list display, Code insert, Coordinate calculation function, Format check

Alarm block display function, Background editing, Simultaneous 3-system program editing

Option

Program operation memory capacity of 1,920 Kbyte (4,800 m), Program memory capacity of 10 MB

Program memory range of 20 MB, Program memory range of 50 MB, Program memory range of 100 MB

Network I/O function, RS-232C, Automatic power shut-off function, Thermal displacement correction function, tool setter

Tool monitor, 3D chamfering function, Variable lead threading, Arc threading.

2-System simultaneous threading I, 2-System simultaneous threading II, High-speed tapping function, Tool life management I

Spindle superimposition function, External memory program operation

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