Cincom

L32

Sliding Headstock Type CNC Automatic Lathe

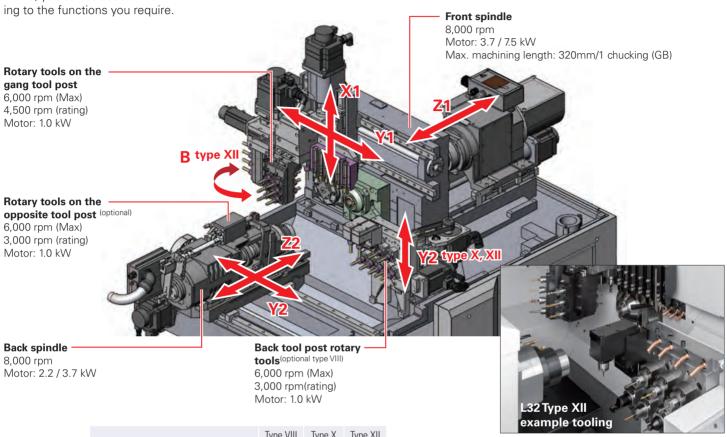


The new L32 — an icon reinvented

With a legacy as one of the best-selling Cincom machines, the nextgeneration L32 is launched with 3 models in modular design.

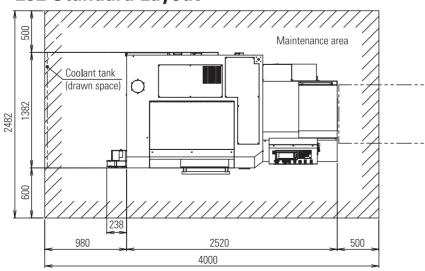
Ranging from a 5-axis machine with excellent cost performance to a high-end machine equipped with B axis and back tool post Y axis, you can select the machine accord-

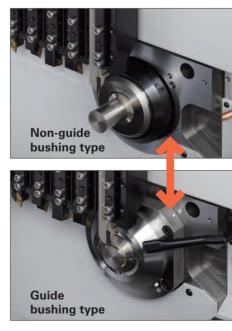
A wide range of modular tooling ensures that the new L32 is both versatile and flexible to meet your production demands into the future.



	Type VIII	Type X	Type XII
B axis (rotary tools on the gang tool post)	-	-	0
Y axis (back tool post Y axis)	-	0	0
Rotary tools on the opposite tool post	OP	OP	OP
Rotary tools on the back tool post	OP	Ο	0

L32 Standard Layout





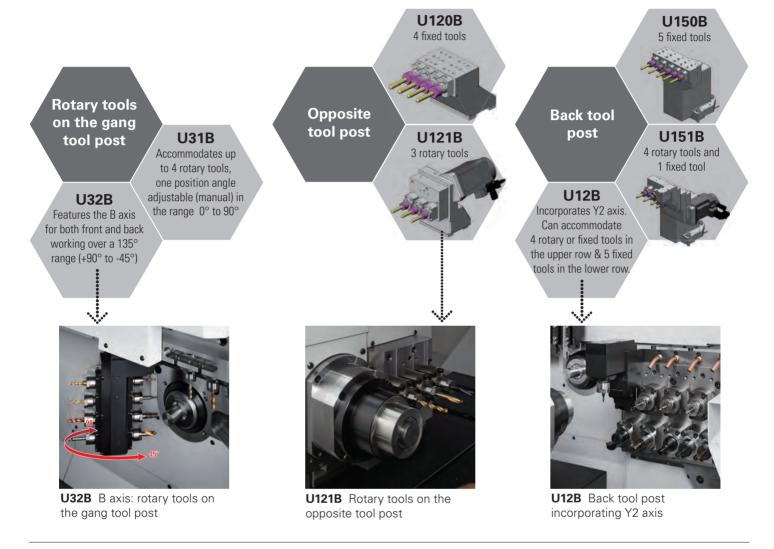
Switchable between guide bushing mode or non-guide bushing mode Can be switched by operator in approximately 30 mins.

Stable, powerful, productive with versatile modular design

Function modules that can be combined without restrictions

With the current shift in manufacturing industry, the requirement is for variable-lot machining of diverse workpiece shapes and

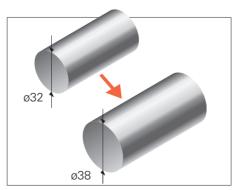
sizes. In order to meet this requirement, Citizen has introduced modular design to the new L32 thus enabling our customers to optimize their manufacturing by selecting the functions to achieve the ideal machine configuration for their needs.





Extra-wide cover for operator convenience

The operator door can be flipped up to provide access to the interior of the machining area through a very large opening, allowing comfortable and easy access for tool setting and other adjustments.



ø32 mm max. bar as standard; ø38 mm as option

Supply of bar stock up to ø38 mm is supported as an option. The machining length per chucking is 320 mm in both capacities. A wide range of workpieces can be machined.



Workpiece conveyor equipped as standard

Workpieces are discharged to the left front of the machine.

Machine Specifications

Item	Type VIII	Туре Х	Type XII	
	L32-1M8	L32-1M10	L32-1M12	
Max. machining diameter (D)		32 mm (option: ø		
Max. machining length (L)	GB:320	mm/1chucking N	IGB: 2.5D	
Spindle through-hole diameter	ø39 mm			
Main spindle speed	Max.8,000 min ⁻¹			
Max. chuck diameter of back spindle		ø32 mm		
Max. protrusion length of back spindle workpiece	80 mm 65 mm			
Max. protrusion length	150 mm 140 mm			
Back spindle speed	Max.8,000 min ⁻¹			
Gang rotary tool: Spindle speed	Max.6,000 min ⁻¹ (Rating 4,500 min ⁻¹)			
Front rotary tool (OP): Spindle speed	Max.6,000 min ⁻¹ (Rating 3,000 min ⁻¹)			
Back tool post rotary tool (OP type VIII): Spindle speed	Max.6,000 min ⁻¹ (Rating 3,000 min ⁻¹)			
Number of tools to be mounted (max.)	19~30	24~44	30~40	
Gang turning tool		6		
Gang rotary tool	4~6	5~13	7~11	
Front drilling tool	4~9	4~16	4~9	
Back drilling tool	5~11	9~20	13~19	
Tool size				
Gang turning tool	□5/8″			
Sleeve	1"			
Chuck and bushing				
Main spindle collet chuck	TF37SP (TF43: ø38 spec)			
Back spindle collet chuck	TF37SP (TF43: ø38 spec)			
Rotary tool collet chuck	ER11, ER16			
Chuck for drill sleeves	ER11, ER16			
Guide bushing	TD:	32 (STM38: ø38 s	spec)	
Rapid feed rate	1032 (011030. 030 3pcc)			
All axes (except Y2)		32 m/min		
Y2 axis	_		ı/min	
Motors			,	
Spindle drive		3.7/7.5 kW		
Gang tool post rotary tool drive	1.0 kW			
Back spindle drive	2.2/3.7 kW			
Back tool post rotary tool drive (OP type VIII)	1.0 kW			
Front rotary tool drive (OP)	1.0 kW			
Coolant oil	0.4 kW			
Lubricating oil	0.003 kW			
Center height	1,050 mm			
Rated power consumption	13.2 kVA			
Full-load current	36A			
Main breaker capacity	60A			
Air pressure and air flow rate for pneumatic devices	0.5 MPa, 64.2 NL			
Weight	6,283 lb		33 lb	
Time VIII head tool poot votom tool is entimed. **Front votom	,			

^{*}Type VIII back tool post rotary tool is optional; **Front rotary tool drive unit is optional for all types

Standard accessories

Main spindle chucking unit Back spindle chucking unit Rotary quide bushing unit Gang rotary tool driving unit Coolant unit (with level detector) Lubricating oil supply unit (with level detector)

Door lock Cut-off tool breakage detector Workpiece separator Lighting Rotary guide bushing drive unit

Main spindle coolant unit Back tool post rotary unit (type X,XII)

Optional accessories

Machine relocation detector

Knock-out jig for through-hole workpiece Chip conveyor Back rotary tool unit (type VIII)

Coolant flow rate detector Signal lamp

3-color signal tower Front rotary tool unit

Standard NC functions

CINCOM SYSTEM M70LPC-VU (Mitsubishi) 8.4 inch color LCD USB slot Program storage capacity: 80m (approx. 32KB) Tool offset pairs: 80 Product counter indication (up to 8 digits) Operating time display function Machine operation information display Multiple repetitive cycle for turning B axis control function (type XII) Back spindle chasing function Interference check function Synch tapping phasing function Spindle speed change detector Constant surface speed control function Automatic power-off function On-machine program check function Chamfering, corner R Nose radius compensation Eco indication Variable lead thread cutting

Arc threading function Geometric functions Spindle synchronized function Spindle C-axis function Back spindle C-axis function Milling interpolation Canned cycle drilling Rigid tapping function High speed Rigid tapping function Differential speed rotary tool function Tool life management I Tool life management II External memory program driving User macros Helical interpolation function Slant helical interpolation function

Hob function Polygon function Inch command Sub inch command Network I/O function

Optional NC functions

Optional block skip (9 sets) Back machining program skip function Program storage capacity 600m (approx. 240KB)

Environmental Information

Basic Information	Energy Usage	Power supply voltage	AC200V
		Electrical power requirement (Max)	13.2kVA
		Required pneumatic pressure	0.5MPa
Environmental Performance	Power Consumption	Standby power*1	0.320kW
Information		Power consumption with model workpiece*2,*3	0.0133kWh/cycle
IIIIOIIIIatioii			6.3g/cycle
	Air Consumption	Required air flow rate	45NL/min (max. 182 NL/min., during air blow)
	Lubricant Consumption	At power ON	1.5cc/60min
	Noise Level	Value measured based on JIS	78.5dB
Approudit to Environmental	Environmental load reduction	RoHS Directive / REACH regulations	Compliant
	Recycling	Indication of the material names of plastic parts	Covered in the instruction manual *5
133463	Environmental management	We pursue "Green Procurement" by prioritizing purchases for goods and services that show consideration for the environment.	

- This is the standby power in the idle stop mode (a function that turns servomotor excitation off when it is not necessary, for example during program editing).
- *2: This is the power consumption in program operation (when not cutting) for one of our standard test pieces, shown for the purpose of comparing the environmental performance with that of existing models.

 *3. The average cycle time is 55 sec with the standard test workpiece of our company.

 *4: This is the value converted in accordance with the CHUBU Electric Power CO2 emissions coefficient for 2009 as published by the Ministry of the Environment.

*5. If polyvinyl chloride (PVC) and fluoric resin are not processed correctly they can generate harmful gases. When recycling these materials, commission a contractor that is capable of processing them appropriately.

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