

CITIZEN

Cincom

M32

Sliding Headstock Type Automatic CNC Lathe



Machine Specification

Item	M32		
	V	VII	VIII
	M32 - 5M5	M32 - 5M7	M32 - 5M8
Max. machining diameter (D)	32 mm dia. (38 mm ^{OP})		
Max. machining length (L)	320 mm/1 chucking		
Max. front drilling diameter	12 mm dia.		
Max. tapping diameter for the front spindle	M12 (Cutting tap)		
Main spindle speed	Max. 8,000 min ⁻¹		
Max. chuck diameter for the back spindle	32 mm dia. (38 mm ^{OP})		
Max. drilling diameter for the back spindle	12 mm dia.		
Max. tapping diameter for the back spindle	M12 (Cutting tap)		
Max. length of the back spindle workpiece	145 mm (Standard recovery unit)		
Back spindle speed	Max. 8,000 min ⁻¹		
Gang rotary tools			
Max. drilling diameter	8 mm dia.		
Max. tapping diameter	M8 (Cutting tap)		
Main spindle speed	Max. 9,000 min ⁻¹		
Turret rotary tools			
Max. drilling diameter	12 mm dia.		
Max. tapping diameter	M12 (Cutting tap)		
Main spindle speed	Max. 6,000 min ⁻¹		
Back rotary tools			
Max. drilling diameter	8 mm dia.		
Max. tapping diameter	M6 (Cutting tap)		
Main spindle speed	Max. 6,000 min ⁻¹		
Number of tools	25 to 27 + α	23 to 31 + α	30 to 36 + α
Turning tools	5		
Cross drills	5 to 7		8 (including 4 B-axis drills)
Gang tool post backside drills	Max. 4		4 (including 4 B-axis drills)
Number of turret stations	10		
Back tool post drills	5	Max. 9	
Tool size			
Turning tool	□ 16 mm		
Sleeve diameter	25.4 mm dia.		
Chuck and bushing			
Main spindle collet chuck	FC081-M (FC251-M: 38-mm dia. Opt.)		
Back spindle collet chuck	FC081-M-K (FC251-M-K: 38-mm dia. Opt.)		
Guide bushings	FG531-M and WFG531-M (FG581-M: 38-mm dia. Opt.)		
Rapid feed rate			
X1, Y1, Z1, Z2, X3, Z3	32 m / min		
Y3	—		32 m / min
X2	18 m / min		
Y2	12 m / min		
B1	-		50 min ⁻¹
Motors			
Front spindle drive	5.5 / 7.5 kW		
Back spindle drive	5.5 / 7.5 kW		
Gang rotary tool drive	2.2 kW		
Turret rotary tool drive	2.2 kW		
Back rotary tool drive	1.0 kW		
Pneumatic unit: Required pressure and required flowrate	0.5 MPa at 110 NL/min. (When stationary)		
Machine main unit dimensions	(W) 2,860 × (D) 1,465 × (H) 1,900 mm		
Weight	4,250 kg		4,300 kg
Power supply voltage	AC200V ± 10%		
Rated power consumption	24 kVA		25 kVA
Full-load current	79 A		
Main breaker capacity	100 A		

Main standard accessories

Main spindle chucking unit	Back spindle chucking unit
Gang rotary tool driving unit	Back rotary tool driving unit *Types VII, VIII
Rotary guide bushing unit	Rotary guide bushing drive unit
Coolant unit (with level detector)	Concentrated lubricating oil supply unit (with level detector)
Air-driven knock-out device for back machining	Air-driven workpiece separator
Machine relocation detector	Spindle cooling unit
Door lock	Machine internal lighting
Automatic fire extinguishing unit	

Special accessories

Knock-out jig for through-hole workpiece	Motordriven knock-out device for back machining
Cut-off tool breakage detector	Long workpiece unit
Product unloader	Workpiece conveyor
Chip conveyor	Medium-pressure coolant unit
High-pressure coolant unit	Coolant flow rate detector
3-color signal tower	M32 special tool

Standard NC functions

CINCOM SYSTEM M830W (Mitsubishi Electric) *Types V, VI	CINCOM SYSTEM M850W (Mitsubishi Electric) *Type VII
15-inch XGA touch panel	USB slot
Program storage capacity: 160 m (Approx. 64 KB)	Tool offset pairs: 99
Product counter indication (up to 8 digits)	User-opened disk capacity of 10 MB
Preparing operation functions	Operating time display function
Machine operation information display	Spindle C-axis function
B-axis control function *Type VIII	Back machining program skip function
Interference check function	Impact detection function
Spindle speed change detector	Constant peripheral speed control function
Automatic power-off function	Spindle 1° indexing function
On-machine program check function	Nose radius compensation
Eco display	Chamfering/Corner R function
Multiplex repetitive cycle for turning	

Special NC functions

Variable lead thread cutting	Arc threading function
3D chamfering function	Geometric command function
Spindle synchronized function	Milling interpolation function
Back spindle 1° indexing function	Back spindle C-axis function
Back spindle chasing function	Canned cycle for drilling
Synchronized tapping phase adjustment function	Synchronized tapping function
High-speed synchronized tapping function	Differential speed rotary tool function
Optional block skip (9 sets)	Tool life management I
Tool life management II	Program storage capacity: 4800 m (1,920 KB)
User-opened disk capacity of 100 MB	External memory program driving
Submicron commands	User macros
Inclined helical interpolation function	Inclined helical interpolation function
Hob function	Polygon function
Inch command	Sub inch command
Network I/O function	RS232C connector
LFV model, 2	LFV mode3
Rotary tool feed per revolution	

Environmental Information

Basic Information	Energy usage	Supply voltage	AC200 V
		Electrical power requirement	V, VII : 24 kVA , VIII : 25 kVA
Environmental Performance Information	Power consumption	Required pneumatic pressure	0.5 MPa
		Standby power	0.779 kW
		Power consumption with model workpiece ^{*1}	0.0217 kWh/cycle
		Power consumption value above converted to a CO2 value ^{*2}	10.3 g /cycle
	Air consumption	Required air flow rate	65 NL/min (Power ON), 110 NL/min (Normal), 175 NL/min (With air blow)
Approach to Environmental Issues	Lubricating oil consumption	At power ON	5.5 cc / 30min
	Noise level	Value measured based on JIS	72 dB
	Recycling	Indication of the material names of plastic parts	Detailed in the part list ^{*3}
Environmental management		We pursue Green Procurement, whereby we make our purchases while prioritizing goods and services that show consideration for the environment.	

*1 : 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.

*2 : This is the value converted in accordance with the CHUBU Electric Power CO2 emissions coefficient for 2017 as published by the Ministry of the Environment.

*3 : If polyvinyl chloride (PVC) and fluorine 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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