CITIZEN





Machine Specification

| Item | | | BNA-42CY5 | BNA-42SY5 |
|---|----------------|--------|--|----------------------------------|
| Capabilities/Capacities | | | | |
| Max. machining length | | | 200 mm | 100 mm |
| Standard machining diameter (Chuck | k diameter) | SP1 | 42 mm dia. | |
| Travel distance | | SP2 | | 34 mm dia. |
| Turret slide travel distance | X axis | | 140 mm | |
| Turret side traver distance | Zaxis | | 285 mm | |
| | Y axis | | 70 (+/-35) mm | |
| Back spindle slide travel distance | | | | 360 mm |
| Spindles | | | | |
| Number of spindles | | | 1 | 2 |
| Spindle speed | SP1 | | 60 to 6,000 min ⁻¹ | |
| | SP2 | | | 50 to 5,000 min ⁻¹ |
| Closing tube through-hole diameter | | | 43 mm dia. | |
| Collat abuak tura | SP2 | | | 30 mm dia. |
| Collet chuck type | SP1 SP2 | | Hardinge S20, DIN173E, B&S | JPN, DIN171E |
| | 312 | | | DIN173E, B&S #22 |
| Power chuck type | SP1 | | 5" and 6" hollow chucks | 5" hollow chuck |
| | SP2 | | | 4" hollow chuck |
| Tool post | | | | |
| Number of tool posts | | | 1 | |
| Type of tool post | | | 12 ST. | |
| Opposite side distance of tool pos | t | | 300 mm | |
| Max. turning radius of tool post | | | 505 mm dia. | |
| Dimensions of tools used | | | 20 mm sq. | |
| Dimensions of tool post holes | | | 25 mm dia. | |
| Rotary tools Number of installed rotary tools | | | Max.12 | |
| Type of rotary tool drive | | | Independent clutch drive | |
| Rotating speed of rotary tools | | | 50 to 5,000 min ⁻¹ | |
| Machining capacities | Drill | | Max. 10 dia. | |
| 3.4 | Тар | | Max. M6 × 1 | |
| | | | (Limited to spiral and point ta | ps for M8 x 1.25) |
| | | | Max. M8 x 1.25 for BSBM | |
| Feed rate | | | | |
| Rapid feed rate | X axis | | 20 m/min | |
| | Z axis | | 20 m/min | |
| | Y axis | | 12 m/min | |
| Slide thrust | B axis | | | 20 m/min |
| Side triust | X axis | | 5 kN | |
| | Zaxis | | 5 kN | |
| | Y axis | | 6.7 kN | |
| | B axis | | | 5 kN |
| Tailstock | | | | 1 |
| | Max. travel di | stance | 200 mm | |
| | Morse taper | size | MT2 | |
| | Max. slide th | nrust | 4.3 kN (at 3.4 MPa) | |
| | Min. slide th | | 0.57kN (at0.45 MPa) | |
| | Drive metho | d | Hydraulic | |
| Motors | | | | () |
| Spindle motor | SP1 | | 11/ 7.5/ 5.5 kW (15%/ 15 min | i/ cont.) |
| Botany tools motor | SP2 | | 5.5/ 3.7 kW (15 min/ cont.) 2.8/ 1.0 kW | |
| Rotary tools motor Coolant pump motor | | | 2.8/ 1.0 kW 0.25 kW | |
| High-pressure coolant motor | | | 1.1/0.75 kW (60/ 50Hz) | |
| Required power source | | | , 0.7 0 (00/ 001/2/ | |
| Power supply | | | AC 200/ 220 +5%/ -10%, 50/ | 60 Hz ±1% |
| Power supply capacity | | | 16 kVA | 26 kVA |
| Air pressure source | | | 0.5 MPa | |
| Fuse capacity on facilities side | | | 75 A | 100 A |
| Tank capacities | | | | |
| Hydraulic tank capacity | | | 18 L | |
| Lubricating oil tank capacity | | | 2 L | |
| Coolant tank capacity | | | 235 L | |
| Machine size | | | 1 745 | |
| Mashina haisht | | | 1,745 mm | |
| Machine height | | | | W/ 2 2E0 v D 1 400 mm |
| Machine height Required floor surface area Machine weight | | | W 2,260 x D 1,433 mm 3,220 kg | W 2,350 x D 1,433 mm 3,650 kg |

| Control unit | | BNA-42CY5 | BNA-42SY5 |
|---|---|--|--|
| Control axis | | FS.0i-TF PLUS | |
| HD1 | | X1, Z1, Y1, C1, E1 (Turre A1 (Rotary tools) | (Turret), A1 (Rotary too During superimposed operation: X1, Z1, Y1, C1, E1 (Turret) |
| HD2 | | | A1 (Rotary tools) During superimpose |
| Feed axis abso | plute position detector | X. Z1. Y1 | operation: Z2, C2, X1,Z1,Y1,B |
| Min. set un Interpolation | it | 0.001 mm/0.001 deg. | 1 |
| Positioner | | G00 | |
| Linear inte | | G01 | |
| Circular int Dwell | erpolation | G02, G03 (multiple qua G04 | adrants available) |
| Threading | | G32 | |
| Multiple th | nreading | G33 | |
| Feed function | | | |
| Cutting fee Per minute fe Manual ha Reference | ding override d speed override eed and per rotation indle feeding point return point return chuck | 0 to 100% (10% increa 0 to 150% (10% increa G98/G99 x1, x10, x100 G28 C27 | |
| | nce point return | | |
| Program inp | | | |
| Tape code | 1 | EIA/ISO auto-detection | |
| | commands | X,Z,Y,C | X,Z,Y,C,B |
| | al commands able data input | U, W, V, H G10 | |
| | system settings | G50 | |
| | coordinate system | | |
| | prage and editing | | 1 Millionte (Truss anatoms test |
| | torage capacity egistered programs | 400 | 1 Mbyte (Two system tot 800 (Two system tot |
| | supplementary | | |
| | ntary functions | | |
| | ipheral speed contro | | |
| | ol compensation | | |
| Tool functi | ons | T4 digits command Upper 2 digits: Tool se Lower 2 digits: Wear of | lection & Geometry offs offset |
| | is compensation | G40,G41,G42 | |
| | | | |
| Operating f | unctions | M01 | |
| Operating for Optional st | unctions top | M01 0 to 1.260 mm/min | |
| Operating f | unctions top Ig | M01 0 to 1,260 mm/min | |
| Operating for Optional s Jog feedin Input/Output PC card slo | unctions top ig ut interface ot and USB mem | 0 to 1,260 mm/min | |
| Operating fr Optional s Jog feedin Input/Outpu PC card sl Automatic o | unctions top Ig ut interface ot and USB mem operation | 0 to 1,260 mm/min hory slot | |
| Operating fr Optional s Jog feedin Input/Outpu PC card sl Automatic o One-cycle, | unctions top ig ut interface ot and USB mem operation /Continuous oper | 0 to 1,260 mm/min hory slot ration, Single block, Blo | ck delete, Machine lock |
| Operating fr Optional s Jog feedin Input/Outpu PC card sl Automatic o One-cycle, | unctions top ig ut interface ot and USB mem operation /Continuous oper | 0 to 1,260 mm/min hory slot | |
| Operating fi Optional s Jog feedin Input/Outpu PC card sli Automatic c One-cycle/ Optional b Other 10.4° color L0 | unctions top ig ut interface ot and USB mem operation /Continuous oper lock skip, Dry run CD, Supporting multi | 0 to 1,260 mm/min nory slot ration, Single block, Blo n, Feed-hold, Optional s ple languages, Decimal-point | stop |
| Operating fr Optional s Jog feedin Input/Outpu PC card sk Automatic o One-cycle, Optional b Other 10.4° color L0 Memory p Standard No | unctions top g tr interface ot and USB mem operation /Continuous oper lock skip, Dry ru CD, Supporting multi rotection, AC dig C functions | 0 to 1,260 mm/min nory slot ration, Single block, Blo n, Feed-hold, Optional s ple languages, Decimal-point jital servos, etc. | stop input, Manual pulse generator |
| Operating fr Optional s Jog feedin Input/Outpu PC card slid Automatic c One-cycle, Optional b Other 10.4* color L(Memory p Standard Nt Chamfering | unctions top g at interface ot and USB men poperation /Continuous oper lock skip, Dry run CD, Supporting multi rotection, AC dig C functions /corner R, Backgro | 0 to 1,260 mm/min nory slot ration, Single block, Blo n, Feed-hold, Optional s ple languages, Decimal-point jital servos, etc. und editing, Operating tin | input, Manual pulse generator ne/Number of parts display |
| Operating for Optional s Jog feedim Input/Outpu- PC card sk Automatic of One-cycle, Optional b Other 10.4* color L0 Memory p Standard N0 Chamfering Canned cor | unctions top g ut interface ot and USB men opperation (Continuous opei lock skip, Dry rur CD, Supporting multi rotection, AC dig C functions C functions /corner R, Backgro mposite cycles (G7 | 0 to 1,260 mm/min nory slot ration, Single block, Blo n, Feed-hold, Optional s ple languages, Decimal-point jital servos, etc. und editing, Operating tin 0 to G76), Spindle synchro | stop input, Manual pulse generator |
| Operating for Optional s Jog feedin Input/Outpu PC card sli Automatic of One-cycle, Optional b Other 10.4° color L0 Memory p Standard NU Chamfering Canned cor Spindle rig | unctions top g g t it interface ot and USB mem opperation (Continuous opee lock skip, Dry ruu CD, Supporting multi rotection, AC dig C functions (cormer R, Backgro prosite cycles (G7 id tapping (Main | 0 to 1,260 mm/min nory slot ration, Single block, Blo n, Feed-hold, Optional s ple languages, Decimal-point jital servos, etc. und editing, Operating tin 0 to G760, Spindle synchra and sub (SY only)) | itop input, Manual pulse generator ne/Number of parts display onization function (SY only) |
| Operating for Optional s Jog feedim Input/Outpu PC card sli Automatic d One-cycle, Optional b Other 10.4° color L0 Memory p Standard Ni Chamfering Canned cor Spindle rig Cylindrical | unctions top g ut interface ot and USB mem yperation /Continuous opel lock skip, Dry rur CD, Supporting multi rotection, AC dig /corner R, Backgro mposite cycles (G7 gid tapping (Main interpolation, Cus | 0 to 1,260 mm/min nory slot ration, Single block, Blo n, Feed-hold, Optional s ple languages, Decimal-point jital servos, etc. und editing, Operating tin 0 to G76), Spindle synchr and sub (SY only)) tom macro B, Canned d | input, Manual pulse generator ne/Number of parts display |
| Operating fn Optional s Jog feedin Input/Outpu- PC card sla Automatic c One-cycle, Optional b Other 10.4° color Lf Memory p Standard Nt Chamfering Canned cor Spindle rig Cylindrical Tool service | unctions top g ut interface ot and USB mem yperation /Continuous opel lock skip, Dry rur CD, Supporting multi rotection, AC dig /corner R, Backgro mposite cycles (G7 gid tapping (Main interpolation, Cus | 0 to 1,260 mm/min nory slot ration, Single block, Blo n, Feed-hold, Optional s ple languages, Decimal-point jital servos, etc. und editing, Operating tin 0 to G76), Spindle synchr and sub (SY only)) tom macro B, Canned d ent, Superimposition co | itop input, Manual pulse generator ne/Number of parts display onization function (SY only) rilling cycles (G80 to G86) |
| Operating fr Optional s Jog feedin Input/Outpu PC card sil Automatic C One-cycle, Optional b Other 10.4" color LC Memory p Standard Nit Chamfering Canned cor Spindle rig Cylindrical Tool service | unctions top g it interface ot and USB men yperation /Continuous oper lock skip, Dry rur CD, Supporting multi rotection, AC dig /comer R, Backgro mposite cycles (G7 jid tapping (Main interpolation, Cus ze life management tal Performance | 0 to 1,260 mm/min nory slot ration, Single block, Blo h, Feed-hold, Optional s ple languages, Decimal-point jital servos, etc. und editing, Operating tin 0 to G76), Spindle synchr and sub (SY only)) tom macro B, Canned d ent, Superimposition co Information | itop input, Manual pulse generator ne/Number of parts display onization function (SY only) rilling cycles (G80 to G86) ntrol function (SY only) |
| Operating fn Optional s Jog feedin Input/Outpu- PC card sla Automatic c One-cycle, Optional b Other 10.4° color Lf Memory p Standard Nt Chamfering Canned cor Spindle rig Cylindrical Tool service | unctions top g ut interface ot and USB mem yperation /Continuous opel lock skip, Dry rur CD, Supporting multi rotection, AC dig /corner R, Backgrc mposite cycles (G7 jid tapping (Main interpolation, Cus ze life managem tal Performance | 0 to 1,260 mm/min nory slot ration, Single block, Blo n, Feed-hold, Optional s ple languages, Decimal-point jital servos, etc. und editing, Operating tin 0 to G76), Spindle synchr and sub (SY only)) tom macro B, Canned d ant, Superimposition co Information BNA-42CY5 | itop input, Manual pulse generator ne/Number of parts display onization function (SY only) rilling cycles (G80 to G86) ontrol function (SY only) BNA-42SY5 |
| Operating fn Optional s Jog feedin Input/Outpu- PC card sla Automatic c One-cycle, Optional b Other 10.4° color Lf Memory p Standard Nt Chamfering Canned cor Spindle rig Cylindrical Tool service | unctions top g it interface ot and USB mem yperation /Continuous oper lock skip, Dry rur CD, Supporting multi rotection, AC dig comer R, Backgro mposite cycles (G7 jid tapping (Main interpolation, Cus ze life managem tal Performance item Standby power | 0 to 1,260 mm/min nory slot ration, Single block, Blo n, Feed-hold, Optional s ple languages, Decimal-point jital servos, etc. und editing, Operating tin 0 to G76), Spindle synchr and sub (SY only)) tom macro B, Canned d ant, Superimposition co Information BNA-42CY5 0.591 kW | itop input, Manual pulse generator ne/Number of parts display onization function (SY only) rilling cycles (G80 to G86) ntrol function (SY only) |
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