

MC20IV

Multi Station Machining Cell



Machine Specification

Item	MC20 IV (MC20-3M4)
Chuck size	4-inch chuck
Max. through spindle workpiece diameter	20 mm dia.
Max. workpiece length	70 mm
Max. drilling diameter with the spindle	7 mm dia.
Max. tapping diameter with the spindle (Cutting tap)	M6
Main spindle speed	Max. 8,000 min ⁻¹ (differs depending on the chuck type)
Gang rotary tools	
Max. drilling diameter	5 mm dia.
Max. tapping diameter (Cutting tap)	M5
Main spindle speed	Max. 8,000 min ⁻¹
Number of tools to be mounted (standard machining specification)	per module: 5
Turning tools	2
Cross drilling tools	3
Number of tools to be mounted (turning / cross machining / end-face machining specification)	per module: 6
Turning tools	2
Cross drilling tools	2
End-face drilling tools	2
Number of tools to be mounted (full tooling capability)	per module: 9
End-face sleeve	4
Cross drilling tools	1
End-face drilling tools	4
Tool size	
Tool (gang tool post)	□ 13 mm
Sleeve	19.05 mm dia., 20 mm dia.
Rapid feed rate	
X axis	32 m/ min
Y axis	32 m/ min
Z axis	32 m/ min
A axis	40 m/ min
Motors	
For spindle (built-in motor)	2.2/3.7 kW
For rotary tools on gang tool post	0.75 kW
For coolant oil	0.18 kW × 2, 0.25kW × 2
For medium-pressure coolant	0.75 kW × 3
Loader axis motor	0.2 kW × 2
Center height	1,060 mm
Rated power consumption	22 kVA
Full-load current	88 A
Main breaker capacity	125 A
Pneumatic unit / Required pressure	0.5 MPa
Required flowrate	310 NI/min
Machine size	W 3,510 × D 2,110 × H 2,000 mm
Weight	5,000 kg

Main standard accessories

Main spindle chucking unit, Spindle cooling unit, Emergency stop box
Machine relocation detector, Gang rotary tool driving unit
Workpiece loading unit set (for Module 1 and Module 4)
Door lock

Special accessories

Work pusher, Pneumatic unit for checking spindle seating
Workpiece loading unit set (for Module 2 and Module 3)
Pneumatic unit for chuck air blow
Pneumatic unit for spindle rear air blow
Pneumatic unit for workpiece hand air blow
Pneumatic unit for tool air blow, Coolant unit (scraping type)
Coolant flow rate detector, Medium-pressure coolant unit
Foot switch, Tablet, 3-color signal tower
Automatic fire extinguishing unit, Fire damper
Material feeder interface (with cut-off check function), LfV

Standard NC functions

Preparing operation functions, Background edit function
On-machine program check function, High-speed program check function
Axis feed overlap function, Spindle speed change detector
Chamfering/Corner R, Nose radius compensation, Circular interpolation
Canned cycle for threading, Canned cycle for composite turning
Product counter indication (8 digits), Obstruction check function
Program storage capacity: 160m (Approx. 64KB)
15-inch touch panel
Automatic power-off function
Input/output I/F (RS232C, CompactFlash, USB)

Special NC functions

Program storage capacity: 1200 m (Approx. 480KB)
User macros, Submicron commands
Synchronized tapping function, Canned cycle for drilling
Constant peripheral speed control function, Differential speed rotary tool function
Tool life management I, Tool life management II, Milling interpolation function
External memory program driving, Polygon function
Hob function, Helical interpolation function, Inclined helical interpolation function
Geometric command function, Variable lead threading
Arc threading, 2-System simultaneous threading III
Coordinate rotation command function, User macro G-code call
High-speed synchronized tapping function, Optional block skip (9 sets)

CITIZEN MACHINERY CO., LTD.

CITIZEN

JAPAN	CITIZEN MACHINERY CO.,LTD. 4107-6 Miyota, Miyota-machi, Kitasaku-gun, Nagano-ken, 389-0206, JAPAN	TEL.81-267-32-5901	FAX.81-267-32-5908
SOUTH ASIA / KOREA	CITIZEN MACHINERY CO.,LTD. 4107-6 Miyota, Miyota-machi, Kitasaku-gun, Nagano-ken, 389-0206, JAPAN	TEL.81-267-32-5901	FAX.81-267-32-5908
TAIWAN	CINCOM MIYANO TAIWAN CO.,LTD. 10FL., No.174, Fuh Sing N. Rd., Taipei, TAIWAN	TEL.886-2-2715-0598	FAX.886-2-2718-3133
CHINA	CITIZEN (CHINA) PRECISION MACHINERY CO.,LTD. 10058, XINHUA ROAD OF ZHOUCUN, ZIBO, SHANDONG, PR. CHINA	TEL.86-533-6150560	FAX.86-533-6161379
EUROPE-Germany	CITIZEN MACHINERY EUROPE GmbH Mettinger Strasse 11, D-73728 Esslingen, GERMANY	TEL.49-711-3906-100	FAX.49-711-3906-106
EUROPE-UK	CITIZEN MACHINERY UK LTD 1 Park Avenue, Bushey, WD23 2DA, UK	TEL.44-1923-691500	FAX.44-1923-691599
EUROPE-Italia	CITIZEN MACCHINE ITALIA s.r.l. Via Guglielmo Marconi 47 24040 Comun Nuovo (BG), ITALY	TEL.39-035-877-738	FAX.39-035-876-547
AMERICA	MARUBENI CITIZEN-CINCOM INC. 40 Boroline Road Allendale, NJ 07401, U.S.A.	TEL.1-201-818-0100	FAX.1-201-818-1877

URL:<https://cmj.citizen.co.jp/>

All specifications are subject to change without prior notice. This product is an export control item subject to the foreign exchange and foreign trade act. Thus, before exporting this product, or taking it overseas, contact your CITIZEN machine dealer. Please inform your CITIZEN machine dealer in advance of your intention to re-sell, export or relocate this product. For the avoidance of doubt products includes whole or part, replica or copy, technologies and software. In the event of export, proof of approval to export by government or regulatory authority must be evidenced to CITIZEN. You can operate the machines after the confirmation of CITIZEN. CITIZEN, LfV, MultiStationMachiningCell and Ocean technology is a registered trademark of Citizen Watch Co., Japan.