

CITIZEN

Cincom

B12/16E

Sliding Headstock Type CNC Automatic Lathe



Machine Specification

Item	B12E				B16E			
	I (B12E-1F1)	II (B12E-1F2)	V (B12E-1F5)	VI (B12E-1F6)	I (B16E-1F1)	II (B16E-1F2)	V (B16E-1F5)	VI (B16E-1F6)
Maximum machining diameter (D)	φ12mm				φ16mm			
Maximum machining length (L)	135 mm/1 chucking (60mm/1 chucking with RGB)							
Maximum front drilling diameter	φ6mm							
Maximum front tapping diameter (tap, die)	M6							
Spindle through-hole diameter	φ20mm							
Main spindle speed	12,000min ⁻¹ (8,000min ⁻¹ with RGB)				10,000min ⁻¹ (8,000min ⁻¹ with RGB)			
Max. drilling diameter for the gang rotary tool	—	φ5mm	—	φ5mm	—	φ5mm	—	φ5mm
Max. tapping diameter for the gang rotary tool	—	M4	—	M4	—	M4	—	M4
Spindle speed of the gang rotary tool	—	4,500min ⁻¹	—	4,500min ⁻¹	—	4,500min ⁻¹	—	4,500min ⁻¹
Max. chuck diameter of back spindle	—	φ12mm		—	φ16mm		—	
Max. protrusion length of the back spindle workpiece	—	30mm		—	30mm		—	
Maximum protrusion length	135mm	80mm		135mm	80mm			
Max. drilling diameter in back machining process	—	φ5mm		—	φ5mm			
Max. tapping diameter in back machining process	—	M3		—	M3			
Back spindle speed	—	6,000min ⁻¹		—	6,000min ⁻¹			
Number of tools to be mounted	9	11	13	15	9	11	13	15
Turning tools on the gang tool post	5 (8 ^{OP})	5	5 (8 ^{OP})	5	5 (8 ^{OP})	5	5 (8 ^{OP})	5
Cross rotary tools	—	2 (3 ^{OP})	—	2 (3 ^{OP})	—	2 (3 ^{OP})	—	2 (3 ^{OP})
Tools for front drilling	4	4	4	4	4	4	4	4
Tools for back drilling	—	—	4	4	—	—	4	4
Tool size								
Tool (gang tool post)	□10×120mm or 60mm							
Sleeve	φ20mm (φ19.05mm ^{OP})							
Chuck and bushing								
Main spindle collet chuck	FC096-M				FC261-M			
Back spindle collet chuck	—	FC096-M-K		—	FC261-M-K		—	
Rotary tool collet chuck	—	ER8	—	ER8	—	ER8	—	ER8
Chuck for drill sleeves	ER8, ER11							
Guide bushing	WFG541-M / WFG551-M				WFG660-M			
Rapid feed rate								
X and Y axes	21m/min							
Z axis	15m/min							
A2 axis	—	15m/min		—	15m/min			
Motors								
Spindle drive	2.2/3.7kW							
Tool spindle drive	—	0.5kW	—	0.5kW	—	0.5kW	—	0.5kW
Back spindle drive	—	1.0kW		—	1.0kW			
Coolant oil	0.18kW							
Center height	1000mm							
Rated power consumption	3.3kVA		5.2kVA		3.3kVA		5.2kVA	
Full-load current	18A		20A		18A		20A	
Main breaker capacity	30A							
Air pressure and air flow rate for pneumatic devices	0.5MPa-30NI/min (Max.50NI/min)							
Weight	1100kg		1150kg		1100kg		1150kg	

Standard accessories

Main spindle chucking device
 Back spindle chucking device *only V & VI
 Workpiece separator *only I & II
 Coolant device (with level detector)
 Lubricating oil supply unit (with level detector)
 2 Gang rotary tool driving devices *only II & VI
 Machine relocation detector
 Door lock function

Special accessories

Fixed guide bushing device
 Rotary guide bushing device
 Coolant flow rate detector
 Signal lamp
 Lighting
 End-face rigid tapping device *only I & II
 Back spindle long workpiece device *only V & VI
 Knock-out jig for through-hole workpiece *only V & VI

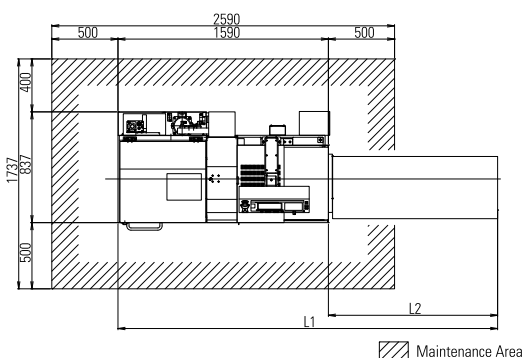
Standard NC functions

NC unit dedicated to the B1216E series
 8.4 inch color liquid crystal display (LCD)
 Operating time display
 Preparation functions
 Main spindle speed change detector
 Corner chamfering / rounding function
 Canned drilling cycle
 Nose R compensation function
 Direct input of on-drawing dimensions
 Main spindle constant surface speed control
 Program storage capacity : 40m (approx.16KB)
 Tool offset pairs : 64 pairs
 Product counter indication (up to 8 digits)
 Automatic power-off function
 Multiple repetitive cycle
 User macro
 Continuous threading function
 On-machine program check function
 Program prior analysis function

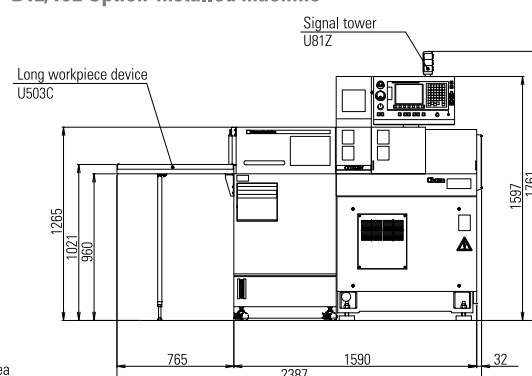
Special NC functions

Program storage capacity 2500m (approx.1MB)
 Sub-micron command function
 Front end-face rigid tapping function
 Tool spindle rigid tapping function *only II & VI
 Tool spindle end-face rigid tapping function *only I & II
 Hobbing and polygon machining function (A) *only I & II
 Hobbing and polygon machining function (B) *only II & VI
 Front-back simultaneously machining function *only V & VI
 Main spindle indexing at 1° intervals *only II & VI
 Simplified Z-A2 axes synchronization function *only V & VI
 Tool life management

B12/16E Standard machine layout



B12/16E Option-installed machine



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