

CITIZEN

Miyano

**BNA42**

Fixed Headstock Type CNC Automatic Lathe



The BNA series packs sophisticated functions and high accuracy into a space-saving compact body.

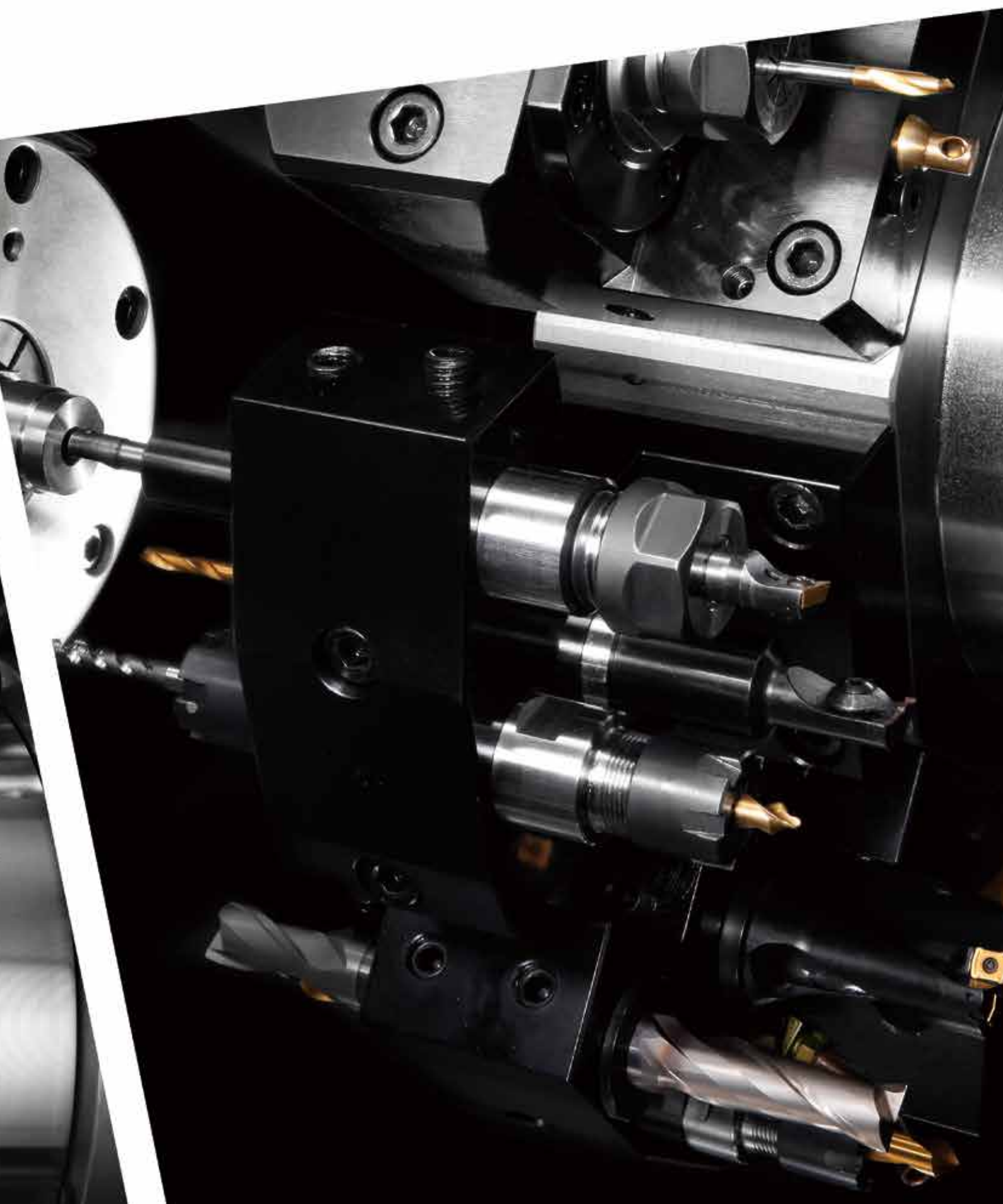
The BNA series aims to set the new standard for machines for cutting bar stock, based on the concept of "space savings and sophisticated functions".

The BNA42S enables back machining with its 2 spindles and 1 turret and combines a high level of basic performance with convenience of use.

The BNA42DHY achieves further shortening of cycle times by adding a compact sub-turret to provide superimposition machining and other forms of simultaneous machining.

The BNA series offers high performance in compact space, round-the-clock stability and accuracy; and ease of use for fast set-ups and quick changeovers.







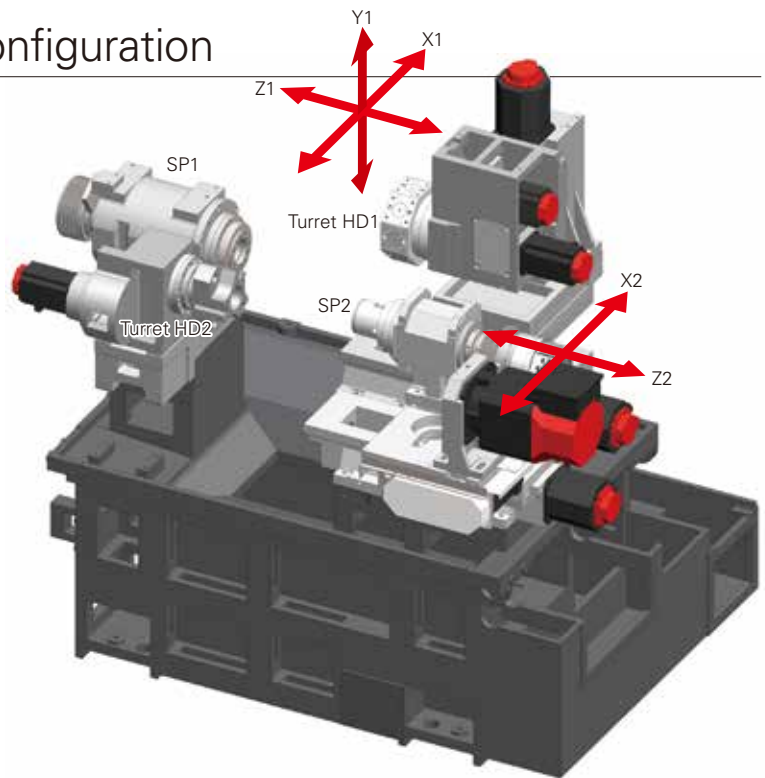
# DHY



## Basic Construction and Axis Configuration

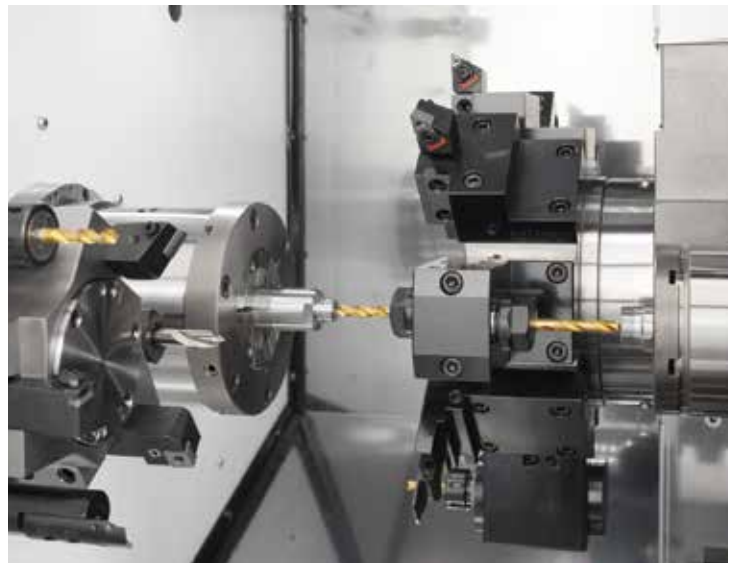
### High-rigidity Scraped Slideways Support Powerful Cutting

High-rigidity scraped slideways are used on all axes except for X axis of SP2. These slideways with face contacts have exceptional rigidity and damping characteristics, achieve powerful cutting, and help to prolong the lives of cutting tools.



## Y-axis Function and Sub-turret

The combination of the Y-axis function incorporated in the main turret (HD1) and the compact 6-station sub-turret (HD2) can achieve further reductions in machining time through overlap processing and other forms of machining performed simultaneously on the main and sub spindles.

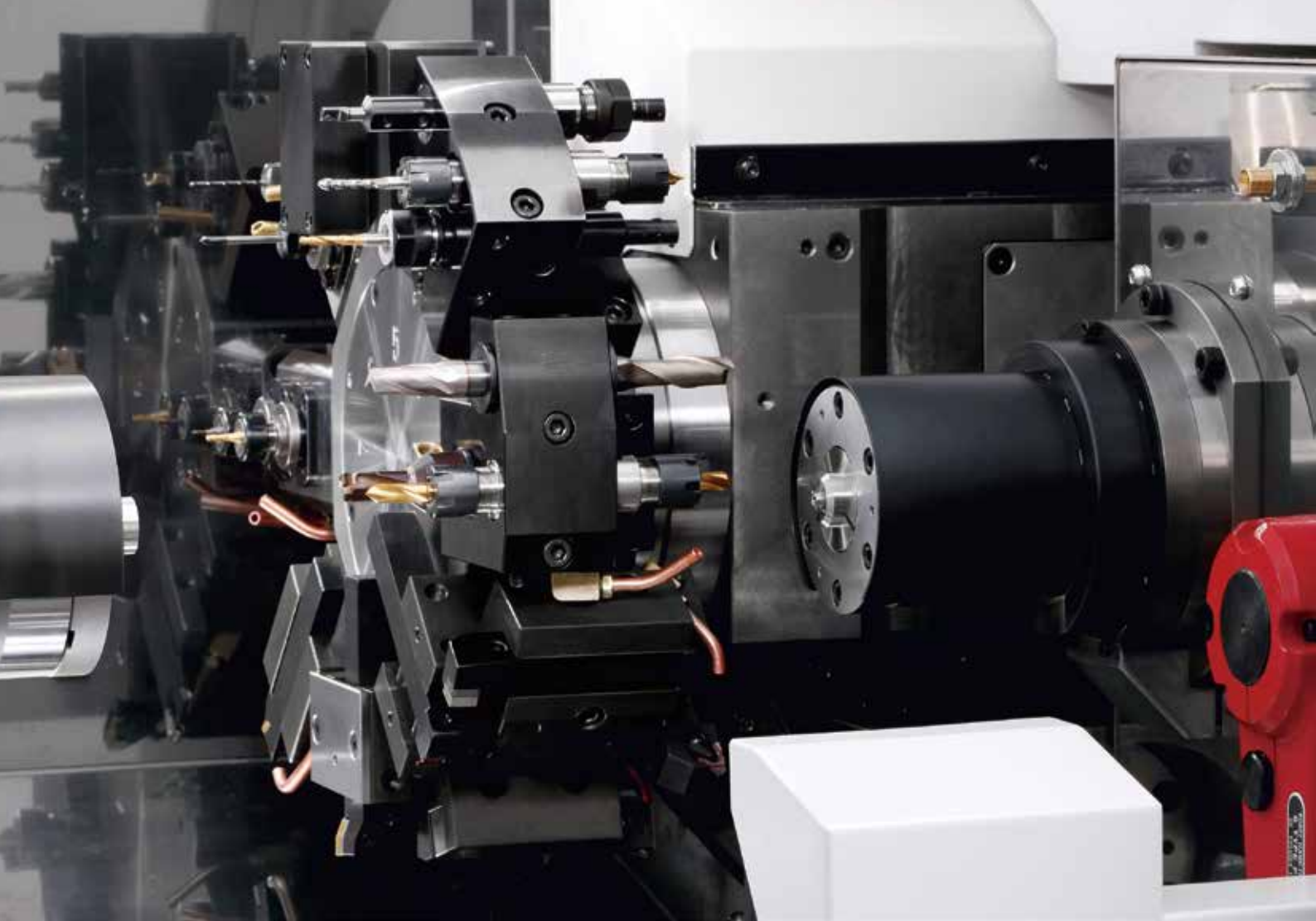


Simultaneous front/back machining

## Power Chuck on Back Spindle

In addition to its 5-inch power chuck on the front spindle, the back spindle can also mount a 4-inch power chuck for flexible accommodation of forged parts.





S

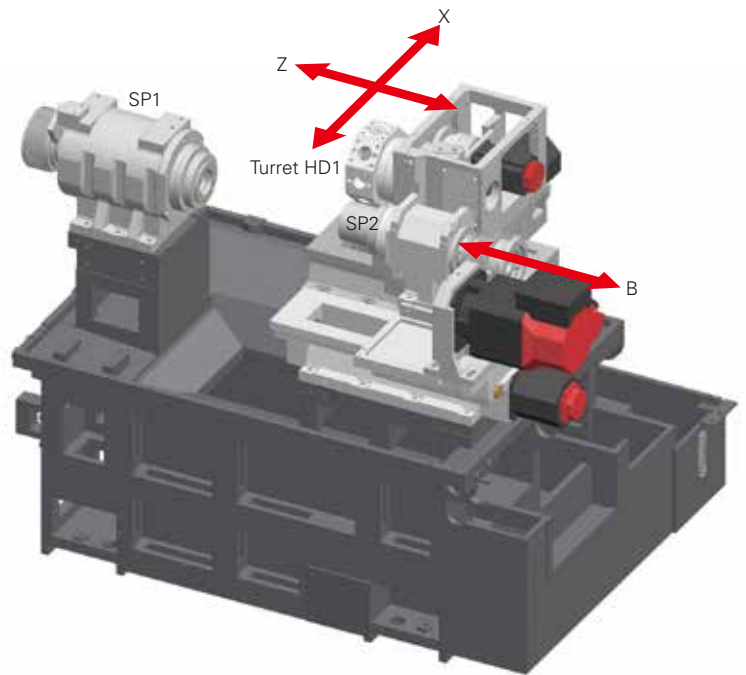


# Basic Construction and Axis Configuration

## Stable, accurate and strong

The machine bed has a platform structure with traditional square, hand-scraped slidways for assured accuracy and long tool life.

The unit mounting faces are not distorted by the effects of heat, and even if the units are subject to thermal expansion they are all displaced in the same direction (perpendicular to their mounting faces), minimizing relative deviations between the workpiece and cutting tools.



## Sub-spindle Enables Complete Machining

The S model delivers increased versatility with the provision of a sub-spindle for pick-off and back machining. Multiple tool holders enable the use of many tools for unrivalled flexibility in a bar turning machine of this compact size.

All BNA models incorporate the latest control technology for reduced non-cutting time and improved productivity.

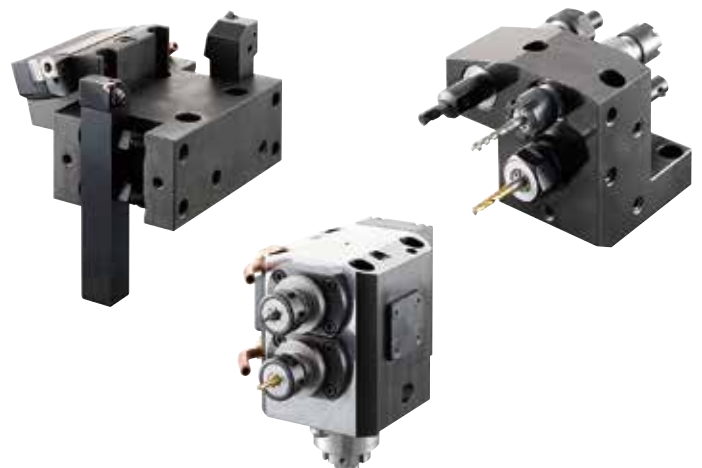


Back machining using tools installed in a triple sleeve holder

## Extensive Tool Range

The 8 station turret with half indexing in combination with multi tool holders helps to standardize set-ups and enable fast changeover to a different workpiece.

With double, triple and even quad tool holders you are assured of sufficient tool positions even for complex workpieces.

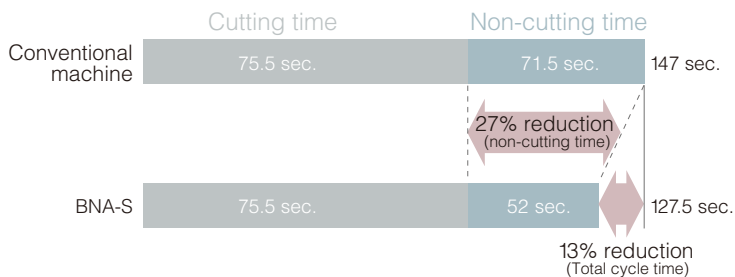


# Substantial Reduction in Non-cutting Time

Miyano's unique control system cuts non-cutting time by 27% (compared to previous model), achieving a 13% reduction in terms of total cycle time.

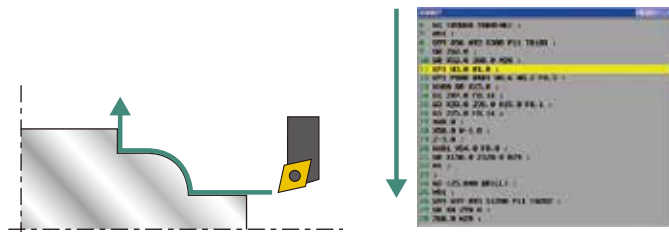


Workpiece used for data measurement



# Program handwheel (DHY)

Easy prove-out is assured using the handwheel for program prove-out.



# Options



**Part catcher**  
Catches workpieces without damaging them and transfers them to the part conveyor.



**Part conveyor**  
Transports workpieces received from the part catcher to outside the machine.

**Chip conveyor**  
Ejects chips smoothly. Various types are available to suit the application.



**Bar feeder**  
A range of barfeeders is available for short or long bars.



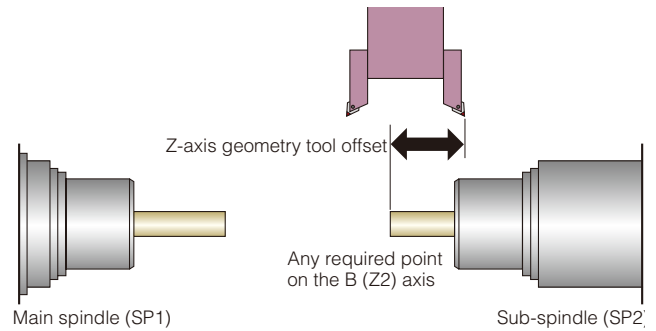


# Support Software

## Arbitrary Point Control by B (Z2) axis

The approach for secondary operation can be made at any required point on the B (Z2) axis, so there is no need to consider the position of the B (Z2) axis when setting the offset for tools that operate on the sub-spindle (SP2).

Wasted motion is eliminated, and a smooth transition from primary to secondary operation can be made at turret index, helping to reduce cutting time.



## B (Z2) axis independent commands (S Type)

B (Z2) axis independent multiple block commands can make it possible for B (Z2) axis programs input in advance to run independently from the main program.

B (Z2) axis commands can contain maximum 10 blocks.

### Machining program example

```
O1000 ;
G591 ;           G591 : B-axis program registration start
G0 B-260. ;     B-axis forward
G01 B-290.43 F4000. ; B-axis positioning
M408 ;         M408 : M403 completion confirmation
M118 ;         M118 : SP2 chuck close
G590 ;         G590 : B-axis program registration end
.
.
N8 (CUT OFF) M91 ; M91 : SP1 position coder selection
G28U0 ;       X-axis origin point return
M291 ;       M291 : B-axis program execution start
T0808M117 ;   Turret selection, M117 : SP2 chuck open
G0G97Z0.S2000M403P11 ; Z-axis positioning,
M403SP1&2 Synchronous forward
Immediate completion
X23.0 ;       X-axis positioning
M290 ;       M290 : B-axis program execution
completion confirmation
G506K0.05F500 ; G506 : B-axis incremental move
G99G1X-1.0 ;  Cut off
G0X50.0M205 ; M205 : SP1&2 Synchronous stop
.
.
```

Synchronous Execution from M291

## Machining Support Screens

You can call up the various support screens with a single touch, greatly improving working efficiency.



Machining data

Entering the machining length and position of the cut-off here makes it easier to measure geometry offsets and to set tools.



Tool setting

Used to measure geometry offsets. It can also be used for tool mounting support, to ensure that the overhang of all tools is fixed at a constant value.



Tool counter

Informs you of the timing (count-up) for tool changes in accordance with the set tool counter stop value. You can also enter wear offsets.



Cycle time

Allows you to measure the cutting time, non-cutting time and running time in each cycle.



Total & preset counter

Used to set the stop value for the product counter and to reset the count value.



Power consumption monitor

Allows monitoring of the power consumption per cycle time, day, or month.



Electromagnetic switch maintenance

Used to set the ON/OFF usage count range for electromagnetic switches for notifying the replacement interval for these switches.



Start condition

Displays information on the start conditions for automatic running.



Spindle and revolving tool unit

Allows you to set the speed range (in manual operation) of the spindle and revolving tools, and to set the spindle override.



Maintenance

Used to access maintenance settings.



Tool monitor (option)

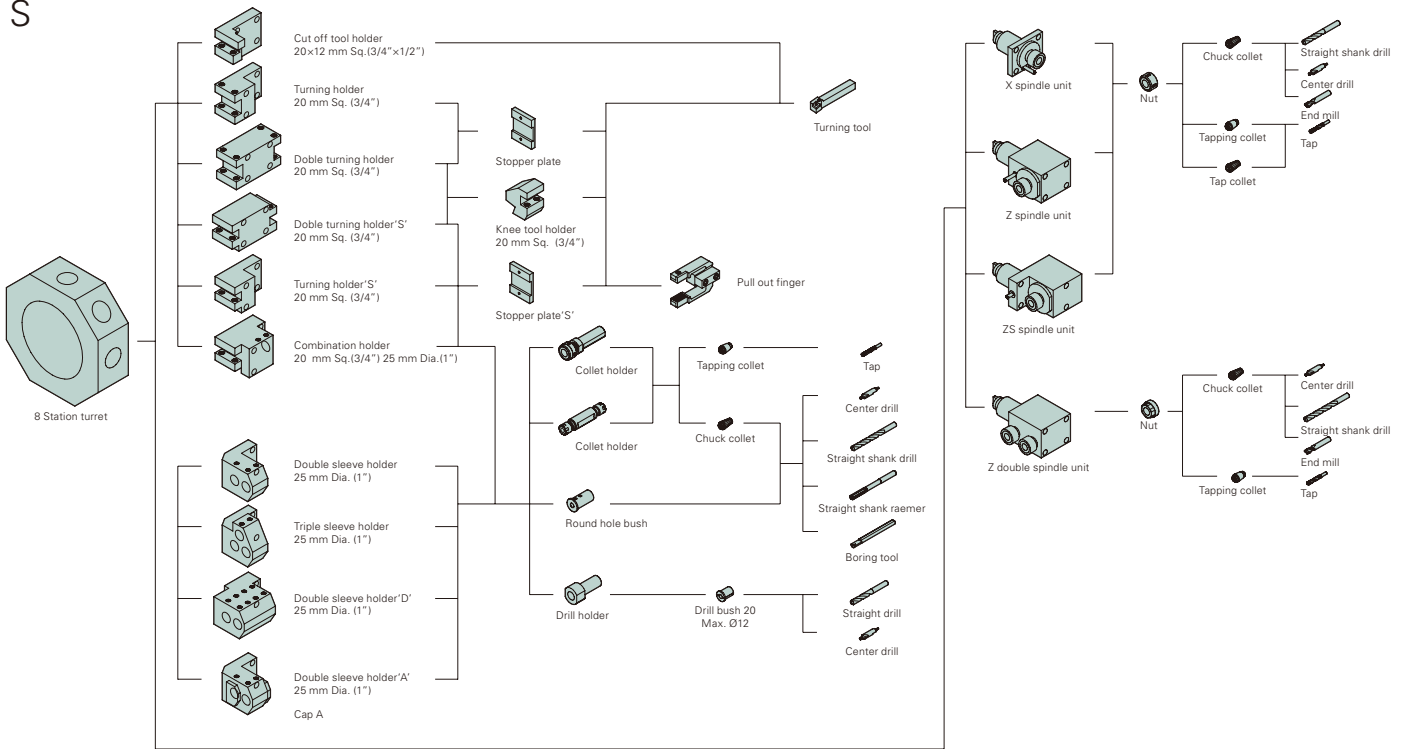
Allows you to monitor tool wear and breakage by checking the current state of the machining and status of the cutting tools in terms of numerical values based on test data.

Availability of machining support software for each machine model

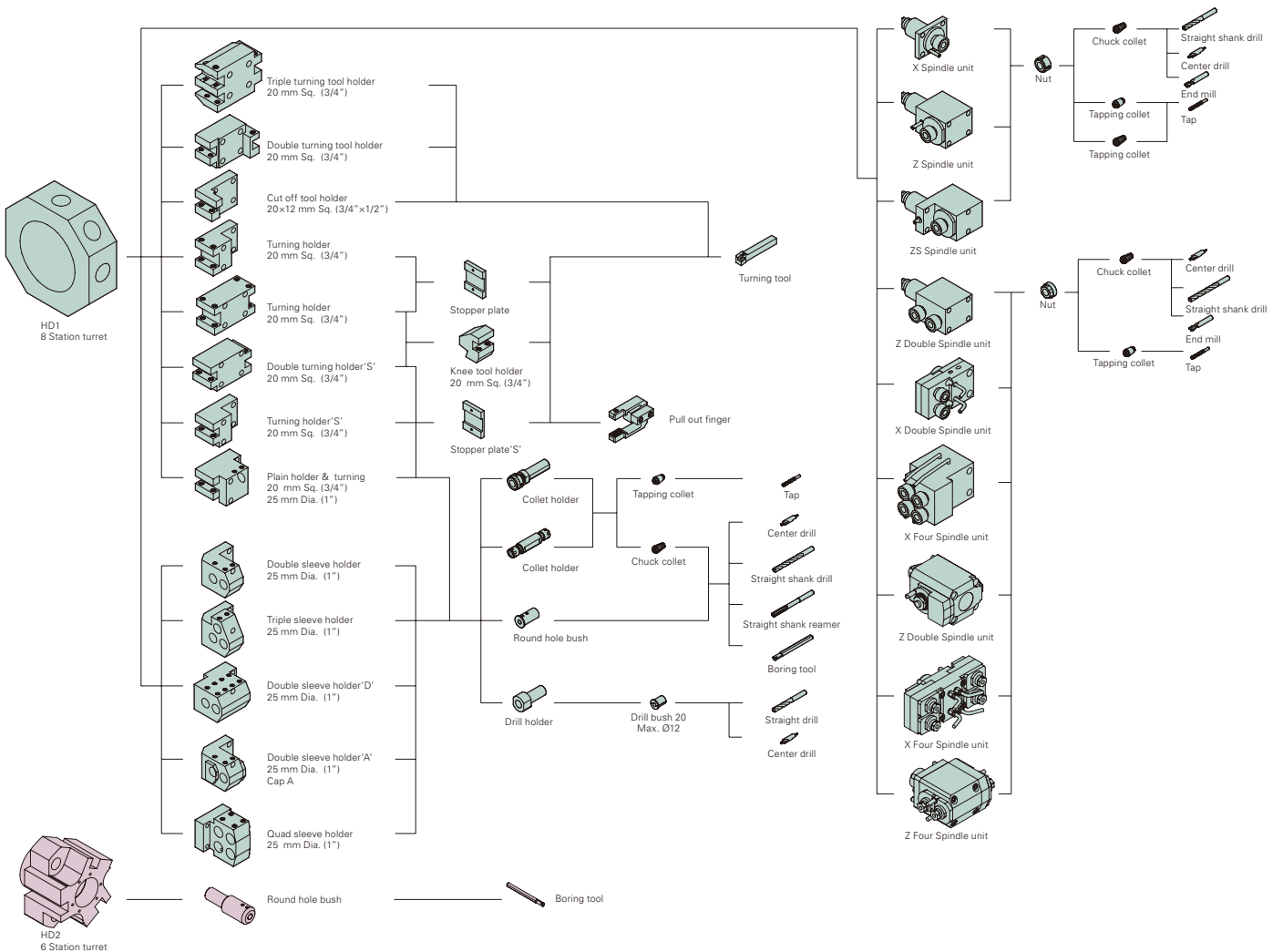
	DHY2	S2
Machining data	✓	✓
Tool setting	✓	✓
Tool counter	✓	✓
Cycle time	✓	✓
Automatic running monitor	✓	✓
Start condition	✓	✓
Total&preset counter	✓	---
Power consumption monitor	✓	---
Electromagnetic switch maintenance	✓	---

# Tooling system

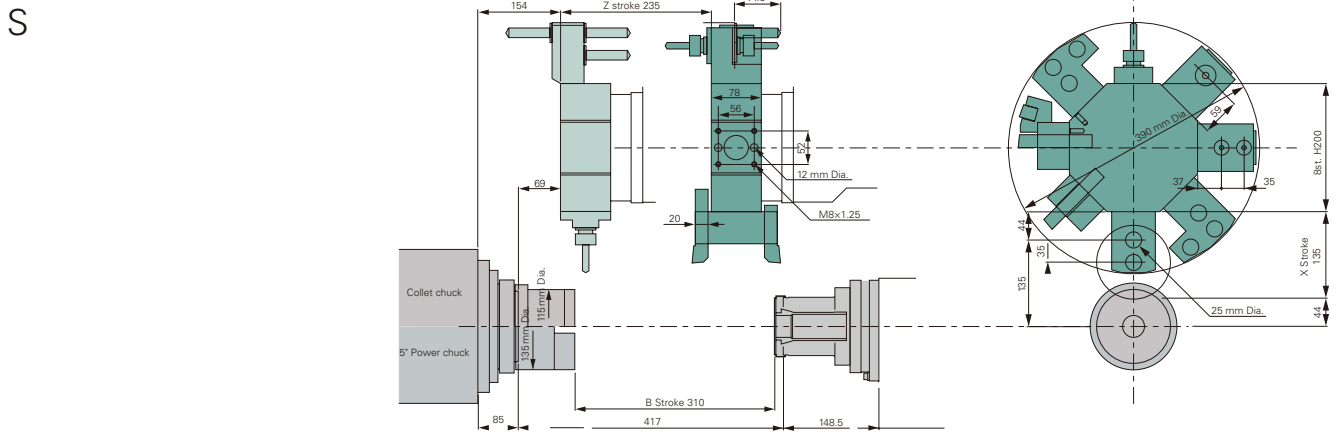
S



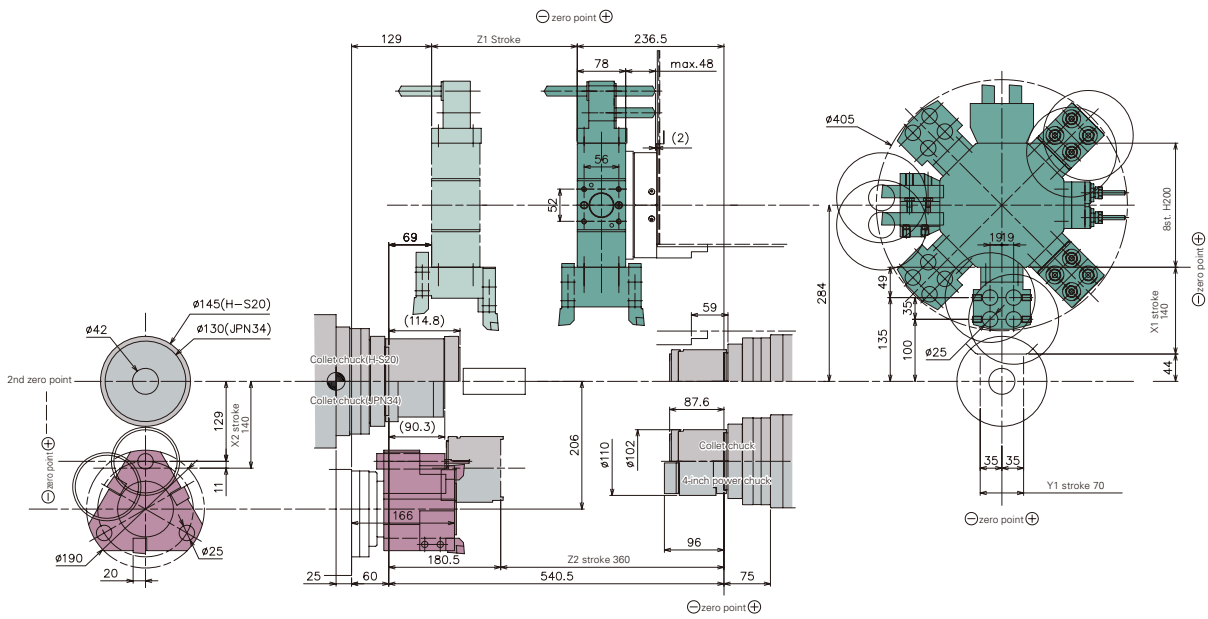
DHY



# Tooling area

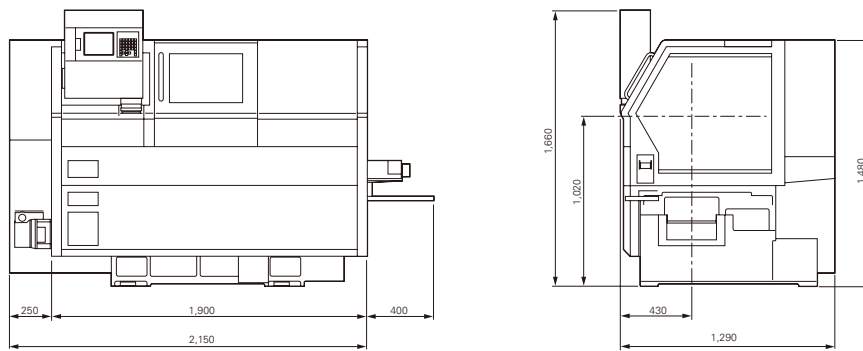


# DHY

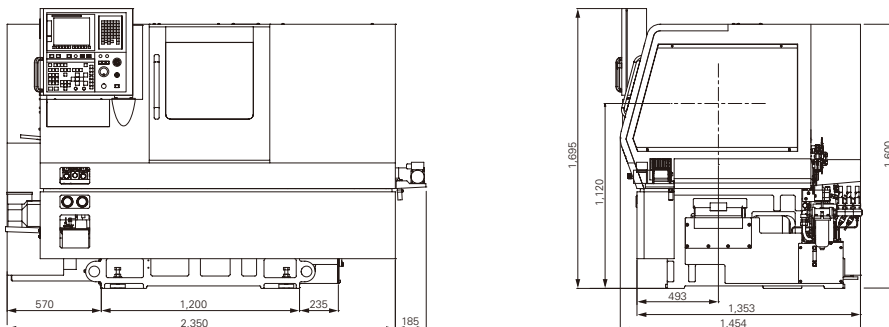


# External view

## S



## DHY



# Machine Specifications

Items	BNA-42S2		BNA-42DHY3	
Machining capacity				
Max. work length	100 mm			
Max. machining diameter of bar work	SP1	42 mm Dia.		42mm
	SP2	34 mm Dia.		
Slide stroke				
Turret slide stroke	X1 axis	135 mm	140 mm	
	Z1 axis	235 mm		
	Y1 axis	—		70 (±35) mm
Spindle slide stroke	X2 axis	—		140 mm
	Z2 axis	—		360 mm
	B axis	310mm		—
Spindle				
Number of spindle	2			
Spindle speed range	SP1	60- 6,000 min <sup>-1</sup>		42mm
	SP2	50- 5,000 min <sup>-1</sup>		
Inner diameter of draw tube	SP1	43 mm Dia.		42mm
	SP2	30 mm Dia.		
Collet chuck type	SP1	Hardinge S20, DIN173E, B&S#22D, JPN34, Hainbuch		42mm
	SP2	DIN173E, B&S#22D, JPN		
Power chuck type	SP1	5" thru-hole chuck		42mm
	SP2	—		
Turret				
Number of turret	1		2	
Type of turret	HD1	8 ST.		42mm
	HD2	—		
Shank height of square turning tool	20 mm Sq.			
Diameter of drill shank	25 mm Dia.			
Revolving tools				
Number of revolving tools	Max.8			
Type of revolving tools	Single Clutch			
Tool spindle speed range	50- 5,000 min <sup>-1</sup>			
Machining capacity	Drill	Max. 10 mmDia.		42mm
	Tap	Max. M6×1 S45C (M8×1.25 Spiral tap and Point tap only)		
Feed rate				
Rapid Feed rate	X1 axis	20 m/ min		42mm
	Z1 axis	20 m/ min		
	Y1 axis	—		
	X2 axis	—		
	Z2 axis	—		
	Baxis	20 m/ min		
Motors				
Spindle drive	SP1(Cs)	7.5/ 5.5 kw (15min./ cont)		42mm
	SP2(Cs)	5.5/ 3.7 kw (15min./ cont)		
Revolving tool drive	2.8/ 1.0 kw			
Coolant pump	0.18 kw			
High pressure coolant drive	1.0/ 0.06 kw (60/ 50Hz)		1.0/ 0.75 kw (60/ 50Hz)	
Power supply				
Capacity	28 KVA		30KVA	
Air supply	0.5 MPa			
Fuse	100 A			
Tank capacity				
Hydraulic oil tank capacity	7L		18L	
Lubricating oil tank capacity	2L			
Coolant tank capacity	165L		175L	
Machine dimensions				
Machine height	1,660 mm		1,700mm	
Floor space	W 2,150 × D1,290 mm		W 2,350 × D1,454 mm	
Machine weight	2,800 kg		3,100 kg	
Optional accessories				
Spindle air blow, Spindle Brake, High pressure coolant, Coolant level switch, Signal tower, Coolant mistcollector, Automatic power shut-off, Chip conveyor, Chip box, Parts catcher, Parts conveyor, RS-232C, 100V				

NC Specification	MIYANO -FANUC 0i-TD
Controlled axis	X, Z, B axis (BNA-S2) X1, Z1, Y, X2, Z2 axis (BNA-DHY2)
Min. input increment	0.001mm (Diameter for X axis), 0.001deg.
Min. output increment	X axis: 0.0005 mm, Z axis: 0.001 mm
Parts program storage capacity	1Mbyte (2560 m Tape length)
Spindle function	Spindle speed S4-digits, Directly specified (G97), Constant Cutting speed control (G96)
Cutting feed rate	F3.4 digit per revolution, F6 digit per minute, directly specified
Cutting feed rate override	0- 150% (in 10% increments)
Rapid traverse rate	X, Z, B axis : 20m/ min (S2) X1, Z1, Z2 axis: 20m/ min Y, X2 axis: 12m/ min (DHY2)
Interpolation	G01, G02, G03
Threading	G32, G92
Canned cycle	G90, G92, G94
Work coordinate setting	Automatic Setting, 64 work coordinate setting by the tool position memory and the geometry offset.
Tool selection and work coordinate settings, and tool wear compensation	Tool selection and work coordinate settings are selected from 1-64 by T AABCC at the specified position for each turret tool wear compensation is selected by BB.
Direct input of tool position	by measured MDI
Input/Output interface	PC card slot
Automatic operation	1 cycle operation/Continuous operation, Single block, Block delete, Machine lock, Optional block skip, Dry run feed hold
Others	8.4" color LCD, No of registered programs: 800, Decimal point input, Manual pulse generator, Memory protect, AC digital servo motor, etc.
NC standard functions	Chamfering/ Corner R, Tool nose R compensation, Constant peripheral speed (G96), Background editing, Programmable data input (G10), Operating time/ Parts No. display, Multiple repetitive canned cycle (G70 -G76) Rigid tap function (Main & sub), Cylindrical interpolation, Custom macro B, Drilling canned cycle (G80 -G86) Tool life management system.

## Environmental Performance Information

		Model	BNA-42DHY3
Basic Information	Energy consumption	Supply voltage	AC 200V ±10%
		Electrical power requirement	28 KVA
		Required pneumatic pressure	0.5 MPa
Environmental Performance Information	Power consumption	Standby power <sup>*1</sup>	0.667 kW (on emergency stop released)
		Power consumption with model workpiece <sup>*2</sup>	0.168 kWh/cycle
		Power consumption value above converted to a CO2 value <sup>*3</sup>	86.184 g/cycle
	Air consumption	Required air flow rate	150 NL/ min (when using air blow)
	Lubricating oil consumption	At power ON	3 cc/15 min
Approach to Environmental Issues	Noise level	Value measured based on JIS	75 dB
	Recycling	Indication of the material names of plastic parts	Detailed in the Instruction Manual <sup>*4</sup>
	Environmental management	We pursue "Green Procurement", whereby we make our purchases while prioritizing goods and services that show consideration for the environment.	

- <sup>\*1</sup> 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).  
<sup>\*2</sup> 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.  
<sup>\*3</sup> This is the value converted in accordance with the CHUBU Electric Power CO2 emissions coefficient (factual emissions coefficient) for 2020 as published by the Ministry of the Environment.  
<sup>\*4</sup> 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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# CITIZEN

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