

CITIZEN

Cincom



Preface

Dear Readers,

Citizen Machinery Europe GmbH has successfully been selling Swiss type lathes and fixed head automatic lathes of the brands Cincom and Miyano all over Germany and in large parts of Europe for many decades. With our 3 locations in Esslingen, Villingendorf and Neuss, we are always personally at your disposal and always in close vicinity throughout Germany to answer your questions regarding sales and other issues. In all service matters, we are there for you in whole of Europe.

Under the Cincom brand, we sell Swiss-type lathes which demonstrate their full power and performance when machining long workpieces and small diameters.

The Miyano brand measures up to all challenges when turning short workpieces in fixed-headstock applications. The machines distinguish themselves by high productivity, quality and precision and grant excellent results in diameter ranges of up to 80 mm.

Our path-breaking LFV Technology as well as laser integration have revolutionized the cutting process. We will continue to work hard on developing new innovations and provide optimum solutions to our customers. With future-oriented products, we look forward to stepping into the future together with you.

Markus Reissig
General Manager Citizen

D25

New innovative control options.

**New sliding headstock automatic lathe –
with double gang tool post at the guide bush.**

The D25 sliding head automatic lathe inspires by its high motor capacity and its large variance of workpieces. It is perfectly suited for fast and complex machining processes. The innovative control unit has been designed in accordance with state-of-the-art standards and is easy to operate. Equipped with double gang tool post and one B axis (type VIII), the D25 sliding headstock type automatic lathe features extremely short machining times hand in hand with maximum productivity. The high number of workpieces of the main and back spindle keeps production cost low and offers versatile machining options – everything on a single machine. As an option, bar material of up to Ø 25 mm can also be machined extending the range of workpieces even more.

Advantages

Up to 59 tools may be mounted.

Grants short machining times.

Highly flexible machining at the main spindle
due to the double gang tool post.

Reduced cycle times thanks to
simultaneous use of several tools.



4.24 m²



Workpiece example

Name Hydraulic component
Material Brass

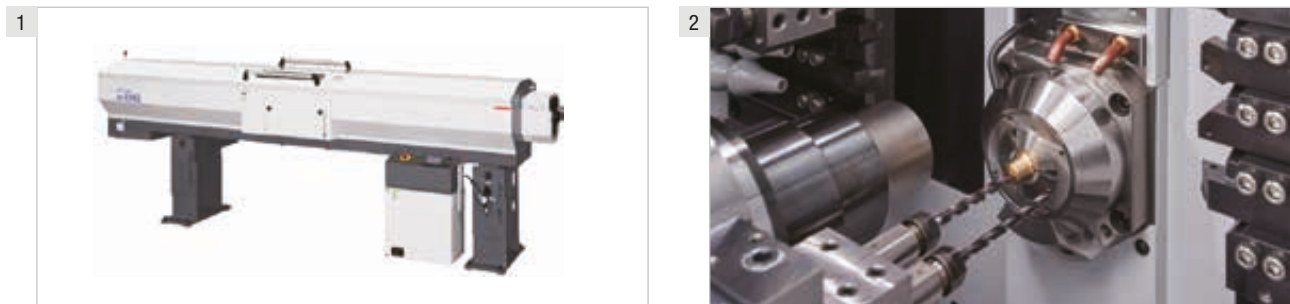


Standard

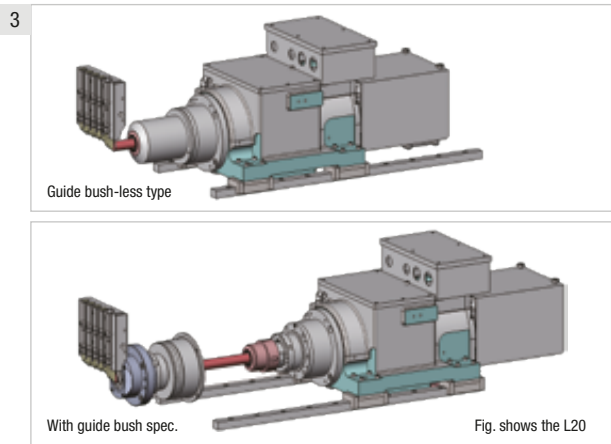


- 1 Control unit
- 2 Pump system
- 3 Workpiece conveyor
- 4 USB slot/SD card slot

Options



- 1 Barfeeder
- 2 Deep hole machining with the opposite tool post
Tools for deep hole machining can be mounted on the opposite tool post. Deep hole machining to 100 mm is possible.
- 3 Ability to use as guide bushing type or guide bushing-less type by switching between them
The guide bushing can be fitted and removed in a quick and simple operation. The machine can be used as an automatic lathe with two roles in a single machine: as a regular guide bushing type automatic lathe when machining long thin workpieces, and as a guide bushing-less automatic lathe when using cold drawn material and to leave short remnant bars.



What is more...
LFV technology as an option



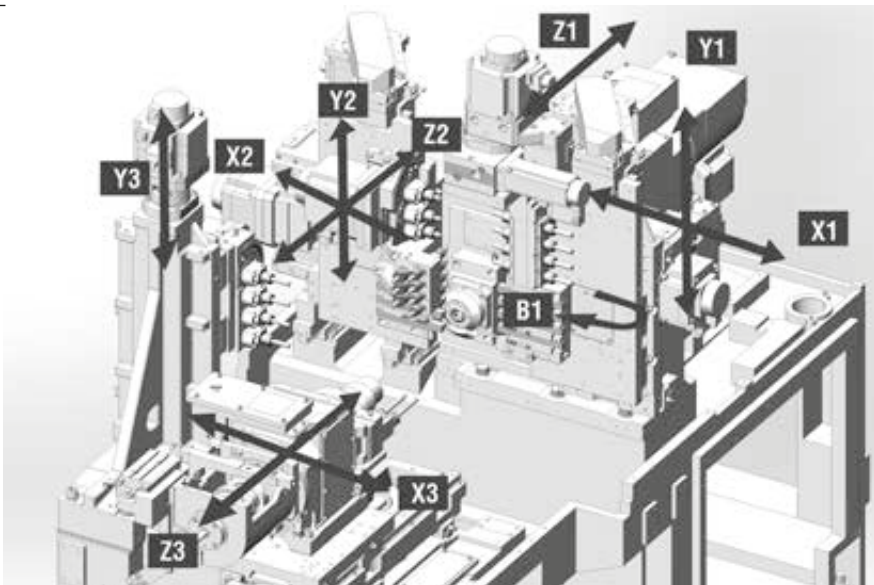
Kinematics

Main spindle
Max. spindle speed: 10,000 rpm

Rotary tools
Max. spindle speed: 9,000 rpm

Back spindle
Max. spindle speed: 10,000 rpm

Rotary tools for back machining
Max. spindle speed: 6,000 rpm



(Model with option)

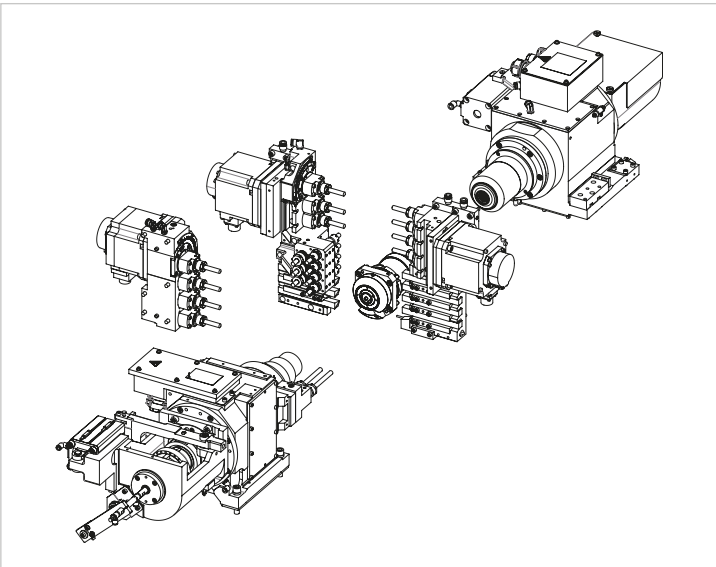
Working area



- 1 Tool layout
- 2 B axis (Type VIII)
- 3 Axis model: type VIII
- 4 Tilt spindle featured on tool post 2 and the back tool post
Tooling that allows manual angle adjustment (a tilt spindle) can be mounted.

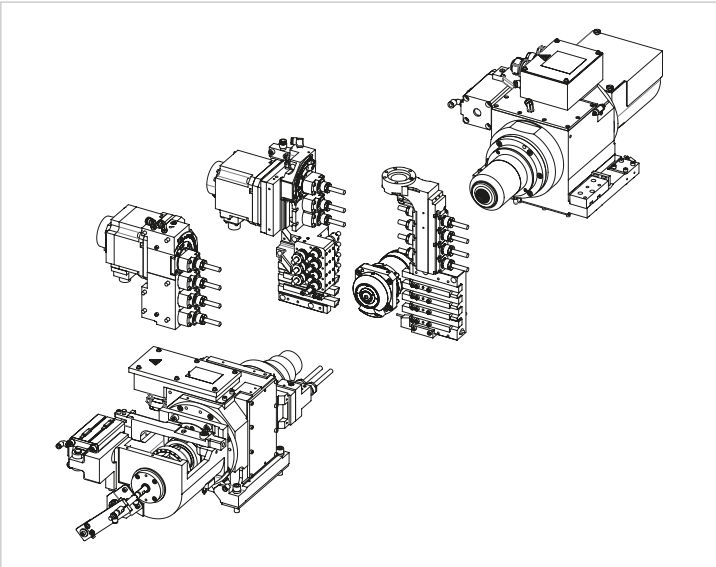


Axis configuration



D25 Type VII

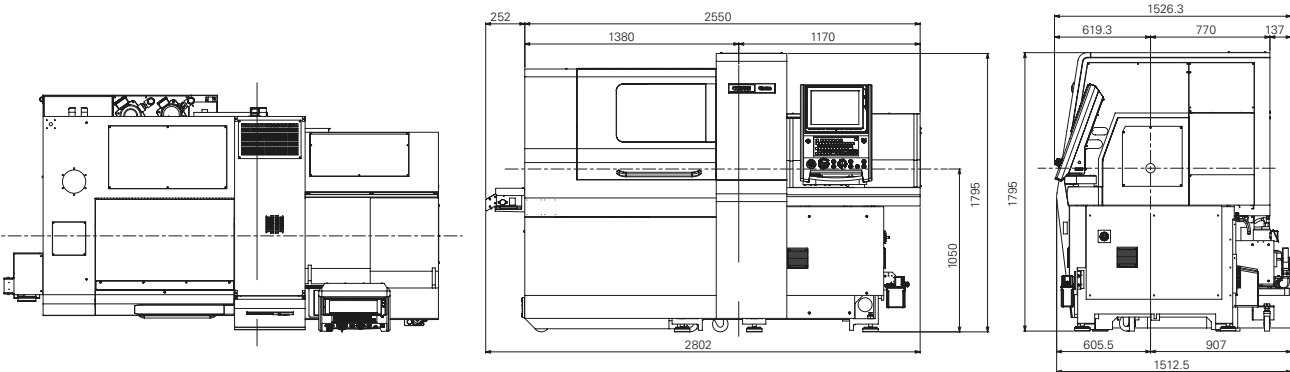
Total of 28 tools + α
Turning tools : 7
Main spindle drilling tools: 4
Rotary tools on the gang tool post: 7 pcs.
Back spindle drilling tools: 7
Back rotary tools: 4 pcs.



D25 Type VIII

Total of 32 tools + α
Turning tools : 7
Main spindle drilling tools: 4
Rotary tools on the gang tool post: 3 stations + 4 B axis
Back spindle drilling tools: 7 + 4 B axis
Back rotary tools: 4 pcs.

Floor plan



Machine specification

Item	D25 Type VII (D25-1M7)	D25 Type VIII (D25-1M8)
Max. machining diameter (D)	Ø 25 mm	Ø 25 mm
Max. machining length (L)		
With guide bush spec.	250 mm	250 mm
Guide bush-less type	62.5 mm	62.5 mm
Max. main spindle drilling diameter	Ø 12 mm	Ø 12 mm
Max. tapping diameter for the main spindle	M10	M10
Main spindle speed	Max. 10,000 rpm	Max. 10,000 rpm
Max. drilling diameter by rotary tool on gang tool post	M8	M8
Rotary tool speed on the gang tool post	Max. 9,000 rpm	Max. 9,000 rpm
Max. chuck diameter of the back spindle	Ø 25 mm	Ø 25 mm
Max. workpiece protrusion length from the back spindle	50 mm	50 mm
Max. drilling diameter for the back spindle	Ø 12 mm	Ø 12 mm
Max. tapping diameter for the back spindle	M10	M10
Back spindle speed	Max. 10,000 rpm	Max. 10,000 rpm
Number of tools Standard (Max.)	35 (59)	35 (43)
Turning tools	7 – 13	7 – 9
Front drilling tools	4 – 23	4 – 13
Front cross drilling tools	7 – 12	7
Back drilling tools	6 – 35	6 – 25
Back cross drilling tools	4 – 6	4 – 6
Tool size		
Turning tools	16 mm sq.	16 mm sq.
Sleeve diameter	25.4 mm sq.	25.4 mm sq.
Chuck and bush		
Main spindle collet chuck	157E	157E
Back spindle collet chuck	157E	157E
Guide bushes	T227	T227
Rapid feed rate		
All axes (excluding Z2)	32 m/min	32 m/min
Z2 axis	24 m/min	24 m/min
Motors		
Motor spindle drive	3.7/ 5.5 kW	3.7/ 5.5 kW
Motor For driving rotary tools on the gang tool post	2.2 kW	2.2 kW
Back spindle drive	2.2/ 3.7 kW	2.2/ 3.7 kW
Motor for rotary tools for back machining	1.0 kW	1.0 kW
Rated power consumption	13 KVA	13 KVA
Total load current	33 A	33 A
Air unit		
Required pressure	0.5 MPa (5 kgf/ cm ²)	0.5 MPa (5 kgf/ cm ²)
Flow rate	Up to 60 NL/min (Power on) Up to 180 NL/min (With air blow)	Up to 60 NL/min (Power on) Up to 180 NL/min (With air blow)
Tank capacity		
Central lubrication device capacity	0.8 L	0.8 L
Coolant tank capacity	300 L	300 L
Machine dimensions		
Machine height	1,795 mm	1,795 mm
Required floor surface area	2,440 × 1,380 mm	2,440 × 1,380 mm
Center height	1,050 mm	1,050 mm
Weight	3,450 kg	3,450 kg
Main standard accessories		
Main spindle chucking unit; Back spindle chucking unit; Cut-off tool breakage detector; Workpiece conveyor; Rotary tool drive device of the gang tool post; Machine internal lighting; Coolant unit (with level detector); Rotary guide bushing drive unit; Central lubricating oil supply unit (with level detector); Spindle cooling unit; Machine relocation detector; Door lock		
Special Accessories		
High-pressure system; Oil mist evacuation; Chip conveyor; Option for long workpieces; LFV		
NC standard functions		
NC unit M850W; 15-inch XGA touch panel; User-opened disk capacity of 10 MB; Program storage capacity: 160 m (Approx. 64 KB); Tool offset pairs: 99; Preparing operation functions; On-machine program check function; Operating time display function; USB slot; Door lock; Interference check function; Automatic thermal displacement compensation function; Impact detection function; Spindle speed change detection; Constant surface speed control (G96); Nose radius compensation; B-axis control function *Type VII; C-axis function of the spindles; Back spindle 1° indexing function; Network I/O function; Milling interpolation; Canned cycle drilling; Geometric command function; Chamfering/Corner R function		
Special NC functions		
Arc threading function; Variable lead thread cutting; Differential speed rotary tool function; User macros; Helical interpolation function; High-speed synchronized tapping function; User-opened disk capacity of 100 MB; Program storage capacity: 4,800 m (1,920 KB); Tool life management I; Tool life management II; Optional block skip (9 sets); Sub inch command; 3D chamfering function		

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