

Cincom

L32

Sliding Headstock Type CNC Automatic Lathe



The new L32 – an icon reinvented

With a legacy as one of the best-selling Cincom machines, the next-generation L32 is launched with 3 models in modular design.

Ranging from a 5-axis machine with excellent cost performance to a high-end machine equipped with B axis and back tool post Y axis, you can select the machine according to the functions you require.

A wide range of modular tooling ensures that the new L32 is both versatile and flexible to meet your production demands into the future.

Rotary tools on the gang tool post
6,000 rpm (Max)
4,500 rpm (rating)
Motor: 1.0 kW

Rotary tools on the opposite tool post (optional)
6,000 rpm (Max)
3,000 rpm (rating)
Motor: 1.0 kW

Back spindle
8,000 rpm
Motor: 2.2 / 3.7 kW

Back tool post rotary tools (optional type VIII)
6,000 rpm (Max)
3,000 rpm (rating)
Motor: 1.0 kW

Front spindle
8,000 rpm
Motor: 3.7 / 7.5 kW
Max. machining length: 320mm/1 chucking (GB)

B type XII

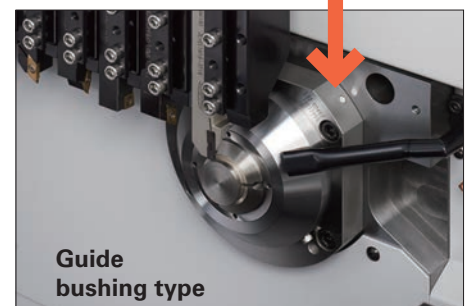
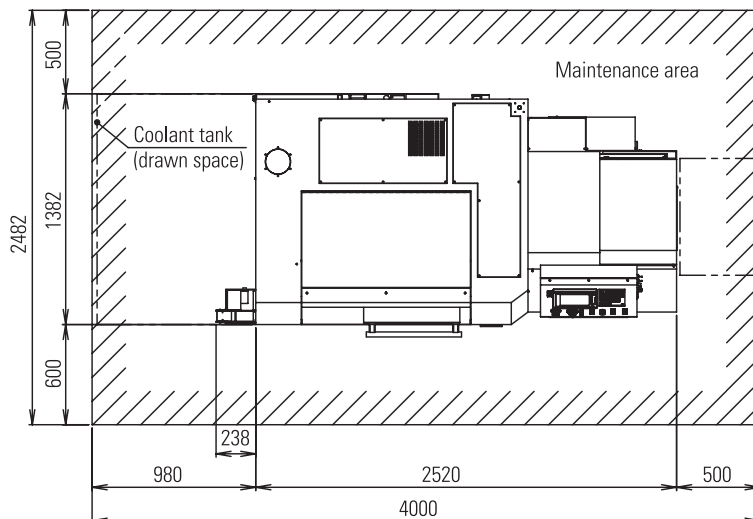
X1, Y1, Z1, X2, Y2, Z2

Y2 type X, XII

L32 Type XII example tooling

	Type VIII	Type X	Type XII
B axis (rotary tools on the gang tool post)	–	–	○
Y axis (back tool post Y axis)	–	○	○
Rotary tools on the opposite tool post	OP	OP	OP
Rotary tools on the back tool post	OP	○	○

L32 Standard Layout



Switchable between guide bushing mode or non-guide bushing mode
Can be switched by operator in approximately 30 mins.

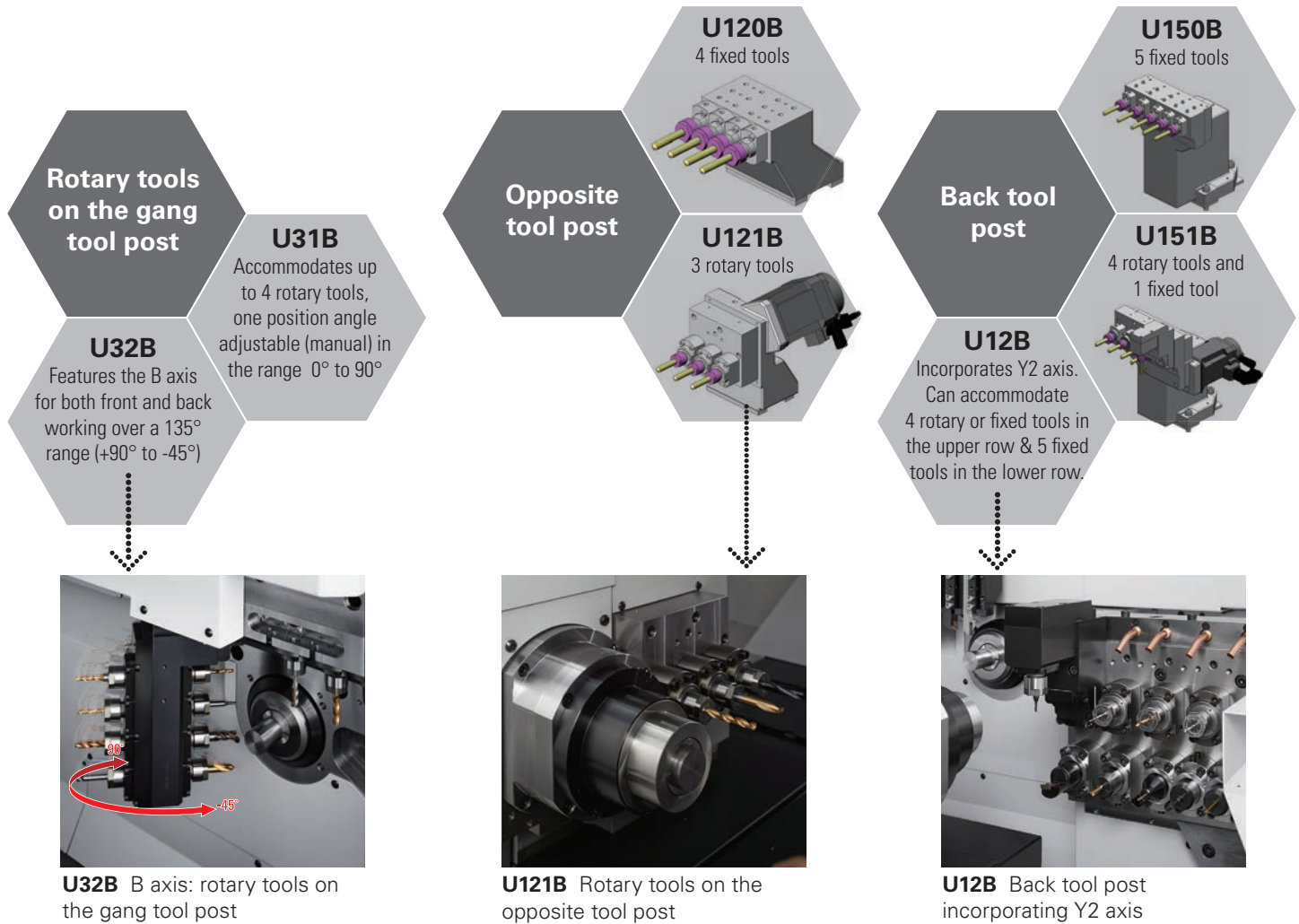
Stable, powerful, productive with versatile modular design

Function modules that can be combined without restrictions

With the current shift in manufacturing industry, the requirement is for variable-lot machining of diverse workpiece shapes and

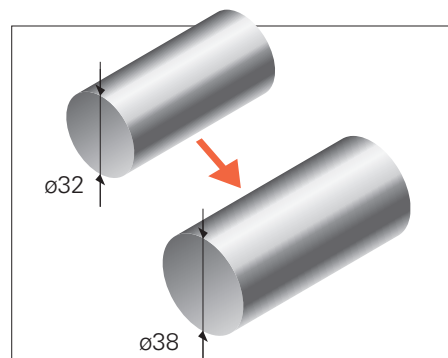
sizes. In order to meet this requirement, Citizen has introduced modular design to the new L32 thus enabling our customers

to optimize their manufacturing by selecting the functions to achieve the ideal machine configuration for their needs.



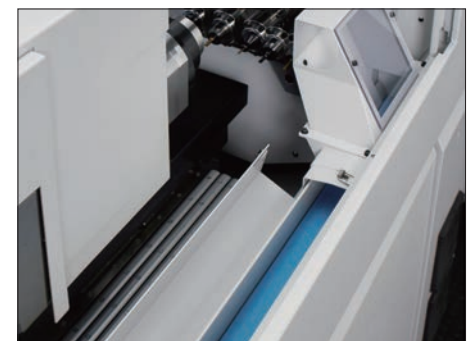
Extra-wide cover for operator convenience

The operator door can be flipped up to provide access to the interior of the machining area through a very large opening, allowing comfortable and easy access for tool setting and other adjustments.



ø32 mm max. bar as standard; ø38 mm as option

Supply of bar stock up to ø38 mm is supported as an option. The machining length per chucking is 320 mm in both capacities. A wide range of workpieces can be machined.



Workpiece conveyor equipped as standard

Workpieces are discharged to the left front of the machine.

Machine Specifications

Item	Type VIII	Type X	Type XII
	L32-1M8	L32-1M10	L32-1M12
Max. machining diameter (D)	ø32 mm (option: ø38)		
Max. machining length (L)	GB:320 mm/1chucking NGB: 2.5D		
Spindle through-hole diameter	ø39 mm		
Main spindle speed	Max.8,000 min ⁻¹		
Max. chuck diameter of back spindle	ø32 mm		
Max. protrusion length of back spindle workpiece	80 mm	65 mm	
Max. protrusion length	150 mm	140 mm	
Back spindle speed	Max.8,000 min ⁻¹		
Gang rotary tool: Spindle speed	Max.6,000 min ⁻¹ (Rating 4,500 min ⁻¹)		
Front rotary tool (OP): Spindle speed	Max.6,000 min ⁻¹ (Rating 3,000 min ⁻¹)		
Back tool post rotary tool (OP type VIII): Spindle speed	Max.6,000 min ⁻¹ (Rating 3,000 min ⁻¹)		
Number of tools to be mounted (max.)	19-30	24-44	30-40
Gang turning tool	6		
Gang rotary tool	4-6	5-13	7-11
Front drilling tool	4-9	4-16	4-9
Back drilling tool	5-11	9-20	13-19
Tool size			
Gang turning tool	□5/8"		
Sleeve	1"		
Chuck and bushing			
Main spindle collet chuck	TF37SP (TF43: ø38 spec)		
Back spindle collet chuck	TF37SP (TF43: ø38 spec)		
Rotary tool collet chuck	ER11, ER16		
Chuck for drill sleeves	ER11, ER16		
Guide bushing	TD32 (STM38: ø38 spec)		
Rapid feed rate			
All axes (except Y2)	32 m/min		
Y2 axis	-	24 m/min	
Motors			
Spindle drive	3.7/7.5 kW		
Gang tool post rotary tool drive	1.0 kW		
Back spindle drive	2.2/3.7 kW		
Back tool post rotary tool drive (OP type VIII)	1.0 kW		
Front rotary tool drive (OP)	1.0 kW		
Coolant oil	0.4 kW		
Lubricating oil	0.003 kW		
Center height	1,050 mm		
Rated power consumption	13.2 kVA		
Full-load current	36A		
Main breaker capacity	60A		
Air pressure and air flow rate for pneumatic devices	0.5 MPa, 64.2 NL		
Weight	6,283 lb	6,393 lb	

*Type VIII back tool post rotary tool is optional; **Front rotary tool drive unit is optional for all types

Environmental Information

Basic Information	Energy Usage			
		Power supply voltage	AC200V	
Environmental Performance Information	Electrical power requirement (Max)		13.2kVA	
	Required pneumatic pressure		0.5MPa	
	Standby power ^{*1}		0.320kW	
	Power consumption with model workpiece ^{*2, *3}		0.0133kWh/cycle	
	Power consumption value above converted to a CO2 value ^{*4}		6.3g/cycle	
	Required air flow rate		45NL/min (max. 182 NL/min., during air blow)	
Approach to Environmental Issues	Lubricant Consumption		At power ON	1.5cc/60min
	Noise Level		Value measured based on JIS	78.5dB
	Environmental load reduction		RoHS Directive / REACH regulations	Compliant
	Recycling		Indication of the material names of plastic parts	Covered in the instruction manual ^{*5}
Environmental management		We pursue "Green Procurement" by prioritizing purchases for goods and services that show consideration for the environment.		

*1: 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).

*2: 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.

*3: The average cycle time is 55 sec with the standard test workpiece of our company.

*4: This is the value converted in accordance with the CHUBU Electric Power CO2 emissions coefficient for 2009 as published by the Ministry of the Environment.

*5: 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.

Standard accessories

Main spindle chucking unit	Door lock
Back spindle chucking unit	Cut-off tool breakage detector
Rotary guide bushing unit	Workpiece separator
Gang rotary tool driving unit	Lighting
Coolant unit (with level detector)	Rotary guide bushing drive unit
Lubricating oil supply unit (with level detector)	Main spindle coolant unit
Machine relocation detector	Back tool post rotary unit (type X, XII)

Optional accessories

Knock-out jig for through-hole workpiece	Coolant flow rate detector
Chip conveyor	Signal lamp
Back rotary tool unit (type VIII)	3-color signal tower
	Front rotary tool unit

Standard NC functions

CINCOM SYSTEM M70LPC-VU (Mitsubishi)	Arc threading function
8.4 inch color LCD	Geometric functions Spindle synchronized function
USB slot	Spindle C-axis function
Program storage capacity: 80m (approx. 32KB)	Back spindle C-axis function
Tool offset pairs : 80	Milling interpolation
Product counter indication (up to 8 digits)	Canned cycle drilling
Operating time display function	Rigid tapping function
Machine operation information display	High speed Rigid tapping function
Multiple repetitive cycle for turning function	Differential speed rotary tool function
B axis control function (type XII)	Tool life management I
Back spindle chasing function	Tool life management II
Interference check function	External memory program driving
Synch tapping phasing function	User macros
Spindle speed change detector	Helical interpolation function
Constant surface speed control function	Slant helical interpolation function
Automatic power-off function	Hob function
On-machine program check function	Polygon function
Chamfering, corner R	Inch command
Nose radius compensation	Sub inch command
Eco indication	Network I/O function
Variable lead thread cutting	

Optional NC functions

Optional block skip (9 sets)
Back machining program skip function
Program storage capacity 600m (approx. 240KB)

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