Marubení Citizen-Cincom Inc.





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Axial Track

The C-332 has a two-position axial shifting device as standard equipment for operations in both Non-quide Bushing and Guide Bushing Modes.



Stock Size Adiustment

> Easy to use, bar diameter adjuster. This turn-knob allows for quick, on the fly switching of bar stock.



Universal Bushing Blocks

Durable Polyurethane bushing blocks eliminate bar vibration. Available in 2mm size increments, oil filled to achieve a hydrodynamic bearing effect.



Dual Anti-Vibration Bushing Device

As standard on sliding headstock applications, the dual anti-vibration bushing devices stabilize



The Marubeni Citizen-Cincom C-332 is designed for automatically feeding round, square and hexagonal bar stock in lengths up to 12', in a diameter range of 3-32 mm, into CNC lathes.

Self-Centering Gripper -**Remnant Retract**

The gripper device holds and inserts the new bar into the bar collet and is also used to extract the remnant. Bar ends that are free of burrs require no additional chamfering. The gripper requires no adjustment for bar size changes as it "self-centers".

The bar remnant is withdrawn to the back end of the magazine. A gripper extracts it from the bar stock collet and deposits it in a remnant area.



CAV Rotating Tip & Collet

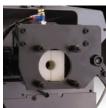
The bar pusher is equipped with a CAV rotating tip that ensures smooth running at high RPM. The bar stock collet is a common pin-on type.



Bushing Blocks

Optional bushing blocks replace rollers on outboard steady rest when running shaped stock.





Swiss Package

As a feature on the Cincom C-332 the Swiss Package includes a synchronization device and telescopic nose. The synchronization device employs an electromagnetic coupling, mechanically linking the lathe headstock's z-axis travel to the bar feeder's pusher to ensure synchronous movement and no loss of connection between the bar stock and collet-pusher. Telescopic nose installs on rear of headstock for full coverage with z-axis support.





Oil Reservoir

Oil reservoir located beneath the remnant area, allows for full storage of collets and bushing blocks in the back stand.

Double Pusher

The two pusher system drastically reduces the overall length of the unit by as much as 4 feet. A short pusher pre-feeds the bar then retracts. A second full-length pusher lowers into position to continue the feeding process.

Control

A reliable, universal Mitsubishi controller and servo drive provide the Cincom C-332 with motion control and functionality. Electronics are mounted on an easy access fold out door.



Remote Pendant

The Cincom-332 features the convenience of an easy-to-use remote control pendant. Functions include:



- manual and automatic operation
- manual load/unload of bar stock for set-up and/or changeover
- movement of bar pusher
- emergency stop

Guide Channels

Universal polyurethane guide channels handle a wide range of stock sizes, yet change over quickly.

The channel is flooded with oil to create a hydrodynamic effect resulting in higher RPM with reduced noise and vibration.



Touch Screen Control

The control is easy to program, yet flexible enough for all applications. Memory storage for 36 jobs simplifies changeovers. Diagnostics and

trouble shooting are all run from this advanced control screen.



Robust Construction

Heavy gauge structural steel ensures rigidity and long term durability.

Large Storage Capacity

The bar stock magazine is an incline rack with a loading capacity of 12 linear inches.

Stock Alignment Guides

The bar stock alignment guides are quickly and easily adjusted for different bar diameters, effectively reducing set up time.



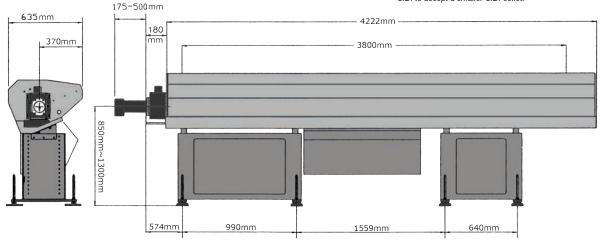
C-332

Technical Data

- Power consumption 2 KW
- Feed force adjustable, max. 450 N (101 lbf)
- Forward feed rate adjustable 750 mm/sec max. (2.46 ft/sec)
- Return feed rate 1000 mm/sec (3.3 ft/sec)
- Loading time30 sec (for 12' bars)
- Oil capacity55 liters (15 gallons)
- Oil viscosity ISO 100-150 hydraulic oil
- Operating voltage 200-230 V/60 Hz
- Compressed air supply 6 bar = (90 psi)
- Compressed air consumption approx. 8 liters per loading action
- Weight without oil 950 kg (2100 lbs)
- Remnant length 406 mm max (16 inches)
- Maximum Bar Length 3810 mm (12'6")
- Bar Diameter Range 3-32 mm (.118"-1.26")
- Magazine Capacity 12 linear inches

	(C)		
	Bar Size Capacity (mm)		
Channel Size	Minimum Bar Size	Maximum Bar Size	Max. Bar Size w/Front Remnant Expulsion*
13mm	5mm(.196")	10mm(.393")	12mm(.472")
21mm	8mm(.315")	16mm(.630")	20mm(.787")
26mm	8mm(.315")	21mm(.827")	25mm(.984")
28mm	10mm(.393")	25.4mm(1.00")	27mm(1.062")
33mm	10mm(.393")	28.5mm(1.125")	32mm(1.260")
36mm	12.7mm(.500")	32mm(1.260")	35mm(1.377")
*This may diameter is attainable only if remnant is ejected through the			

*This max. diameter is attainable only if remnant is ejected through the lathe spindle or if one end of the bar stock is turned down to a smaller O.D. to accept a smaller O.D. collet.



Technical data subject to change without notice

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