

Marubeni Citizen-Cincom Inc.

C-332



The C-332 is an Automatic Magazine style Bar Feeder designed for feeding round, square and hexagonal bar stock into CNC lathes.



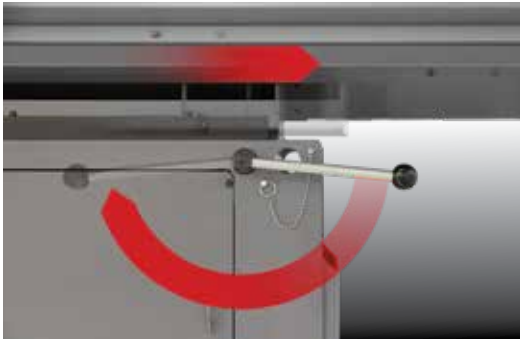
C-332

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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.

- **Axial Track**

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



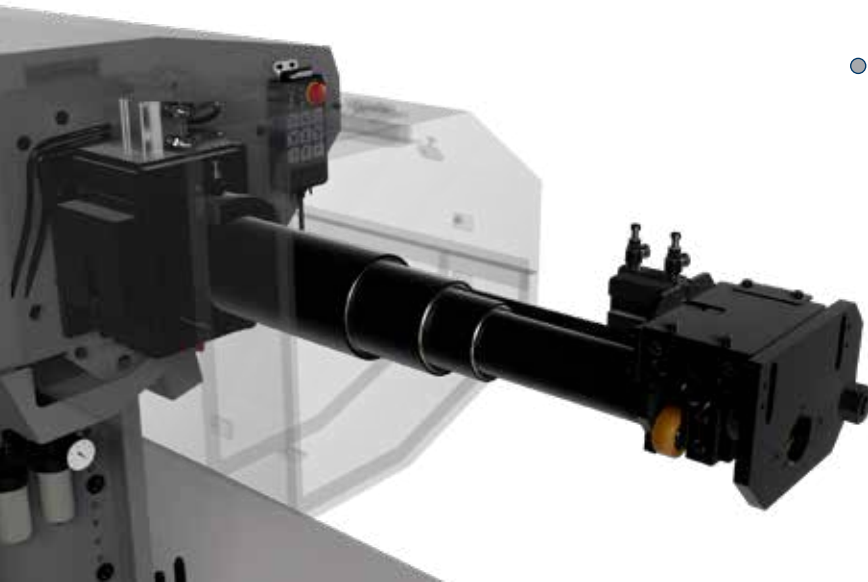
- **Universal Bushing Blocks**

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 bar stock between the guide channel and lathe spindle, maximizing RPM potential. Superior support and easy set up of all bar diameters with universal bushing blocks .



- **Self-Centering Gripper - Remnant Retract**

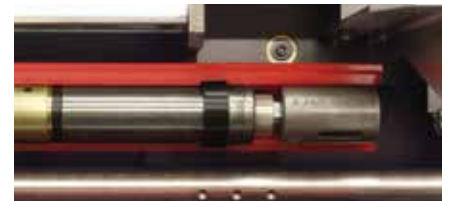
The gripper device holds and inserts the new bar into the bar collet and is also used to extract the remnant. Bar ends that are free of burrs require no additional chamfering. The gripper requires no adjustment for bar size changes as it "self-centers".

The bar remnant is withdrawn to the back end of the magazine.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.



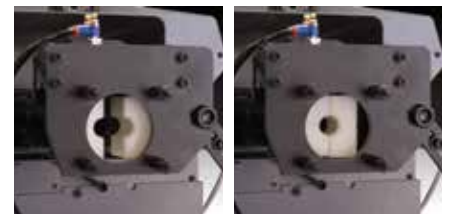
- **CAV Rotating Tip & Collet**

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.



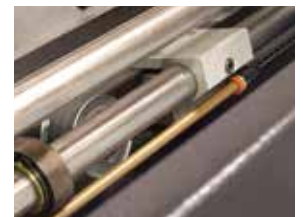
- **Bushing Blocks**

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 & Storage**

Oil reservoir located beneath the remnant area. Storage cabinet 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 Schneider controller and servo drive provide the Cincom C-332 with motion control and functionality. Electronics are mounted on an easy access fold out door.



- **Touch Screen Control**

The control is easy to program, yet flexible enough for all applications. Memory storage for 300 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.

- **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.



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Technical Data

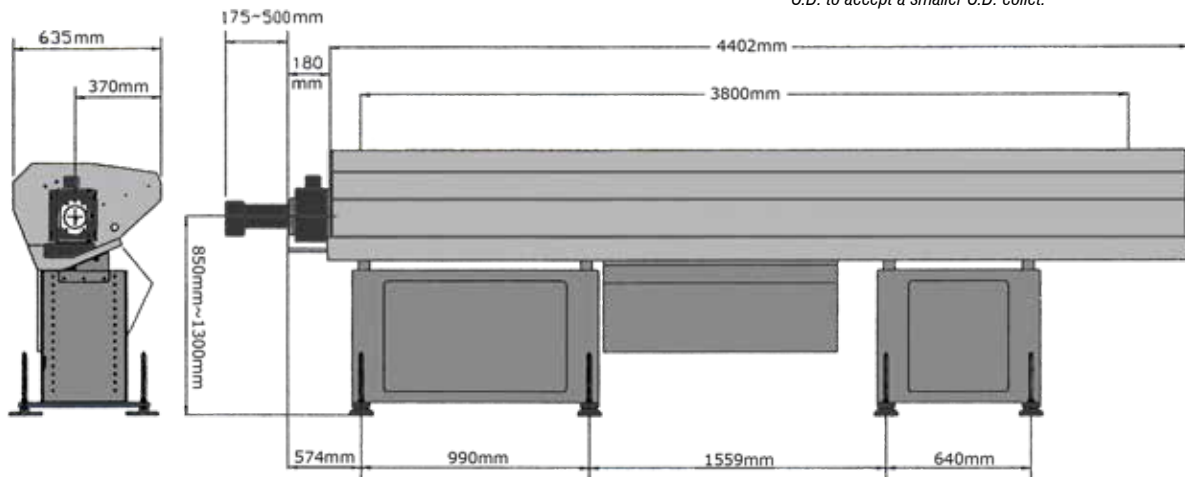
- **Power consumption**
2 KW
- **Feed force**
adjustable, max. 450 N (101 lbf)
- **Forward feed rate**
adjustable 750 mm/sec max. (2.46 ft/sec)
- **Return feed rate**
1000 mm/sec (3.3 ft/sec)
- **Loading time**
30 sec (for 12' bars)
- **Oil capacity**
55 liters (15 gallons)
- **Oil viscosity**
ISO 100-150 hydraulic oil
- **Operating voltage**
200-230 V/60 Hz
- **Compressed air supply**
6 bar = (90 psi)
- **Compressed air consumption**
approx. 8 liters per loading cycle
- **Weight without oil**
1140 kg (2500 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

Channel Size	Bar Size Capacity (mm)		
	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 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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