

CITIZEN

Miyano

BNA42GT

Fixed Headstock Type CNC Automatic Lathe





GTY

Configured with two spindles, one turret, 2 x Y axes, gang tools and X3 axis to back spindle, the BNA42GTy can mount up to 45 tools.

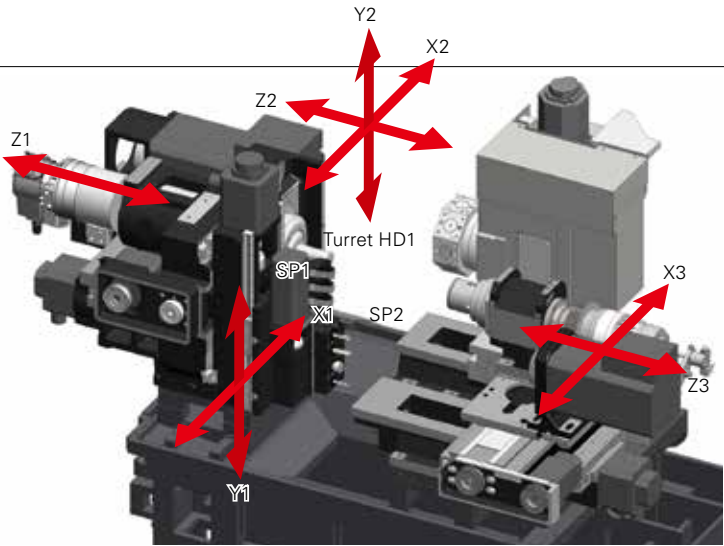
- 3 tool simultaneous cutting
- renowned Miyano accuracy
- high productivity with fast cycle times
- versatile tool layout



Designed for accuracy and long tool life

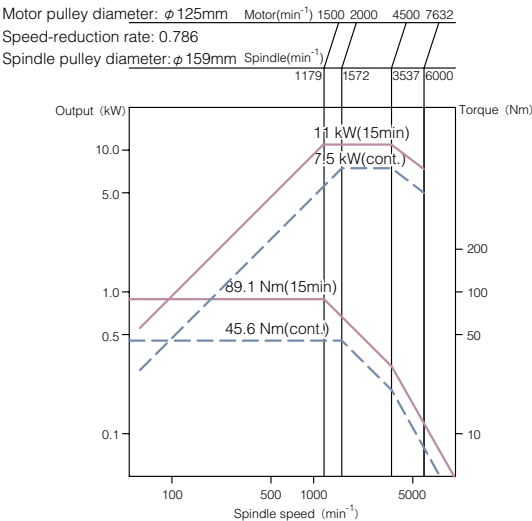
High-rigidity hand scraped slideways are used on all axes. These slideways with face contacts have exceptional rigidity and damping characteristics, enable powerful cutting, and help to prolong cutting tool life. The bed where major machine units such as spindles and tool slides are mounted has a platform-like surface table structure.

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.



Spindle Motors with Increased Output

The spindle 1 motor has the highest output in the BNA series. This enables powerful cutting.



Easy to Use Tooling System

The turret has 8 stations, but the half-indexing mechanism makes it possible to mount tools at up to 16 positions. The use of optional multiple tool holders can further increase the number of tool positions.



LFV Technology (optional)



LFV* is a technology for performing machining while vibrating the X and Z servo axes in the cutting direction in synchrony with the rotation of the spindle. It lessens the various problems caused by chips entangling with the product or tool, and is effective for small-diameter deep hole machining and the machining of difficult-to-cut materials.

*LFV is a registered trademark of Citizen Watch Co., Ltd.

Vibration mode

	LFV mode 1	LFV mode 2	LFV mode 3
Operation	Multiple vibrations per spindle revolution	Multiple spindle revolutions per vibration	Vibration threading
Specification	The axes execute multiple vibrations during one spindle revolution, reliably breaking chips up into small pieces.	Machining is carried out while rotating the spindle multiple revolutions per vibration.	A vibrating behavior is applied in the direction of the cutting (notching) during threading with the timing of this vibration changing with each pass in relation to the rotary phase of the spindle to provide "air-cutting" during the machining and break up chips.
Application	Ideal for outer/inner diameter machining and groove machining	Ideal for micro-drilling, where peripheral speed is required	Optimal for threading of internal and external diameters
Waveform			

Note 1: LFV machining can be performed with the X1, Z1 axis. Note 2: LFV machining can be performed simultaneously on a maximum of 1 pair of axes.

Note 3: For LFV machining with rotary tools, the "LFV function" and "rotary tool feed per revolution" options are required.

Cycle time shortened by superimposition control

Superimposition control allows simultaneous cutting with two tools at the main spindle (SP1), or with three tools when the sub spindle (SP2) is included, shortening cycle times.



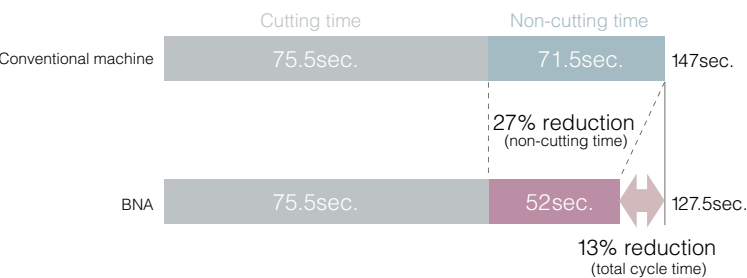
Examples

	Simultaneous machining with 2 tools		Simultaneous machining with 3 tools	
	Independent simultaneous machining of front/ back faces	Superimposition simultaneous machining of front/ back faces	Simultaneous machining of front/ back faces	Superimposition simultaneous machining of front/ front/ back faces
Turning				
Milling				

Substantial Reduction in Non-cutting Time

The unique control system cuts non-cutting time by 27% (compared to earlier equivalent Miyano products).

The result is a 13% reduction in cycle time.



Support screens improve operating convenience



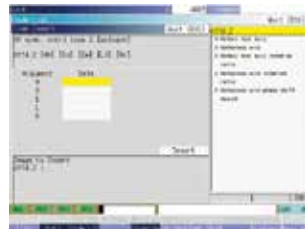
The program screen, organized for easy reading, can be displayed in synchronization with the editing screen. This simplifies the editing of complex programs with a lot of queuing.

All you have to do is input the machining length, chucking length and so on, and the escape and approach positions are automatically calculated. This is useful for collision prevention and shortening setup times.

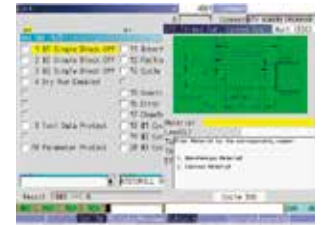


HMI (Human Machine Interface) is adopted

Graphics displayed for each item and screens that display all the necessary information in one place greatly improve operating convenience.



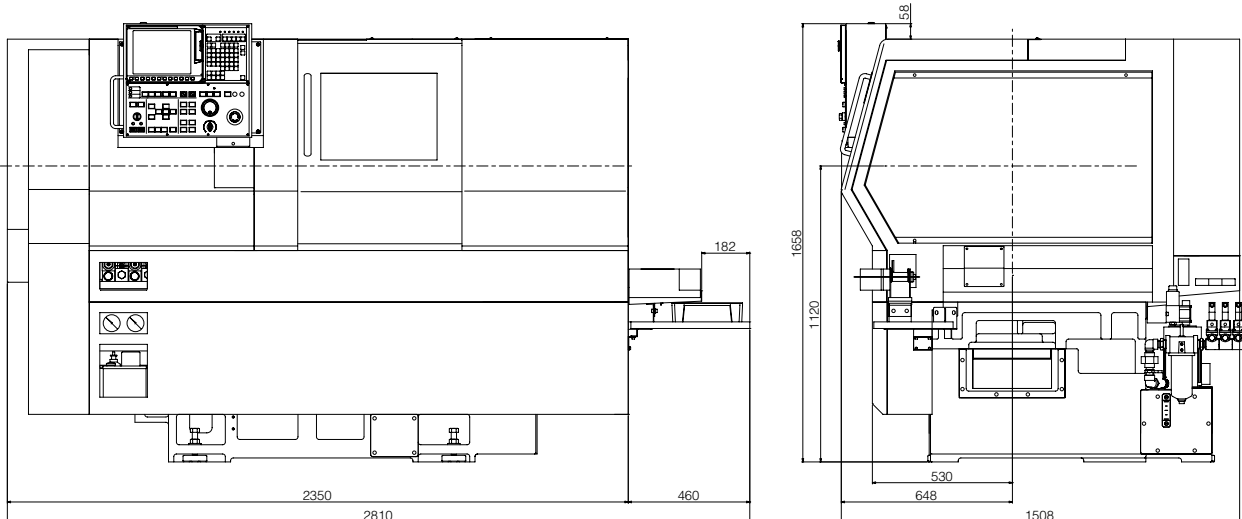
The function displays the list of G and M codes including explanations of the arguments to support programming.



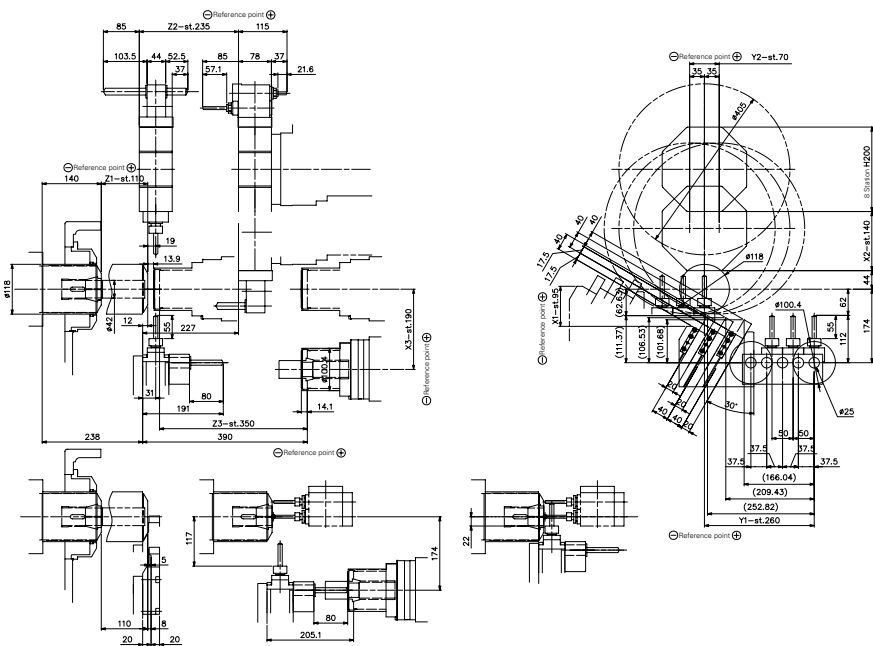
The coordinate calculation function and calculator function incorporated in the NC unit can be used for complex intersection point calculations.

Programs for canned cycles etc. can be created in the conversational style.

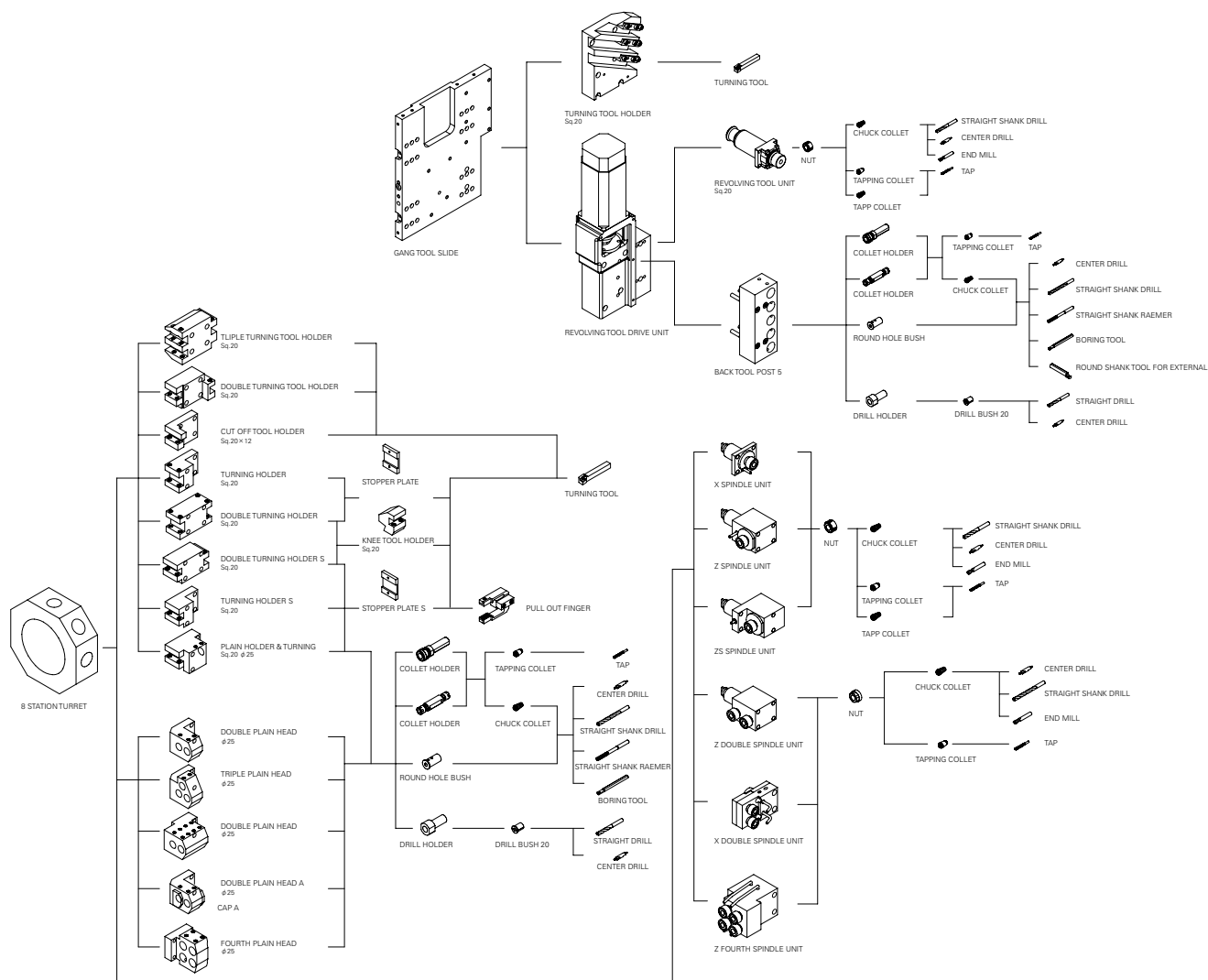
External view



Tooling area



Tooling system



Machine specification

Items		BNA-42GTY	
Machining capacity			
Max. machining diameter of bar work	SP1	42 mm	
	SP2	34 mm	
Max. machining length		110 mm	
Spindle			
Number of spindle		2	
Spindle speed range	SP1	6,000 min ⁻¹	
	SP2	5,000 min ⁻¹	
Spindle minimum index angle	SP1	0.001°	
	SP2	0.001°	
Turret			
Number of turret		2	
Tool for SP1	Turning	3	
Drill/ Bore		-	
Revolving tool	Turning	3	
Tool for SP2		-	
Drill/ Bore		5	
Revolving tool		-	
Type of turret		8 St.	
Revolving tool		8 (Op.)	
Max. number of tools		21- 43	
Shank size of turning tool		20 mm Sq.	
Diameter of sleeve holder		25 mm Dia	
Revolving tool chuck		AR16 (10 mm Dia)	
Tool spindle speed range		6,000 min ⁻¹	
Slide stroke			
Traverse rate/ Feed rate	Z1 axis	110 mm	30 m/ min
	X1 axis	95 mm	24 m/ min
	Y1 axis	260 mm	30 m/ min
	Z2 axis	235 mm	20 m/ min
	X2 axis	140 mm	20 m/ min
	Y2 axis	70 mm	12 m/ min
	Z3 axis	360 mm	20 m/ min
	X3 axis	190 mm	12 m/ min
Motors			
Spindle drive	SP1	11/ 7.5kw (15 min/ cont.)	
	SP2	5.5/ 3.7kw (15 min/ cont.)	
Revolving tool drive	Turret	1.0 kW	
Gang tool		1.5 kW	
Tank capacity			
Coolant tank capacity		165 L	
Hydraulic tank capacity		7 L	
Lubricating tank capacity		2 L	
Power supply			
Voltage		AC 200/ 220 V ± 10%	
Capacity		28 KVA	
Fuse		100 A	
Air supply		0.5 MPa	
Machine dimensions			
Machine height		1,680 mm	
Floor space		W 2,350× D 1,475 mm	
Machine weight		3,740 kg	
Options			
Spindle air blow, Spindle Brake, High pressure coolant,			
Inner High pressure coolant & Air blow, Coolant level swich, Signal tower,			
Coolant mist collector, Automatic power shut-off, Chip conveyor, Chip box, Parts catcher, Parts conveyor,			
Drill breakage detector, RS-232C, 100V, LFV			

NC Specification	
Model device	MITSUBISHI M730VS
Display devise	10.4" color LCD
Controllable axis	
command specified axes	X1, Z1, Y1, C1 -axis
	X2, Z2, Y2, C2 -axis
	X3, Z3 -axis
auxiliary axes	C3, C4, T1 -axis
Control axis groups	3 groups
Input code	ISO
Command input system	Incremental and absolute
Feed command system	Per rotation feed and per minute
Cutting feed rate and Rapid feed override	Max.100%
Tool offset data	80 pairs
Program storage capacity	320 m
Standard function	
On machine program check function	
Manual feed function	
Manual data input (MDI) function	
Operation time display	
Product counter display	
Cycle time check function	
Preparation functions	
Start position automatic return	
Automatic cut-off machining function	
Tool set function	
Spindle speed simultaneous command for 3 spindle	
3 Sets of M code simultaneous command	
Control axis swap function	
Control axes superimpose command	
Arbitrary superposition function	
Function to superimpose 2 pairs of axes	
Background editing	
Simultaneous program editing two control axis group	
Editing support functions	
Calculator function	
Code list display	
Coordinate calculation function	
Spindle C-axis function spindle	
Constant surface speed control	
Cut off confirmation	
Tool nose R compensation function	
Arc radius specification	
Thread cutting canned cycle	
Spindle synchronizing control function	
Milling interpolation	
Option	
Helical interpolation, Corner chamfering/ Radius function,	
Spindle synchronous tap function, Revolving tool synchronous tap function,	
Custom macro, Multiple canned cycles for turning, Canned cycles for drilling,	
Inch / metric change, Rotary tool feed per revolution	

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