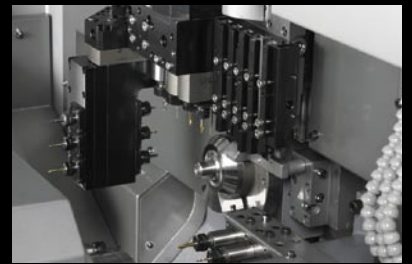


**"Impressive Value" Production**  
Adding value to efficient production

# Cincom

Sliding Headstock Type Automatic CNC Lathe

## L20ix



**CITIZEN**  
Micro HumanTech

# Maximum 31 tools can be mounted.

**L20IX is debut ; Best seller machine 'L20' develop to the more powerful machine.**

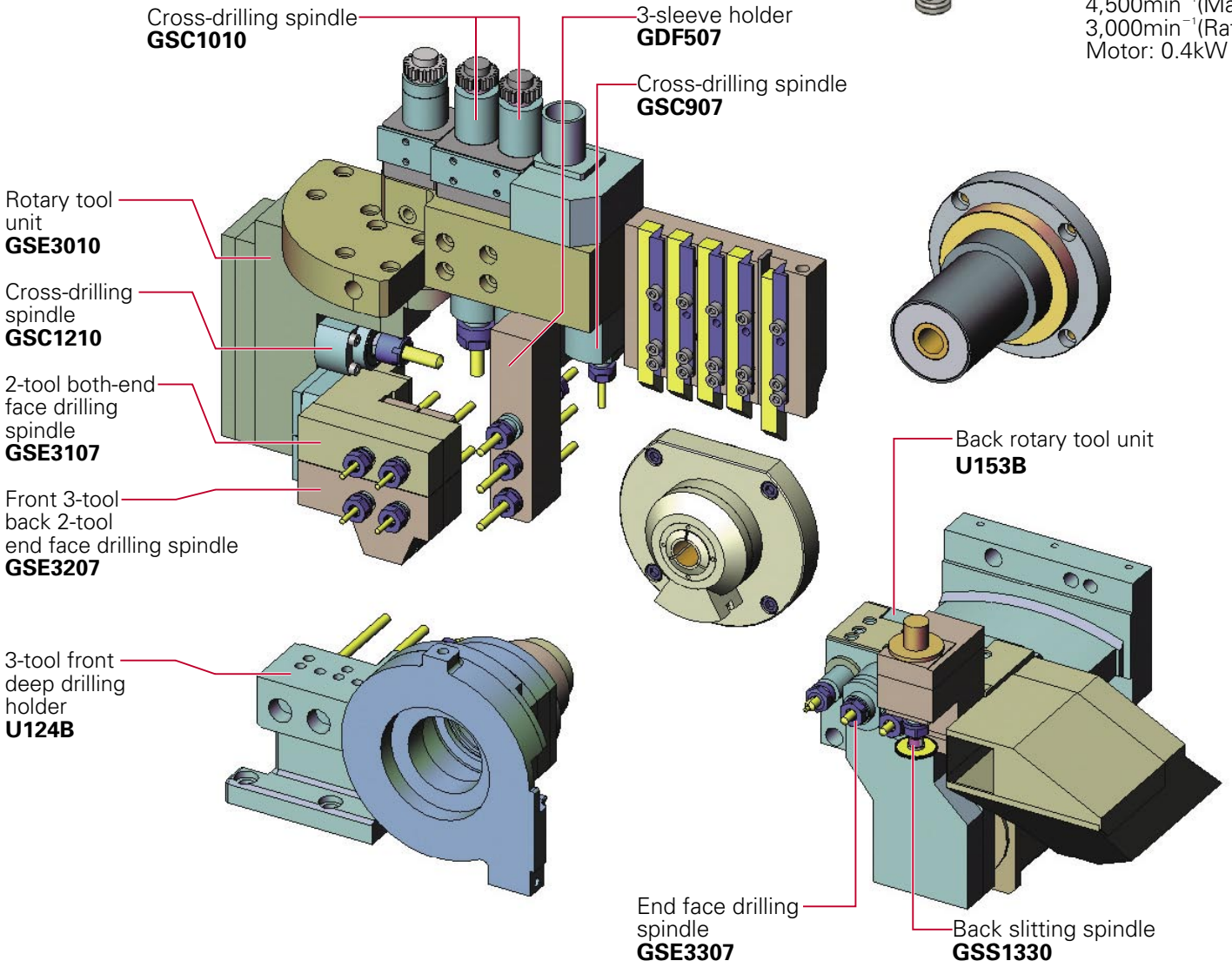
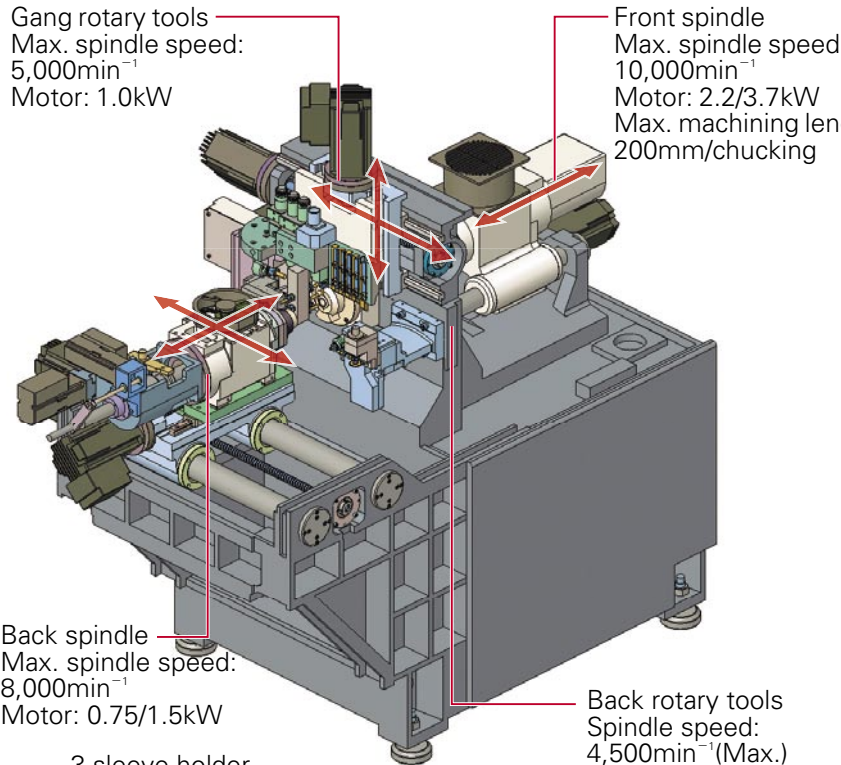
Citizen's L20 series has been acclaimed by customers around the world for its combination of cost, function and ease-of-use making the L20 the benchmark 20mm machine.

Now, the L20IX is introduced with significantly improved face rotary tool functions and additional functions such as back slitting.

Up to 31 tools can be mounted including:

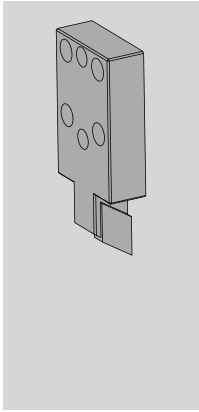
- Front 3-tool, back 2-tool end face drilling spindle (GSE 3207)
- 2-tool both-end face drilling spindle (GSE 3107)
- Back tool post equipped with 3 rotary tools as standard (GSE 3307) and capable to perform back slitting by using GSS 1330.

This new model, equipped with up to 31 tools, enables easy machining of complex shapes with the convenience of a gang tool machine.



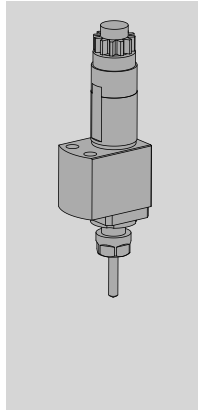
# Outstanding tooling versatility of the new L20

## Easy machining of complex shapes



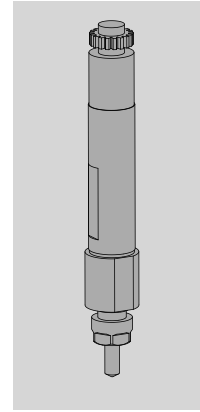
### **GTF3712** **1-tool holder**

This is a tool holder for front turning that is mounted on the 5-rotary-tool vertical holder. The GTF3711 for back turning and grooving is also available.



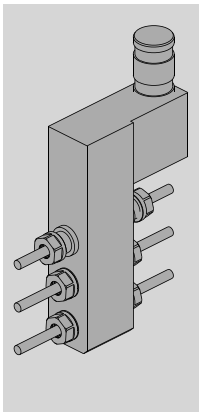
### **GSC907** **Cross-drilling spindle**

This is for performing drilling and milling on the outer diameter.  
Max. collet dia.:  $\phi 7$ mm  
Chuck model : ER11



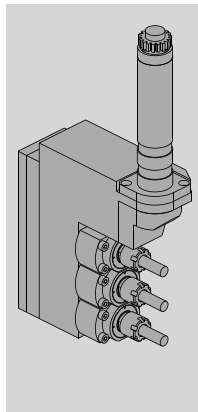
### **GSC1010** **Cross-drilling spindle**

This is for performing drilling and milling on the outer diameter.  
Max. collet dia. :  $\phi 10$ mm  
Chuck model : ER16



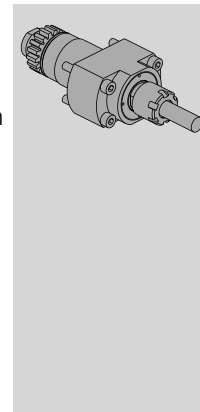
### **GDF507** **3-sleeve holder**

Up to three sleeves can be mounted in this holder, for drilling on front/back end faces. The sleeve mounting hole diameter is  $\phi 19.05$ mm. This figure shows the holder installed with three double-ended sleeves.



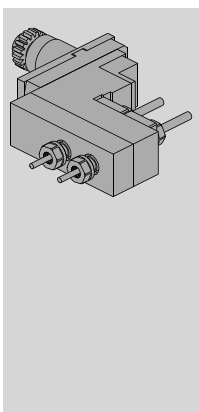
### **GSE3010** **Rotary tool unit**

The mounting direction of this spindle can be switched for cross or end face machining, and it can perform drilling on the outer diameter or drill on the end face. This figure shows the holder installed with three GSC1210 rotary spindles.



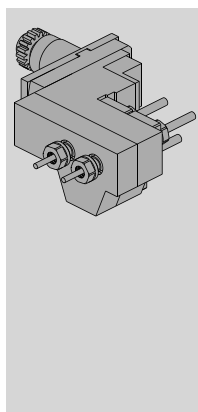
### **GSC1210** **Cross-drilling spindle**

This is for performing drilling and milling on the outer diameter. This spindle is mounted on GSE3010. Max. collet dia. :  $\phi 10$ mm  
Chuck model : ER16



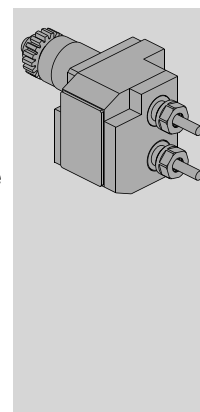
### **GSE3107** **2-tool both-end face drilling spindle**

This spindle performs drilling or milling on the front and back end face. This spindle is mounted on GSE3010. [Front] Max. collet dia. :  $\phi 7$ mm  
Chuck model : ER11  
[Back] Max. collet dia. :  $\phi 5$ mm  
Chuck model : ER8



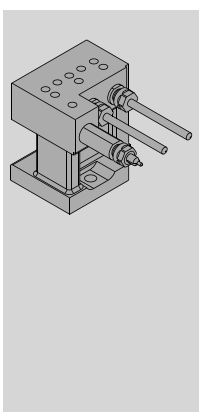
### **GSE3207** **Front 3-tool back 3-tool end face drilling spindle**

This spindle performs drilling or milling on the front and back end face. This spindle is mounted on GSE3010. [Front] Max. collet dia. :  $\phi 7$ mm  
Chuck model : ER11  
[Back] Max. collet dia. :  $\phi 5$ mm  
Chuck model : ER8



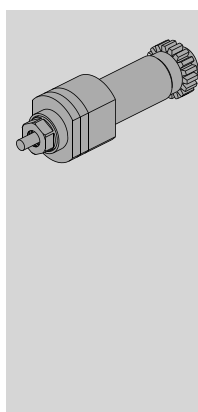
### **GSC1307** **2-tool cross-drilling spindle**

This is for performing drilling and milling on the outer diameter. This spindle is mounted on GSE3010. Max. collet dia. :  $\phi 7$ mm  
Chuck model : ER11



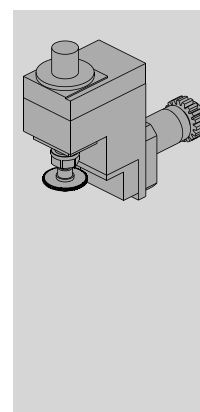
### **U124B** **3-tool front deep drilling holder**

This is for performing front drilling. Up to three  $\phi 19.05$ mm diameter sleeves can be mounted. It is possible to 100mm depth drilling. Efficient tool length : 75mm (1 tool), 100mm (2 tool)



### **GSE3307** **End face drilling spindle**

This is for performing drilling and milling on the back end face. This spindle is mounted on back tool post. Max. collet dia. :  $\phi 7$ mm  
Chuck model : ER11



### **GSS1330** **Back Slitting spindle**

This is for performing back slitting. This spindle is mounted on back tool post. Max. cutter dia. :  $\phi 30$ mm  
Max. collet dia. :  $\phi 7$ mm  
Chuck model : ER11

# Machine Specifications

Item	L20IX
Maximum machining diameter (D)	φ20mm
Maximum machining length (L)	200mm/1chucking
Maximum front drilling diameter	φ10mm
Maximum front tapping diameter (tap, die)	M8
Spindle through-hole diameter	φ24mm
Main spindle speed	10,000min <sup>-1</sup>
Maximum drilling diameter for the gang rotary tool	φ7mm
Maximum tapping diameter for the gang rotary tool	M6
Spindle speed of the gang rotary tool	5,000min <sup>-1</sup>
Maximum chuck diameter of back spindle	φ20mm
Maximum protrusion length of the back spindle workpiece	30mm (Max. protrusion length 80mm)
Maximum drilling diameter in back machining process	φ8mm
Maximum tapping diameter in back machining process	M6
Back spindle speed	8,000min <sup>-1</sup>
Number of tools to be mounted	31
Turning tools on the gang tool post	5~7
Cross rotary tools	4~8
Rotary tools for front drilling	0~5
Tools for front drilling	3~6
Tools for back drilling	4~8
Tool size	
Tool (gang tool post)	□12mm, □13mm (□16mm for T01 only)
Sleeve	φ19.05mm
Chuck and bushing	
Main spindle collet chuck	FC034-M
Back spindle collet chuck	FC034-M-K
Rotary tool collet chuck	ER11, ER16
Chuck for drill sleeves	ER11, ER16
Guide bushing	WFG206-M
Rapid feed rate	
All axes	32m/min
Motors	
Spindle drive	2.2/3.7kW
Tool spindle drive	1.0kW
Back spindle drive	0.75/1.5kW
Coolant oil	1.0kW
Center height	1050mm
Input power capacity	8kVA
Air pressure and air flow rate for pneumatic devices	0.5MPa · 50NI/min (Max.150NI/min)
Weight	2100kg

## Standard Accessories

Main spindle chucking device	Lubricating oil supply unit (with level detector)
Rotary guide bushing drive device	Back spindle chucking device
Coolant device (with level detector)	Gang rotary tool driving device
Door switch	Lighting
Workpiece separator	

## Special Accessories

Fixed guide bushing device	Chip conveyor
Rotary guide bushing device	Coolant flow rate detector
Front / back rotary tool drive unit	Signal lamp
Cut-off tool breakage detector	3-color signal tower
Knock-out jig for through-hole workpiece	Long workpiece machining device
Workpiece conveyor	

## Standard NC Functions

NC unit dedicated to the L series	Thread cutting canned cycle
10.4 inch color liquid crystal display (LCD)	Continuous thread cutting
Operating time display	Main spindle speed change detector
Preparation functions	Back spindle speed change detector
Three-dimensional interference check function	Main spindle indexing at 1 intervals
On-machine program check function	Nose R compensation function
Program storage capacity : 40 m	Corner chamfering/ rounding function
Tool offset pairs : 40 pairs	Multiple repetitive cycle for turning
Product counter display : Up to 8 digits	Automatic power-off function
Tooling information function	

## Special NC Functions

Back spindle indexing at 1 intervals	Spindle synchronized function
Main spindle C axis function (1/1000)	Milling interpolation function
Back spindle C-axis function (1/1000)	User macro
Canned drilling cycle	Helical interpolation function
Program storage capacity 1200m (max.)	Tool life management I
Main spindle rigid tapping function	Tool life management II
Tool spindle rigid tapping function	Sub-micron command function
Back spindle rigid tapping function	Circular thread cutting function
Rigid tapping phase matching function	Tool offset pairs 80 pairs (max.)



## CITIZEN MACHINERY CO.,LTD.

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CITIZEN MACHINERY CO.,LTD.  
CITIZEN MACHINERY ASIA CO.,LTD.  
CITIZEN MACHINERY CHINA CO.,LTD.  
CITIZEN MACHINERY EUROPE GmbH  
CITIZEN MACHINERY UK LTD.  
MARUBENI CITIZEN-CINCOM INC.

TEL.81-267-32-5961 FAX.81-267-32-5928  
TEL.66-35-721-833 FAX.66-35-721-835  
TEL.86-21-6415-6485 FAX.86-21-6334-3289  
TEL.49-711-3906-100 FAX.49-711-3906-106  
TEL.44-01923-691500 FAX.44-01923-691599  
TEL.1-201-818-0100 FAX.1-201-818-1877

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