



watch



automobile



aerospace



medical



industry

PCM
be driven.

TOOL HOLDERS CITIZEN CINCOM A20.



Made in Switzerland
since 1969

PCM WILLEN SA

For over 40 years, PCM Willen SA is one of the world's leading manufacturers of special tool holders for automatic lathes.

All our products are developed and manufactured in Switzerland and bear the label «Swiss Made», which is synonymous with precision, quality and reliability.

Our company is located in the middle of French-speaking part of Switzerland at the edge of Lake Geneva near Montreux.

Our international dealer network ensures continued after sales support. We offer training courses, which we tailor to individual customer requirements.

PCM stays for innovation and progress. Our superbly qualified engineering staff ensures finest quality of manufacturing solutions and keeps our customers ahead of the competition.

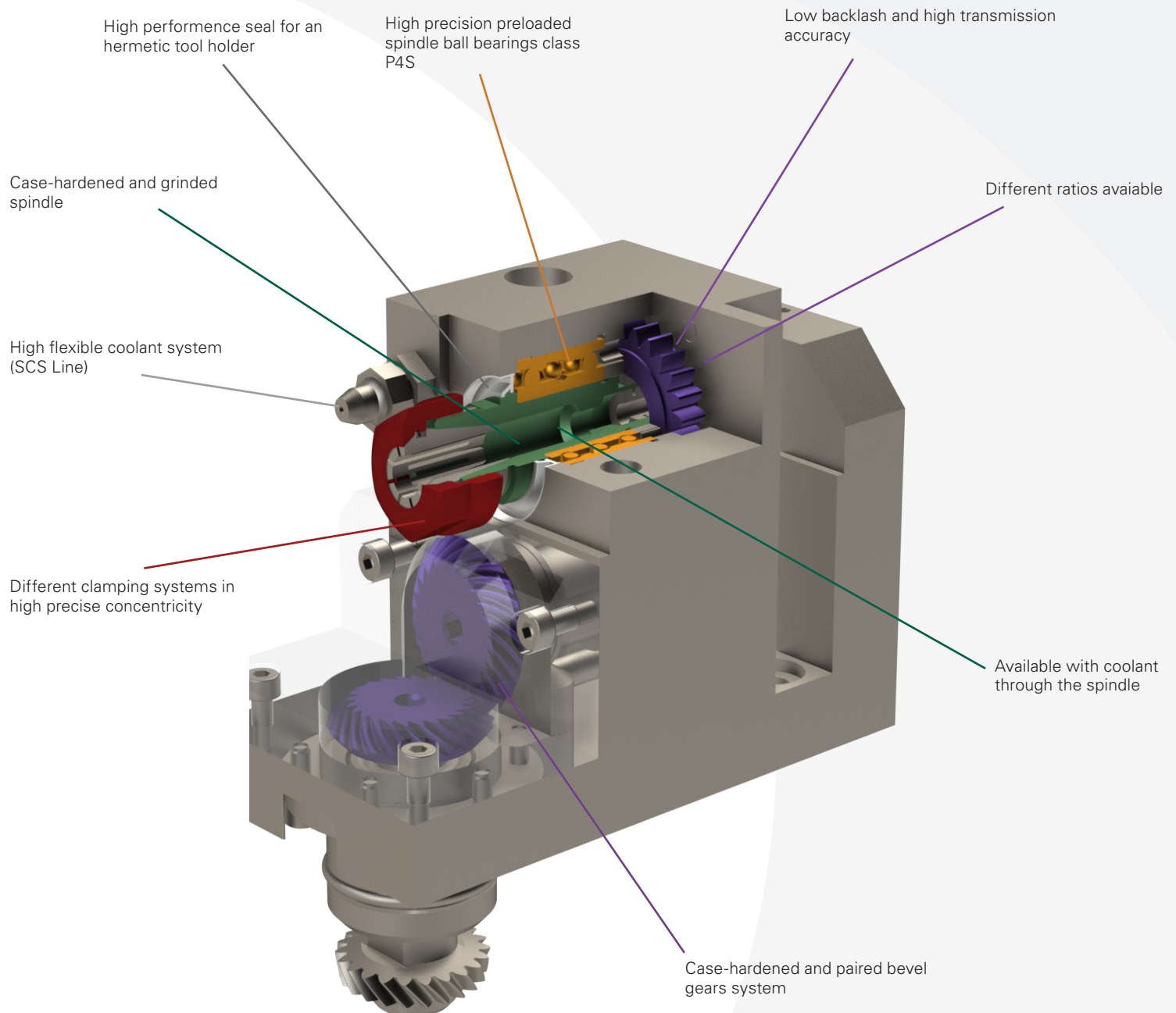
In close cooperation with machine builders and end users, we stay on the way to satisfied customers. We will keep this track in the future.

The best quality toolholders can only provide optimum performance if they are maintained or repaired with first class replacement parts. PCM experts emphasize professional after sale support for all PCM equipment.



YOUR CHOISE N°1 IN TOOLING SYSTEMS

- Long service life ←
- Very gentle transmission even at high speed operation ←
- 100% tested ←
- Customised tool available ←



CITIZEN CINCOM A20

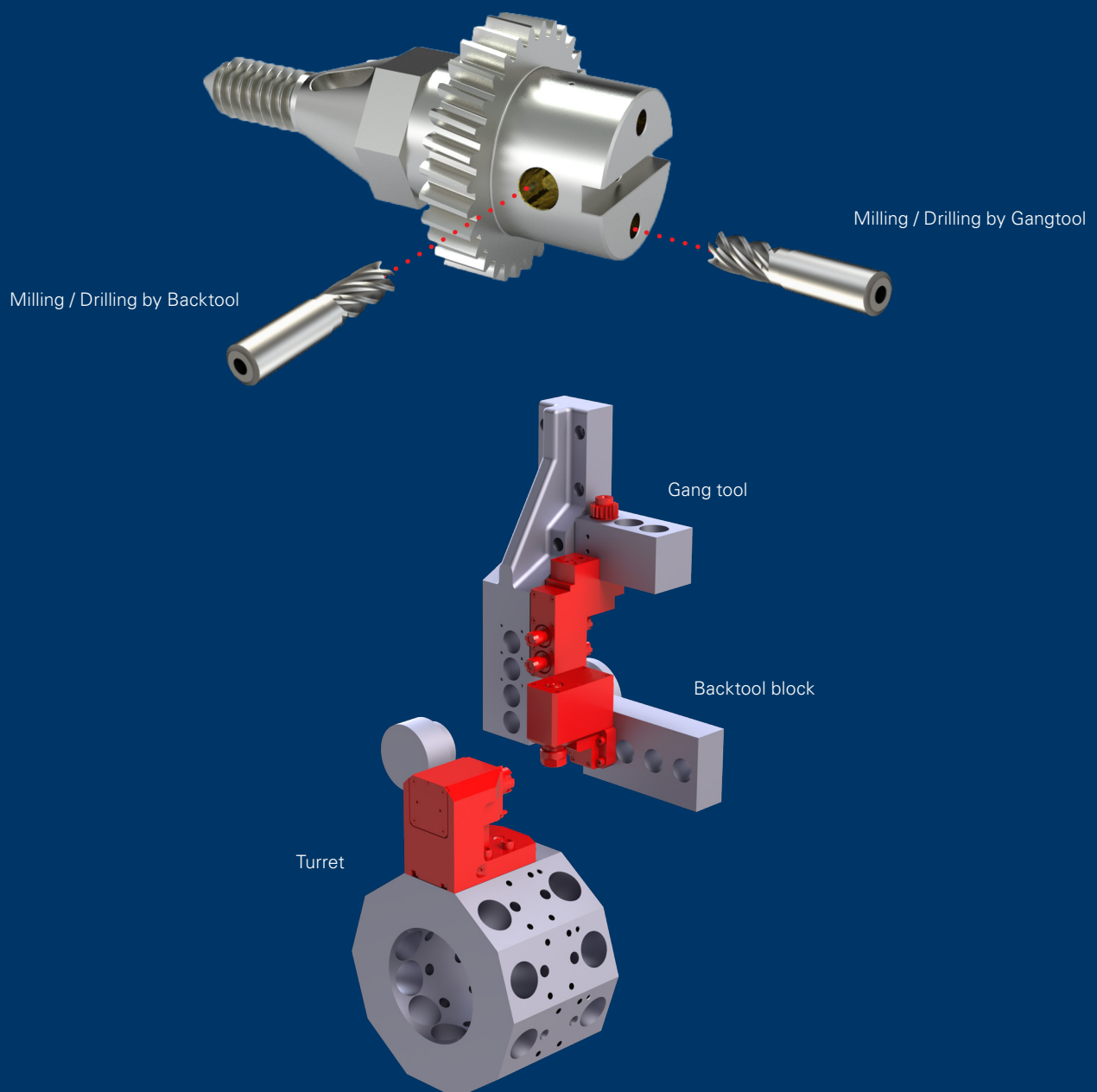
Radial tools	5
Axial tools	17
Accelerated tools	25
Adjustable tools	35
Slitting saw tools	39
Polygon tools	45
Hobbing tools	51
Whirling tools	55
Static tools	59

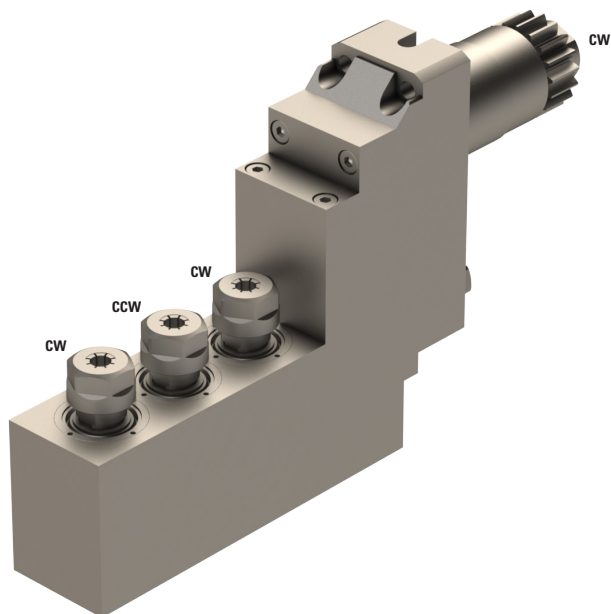
Rotation: **cw** Clockwise **ccw** Counterclockwise
Cooling: **INT** Interior **EXT** Exterior **⊘** Without

RADIAL DRILLING / MILLING TOOLS

The machining direction of radial tools is usually at 90° to the drive. These tools make it possible to carry out face machining on the gang tool. On the backtool block, these tools are used for radial machining.

These tools are available in different versions such as spindle cooling, transmission, multi-spindle, etc.



BSE-3106

3xER11



1:1

Position

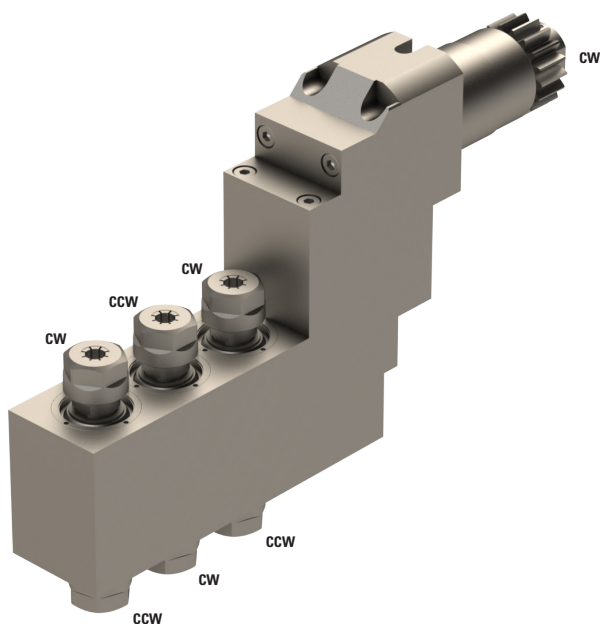
Upper gang tool post

Machines Types

A232-VII	M220-III
A32-VII	M220-V
A320-VII	M232-III
D25-VII	M232-V
L32-1M8	M320-III
L32-1M10	M320-V
L32-1M12	M332-III
L220-2M8	M332-V
L220-2M10	M32-4M5
	M32-4M8

Notes

Max. 2 tool holders
CITIZEN original article BSE-607

**BSE-3206**

3xER11+3xER11



1:1

Position

Upper gang tool post

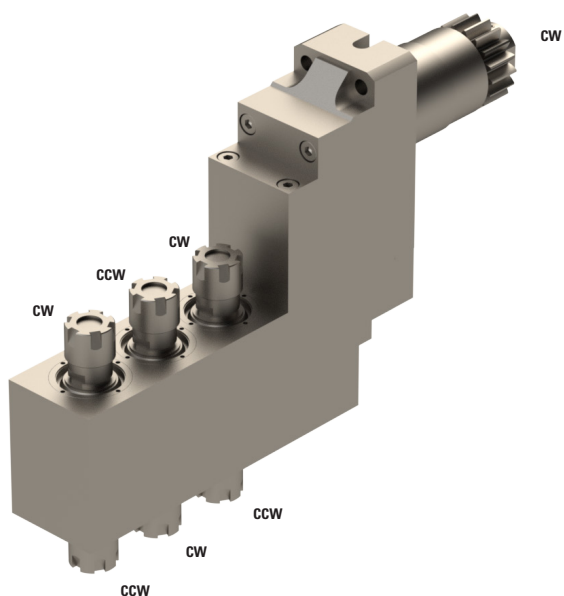
Machines Types

A20-VII
A20-3F7N

Notes

We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

BSE3206-II



3xER11+3xER11



1:1

Position

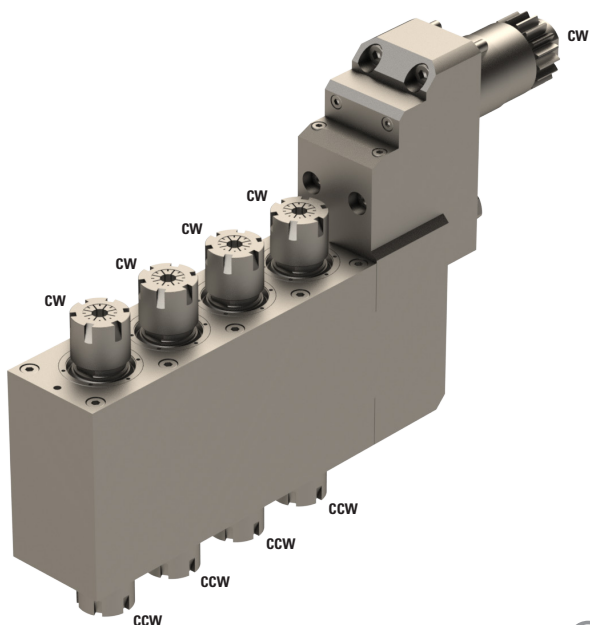
Upper gang tool post

Machines Types

A20
A32
L20
L32
D25

Notes

BSE-3208



4xER16+4xER16



1:1

Position

Upper gang tool post

Machines Types

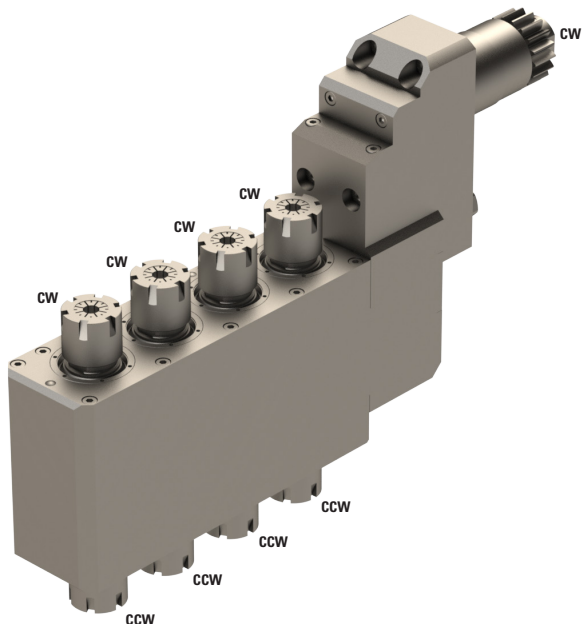
A232-VII
A32-VII
A320-VII

Notes

with Gears

We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

BSE-3208-II



4xER16+4xER16



1:1

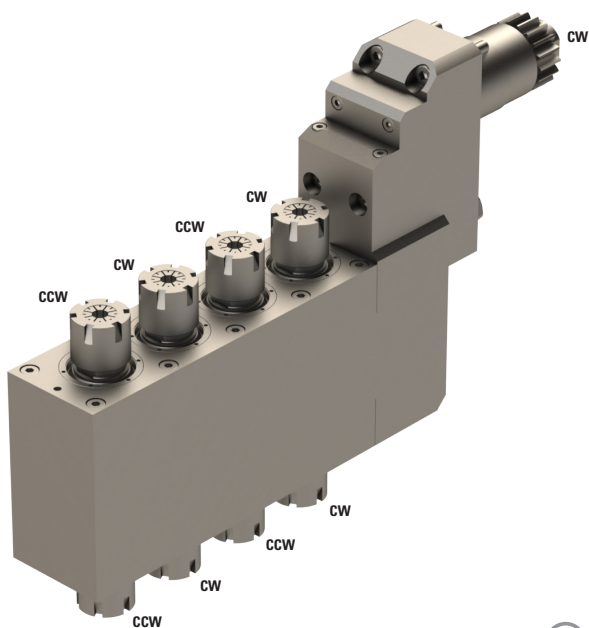
Position

Upper gang tool post

Machines TypesA232-VII
A32-VII
A320-VII**Notes**

with Gears

BSE-3208-III



4xER16+4xER16



1:1

Position

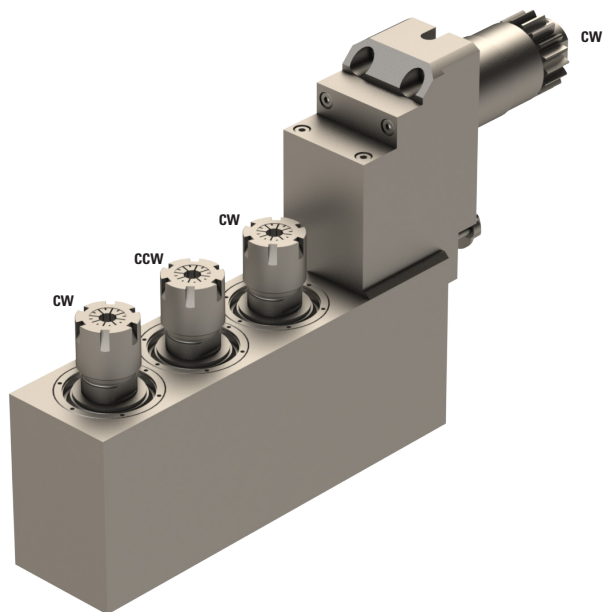
Upper gang tool post

Machines TypesA232-VII
A32-VII
A320-VII**Notes**

with Gears

We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

BSE3209



3xER16



1:1

Position

Upper gang tool post

Machines Types

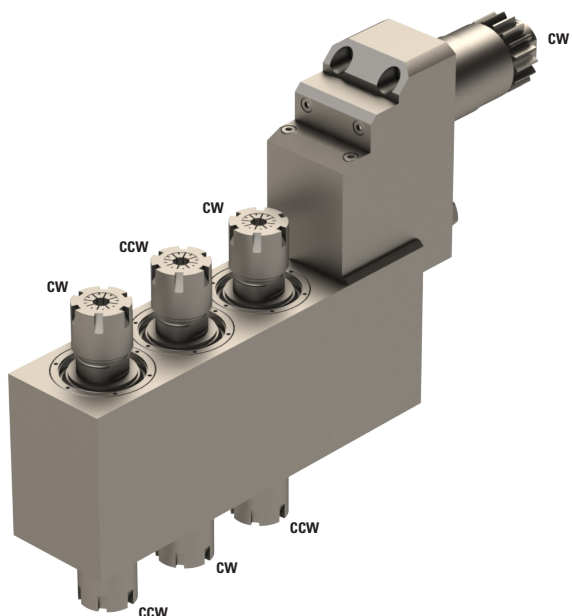
A232-VII	M220-III
A32-VII	M220-V
A320-VII	M232-III
D25-VII	M232-V
L32-1M8	M320-III
L32-1M10	M320-V
L32-1M12	M332-III
L220-2M8	M332-V
L220-2M10	M32-4M5
	M32-4M8

Notes

Max. 2 tool holders
CITIZEN original article GSE-1610



BSE3210



3xER16+3xER16



1:1

Position

Upper gang tool post

Machines Types

A232-VII	M220-III
A32-VII	M220-V
A320-VII	M232-III
D25-VII	M232-V
L32-1M8	M320-III
L32-1M10	M320-V
L32-1M12	M332-III
L220-2M8	M332-V
L220-2M10	M32-4M5
	M32-4M8

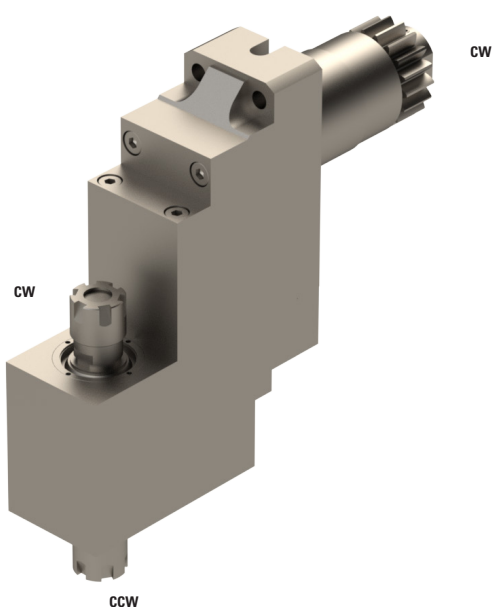
Notes

Max. 2 tool holders
CITIZEN original article GSE-1810



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

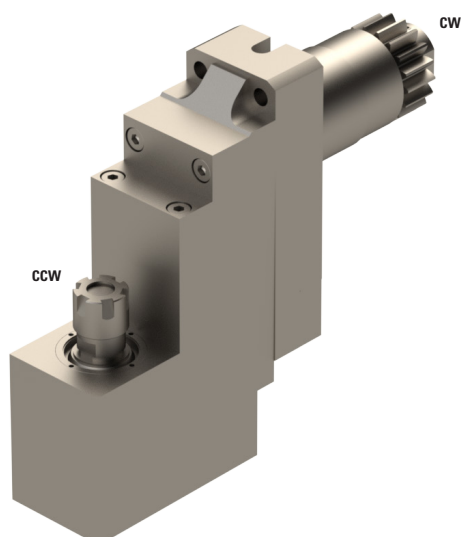
BSE1007-II



	1xER11+1xER11
	1:1
Position	Upper gang tool post
Machines Types	A20 A32 L20 L32 D25
Notes	



BSE107

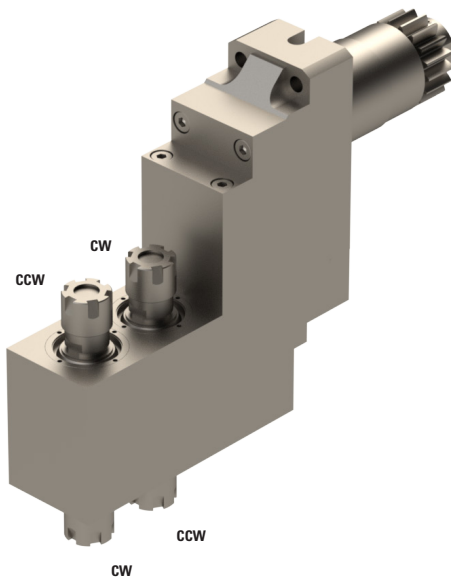


	ER11
	1:1
Position	Upper gang tool post
Machines Types	A20 D25 L20 A32/L32
Notes	



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

BSE2007-II



CW



2xER11+2xER11



1:1

Position

Upper gang tool post

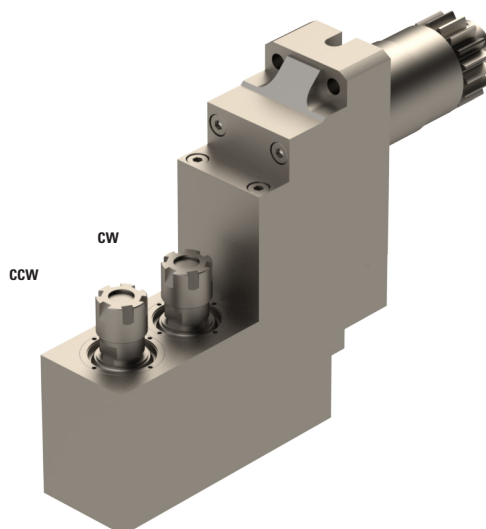
Machines Types

A232-VII	L32-1M8
A32-VII	L32-1M10
A320-VII	L32-1M12
D25-VII	L220-2M8

Notes



BSE-207-II



CW



2xER11



1:1

Position

Upper gang tool post

Machines Types

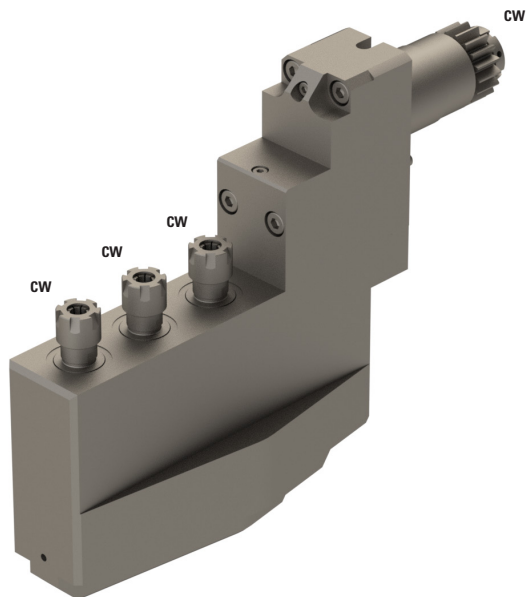
A20
D25
L20
A32/L32

Notes



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

BSE3007-IK-3X



3x ER11



1:1/1:3

Position

Upper gang tool post

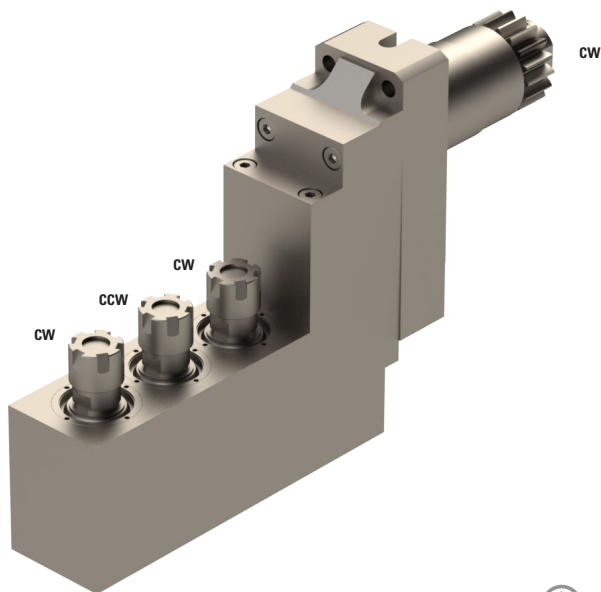
Machines Types

A20
D25
L20/L25
A32/L32
M32

Notes

Internal, max 120 [bar].
An oil filtered to 50µm is required.
High pressure lines are not supplied as standard.
Threaded hole for high pressure line: G1/8.
High pressure lines and quick couplings can be ordered.
Article:
- MI-CA-01-00 (Adapter 1/8 -> M8x1)
- MI-QC-01-00 (Female quick coupling)
- MI-CC-01-01 (Male quick coupling)
- MI-DT-01-02 (M8x1 pipe, 305mm) or MI-DT-01-03 (M8x1 pipe, 406mm)
Max. pressure = 220 [bar]

BSE3107-II



3xER11



1:1

Position

Upper gang tool post

Machines Types

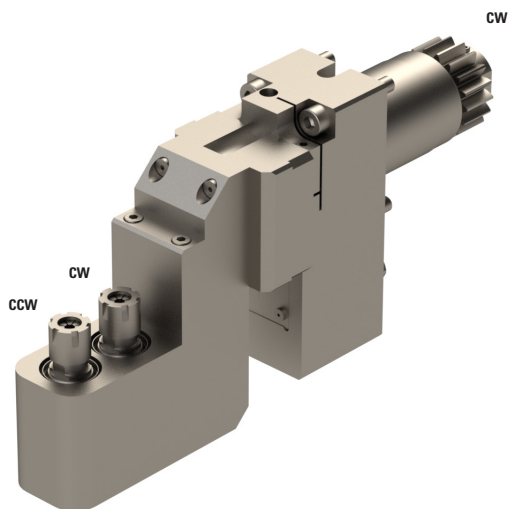
A20
D25
L20
A32/L32

Notes

We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

**MODULAR
SYSTEM**

CITIZEN6-GSE-208



2xER08



1:1

RPM max.

6'000

Position

T08-T10

Machines Types

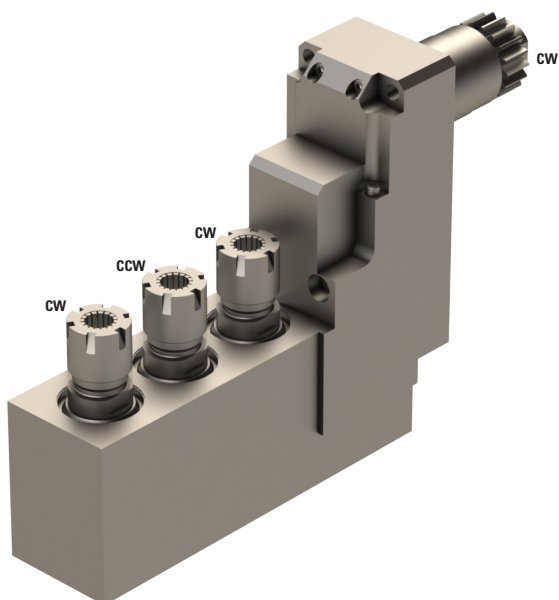
A232-VII
A32-VII
A320-VII
L20E-2M8
L20E-2M10
L20E-2M12
L20E-IX
L32-1M8
L32-1M10
L32-1M12

Notes

Adjustable $\pm 15^\circ$
The CITIZEN6-PCR base and GSE-208 head are together
on this tool.
Possibility to order them individually.



GSE-1510



3xER16



1:1

Position

Upper gang tool post
Front gang tool post

Machines Types

A320-VII	L220-2M10
D25-VII	M32-4M5
L32-1M8	M32-4M8
L32-1M10	M32-5M5
L32-1M12	M32-5M7
L220-2M8	M32-5M8

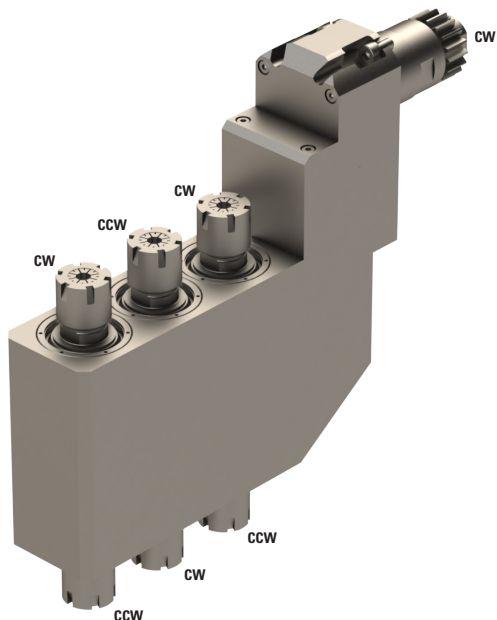
Notes

---> M532 interferences on T10



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

GSE-1710



3xER16+3xER16



1:1

Position

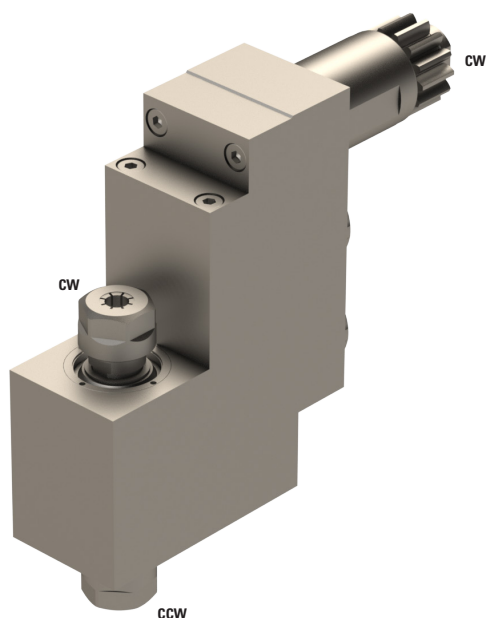
Upper gang tool post

Machines Types

A232-VII
A32-VII
A320-VII

Notes

MSE-1007



1xER11+1xER11



1:1

Position

Front gang tool holders

Machines Types

A20-VII
A20-3F7N
L12-1M7

Notes

Need 3 positions

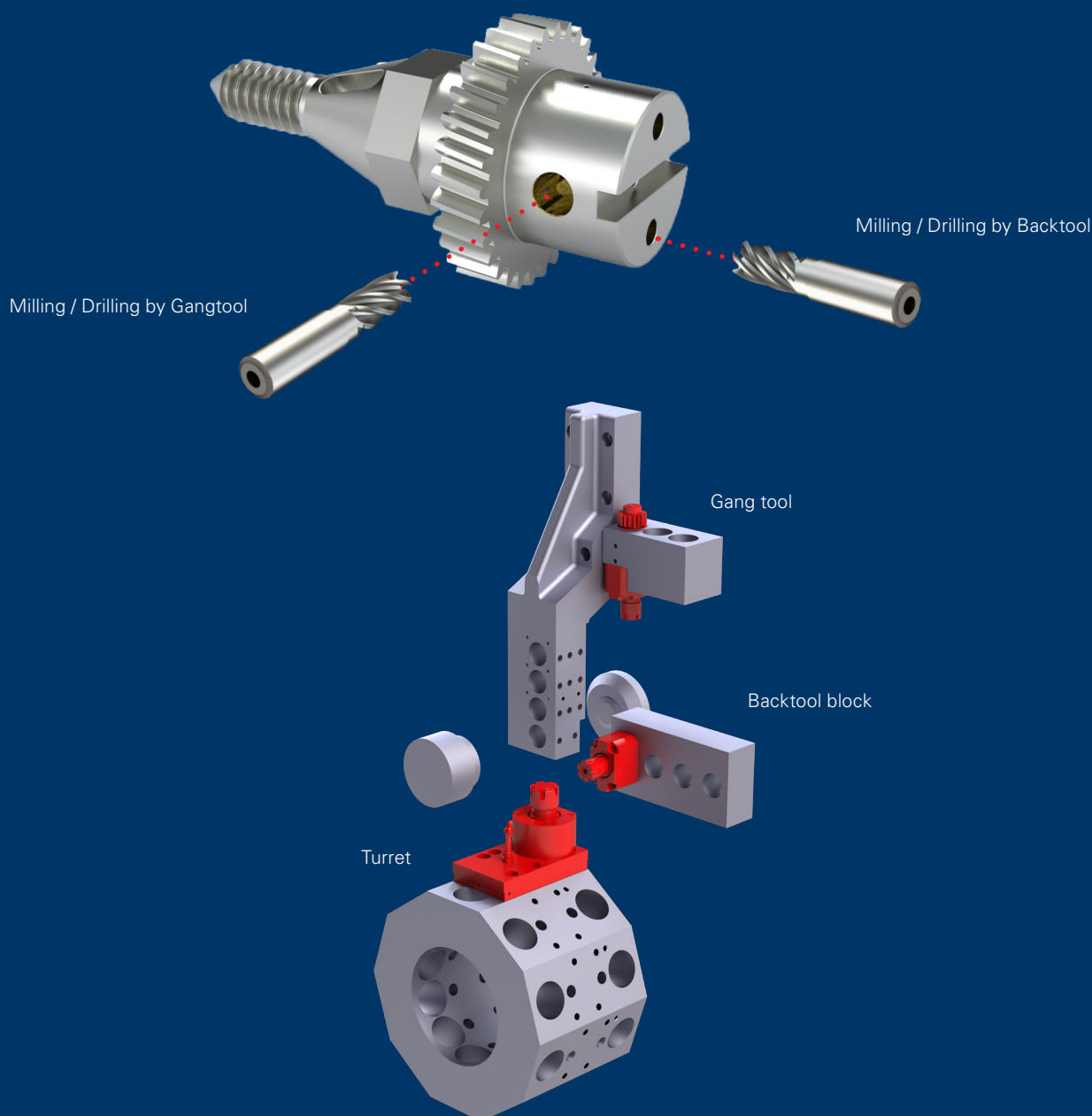
We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

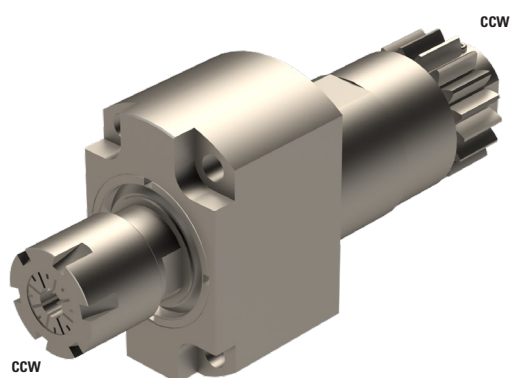
AXIAL DRILLING / MILLING TOOLS

The machining direction of radial tools is usually 0° relative to the drive. These tools make it possible to carry out radial machining on the gear tool. On the backtool block, these tools are used for face machining.

These tools are available in different versions such as spindle cooling, transmission, multi-spindle, etc.



GSC-1110



ER16



1:1

Position

Upper gang tool

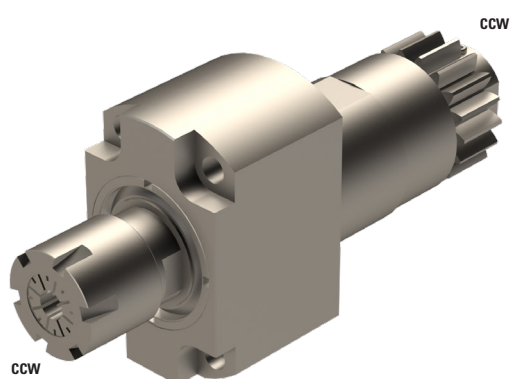
Machines Types

A20-3F7N	M220-III
A232-VII	M220-V
A32-VII	M232-III
A320-VII	M232-V
D25-VII	M320-III
L20E-2M8	M320-V
L20E-2M10	M332-III
L20E-2M12	M332-V
L32-1M8	M32-4M5
L32-1M10	M32-4M8
L32-1M12	M32-5M5
	M32-5M7
	M32-5M8

Notes



GSC1110-L



ER16



1:1

Position

Upper gang tool

Machines Types

A20-3F7N	M220-III
A232-VII	M220-V
A32-VII	M232-III
A320-VII	M232-V
D25-VII	M320-III
L20E-2M8	M320-V
L20E-2M10	M332-III
L20E-2M12	M332-V
L32-1M8	M32-4M5
L32-1M10	M32-4M8
L32-1M12	M32-5M5
	M32-5M7
	M32-5M8

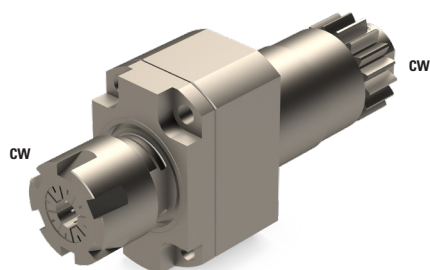
Notes

LENGTH : 70mm



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

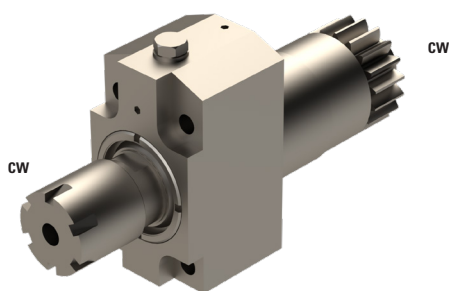
GSC-1113



		ER20
		1:1
Position		Upper gang tool post
Machines Types	A232-VII	L20V
	A32-VII	L20VII
	A320-VII	L20VIII
	L20E2M8	L20X
	L20E2M10	L32-1M8
	L20E-1M12	L32-1M10
	L20E-IX	L32-1M12
Notes		



GSC1310-HP-II



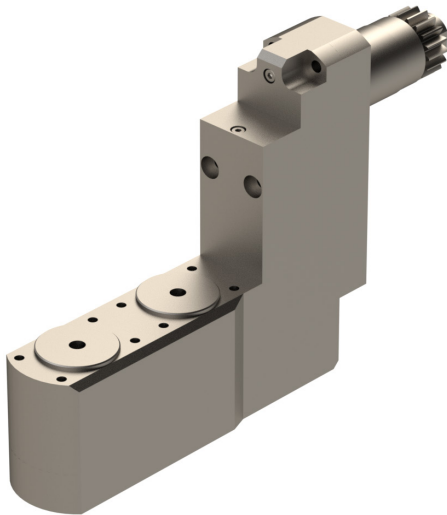
		ER16
		1:1
Position		Upper gang tool post
Machines Types	A232-VII	L220-2M8
	A32-VII	L220-2M10
	A320-VII	M32-4M5
	D25-VII	M32-4M8
	L32-1M8	M32-5M5
	L32-1M10	M32-5M7
	L32-1M12	M32-5M8
Notes		

Intern, max 150 [bar]
 There is a need for an oil filtered at 50µm.
 The high pressure flexible tubes are not delivered.
 Tapping for high pressure flexible tube: M6.
 Possibility of ordering a high pressure flexible tube L:300 mm. Article: «Kit d'arrosage 010» and «Kit d'arrosage 047»
 Input: M6 (M)
 Output: 1/8" (M)
 Pression max = 200 bar



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

GSE1505



 2xØ31mm

 1:1 or 1:4

Position Upper gang tool post

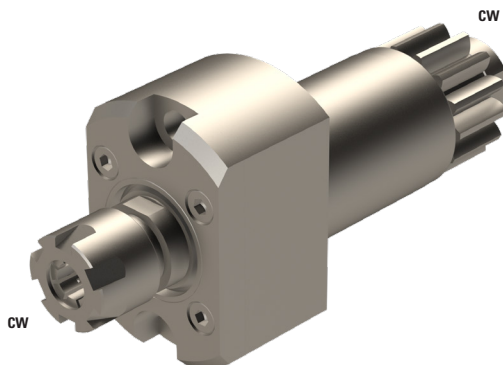
Machines Types	A232-VII	L220-2M8
	A32-VII	L220-2M10
	A320-VII	M32-4M5
	D25-VII	M32-4M8
	L32-1M8	M32-5M5
	L32-1M10	M32-5M7
	L32-1M12	M32-5M8

Notes

Possibility to use the tool holders GSC-1110 and GSC-1110-4x for axial machining



MSC-507-II



 ER11

 1:1

Position Upper gang tool post
Back gang tool post
Front gang tool post

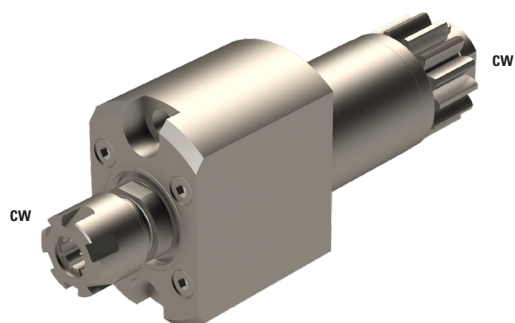
Machines Types	A20-VII	M320-V
	A20-3F7N	M332-III
	A320-VII	M332-V
	L12-1M7	M32-4M5
	L20E-2M12	M32-4M8
	L20E-2M10	M32-5M5
	L20E-2M8	M32-5M7
	L20E-IX	M32-5M8
	L220VII	M212-C
	L220IX	M212-V
	L20X	M216-C
	L32-1M12	M216-V
	L32-1M10	M312-III
	L32-1M8	M312-V
	M220-III	M312-VII
	M220-V	M316-III
	M232-III	M316-V
	M232-V	M16-4M5
	M320-III	M16-4M8

Notes



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

MSC-507-L



ER11



1:1

Position

Upper gang tool post
Back gang tool post
Front gang tool post

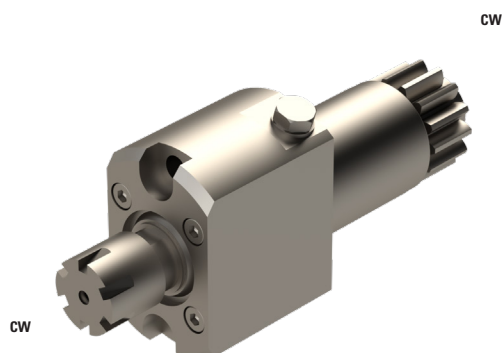
Machines Types

A20-VII	M320-V
A20-3F7N	M332-III
A320-VII	M332-V
L12-1M7	M32-4M5
L20E-2M12	M32-4M8
L20E-2M10	M32-5M5
L20E-2M8	M32-5M7
L20E-IX	M32-5M8
L220VIII	M212-C
L220IX	M212-V
L20X	M216-C
L32-1M12	M216-V
L32-1M10	M312-III
L32-1M8	M312-V
M220-III	M312-VII
M220-V	M316-III
M232-III	M316-V
M232-V	M16-4M5
M320-III	M16-4M8

Notes



MSC507-HP



ER11



1:1

Position

Upper gang tool post
Back gang tool post
Front gang tool post

Machines Types

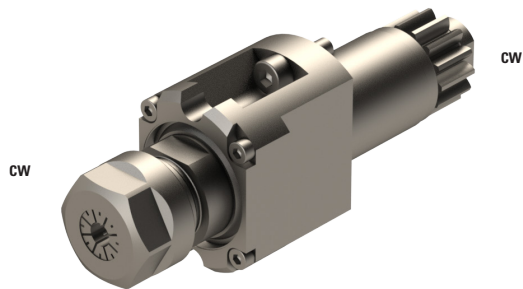
A20-VII	M220-V
A20-3F7N	M212-C
A320-VII	M212-V
L12-1M7	M216-C
L20E-2M12	M216-V
L20E-2M10	M312-III
L20E-2M8	M312-V
L20E-IX	M312-VII
L20X	M316-III
L32-1M12	M316-V
L32-1M10	M16-4M5
L32-1M8	M16-4M8
M220-III	

Notes



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

MSC-512



ER16



1:1

Position

 Upper gang tool post
 Front gang tool post

Machines Types

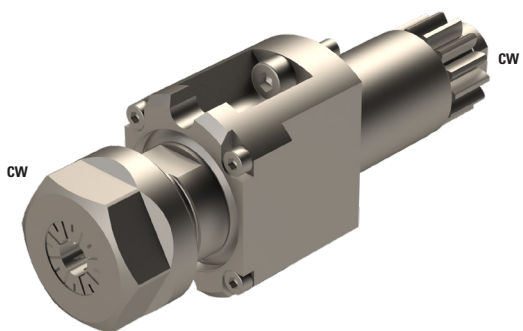
A20-3F7N	M212-V
A320-VII	M216-C
L12-1M7	M216-V
L20E-2M12	M312-III
L20E-2M10	M312-V
L20E-2M8	M312-VII
L20E-IX	M316-III
L20X	M316-V
M212-C	M16-4M5
	M16-4M8

Notes

Position T08-T10 with tool holder MSC-507-II on his side.



MSC-513



ER20



1:1

Position

 Upper gang tool post
 Front gang tool post

Machines Types

A20-3F7N	M212-V
A320-VII	M216-C
L12-1M7	M216-V
L20E-2M12	M312-III
L20E-2M10	M312-V
L20E-2M8	M312-VII
L20E-IX	M316-III
L20X	M316-V
M212-C	M16-4M5
	M16-4M8

Notes

Position T08-T10 with tool holder MSC-507-II on his side.

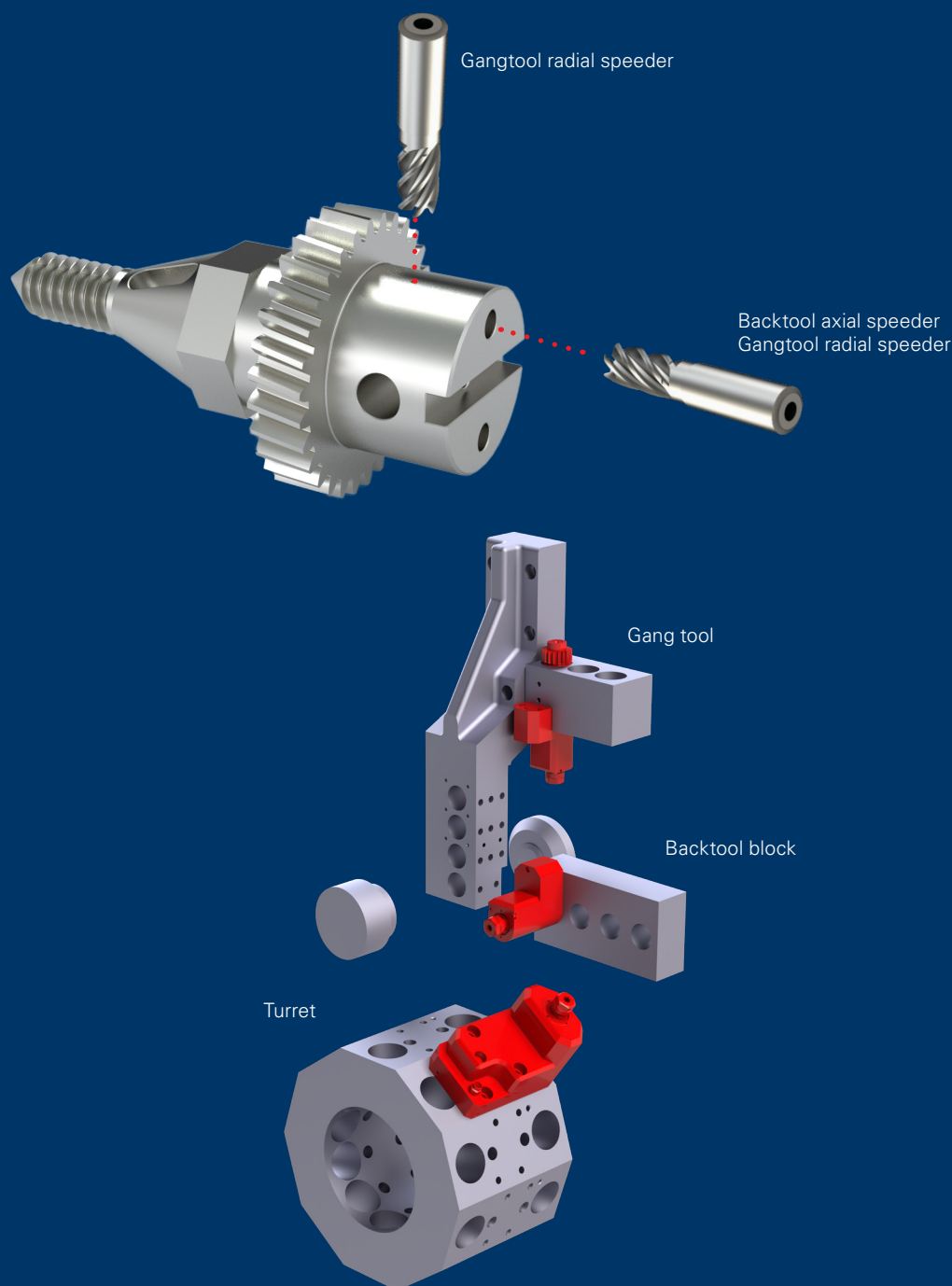


We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

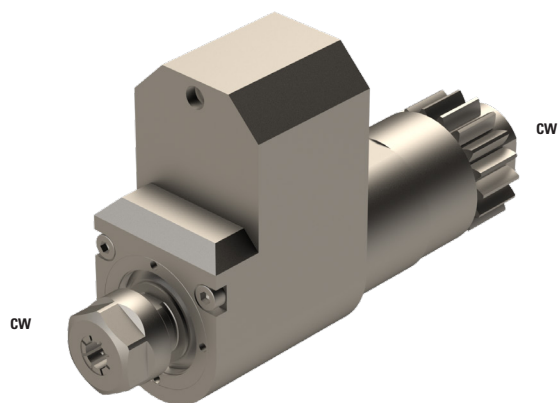
We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

ACCELERATED TOOLS (SPEEDERS)

The accelerated tools, also called speeder, are internally translated to achieve higher speeds. This is necessary if the required cutting speed cannot be achieved with the machine's rotational speeds. Engraving, small drillings and milling can be done with them. The tool size is under 3mm as usual. The tools are available with ratios from 1:2 to 1:3.8 and reach a maximum speed of 38'000 rpm. These tools are available in different versions such as spindle cooling, transmission, multi-spindle, etc



BSC-510-3X



ER11



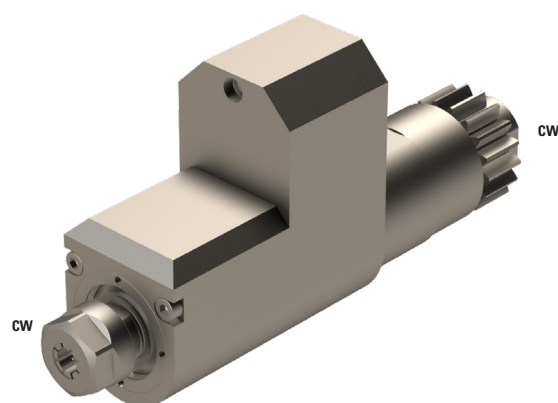
1:3

Position

Upper gang tool post

Machines TypesA20-VII
A20-3F7N**Notes**

BSC-510-3X-L



ER11



1:3

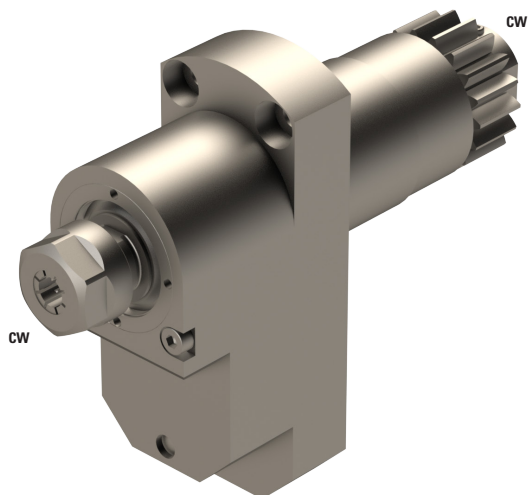
Position

Upper gang tool post

Machines TypesA20-VII (Only for old
version)**Notes**

We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

BSC-610-3X



ER11



1:3

Position

Upper gang tool post

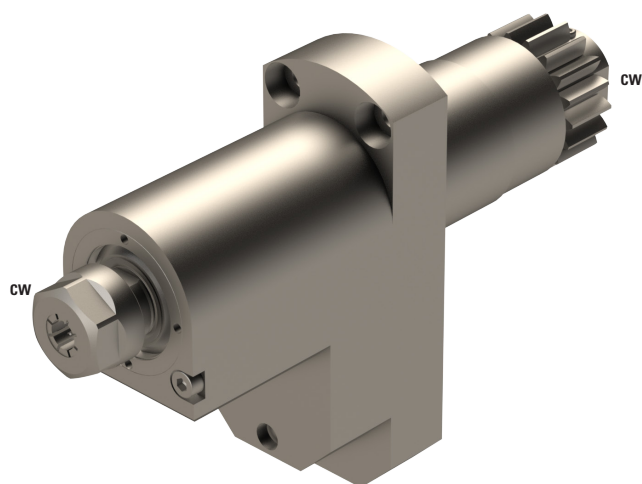
Machines Types

	M220-V
	M232-III
A232-VII	M232-V
A32-VII	M320-III
A320-VII	M320-V
D25-VII	M332-III
L32-1M8	M332-V
L32-1M10	M32-4M5
L32-1M12	M32-4M8
M220-III	M32-5M5
	M32-5M7
	M32-5M8

Notes



BSC-610-L-3X



ER11



1:3

Position

Upper gang tool post

Machines Types

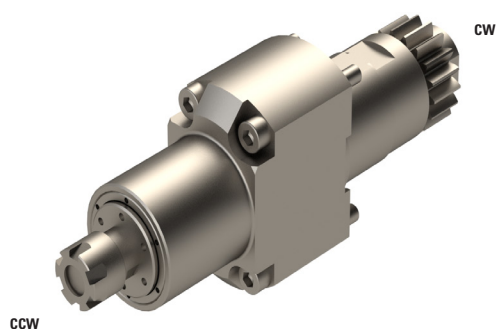
	M232-III
	M232-V
A232-VII	M320-III
A32-VII	M320-V
A320-VII	M332-III
D25-VII	M332-V
L32-1M8	M32-4M5
L32-1M10	M32-4M8
L32-1M12	M32-5M5
M220-III	M32-5M7
M220-V	M32-5M8

Notes



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

BSC1107-4X



ER11



1:3.8

Position

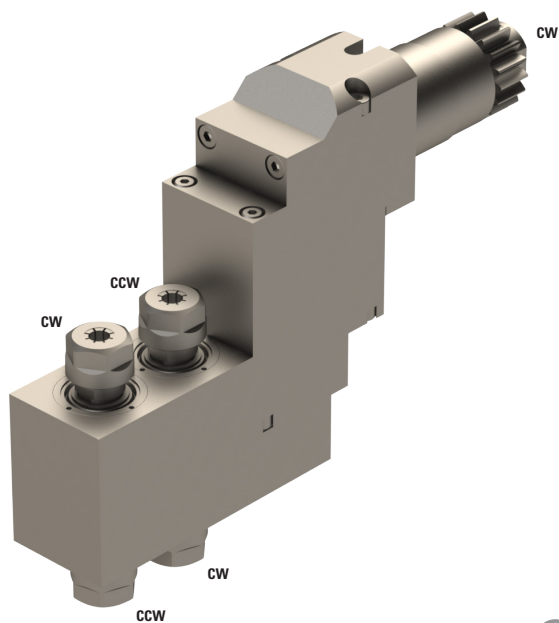
 Upper gang tool post
 Front gang tool post

Machines Types

A232-VII	L220-2M8
A32-VII	L220-2M10
A320-VII	M32-4M5
D25-VII	M32-4M8
L32-1M8	M32-5M5
L32-1M10	M32-5M7
L32-1M12	M32-5M8

Notes


BSE-2007-2X



2xER11+2xER11



1:2

Position

Upper gang tool post

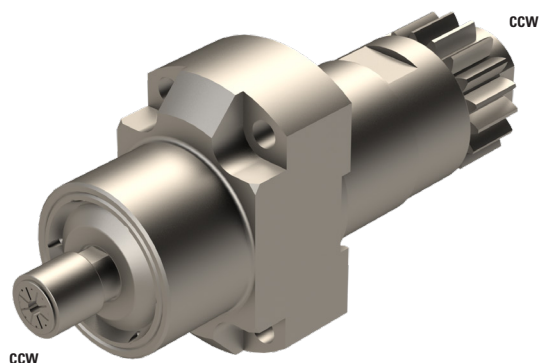
Machines Types

 A20-VII
 A20-3F7N

Notes


We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

GSC-1110-4X



 ER08

 1:3.8

Position Upper gang tool post

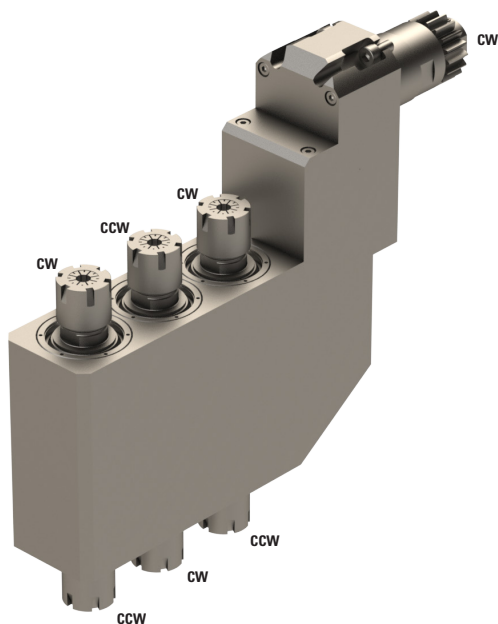
Machines Types

A232-VII	M232-III
A32-VII	M232-V
A320-VII	M320-III
D25-VII	M320-V
L32-1M8	M332-III
L32-1M10	M332-V
L32-1M12	M32-4M5
M220-III	M32-4M8
M220-V	M32-5M5
	M32-5M7
	M32-5M8

Notes



GSE-1710-2X



 3xER16+3xER16

 1:2

Position Upper gang tool post

Machines Types

A232-VII
A32-VII
A320-VII
L32-1M8
L32-1M10
L32-1M12

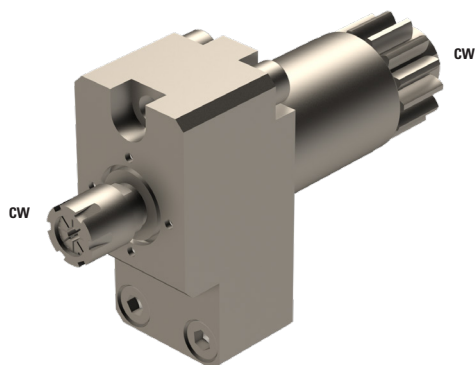
Notes

On block L32U30B (Version X and VIII) Position T10
On block L32U32B (Version IX and XII) Position T08-09



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

GSE-3307-3X



ER08



1:3

Position

Front gang tool post

Machines Types

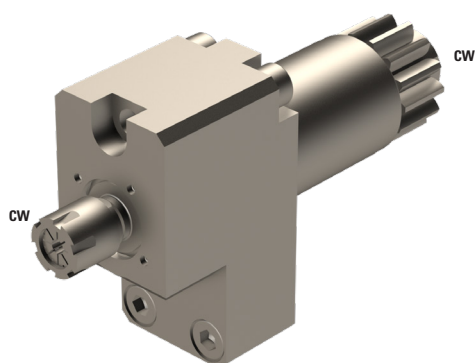
A20-3F7N	L20E-2M12
A20-VII	L20E-IX
A320-VII	L20X
L12-1M7	L32-1M8
L20E-2M8	L32-1M10
L20E-2M10	L32-1M12

Notes

Use at maximum torque of 1500Nm



GSE-3307-L-3X



ER08



1:3

Position

Front gang tool post

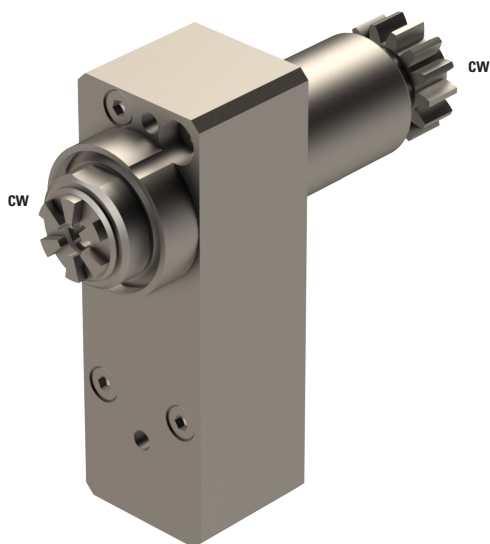
Machines Types

A20-3F7N	L20E-2M12
A20-VII	L20E-IX
A320-VII	L20X
L12-1M7	L32-1M8
L20E-2M8	L32-1M10
L20E-2M10	L32-1M12

Notes


We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

GSE-3507-3X



ER11



1:3

Position

Front gang tool post

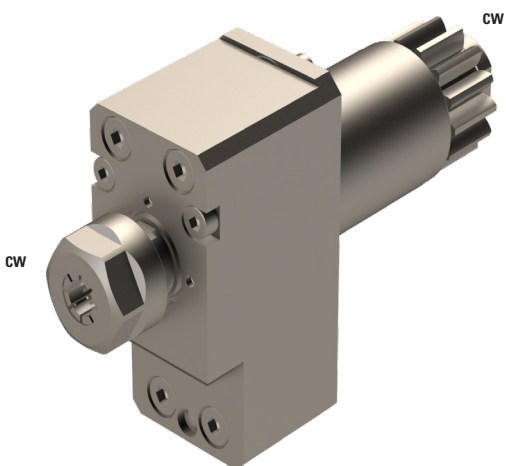
Machines Types

A20-3F7N	L20E-2M12
A20-VII	L20E-IX
A320-VII	L20X
L12-1M7	L32-1M8
L20E-2M8	L32-1M10
L20E-2M10	L32-1M12

Notes



MSC-507-2X



ER11



1:2

Position

Upper gang tool post
Back gang tool post
Front gang tool post

Machines Types

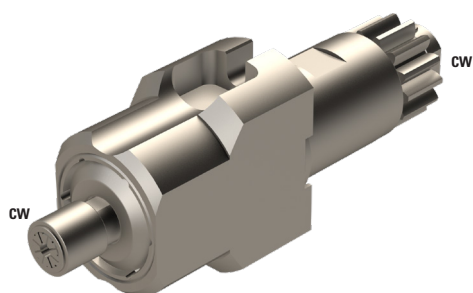
A20-VII	M332-III
A20-3F7N	M332-V
A320-VII	M32-4M5
L12-1M7	M32-4M8
L20E-2M12	M32-5M5
L20E-2M10	M32-5M7
L20E-2M8	M32-5M8
L20E-IX	M212-C
L20X	M212-V
L32-1M12	M216-C
L32-1M10	M216-V
L32-1M8	M312-III
M220-III	M312-V
M220-V	M312-VII
M232-III	M316-III
M232-V	M316-V
M320-III	M16-4M5
M320-V	M16-4M8

Notes



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

MSC-507-4X



ER08



1:3.8

Position

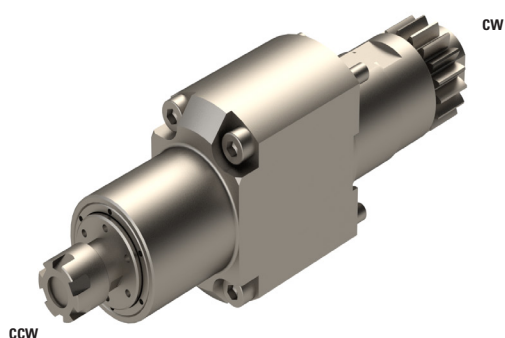
 Upper gang tool post
 Back gang tool post
 Front gang tool post

Machines Types

A20-VII	M332-III
A20-3F7N	M332-V
A320-VII	M32-4M5
L12-1M7	M32-4M8
L20E-2M12	M32-5M5
L20E-2M10	M32-5M7
L20E-2M8	M32-5M8
L20E-IX	M212-C
L20X	M212-V
L32-1M12	M216-C
L32-1M10	M216-V
L32-1M8	M312-III
M220-III	M312-V
M220-V	M312-VII
M232-III	M316-III
M232-V	M316-V
M320-III	M16-4M5
M320-V	M16-4M8

Notes


RSC1107-4X



ER11



1:3.8

Position

Back gang tool post

Machines Types

A232-VII	L220-2M8
A32-VII	L220-2M10
A320-VII	M32-4M5
D25-VII	M32-4M8
L32-1M8	M32-5M5
L32-1M10	M32-5M7
L32-1M12	M32-5M8

Notes

RPM max. 22'800



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

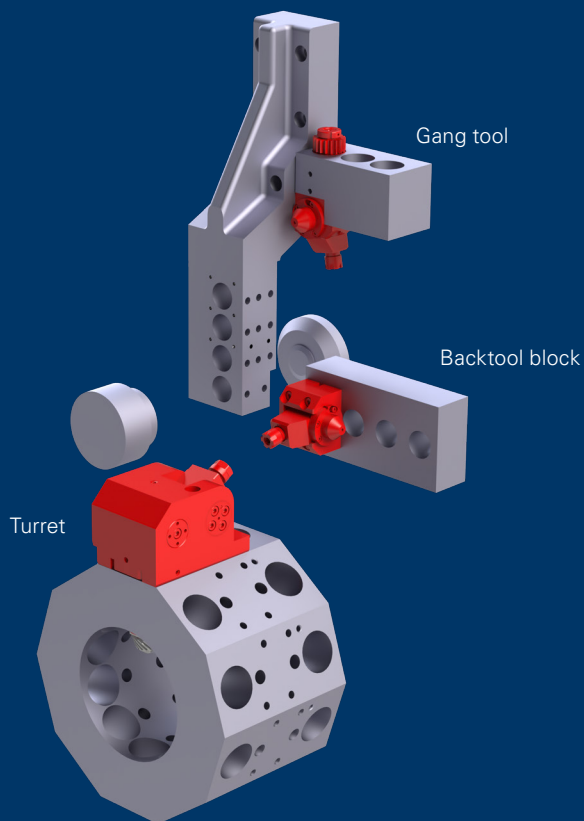
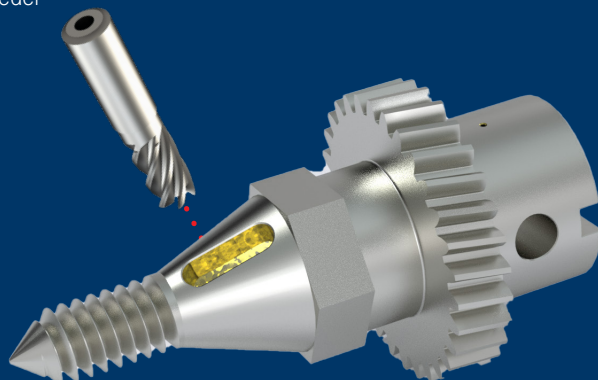
We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

ANGLE ADJUSTABLE TOOLS

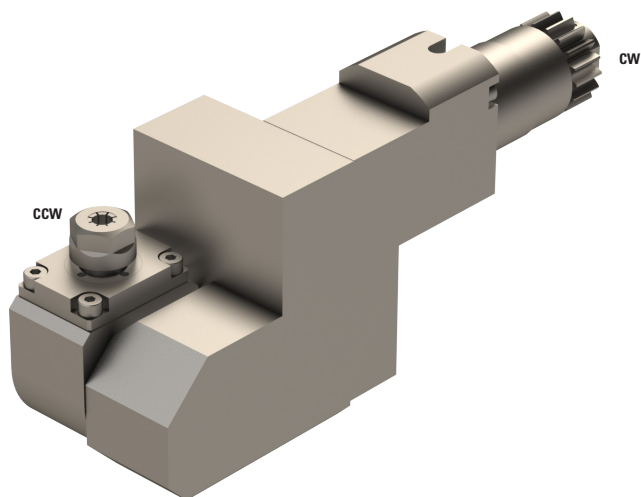
Most bar turning machines are not equipped with a fourth axis (B axis) for inclined drilling and milling. For this reason, tools have been developed with which an angle of 0° - 90° can be set. The adjustment of the angle is done manually.

Thus, the doors are open to all machines to produce complex workpieces in one clamping.

Gangtool radial speeder



BSA-107



ER11



1:1

Position

Upper gang tool post

Machines Types

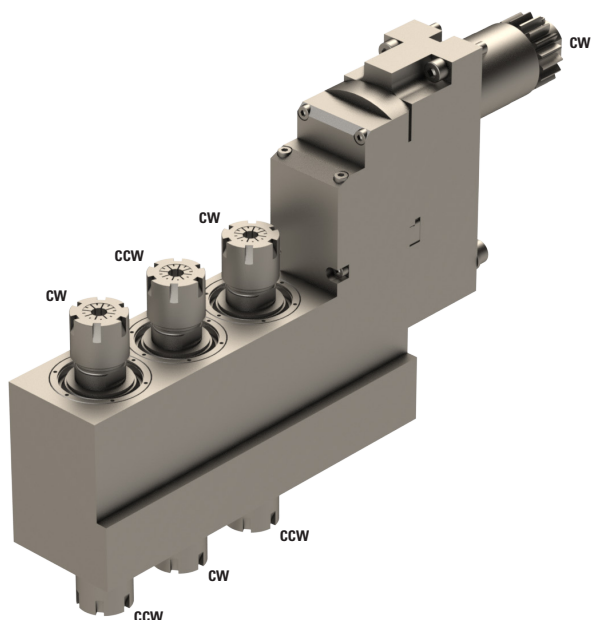
A320

Notes

Adjustable 0°-180°
Crash with U150B by working with tool position T11 and T12



BSA-2010



3xER16+ 3xER16



1:1

Position

Upper gang tool post

Machines Types

	M232-III
A232-VII	M232-V
A32-VII	M320-III
A320-VII	M320-V
D25-VII	M332-III
L32-1M8	M332-V
L32-1M10	M32-4M5
L32-1M12	M32-4M8
M220-III	M32-5M5
M220-V	M32-5M7
	M32-5M8

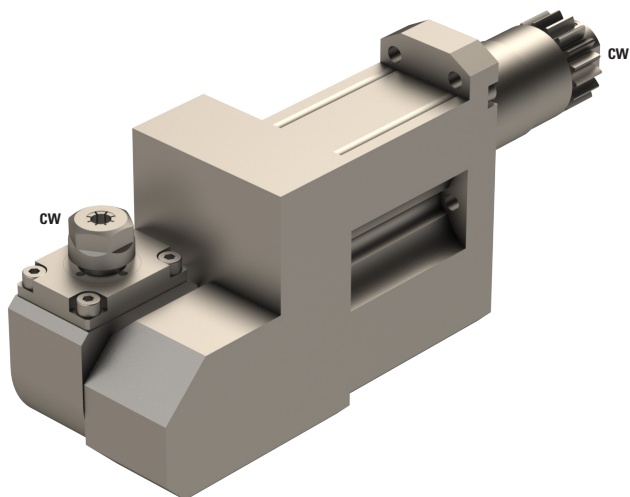
Notes

Adjustable 0°-21°
By using angle adjustment, T10 is covered by this tool.



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

BSA-3107



ER11



1:1

Position

Upper gang tool post

Machines Types

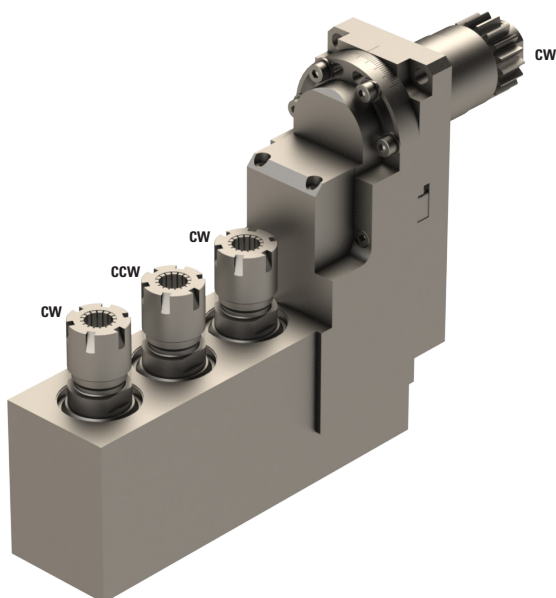
A232-VII
A32-VII
A320-VII

Notes

Adjustable 0°-180°
Crash with U150B / U151B by working with tool position
T11 and T12



GSA-1510



3xER16



1:1

Position

Upper gang tool post

Machines Types

A232-VII	L220-2M8
A32-VII	L220-2M10
A320-VII	M32-4M5
D25-VII	M32-4M8
L32-1M8	M32-5M5
L32-1M10	M32-5M7
L32-1M12	M32-5M8

Notes

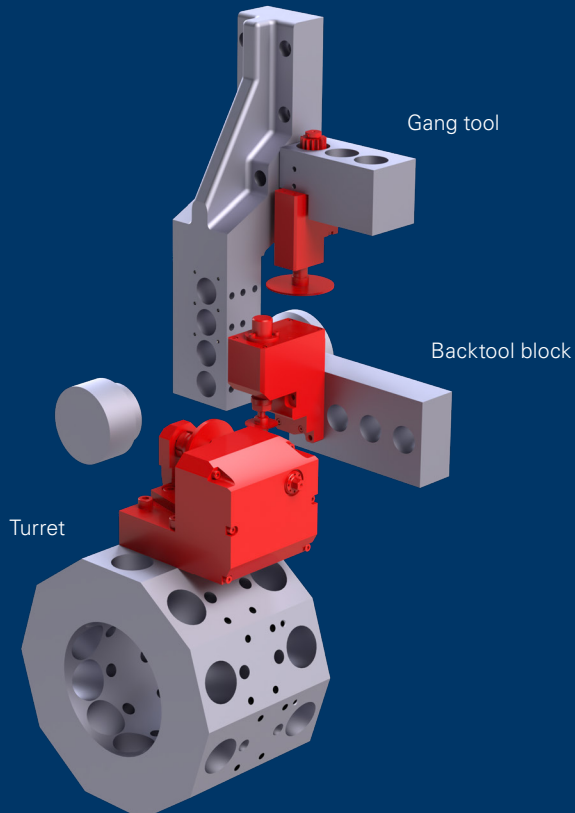
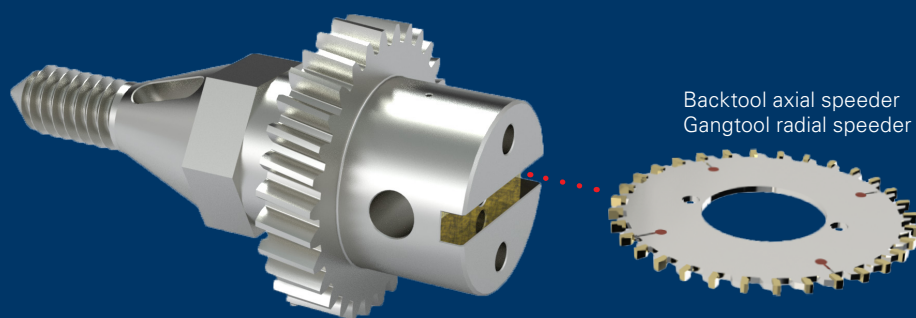
Need 2 tool positions
Adjustable 0°-30°



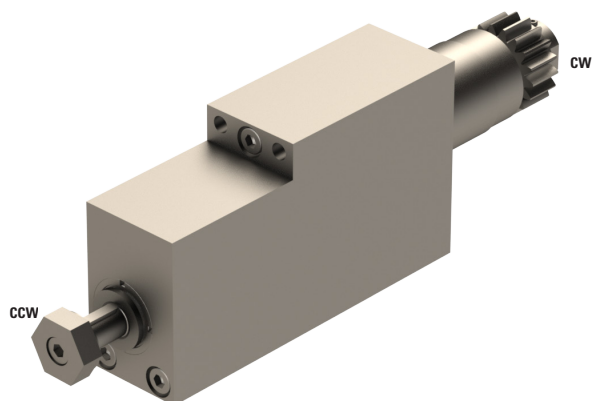
We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

SAWBLADE TOOLS

On a bar lathe, the distance between a tool and the guide bush is very short in order to achieve maximum stability of the workpiece and therefore minimum vibration. The distance from the tool axis to the zero point of the machine is between 2 mm and 10 mm, depending on the type of machine. It is therefore impossible to make a niche. For this reason, tools have been developed that have a greater distance from the machine zero point and whose spindle has a very stable design. Thus, the forces that occur during such a process can be absorbed without damaging the bearings of the tool holder. Side milling cutters with a diameter of up to 75 mm can be used.



GSS1035-DEC



10mm



1:1

Position

Upper gang tool post

Machines Types

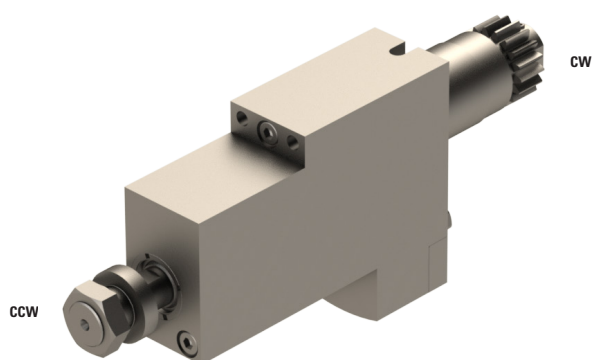
A232-VII	L20V
A32-VII	L20VII
A320-VII	L20VIII
L20E2M8	L20X
L20E2M10	L32-1M8
L20E-1M12	L32-1M10
L20E-IX	L32-1M12

Notes

Max. tool Ø50mm
Max. thickness 15.5mm



GSS1307-DEC



16



1:1

Position

Upper gang tool post

Machines Types

A20
L20
A32/L32
M32

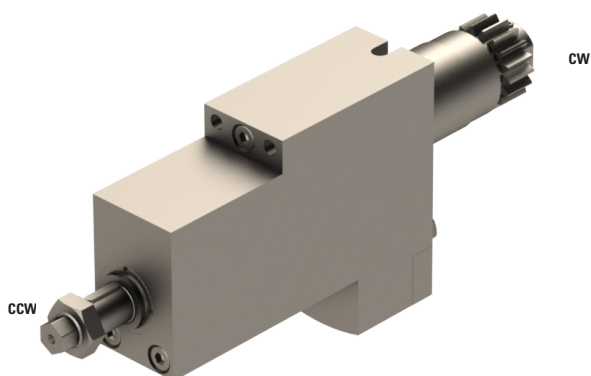
Notes

Diameter of the mill : Ø63 mm max.
Width of mill cutter : 6mm max.



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

GSS1335-DEC



 13

 1:1

Position Upper gang tool post

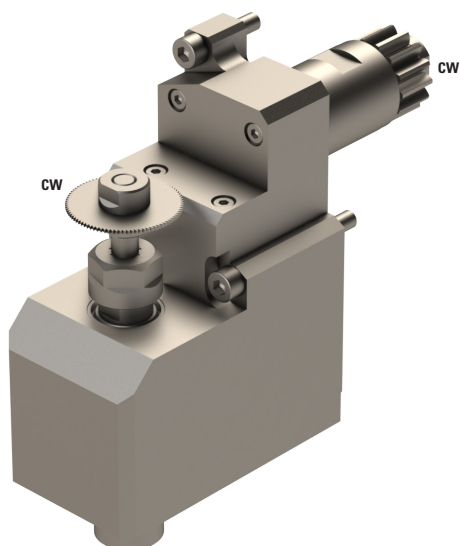
Machines Types
A20
L20
A32/L32
M32

Notes

Diameter of the mill : Ø58mm max.
Width of mill cutter : 15mm max



GSS1530



 ER11

 5:3

Position Front gang tool post

Machines Types
A20-3F7N
L12-1M7
L20E-2M8
L20E-2M10
L20E-2M12
L20E-IX
L20X

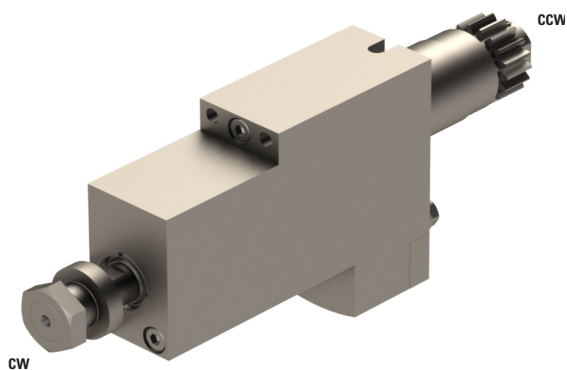
Notes

RPM max. : 5'400
Max. tool Ø63 mm
Max. cutter thickness 2 mm



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

GSS15835-DEC



Ø 15.875mm (Ø5/8")

⚙️ 1:1

Position Upper gang tool post

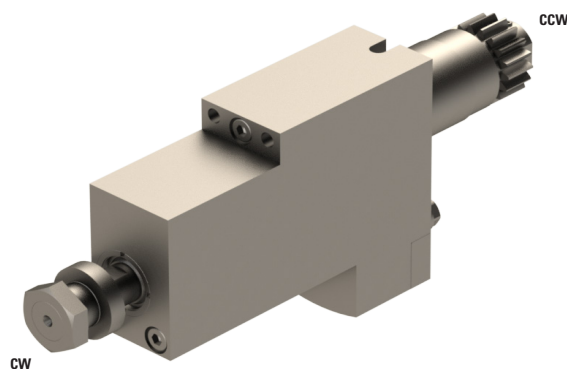
Machines Types	A232-VII	L220-2M8
	A32-VII	L220-2M10
	A320-VII	M32-4M5
	D25-VII	M32-4M8
	L32-1M8	M32-5M5
	L32-1M10	M32-5M7
	L32-1M12	M32-5M8

Notes

Diameter of the mill : Ø63mm max.
Width of mill cutter : 8mm max.



GSS15835-DEC-II



Ø 15.875mm (Ø5/8")

⚙️ 1:1

Position Upper gang tool post

Machines Types	A232-VII	L220-2M8
	A32-VII	L220-2M10
	A320-VII	M32-4M5
	D25-VII	M32-4M8
	L32-1M8	M32-5M5
	L32-1M10	M32-5M7
	L32-1M12	M32-5M8

Notes

Diameter of the mill : Ø63mm max.
Width of mill cutter : 8mm max.



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

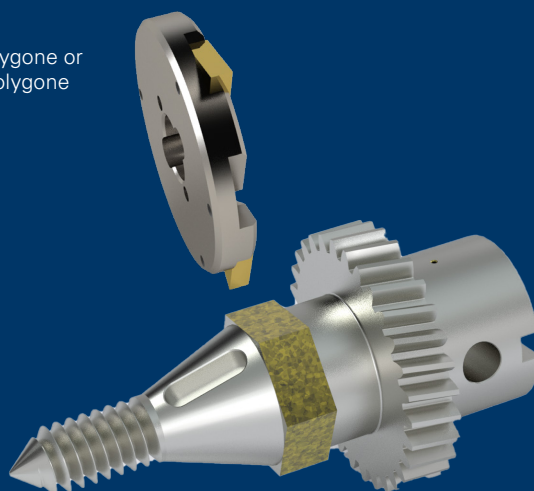
We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

POLYGON TOOLS

The polygon turning unit has a multitude of inserts, and is synchronized so that when an insert cuts the turning bar stock, it cuts the bar at the same radial position each time the workpiece rotates = counterrun. This enables geometries such as hexes, squares and flats to be machined at faster speeds than by milling.

The surfaces can be produced using the grooving method as well as the longitudinal turning method. It can also be used to copy a chamfer (deburring the surface).

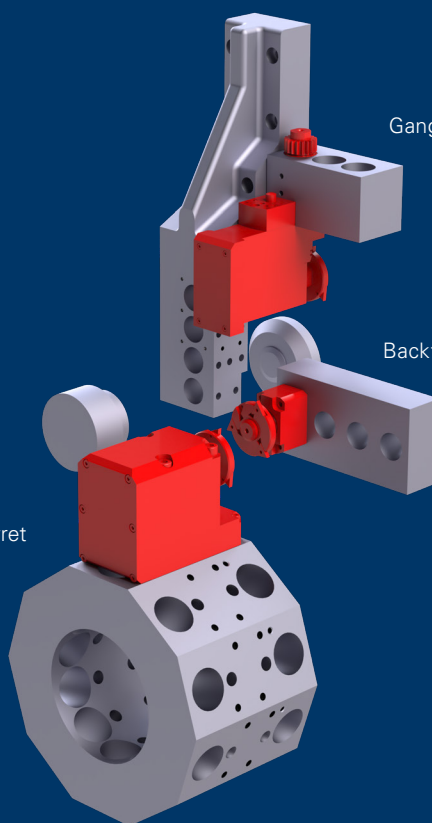
Backtool axial Polygone or
Gangtool radial Polygone



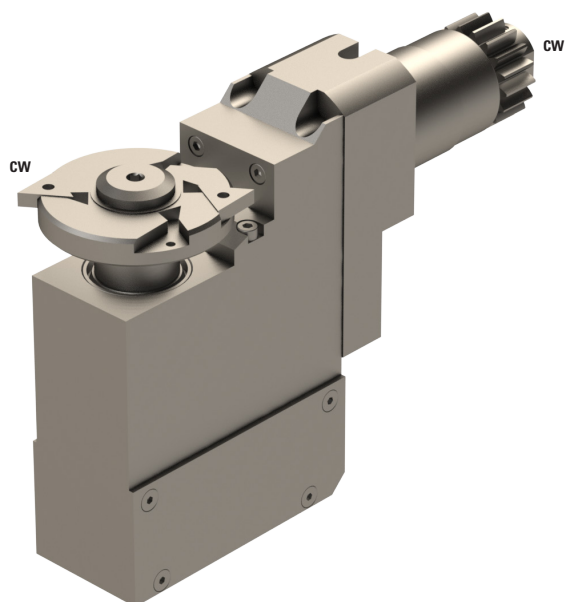
Gang tool

Backtool block

Turret



BSP-509

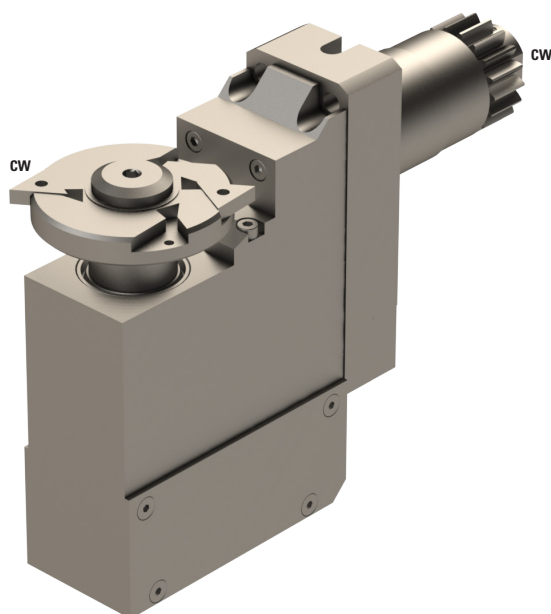


	Ø13mm
	1:1
Position	Upper gang tool post
Machines Types	A20-VII A20-3F7N
Notes	

Max. tool Ø60 mm



BSP-510



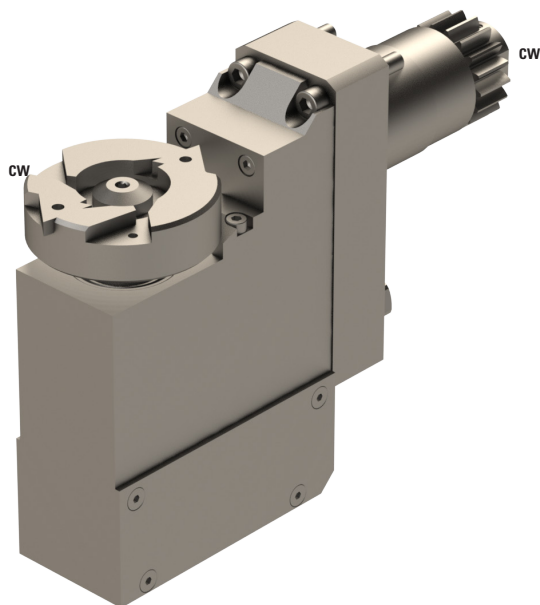
	Ø13																		
	1:1																		
Position	Upper gang tool post																		
Machines Types	<table border="0"> <tr> <td>A232-VII</td><td>M232-III</td></tr> <tr> <td>A32-VII</td><td>M232-V</td></tr> <tr> <td>A320-VII</td><td>M320-III</td></tr> <tr> <td>D25-VII</td><td>M320-V</td></tr> <tr> <td>L32-1M8</td><td>M332-III</td></tr> <tr> <td>L32-1M10</td><td>M332-V</td></tr> <tr> <td>L32-1M12</td><td>M32-4M5</td></tr> <tr> <td>M220-III</td><td>M32-4M8</td></tr> <tr> <td>M220-V</td><td></td></tr> </table>	A232-VII	M232-III	A32-VII	M232-V	A320-VII	M320-III	D25-VII	M320-V	L32-1M8	M332-III	L32-1M10	M332-V	L32-1M12	M32-4M5	M220-III	M32-4M8	M220-V	
A232-VII	M232-III																		
A32-VII	M232-V																		
A320-VII	M320-III																		
D25-VII	M320-V																		
L32-1M8	M332-III																		
L32-1M10	M332-V																		
L32-1M12	M32-4M5																		
M220-III	M32-4M8																		
M220-V																			
Notes																			

Max. tool Ø 60 mm



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

BSP-511



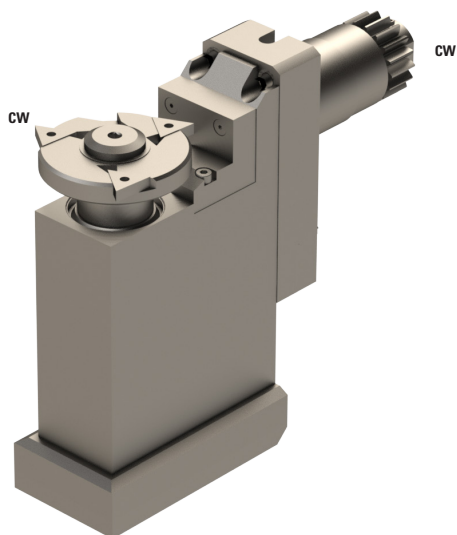
	Ø10	
	1:1	
Position	Upper gang tool post	
Machines Types	A232-VII	M232-III
	A32-VII	M232-V
	A320-VII	M320-III
	D25-VII	M320-V
	L32-1M8	M332-III
	L32-1M10	M332-V
	L32-1M12	M32-4M5
	M220-III	M32-4M8
	M220-V	

Notes

Max. tool Ø 55 mm



BSP-513



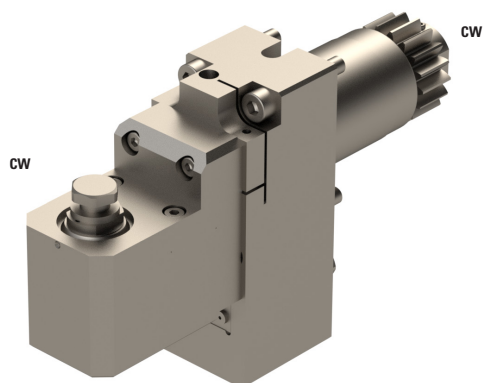
	Ø13mm
	1.5:1
Position	Upper gang tool post
Machines Types	A20-VII
	A20-3F7N
	A32
	L220
	L32

Notes

Max. tool Ø70 mm
Max. thickness 8.3 mm



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

**MODULAR
SYSTEM****CITIZEN6-GSP-218**

Ø	8
---	---

⚙️➕	1:1
-----	-----

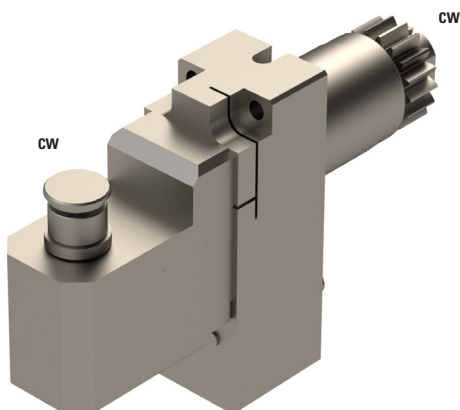
Position	Upper gang tool post
----------	----------------------

Machines Types

A232-VII	L20E-2M12
A32-VII	L20E-IX
A320-VII	L32-1M8
L20E-2M8	L32-1M10
L20E-2M10	L32-1M12

Notes

Adjustable $\pm 15^\circ$
 Diameter of the mill : $\varnothing 45$ mm max.
 Width of mill cutter : 5mm max.
 The CITIZEN6-PCR base and GSP-218 head are together on this tool.
 Possibility to order them individually.

**MODULAR
SYSTEM****CITIZEN6-GSP-518**

—■—	15.875mm
-----	----------

⚙️➕	1:1
-----	-----

Position	Upper gang tool post
----------	----------------------

Machines Types

A232-VII	L20E-2M12
A32-VII	L20E-IX
A320-VII	L32-1M8
L20E-2M8	L32-1M10
L20E-2M10	L32-1M12

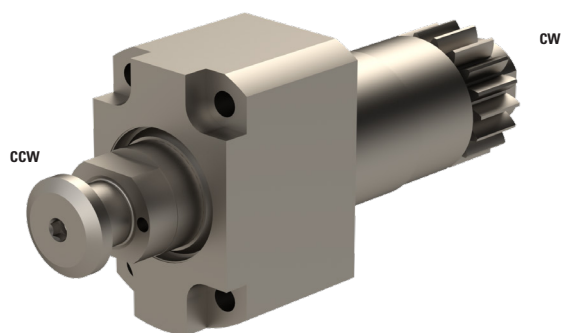
Notes

Brush tool holders
 Adjustable $\pm 15^\circ$
 Diameter of the brush : $\varnothing 54$ mm max.
 Width of mill brush : 10mm max.
 The CITIZEN6-PCR base and GSP-518 head are together on this tool.
 Possibility to order them individually.



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

RSP-013



	13
	1:1
Position	Upper gang tool post
Machines Types	A20 A32 L220 L32
Notes	

Diameter of the mill : Ø72mm max.
Width of mill cutter : 8.3mm max.



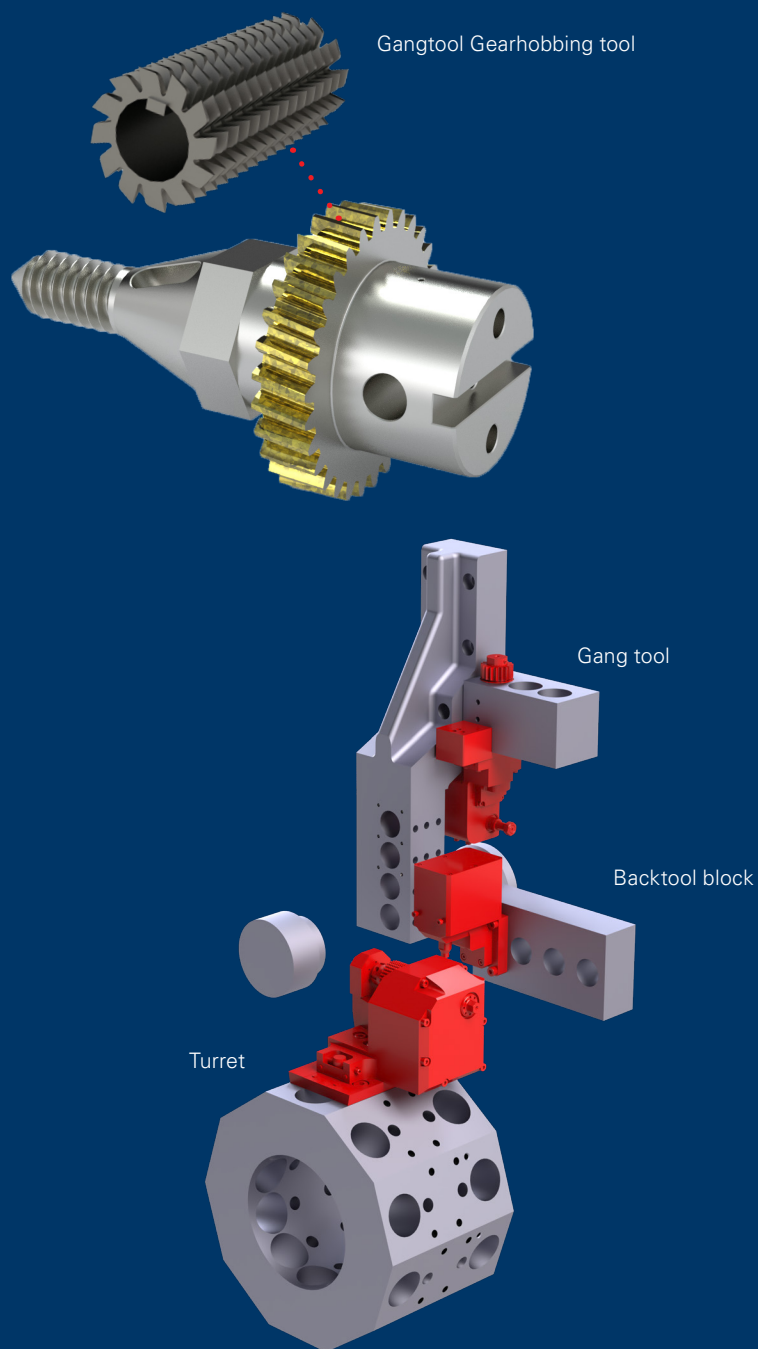
We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

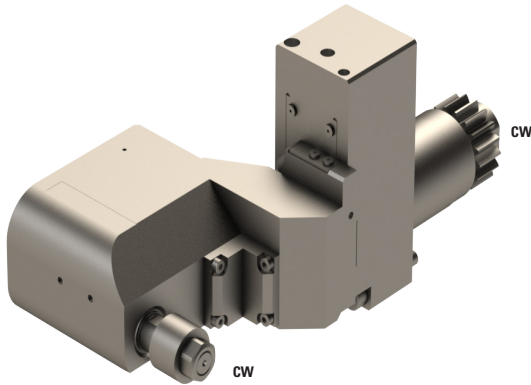
HOBGING TOOLS

When gear cutting on a bar-turning machine, make sure that the main spindle turns synchronously with the tool. For this purpose, the machine manufacturer provides a macro that guarantees synchronism and simplifies programming.

The smallest gears have a module of 0.03mm and the largest a module of 2mm.

Furthermore spur and helical gears can be produced.



**MODULAR
SYSTEM****CITIZEN6-LSH-180**

8mm



1:1

Position

Upper gang tool post

Machines Types

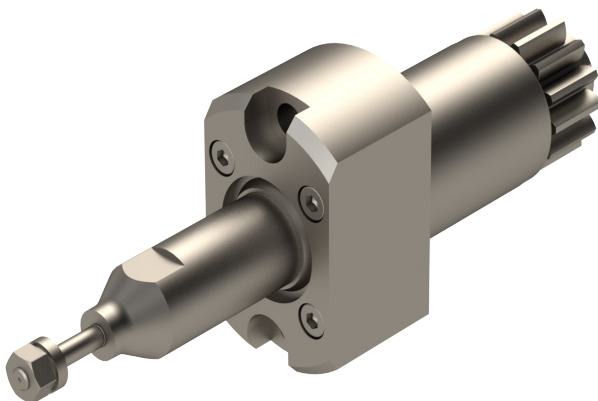
A232-VII	L20E-2M12
A32-VII	L20E-IX
A320-VII	L32-1M8
L20E-2M8	L32-1M10
L20E-2M10	L32-1M12

Notes

The CITIZEN6-PCR base and LSH-180 head are together on this tool. Possibility to order them individually.

Adjustable -2° to +15° with max. tool Ø18 mm and max. thickness 12 mm

Adjustable -2° to +4° with max. tool Ø24 mm and max. thickness 12 mm

**MSH50735**

Ø3.5mm



1:1

Position

Upper gang tool post

Machines Types

L12
L20
L20E
L20X
L220
A220
A32

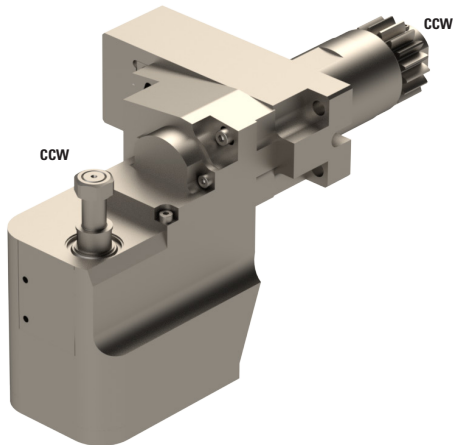
Notes

For hobbing cutter Ø3.5mm



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

LSH280

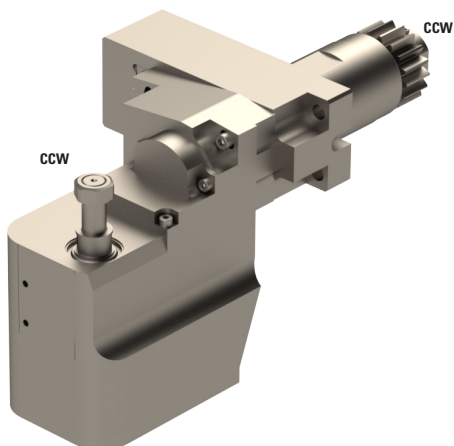


	Ø8
	1:1
Position	Upper gang tool post
Machines Types	A320
Notes	

Diameter of the mill : Ø18mm max.
Width of mill cutter : 12 mm max.



LSH280-II



	Ø8
	3:2
Position	Upper gang tool post
Machines Types	A320
Notes	

Adjustable $\pm 5^\circ$
Diameter of the mill : Ø18mm max.
Width of mill cutter : 12 mm max.

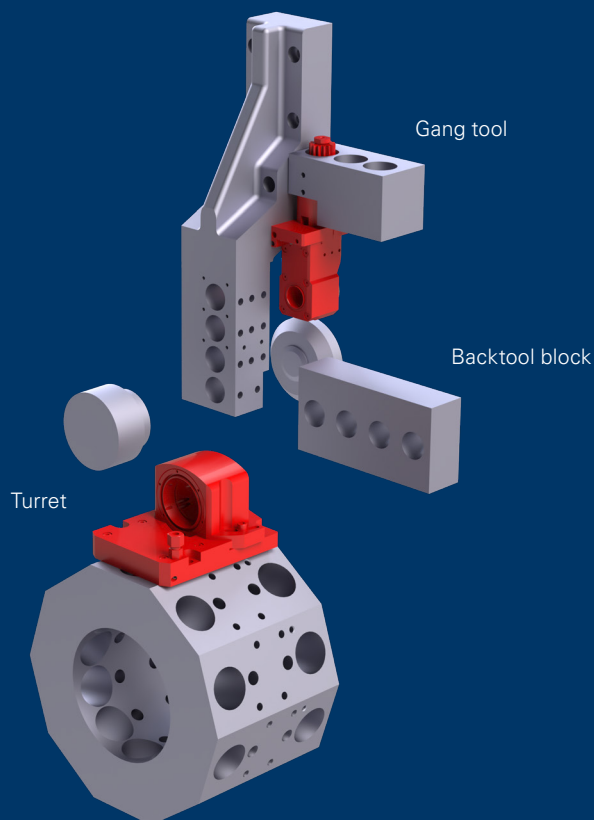


We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

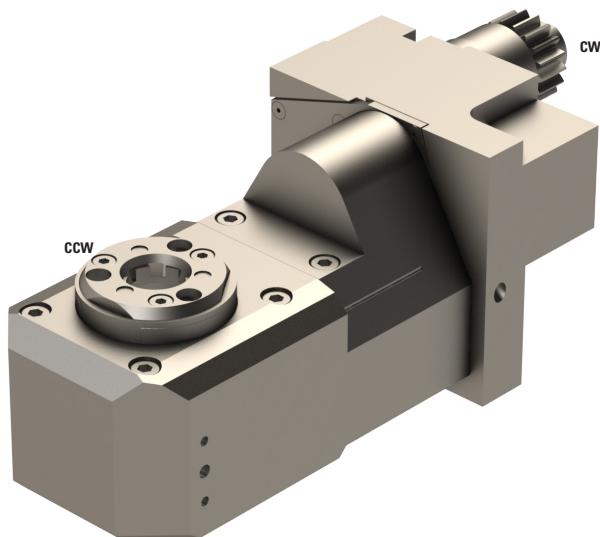
WHIRLING TOOLS

Thread Whirling is a form of the Thread Milling process with the exception that the cutters are mounted on the inside of a Cutting Ring or Cutter Holder rather than the outside of a milling tool. This process is used in the production of screws. The process is very stable and safe due to short chip formation.

Whirling can also be used to produce eccentric shafts.



BSW-215



-



1:1

Position

Upper gang tool post

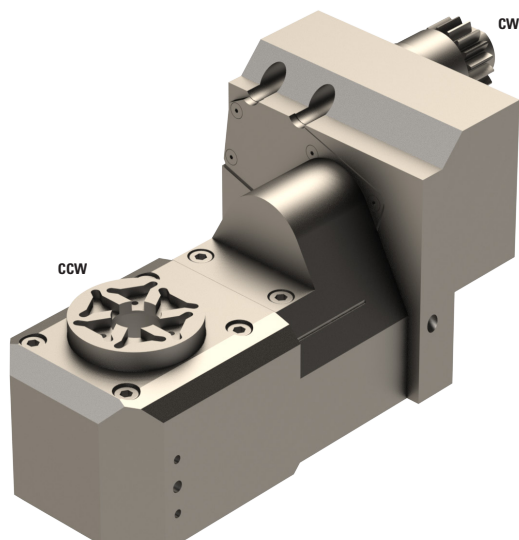
Machines Types
A20-VII
A20-3F7N
Notes
Adjustable $\pm 15^\circ$

The vertical drill holder must be removed from the machine

Thread whirling ring not included!

W03120611120 / SCHWANOG Thread whirling ring / Z=6
 $\varnothing 12$ mmW02120611111 / GLOOR Thread whirling ring / Z=6 $\varnothing 12$
mmW04120911112 / UTILIS Thread whirling ring / Z=9 $\varnothing 12$ mmW04121211112 / UTILIS Thread whirling ring / Z=12 $\varnothing 12$
mmW01120311111 / GLOOR Thread whirling ring / Z=3 $\varnothing 12$
mm

BSW-315



-



1:1

Position

Upper gang tool post

Machines Types
A232-VII
A32-VII
A320-VII
Notes
Adjustable $\pm 15^\circ$

Removal of the GDF-9101 bore bar holder is necessary.

Thread whirling ring not included!

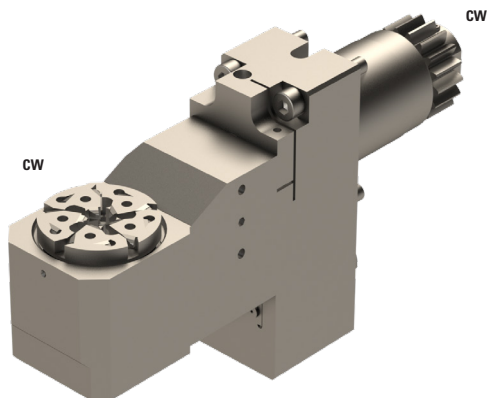
ADDITIONAL ARTICLES :

W03120611120 / SCHWANOG Thread whirling ring Z=6 $\varnothing 12$ W02120611111 / GLOOR Thread whirling ring Z=6 $\varnothing 12$ W04120911113 / UTILIS Thread whirling ring Z=9 $\varnothing 12$ W04121211112 / UTILIS Thread whirling ring Z=12 $\varnothing 12$ 

We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

**MODULAR
SYSTEM**

CITIZEN6-GSW-210



1:1

Position

Upper gang tool post

Machines Types

A232-VII	L20E-2M12
A32-VII	L20E-IX
A320-VII	L32-1M8
L20E-2M8	L32-1M10
L20E-2M10	L32-1M12

Notes

Adjustable $\pm 10^\circ$

The CITIZEN6-PCR base and GSW-210 head are together on this tool. Possibility to order them individually.

Thread whirling ring not included!

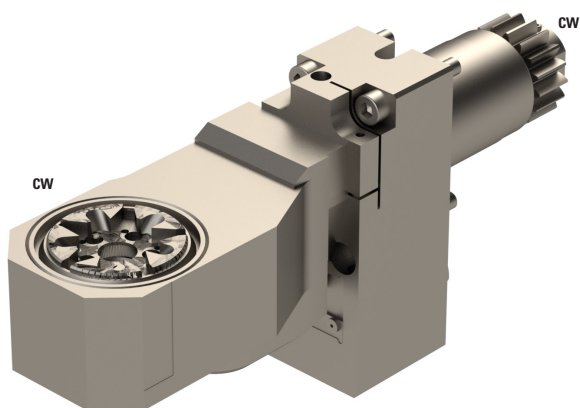
W04060611111 / UTILIS Thread whirling ring / Z=6 Ø6 mm

W03060511111 / SCHWANOG Thread whirling ring / Z=5 Ø6 mm



**MODULAR
SYSTEM**

CITIZEN6-GSW-220



1:1

Position

Upper gang tool post

Machines Types

A232-VII	L20E-2M12
A32-VII	L20E-IX
A320-VII	L32-1M8
L20E-2M8	L32-1M10
L20E-2M10	L32-1M12

Notes

Adjustable $\pm 20^\circ$

The CITIZEN6-PCR base and GSW-220 head are together on this tool. Possibility to order them individually.

Thread whirling ring not included!

W03040511111 / SCHWANOG Thread whirling ring / Z=5 Ø4 mm

W03060511112 / SCHWANOG Thread whirling ring / Z=5 Ø6 mm

W02060511111 / GLOOR Thread whirling ring / Z=5 Ø6 mm

W04060511111 / UTILIS Thread whirling ring / Z=5 Ø6 mm



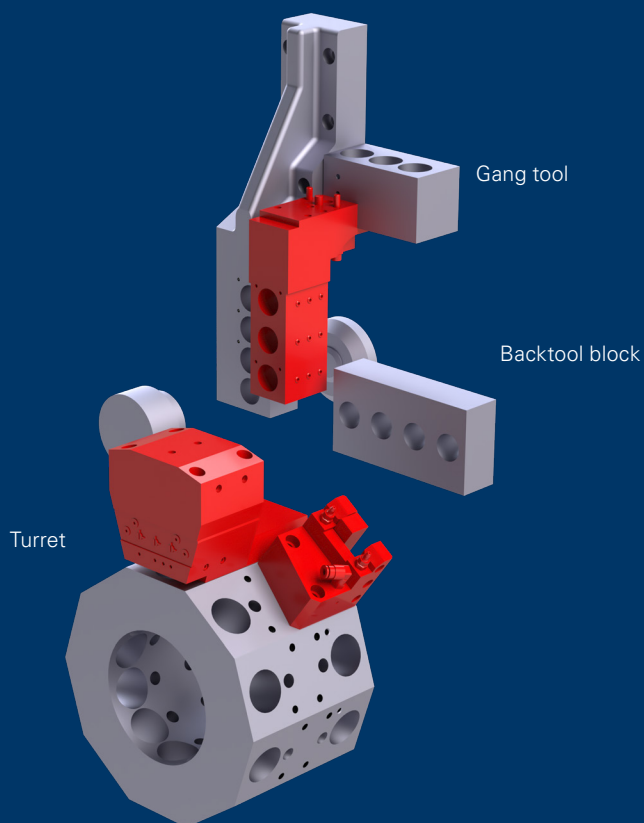
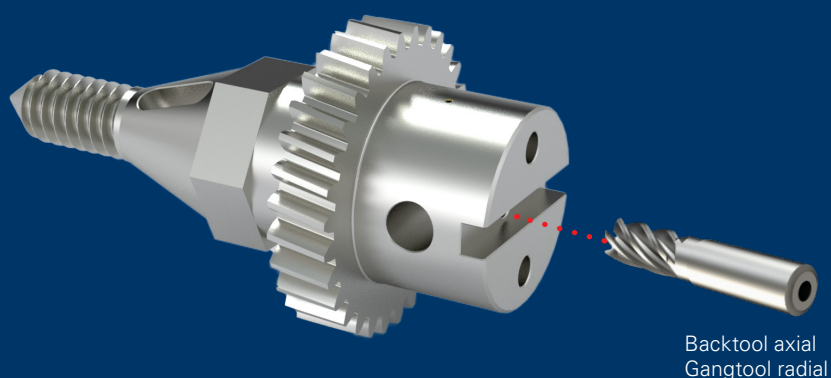
We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

STATIC TOOLS

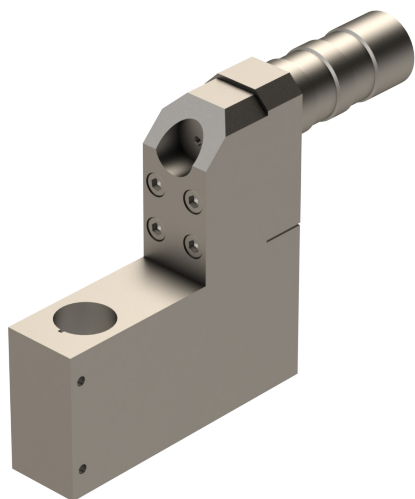
The toolholders are non-rotating tools. They can accommodate drilling spindles, collets or high-frequency spindles.

These toolholders are only for centric machining.

When using a high-frequency spindle, the same operations can be performed as with the driven toolholders.



852-354-OF010



Ø 25



-

Position Upper gang tool post

Machines Types

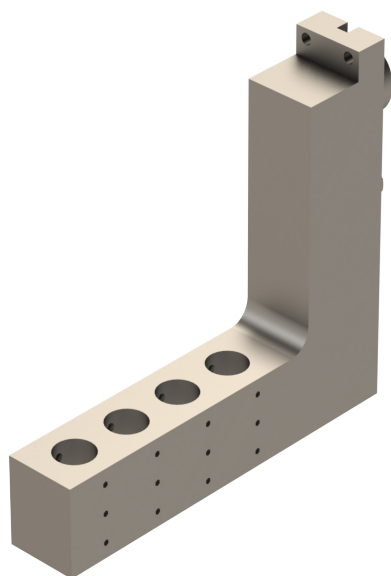
A232-VII	L220-2M8
A32-VII	L220-2M10
A320-VII	M32-4M5
D25-VII	M32-4M8
L32-1M8	M32-5M5
L32-1M10	M32-5M7
L32-1M12	M32-5M8

Notes

For high frequenz spindel Meyrat



GDF-1207-L



4xØ19.05mm



-

Position Upper gang tool post

Machines Types

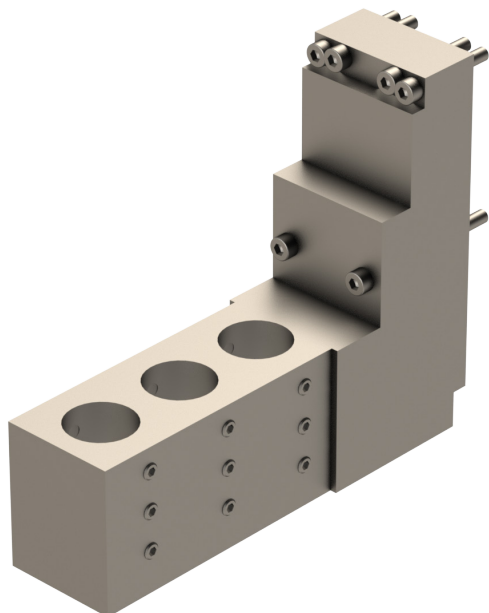
A20-3F7N
L20E-2M10
L20E-2M12
L20E-2M8
L32-1M10
L32-1M12
L32-1M8

Notes



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

GDF-1501-II



3xØ25.4mm



-

Position

Upper gang tool post

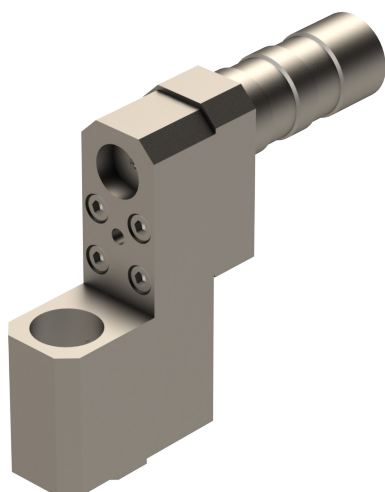
Machines Types

A20-3F7N	M220-III
A232-VII	M220-V
A32-VII	M232-III
A320-VII	M232-V
L20E-2M8	M320-III
L20E-2M10	M320-V
L20E-2M12	M332-III
L32-1M8	M332-V
L32-1M10	M32-4M5
L32-1M12	M32-4M8

Notes



GDF903



Ø

25,4



-

Position

Upper gang tool post

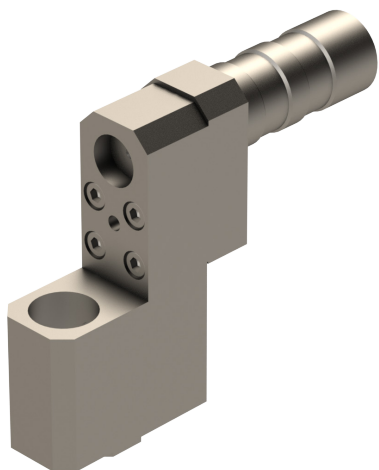
Machines Types

A232-VII	L220-2M8
A32-VII	L220-2M10
A320-VII	M32-4M5
D25-VII	M32-4M8
L32-1M8	M32-5M5
L32-1M10	M32-5M7
L32-1M12	M32-5M8

Notes



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

GDF-903-25

Ø	25
---	----



-

Position	Upper gang tool post
----------	----------------------

Machines Types	A232-VII	L220-2M8
	A32-VII	L220-2M10
	A320-VII	M32-4M5
	D25-VII	M32-4M8
	L32-1M8	M32-5M5
	L32-1M10	M32-5M7
L32-1M12	M32-5M8	

Notes



We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

A series of horizontal gray lines for writing notes, spanning the width of the page. The lines are evenly spaced and cover the majority of the page area below the header and above the footer.

A large area of horizontal grey lines for writing notes, spanning most of the page width and height.

Visit us online :
www.pcm.ch



PCM Willen SA

Route du Grammont 101
1844 Villeneuve
Switzerland

Tél. +41 (0)21 967 33 66
Fax: +41 (0)21 960 38 95