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industry

PCMI[®]
be driven.

TOOL HOLDERS

CITIZEN CINCOM L12.



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.

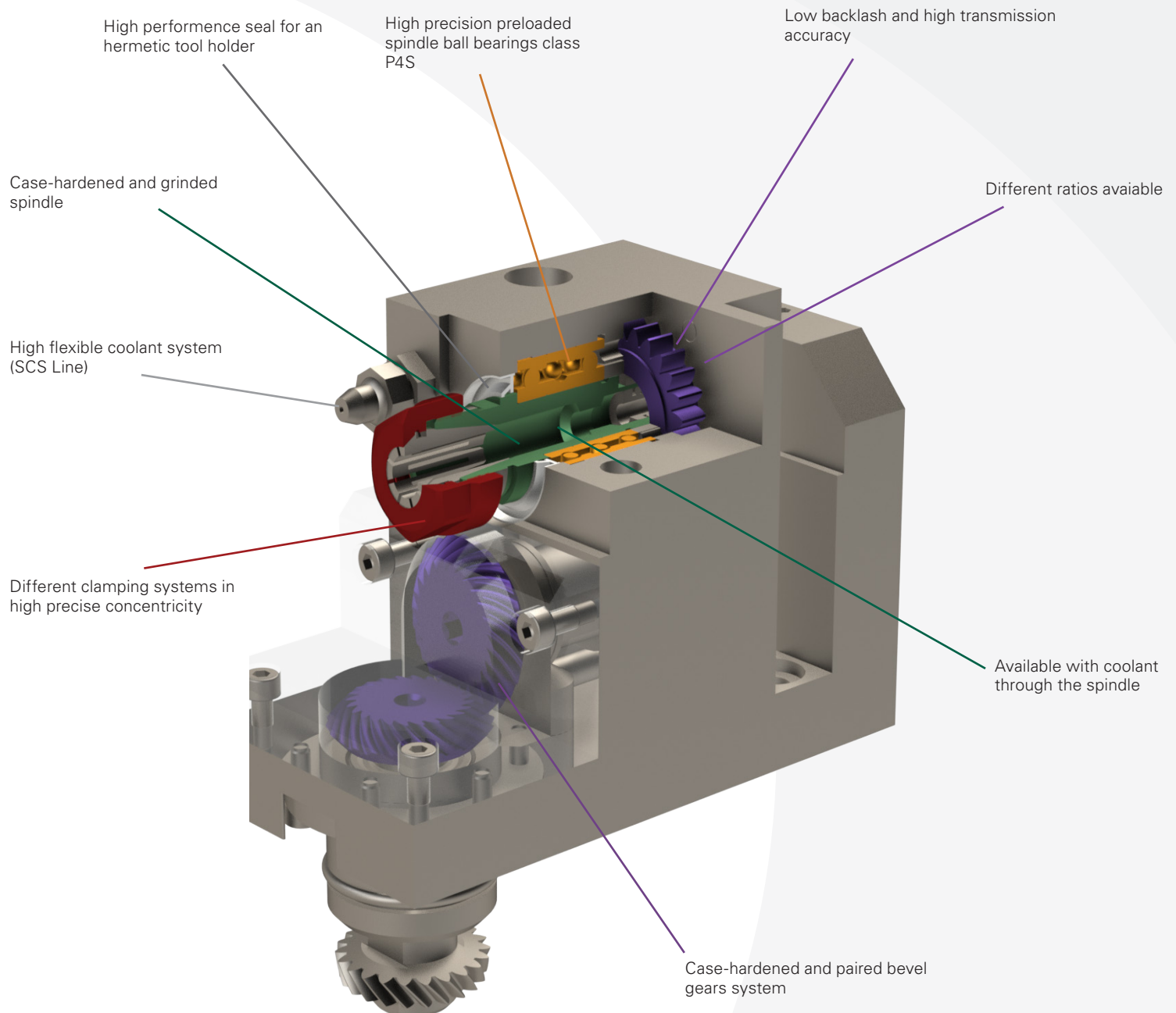
In close cooperation with machine builders and end users, we stay on the way to satisfied customers. We will keep this track in the future.

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 CHOICE N°1 IN TOOLING SYSTEMS

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



CITIZEN CINCOM L12

Radial tools	5
Axial tools	15
Accelereted tools	21
Slitting saw tools	27
Polygon tools	31
Hobbing tools	35
Whirling tools	45
Static tools	49

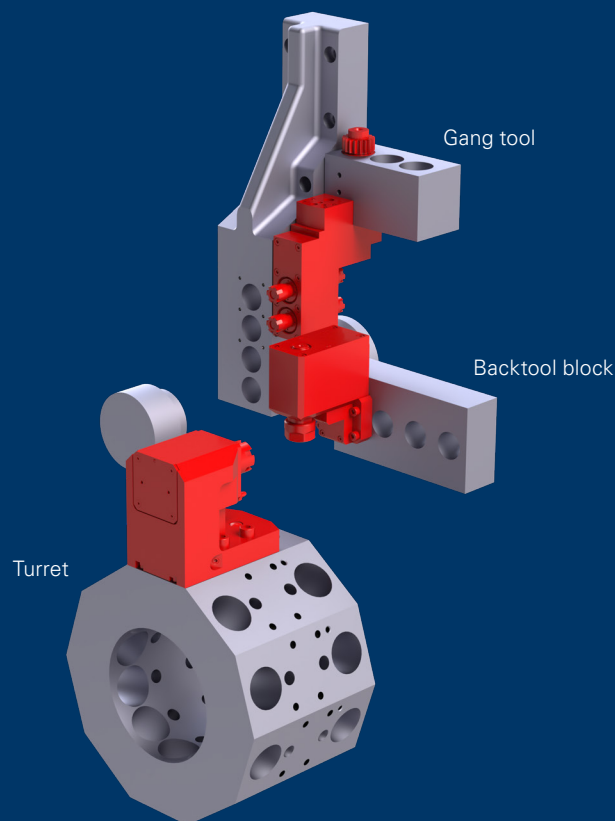
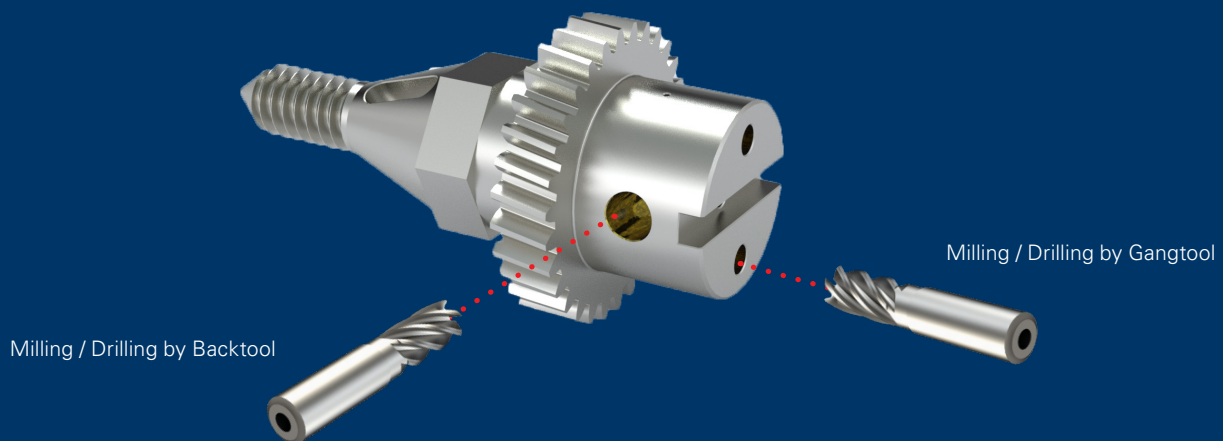
Rotation: **cw** Clockwise **ccw** Counterclockwise

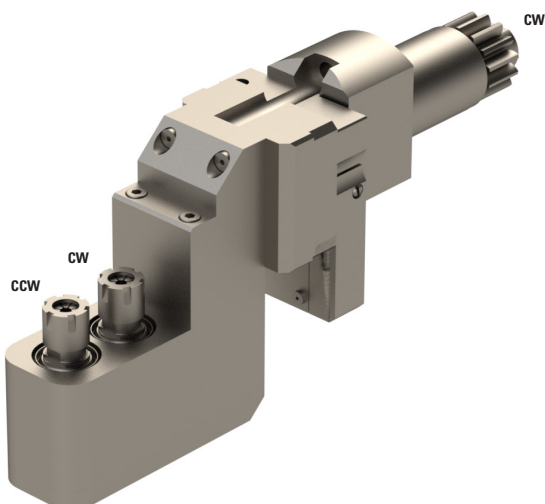
Cooling: **INT** Interior **EXT** Exterior **⊘** Without

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.



**MODULAR
SYSTEM****CITIZEN5-GSE208**

2xER08



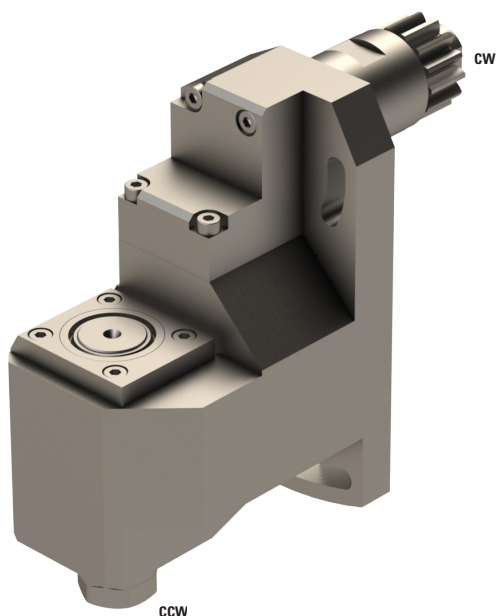
1:1

Position

Upper gang tool post

Machines TypesL12-1M7
M16-4M5
M16-4M8**Notes**

Adjustable $\pm 15^\circ$
The CITIZEN5-PCR base and GSE-208 head are together on this tool.
Possibility to order them individually.

**GSE3607-1B**

1xER11



1:1

Position

Upper gang tool post

Machines Types

L12-1M7

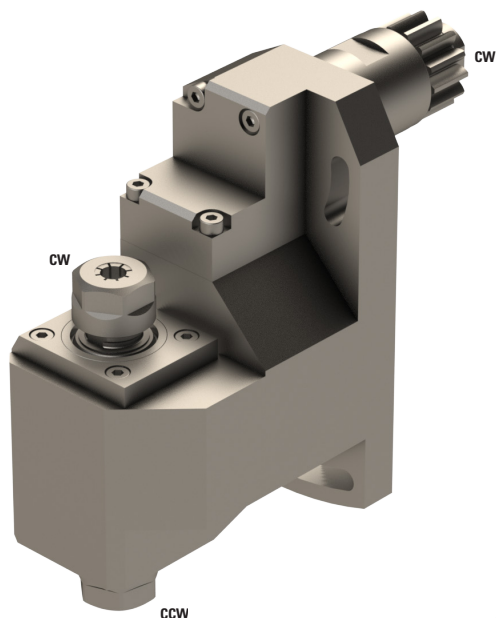
Notes



Adjustable $\pm 45^\circ$



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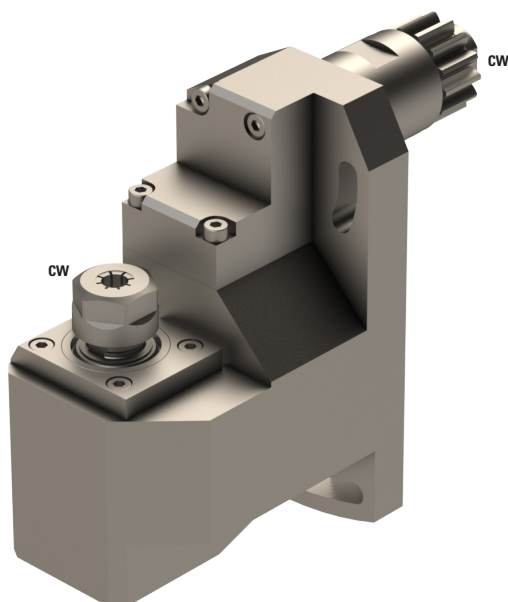
GSE3607-1D





	1xER11+1xER11
	1:1
Position	Upper gang tool post
Machines Types	L12-1M7
Notes	

Adjustable $\pm 45^\circ$

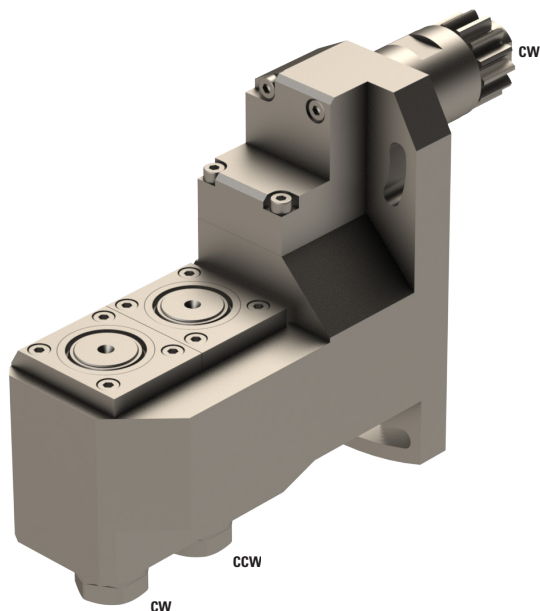
GSE3607-1M



	1xER11
	1:1
Position	Upper gang tool post
Machines Types	L12-1M7
Notes	

Adjustable $\pm 45^\circ$

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GSE3607-2B

2xER11



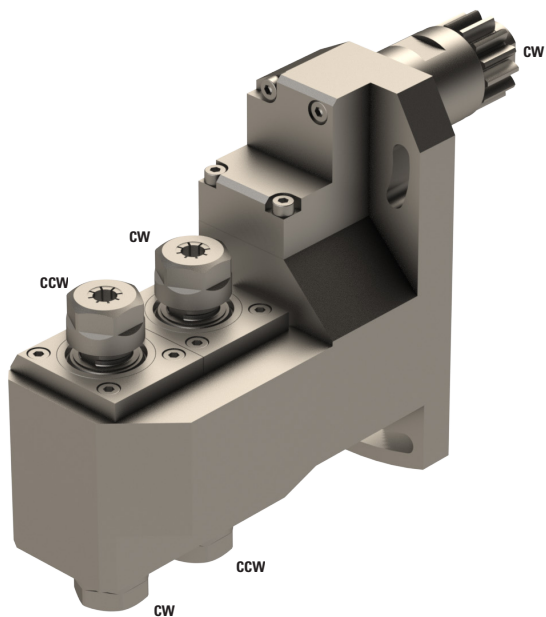
1:1

Position

Upper gang tool post

Machines Types

L12-1M7

NotesAdjustable $\pm 30^\circ$ **GSE3607-2D**

2xER11+2xER11



1:1

Position

Upper gang tool post

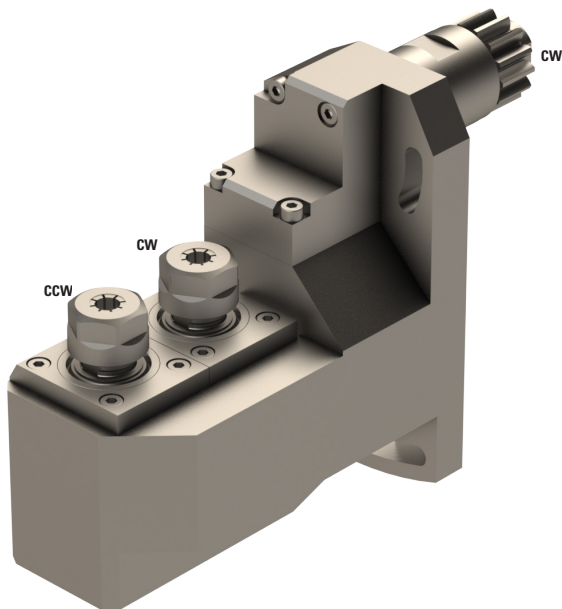
Machines Types

L12-1M7

NotesAdjustable $\pm 30^\circ$ 

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GSE3607-2M

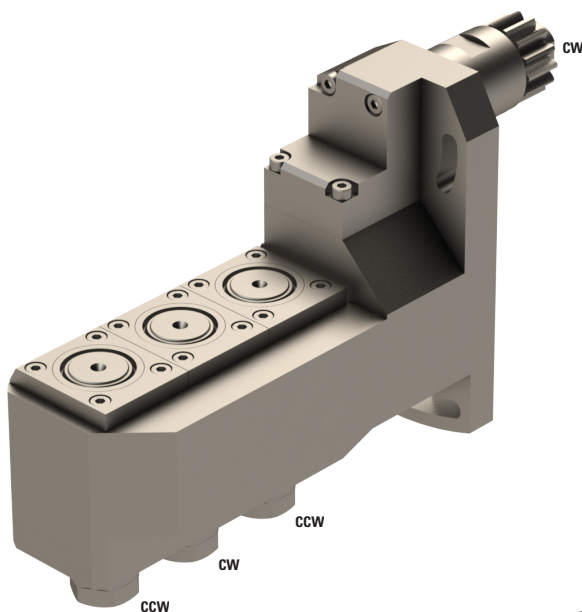


	2xER11
	1:1
Position	Upper gang tool post
Machines Types	L12-1M7
Notes	

Adjustable $\pm 30^\circ$



GSE3607-3B

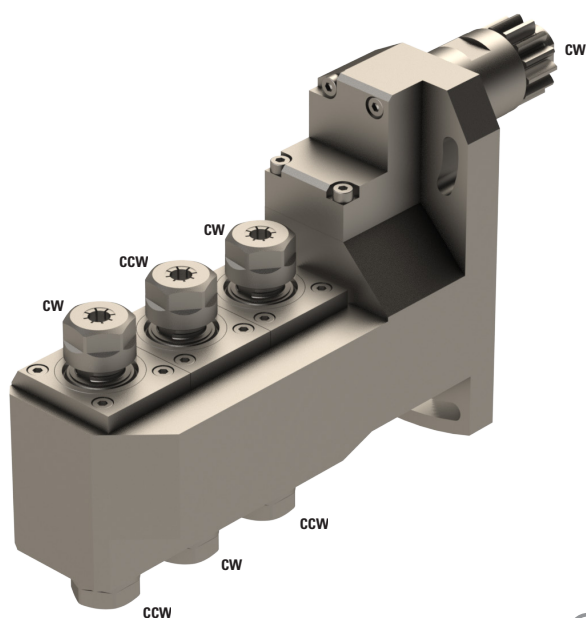


	3xER11
	1:1
Position	Upper gang tool post
Machines Types	L12-1M7
Notes	

Adjustable $\pm 30^\circ$



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GSE3607-3D

3xER11+3xER11



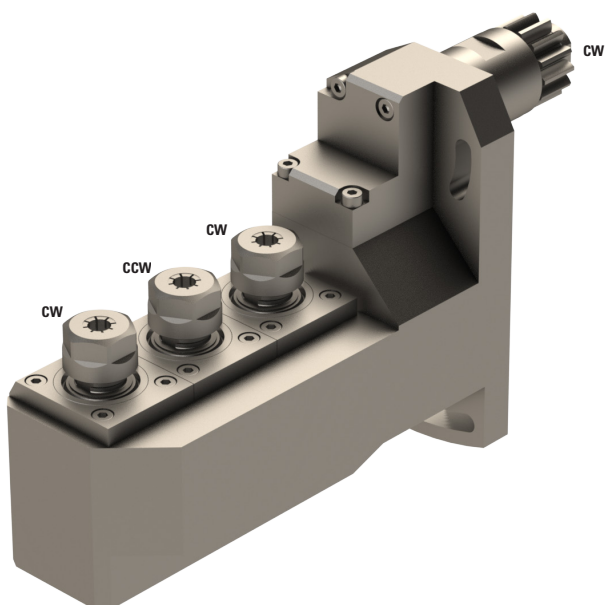
1:1

Position

Upper gang tool post

Machines Types

L12-1M7

NotesAdjustable $\pm 30^\circ$ **GSE3607-3M**

3xER11



1:1

Position

Upper gang tool post

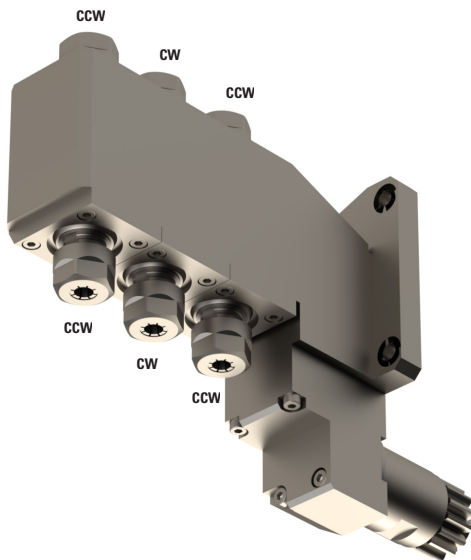
Machines Types



L12-1M7

NotesAdjustable $\pm 30^\circ$

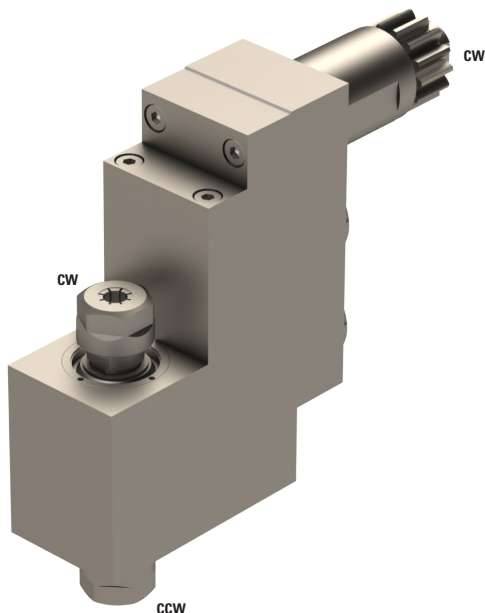
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GSE4307



	3xER11+3xER11
	1:1
Position	Upper gang tool post
Machines Types	L12-VII
Notes	

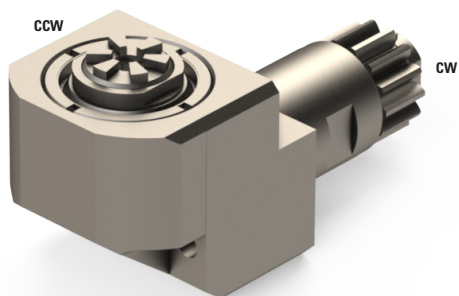
MSE-1007



	1xER11+1xER11
	1:1
Position	Front gang tool holders
Machines Types	A20-VII A20-3F7N L12-1M7
Notes	

Need 3 positions

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RSC507

ER11



1:1

Position

Front gang tool post

Machines Types

L12-1M7

Notes

90° tool holder with reduced space requirement
Recommended max. output torque = 1Nm



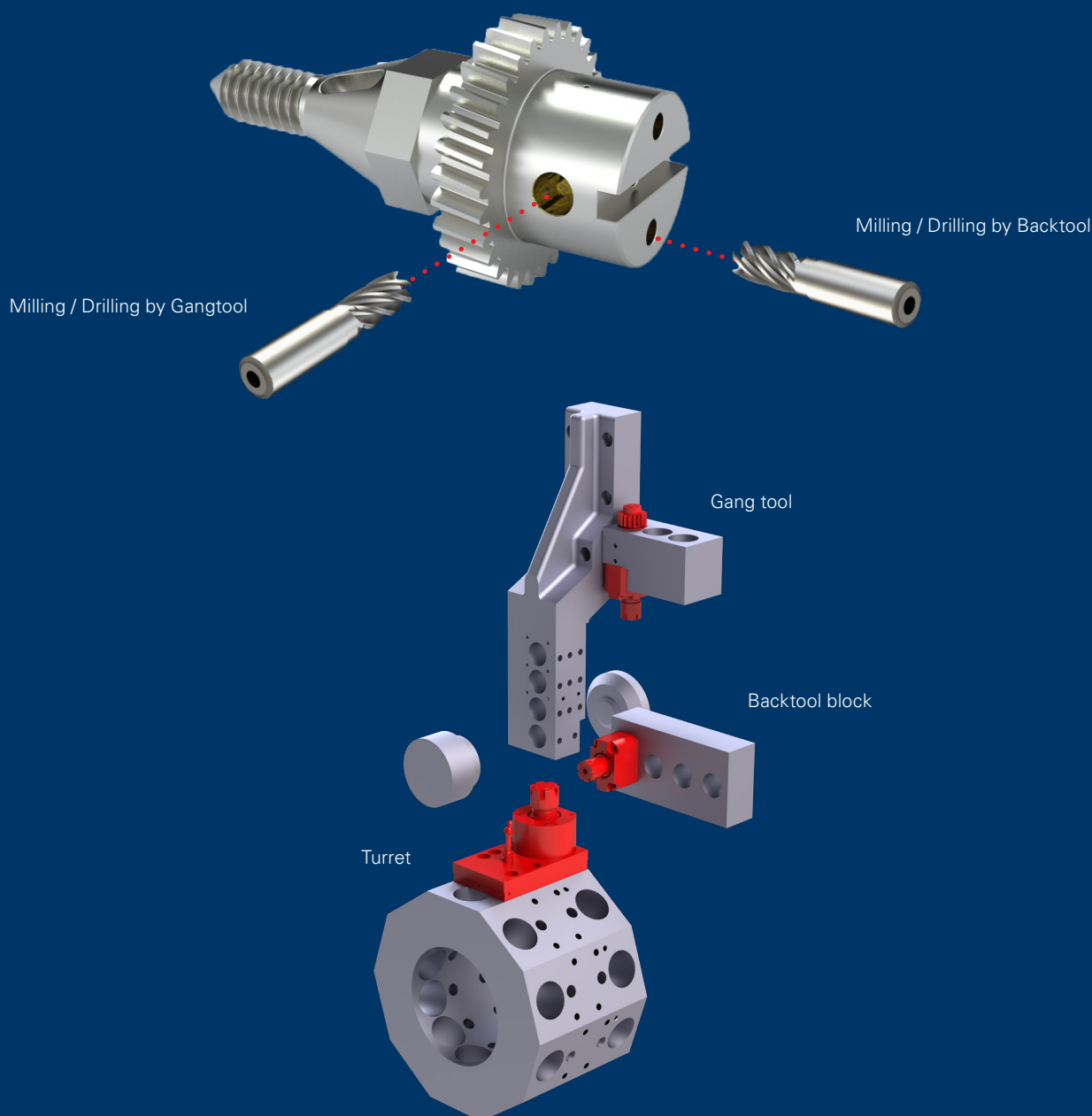
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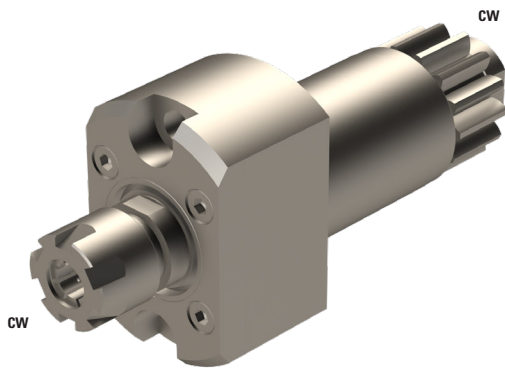
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AXIAL DRILLING / MILLING TOOLS

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.



MSC-507-II

ER11



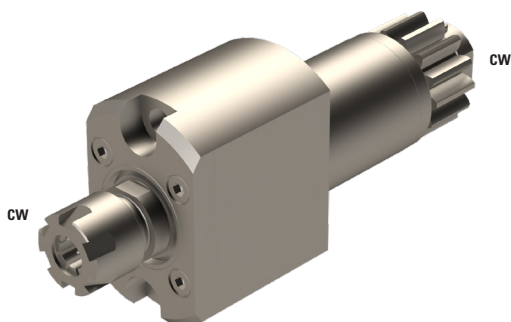
1:1

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
L220-VIII	M212-C
L220-IX	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**MSC-507-L**

ER11



1:1

Position

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

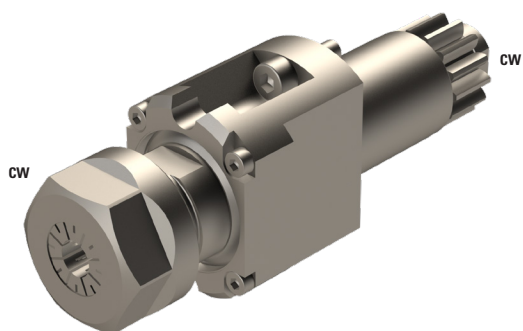
Machines Types

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
L220-VIII	M212-C
L220-IX	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

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MSC-513



ER20



1:1

Position

Upper gang tool post
Front gang tool post

Machines Types

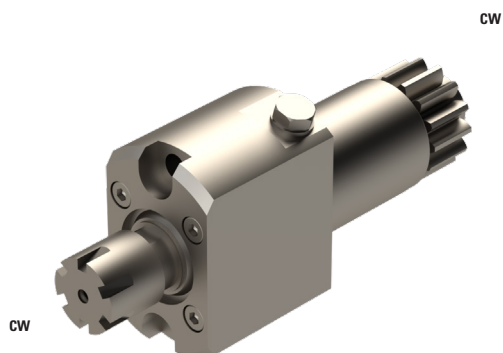
A20-3F7N	M212-V
A320-VII	M216-C
L12-1M7	M216-V
L20E-2M12	M312-III
L20E-2M10	M312-V
L20E-2M8	M312-VII
L20E-IX	M316-III
L20X	M316-V
M212-C	M16-4M5
	M16-4M8

Notes

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



MSC507-HP



ER11



1:1

Position

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

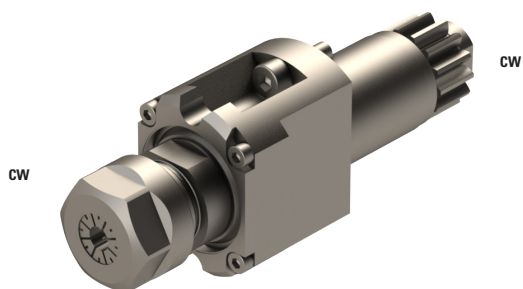
Machines Types

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



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MSC-512

ER16



1:1

PositionUpper 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.

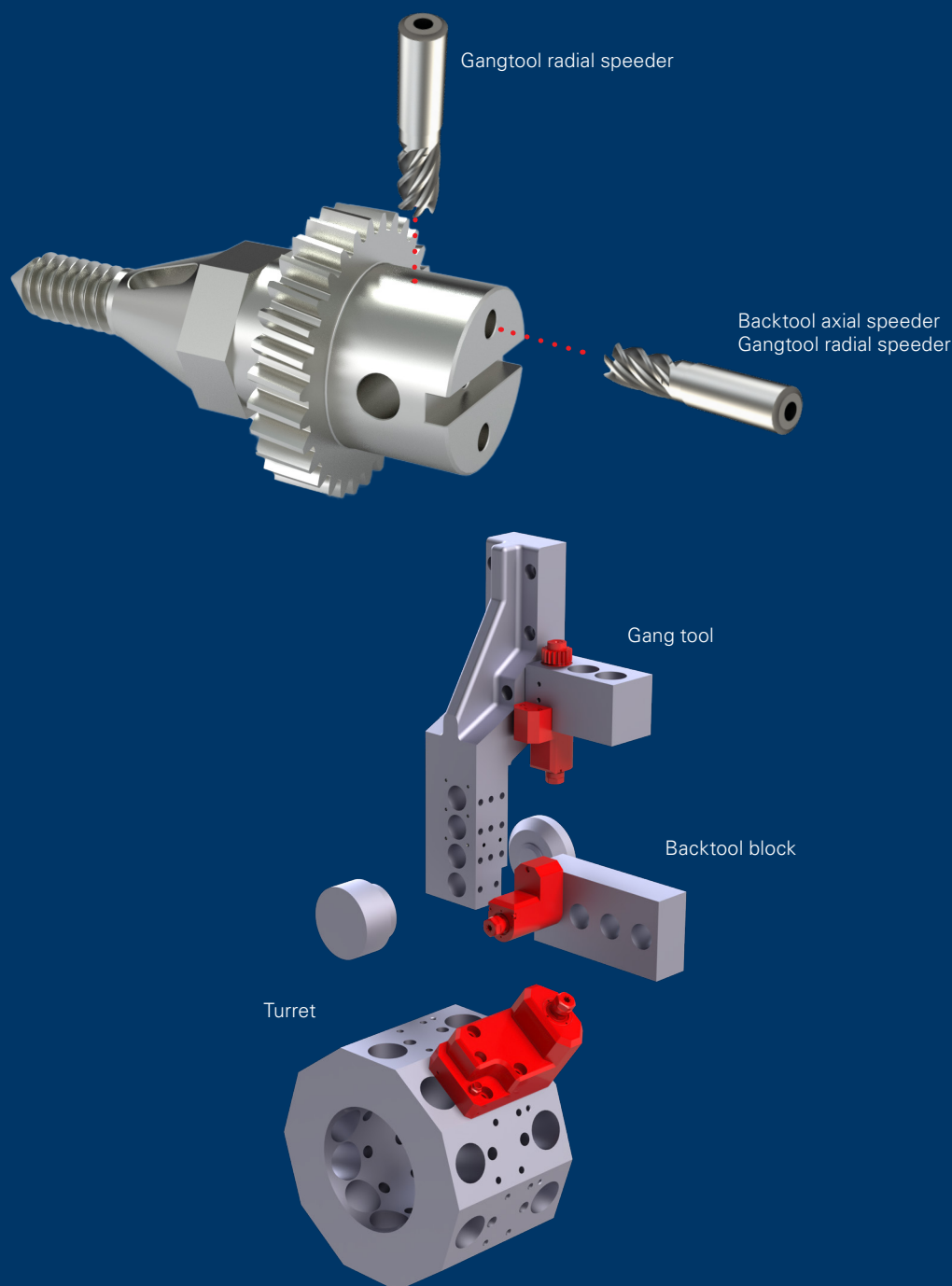


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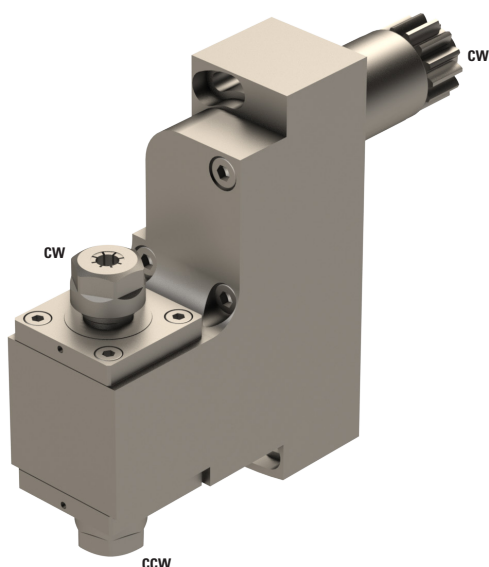
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ACCELERATED TOOLS (SPEEDERS)

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



GSE-1207-3X



2xER11



1:3

Position

Upper gang tool post

Machines Types

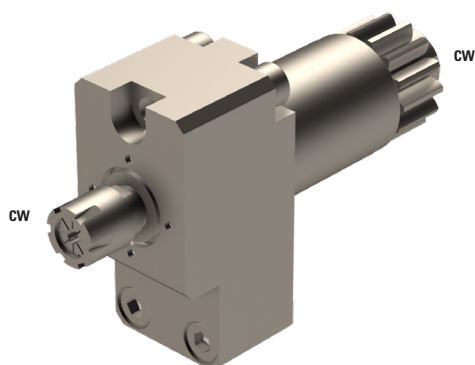
L12-1M7

Notes

Adjustable +30°
Need 2 position if inclined



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

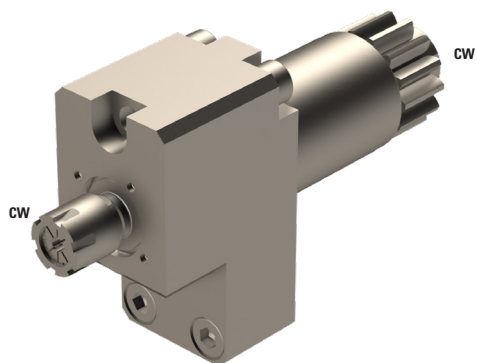
Notes

Use at maximum torque of 1500Nm



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GSE-3307-L-3X



ER08



1:3

Position

Front gang tool post

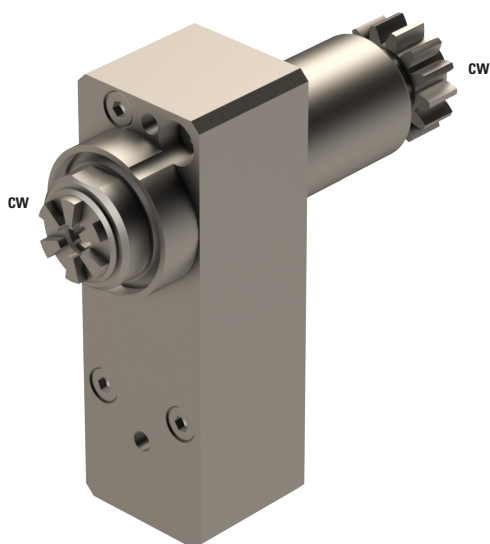
Machines Types

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

Notes



GSE-3507-3X



ER11



1:3

Position

Front gang tool post

Machines Types

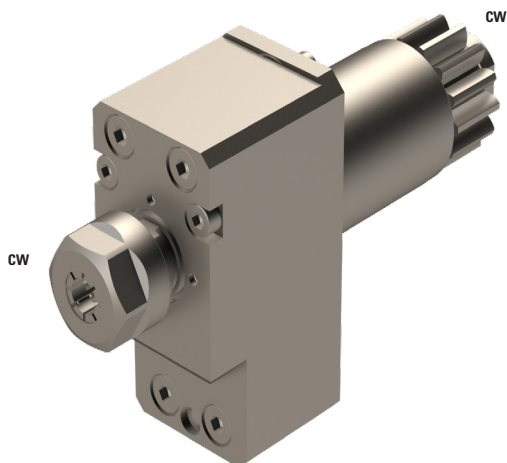
A20-3F7N	L20E-2M12
A20-VII	L20E-IX
A320-VII	L20X
L12-1M7	L32-1M8
L20E-2M8	L32-1M10
L20E-2M10	L32-1M12

Notes



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MSC-507-2X



ER11



1:2

Position

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

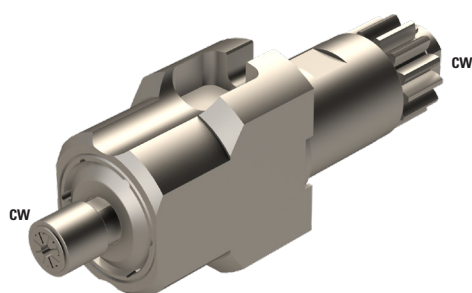
Machines Types

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



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



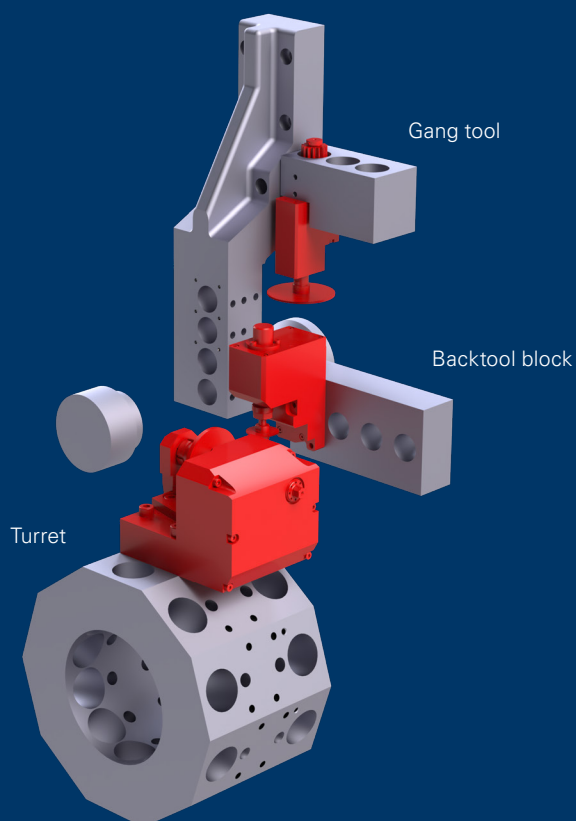
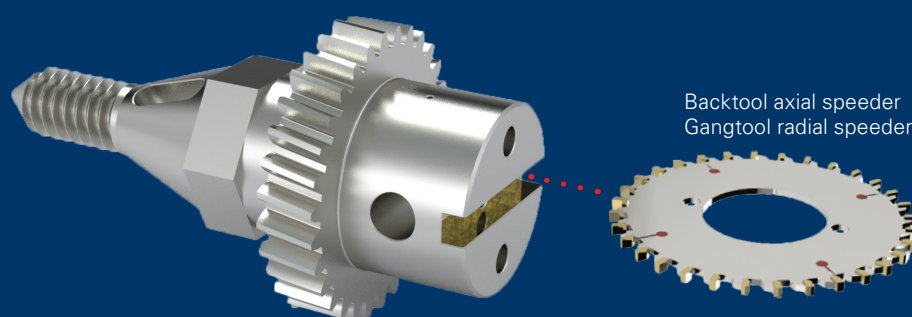
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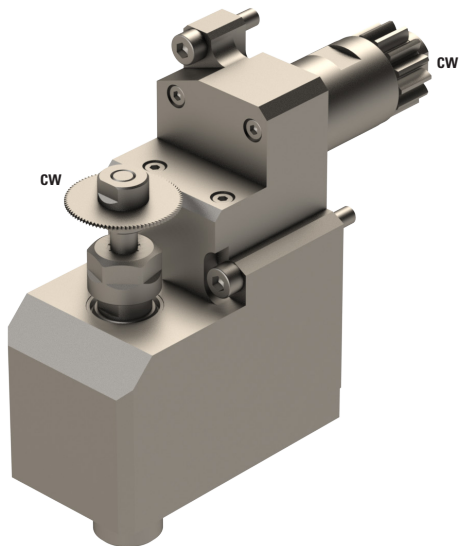
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SAWBLADE TOOLS

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.



GSS1530

ER11



5:3

Position

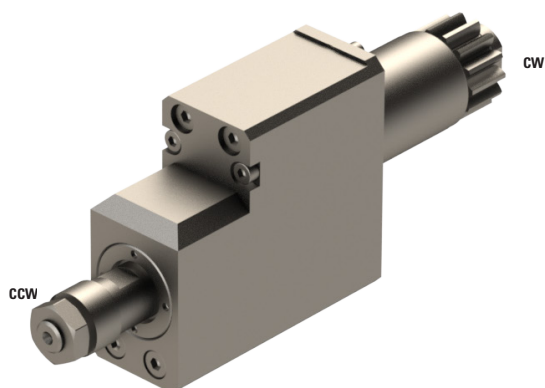
Front gang tool post

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

**GSS610**

10



1:1

Position

Upper gang tool post

Machines Types

L12-1M7
M416

Notes

Diameter of the mill : Ø40mm max.
Width of mill cutter : 4.5mm max.

Uses 2 positions
Citizen M416: T06 to T09
Citizen L12 1M7: T08 to T10
Attention in position T09-T08 collision with U151B



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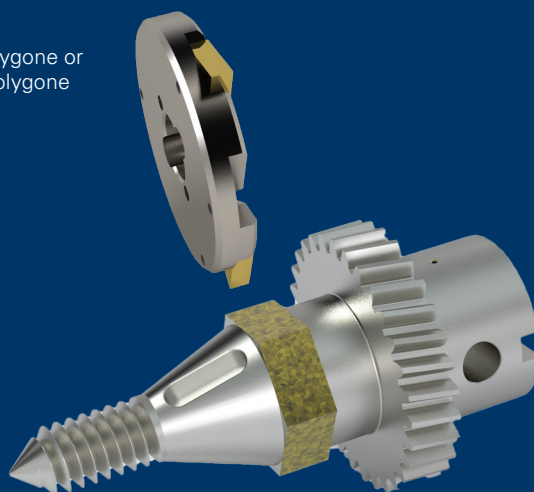
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POLYGON TOOLS

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).

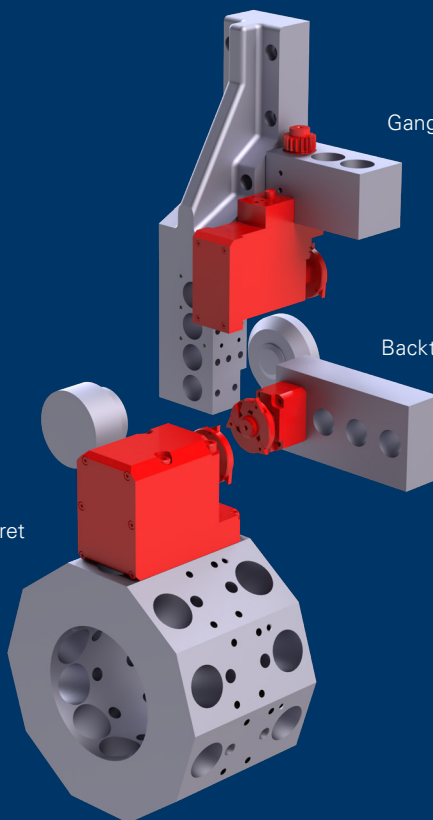
Backtool axial Polygone or
Gangtool radial Polygone

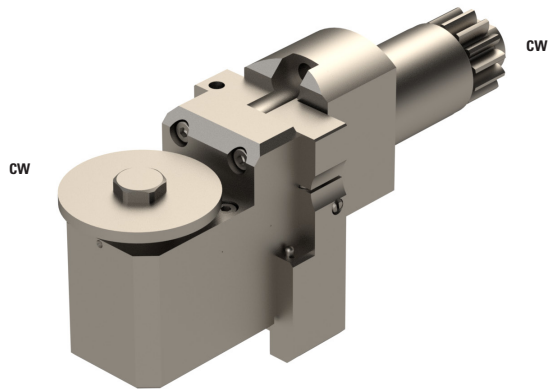


Gang tool

Backtool block

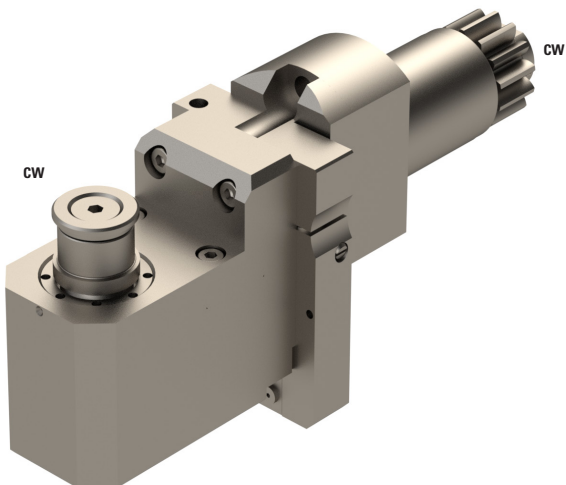
Turret



**MODULAR
SYSTEM****CITIZEN5-GSP-218**

Ø	8
⚙️	1:1
Position	Upper gang tool post
Machines Types	L12-1M7
Notes	

Adjustable $\pm 15^\circ$
 Diameter of the mill : Ø 45mm max.
 Width of mill cutter : 5mm max.
 The CITIZEN5-PCR base and GSP-218 head are together on this tool.
 Possibility to order them individually.

**MODULAR
SYSTEM****CITIZEN5-GSP-518**

Ø	15.875
⚙️	1:1
Position	Upper gang tool post
Machines Types	L12-1M7
Notes	

Adjustable $\pm 15^\circ$
 Diameter of the mill : Ø54 mm max.
 Width of mill cutter : 10mm max.
 The CITIZEN5-PCR base and GSP-518 head are together on this tool.
 Possibility to order them individually.



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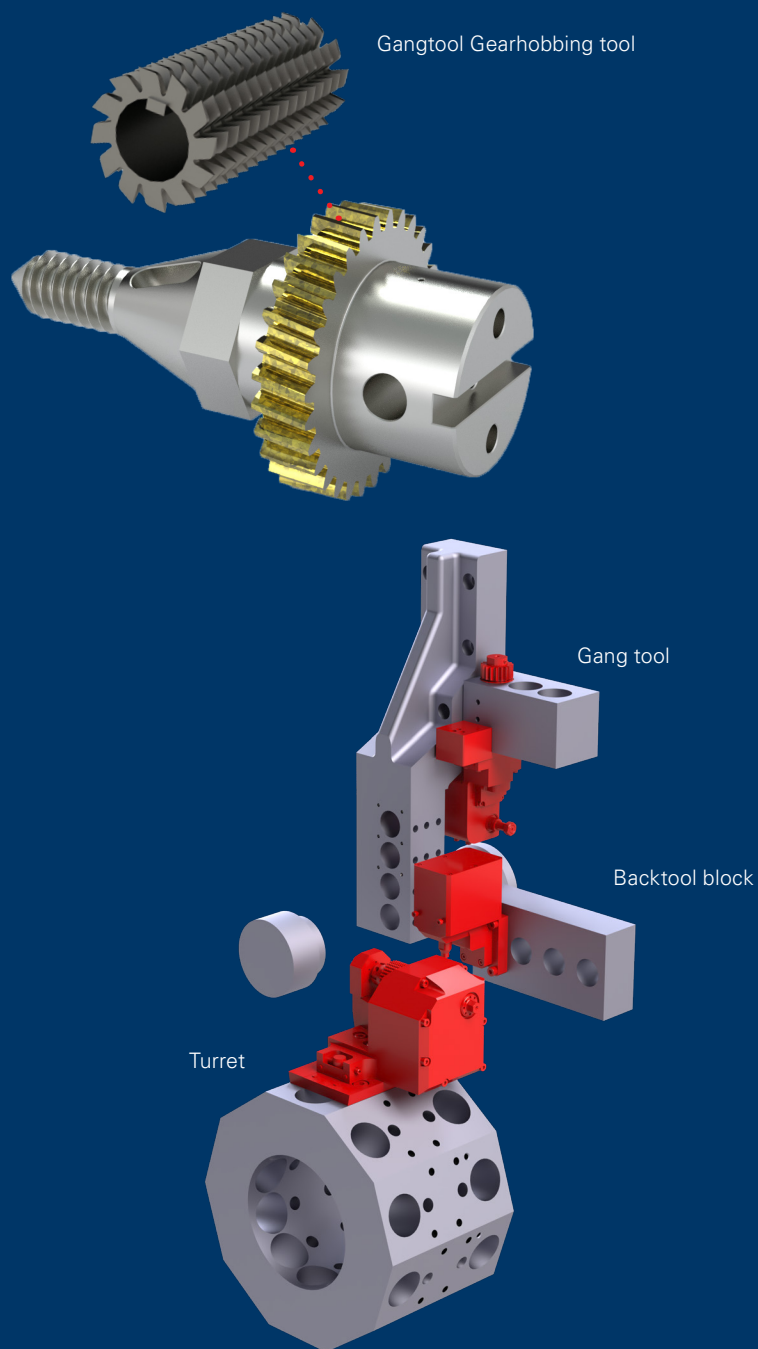
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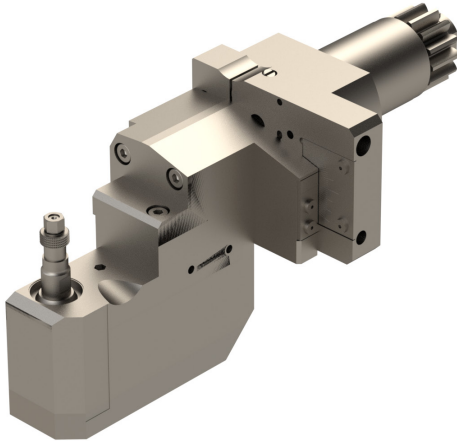
HOBGING TOOLS

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****CITIZEN5-GSH-045**

Ø	4.5
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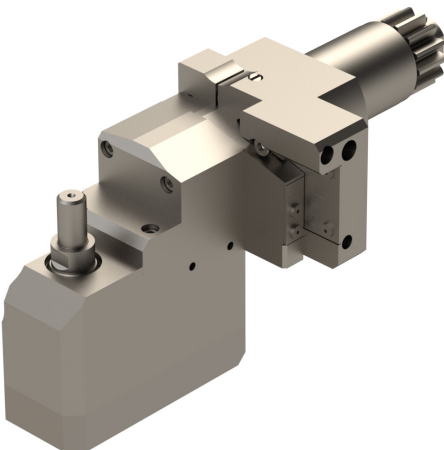
⚙️➡️⚙️	1:1
--------	-----

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

Machines Types	L12
----------------	-----

Notes

Adjustable $\pm 2^\circ$
 Width of mill cutter : 8mm max.
 The CITIZEN5-PCR base and GSH-045 head are together
 on this tool.
 Possibility to order them individually.

**MODULAR
SYSTEM****CITIZEN5-GSH-080**

Ø	8
---	---

⚙️➡️⚙️	1:1
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Machines Types	L12
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Notes

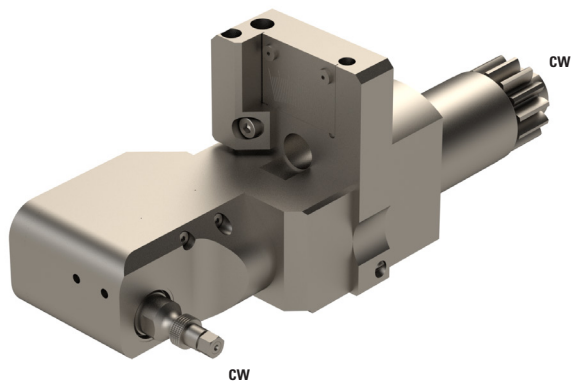
Adjustable $\pm 2^\circ$
 Width of mill cutter : 10mm max.
 The CITIZEN5-PCR base and GSH-080 head are together
 on this tool.
 Possibility to order them individually.



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**MODULAR
SYSTEM**

CITIZEN5-LSH-035



Ø 3.5

⚙️ 1:1

Position Upper gang tool post

Machines Types L12-1M7

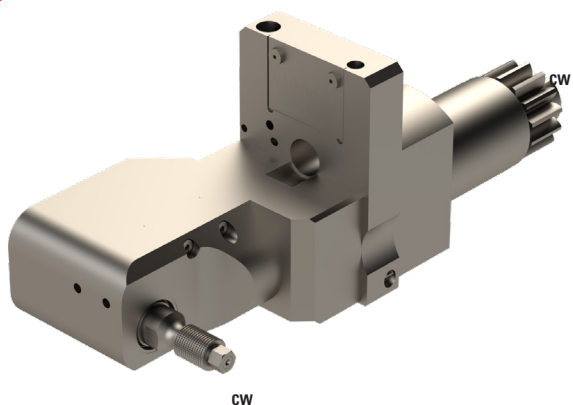
Notes

Adjustable $\pm 2^\circ$
Diameter of the mill : \varnothing 8mm max.
Width of mill cutter : 6 mm max.
The CITIZEN5-PCR base and LSH-035 head are together on this tool.
Possibility to order them individually.
Compatible only with the main spindle L12 864-571.



**MODULAR
SYSTEM**

CITIZEN5-LSH-035-L



Ø 3.5

⚙️ 1:1

Position Upper gang tool post

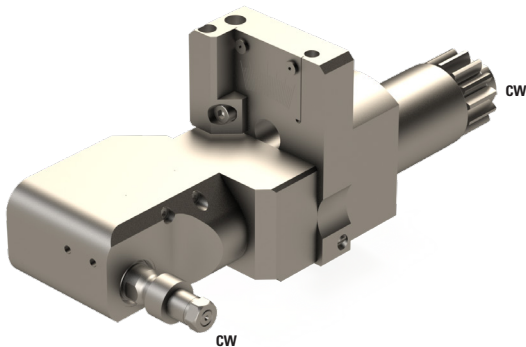
Machines Types L12-1M7

Notes

Adjustable $\pm 10^\circ$
Diameter of the mill : \varnothing 12mm max.
Width of mill cutter : 10 mm max.
The CITIZEN5-PCR base and LSH035-L head are together on this tool.
Possibility to order them individually.
Compatible only with the main spindle L12 864-571.

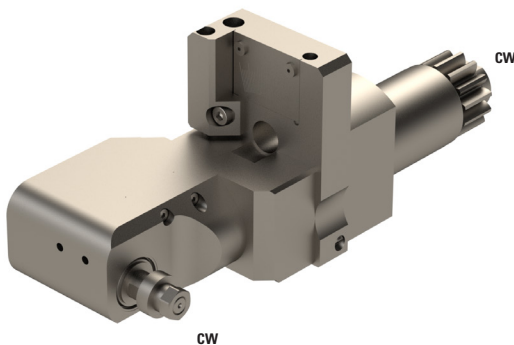


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**MODULAR
SYSTEM****CITIZEN5-LSH-045**

Ø	4.5
⚙️	1:1
Position	Upper gang tool post
Machines Types	L12-1M7
Notes	

Adjustable $\pm 2^\circ$
 Diameter of the mill : Ø 12mm max.
 Width of mill cutter : 3-12 mm max.
 The CITIZEN5-PCR base and LSH-045 head are together on this tool.
 Possibility to order them individually.
 Compatible only with main spindle L12-864-571.

**MODULAR
SYSTEM****CITIZEN5-LSH-050**

Ø	5
⚙️	1:1
Position	Upper gang tool post
Machines Types	L12-1M7
Notes	

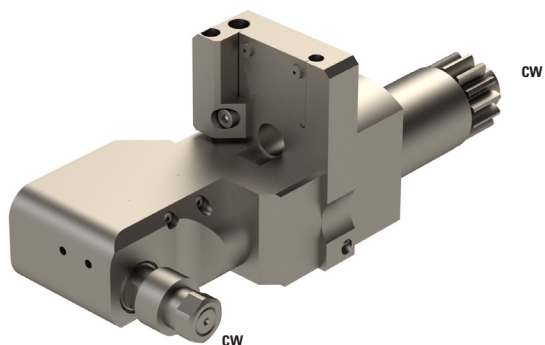
Adjustable $\pm 2^\circ$
 Diameter of the mill : Ø 12mm max.
 Width of mill cutter : 6 mm max.
 The CITIZEN5-PCR base and LSH-050 head are together on this tool.
 Possibility to order them individually.
 Compatible only with the main spindle L12 864-875.



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**MODULAR
SYSTEM**

CITIZEN5-LSH-080



Ø 8

⚙️ 1:1

Position Upper gang tool post

Machines Types L12-1M7

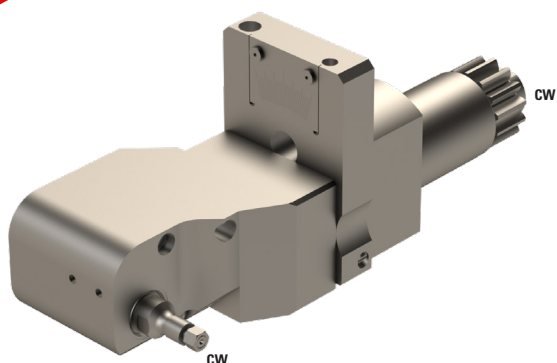
Notes

Adjustable $\pm 2^\circ$
Diameter of the mill : \varnothing 18mm max.
Width of mill cutter : 5-12 mm max.
The CITIZEN5-PCR base and LSH-080 head are together on this tool.
Possibility to order them individually.
Compatible only with the main spindle L12 864-875.



**MODULAR
SYSTEM**

CITIZEN5-LSH-135



Ø 3.5

⚙️ 1:1

Position Upper gang tool post

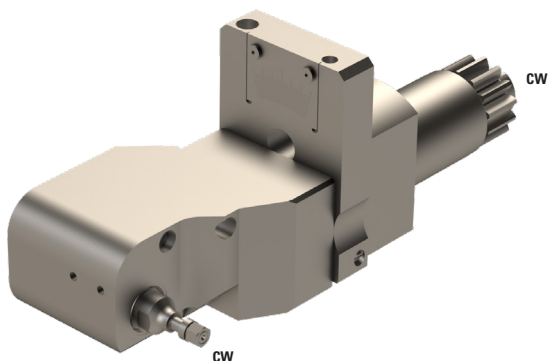
Machines Types L12-1M7

Notes

Adjustable $\pm 2^\circ$
Diameter of the mill : \varnothing 8mm max.
Width of mill cutter : 6mm max.
Can only be used with the special barrel L12-864-571.
The distance between the cutter and the barrel is reduced.
The CITIZEN5-PCR base and LSH-135 head are together on this tool.
Possibility to order them individually.



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**MODULAR
SYSTEM****CITIZEN5-LSH-235**

Ø	3.5
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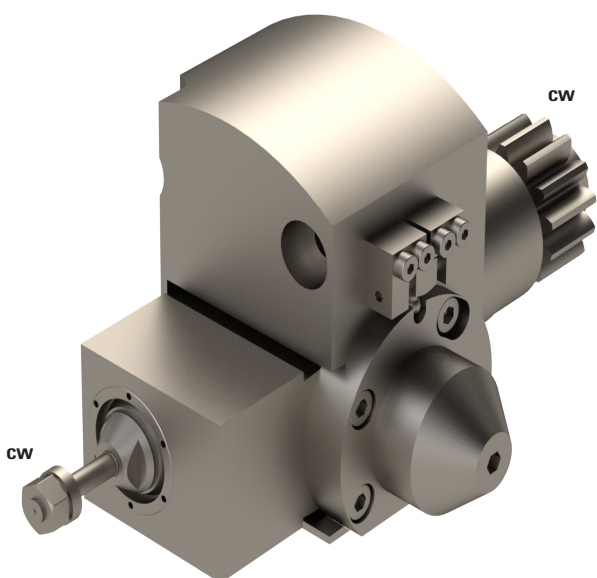
⚙️	1:1
----	-----

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

Machines Types	L12-1M7
----------------	---------

Notes

Adjustable $\pm 2^\circ$
 Diameter of the mill : $\varnothing 10$ mm max.
 Width of mill cutter : 6 mm max.
 Can only be used with the special barrel L12-864-571.
 The distance between the cutter and the barrel is reduced.
 The CITIZEN5-PCR base and LSH-235 head are together
 on this tool.
 Possibility to order them individually

**GSH235**

⚙️	$\varnothing 3.5$ mm
----	----------------------

⚙️	1:1
----	-----

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

Machines Types	L12-1M10
----------------	----------

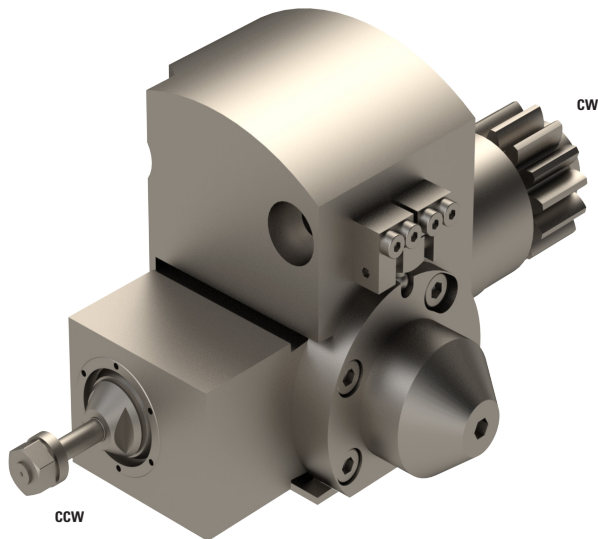
Notes


Adjustable $\pm 5^\circ$



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GSH-245



 Ø4.5mm

 1:1

Position Upper gang tool post

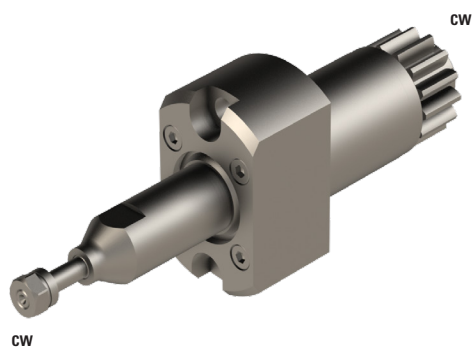
Machines Types L12-1M10


Notes

Adjustable $\pm 5^\circ$



MSH507



 Ø4.5mm

 1:1

Position Upper gang tool post

Machines Types L12-1M7

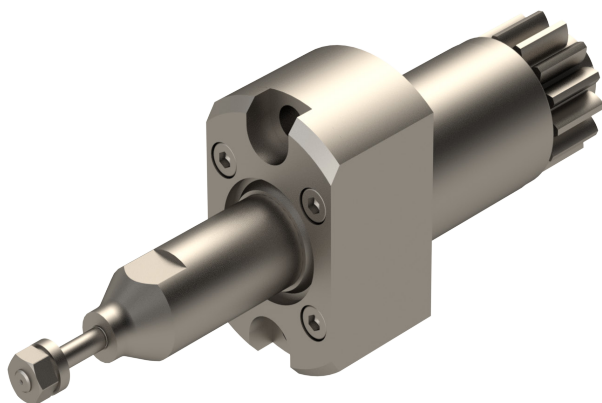
Notes

Diameter of the mill : Ø 12mm

Width of mill cutter : 10mm



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MSH50735

Ø3.5mm



1:1

Position

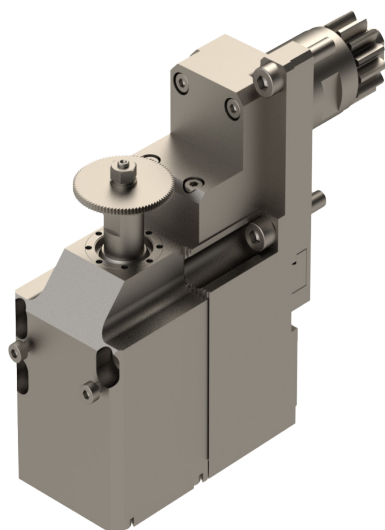
Upper gang tool post

Machines Types

L12
L20
L20E
L20X
L220
A220
A32

Notes

For hobbing cutter Ø3.5mm

**RSH035**

3.5mm



1:1

Position

Front gang tool post

Machines Types

L12VII

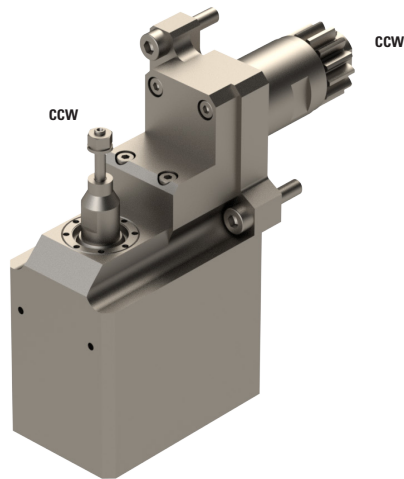
Notes

Diameter of the mill : Ø 30mm
Width of mill cutter : 3.5mm max
Adjustable $\pm 5^\circ$
Adjustable height $\pm 2^\circ$
Need 2 tools positions



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RSH035-II



Ø 3.5mm

⚙️ 1:1

Position Front gang tool post

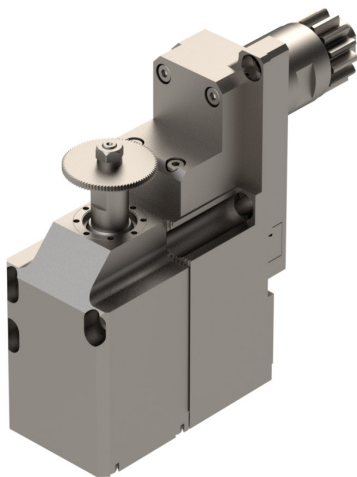
Machines Types L212-X

Notes

Use with spindle for F8 collet



RSH045



Ø 4.5mm

⚙️ 1:1

Position Front gang tool post

Machines Types L12VII

Notes

Diameter of the mill : Ø 30mm
Width of mill cutter : 4.5mm max
Adjustable height $\pm 2^\circ$
Need 2 tools positions

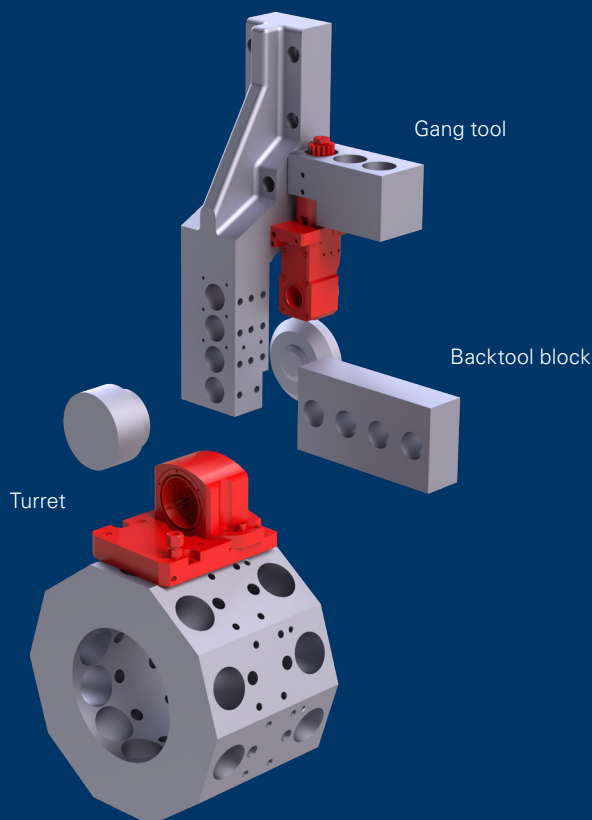


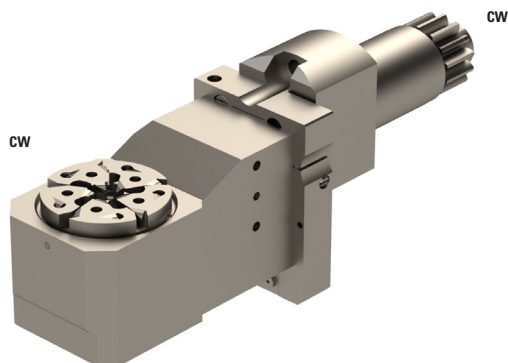
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WHIRLING TOOLS

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.



**MODULAR
SYSTEM****CITIZEN5-GSW-210**

Ø -

1:1

Position Upper gang tool post**Machines Types** L12-1M7
L12X**Notes**

Adjustable $\pm 10^\circ$
The CITIZEN5-PCR base and GSW-210 head are together on this tool.

Possibility to order them individually.

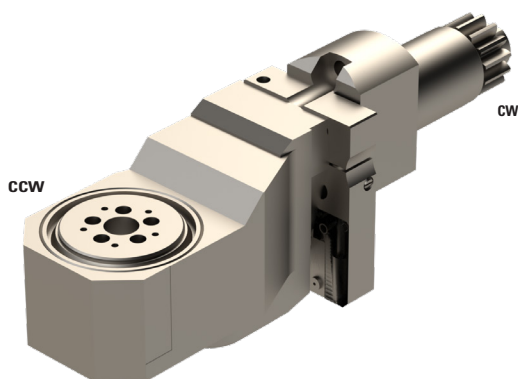
PCM cutterhead, Z=5, Ø6 mm

W04060611111 / UTILIS Thread whirling ring

Z=6 Ø6 mm

W03060511111 / SCHWANOG Thread whirling ring

Z=5 Ø6 mm

**MODULAR
SYSTEM****CITIZEN5-GSW-220-II**

Ø -

1:1

Position Upper gang tool post**Machines Types** L12-1M7
L12X
M416**Notes**

QUICK-CHANGE WHIRLING TOOL HOLDER (CR)

Adjustable $\pm 20^\circ$

The CITIZEN5-PCR base and GSW-220-II head are together on this tool.

Possibility to order them individually.

Possible collision with back tool post on L12.

W03040511111 / SCHWANOG Thread whirling ring

Z=5 Ø4 mm

W03060511112 / SCHWANOG Thread whirling ring

Z=5 Ø6 mm

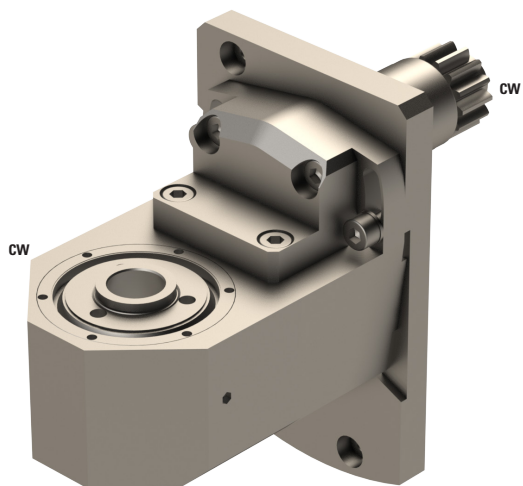
W02060511111 / GLOOR Thread whirling ring

Z=5 Ø6 mm



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LSW-515



-



1:1

Position

Upper gang tool post

Machines Types

L12-1M7

Notes

Adjustable +15°
Need 3 tool positions
Thread whirling ring not included !
W03060511113 / SCHWANOG Thread whirling ring
Z=5 Ø6 mm
501-0003 / GLOOR Thread whirling ring
Z=5 Ø6 mm
W01060311113 / GLOOR Thread whirling ring
Z=3 Ø6 mm



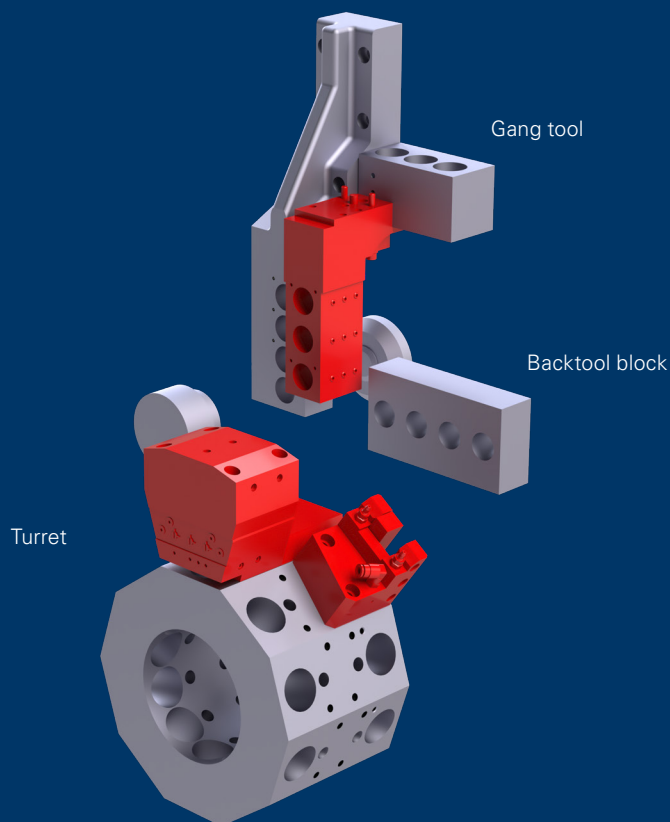
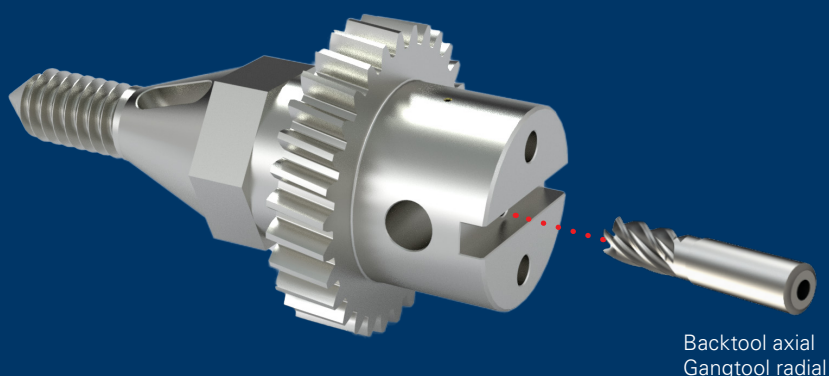
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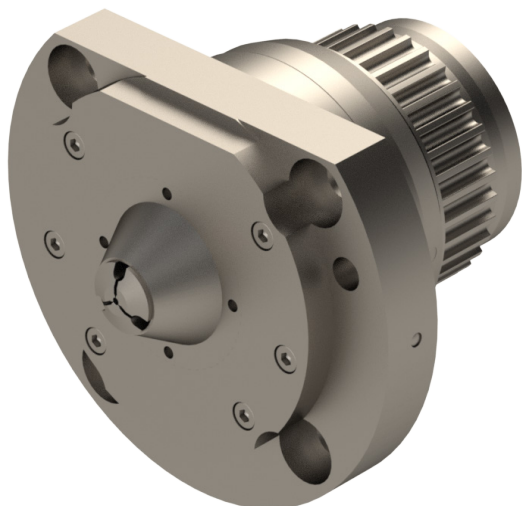
STATIC TOOLS

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.



L12-856-807

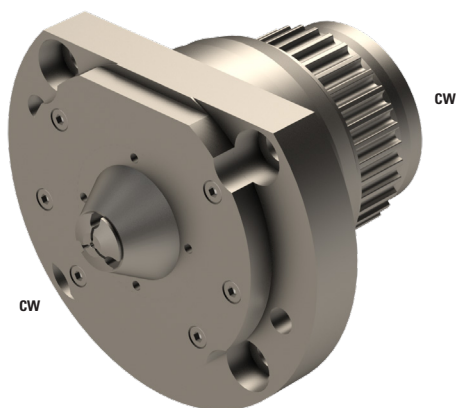
Ø7mm

Machines Types

L12-2M

Notes

For collet Meister 1352
Main spindle with fine adjustment

**L12-864-571**

Ø7

Machines Types

L12-1M7

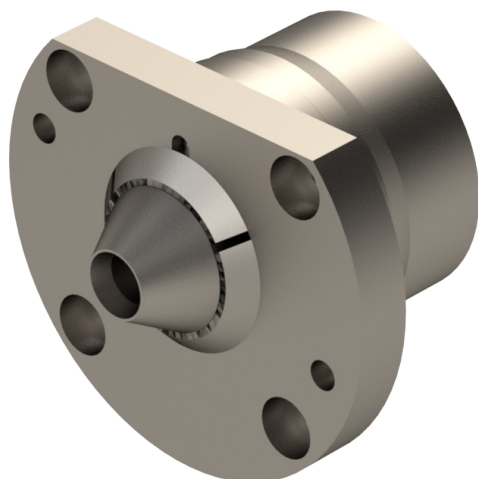
Notes

Replace the main spindle
Max. material Ø7 mm



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L12-872-761



Ø7mm

Machines Types

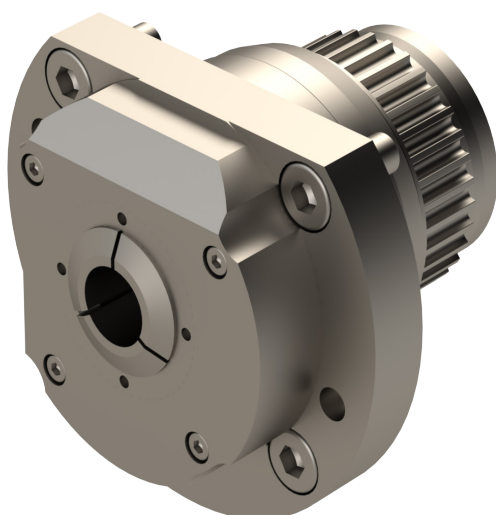
L12-1M7

Notes

For collet Meister 1352
Adjustable axial position
Main spindle



L12-876-872



Ø16mm

Machines Types

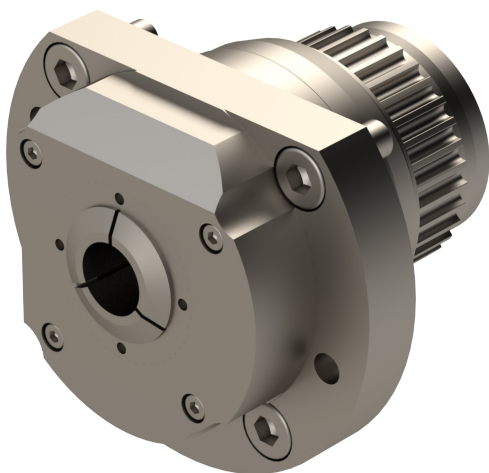
L12-1M7

Notes

For collet WIBEMO 605
Main spindle



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L12-876-876

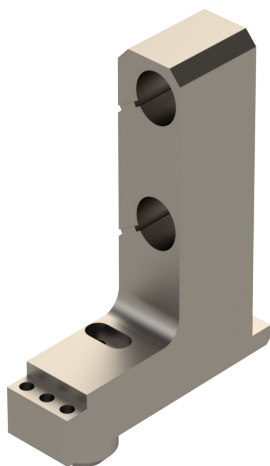
Ø16mm

Machines Types

L12-2M

Notes

Wibemo 605 Collet
Main guide bushing device

**LDF-HF08**

2xØ19.05mm



-

Machines Types

L12-2M10

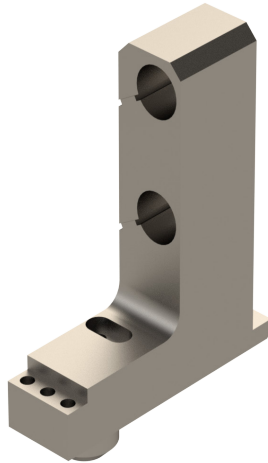
Notes

For MEYRAT MHF-19 Radial spindle



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LDF-HF08L



2xØ19.05mm



-

Machines Types

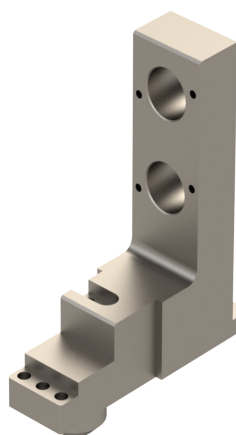
L12-2M10

Notes

For MEYRAT MHF-19 Radial spindle



LDF-HF09



2xØ20mm



-

Machines Types

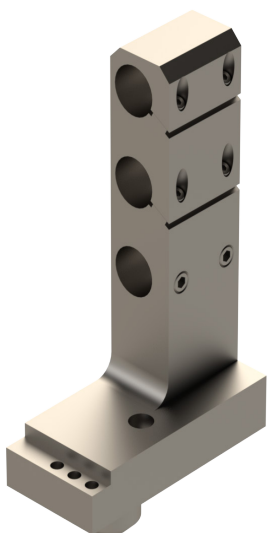
L12-2M10

Notes

For Nakanishi BM-320F Radial spindle



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LDF-HF102x HFØ19.05mm + 1x
Ø19.05mm

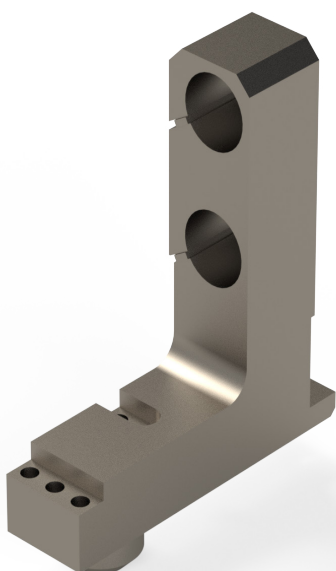
-

Machines Types

L12-2M10

Notes

For MEYRAT MHF-19 Radial spindle

**LDF-HF13**

2x Ø22mm



-

Machines Types

L12-2M10

Notes

For Nakanishi BMJ-322 radial spindle



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

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