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PCMI[®]

TOOL HOLDERS

CITIZEN CINCOM L20.



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.

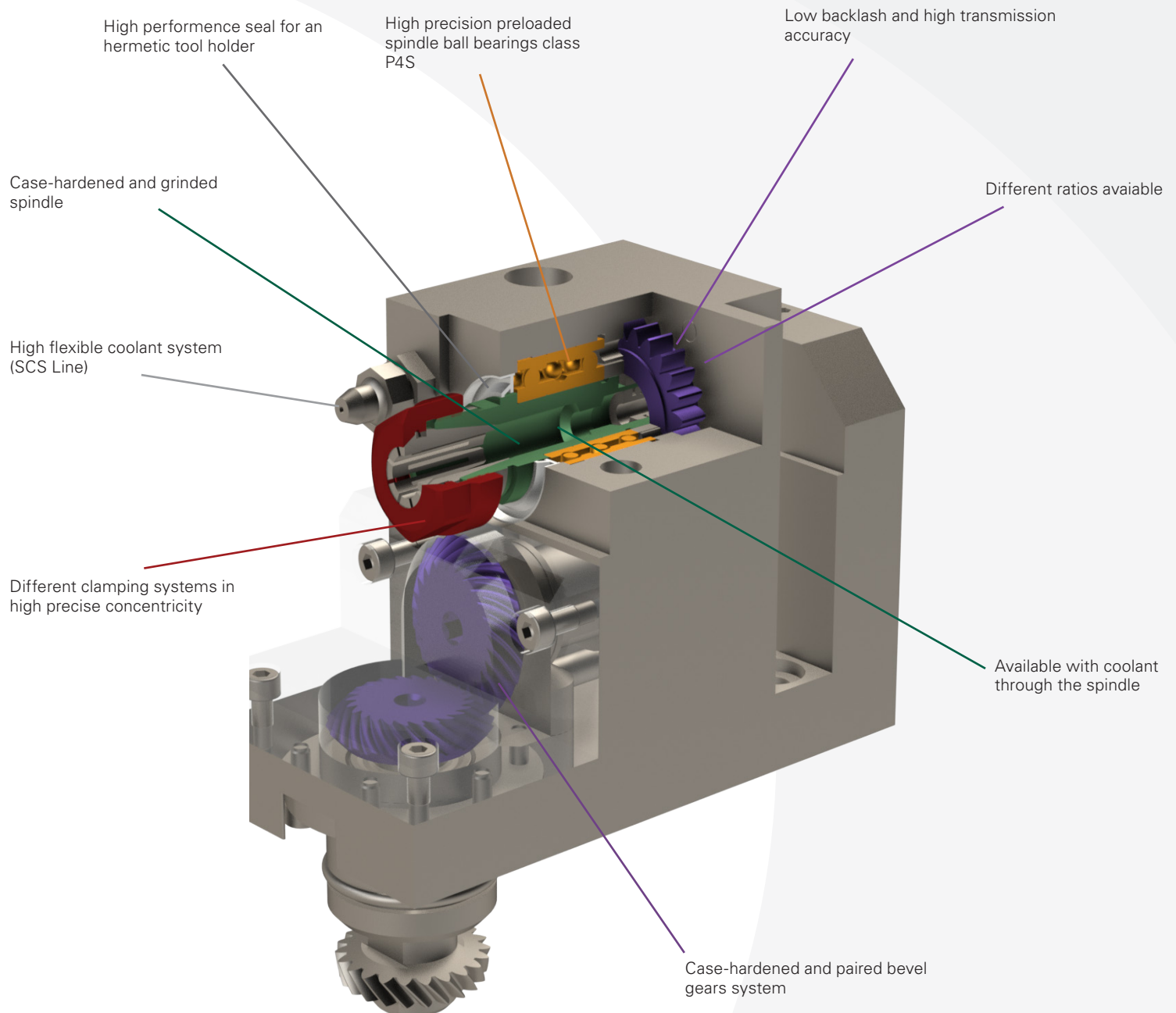
In close cooperation with machine builders and end users, we stay on the way to satisfied customers. We will keep this track in the future.

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 L20

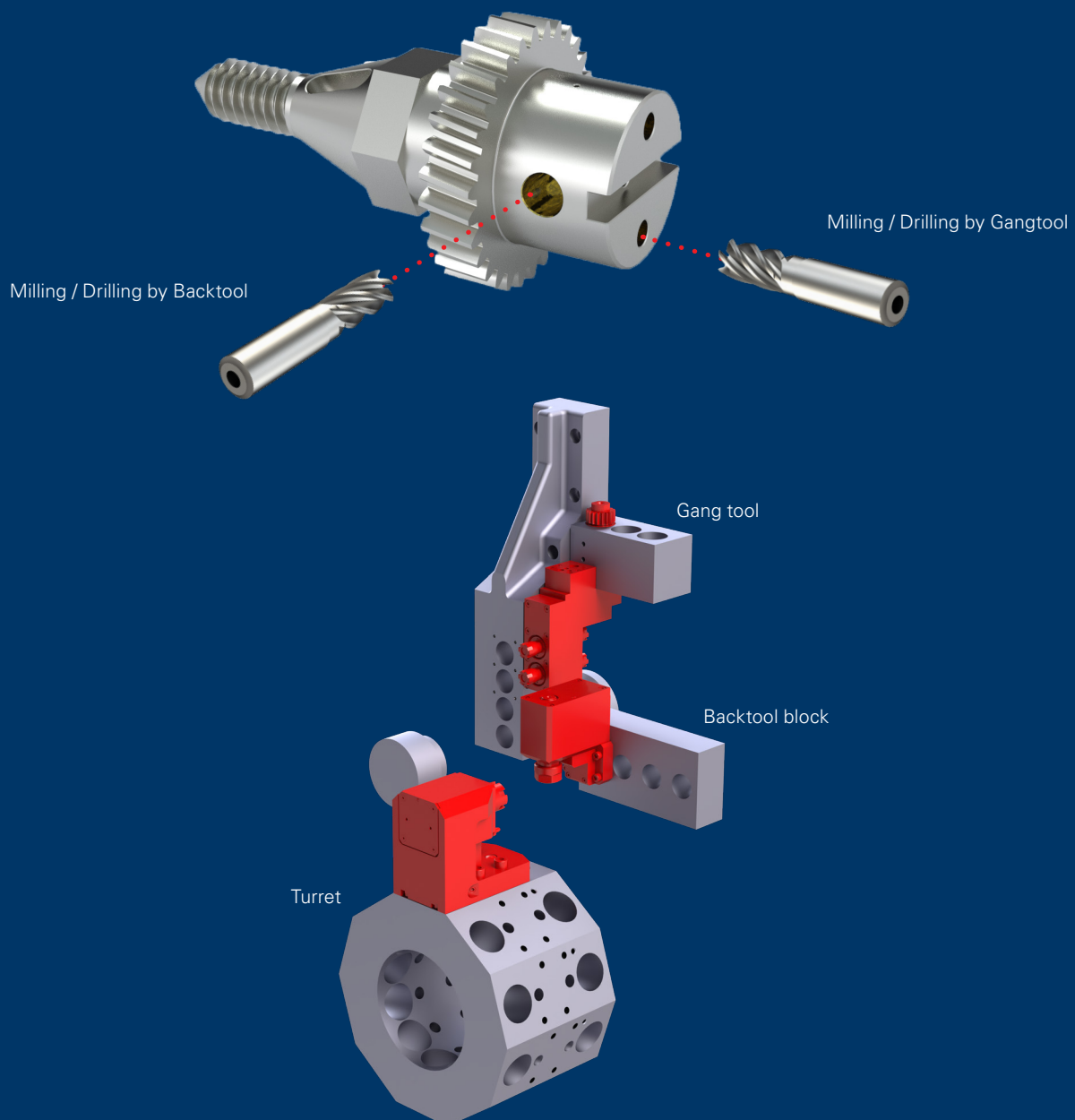
Radial tools	5
Axial tools	17
Accelereted tools	27
Adjustable tools	39
Slitting saw tools	43
Polygon tools	51
Hobbing tools	57
Whirling tools	61
Static tools	69

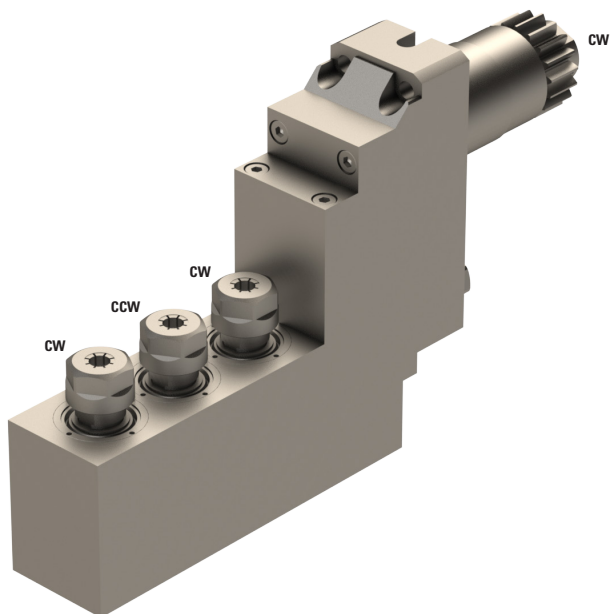
Rotation: **cw** Clockwise **ccw** Counterclockwise
Cooling: **INT** Interior **EXT** Exterior **⊘** Without

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

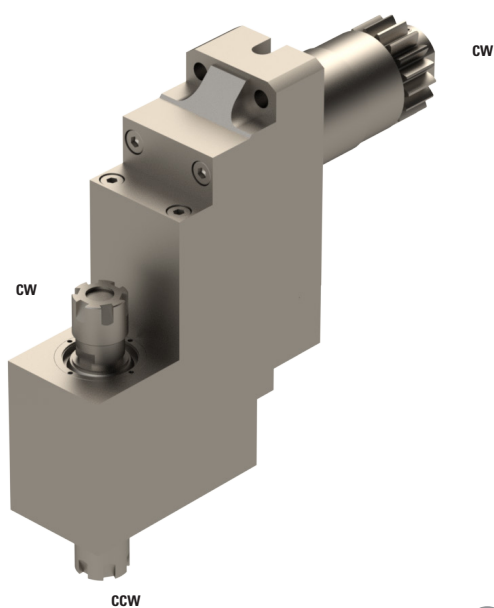
Upper gang tool post

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

**BSE1007-II**

1xER11+1xER11



1:1

Position

Upper gang tool post

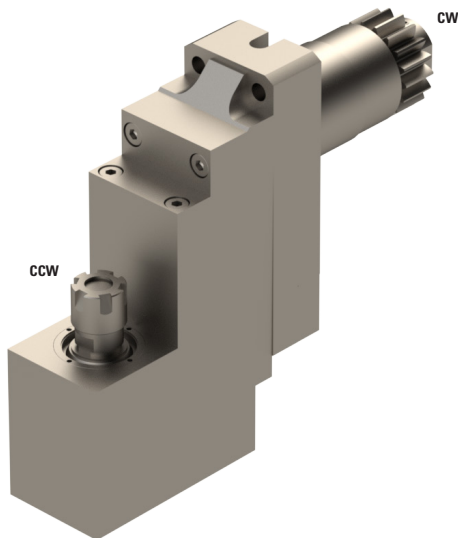
Machines Types

A20
A32
L20
L32
D25

Notes

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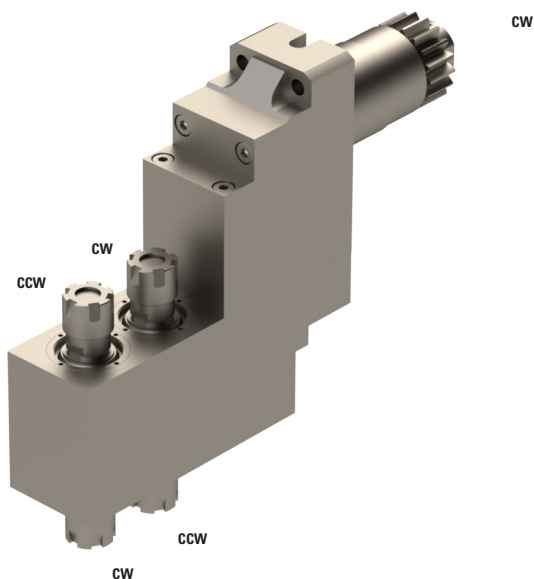
BSE107



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



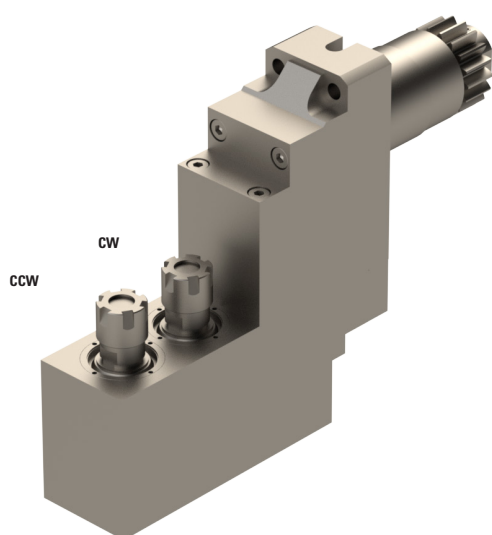
BSE2007-II



	2xER11+2xER11	
	1:1	
Position	Upper gang tool post	
Machines Types	A232-VII A32-VII A320-VII D25-VII	L32-1M8 L32-1M10 L32-1M12 L220-2M8
Notes		



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BSE-207-II

CW



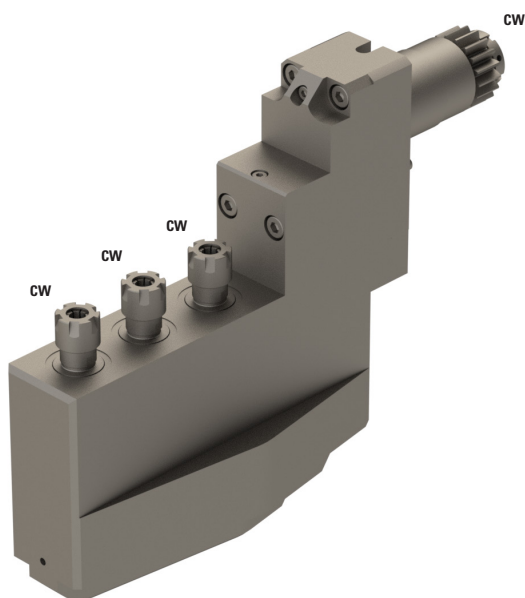
2xER11



1:1

Position

Upper gang tool post

Machines TypesA20
D25
L20
A32/L32**Notes****BSE3007-IK-3X**

CW



3x ER11



1:1/1:3

Position

Upper gang tool post

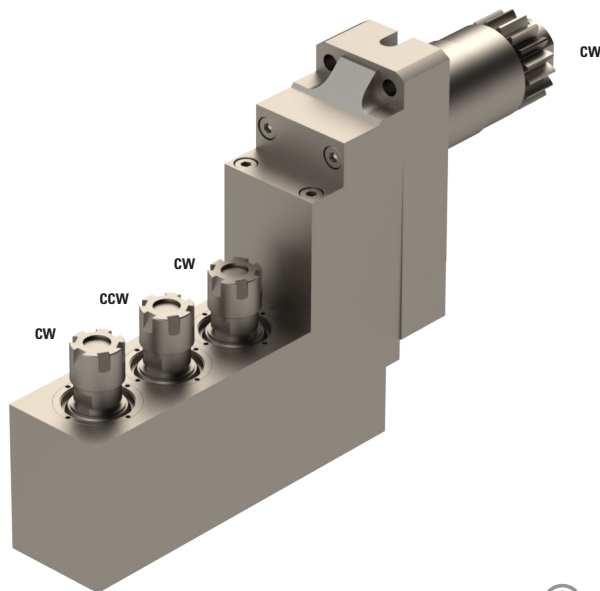
Machines TypesA20
D25
L20/L25
A32/L32
M32**Notes**

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]



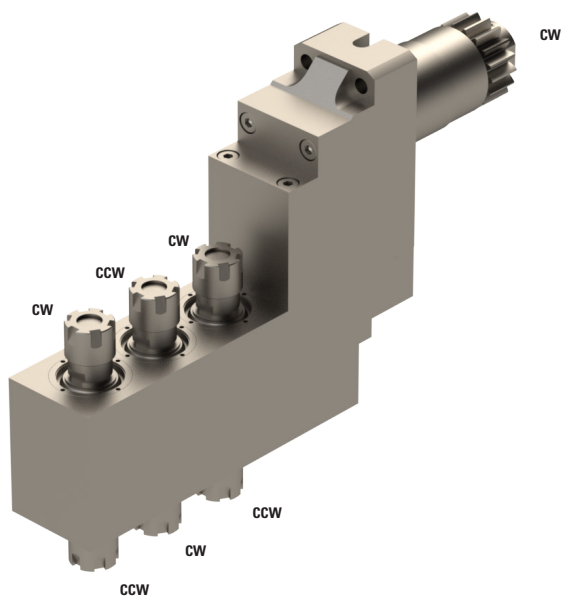
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BSE3107-II



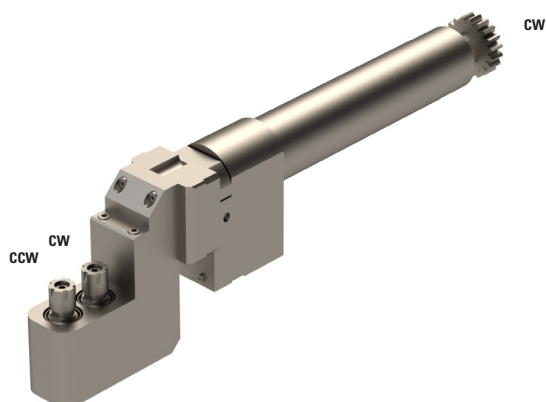
	3xER11
	1:1
Position	Upper gang tool post
Machines Types	A20 D25 L20 A32/L32
Notes	

BSE3206-II



	3xER11+3xER11
	1:1
Position	Upper gang tool post
Machines Types	A20 A32 L20 L32 D25
Notes	

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**MODULAR
SYSTEM****CITIZEN7-GSE-208**

2xER08



1:1

Position

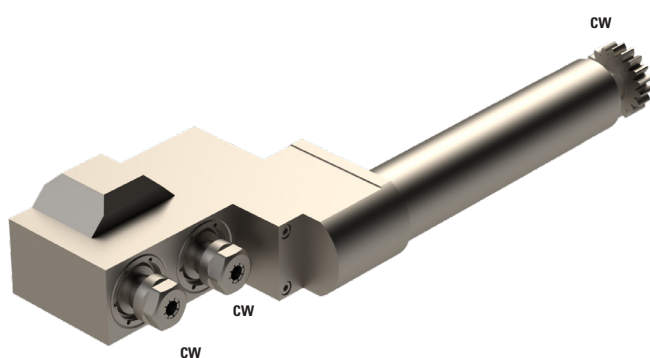
Upper gang tool post

Machines Types

L20E-2M8	M20-2M3
L20E-2M10	M20-2M5
L20E-1M12	M20-3M3
L20E IX	M20-3M5
L20V	M32-2M3
L20VII	M32-2M5
L20VIII	M32-3M3
L20X	M32-3M5

Notes

The CITIZEN7-PCR base and GSE208 head are together on this tool.
Possibility to order them individually.

**GSA-306-L-522**

2xER11



1:1

Position

Upper gang tool post

Machines Types

L20E-2M8	M20-2M3
L20E-2M10	M20-2M5
L20E-1M12	M20-3M3
L20E IX	M20-3M5
L20V	M32-2M3
L20VII	M32-2M5
L20VIII	M32-3M3
L20X	M32-3M5

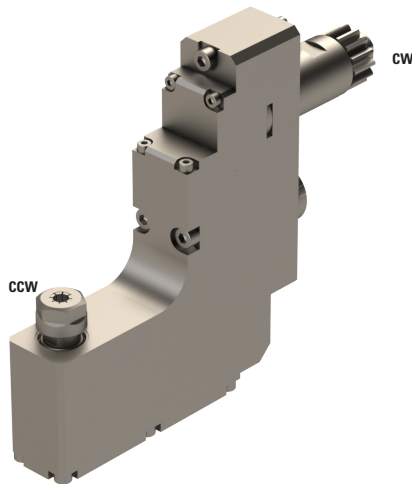
Notes

Adjustable 0°/5°/21°



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GSC-1407



 ER11

 1:1

Position Front gang tool post

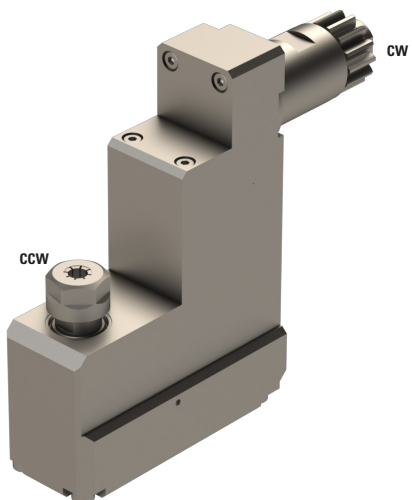
Machines Types L20X

Notes

Need 3 positions
Bloc U127B



GSC-1507



 ER11

 1:1

Position Front gang tool post

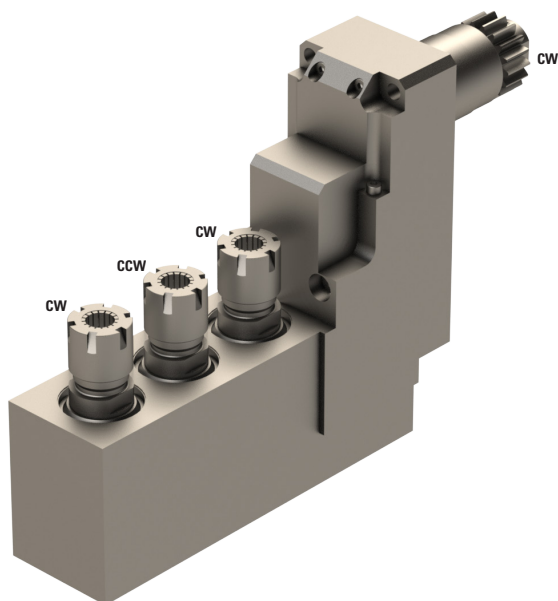
Machines Types

L20E2M8
L20E2M10
L20E-1M12
L20E-IX
L20X
L20XII

Notes



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GSE-1510

3xER16



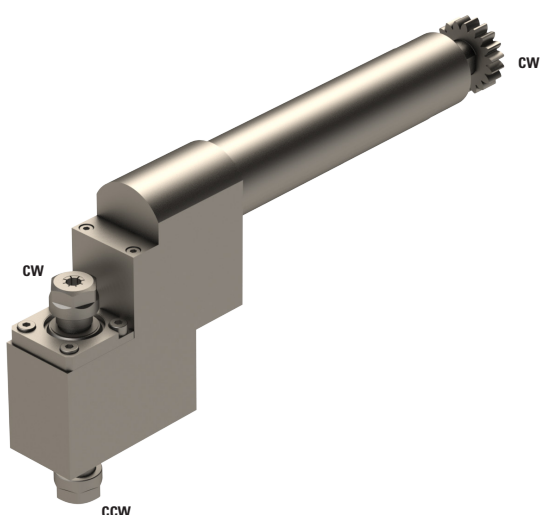
1:1

PositionUpper 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

**GSE-306-DE011**

2xER11



1:1

Position

Upper gang tool post

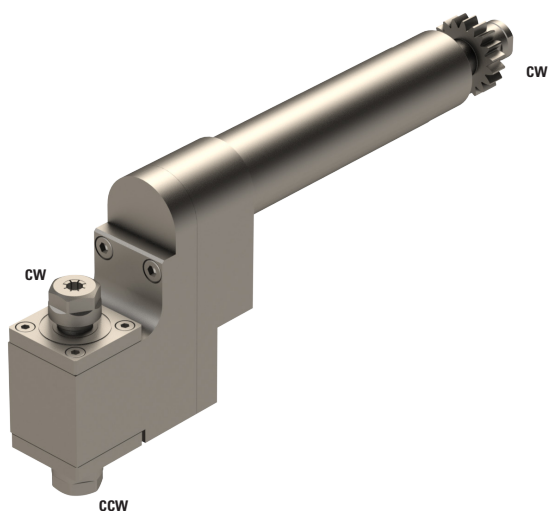
Machines Types

L20E-2M8	M20-2M3
L20E-2M10	M20-2M5
L20E-1M12	M20-3M3
L20E IX	M20-3M5
L20V	M32-2M3
L20VII	M32-2M5
L20VIII	M32-3M3
L20X	M32-3M5

Notes

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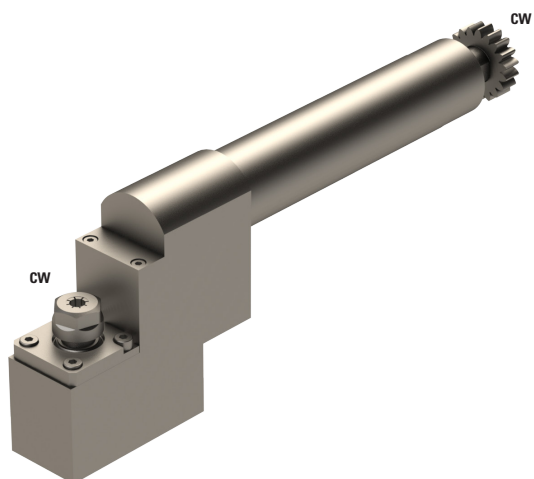
GSE-306-DE511



	2xER11
	1:1
Position	Upper gang tool post
Machines Types	L25-VII
Notes	



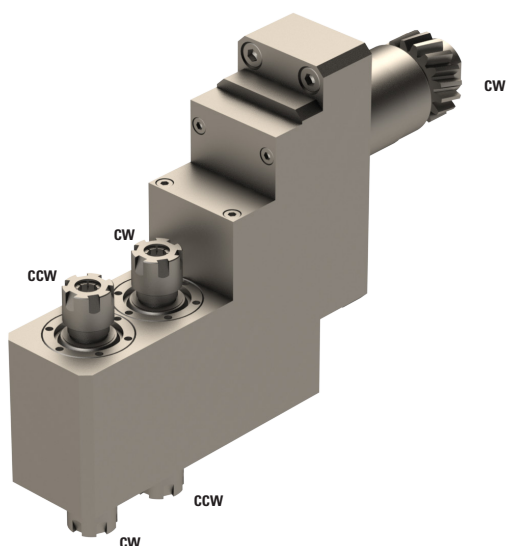
GSE-306-L-520



	ER11																
	1:1																
Position	Upper gang tool post																
Machines Types	<table> <tr> <td>L20E-2M8</td><td>M20-2M3</td></tr> <tr> <td>L20E-2M10</td><td>M20-2M5</td></tr> <tr> <td>L20E-1M12</td><td>M20-3M3</td></tr> <tr> <td>L20E IX</td><td>M20-3M5</td></tr> <tr> <td>L20V</td><td>M32-2M3</td></tr> <tr> <td>L20VII</td><td>M32-2M5</td></tr> <tr> <td>L20VIII</td><td>M32-3M3</td></tr> <tr> <td>L20X</td><td>M32-3M5</td></tr> </table>	L20E-2M8	M20-2M3	L20E-2M10	M20-2M5	L20E-1M12	M20-3M3	L20E IX	M20-3M5	L20V	M32-2M3	L20VII	M32-2M5	L20VIII	M32-3M3	L20X	M32-3M5
L20E-2M8	M20-2M3																
L20E-2M10	M20-2M5																
L20E-1M12	M20-3M3																
L20E IX	M20-3M5																
L20V	M32-2M3																
L20VII	M32-2M5																
L20VIII	M32-3M3																
L20X	M32-3M5																
Notes																	



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GSE-3107

2xER11+2xER11



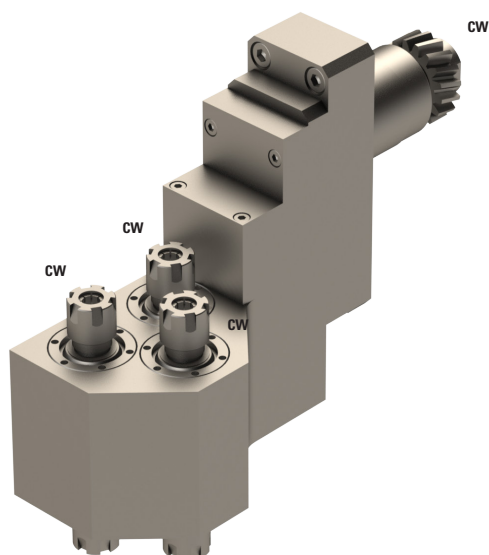
1:1

Position

Back gang tool post

Machines Types

L20E2M8
L20E2M10
L20E-1M12
L20E-IX
L20V
L20VII
L20VIII
L20X

Notes**GSE-3207**

3xER11 + 3xER11



1:1

Position

Back gang tool post

Machines Types

L20E

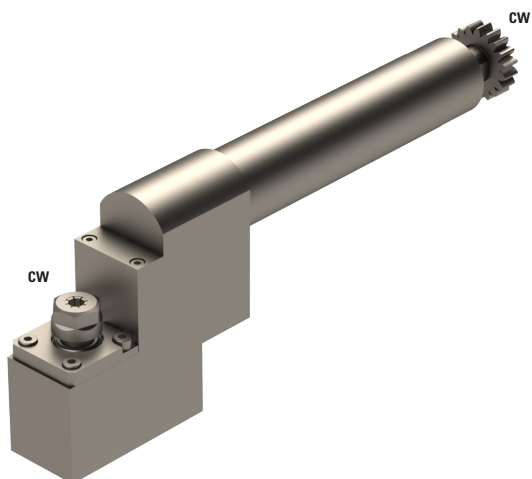
Notes

Only with the block GSE3210



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GSE-310-L-520



ER16



1:1

Position

Upper gang tool post

Machines Types

L20V	M232-V
L20VII	M320-III
L20VIII	M320-V
L20X	M332-III
M220-III	M332-V
M220-V	M32-4M5
M232-III	M32-4M8

Notes

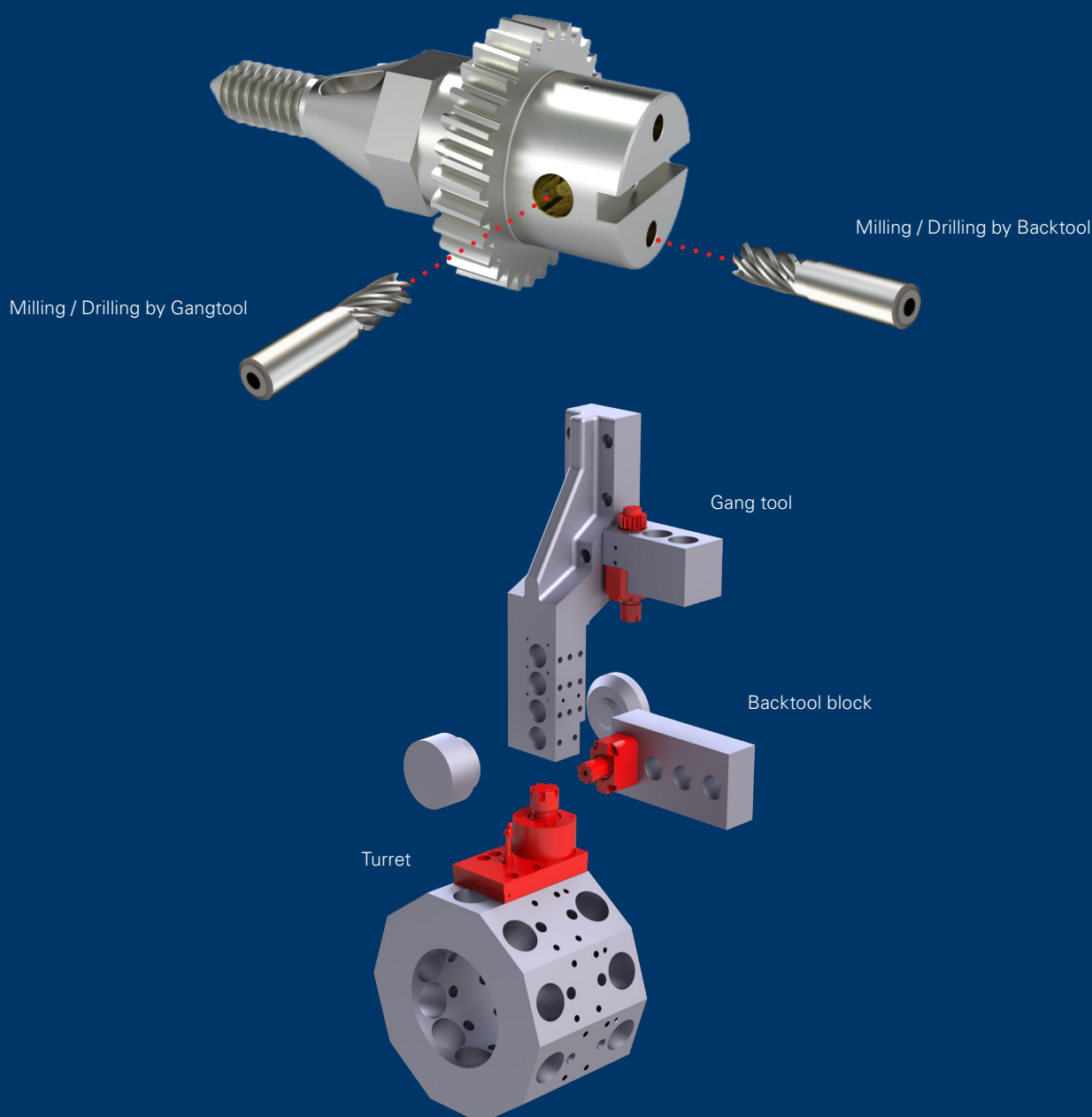


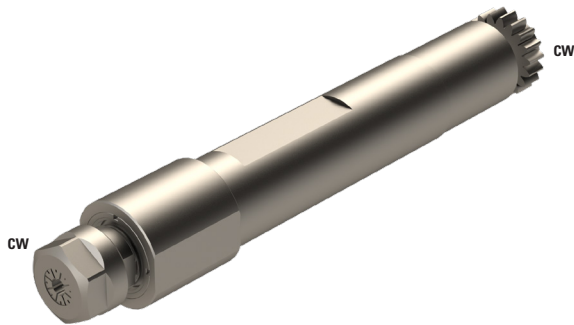
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AXIAL DRILLING / MILLING TOOLS

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.



GSC-1010

ER16



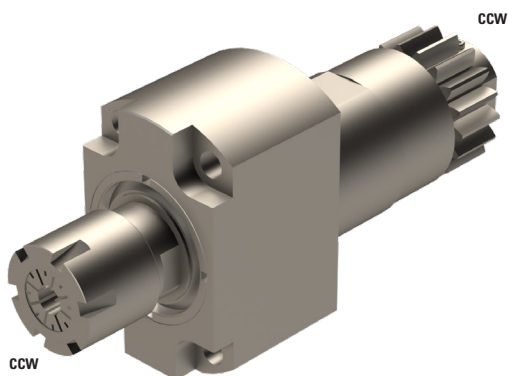
1:1

Position

Upper gang tool post

Machines Types

L20E-2M8	M20-2M3
L20E-2M10	M20-2M5
L20E-1M12	M20-3M3
L20E IX	M20-3M5
L20V	M32-2M3
L20VII	M32-2M5
L20VIII	M32-3M3
L20X	M32-3M5

Notes**GSC-1110**

ER16



1:1

Position

Upper gang tool

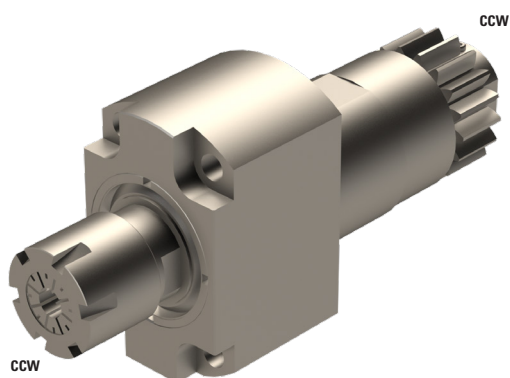
Machines Types

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

Notes

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GSC1110-L



ER16



1:1

Position

Upper gang tool

Machines Types

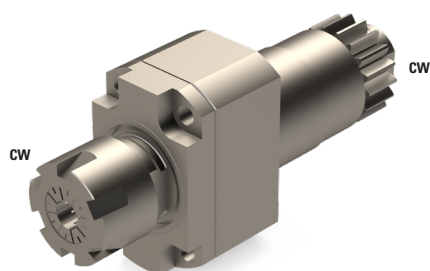
A20-3F7N	M220-III
A232-VII	M220-V
A32-VII	M232-III
A320-VII	M232-V
D25-VII	M320-III
L20E-2M8	M320-V
L20E-2M10	M332-III
L20E-2M12	M332-V
L32-1M8	M32-4M5
L32-1M10	M32-4M8
L32-1M12	M32-5M5
	M32-5M7
	M32-5M8

Notes

LENGTH : 70mm



GSC-1113



ER20



1:1

Position

Upper gang tool post

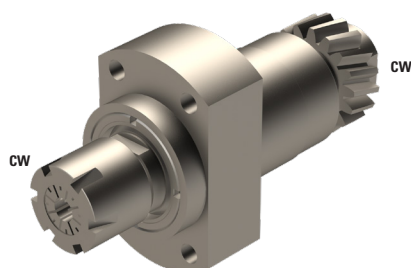
Machines Types

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

Notes



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GSC-1210

ER16



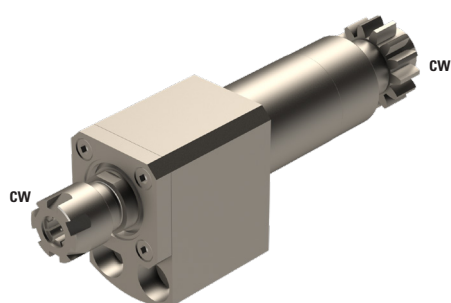
1:1

Position

Upper gang tool post

Machines Types

L20E2M8
L20E2M10
L20E-1M12
L20E-IX

Notes**GSC-907**

ER11



1:1

Position

Upper gang tool post

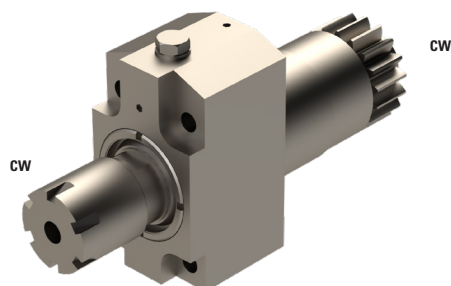
Machines Types

L20E-2M8	M20-2M3
L20E-2M10	M20-2M5
L20E-1M12	M20-3M3
L20E IX	M20-3M5
L20V	M32-2M3
L20VII	M32-2M5
L20VIII	M32-3M3
L20X	M32-3M5

Notes

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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»

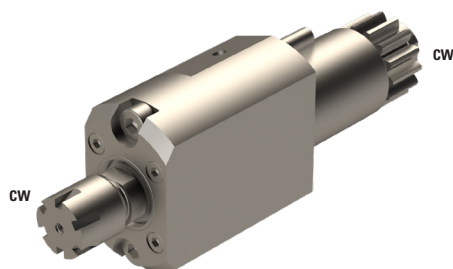
Input: M6 (M)

Output: 1/8" (M)

Pression max = 200 bar



GSE3407-HP



ER11



1:1

Position

Back gang tool post

Machines Types

L20E2M8
L20E2M10
L20E-1M12
L20E-IX

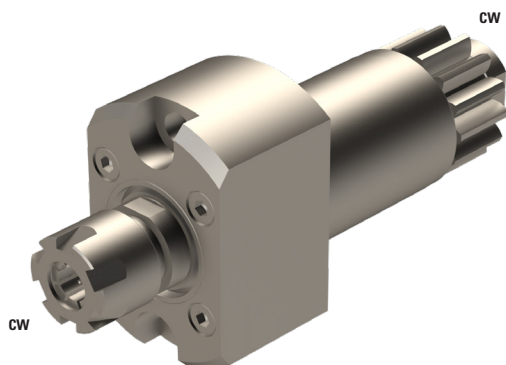
Notes

RPM max : 3'900



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MSC-507-II



ER11



1:1

Position

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

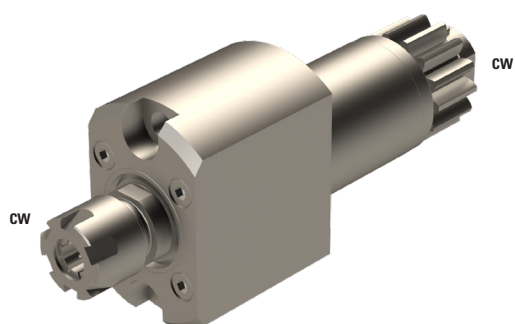
Machines Types

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
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



MSC-507-L



ER11



1:1

Position

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

Machines Types

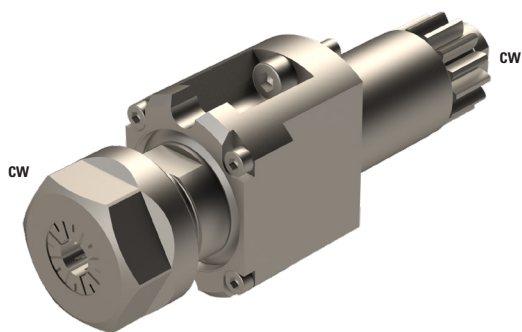
A20-VII	M320-V
A20-3F7N	M332-III
A320-VII	M332-V
L12-1M7	M32-4M5
L20E-2M12	M32-4M8
L20E-2M10	M32-5M5
L20E-2M8	M32-5M7
L20E-IX	M32-5M8
L220-VIII	M212-C
L220IX	M212-V
L20X	M216-C
L32-1M12	M216-V
L32-1M10	M312-III
L32-1M8	M312-V
M220-III	M312-VII
M220-V	M316-III
M232-III	M316-V
M232-V	M16-4M5
M320-III	M16-4M8

Notes



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MSC-513



ER20



1:1

Position

Upper gang tool post
Front gang tool post

Machines Types

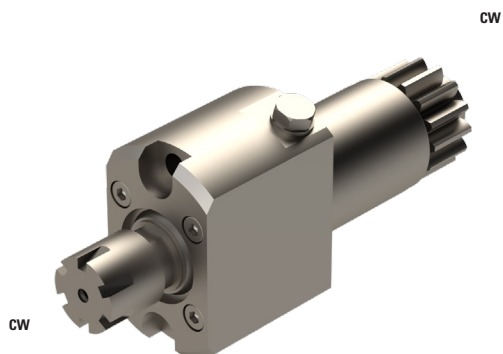
A20-3F7N	M212-V
A320-VII	M216-C
L12-1M7	M216-V
L20E-2M12	M312-III
L20E-2M10	M312-V
L20E-2M8	M312-VII
L20E-IX	M316-III
L20X	M316-V
M212-C	M16-4M5
	M16-4M8

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

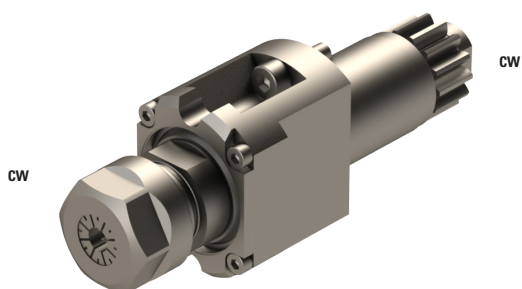
Machines Types

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



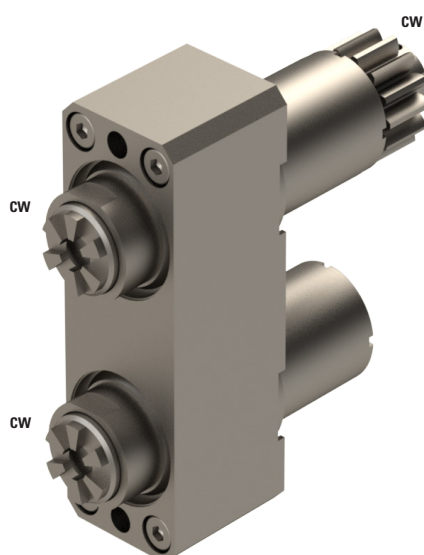
1:1

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.

**MSE807**

2xER11



1:1

Position

Front gang tool post

Machines Types

L220E

Notes

U155B

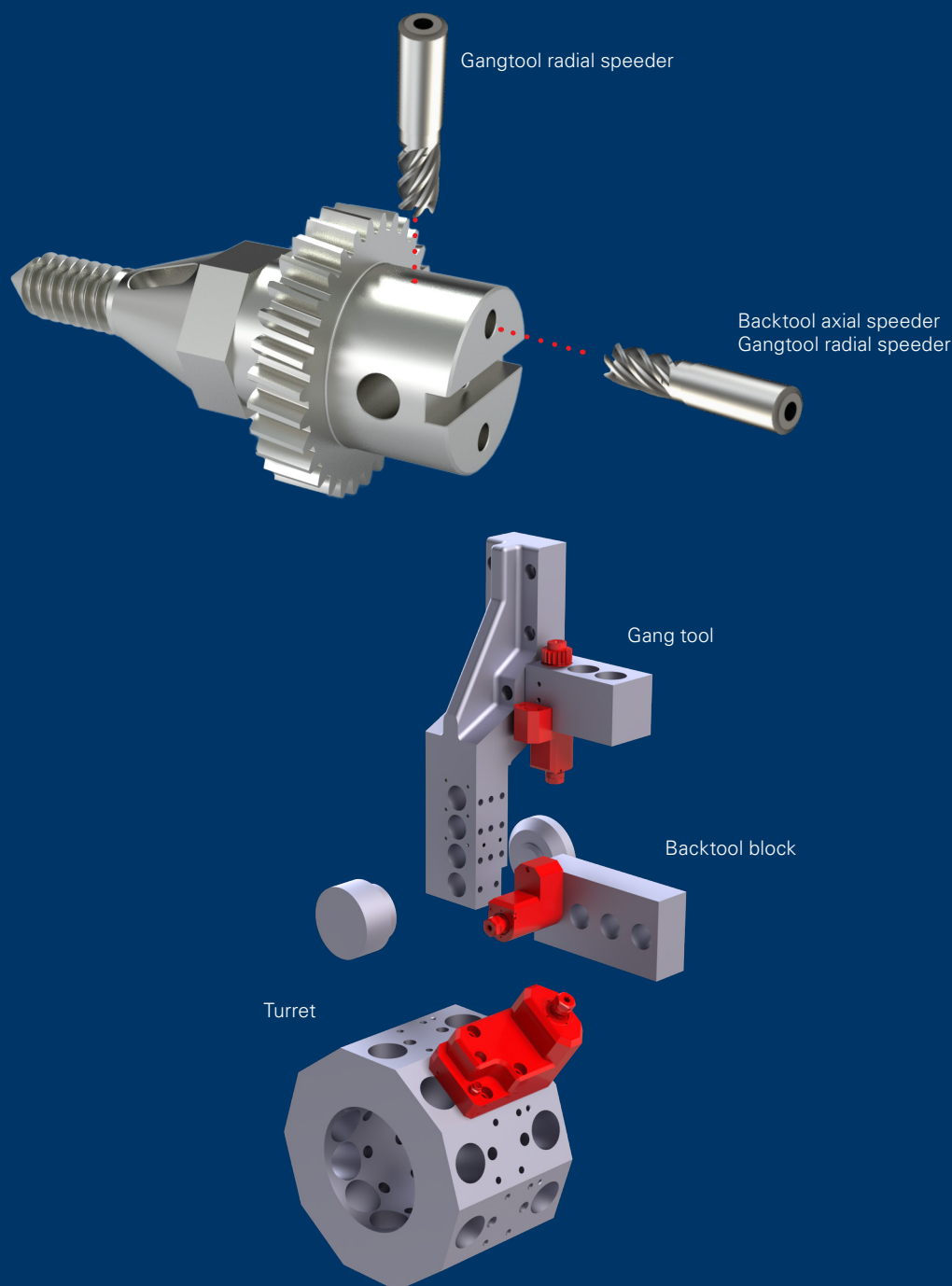


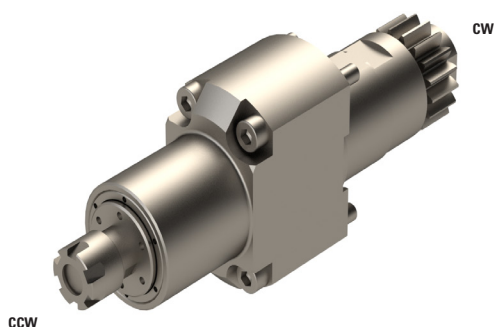
We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

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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



BSC1107-4X

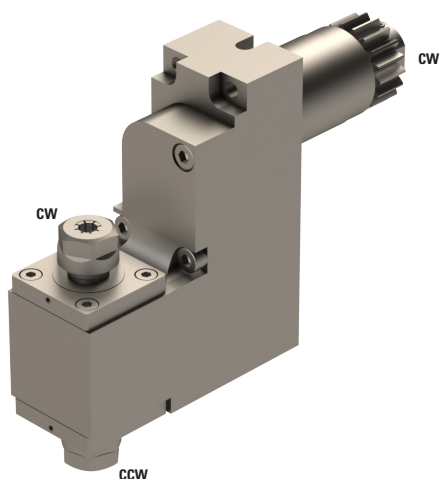
ER11



1:3.8

PositionUpper 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**BSE307-3X**

2xER11



1:3

Position

Upper gang tool post

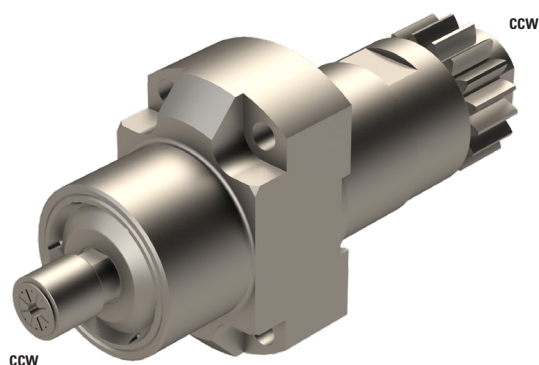
Machines Types

L20E2M8
L20E2M10
L20E-1M12
L20E-IX
L20V
L20VII
L20VIII
L20X
M32-3M5
M32-3M3
M32-4M5
M32-4M8

Notes

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GSC-1110-4X



 ER08

 1:3.8

Position Upper gang tool post

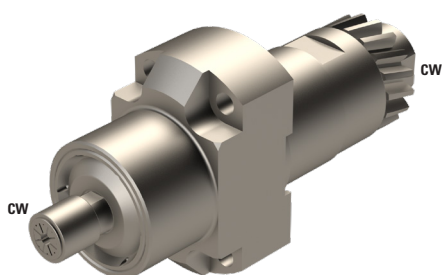
Machines Types

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



GSC-1210-4X



 ER08

 1:3.8

Position Back gang tool post

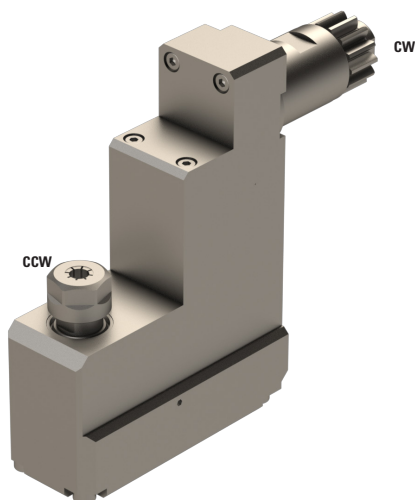
Machines Types

L20E2M8
L20E2M10
L20E-1M12
L20E-IX

Notes



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GSC-1507-3X

ER11



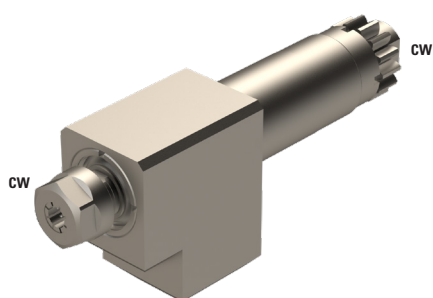
1:3

Position

Front gang tool post

Machines Types

L20E2M8
L20E2M10
L20E-1M12
L20E-IX
L20X
L20XII

Notes**GSC-204-3X**

ER11



1:3

Position

Upper gang tool post

Machines Types

L20E-2M8	M20-2M3
L20E-2M10	M20-2M5
L20E-1M12	M20-3M3
L20E IX	M20-3M5
L20V	M32-2M3
L20VII	M32-2M5
L20VIII	M32-3M3
L20X	M32-3M5

Notes

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GSC-310-3X



	ER11
	1:3
Position	Upper gang tool post
Machines Types	L25
Notes	



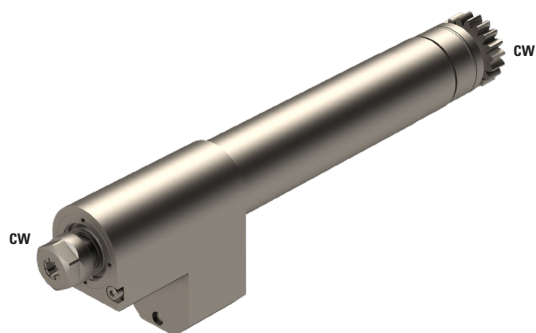
GSC-510-3X



		ER11
		1:3
Position		Upper gang tool post
Machines Types	L20E-2M8	M20-2M3
	L20E-2M10	M20-2M5
	L20E-1M12	M20-3M3
	L20E IX	M20-3M5
	L20V	M32-2M3
	L20VII	M32-2M5
	L20VIII	M32-3M3
	L20X	M32-3M5
Notes		



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GSC-510-L-3X

ER11



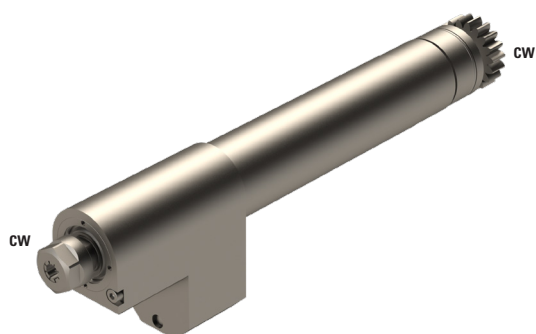
1:3

Position

Upper gang tool post

Machines Types

L20E-2M8	M20-2M3
L20E-2M10	M20-2M5
L20E-1M12	M20-3M3
L20E IX	M20-3M5
L20V	M32-2M3
L20VII	M32-2M5
L20VIII	M32-3M3
L20X	M32-3M5

Notes**GSC-510-L-3X**

ER11



1:3

Position

Upper gang tool post

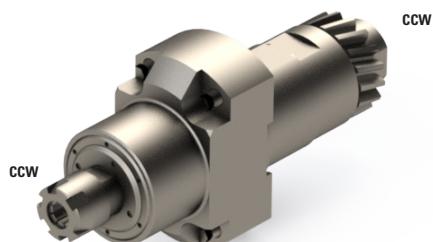
Machines Types

L20E-2M8	M20-2M3
L20E-2M10	M20-2M5
L20E-1M12	M20-3M3
L20E IX	M20-3M5
L20V	M32-2M3
L20VII	M32-2M5
L20VIII	M32-3M3
L20X	M32-3M5

Notes

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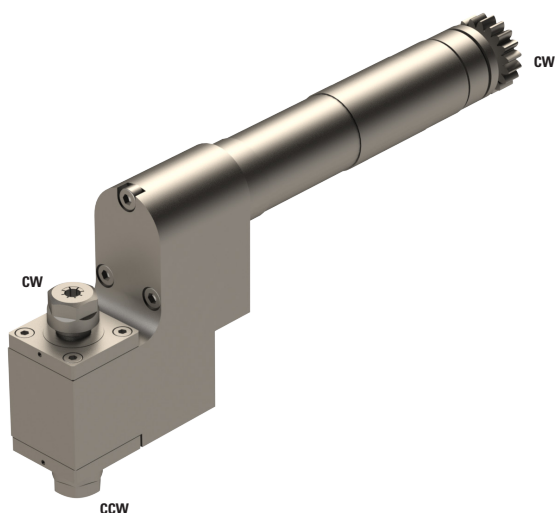
GSC1207-4X



	ER11
	1:3.8
Position	Upper gang tool post
Machines Types	L20E L20X
Notes	



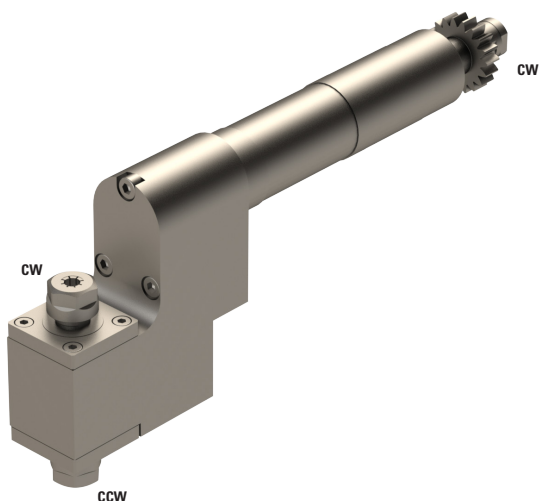
GSE-306-DE312



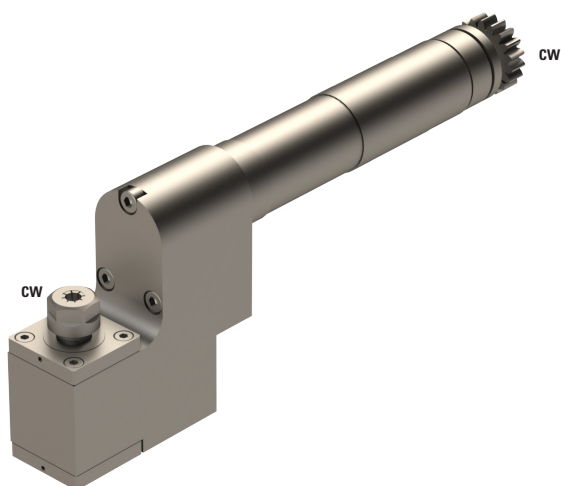
	2xER11																
	1:3																
Position	Upper gang tool post																
Machines Types	<table border="0"> <tr> <td>L20E-2M8</td><td>M20-2M3</td></tr> <tr> <td>L20E-2M10</td><td>M20-2M5</td></tr> <tr> <td>L20E-1M12</td><td>M20-3M3</td></tr> <tr> <td>L20E IX</td><td>M20-3M5</td></tr> <tr> <td>L20V</td><td>M32-2M3</td></tr> <tr> <td>L20VII</td><td>M32-2M5</td></tr> <tr> <td>L20VIII</td><td>M32-3M3</td></tr> <tr> <td>L20X</td><td>M32-3M5</td></tr> </table>	L20E-2M8	M20-2M3	L20E-2M10	M20-2M5	L20E-1M12	M20-3M3	L20E IX	M20-3M5	L20V	M32-2M3	L20VII	M32-2M5	L20VIII	M32-3M3	L20X	M32-3M5
L20E-2M8	M20-2M3																
L20E-2M10	M20-2M5																
L20E-1M12	M20-3M3																
L20E IX	M20-3M5																
L20V	M32-2M3																
L20VII	M32-2M5																
L20VIII	M32-3M3																
L20X	M32-3M5																
Notes																	



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GSE-306-DE512

	2xER11
	1:3
Position	Upper gang tool post
Machines Types	L25-VII
Notes	

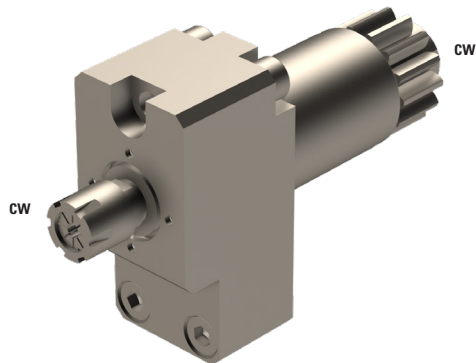
**GSE-306-SE312**

		ER11
		1:3
Position	Upper gang tool post	
Machines Types	L20E-2M8	M20-2M3
	L20E-2M10	M20-2M5
	L20E-1M12	M20-3M3
	L20E IX	M20-3M5
	L20V	M32-2M3
	L20VII	M32-2M5
	L20VIII	M32-3M3
	L20X	M32-3M5
Notes		



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GSE-3307-3X



ER08



1:3

Position

Front gang tool post

Machines Types

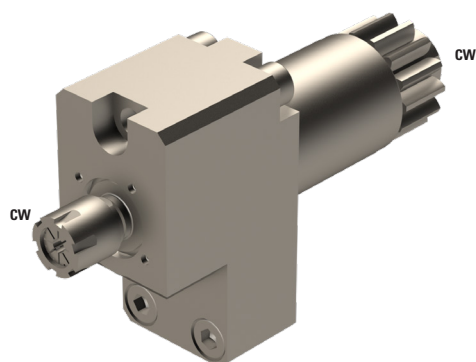
A20-3F7N	L20E-2M12
A20-VII	L20E-IX
A320-VII	L20X
L12-1M7	L32-1M8
L20E-2M8	L32-1M10
L20E-2M10	L32-1M12

Notes

Use at maximum torque of 1500Nm



GSE-3307-L-3X



ER08



1:3

Position

Front gang tool post

Machines Types

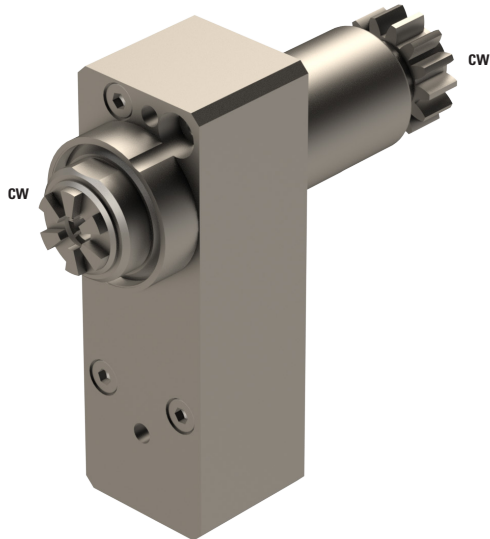
A20-3F7N	L20E-2M12
A20-VII	L20E-IX
A320-VII	L20X
L12-1M7	L32-1M8
L20E-2M8	L32-1M10
L20E-2M10	L32-1M12

Notes



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GSE-3507-3X



ER11



1:3

Position

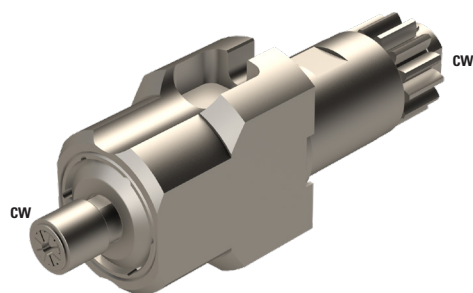
Front gang tool post

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-507-4X



ER08



1:3.8

Position

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

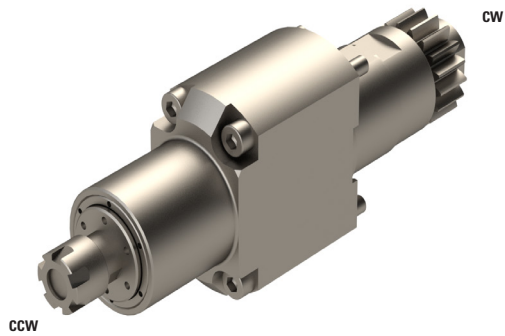
Machines Types

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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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



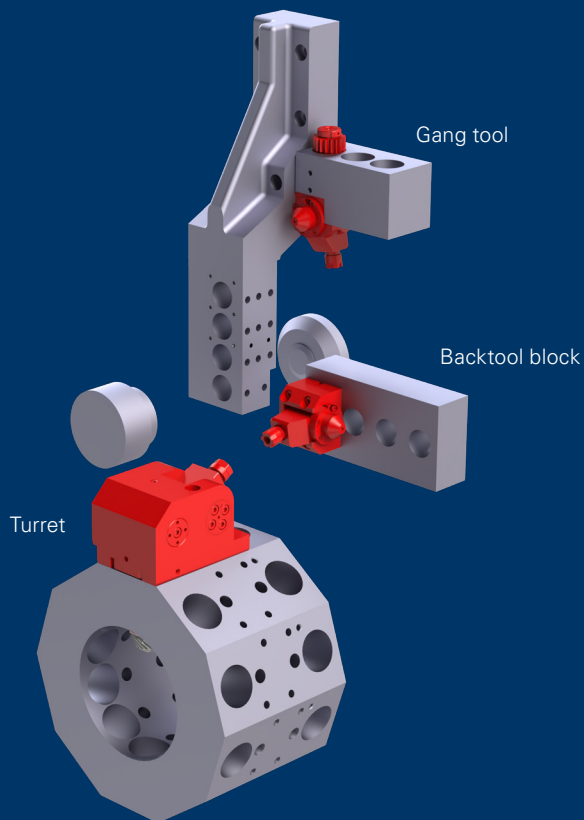
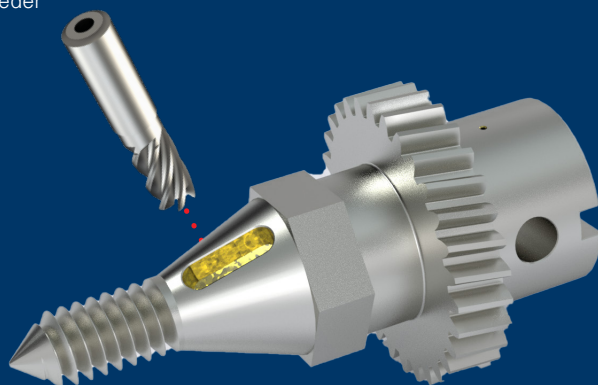
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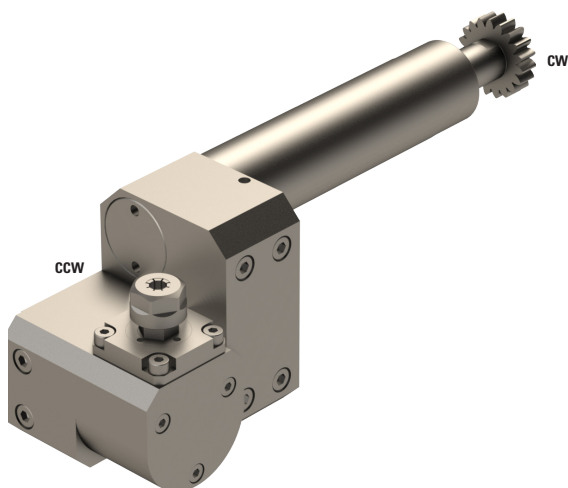
ANGLE ADJUSTABLE TOOLS

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



GSA-107

ER11



1:1

Position

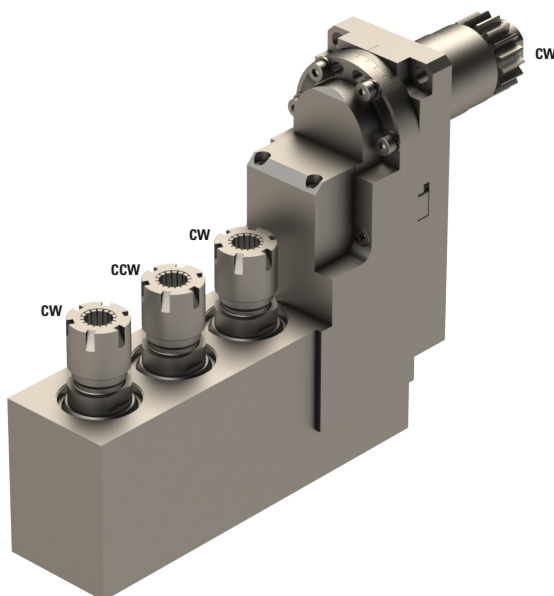
Upper gang tool post

Machines Types

L20E-2M8	M20-2M3
L20E-2M10	M20-2M5
L20E-1M12	M20-3M3
L20E IX	M20-3M5
L20V	M32-2M3
L20VII	M32-2M5
L20VIII	M32-3M3
L20X	M32-3M5

Notes

Need 2 tool positions
Adjustable 0°-180°

**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

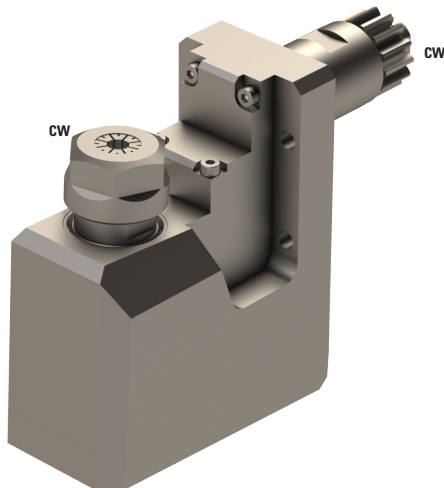
Notes

Need 2 tool positions
Adjustable 0°-30°



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GSA-1530

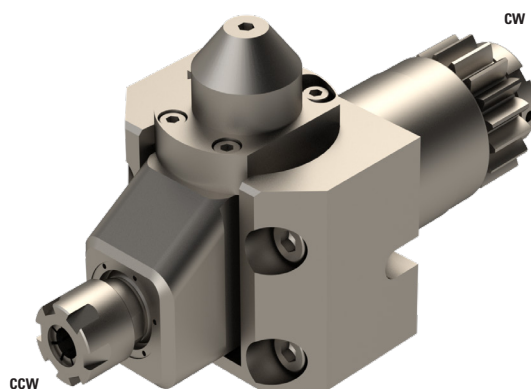


	ER16
	1:1
Position	Upper gang tool post
Machines Types	L20E2M8 L20E2M10 L20E-1M12 L20E-IX
Notes	

Fixe angle on 93°



GSA1007



	ER11
	1:1
Position	Upper gang tool post
Machines Types	L20X
Notes	

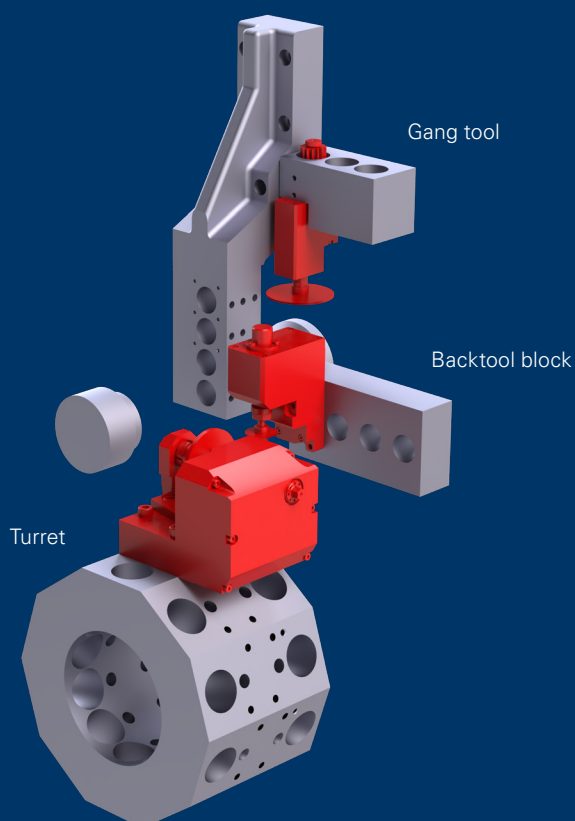
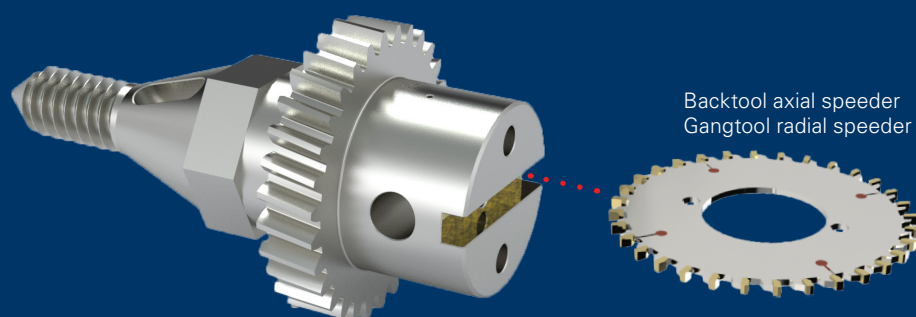
Adjustable $\pm 10^\circ$
Maximum Angle against the spindle $+9^\circ$

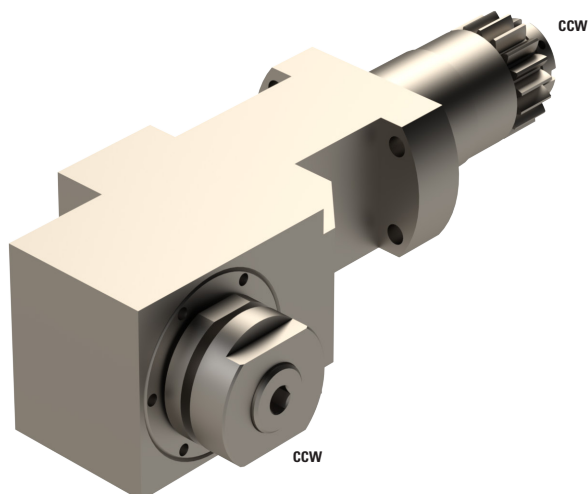


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SAWBLADE TOOLS

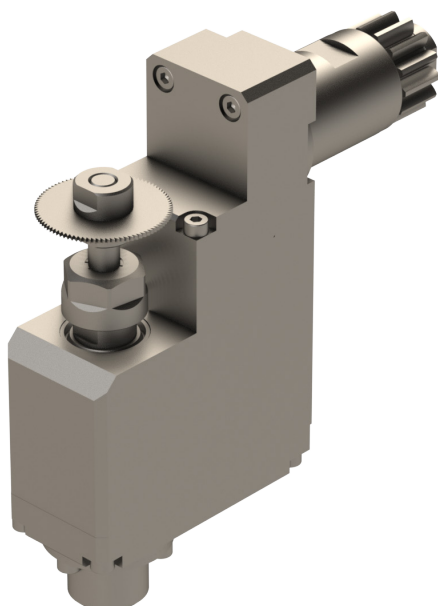
On a bar lathe, the distance between a tool and the guide bush is very short in order to achieve maximum stability of the workpiece and therefore minimum vibration. The distance from the tool axis to the zero point of the machine is between 2 mm and 10 mm, depending on the type of machine. It is therefore 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.



BSS122

	22
	2:1
Position	Upper gang tool post
Machines Types	L220X
Notes	

RPM max : 1'000
 Max. tool Ø80 - Ø125
 Max. cutter thickness 5mm max.

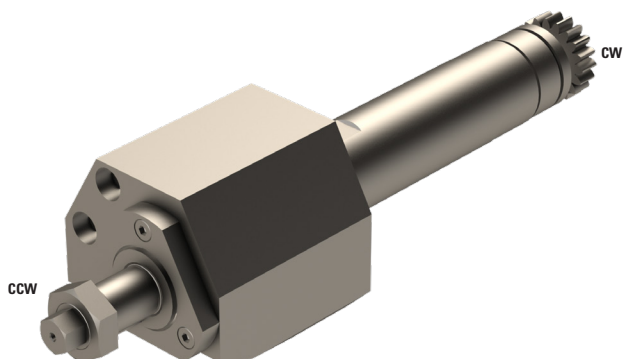
**GSS-1331**

	ER11
	1:1
Position	Back gang tool post
Machines Types	L20E-2M8 L20E-2M10 L20E-2M12 L20E-IX L20E-X
Notes	



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GSS-510



Ø 16

2:1

Position Upper gang tool post

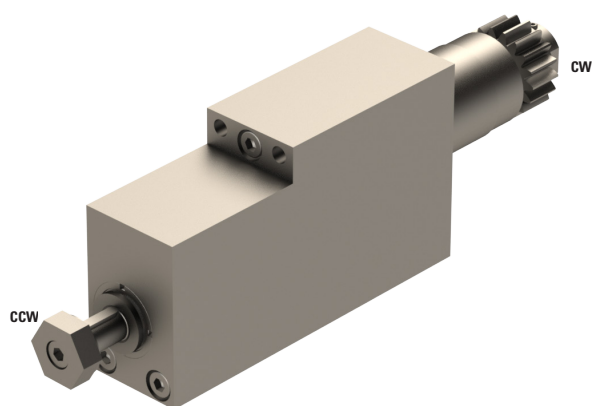
Machines Types	L20E-2M8	M20-2M3
	L20E-2M10	M20-2M5
	L20E-1M12	M20-3M3
	L20E IX	M20-3M5
	L20V	M32-2M3
	L20VII	M32-2M5
	L20VIII	M32-3M3
	L20X	M32-3M5

Notes

Need 2 tool positions



GSS1035-DEC



10mm

1:1

Position Upper gang tool post

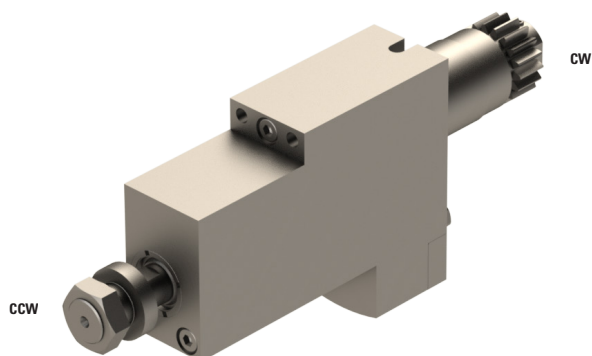
Machines Types	A232-VII	L20V
	A32-VII	L20VII
	A320-VII	L20VIII
	L20E2M8	L20X
	L20E2M10	L32-1M8
	L20E-1M12	L32-1M10
	L20E-IX	L32-1M12

Notes

Max. tool Ø50mm
Max. thickness 15.5mm



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GSS1307-DEC

	16
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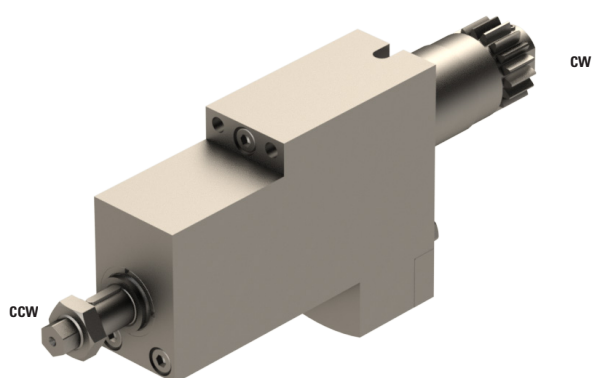
	1:1
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Position	Upper gang tool post
-----------------	----------------------

Machines Types	A20 L20 A32/L32 M32
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Notes

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

**GSS1335-DEC**

	13
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	1:1
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Position	Upper gang tool post
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Machines Types	A20 L20 A32/L32 M32
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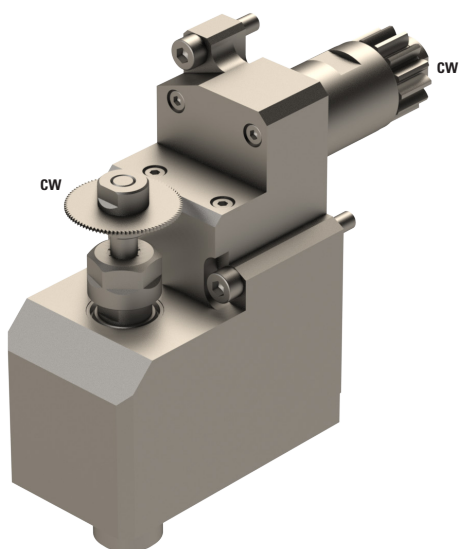
Notes

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



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GSS1530



ER11



5:3

Position

Front gang tool post

Machines Types

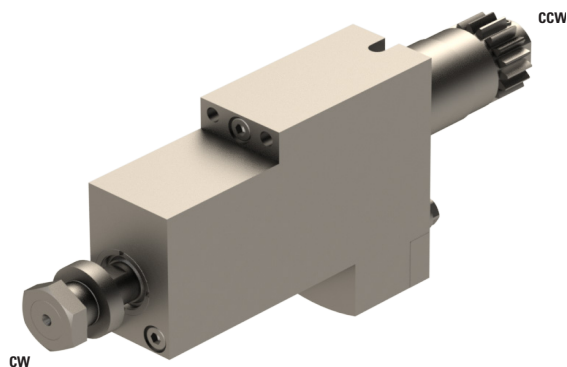
A20-3F7N
L12-1M7
L20E-2M8
L20E-2M10
L20E-2M12
L20E-IX
L20X

Notes

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



GSS15835-DEC



15.875mm (Ø5/8")



1:1

Position

Upper gang tool post

Machines Types

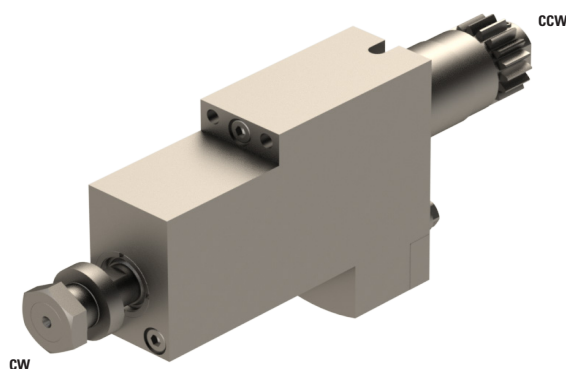
A232-VII L220-2M8
A32-VII L220-2M10
A320-VII M32-4M5
D25-VII M32-4M8
L32-1M8 M32-5M5
L32-1M10 M32-5M7
L32-1M12 M32-5M8

Notes

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



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GSS15835-DEC-II

Ø	15.875mm (Ø5/8")
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⚙️➡️⚙️	1:1
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Position	Upper gang tool post
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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.



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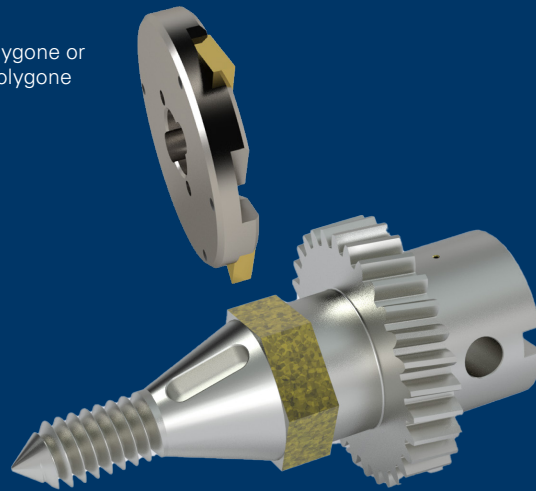
We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

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).

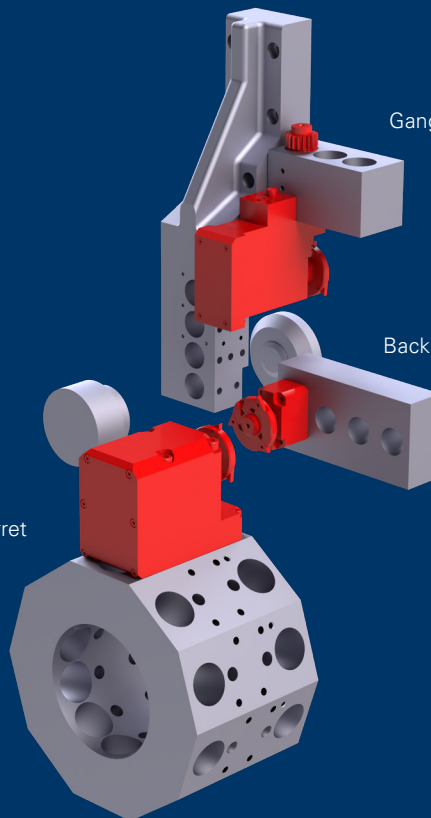
Backtool axial Polygone or
Gangtool radial Polygone

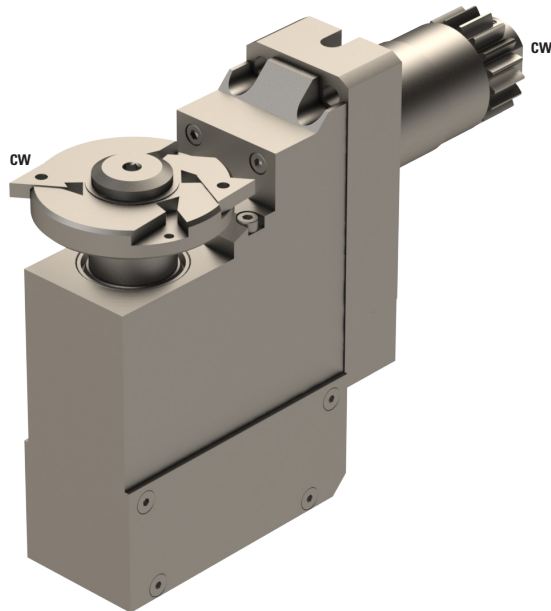


Gang tool

Backtool block

Turret



BSP-510

 $\varnothing 13$

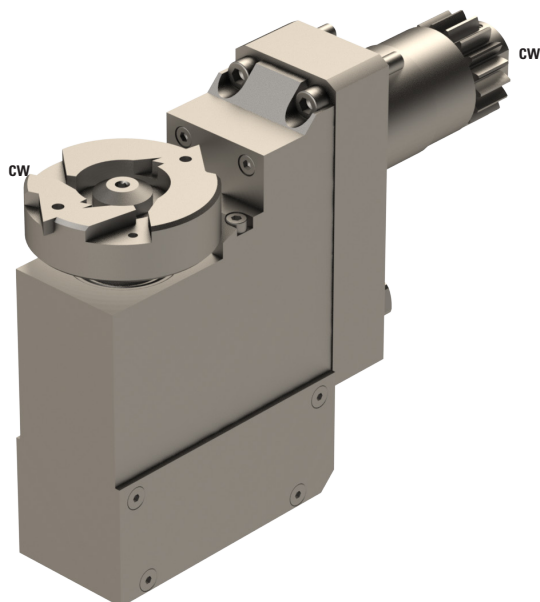
 1:1

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 $\varnothing$ 60 mm

**BSP-511**

 $\varnothing 10$

 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	

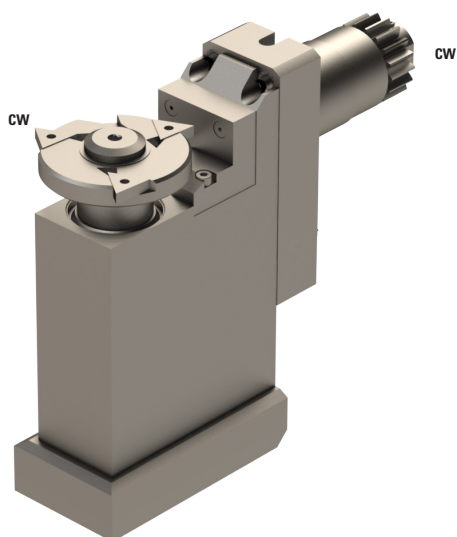
Notes

Max. tool $\varnothing$ 55 mm



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BSP-513



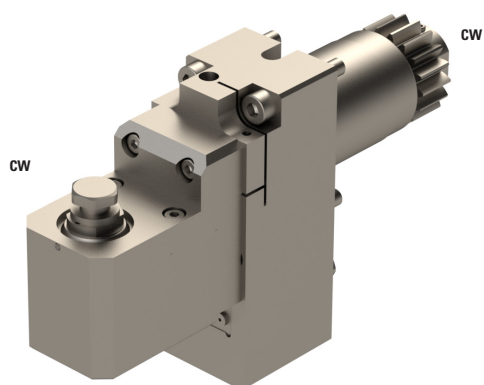
	Ø13mm
	1.5:1
Position	Upper gang tool post
Machines Types	A20-VII A20-3F7N A32 L220 L32
Notes	

Max. tool Ø70 mm
Max. thickness 8.3 mm



**MODULAR
SYSTEM**

CITIZEN6-GSP-218

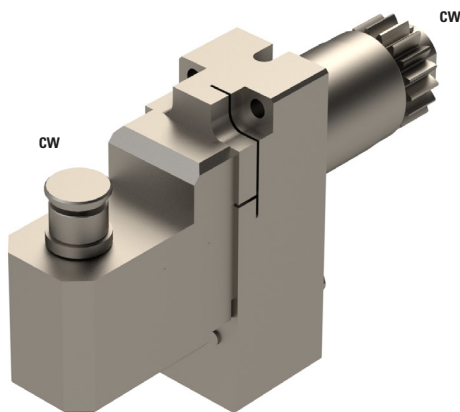


	8
	1:1
Position	Upper gang tool post
Machines Types	A232-VII L20E-2M12 A32-VII L20E-IX A320-VII L32-1M8 L20E-2M8 L32-1M10 L20E-2M10 L32-1M12
Notes	

Adjustable $\pm 15^\circ$
Diameter of the mill : Ø45 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.



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

15.875mm



1:1

Position

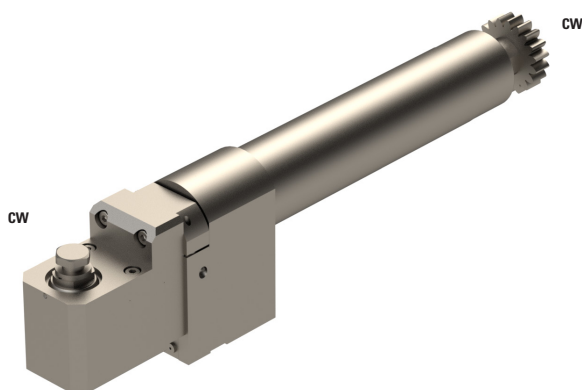
Upper gang tool post

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.

**MODULAR
SYSTEM****CITIZEN7-GSP-218** $\varnothing$

8



1:1

Position

Upper gang tool post

Machines Types

L20E-2M8	M20-2M3
L20E-2M10	M20-2M5
L20E-1M12	M20-3M3
L20E IX	M20-3M5
L20V	M32-2M3
L20VII	M32-2M5
L20VIII	M32-3M3
L20X	M32-3M5

Notes

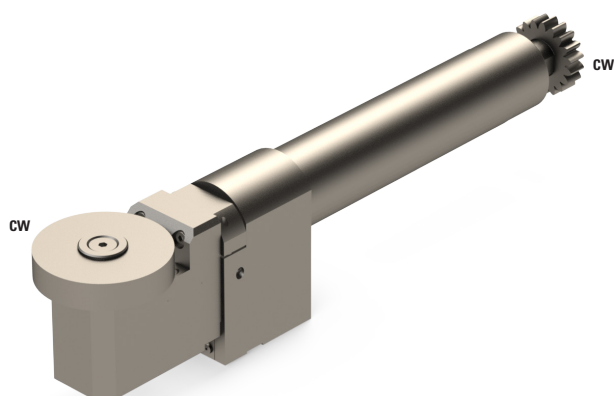
Adjustable $\pm 15^\circ$
Diameter of the brush : $\varnothing 46$ mm max.
Width of mill brush : 5mm max.
The CITIZEN7-PCR base and GSP-218 head are together on this tool.
Possibility to order them individually.



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**MODULAR
SYSTEM**

CITIZEN7-GSP-518



Ø 15.875

1:1

Position Upper gang tool post

Machines Types

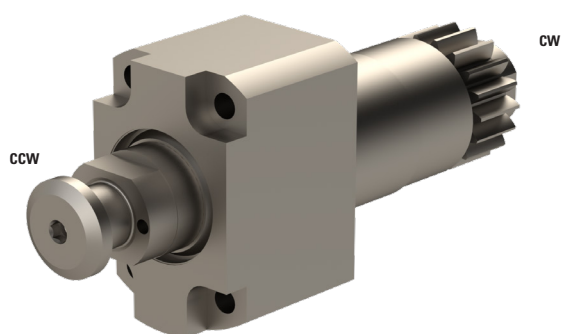
L20V
L20VII
L20VIII
L20X

Notes

Adjustable $\pm 15^\circ$
Diameter of the brush : $\varnothing 45$ mm max.
Width of mill brush : 10mm max.
The CITIZEN7-PCR base and GSP-518 head are together on this tool.
Possibility to order them individually.



RSP-013



13

1:1

Position Upper gang tool post

Machines Types

A20
A32
L220
L32

Notes

Diameter of the mill : $\varnothing 72$ mm max.
Width of mill cutter : 8.3mm max.



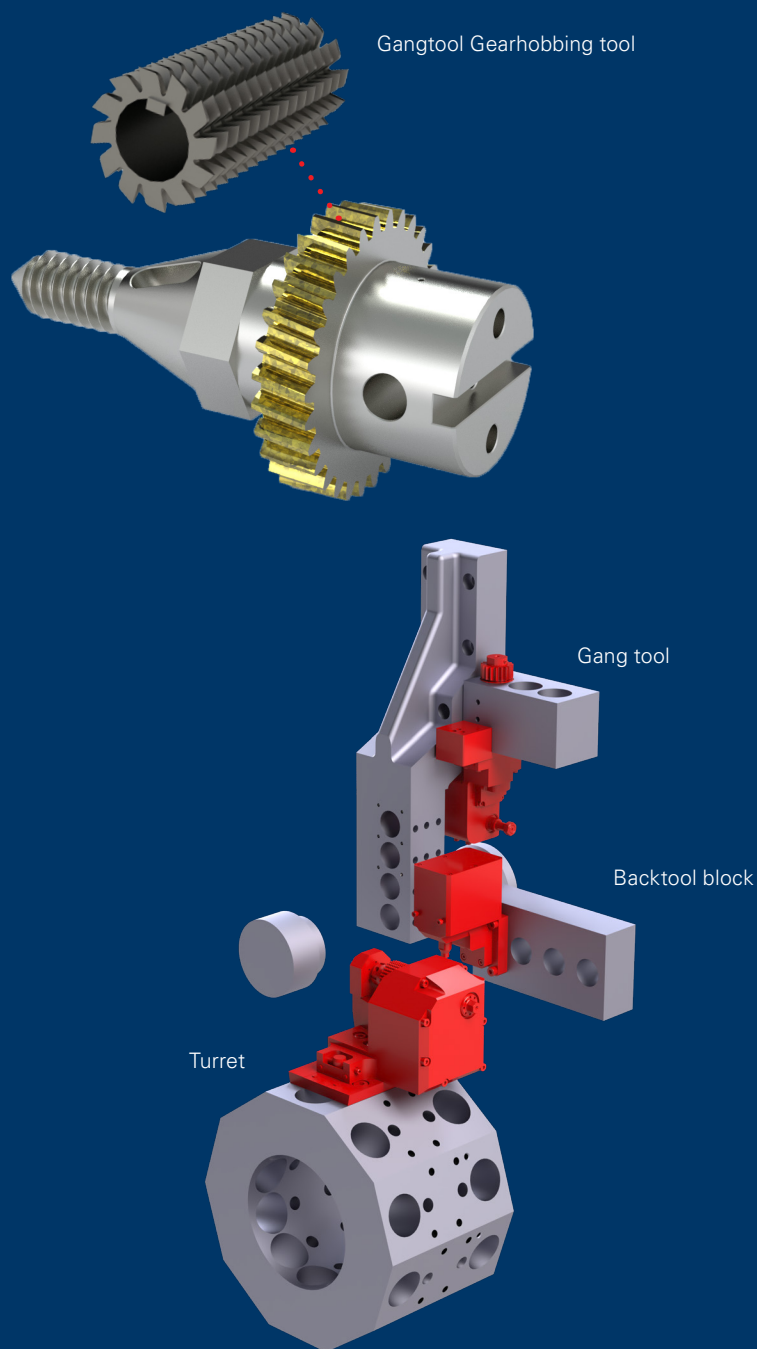
We strive to publish complete, correct and up-to-date information. However, we take no responsibility for, and make no warranty as to, the accuracy, completeness or frequency of updates. We reserve the right to make changes.

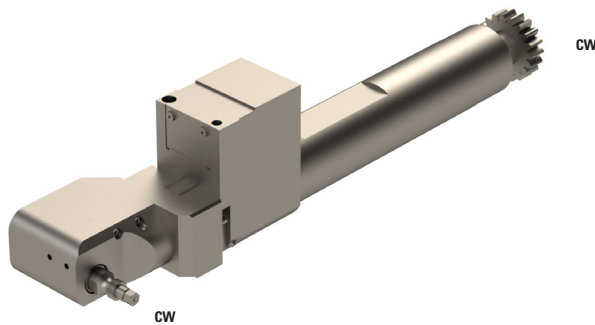
HOBGING TOOLS

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**
CITIZEN7-LSH-035


Ø	3.5
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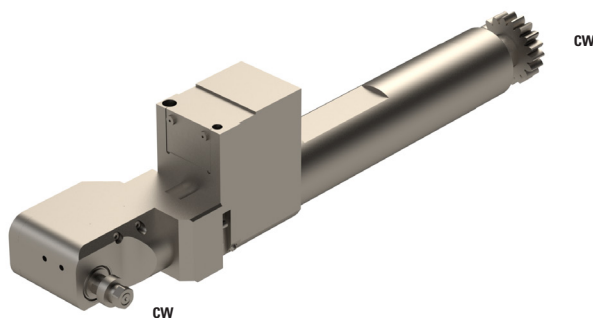
⚙️	1:1
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Position	Upper gang tool post
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Machines Types	L20E-2M8	M20-2M3
	L20E-2M10	M20-2M5
	L20E-1M12	M20-3M3
	L20E IX	M20-3M5
	L20V	M32-2M3
	L20VII	M32-2M5
	L20VIII	M32-3M3
	L20X	M32-3M5

Notes

Adjustable -2° to +15°
 Width of mill cutter : 8 mm max.
 The CITIZEN7-PCR base and LSH-035 head are together on this tool.
 Possibility to order them individually.


**MODULAR
SYSTEM**
CITIZEN7-LSH-050


Ø	5
---	---

⚙️	1:1
----	-----

Position	Upper gang tool post
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Machines Types	L20E-2M8	M20-2M3
	L20E-2M10	M20-2M5
	L20E-1M12	M20-3M3
	L20E IX	M20-3M5
	L20V	M32-2M3
	L20VII	M32-2M5
	L20VIII	M32-3M3
	L20X	M32-3M5

Notes

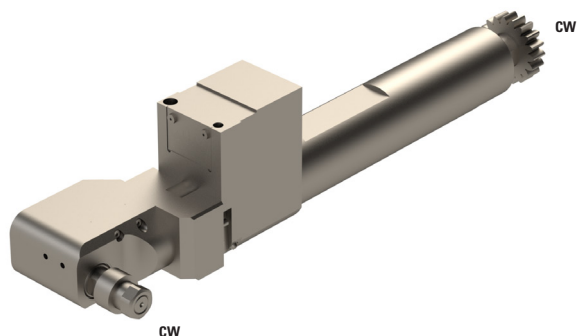
Adjustable -2° to +15°
 Width of mill cutter : 6 mm max.
 The CITIZEN7-PCR base and LSH-050 head are together on this tool.
 Possibility to order them individually.



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**MODULAR
SYSTEM**

CITIZEN7-LSH-080



Ø 8

1:1

Position Upper gang tool post

Machines Types

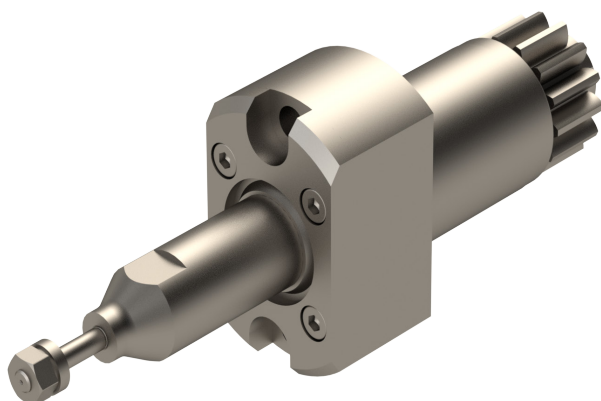
L20E-2M8	M20-2M3
L20E-2M10	M20-2M5
L20E-1M12	M20-3M3
L20E IX	M20-3M5
L20V	M32-2M3
L20VII	M32-2M5
L20VIII	M32-3M3
L20X	M32-3M5

Notes

Adjustable -2° to +15°
Width of mill cutter : 12 mm max.
The CITIZEN7-PCR base and LSH-080 head are together on this tool.
Possibility to order them individually.



MSH50735



Ø3.5mm

1:1

Position Upper gang tool post

Machines Types

L12
L20
L20E
L20X
L220
A220
A32

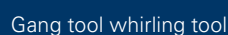
Notes

For hobbing cutter Ø3.5mm



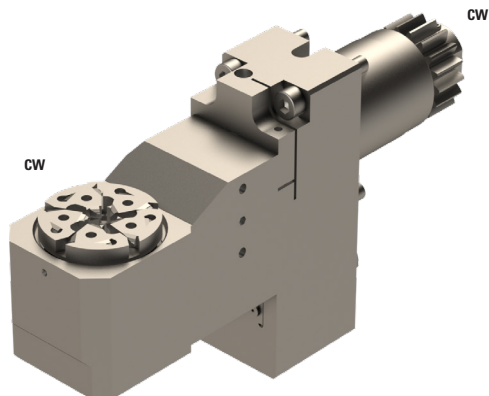
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Whirling can also be used to produce eccentric shafts.



Backtool block

Turret

**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

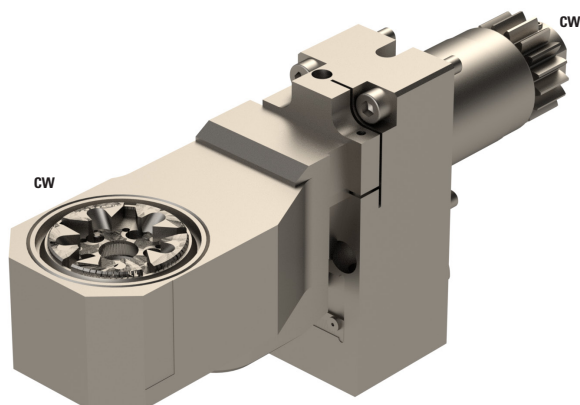
NotesAdjustable $\pm 10^\circ$

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

NotesAdjustable $\pm 20^\circ$

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

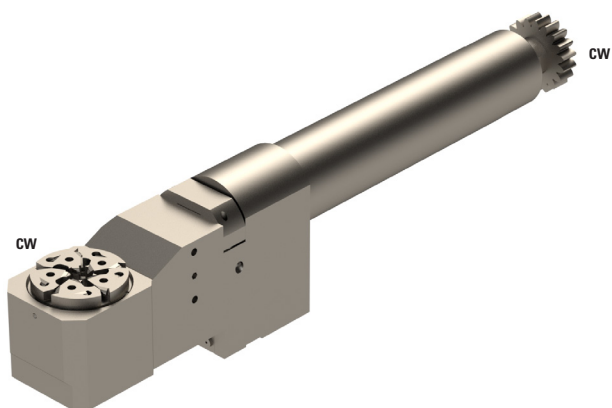
W04060511111 / UTILIS Thread whirling ring / Z=5 Ø6 mm



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**MODULAR
SYSTEM**

CITIZEN7-GSW-210



1:1

Position

Upper gang tool post

Machines Types

Same as CITIZEN7-LSH

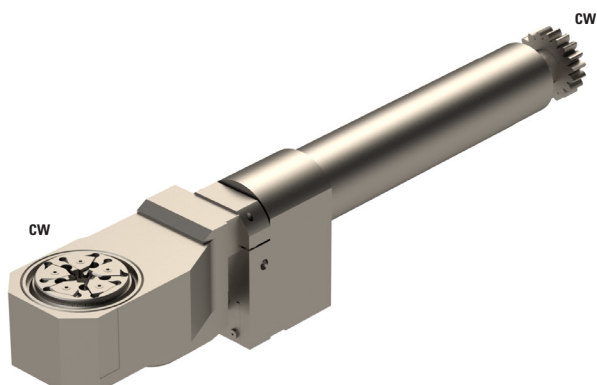
Notes

Adjustable $\pm 10^\circ$
The CITIZEN7-PCR base and GSW-210 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



**MODULAR
SYSTEM**

CITIZEN7-GSW-220



1:1

Position

Upper gang tool post

Machines Types

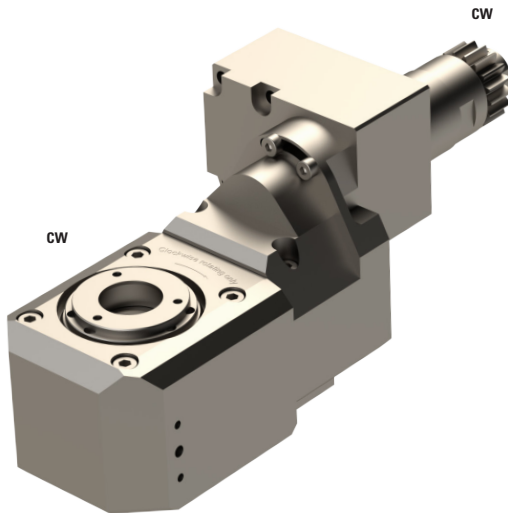
Same as CITIZEN7-LSH

Notes

Adjustable $\pm 20^\circ$
The CITIZEN7-PCR base and GSW-220 head
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



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GSW161

1:1

Position

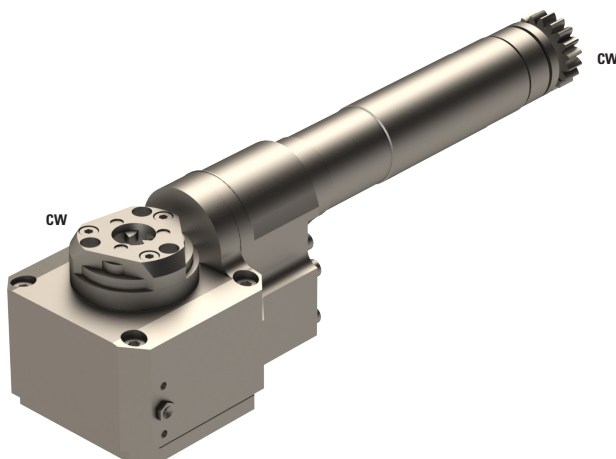
Upper gang tool post

Machines Types

L220

Notes

Adjustable 0°-16°
Thread whirling ring not included!
See more information on our website.

**LSW-101-L20**

2:1

Position

Upper gang tool post

Machines Types

L20E-2M8	M20-2M3
L20E-2M10	M20-2M5
L20E-1M12	M20-3M3
L20E IX	M20-3M5
L20V	M32-2M3
L20VII	M32-2M5
L20VIII	M32-3M3
L20X	M32-3M5

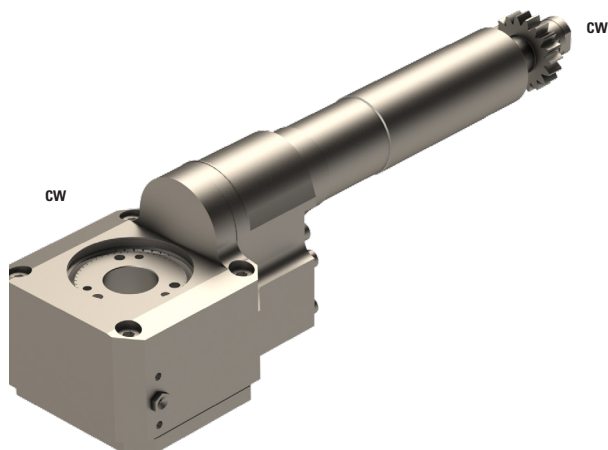
Notes

Need 2 tool positions
Adjustable $\pm 10^\circ$
Thread whirling ring included!
LSW-101-FPGLO-12
GLOOR Thread whirling ring
Z=3 Ø12 mm



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LSW-101-L25-000



1:1

Position

Upper gang tool post

Machines Types

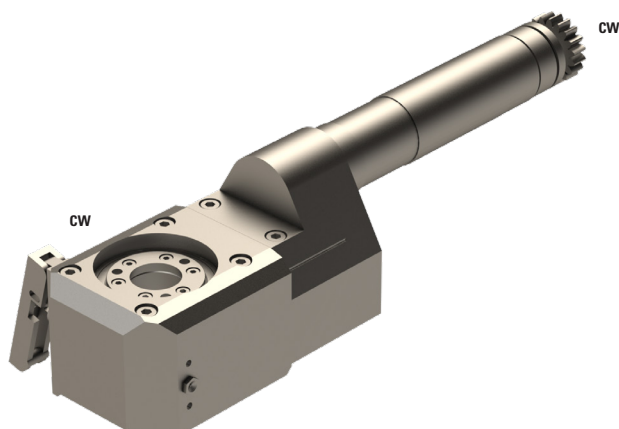
L20E-2M8	M20-2M3
L20E-2M10	M20-2M5
L20E-1M12	M20-3M3
L20E IX	M20-3M5
L20V	M32-2M3
L20VII	M32-2M5
L20VIII	M32-3M3
L20X	M32-3M5

Notes

Adjustable $\pm 10^\circ$
 SCHWANOG cutter head 857-207-01, Z=6, $\varnothing 12$ mm
 SCHWANOG cutter head SWG-192236, Z=6, $\varnothing 12$ mm
 GLOOR cutter head LSW-101-FPGLO, Z=3, $\varnothing 6$ mm
 GLOOR cutter head LSW-101-FPGLO-12, Z=3, $\varnothing 12$ mm
 GLOOR cutter head 01-0001, Z=6, $\varnothing 11$ mm
 UTILIS cutter head 137600, Z=9, $\varnothing 12$ mm
 UTILIS cutter head 137356, Z=12, $\varnothing 12$ mm
 HORN cutter head M302.C012.10.06, Z=6, $\varnothing 12$ mm



LSW-215-000



1:1

Position

Upper gang tool post

Machines Types

L20E-2M8	M20-2M3
L20E-2M10	M20-2M5
L20E-1M12	M20-3M3
L20E IX	M20-3M5
L20V	M32-2M3
L20VII	M32-2M5
L20VIII	M32-3M3
L20X	M32-3M5

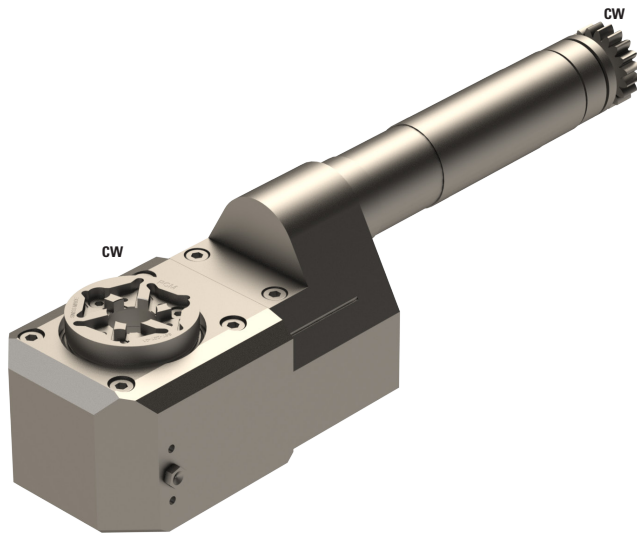
Notes

Adjustable $\pm 15^\circ$
 LSW-215-000-L25ADAPT
 Adaptation kit for using the LSW-215-000 tool on the L25.
 W03120611118 / SCHWAOG Thread whirling ring
 Z=6 $\varnothing 12$ mm
 W04120911113 / UTILIS Thread whirling ring
 Z=9 $\varnothing 12$ mm
 W04121211111 / UTILIS Thread whirling ring
 Z=12 $\varnothing 12$ mm
 W05120611112 / HORN Thread whirling ring
 Z=6 $\varnothing 12$ mm



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LSW-215-SWG



1:1

Position

Upper gang tool post

Machines Types

L20E-2M8	M20-2M3
L20E-2M10	M20-2M5
L20E-1M12	M20-3M3
L20E IX	M20-3M5
L20V	M32-2M3
L20VII	M32-2M5
L20VIII	M32-3M3
L20X	M32-3M5

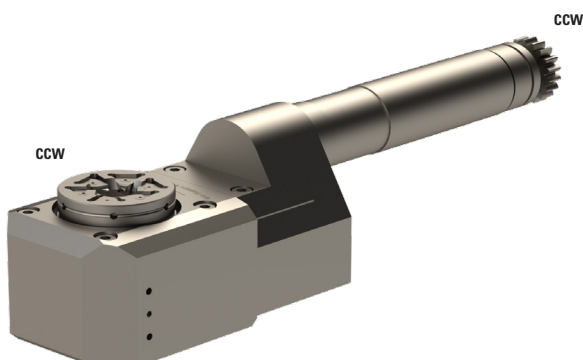
Notes
Adjustable $\pm 15^\circ$

Thread whirling ring included!
 Art. W03120611117
 SCHWAOG Thread whirling ring
 Z=6 Ø11 mm

It can be ordered without the LSW-215-000 thread whirling ring.



LSW215-II



1:1

Position

Upper gang tool post

Machines Types

L20E-2M8	M20-2M3
L20E-2M10	M20-2M5
L20E-1M12	M20-3M3
L20E IX	M20-3M5
L20V	M32-2M3
L20VII	M32-2M5
L20VIII	M32-3M3
L20X	M32-3M5

Notes

2 tool positions are required
 Thread whirling ring not included!
 W03120621112 / SCHWANOG Thread Whirling ring / Z=6
 Ø12 mm
 W01120321111 / GLOOR Thread Whirling ring / Z=3 Ø12
 mm
 W01080321111 / GLOOR Thread Whirling ring / Z=3 Ø8
 mm
 W01080321112 / GLOOR Thread Whirling ring / Z=3 Ø8
 mm
 W05110621111 / HORN Thread Whirling ring / Z=6 Ø11mm



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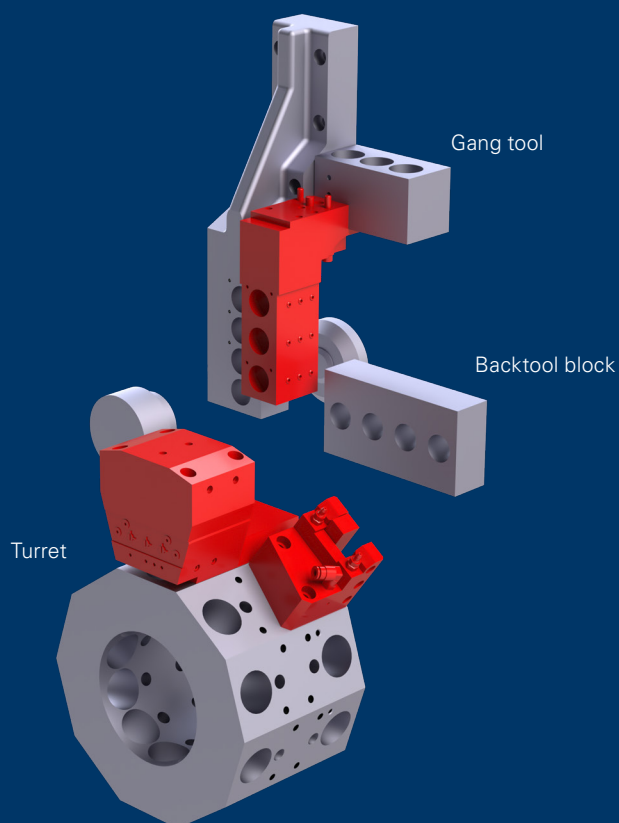
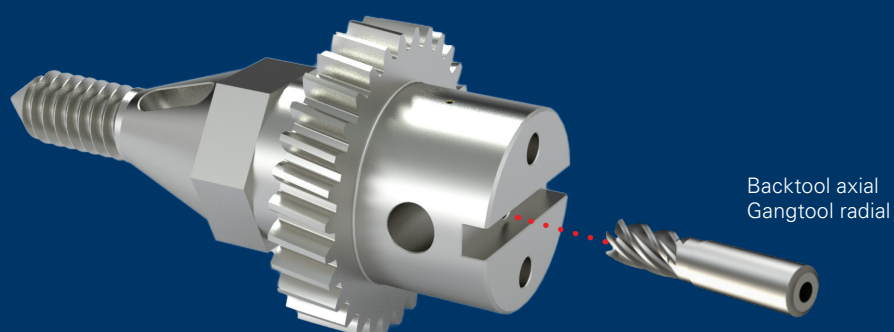
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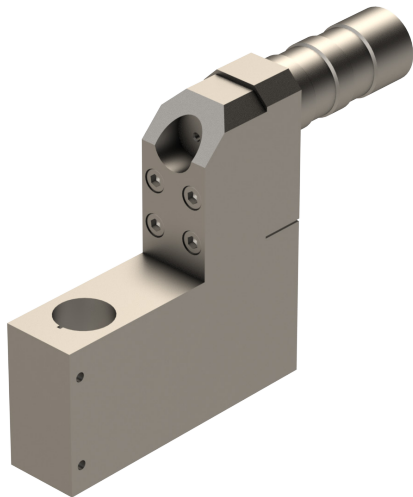
STATIC TOOLS

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.

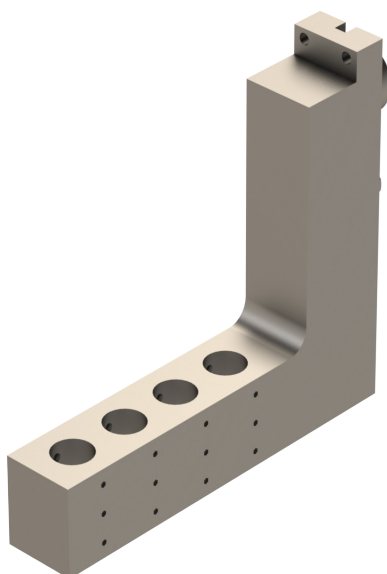


852-354-OF010

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

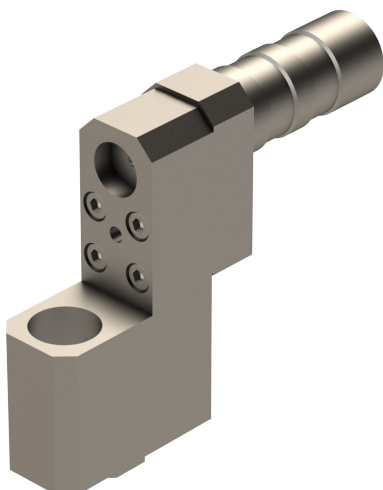
**GDF-1207-L**

4xØ19.05mm		
⚙️	-	
Position	Upper gang tool post	
Machines Types	A20-3F7N	
	L20E-2M10	
	L20E-2M12	
	L20E-2M8	
	L32-1M10	
	L32-1M12	
	L32-1M8	

Notes

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GDF903



Ø 25,4

⚙️ -

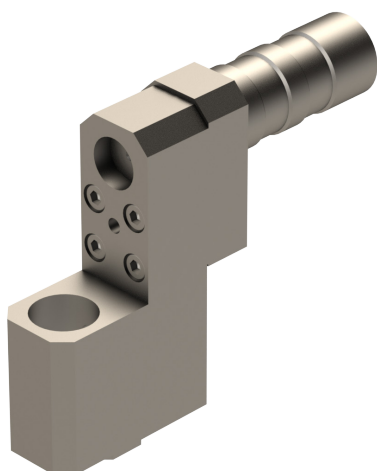
Position Upper gang tool post

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



GDF-903-25



Ø 25

⚙️ -

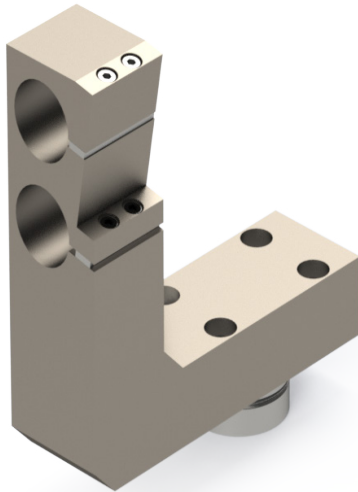
Position Upper gang tool post

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



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LDF-HF05

2x Ø22mm



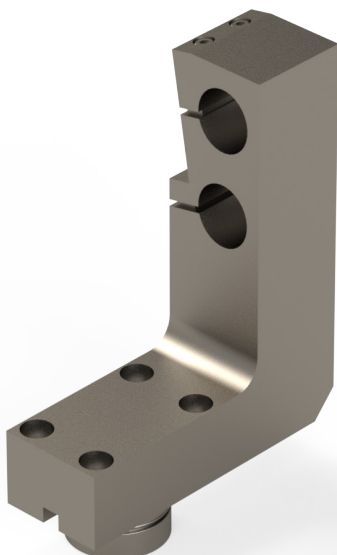
-

Machines Types

L20E-2M8 / X1-Y1 / Main
spindle
L20E-2M10 / X1-Y1 / Main
spindle
L20E-2M12 / X1-Y1 / Main
spindle

Notes

For Nakanishi BM-322 spindel

**LDF-HF06**

2xØ19.05mm



-

Machines Types

L20E-2M8 / X1-Y1 / Main
spindle
L20E-2M10 / X1-Y1 / Main
spindle
L20E-2M12 / X1-Y1 / Main
spindle

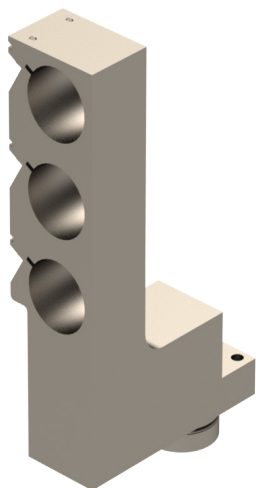
Notes

For MEYRAT MHF-19 Radial spindle



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LDF-HF07



3xØ30mm



-

Machines Types

L20E-2M8 / X1-Y1 / Main spindle
L20E-2M10 / X1-Y1 / Main spindle
L20E-2M12 / X1-Y1 / Main spindle

Notes

For MEYRAT MHT-30 Radial spindle



LDF-HF07-1



3xØ19.05mm



-

Machines Types

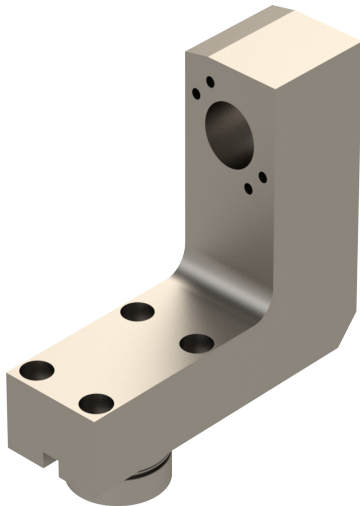
L20E-2M8 / X1-Y1 / Main spindle
L20E-2M10 / X1-Y1 / Main spindle
L20E-2M12 / X1-Y1 / Main spindle

Notes

For MEYRAT MHF-19 Radial spindle



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LDF-HF11

1x Ø19.05mm



-

RPM max.

-

Machines Types

L20E-2M8 / X1-Y1 / Main
spindle
L20E-2M10 / X1-Y1 / Main
spindle
L20E-2M12 / X1-Y1 / Main
spindle

Notes

For Nakanishi BM-319F Radial spindle



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