Did You Know?
Skip the Milling, Run Non-Conformed Stock!

Sometimes it makes sense to run hex or other stock rather than milling to shape. To set up the machine, use a round bar loader collet to fit over points of the stock. In Spindle 1, use a chucking sleeve with a pin to hold the collet in place as a new bar is loaded. To teach the machine rotational relationships, you will now perform phase adjustment.
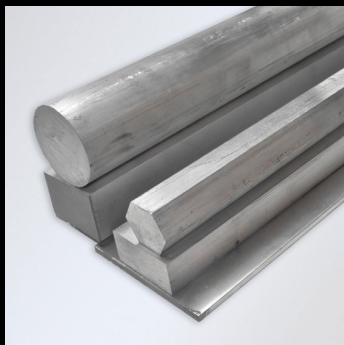
You can adjust phase between the following on your Citizen:

- Main spindle and guide bushing
- Main spindle and back spindle
- Main spindle, guide bushing, and back spindle

In the phase adjustment menu, there are three (3) selections located on the right. Enter the desired number in the Operation Select field, close all doors, and press the menu key [Phase Adj] and Start Key simultaneously. A phase adjustment confirmation message will appear.

```
Operation Select  Phse adj between m sp and GB

Pass the material through the spindle and
the guide bushing.
After that press menu key [Phse adj] and
START key simultaneously.
```

```
Select command item and
press [INPUT] key.

 1. Phase adj. between
    main spindle and
    guide bushing
 2. Phase adj. between
    main spindle and
    back spindle
 3. Phase adj. between
    main spindle GB,
```

Lastly, add M26 to bar loader sub program to line up guide bushing and main spindle at bar change.

```
O8000(BAR-CHANGE-HEX)          G0X.68Z1.3+.63T1
$1                             M97M95
M9                             M3S1=500M24S2=500
M3S1=25M53
G0X#814+#815W-3.8              G814R0(Change R to Shift Phase)
M54                            M77
M7                             G96M3S230
M55                            G650
M6                             !L1
M3S1=#817                      G1X.6F.003
M26                            G0X.68
G99G1W3.8F.01                  W-.03
M52                            G1X.625
X#824F#822                     X.6W.03F.001
M99                            G231X-.1A-.02F.003
                               G97M5M25
$1 (Pick Off-Cut Off Hex Part) G113
T100                           M96M94
G50S4000
```

For questions, check your machine manual or give us a call!

Miss our Last Tech Tips? Click Below!

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Did You Know?
Citizen ECO Screen and Monitor

Example graph displays

Eco | 0 | 200 Comment TEST-PROGRAM
[kWh] | Power Consumption | Last Output :
Value under the selection is disp.
Consume.1 30.1 [kWh]
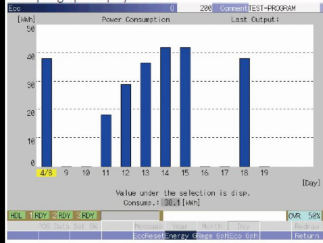
Equipped standard on Citizen lathes, the Eco Monitor shows machine power consumption in the form of a graph. The screens shows various power consumption data points. Working from the I/O screen, this data can be outputted (in CSV format) to a CF card or network.

Machine Operation Information

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Did You Know?
## Cincom Low Frequency Vibration-Cutting

What is LFV?

Chip Control: Servo-controlled axes oscillate in the axial direction, and machining is carried out while synchronizing this vibration with spindle rotation. The air cutting time created during machining leads to intermittent chip removal.

LFV-Produced Chips: Two 14.3 gram samples of 304 Stainless, which would you prefer?

View our Webinar on Low Frequency Vibration Here

NYLON
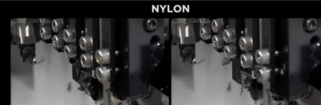
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