

TIPO C25

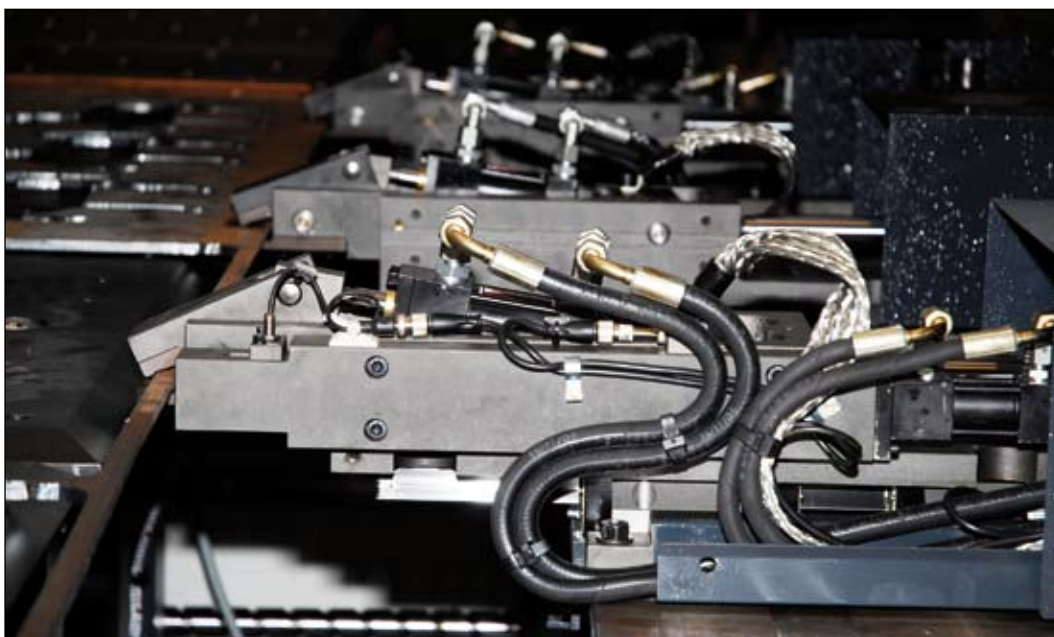
Flexible CNC center for punching, marking, drilling, boring, milling, tapping and high definition thermal cutting of large plates

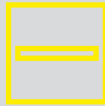


STANDARD CONFIGURATION

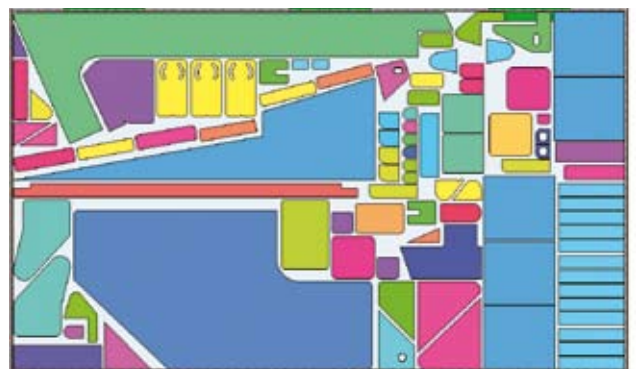


Ficep, founded in 1930, a leading company in the evolution of machines for the structural steel industry, is facing the new millennium as a leader once again by showing the exclusive TIPO C range, FLEXIBLE CNC CENTER FOR PUNCHING, MARKING, DRILLING, BORING, MILLING, TAPPING AND HIGH DEFINITION THERMAL CUTTING of large plates.





Flexible CNC center for punching, marking, drilling, boring, milling, tapping and high definition thermal cutting of large plates

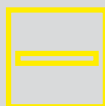


STANDARD CONFIGURATION

TIPO C25 line is designed to comply with the different requirements when automatically processing in one cycle on large plates (6000 x 2500 mm.) and different thicknesses (from 1,5 mm. upto 20 mm.), ensuring high quality, precision, productivity and flexibility.

TIPO C25 line is a flexible CNC center capable of complying with the requirements of both traditional steel fabricators and all types of industry requiring flat components in steel for their particular needs.





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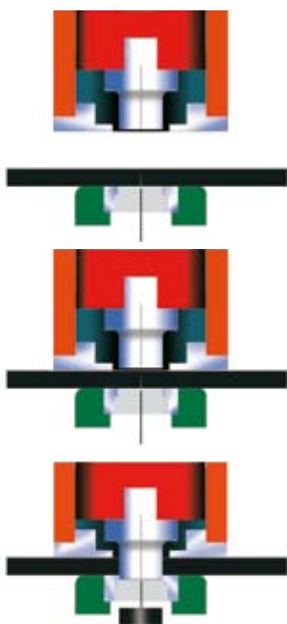
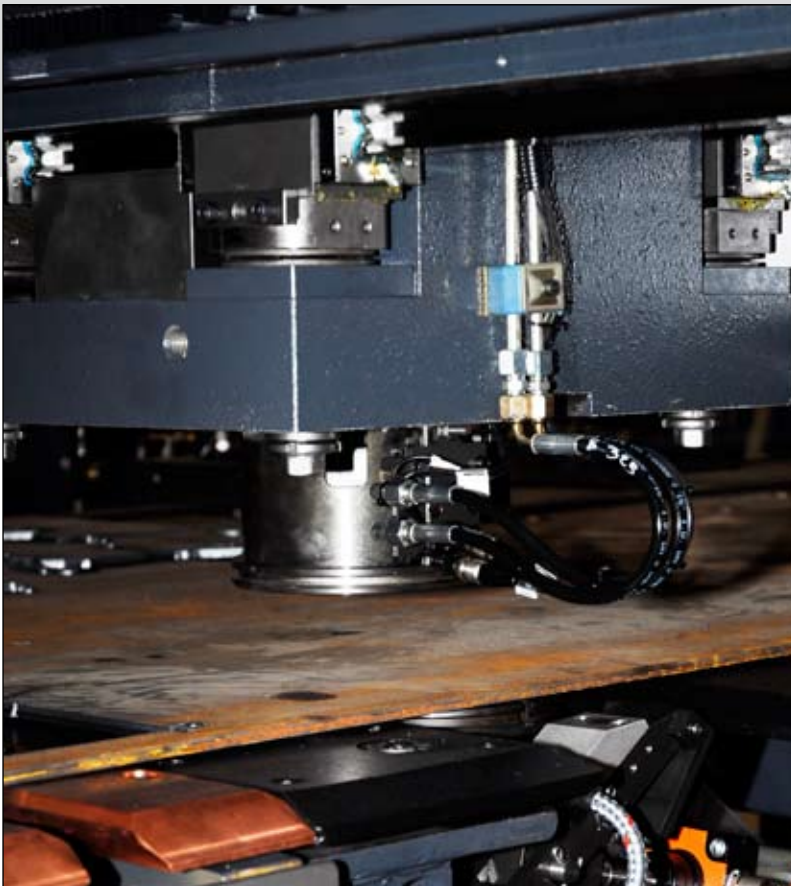
APPLICATION FIELDS

TIPO C 25 line is suitable for the manufacturers of:

- Energy steel towers
- Telecommunication steel towers
- Stationary and moving cranes
- Fork lift trucks
- Bridge cranes
- Lifts
- Removal means
- Asphaltting machines
- Earth moving machines
- Agricultural machines
- Machine tools
- Industrial furnace
- Industrial kitchens
- Industrial washing machines
- Transformers
- Industrial vehicles
- Railway vehicles
- Crushing machines
- Tile manufacturing machines



HYDRAULIC PUNCHING



FRAME AND HANDLING

The frame is made of high resistance rolled steel sections, electric welded and stress-relieved.

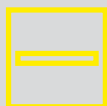
Sliding guides run on precision rolls; axis move by means of precision grinded ball screws. Any alignment and orthogonal operation is made through sophisticated precision laser equipments.

HYDRAULIC PUNCHING

The punching strength, which is constant throughout the punch stroke, is generated by a special high pressure hydraulic cylinder. This allows the use of progressive punches that considerably reduce the punching force, optimizing the production quality both on minimum and larger thicknesses. The clever tool handling allows automatic compensation of the strokes and the use of standard punches, re-sharpened or progressive punches.

PLATE HOLDER AND HYDRAULIC STRIPPER

The stripper holder system is hydraulic and coaxial to the punch, the aim is to reduce noise to the minimum and to improve the punching quality.



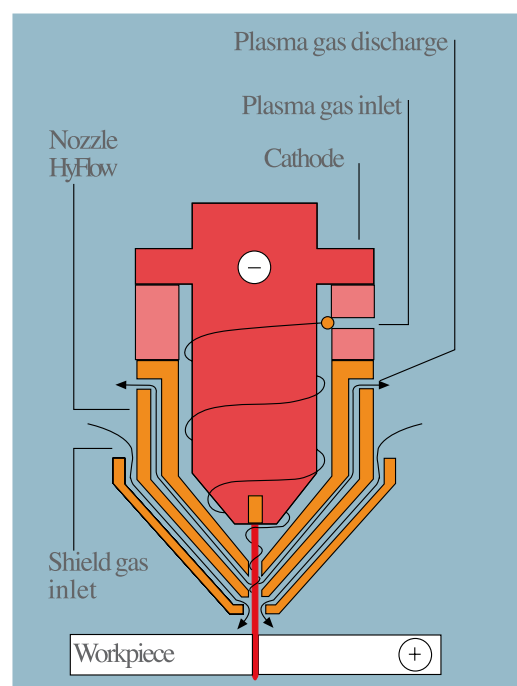
THERMAL CUTTING

Three PLASMA power units are available:

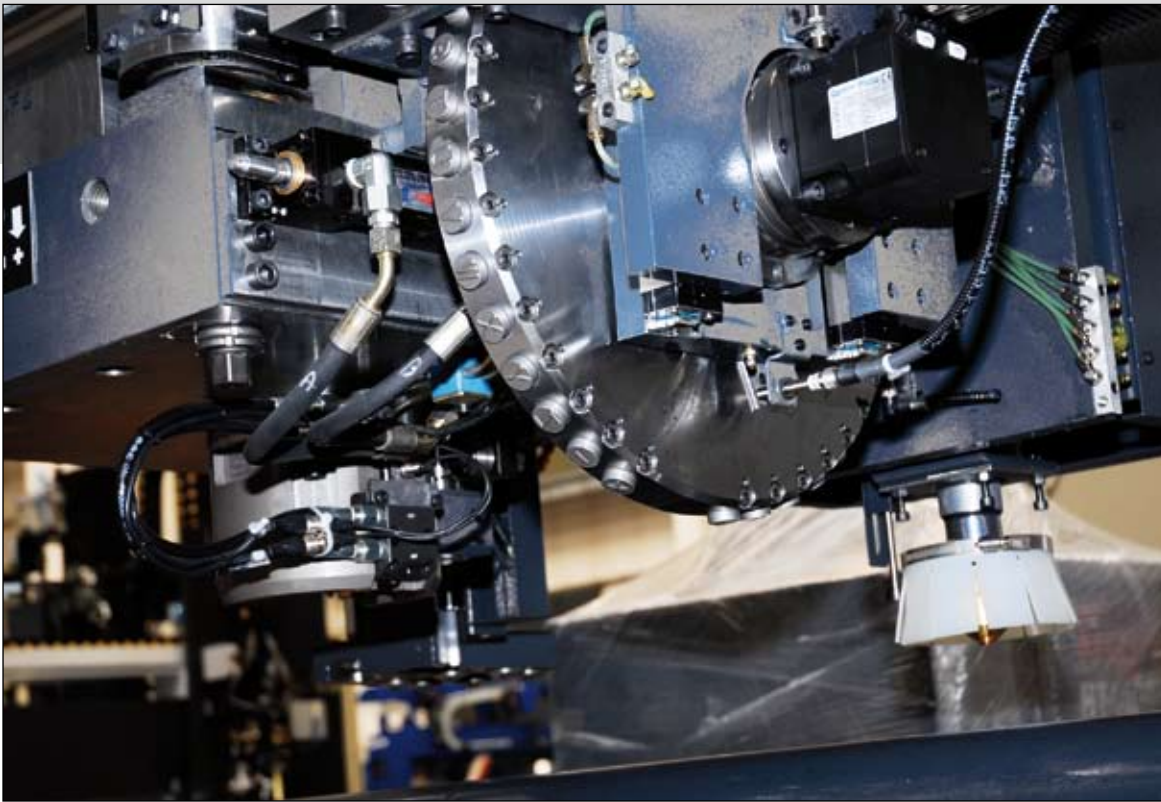
- HT2000 with compressed air and oxygen: very simple and suitable to those who have no high quality requirements.
- HPR 260 at high definition: very precise, it uses oxygen and compressed air.
- HT 4400, using different kinds of gas depending on the application, is the most powerful and the quickest in the maximum quality field.

All these units take advantage of the sophisticated Ficep system to control the torch height and to handle cutting parameters, this makes the process easier and always ensures maximum performances.

The operation of the plasma torch can be separated from the other working units (Ficep patent) to work independently and optimize the dynamic cutting characteristics.



OPTIONS



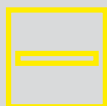
HYDRAULIC MARKING

The FICEP marking unit is the only one capable to ensure a deep marking that remains visible even after several plate treatments. The hydraulic marking unit consists of a set of alpha-numerical characters driven by a servomotor controlled by CNC, also equipped with one hydraulic cylinder providing a 90 kN force.



DRILLING/TAPPING/MILLING

As an option, it is possible to add a powerful drill head with automatic tool change system to carry out drilling, tapping, milling and other mechanical operations.



TABLES



TABLES

TIPO C lines are usually fitted with plate supporting tables. A table with catches fitted with sensors allows plates to be automatically loaded to the pinching position.



UNLOADING OF PIECES

Small pieces upto 2500 x 600 mm. are unloaded through a tilting automatic table. Pieces unloaded from the tilting table can be conveyed to the back of the machine by a simple conveyor.

TOOL CHANGE SYSTEM

TIPO C25 lines in the standard configuration are fitted with an automatic tool changer – the change is made in full safety for the operator. In the standard configuration, tools are loaded manually on the tool holder. There is the option of loading tools automatically, both on new and already installed machines, by adding the exclusive and patented FICEP tool-change system. The system provides options for 4 tools upto 14 tools, or any number of tools to be defined with the Customer. The tool changer can easily be opened to allow access for tools loading and for ordinary maintenance operations.



HARDWARE & SOFTWARE

FICEP MINOSSE CONTROL UNIT

The new generation control unit, with controlled axes, is based on a fieldbus canopen technology. The cnc is lodged in a control panel that can be oriented to let the operator have a complete view of the machine.

All the input and output cards are connected to the bus and positioned on the machine, when possible.

The cnc is equipped with:

- Digital inputs (24v – optoinsulated)
- Digital outputs (24v – protected transistors)

The control panel is an industrial pc containing the cnc and having the following specifications:

- 600 Mhz cpu with I2 512 kb “cache”
- 512 Mb ram memory
- Touch screen colour video tft 12.1”
- Keyboard panel and auxiliary pushbutton panel
- 10/100 Rj45 ethernet port
- Usb modem
- 1 Additional usb port
- Windows xp embedded operative system
- Teleservice software

Programming

- Simplified data input (with tables and workpiece on-screen graphics)
- Absolute and incremental values
- Diameters programming
- Linear, matrix and flange patterns

Processing

- Automatic tool assignment
- Unit offset sum
- Values ordering

Execution

- Automatic cycle stop for “setup” modification, and on-screen indication of the tools to be changed.
- Table with drilling parameters



All the indications are clearly displayed on the screen, and concern:

- Current program indication, with clear description of the program running at the moment
- CNC inside and outside alarms
- Registration of the date and time of the last 100 alarm messages
- Diagnostic messages to the operator.

Software Package “WIN-NEST”, specifically studied for nesting of the piece programs into the large plate after having imported them either from a CAD application, or from the software package “WIN-STEEL”. The package runs on an IBM PC or compatibles.



TECHNICAL SPECIFICATION

		TIPO C16	TIPO C25
SPECIFICATION OF THE RAW MATERIAL PLATE IN INFEED SIDE			
Maximum length without repositioning and with combined punching-thermal cutting operations	mm	3100	6000
Maximum width	mm	1600	2500
Minimum / maximum plate thickness	mm	1,5 - 16	1,5 - 20
Maximum positioning weight	Kg	600	2500
Maximum linear weight of plate to be processed	Kg/m ²	125	150
Maximum vectorial traverse speed	m/min.	50	50
Working level's height	mm	1100	1100
Positioning accuracy and machine axes repetibility	+/- mm	0,10	0,10
SPECIFICATION OF THE WORKPIECE IN OUTFEED SIDE			
Max. allowed dimens. for the parts to be unloaded into trap door (option)	mm	1600 x 600	2500 x 600
Max. dimension of the single part to be processed	mm	3100 x 1600	6000 x 2500
PUNCHING CAPACITY (400N/mm²)			
Punching force	kN	500	1000
Maximum stripping force	kN	50	100
Maximum die hole diameter	mm	100	100
Max. diameter on thickness (using flat punch)	mm	25 x 16	38 x 20
Punching speed with 25 mm pitch on 3 mm thickness: with special power pack and proportional valve (option)	strokes/min.	150	150
Tool change system (option)	no. of tools	12	4 - 14
THERMAL CUTTING UNIT			
Thermal cutting with standard plasma		HPR 260	HPR 260
Thermal cutting with plasma		HT 2000	HT 2000
DRILLING/TAPPING/MILLING UNITS			
Change system	no. of tools	6	6
Spindle motor power	kW	11	11
MARKING UNIT			
Marking force (option)	kN	90	90
Characters (letters/nrs.)	no.	38	38



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