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CNC PLATE PUNCHING LINE
FOR THICK PLATES





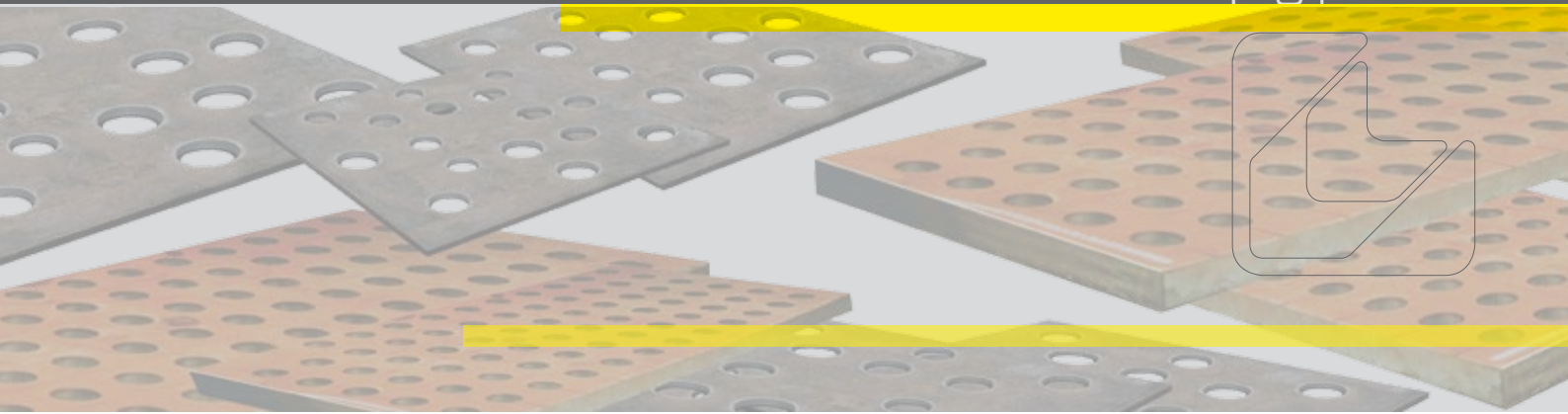
Hydraulic punching machine of the C-frame type, with a 500 mm throat depth, fitted with a tool having three selectable punches. Each punch has a punching force of kN 800 throughout its entire stroke.

One-piece steel frame containing the electric system, the hydraulic system and the CNC. The punching unit is supplied ready to work and does not require installation.



- **Plate clamping system**, self-adjustable to suit the plate thickness, used for both stripping during punching, and for repositioning of the pinchers
- **When required, the machine can also be fitted with a drilling unit and/or a marking tool**
- **Coordinate table** to position the plate in the working area, complete with:
 - **Positioning system** on the two axes of the plate holding carriage, complete with ball screws and servo motors
 - **Plate holding carriage** fitted with two pinchers, to clamp plates from 3 to 40 mm thick
 - **Zero plate reference unit**
 - **Supporting table with balls** to support the workpiece during processing
 - **Plate clamping pinchers**, hydraulically controlled, to clamp both plates
- **Hydraulic system** complete with power pack fitted with an oil preheating system and circuitry for cooling with air / oil heat exchanger
- **Pneumatic system**
- **Electric system** complete with auxiliary pushbuttons and electric cabinet manufactured according to EN 60204-1 standards and located on the machine.
- **Ficep MINOSSE CNC Control System**, with 2 axes, integrated into the punching unit.





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OPTIONS

DRILLING UNIT

This unit enables drilling of holes, as an alternative to punching, up to a max. diameter of 40 mm. The unit is automatically inserted into the punching unit's working cycle and is supplied complete with:

- Spindle rotation motor
- Sensitive, self-controlled speed change unit for fast approach, work preset speed, fast retract
- Feed system
- Engraving tool
- External and internal oil mist coolant system for drills

MARKING TOOL

The marking tool can be used in place of the left-hand punch holder included with the basic machine. In just a few seconds, it is possible to have a simple and quick marking unit!

Hydraulic power pack



Lubricating system cabinet



Clamps for material handling



FICEP MINOSSE CONTROL UNIT

The new generation control unit, with 2 controlled axes, is based on a field bus CANopen technology.

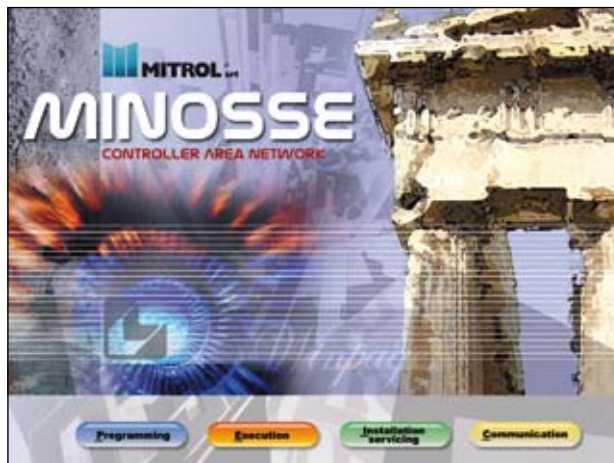
The CNC is positioned inside the electric cabinet on board of the machine.

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 L2 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.

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



MAIN CAPACITIES AND SPECIFICATIONS

PUNCHING CAPACITY			
Maximum punching capacity throughout the entire stroke and available on all punches		kN	800
Material thickness with standard tools	MIN.	mm	3
	MAX.	mm	25
Maximum diameter		mm	46
X and Y axes positioning stroke		mm	1000 x 500
Maximum plate weight at a standard positioning speed		Kg	100
Maximum plate size with programmed repositioning		mm	500 on the length
Punches		no.	3
Punching max. thickness with shear strength 400N/mm ² dia. max. through		mm	32 x 20
OPTIONAL			
DRILLING CAPACITY			
Monospindle drill head with a spindle rotation motor			
Maximum plate thickness		mm	40
Maximum hole diameter		mm	40
Motor		kW	5,5
MARKING CAPACITY			
Available marking force		kN	800
Marking tool		no.	1
Characters per group		no.	8
Size of characters (Ficep 31)		mm	16 x 8



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