

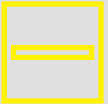
80 YEARS
1930 - 2010



P 81

CNC PUNCHING & DRILLING
LINE FOR PLATES

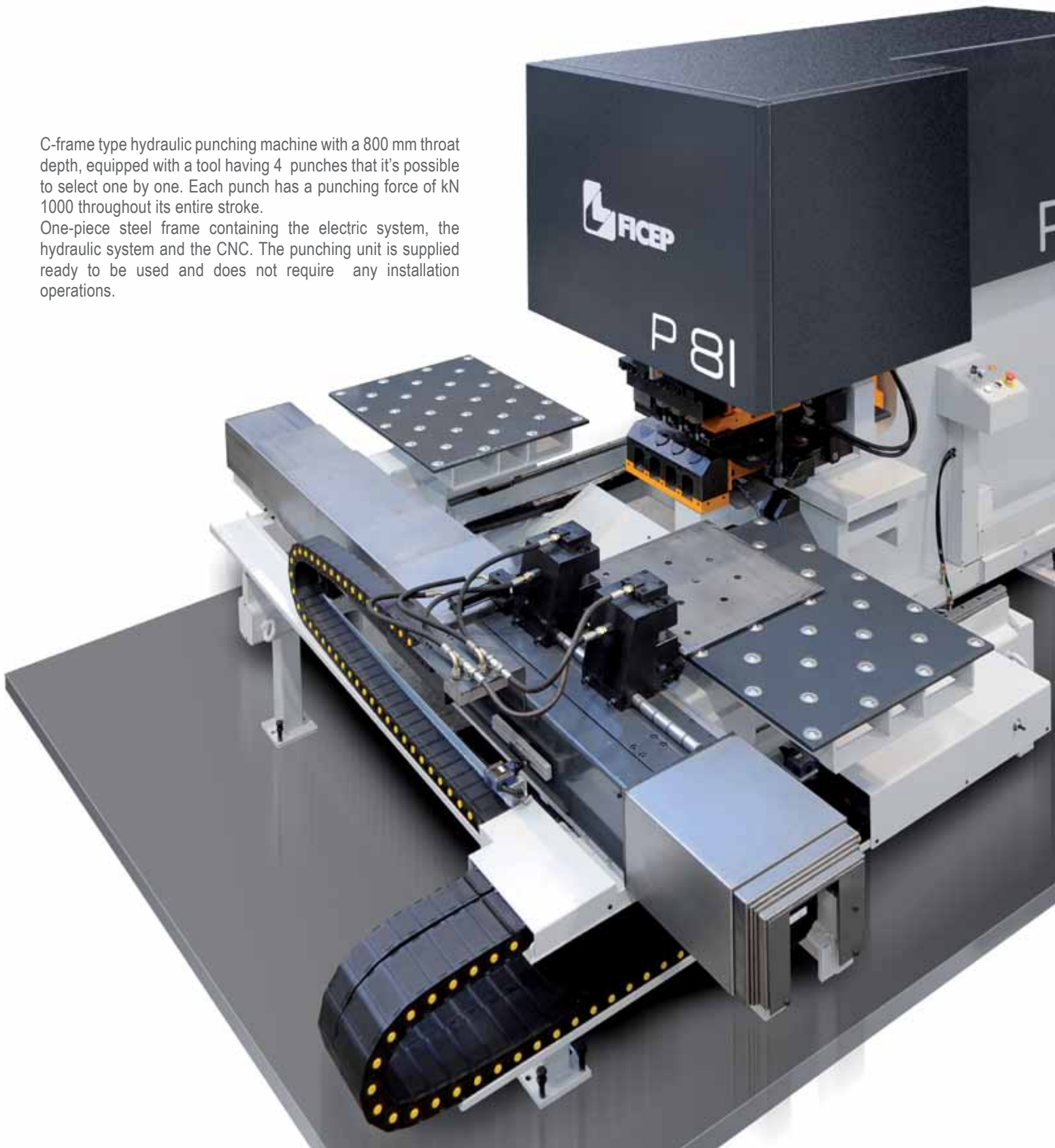




CNC PUNCHING & DRILLING LINE FOR PLATES

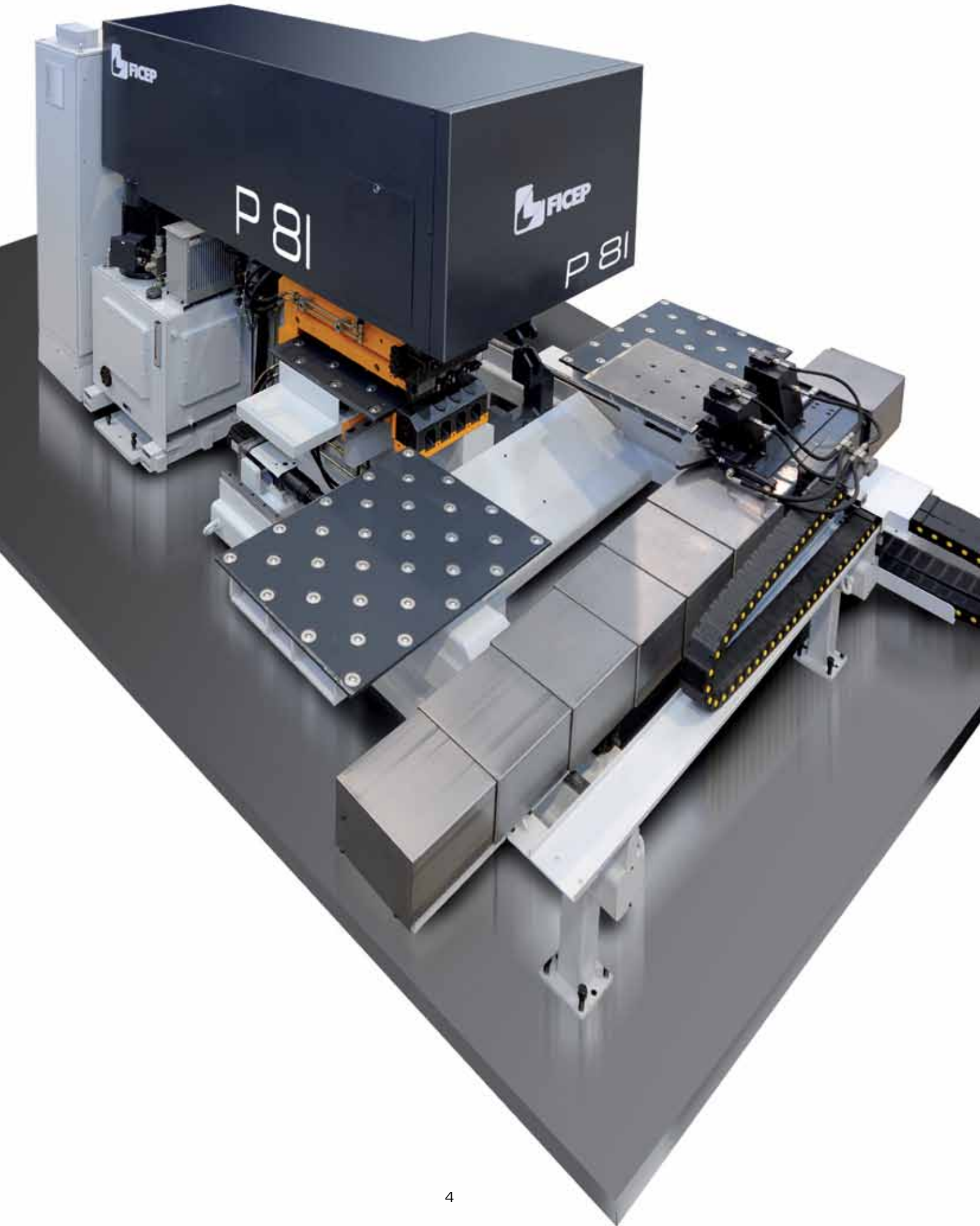
C-frame type hydraulic punching machine with a 800 mm throat depth, equipped with a tool having 4 punches that it's possible to select one by one. Each punch has a punching force of kN 1000 throughout its entire stroke.

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





- **Plate clamping system**, self-adjustable to suit the plate thickness, used for both stripping during punching operations 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** equipped with two pinchers suitable to clamp plates from 3 to 40 mm thick
 - **Zero plate reference unit**
 - **Supporting table with balls** to support the workpiece during the 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 located on the machine.
- **Ficep TAURO CNC Control System**, with 2 axes, integrated into the punching unit.



CNC PUNCHING & DRILLING LINE FOR PLATE



Table on linear guides moving through ball screws



Pinchers and zero reference moving device

OPTIONS

Drilling Unit



Marking Tool



Control unit TAURO series

The new generation control unit, with 2 controlled axes, is based on a field bus CANopen technology (it is used both for digital inputs/outputs and for the axes control through digital servo-operation).

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

The CNC is equipped with:

- ARM principal microprocessor at 200 Mhz with 128 MB RAM
- 10/100 RJ45 Ethernet port
- 2 USB ports
- real-time processor
- digital inputs (24V – optoinsulated)
- digital outputs (24V – protected transistors)
- USB modem with teleservice software

Main specifications:

- Simplified data input (with tables and workpiece on-screen graphics)
- Storage of the piece programs which can be imported and exported using ASCII files
- Counting of the pieces to be processed or already processed

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

- CNC internal and external alarms
- Diagnostic and indicative messages





PUNCHING CAPACITY			
Maximum punching capacity throughout the entire stroke and available on all punches		kN	1000
Material thickness with standard tools	MIN.	mm	3
	MAX.	mm	25
Maximum diameter		mm	46
X and Y axes positioning stroke		mm	1000 x 800
Maximum plate weight at a standard positioning speed		Kg	200
Maximum plate size with programmed repositioning		mm	800 on the length
Punches		no.	4
Punching max. thickness with shear strength 400N/mm ² dia. max. through		mm	32 x 25
OPTIONAL			
DRILLING CAPACITY			
Spindle speed with continuous program adjustment		rpm	180 - 800
Maximum plate thickness		mm	40
Maximum hole diameter		mm	40
Motor		kW	5,5
MARKING CAPACITY			
Available marking force		kN	1000
Marking tool		no.	1
Characters per group		no.	8
Size of characters (Ficep 31)		mm	16 x 8

AUTOMATIC LINES FOR PUNCHING, DRILLING AND MARKING PLATES						
Model	Max machinable plate*	Punching force kN	Drilling Kw.	Max diameter mm	Max thickness. mm	Ficep Cnc
P51	500 for repositioning	800		46	25	MINOSSE
P81	800 for repositioning	1000		46	25	TAURO
P112 D	1000 for repositioning		19	40	80	MINOSSE

* The coordinate table allows automatic repositioning of the plates, hence the maximum length depends on the maximum weight of the plate being processed



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