

80 YEARS
1930 - 2010

ANGLES



ANGLES - ANGOLARI - CORNIERES - WINKELPROFILE - ANGULARES

 **FICEP**
S.p.A.



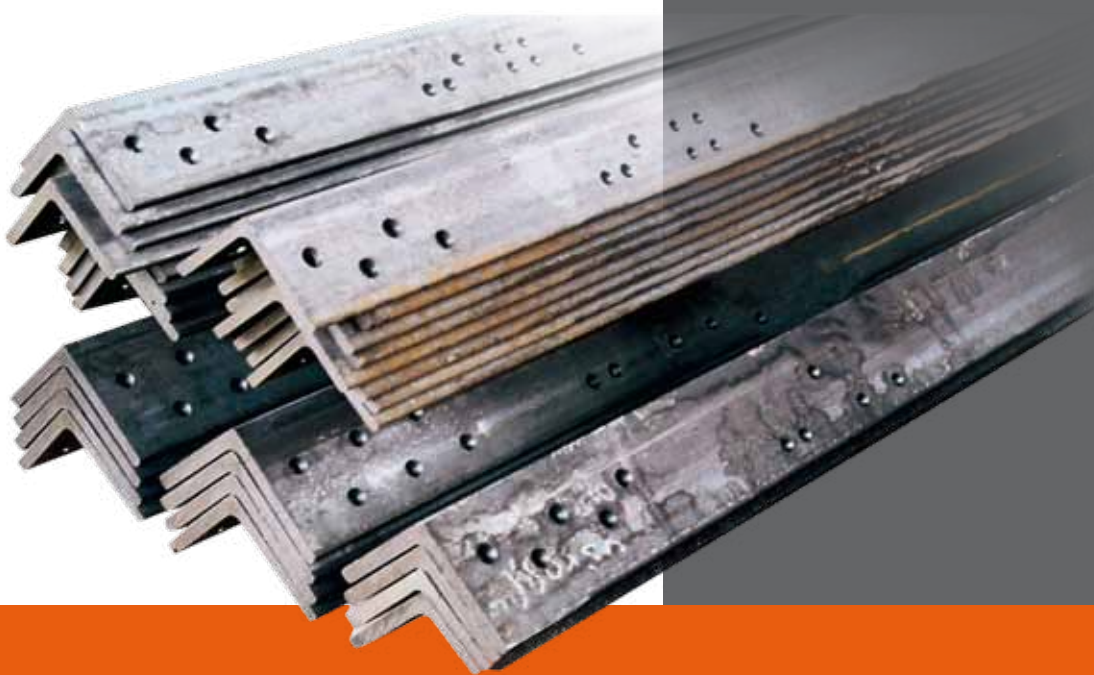
**since 1930 the
successful
production of
machines and
systems for
the steel
construction
industry**





Ficep was founded in 1930 in the tiny village of Gazzada in the extreme north of Italy. Four generations have followed in this medium-size family company, dedicating time and effort with a passion for the quest to excel in the niche sectors of steel construction and forging machinery manufacture.

In 2010 the company will be celebrating its first 80 years with an even closer eye on the future.







**Customers all around
the world have
chosen our
high-technology
systems in
constructing their
future**



The FICEP lines of CNC machines for the production of angles are predominant throughout the world.

Wherever you are, if you happen to see a line of pylons or telephone poles, they were probably constructed thanks to the substantial contribution of a Ficep angle machine.

No reputable steel construction company should be without a Ficep CNC line.

Ficep is represented throughout the world by its network of direct branches (9) and local agents with proven experience and reliability.



**more than 40 years producing
automatic CNC lines for the
construction of pylons**

HP

High Performance



Ficep's success lies in the company's passion for its job, in knowing the market with research and development of the technology involved in niche products.

From the first creation of manual machines, Ficep production has evolved through basic motorised machines to complete CNC lines. As early as the 60s, Ficep was the first to introduce automatic lines to face the enormous and constantly growing market demand for steel construction.

Even today, products are still evolving and the "HP" range, with its extraordinary performance, is an example of renewed vitality.





The new HP High Performance series offers 20% more performance



HP

High Performance

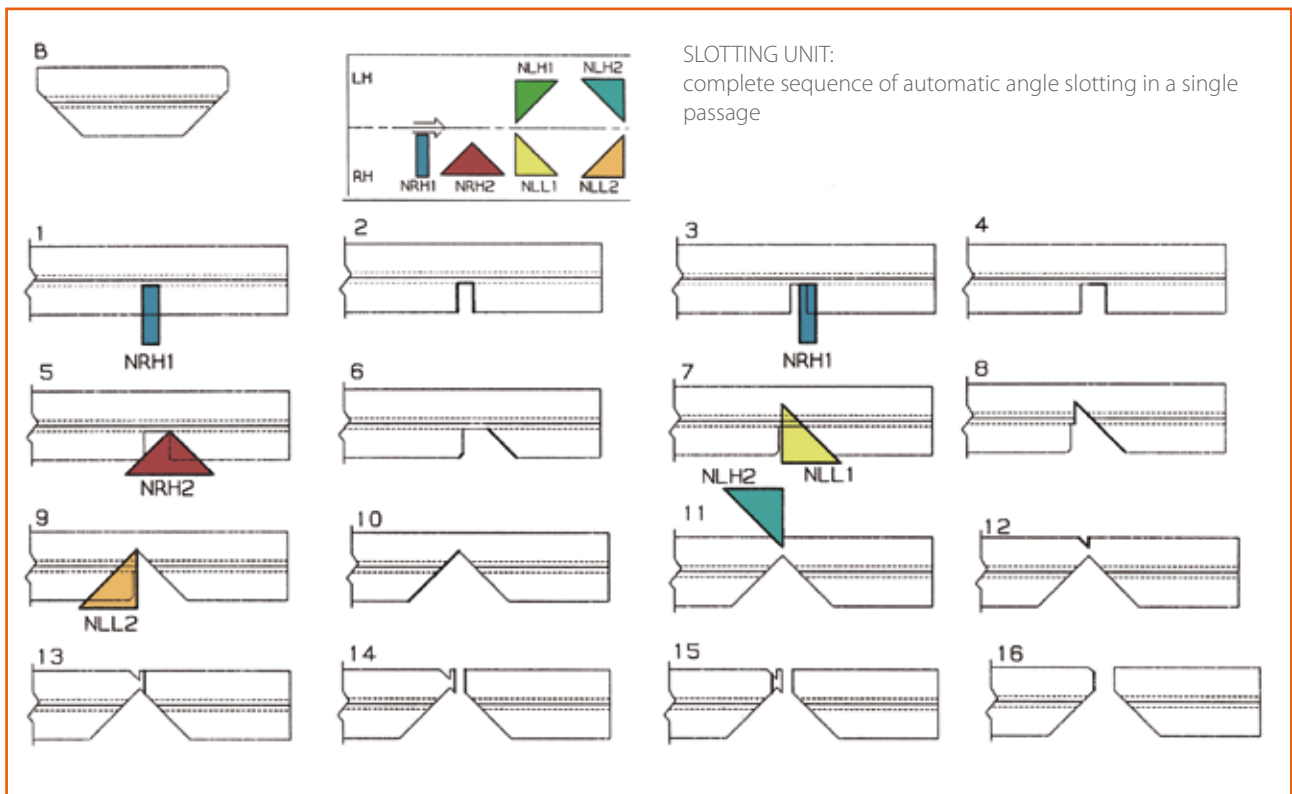
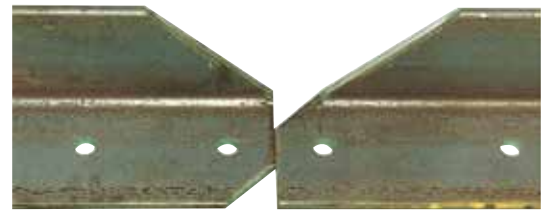


Girder builders have to face exasperating work schedules, often in extreme weather conditions. These needs are answered by the CNC lines in the new "HP" range which are outstanding for their:

- extreme robustness
- capacity of hydraulic units
- innovative hydraulic circuits
- resistance to fatigue and extreme climates
- dedicated intuitive hardware and software.

Ficep technicians have studied new hydraulic circuits to reduce cycle times and to obtain 20% more performance than previous models. The hydraulic units, separate from the machine, have been expanded and enabled to support work and environmental stress.





Total automation in the angle process



HP

High Performance

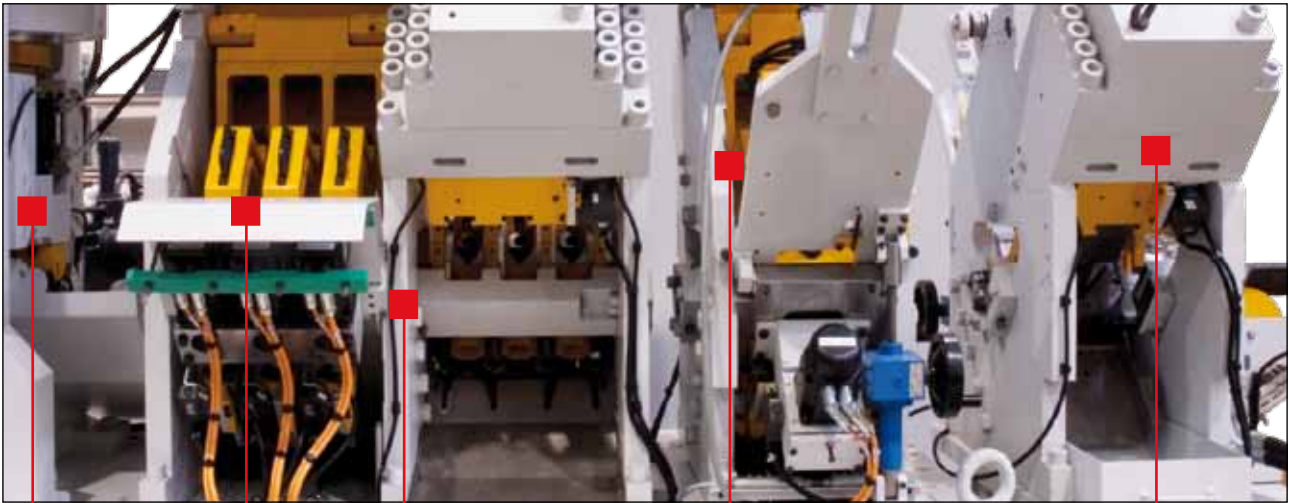
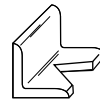
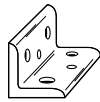
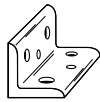
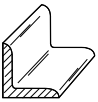


The modular "HP" lines can be combined in different ways, both in terms of size and the capacity to carry out various operations in a single pass.

The customer can easily configure a line which can be made to measure to suit company needs.

The "HP" lines are true and proper work cells where an angle enters as raw material and exits in an infinite combination of punched, drilled, slotted, marked and cut to measure segments.





Shear

Punching unit with three independent punches selected from program

Punching unit with three punches – view of the dies

Marking tool unit

Additional pressing unit with connection for optional tools



Drilling unit with automatic tool change



Automatic Marking unit.



Rapid-change shears for Cutting plates and U-bars.



A series of optional equipment to suit even the most demanding customers

HP

High Performance



The "HP" lines are flexible and can be combined according to customer requirements.

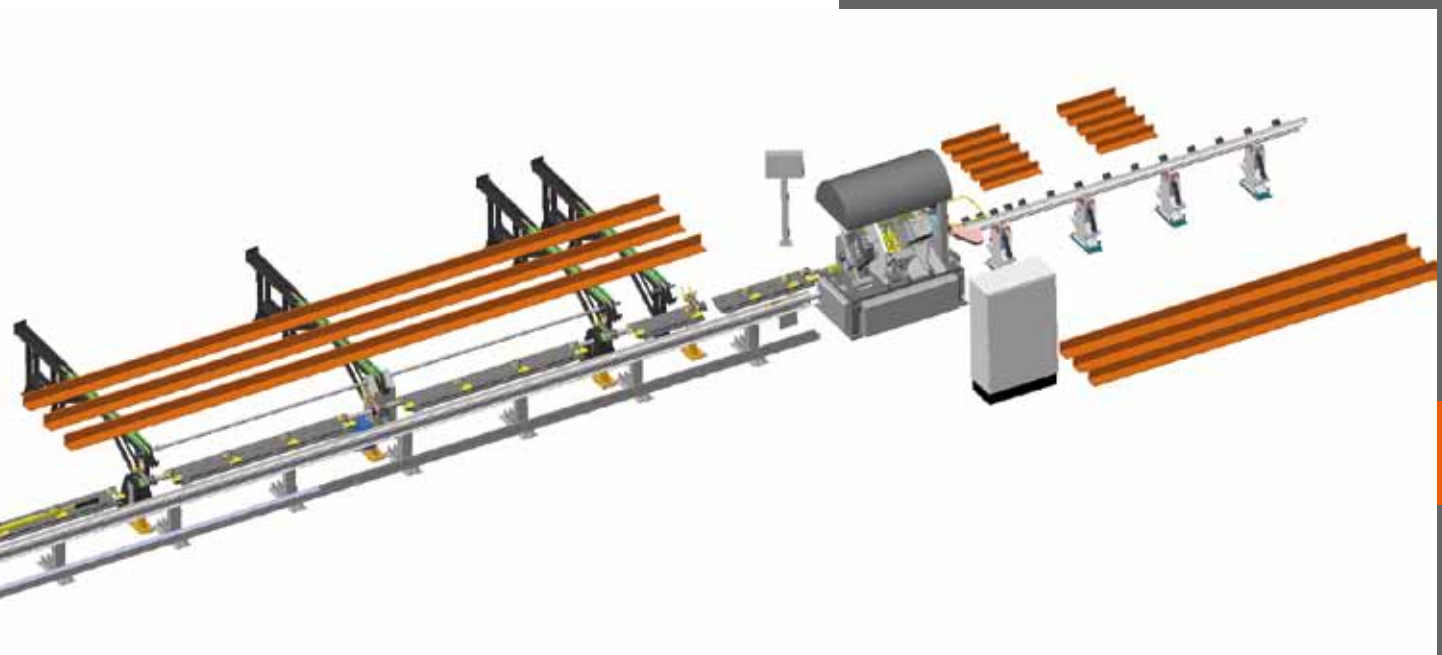
The basic machines are 80% standard but, in final construction stages, can be customised to specific requirements. This possibility gives the Ficep line a double personality of a series-made machine with tailor-made features.

Configurations can be made with:

- versions with 1,2 or3 diameter punching on each flanges of the angle.
 - rapid-change shears to cut plates and U beams.
 - interchangeable CNC programmed tool markers or writers.
 - automatic tool change drill
 - complete slotting unit or groups
- Supplementary pressing unit with interchangeable inserts for various pieces of equipment.

Great flexibility also in plant layout that can reach complete automation, starting from:

- automatic loading benches
- planetary feeders for automatic loading of angles from bench to roller
- feed rollers of various lengths
- evacuation tables divided left/right unloading on sequences of various lengths.







HP

High Performance

Model		HP 12 T4	HP 16 T2	HP 16 T4	HP 16 T6	HP 20 T4	HP 20 T6	HP 25 T	HP 35 T
Punching capacity									
Max. available strength	kN	650	650	720	720	1000	1000	-	-
Max. standard diameter	mm.	30 (32)	30 (32)	32	32	32	32	-	-
Diameter x thickness (410N/mm ²)	mm.	32 x 13	30 x 15	30 x 19	30 x 19	32 x 25	32 x 25	-	-
Diameter x thickness (510 N/mm ²)	mm.	30 x 13	30 x 12	25 x 19	25 x 19	30 x 20	30 x 20	-	-
Diameter x flange	no.	2	1	2	3	2	3	-	-
Angles (410 N/mm ²)	min.mm.	30x30 x3	30x30 x3	40x40 x4	40x40 x4	40x40 x4	40x40 x4	-	-
	maxi. mm.	120x120 x13	160x160 x15	160x160 x19	160x160 x19	200x200 x25	200x200 x25	-	-
Cutting capacity									
Max. shearing power	kN	1800	1800	2000	2000	4500	4500	-	-
Disk saw capacity	mm	-	-	-	-	-	-	250x250 x40	350x350 x40
Marking capacity									
Daisy wheel marking unit	kN	80	80	80	80	80	80	80	80
Cassettes marking unit	kN	1000	1000	1000	1000	1000	1000	-	-
Fonts available daisy wheel unit	no.	38	38	38	38	38	38	38	38
Fonts available cassettes unit	no.	4/8	4/8	4/8	4/8	4/8	4/8	-	-
Multi-function unit (optional)									
Max. available power	kN	900	900	900	900	900	900	-	-
Drilling capacity (optional)									
Drilling angle	min. mm	40x40 x4	40x40 x4	40x40 x4	40x40 x4	40x40 x4	40x40 x4	60x60 x6	60x60 x6
	maxi. mm.	120x120 x15	160x160 x20	160x160 x20	160x160 x20	250x250 x40	250x250 x40	250x250 x40	350x350 x40
Max. drill diameter	mm.	40	40	40	40	40	40	40	50
Diameter per flange	no.	1 (3)	1 (3)	1 (3)	1 (3)	1 (3)	1 (3)	1 (3)	1 (6)
Spindle speed	RPM	180-1000	180-1000	180-1000	180-1000	180-1000	180-1000	180-1500	180-3000
Forward speed	mm./1'	60-160	60-160	60-160	60-160	60-160	60-160	60-300	60-500
Control unit									
Ficep CNC Minosse series									
Axis-controlled	no.	5	3	5	7	5	7	3	3





The "A" series in the Ficep line have been created for small and medium steel construction companies. These machines provide flexibility and simple use so they can be utilised by customers who do not have specialised staff and where production lots are short and diverse.

Here, too, the range is complete and can be configured according to customer requirements.





Series A, strength and innovative technology for top level products



Lines in the "A" series are characterised by the input of material by means of an innovative roller conveyor system.

The operator only has to manually feed the angle onto the conveyor rollers, then the machine automatically conveys and positions the piece according to its size.

The roller system created by Ficep technicians allows precision with a minimum loss of material therefore reducing cost.

The "A" range includes various sizes to cover all the more common sizes of angles used in steel construction.



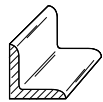
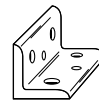
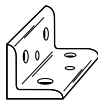


CNC-controlled 38-character marking unit

Punching unit with two punches inserted

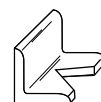
Hold down

Shear



Optional press unit with connection for supplementary equipment other than standard on the basic line.

- interchangeable marking tool
- simultaneous double punching unit
- triangular slotting unit





SERIE



FICEP
S.p.A.



The lines of the "A" series also maintain the prerogative of being flexible and combined according to the customer's requirements. The basic machine can be configured with options of:

- 1/2/3 diameters per flange.

Each diameter is managed by the CNC on an infinite number of surface types.

Each punch is housed in a special rapid-change holder

- written marks programmed by the CNC
- supplementary press unit for housing supplementary rapid-change tools.



Model		A 92	A 162	A 164	A 166	A 204	A 206
Punching capacity							
Max. available strength	kN	400	650	720	720	1000	1000
Max. standard diameter	mm.	30	30 (32)	32	32	32	32
Diameter x thickness (410N/mm ²)	mm.	30 x 9	30 x 15	30 x 19	30 x 19	32 x 25	32 x 25
Diameter x thickness (510 N/mm ²)	mm.	27 x 9	27 x 15	25 x 19	25 x 19	30 x 20	30 x 20
Diameter per flange	no.	1	1	2	3	2	3
Angles (410 N/mm²)							
	min. mm.	30x30x3	30x30x3	30x30x3	30x30x3	40x40x4	40x40x4
	maxi. mm.	90x90x9	160x160x15	160x160x19	160x160x19	200x200x25	200x200x25
Cutting capacity							
Max. shearing power	kN	900	1800	2000	2000	4500	4500
Marking capacity (optional)							
Daisy wheel marking unit	kN	80	80	80	80	80	80
Cassettes marking unit	kN	-	1000	1000	1000	1000	1000
Fonts available daisy wheel unit	no.	38	38	38	38	38	38
Fonts available cassettes unit	no.	-	4/8	4/8	4/8	4/8	4/8
Multi-function unit (optional)							
Max. available power	kN	-	900	900	900	900	900
Control unit							
Ficep CNC Minosse series							
Axis controlled	no.	3	3	5	7	5	7

HARDWARE

FICEP CNC CONTROL UNIT – MINOSSE SERIES

The new generation Minosse control unit, with 6 controlled axes, is based on a fieldbus CANopen technology. The CNC is positioned on a mobile control panel, so that the operator can have a complete view of the machine. All the input and output cards are connected to the bus and lodged on the machine, if it's possible.

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

Main features

- "Input" management of simplified data (tabular form)
- Piece program storage, with possibility of import/export using ASCII type files: all displays are positive and in language concerning:
- Alarms inside and outside the CNC
- Diagnostics and information for the operator

SOFTWARE

The dedicated software for Ficep lines has been studied and developed for the typical applications concerning angles, U-bars and plates. The profiles are managed according to casting plans that organise the processes and quantities thus facilitating the operator's tasks.

Programming is simple and easy to follow.

All Ficep lines are pre-arranged for exchange of information with top level external computer hosts.



AFTER SALES SERVICE

The Ficep after sales service is divided along three main lines:

START UP

taking care to train the customer's staff, starting up and testing the machine during the installation phase.

HELP LINE

following the customer's operations and providing support when seeking faults, searching for spare parts, consumer supply, and software updates.

MAINTENANCE SERVICE

providing non-routine maintenance and managing the eventual program of preventive maintenance.

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via Matteotti, 21
21045 GAZZADA SCHIANNO VA - ITALY
Tel. +39 0332 876.111
Fax +39 0332 462.459
www.ficep.it
E-mail: ficep@ficep.it



Z.I. "Les Platanes" - B.P. 20
33360 CAMBLANES - FRANCE
Tel. +33 (0) 556.20.15.55
Telefax +33 (0) 556.20.15.56
www.ficep-france.fr
E-mail: ficep@ficep-france.fr



2301 Industry Court - Forest Hill Industrial Park
FOREST HILL, MD 21050 USA
Tel. 1-410-588-5800
Fax 1-410-588-5900
www.ficepcorp.com
E-mail: info@ficepcorp.com



Poligono Industrial Ali-Gobeco
Calle Becolarra, N2 - Pabellón 30
01010 VITORIA (ALAVA) - SPAIN
Tel. +34 945.14.83.11
Fax +34 945.14.81.37
www.ficepiberica.com
E-mail: ficep@ficepiberica.com



Unit 204, 2nd Floor - Block C
DB Plaza Discovery Bay - HONG KONG
Tel. +852-2544 6888
Fax +852-2544 5123
www.ficep.com.hk
E-mail: info@ficep.com.hk



10 The Courtyards - Victoria Park
Victoria Road Leeds LS14 2LB
UNITED KINGDOM
Sales Tel: 0113 2653921
Service Tel: 0113 2653923
Fax: 0113 2653913
www.ficep.co.uk
E-mail: info@ficep.co.uk



144 El-Alam Str. Forest Bldg., Badaro
P.O.Box 2019/116 Beirut Court House Beirut
LEBANON
Tel. +961 1 386664
Fax +961 1 386011
Mobile: +961 70126826
www.ficep-me.com
E-mail: info@ficep-me.com



Bernhard-Hahn-Str. 7-9
41812 Erkelenz GERMANY
Tel. 02431-80020
Fax 02431-800213
www.ficep-hmb.de
E-mail: info@ficep-hmb.de



Av. Vital Brasil n° 540 - Centro - Poá
São Paulo 08557-000 -BRASIL
Tel./Fax: +55-11-4636.8798
e-mail: ficepsulamerica@ig.com.br



Office, Tele/fax 0044-2886751150
Mobile 0044-7711610244
Office, Tele/fax 0044-1460239635
Mobile 0044-7876591176



127051, Москва, ул. Петровка, 20/1, офис 36.
Тел.: (495) 6423794, 6423795
Факс: (495) 5858696
E-mail: pmcm@mail.ru



FICEP INDIA SERVICE
Pradman Engineering Services Pvt. Ltd.
Plot No A-490, Road U, Opp. DGP Windsor,
Next to Irmra, Wagle Industrial Estate,
Thane (W) - 400604 India
(Tel) +91 22 25806179 / 80
Gaurang Trivedi - Technical Services
(Mob) +91 9702701730