

HARDWARE & SOFTWARE

FICEP MINOSSE CONTROL UNIT

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

The CNC is positioned in a mobile control panel to let the operator have a complete system overview. All the input and output cards are connected to the bus and positioned, where possible, directly on 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.
- Possibility for the drill heads to operate in “multitasking” mode in their working areas (even with automatic tool changer).
- Automatic control to prevent any possible collision of the drills.
- Drilling parameters table.

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.

“WIN-NEST” Software Package, 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.



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TIPO A

Automatic CNC drilling and thermal cutting line for high thickness plates



TIPO A

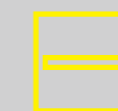
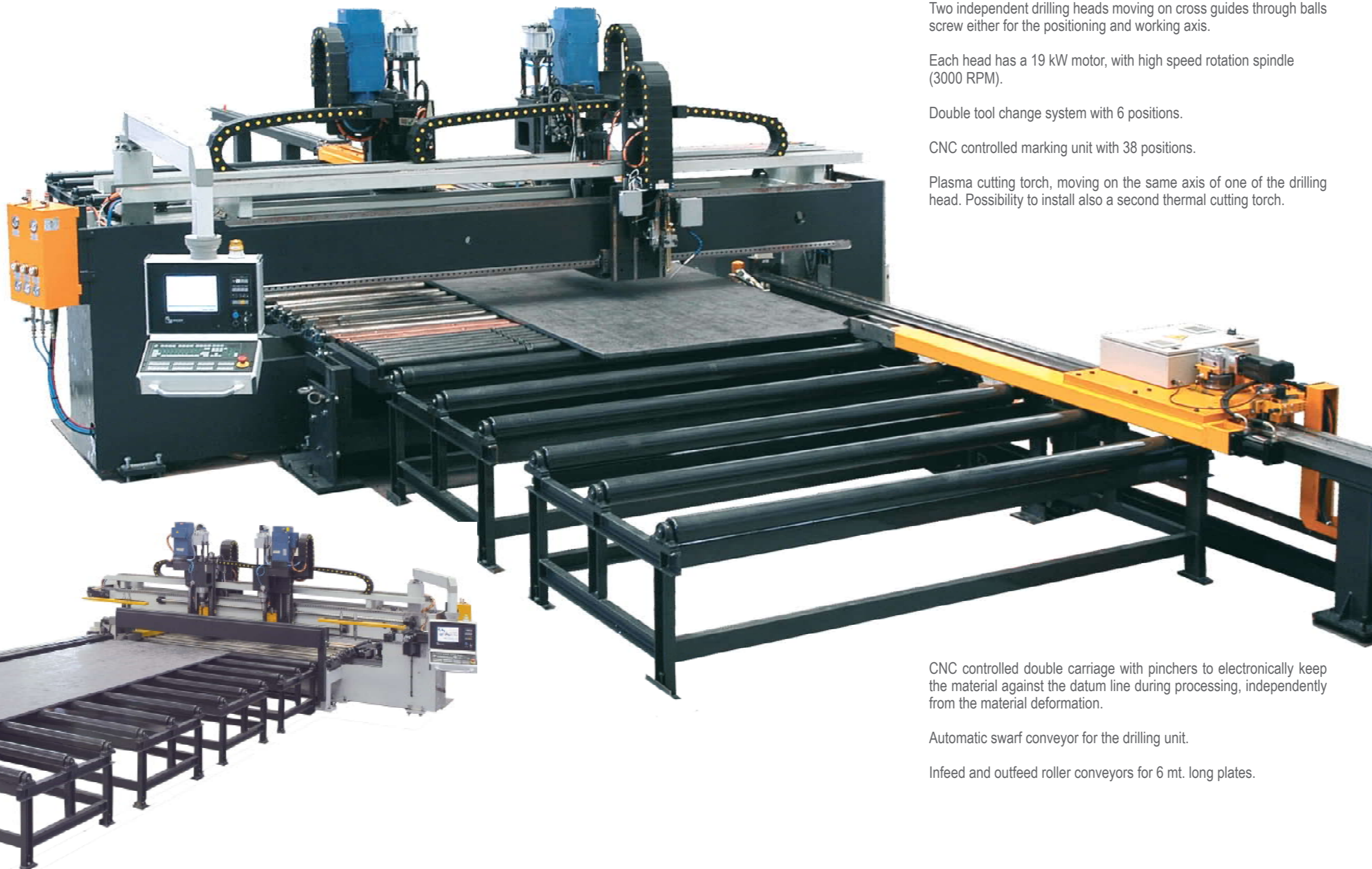
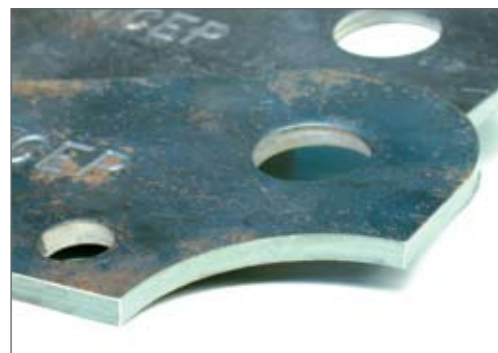
Suitable for:

- Manufactures of bridges and viaducts
- Shipyards
- Manufactures of agricultural and earth moving machinery
- Heavy structural steel manufactures

The main feature of Ficep CNC working centers is to process automatically the largest plates available on the market without thickness limits.

The CNC line A 31 can carry out in one step the main operations required in the steel construction industry such as drilling, milling, pointing, tapping, marking and cutting with the following advantages:

- Reduced overall dimensions
- Reduced material handling
- High processing speed
- Variety of operations
- Precision
- Productivity
- Optimization



MAIN TECHNICAL SPECIFICATIONS



Portal baty with over-dimensioned frame.

Two independent drilling heads moving on cross guides through balls screw either for the positioning and working axis.

Each head has a 19 kW motor, with high speed rotation spindle (3000 RPM).

Double tool change system with 6 positions.

CNC controlled marking unit with 38 positions.

Plasma cutting torch, moving on the same axis of one of the drilling head. Possibility to install also a second thermal cutting torch.

CNC controlled double carriage with pinchers to electronically keep the material against the datum line during processing, independently from the material deformation.

Automatic swarf conveyor for the drilling unit.

Infeed and outfeed roller conveyors for 6 mt. long plates.

MODEL		Tipo A16	Tipo A 31
Specifications of the large plate to be processed (entry side):			
Length	max.mm	3000	6000
	min. mm	1500	2500
Width	max. mm	1600	3100
	min. mm	400	400
Specifications of the processed piece (exit side):			
Length	mm	200	200
Width	mm	150	150
Max. positioning weight	Kg	5000	7500
Longitudinal transferring speed	m/mm	30	30
Vertical drill head	no.	1	1 (2)
Spindle per vertical drill head	no.	1	1
Maximum hole diameter	mm	40 (50)	40 (50)
Maximum thickness that can be drilled	mm	130	130
Spindle rotation motor (a.c.)	kW	19	19
Spindle rotation speed with continuous adjustment from program	RPM	180 + 3000	180 + 3000
Automatic tool changer at 6 positions	no.	1	1 (2)
Optional marking unit at 38 stations	kN	80	80
Oxycutting torch	no.	1	1 (2)
Plasma cutting system HYPER THERM	no.	1	1 (2)
Ficep control unit		Minosse	Minosse