

**80** YEARS  
1930 - 2010



**HP 25T - HP 35T**  
CNC automatic drilling lines  
for angles

 **FICEP**  
S.p.A.



CNC automatic drilling lines  
for angles

# HP

**High Performance**

The new Ficep drilling line for angles offers quality, accuracy and productivity.

The use of ultra powerful spindles, together with a new generation of high performance tools make it possible to have high speed rotation and feed speed.

All the advantages of dynamically drilling the angles are clearly defined to offer economic processing even on large sizes.

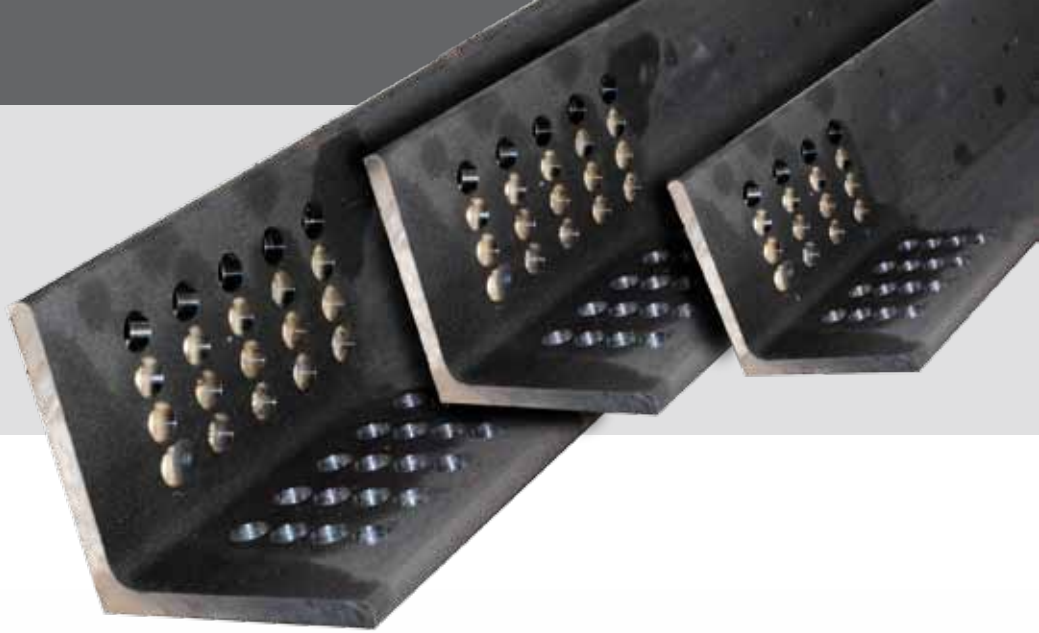
drilling unit





6 position tool changer





The HPT series drilling machines are modular and can include the following functions:

- Scribing or hard stamp marking
- Single or double shearing
- High speed sawing

The size of angle requiring processing and the tough tolerance limits set in some contract specifications can be achieved simply by these drilling lines.

The working cycle is automatically managed by the CNC through specific software programs designed for easy interface.

The angles are loaded on transfer arms and automatically fed on to the conveyor track. The system is designed for automatic clamping with a controlled axis feed, material is conveyed through the machine and every process takes place sequentially. The pieces, scrap or remnants completed after the saw or shear are then unloaded in an organized process and offloaded at pre determined positions on the unloading area.



#### DRILLING MACHINES

The two drilling units are equipped with very powerful spindles and an automatic tool change device with 6 positions.

The spindle positioning and feed are automatically managed by the CNC, they utilise linear guides with controlled servomotors and ball screws ensuring maximum precision on every axis.

#### MARKING MACHINES

The optional marking units can be the hard stamping type managed by the CNC or an 8 selectable cassette type, each one including 13 characters.

#### CUTTING

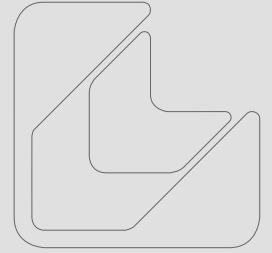
The cutting, according to the client's needs, can be as follows:

Hydraulic shearing with single or double cutting  
Travelling high speed circular saw with hardened or added carbide inserts

Both shearing machines are equipped with heavy duty hold downs and quick blade changing facility.

# HP

High Performance



Hydraulic shearing



Marking unit



Circular saw



### CNC FICEP control unit - TAURO series

A new generation control unit with fully controlled axis, based on the CANopen fieldbus technology (used for both digital Input/output and the axis control occurring through digital servo-operations)

The CN is housed in the command console.

The CN is equipped with:

- Main microprocessor ARM at 200 Mhz with 128 MB RAM
- RJ45 10/100 Ethernet port
- 2 USB ports
- Real-time microprocessor
- Control panel with TFT 12" color touch screen
- Opto-insulated 24V digital inputs
- Protected transistors 24V digital outputs
- USB modem with remote assistance software

Main characteristics

- Data input simplified management (table-form)
- Piece programs storage, with possibility to import and export using ASCII files

All displays are in clear and in language and are related to:

- CNC internal and external alarms
- Diagnostic and informative messages to the operator





## EFFICIENCY DATA AND TECHNICAL CHARACTERISTICS

Model		HP 25T	HP 35T
<b>Drilling capacity</b>			
Drilling angle			
	min. mm.	60x60x6	60x60x6
	max. mm.	250x250x40	350x350x40
Maximum workable diameter	mm.	40	40
Maximum workable thickness	mm.	40	40
Spindle nose	type	HSK-A80	HSK-A80
Spindle rotation speed	rpm	180-3500	180-3500
Feed speed	mm./1'	80-300	80-300
Tools positions changing	no.	6	6
Spindles power	kW	19	19
<b>Cutting capacity (optional)</b>			
<b>Single cut shearing</b> maximum power	kN	4500	4500
Maximum shearing angle(Fe 44R=410N/mm <sup>2</sup> )	mm.	200x200x25	200x200x25
<b>Circular saw</b>	kW	18	18
Blade diameter	mm.	560	560
Cut speed	mt/min	80-180	80-180
Cutting maximum angle	mm.	250x250x40	350x350x40
<b>Marking capacity (optional)</b>			
<b>Daisy wheel marking unit</b>	kN	80	80
Marking characters	no.	38	38
Character size	mm.	16x8	16x8
<b>Cassettes marking unit</b>	kN	1000	1000
Selectable cassette	no.	8	8
Characters per cassette	no.	13	13
Character size	mm.	16x8	16x8
<b>Control unit</b>			
CNC Ficep	serie	TAURO	TAURO
Controlled axes	no.	5	5



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