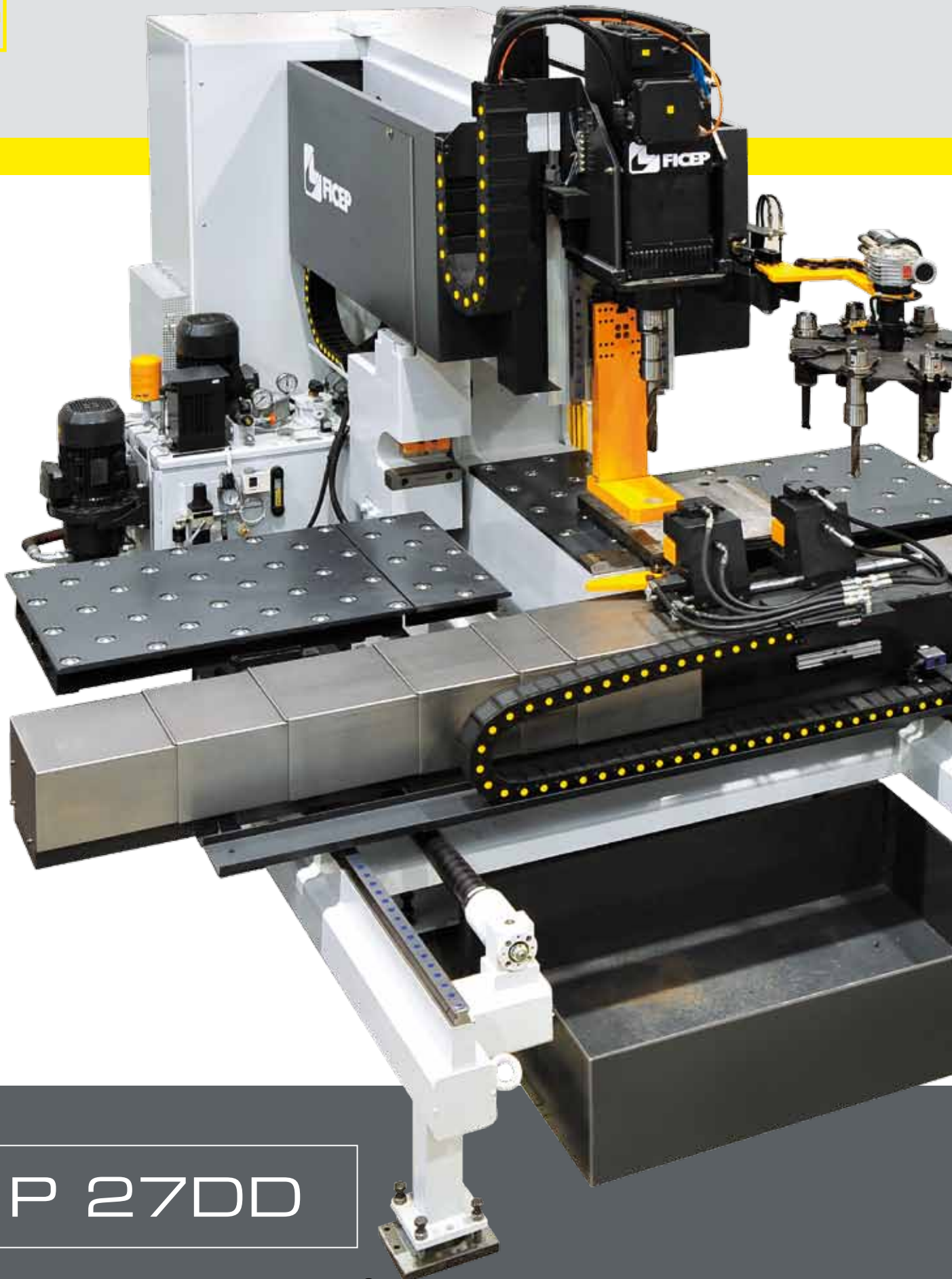


80 YEARS
1930 - 2010



P 27DD
CNC plate drilling line





P 27DD



CNC plate drilling line

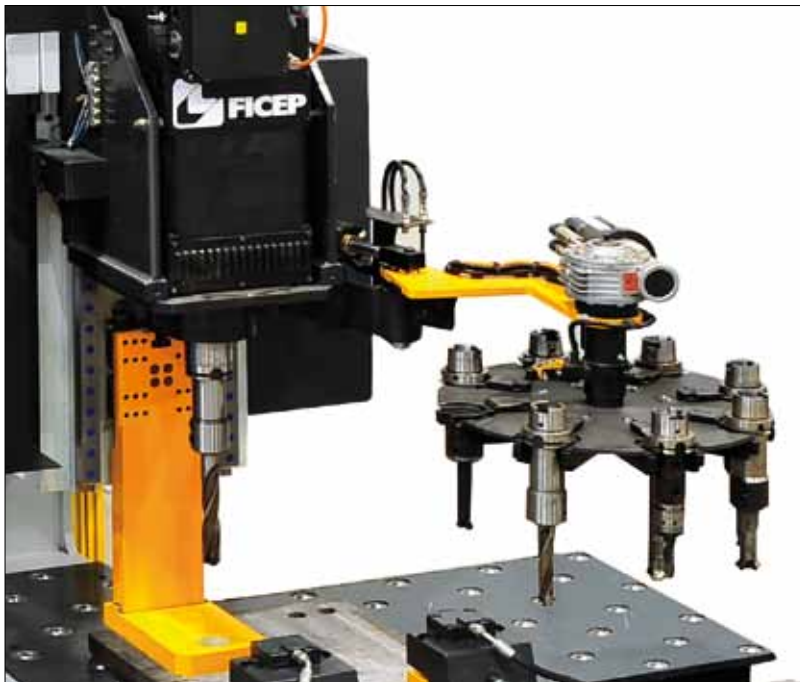


P 27DD is a drilling machine specifically designed for automatic drilling of plates to a considerable thickness of 80mm. Traditional systems such as (drilling machines, portable manual drilling machines, etc) have been overcome by this high speed drilling machine which not only carries out the drilling operation, but can also mark, thread and scribe the plates to mark possible welding layout positions (scribing).

The drilling machine is made up of:

- Rigid and sturdy electrowelded plate frame
- High speed Ballscrew controlled drilling head
- 19 kw power spindle
- Automatic tool changing device with 8 positions
- Coordinate table for automatic movement of 1000mm x 1250 mm plates, with possibility to reposition and move using ball screw drives over a roller ball table
- Ficep Minosse series CNC
- Dedicated software packages for processing structural plates.

The drilling machine is conceived both for field programming and connection to higher level host computers.



8-positions device for automatic change of tools with ISO adapters. Among the tools available, besides the drilling bits in various configurations, automatic tapping and scribing tools and counter sinking may be mounted.

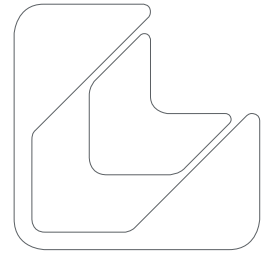


Independent marking unit with hard stamping device



Automatic scribing tool.





CNC plate drilling line

FICEP MINOSSE SERIES CNC CONTROL UNIT

The new generation control unit, with 3 controlled axes, is based on the CAN open fieldbus technology.

The CNC is accommodated inside an electrical cabinet arranged on board the machine.

The CNC is provided with:

- 24V opto-isolated digital inputs
- Protected 24V transistor digital outputs

The control panel is an industrial PC containing the numerical control card.

PC features:

- . CPU 600 Mhz with L2 512 KB cache
- . 512 MB RAM memory
- . 12.1" touch screen colour TFT monitor
- . Panel and auxiliary pushbutton panel
- . 10/100 RJ45 Ethernet port
- . USB modem
- . 1 extra USB port
- . Windows XP Embedded operating system
- . Tele assistance software

Programming

- Data input simplified in table data form, with piece graphic in line
- Absolute and incremental units
- Programming by diameters
- Linear, matrix and flange pattern.

Processing

- Tools assigned automatically
- Unit offset sum
- Arrangement of units

Execution

- Automatic cycle stop to modify set-up with the tool to be replaced indicated on the display
- Drilling parameters table



All displays are decoded and in language and they regard:

- The programme being executed with the decoded indication of the process in progress
- Alarms inside and outside the CNC
- Date and time recording of the last 100 alarms
- Diagnostic messages to the operator



Model		P 27DD
Main technical features		
• Plate size	min. mm	100 x 100
	max. mm	1000 x *
<i>* The coordinate table allows repositioning the clamps, hence the maximum length depends on the maximum weight of the plate.</i>		
• Max weight at normal positioning speed	kg	250
<i>A plate weighing up to 400 kg may be positioned at a low positioning speed</i>		
• Plate thickness	min. mm	6
	max. mm	80
• Angles (machinable with optional equipment)	min. mm	60 x 60 x 6
	max. mm	150 x 150 x 12
• Machinable angle lengths	min. mm	100
	max. mm	800
• X axis positioning travel	mm	1250
• Y axis positioning travel	mm	1000
• Maximum axes positioning speed	m/min.	40
• Maximum axes positioning speed at 45°	m/min.	56
Drilling capacity		
• Vertical drilling head	no.	1
• Vertical head spindle	no.	1
• Maximum drilling diameter	mm	40
• Maximum drilling thickness	mm	80
• Power installed on the spindle (approx)	kW	19
• Spindle speed constantly adjustable by the programme	RPM	da 180 a 3000
<i>N.B.: All tolerances of the mentioned unmachined profiles are intended to comply with the UNI 5783-5784/73 standards.</i>		

AUTOMATIC LINES FOR PUNCHING, DRILLING AND MARKING PLATES						
Model	Max machinable plate *	Punching force kN	Drilling kW	Max diameter mm	Max thickness mm	Cnc Ficep
P 51	500 for repositioning	800		46	25	MINOSSE
P 1104P	800 for repositioning	1000		46	25	MINOSSE
P 27DD	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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