

OFFER

SECOND-HAND LINE 1103 DF

AUTOMATIC CNC DRILLING LINE

SERIAL NUMBER: 33313 – MANUFACTURING YEAR: 2011

PURCHASED AS SEEN

FICEP S.p.A

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MAIN TECHNICAL SPECIFICATIONS

Sections that can be drilled:

I-Beams (without camber)

• Web height	min. mm	80
	max. mm	1020
• Flange width	min. mm	42
	max. mm	510

UNP Channels (web downwards)

• Web height	min. mm	80
	max. mm	1020
• Flange width	min. mm	45
	max. mm	300

Angles

• Flange height (unequal flanges as well)	min. mm	80 x 80 x 8
	max. mm	300 x 300 x 40

Flats

• Width	min. mm	100
	max. mm	1020

Square Tubes (4 sides coping)

• Size	min. mm	80 x 80
	max. mm	400 x 400

Rectangular Tubes (4 sides coping)

• Size	min. mm	80 x 40
	max. mm	400 x 300



All Sections

• Maximum thickness that can be drilled	mm	100
• Maximum length	mm	12000
• Minimum transferable length	mm	2500

(with longitudinal copes on both heads having a maximum length of 400 mm on the lower half flanges)

Drilling Capacity

• Vertical drill heads	no.	1
• Horizontal drill heads	no.	2
• Spindles per vertical drill head	no.	1
• Spindles per each horizontal drill head	no.	1
• Maximum hole diameter	mm	50
• Spindle rotation motor per head (a.c.)	kW	19
• Spindle rotation speed	RPM	180 -3000
• Spindle drill feed rate	mm/min	40 - 1000
• Spindle fast approach/return speed	mm/min	15

Other Specifications

• Max. positioning weight	Kg.	5400
• Max. linear weight of the section	Kg./m	220
• Max. carriage speed	m/min.	40
• Horizontal heads spindle positioning speed	m/min.	15
• Vertical head spindle positioning speed	m/min.	30
• Working level's height	mm	865

NOTE: Dimensional tolerance of raw sections are to UNI 5783-5784/73 standards.



SYSTEM CONFIGURATION

IC	INFEED CONVEYOR (for bars up to 12 mt)
IC-01	Carriage supporting structure
IC-02x	Carriage complete with pincher arm and automatic clamping
IC-03	Idle rolls rollerway
WU	WORKING UNITS
WU-01	Monospindle horizontal drilling heads (n. 2)
WU-02	Monospindle vertical drill head
WU-03	Hydraulic double jaw vice assembly
OWU-03	Tool-change system (with 6 positions)
OWU-04	Electronic devices for zero reference setting
OWU-05	Device for "SCRIBING" operations
OWU-06	Web scribing device (underside)
OC	OUTFEED CONVEYOR (for bars up to 12 mt)
OC-01	Powered rollerway
OC-02	Alignment device
HY	HYDRAULIC AND PNEUMATIC SYSTEMS
HY-01	Hydraulic power pack
HY-02	Pneumatic system
EL	ELECTRIC SYSTEM
EL-01	On-board distribution system
EL-02	Electric cabinet
CN	FICEP CONTROL UNIT



PA	STANDARD PAINTING
TD	TECHNICAL DOCUMENTATION
SP	SAFETY PROTECTION
SP-01	Protections on the machine (included)
SP-02	Outside protections (excluded)



CONDITIONS OF SUPPLY

P	PRICE	POA
D	DELIVERY TIME	(X) working weeks from receipt of the order and relevant downpayment – S.P.S. (Subject to prior sale)
PK	PACKING	Included
DT	DELIVERY TERMS	Ex our Gazzada works
PT	PAYMENT TERMS	20% downpayment with the order, 80% balance upon advice of goods ready for shipment

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