

OFFER

SECOND HAND LINE

1203 DB

AUTOMATIC CNC DRILLING & SAWING LINE

SERIAL NUMBER: 27895 – MANUFACTURING YEAR: 2003

PURCHASED AS SEEN

FICEP S.p.A

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MAIN TECHNICAL SPECIFICATIONS

I-Beams (without camber)

Web height	min.mm	80
	max.mm	1220
Flange width	min.mm	42
	max.mm	500

UNP Channels (web downwards)

Web height	min. mm	80
	max. mm	1220
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 50

Flats

Width	min. mm	100
	max. mm	1220

Square Tubes

Size	min. mm	80 x 80
	max. mm	500 x 500

Rectangular Tubes

Size	min. mm	80 x 40
	max. mm	1200 x 500

All beams

Max. thickness that can be drilled	mm	75
Max. length infeed side	mm	20000
Max length outfeed side	mm	18000
Minimum length to be transferred	mm	1300

Drilling Capacities

Vertical drill head	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	40
Spindle rotation motor per head (a.c.)	kW	11
Program controlled spindle rotation speed with continuous variation	RPM	180 – 1500

Band Sawing Unit model 1260 BH

Minimum sawing capacity at 90°	mm	80 x 10
Maximum sawing capacity at 90°	mm	1250 x 600
Sawing capacity at 45°	mm	800 x 600
Toothed band's size	mm	54 x 1.6
Band motor's power	kW	7,5
Toothed band's speed	m/min.	20 - 100

Other Specifications

Maximum positioning weight	Kg	8000
Maximum linear weight of the section	Kg/m	375
Maximum carriage speed	m/min.	40
Spindle positioning speed	m/min.	10
Working level's height	mm	850

NOTE: Dimensional tolerances of the raw sections are to UNI 5783-5784/73 standards

SYSTEM CONFIGURATION

IC INFEED CONVEYOR (FOR BARS UP TO 20 MT)

- IC-01 Carriage supporting structure
- IC-02 Carriage
- IC-03 Idle rolls rollerway
- OIC-1/2 Infeed conveyor's extension for 20 mt long bars
- OIC-2/3 Infeed transfer table with catches
(20 mt - 6 arms - 8000 kg - 5,3 mt width)
- OIC-4 Automatic Pincher Clamping Device
- OIC-5 Increase of rolls number (infeed and outfeed)

WU WORKING UNITS

- WU-01 Monospindle Horizontal Drill Heads (no. 2)
- WU-02 Monospindle vertical drill head
- WU-03 Hydraulic double jaw vice assembly
- WU-04 Sliding idle roll
- OWU-1 Marking unit with 36 positions mod. MKT 36 N
(1 set of marking characters included)
- OWU-2 Electronic devices for automatic zero reference setting
- OWU-3 Swarf conveyor for the drilling unit
- OWU-4 Tool-change systems

SU SAWING UNIT

- SU-01 Band Sawing Unit Model 1260 BH
- OSU-1 Saw mitering at +45° / -60°
- OSU-2 Vertical hold-downs for the saw



OC OUTFEED CONVEYOR (FOR BARS UP TO 18 MT)

OC-01 Powered rollerway

OOC-1/3 Outfeed conveyor's extension for 18 mt long bars

OOC-3/2 Outfeed transfer table with carts with 2 selectable zones (18 mt - 5 arms - 5250 kg - 5,3 mt width)

HY HYDRAULIC AND PNEUMATIC SYSTEM

HY-01 Hydraulic power pack

HY-02 Pneumatic system

EL ELECTRIC SYSTEM

EL-01 On board distribution system

EL-02 Electric cabinet

CN FICEP CNC Control System

PA STANDARD PAINTING

TD TECHNICAL DOCUMENTATION

SP SAFETY PROTECTIONS

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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