



STEEL  
CONSTRUCTION

ANGLES & FLATS  
BEAMS & PIPES  
PLATES  
SURFACE TREATMENT  
ROBOTIC WELDING  
SOFTWARE & AUTOMATION



**XP T**

High performance CNC punching  
and shearing lines for angles



Montfort International Itée

# L XP T

## High performance CNC punching and shearing lines for angles

Thanks to our extensive experience that has been gained as the world's leader in the design and production of angle lines our engineers have been able to create a brand-new range of angle processing lines. The XP-T product line represents a technological breakthrough in angle line designs for diverse applications. The XP-T product range is our response to the productivity, capability and accuracy demands of the world's most challenging applications.

- ↳ **Faster material positioning**  
 Improved, high speed rack and pinion material positioning system processes angles at speeds up to 390 feet per minute.
- ↳ **Faster material clamping**  
 Unique automatic roller hold-downs constantly keep the material securely clamped even during positioning. Each independent punching unit has two hold-downs, one before and one after the punch tool to better guarantee gauge line accuracy.
- ↳ **Faster punching**  
 Super fast punching operations are achieved by a new high tech hydraulic power pack. The speed of the punching units are automatically adjusted by the software based upon the diameter of the hole to be punched and the material being processed.



Pegaso is the latest generation CNC for FICEP lines where the PC, CNC and PLC are all integrated into a single circuit board for maximum reliability. Pegaso is based upon a field bus technology using CanBus and EtherCAT for controlling up to 32 separate CNC axes.



**↳ Faster processing and tool pre-positioning**

Each punching tool has its own press cylinder and independent positioning system. This independent design permits the tools that are not being used to position to the next required location in mast time.

**↳ Faster shearing**

Innovative hydraulic power pack design minimizes the shearing process. The force and speed of the shearing is automatically managed by the CNC control based upon the material size being processed.

**↳ Faster hydraulic oil flow**

The hydraulic manifolds are designed to allow the oil to reach the maximum flow rate to the press cylinders.

**↳ Faster hydraulic pressure delivery**

The new generation hydraulic power pack allows for the automatic CNC controlled adjustment of the presses operational pressure.

**Daisy-wheel programmable marking unit****On-board manifolds****Quick-change punch holders****Single-cut shearing unit**



Pegaso control unit



Infeed cross transfer and rotating loading system

**The system layout is also flexible to incorporate:**

- Automatic stock length loading tables
- Rotary loaders for the automatic transfer of angles from the loading table to the system's infeed conveyor
- Infeed and outfeed conveyors of various lengths
- Discharge tables for left or right unloading, based upon the requirement

XP-T CNC punching and shearing line	XP10T2	XP10T4	XP12T4	XP12T6	XP16T4	XP16T6
Angle size [min. inch]	1-1/4 x 1-1/4" x 1/8"	1-1/4 x 1-1/4" x 1/8"	1-1/4 x 1-1/4" x 1/8"	1-1/4 x 1-1/4" x 1/8"	1-1/4 x 1-1/4" x 1/8"	1-1/4 x 1-1/4" x 1/8"
Angle size [max. inch]	4" x 4" x 1/2"	4" x 4" x 1/2"	4-1/2" x 4-1/2" x 1/2"	4-1/2" x 4-1/2" x 1/2"	6" x 6" x 5/8"	6" x 6" x 5/8"
Diameter per leg [no.]	1	2	2	3	2	3
Punching force [US tons]	72	72	72	72	88	88
Punching diameter [max. inch]	1-1/4"	1-1/4"	1-1/4"	1-1/4"	1-1/4"	1-1/4"
Shearing force [US tons]	198	198	198	198	242	242

TECH SPECS