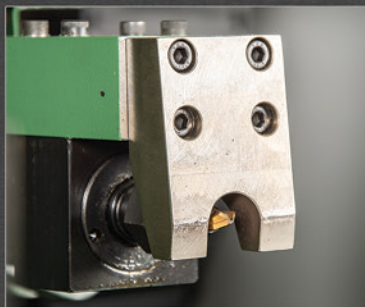


Peddinghaus

BDL-1250/9D

HEAVY DUTY CARBIDE DRILL LINE



A Letter from the CEO



Anton Peddinghaus

Welcome to the World of Peddinghaus – The World of “BETTER”.

In the world of Peddinghaus we aim to be better. Take a look at any of our 5,000+ installations throughout the globe. These fabricators experience reduced costs and higher production using our equipment. Why? Because with Peddinghaus they receive better technology, better service, and better quality than anyone else can provide. These things aren't easy to do, and not every company can guarantee what Peddinghaus does. I am proud that I can say these things because at Peddinghaus we work harder than anyone to give our customers the best. Whether they are located in Mexico City, Mumbai, or Melbourne; they all receive the very same service, spare parts, and support that is second to none.

Welcome to Partnerships – From Software to Service to Sales.

At Peddinghaus we maintain strong partnerships with industry leaders to ensure your success. Whether this is our relationship with leading software providers (such as Shop Data Systems, Sigmanest, Steel Office, AceCad, Tekla, FabTrol, Design Data, and more) or our partnership with regional sales and support organizations - our goal is to work together to serve you better.

Welcome to the BDL-1250/9D – More than Just a Machine.

When production matters most, the BDL-1250/9D carbide drill is unmatched in its ability to process the heaviest sections. Processing an average of 200 plus tons of structural steel per 40-hour work week, the BDL-1250/9D is the preferred drilling solution for the world's largest fabricators.

With superior clamping power to accommodate carbide drilling, the BDL-1250/9D boasts an impressive 1800 RPM spindle speed. Combine that with today's modern technologies including micro-mist coolant, spindle specific motors, carbide part marking, Smart Spindle II technology and automatically adjusting roller measurement, the BDL-1250/9D proves to be the industry's premier drill line.

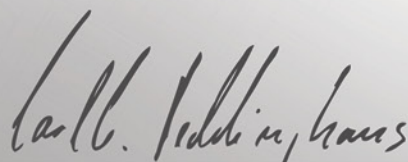
Welcome to Peddinghaus Service – Unmatched Global Support.

At Peddinghaus service is priority number 1. Peddinghaus' global team of customer support representatives are on duty, on call, all the time at our very own 24-hour customer support center. Combined with state-of-the-art remote diagnostic software, readily available local field support professionals, and the industry leading warranty - customer support from Peddinghaus is only a call or a click away.

Welcome to Peddinghaus – A Tradition of Innovation, a Reputation for Excellence.

My great-grandfather and grandfather perfected Ironworkers during their time with Peddinghaus; then it was my father's turn to pioneer the TDK drill line. In today's world I am proud that we at Peddinghaus continue to offer new solutions for our customers such as the BDL-1250/9D. This is only possible through constant innovation, and continuing investment in research and development. I invite you to see why Peddinghaus technology is the chosen provider for steel fabricators the world over.

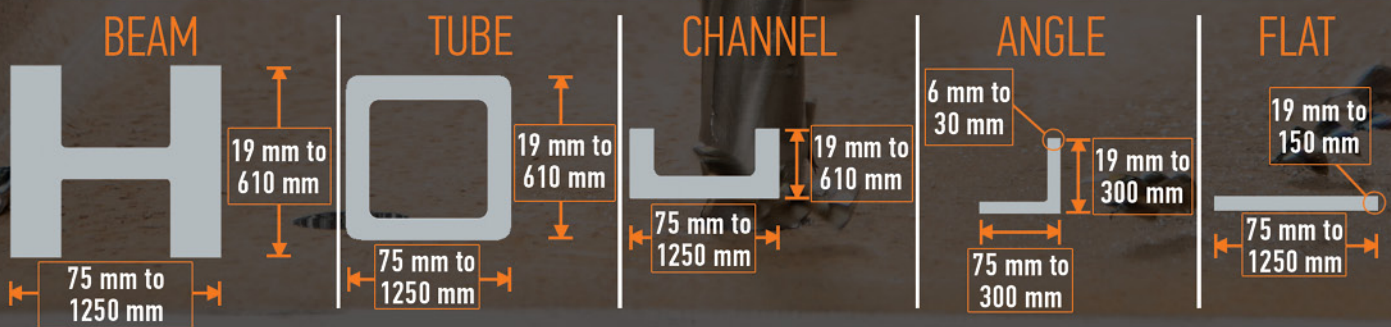
Please visit www.peddinghaus.com for a “video test drive” and additional technical details on the BDL-1250/9D. Or, plan a visit to the Peddinghaus manufacturing campus at our headquarters in Bradley, IL USA. See the depth of our organization, and our commitment to your success with world class customer support.



Carl G. (Anton) Peddinghaus | Chief Executive Officer | Peddinghaus Corporation

Ideal for Processing Structural Steel in an Array of Applications Including:

- Steel Building Components (floor beams, columns, etc.)
- Wind Tower Components
- Joist Components
- Sign Structure Components
- Truss Components
- Girder Components
- Mining Equipment Components
- Aggregate Handling Components

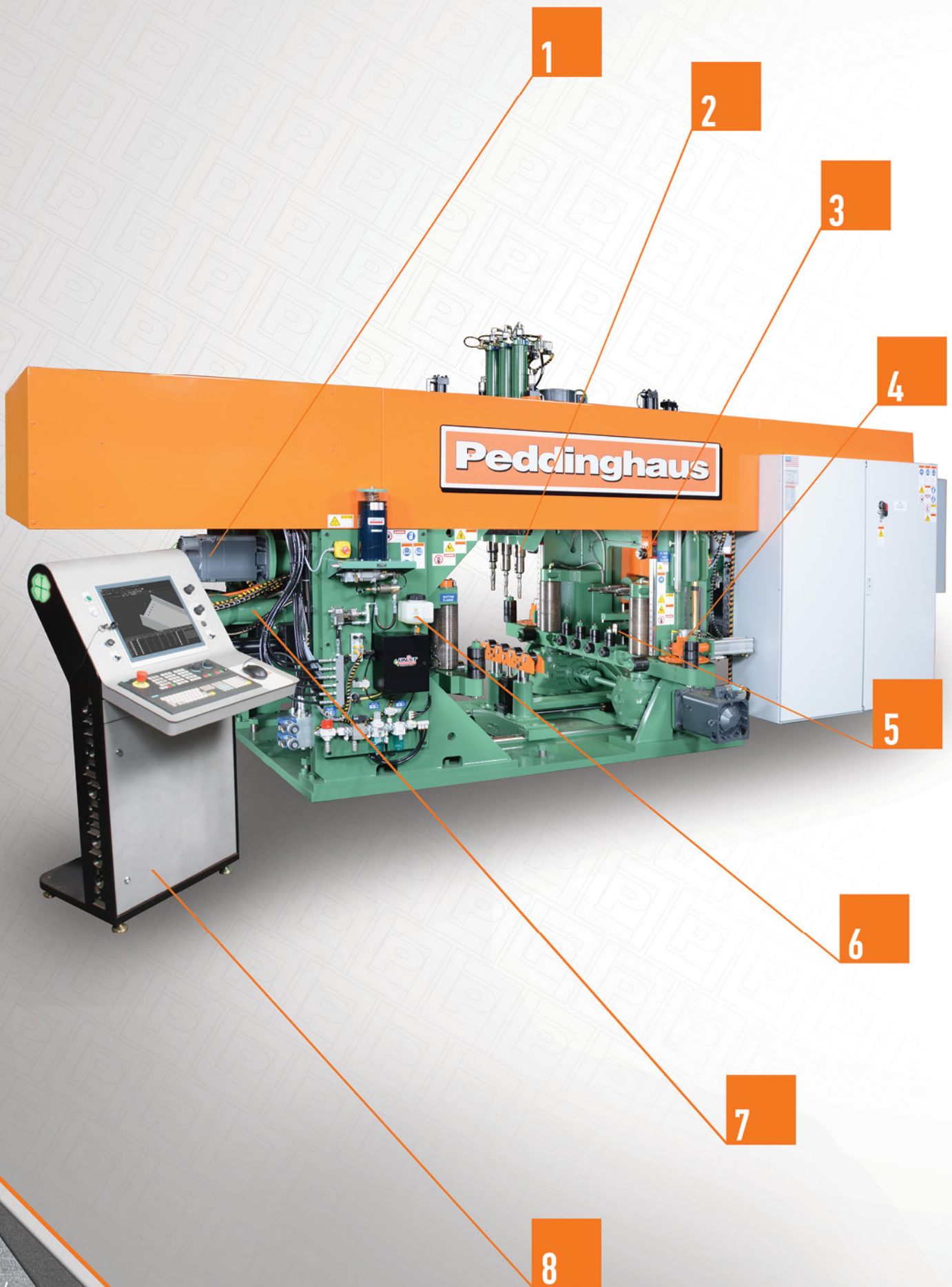


Maximum length is dictated by a maximum material weight of 19,867 kg. Machine is rated for sections up to 1,260 kg per m

Technical Specifications

Maximum Section Width	1,250 mm
Minimum Section Width	75 mm
Maximum Section Height	610 mm
Minimum Section Height	19 mm
Maximum Section Weight	19,867 Max kg
Spindle Power	18.6 kW
Spindle Speed	145 - 1800 RPM
Number of Spindles	9
Maximum Hole Size	50 mm

The Undisputed Leader in Productivity





1 POWERFUL SIEMENS SPINDLE MOTORS

- High speed 18.6 kW Siemens spindle specific motors power each of the nine drill spindles of the BDL-1250/9D
- The high torque motors of the BDL-1250/9D provide maximum efficiency when paired with carbide tooling technology



2 NINE SPINDLE DRILLING

- The BDL-1250/9D is equipped with nine spindles - three in each of the drilling axes
- The nine spindle design provides the ability to process up to three different operations on material surface without the need to change tooling, greatly increasing processing productivity



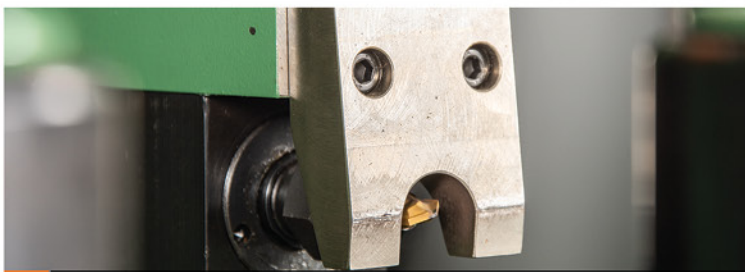
3 UNMATCHED CLAMPING

- The BDL-1250/9D achieves optimum guidance of the workpiece through the machine
- Employs 4 vertical hold-downs and 4 knurled horizontal clamp rollers
- Equipped with an underside material clamp which stabilizes and supports the web on larger sections of material during the drilling process



4 ROLLER FEED MEASUREMENT

- Roller measurement with automatic height control provides paramount accuracy and unmatched versatility
- Material handling can be placed outside in any climate to free shop space for other processes such as welding and fit-up



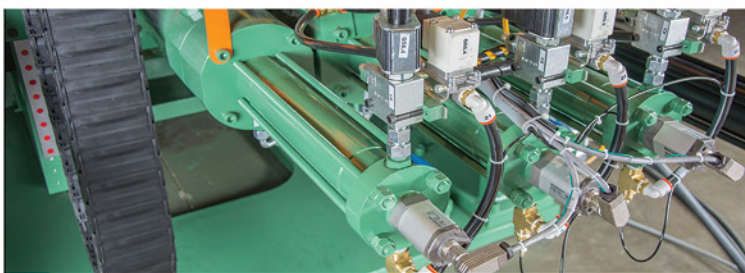
5 MULTI-AXIS CARBIDE SCRIBING

- The BDL-1250/9D is capable of scribing any character or shape in multiple orientations
- Additional scribing is possible in each of the three spindle axes as well as the underside of a profile



6 MINIMUM QUANTITY LUBRICATION (MQL)

- 97% air, 3% eco-friendly vegetable oil-based lubricant
- Eliminates flood coolant mess
- No need to clean parts for painting or other fabrication processes



7 COMPLETE POSITIONING FEEDBACK

- Each of the spindles of the BDL-1250/9D are equipped with comprehensive positioning feedback
- Positioning feedback allows for tapping, countersinking, Smart Spindle II short stroke drilling technology and consistent drill feed for improved tool life



8 PEDDINGHAUS CONTROL

- Robust and intuitive user interface
- Siemens 10 year spare parts guarantee
- Allows for modern remote assistance and web cam technology for fast and painless troubleshooting



CHAMPION

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Peddinghaus

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363

Unmatched Productivity

Multi-Spindle Drilling

Continuous production can be stifled when frequent tool changes are required. The BDL-1250/9D comes standard with a three spindle drilling unit in each drilling axis, eliminating the need to change tooling in programs with up to three hole diameters. The three drill assemblies on the BDL-1250/9D operate simultaneously or independently of one another using either the same or different drill diameters, speeds and feeds. Fully programmable via CNC program, spindle operation is designed with carbide drilling in mind, allowing for some of the fastest drilling times on the market.

High Speed Carbide Drilling

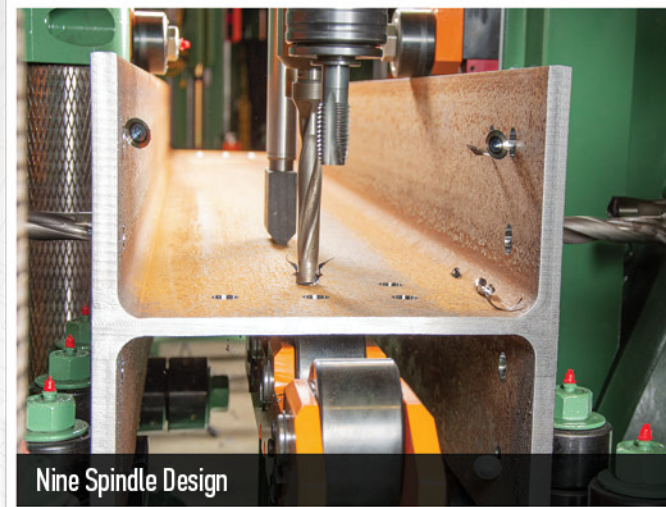
Combining sophisticated Siemens electronics, heavy duty carbide drilling and superior feedback, the BDL-1250/9D drill spindle is both versatile and efficient. The drill assemblies of the BDL-1250/9D employ 18.6 kW Siemens servo motors. These spindles boast a speed range of 145-1800 RPM. The exceptional strength of the BDL-1250/9D spindles allow for faster processing times in drilling, tapping, countersinking and scribing using carbide tooling.

The sheer throughput of the BDL-1250/9D is perfect for fabricators processing the heaviest sections. Columns in excess of 1086 kg/m are continually executed with ease on this one-of-a-kind system. Proven to process an average of 200 plus tons of structural steel per week, the BDL-1250/9D proudly serves some of the world's largest fabricators.

Smart Spindle II Technology

The Peddinghaus Smart Spindle approach reduces overall operating time by finishing every hole in a profile as quickly as possible. Not all material is perfect. Flanges can be toed in, toed out or simply rolled at various thicknesses; this is the nature of structural steel. By collecting data including all pertinent dimensions of material and tool length, machine motions are optimized using Smart Spindle II technology.

Smart Spindle drilling technology begins by rapidly approaching the material, probing against the material if the length has not already been established. The tool then retracts, spins in open air and samples air drilling torque. As the machine enters drilling speeds and feeds, hole creation begins. Upon breakthrough of the material, the machine senses a drop in torque similar to the air drilling reading. The tool then retracts rapidly and advances to the next hole in the pattern.



CHAMPION
Street

CHAMPION

Peddinghaus



Modular Designs

The Peddinghaus Way

Easily Integrate into an Existing Layout – Modular Design

The Peddinghaus Roller Feed material measurement system allows for an array of material handling options. Peddinghaus conveyors can be quickly expanded, split apart, transferred across to another conveyor and modified with no sacrifice in machine accuracy or functionality.

Minimize Footprint – Store Material Handling Outdoors

Peddinghaus' Roller Feed design makes it easy to place material handling outdoors. In addition to saving shop space, this innovative method eliminates unnecessary crane handling that inhibits other operations inside of the shop. Easily unload delivery trucks outside, and load conveyor without slowing other portions of production.

Your Resource for Superior Shop Flow

Shop layout and material handling efficiency is paramount for cost savings. Every time a profile is handled with a crane, profits are lost. This unnecessary shop cost not only slows the productivity of other processes, but creates unneeded work related hazards. With the help of Peddinghaus' seasoned layout engineers and systems personnel fabricators learn the secrets to shop floor success without experiencing the pitfalls of poor layout and planning.

Band Saw Integration

The BDL-1250/9D drill line with its powerful material handling support, meticulous measurement capabilities and high speed designs is suited for tandem operations with an array of band sawing solutions. High speed carbide drilling combined with Peddinghaus' miter cut and straight cut band saws can accommodate your production needs.

AccuMeasure System

If you are looking for maximum throughput, saw tandem systems may not fit your production ideally. Splitting apart a drill and a saw allows neither machine to wait on the other, maximizing production. Saw measurement options are available via the Peddinghaus AccuMeasure Roller Feed measurement system. The AccuMeasure allows for complete handling versatility, while maintaining a streamlined CNC solution. Available for all Peddinghaus automatic band saws, the AccuMeasure is the ideal complement to a complete Peddinghaus system.



Modular Configurations



Minimize Footprint



Band Saw Integration



AccuMeasure Roller Feed

Peddinghaus Software

Raptor from Peddinghaus is today's premier structural machine tool 3D CAD/CAM platform. Equipped with versatile modules to import, modify, inspect, create and export part programs, Raptor is fully customizable to fit the unique needs of the individual fabricator.

3D Module – Modify, Inspect, Create

The core of Raptor is the 3D Module. If part data has been imported into Raptor, the 3D Module works as an inspection tool and is capable of modifying imported part information. If part files need to be created, the intuitive design and user-friendly interface of the 3D Module allows for powerful programming options.

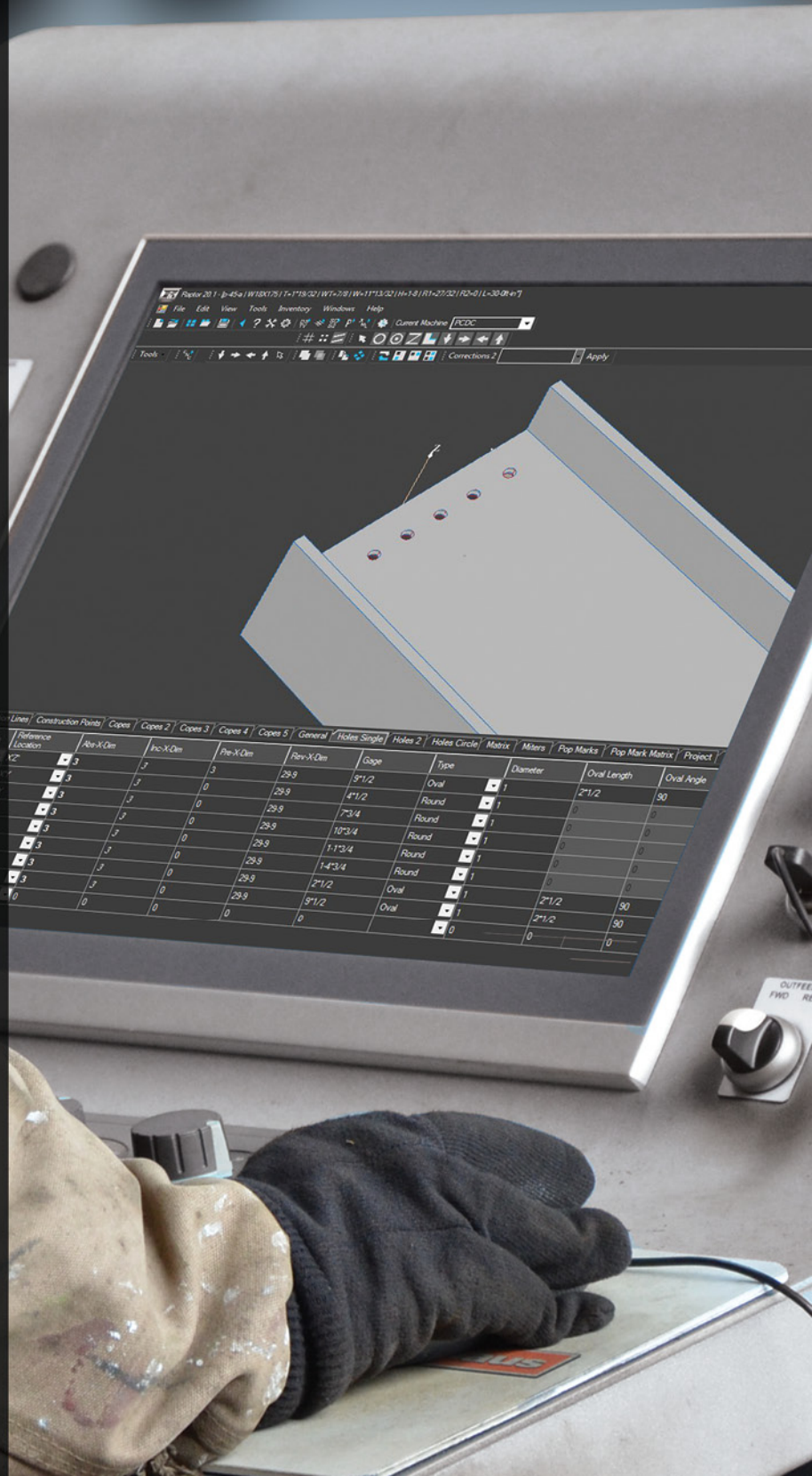
Tekla API Import Module

The Tekla API Module allows for the direct importation of Tekla part files into Raptor software, eliminating the need to convert to an intermediary file type.

By referencing part data with the Tekla BIM model, Raptor's Tekla API Module is capable of generating scribe marks and weld locations based on the model's original geometry. Using Raptor's Tekla API, Peddinghaus Bridges the gap between design and fabrication. This is ideal for machines utilizing 4-axis layout marking.

DSTV Import Module

Raptor integrates with popular Building Information Modeling (BIM) software programs capable of generating the common file standard – DSTV. DSTV files are imported into Raptor software for editing or for CNC file creation. Commonly used BIM programs include SDS/2 by Design Data, Tekla Structures, Graitec and more.



Peddinghaus Software

Linking Design to Fabrication

DSTV Export Module

Raptor is capable of exporting part information into a DSTV file format (including scribes, copes, pop-marks and holes). All enhancements or corrections applied within Raptor are included within the exported DSTV file using this module. The DSTV export module brings the power of Raptor to third party CNC machinery that can import files of this type.

iDSTV+ and DSTV+ Import/Export Module

Select MRP systems are capable of exporting batch nested files in a format known as DSTV+ and iDSTV+. These file types play an important role in the automated development of cut sheets for production. Raptor is capable of importing and exporting these DSTV+ and iDSTV+ files for production on equipment. This eliminates the need to manually batch nest files, which have already been batch nested within third party MRP platform.

Peddimat Import and Export Module

The Peddimat Import and Export Module provides users with the ability to create new Peddimat files or utilize existing Peddimat files within Raptor. This option allows users complete flexibility in regards to legacy software compatibility.

PeddiTrack Parts Tracking Module

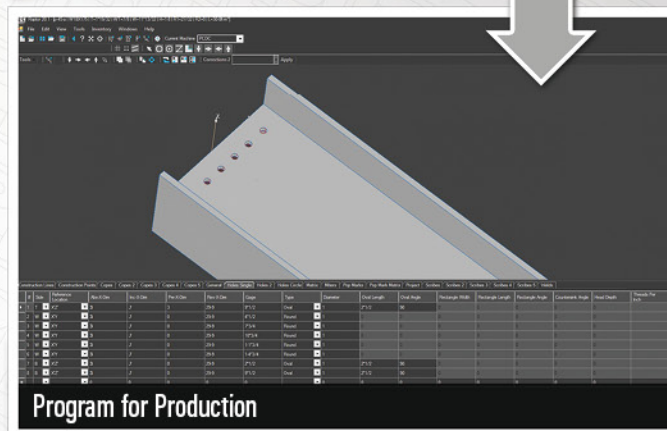
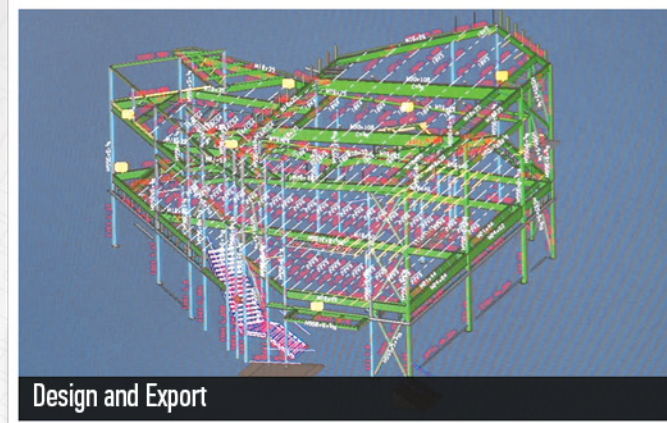
The PeddiTrack parts tracking utility is a module for monitoring the production of parts on Peddinghaus machines using Siemens controls. PeddiTrack works in the background of the CNC control creating output files that display vital information regarding part production.

The Peddimat Legacy Export Module

- Documentation of production
- Potential to view progress remotely
- Ability to monitor employee productivity
- Elimination of human error in the production monitoring process

Raptor Software Modules

IMPORT	Tekla API / DSTV / DSTV+ iDSTV / iDSTV+ / Peddimat
MODIFY / INSPECT / CREATE	3D Module
EXPORT	Post Processor / DSTV / DSTV+ iDSTV / iDSTV+ / Peddimat





*SteelFab installs a 6th BDL-1250/9D drill line at their Charlotte, North Carolina Plant.
Photo Credit: Russell Barngrover*

BDL-1250/9D User Testimonials

SEVERFIELD (UK) LTD.
Dalton, North Yorkshire - United Kingdom



"I would say all of the machinery has been crucial to our operations but if one stood out for me, it would be the BDL-1250/9D drills. I'm used to seeing drills that take a considerable amount of time. I've seen our process sped up three-fold by using the new BDL; the drilling speed is phenomenal."

– Wayne Barron, Production Director

STEELFAB
Charlotte, North Carolina - USA



"Since our very first Peddinghaus drill back in the early 80s we knew we had a winner. Without reliable equipment, we could not meet the demands of our customers. The BDL-1250/9D has become the backbone of meeting those demands. In fact, we currently use 17 of them throughout our 7 locations. Most run around the clock six days a week. SteelFab, Inc values the relationship formed so many years ago and without Peddinghaus providing the equipment, our growth would not be where it is today."

– Russell Barngrover, Executive Vice President

HASLINGER STAHLBAU GmbH
Feldkirchen - Austria



"The BDL-1250/9D drill line allows us to drill 70 mm holes in a matter of seconds, which was impossible on our previous drill lines. This machine is excellent for both heavy and small steel fabrications, giving us the advantage to produce more tonnage compared to our competitors using older technology."

– Andreas Tiffner, Machine Programmer and Coordinator

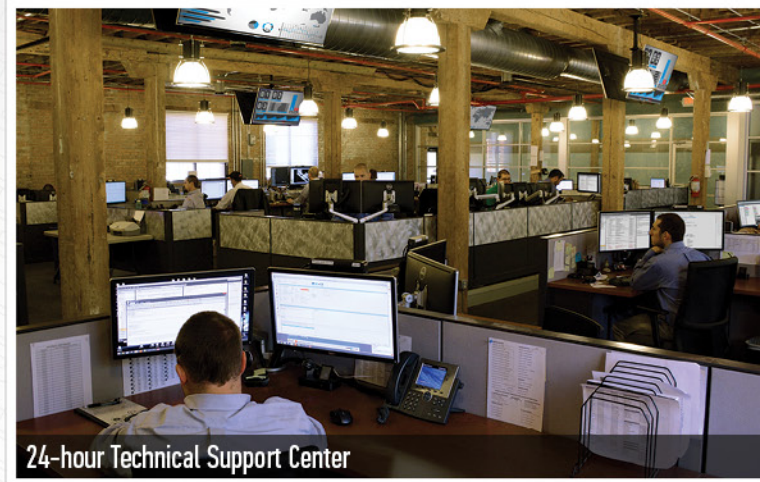


The Best Support in the Industry

Peddinghaus strives to provide an unparalleled level of service for industry partners, no matter where in the world they are located. This is done by offering the only 24-hour technical support center in the industry and employing an expansive team of field service technicians throughout the globe.

24-hour Technical Support Center

Located in Bradley, Illinois - USA, Peddinghaus maintains a 24-hour technical support center to assist customers with any questions or concerns that may arise in the operation of Peddinghaus machinery. Service technicians leverage remote diagnostic software as well as web cameras in order to troubleshoot questions. Over 95% of telephone calls are resolved without the need for an on-site visit from a Peddinghaus technician.



24-hour Technical Support Center

Global Access to Spare Parts

Peddinghaus maintains vast amounts of spare parts at their North American locations and are in close proximity to major ports and shipping hubs. For international partners, local spare parts storage is maintained at our sales and service offices around the globe. In addition, local dealer representatives and dedicated parts storage facilities have been established throughout the world to expedite part shipments. This means faster delivery of parts when they are needed.



50+ Field Service Technicians

Expansive Team of Field Service Technicians

For advanced issues, over 50 field service technicians are employed by Peddinghaus throughout the world. Technicians are conveniently located geographically and may be based out of an office near your installation. These technicians operate globally and are available for on-site assistance.



PeddiUniversity Training Center

World Class Training for Maintenance Staff, Operators and Programmers

Peddinghaus offers training on-site, over the internet and at their corporate headquarters for maintenance staff, operators and programmers. Training at Peddinghaus' global headquarters is free of charge for those willing to make the trip and provides staff with direct access to the masters behind the machinery.



Peddinghaus

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