THE BDL-1250/9D CARBIDE DRILL LINE

BDL-1250/9D

BIGGER • FASTER • STRONGER

Dear Industry Partner,

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. When fabricators ask me about the production of this machine, they are shocked as I describe a drill line capable of processing over 200 tons of steel in a 40 hour work week. Trust me, this is reality! To prove it, here are just a few statements from fabricators who have employed this machine within their production process:

- *"The BDL-D is five times faster than our previous drill for the heavy industrial work we process. On a single project running two shifts we had 120 tons of steel pass through that drill in a twenty four hour period! Nobody touches that capacity."* ***– Tony Dean, Structural Steel Services, Meridian, Mississippi - USA***
- *"We're now drilling 5" (127 mm) flanges on W14x730 beams in about 39 seconds compared to 2 minutes with our previous drill. We have seen as much as a 50% increase in overall production throughput since it's installation."* ***– Russell Barngrover, SteelFab, Charlotte, North Carolina - USA***
- *"It is a great machine. It is fast and rugged. We estimate a 40% increase in productivity because of its speed, Smart Spindle drilling technology and its rugged clamping design. With the addition of the BDL-D we have no limit on capacity."* ***– Gene Grossi, Jr., Samuel Grossi & Sons, Bensalem, Pennsylvania - USA***
- *"We are producing holes now in 2-3 seconds compared to 9-10 seconds. The productivity speaks for itself, and gives us the edge against competitors using older technology."* ***– Rob Wright, Waiward Steel Fabricators, Edmonton, Alberta - Canada***

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.

Carl G. "Anton" Peddinghaus
Chief Executive Officer - Peddinghaus Corporation

BDL-1250/9D

BDL-1250/9D	Inch	Metric
Maximum Section Width	50"	1250 mm
Minimum Section Width	3"	75 mm
Maximum Section Height	24"	610 mm
Minimum Section Height	3/4"	19mm
Maximum Section Weight	43,800 Max lbs	19,867 Max kg
Spindle Ho rsepower	25 HP	18.6 kW
Spindle Speed	145 - 1800 RPM	145 - 1800 RPM
Number of Spindles	9	9
Maximum Hole Size	2"	50 mm
Machine Weight	32,430 lbs	14,710 kg

THE WORLD'S FASTEST DRILL LINE

The Undisputed Winner in Head-to-Head Comparisons

The Peddinghaus BDL-1250/9D Drill Line exhibits tremendous amounts of production power in a compact package. Designed for the world's heaviest production requirements, the BDL-1250/9D is the ideal machine for high throughput/high tonnage projects. When compared to other drill lines, there simply is no contest as the BDL-1250/9D consistently wins in head-to-head comparisons.

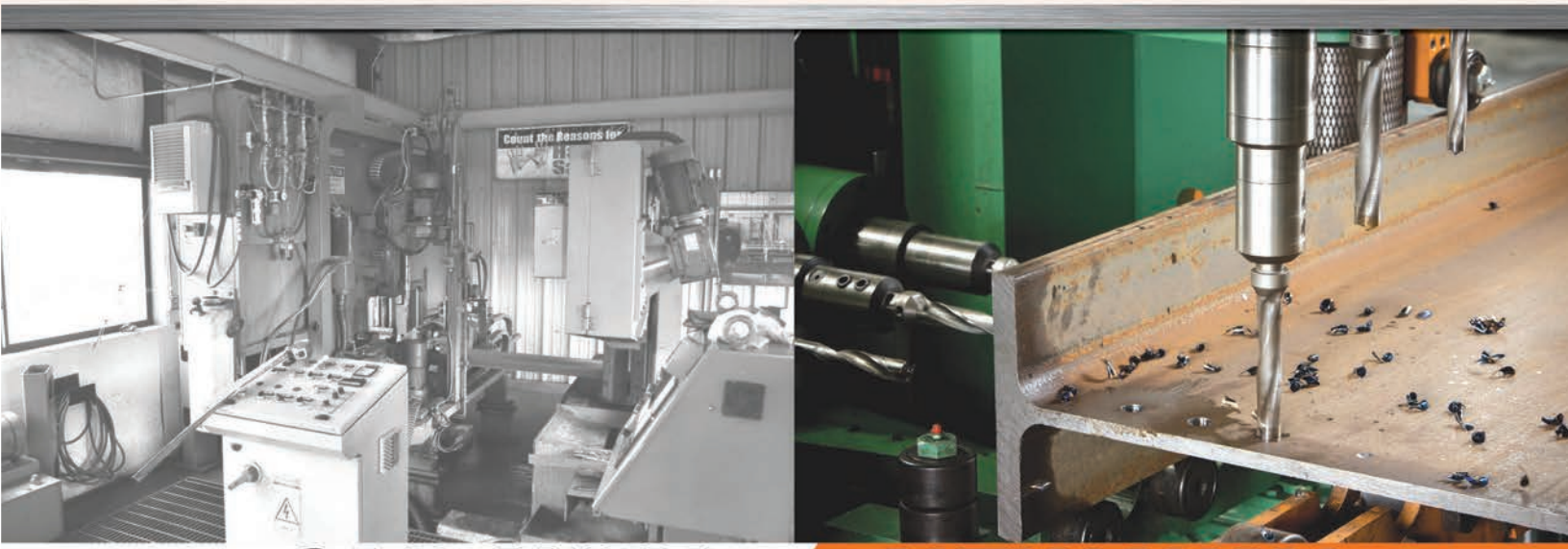
For fabricators looking to update existing systems to a modern and higher productivity solution, the BDL-1250/9D provides an incomparable efficiency advantage when compared to older drilling equipment due to its innovative technology.

The BDL-1250/9D provides everything a fabricator needs to tackle most diverse structural applications:

- Nine Spindle Carbide Drilling
- 4-Axis Layout Marking
- Tapping
- Countersinking
- Hard Stamping

WHAT'S THE DIFFERENCE? - OLD TECHNOLOGY vs. NEW TECHNOLOGY

	OLDER DRILL LINES	THE BDL-1250/9D
Typical Tonnage Throughput	80 to 150 tons per week depending on machine	200+ tons per week
Tooling	Twist Drills	Carbide Tooling
4-Axis Layout Marking	Incompatible	Fully Compatible
Lubrication System	Water Based Mixture	Minimum Quantity Lubrication
Electronic Feedback	Unavailable	Complete Electronic Feedback
Software	DOS based	NEW Raptor Software



OLD WAY vs. NEW WAY

Increase Production, Increase Profitability

OLD MACHINE	
Tonnage Capability Per Week	125
Selling Price per Ton (no coatings)	$2,000
Market Price Weekly Production (125 x $2,000)	$250,000
Profit Margin	3%
Profit Per Week ($250,000 x 3%)	$7,500
PROFIT PER 50 WEEK YEAR	**$375,000**

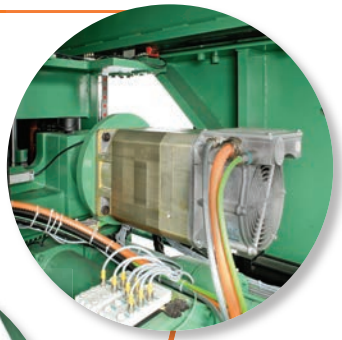
BDL-1250/9D	
Tonnage Capability Per Week	200 (or more)
Selling Price per Ton (no coatings)	$2,000
Market Price Weekly Production (200 x $2,000)	$400,000
Profit Margin	3%
Profit Per Week ($40,000 x 3%)	$12,000
PROFIT PER 50 WEEK YEAR	**$600,000**

EASILY EARN $225,000 MORE EACH YEAR

THE UNDISPUTED LEADER IN PRODUCTIVITY

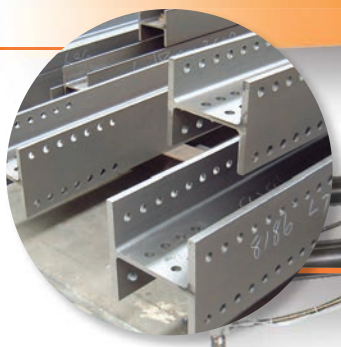
POWERFUL SIEMENS SPINDLE MOTORS

- High Speed 25 HP / 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.



COMPLETE POSITIONING FEEDBACK

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



THROUGH THE TOOL MINIMUM QUANTITY LUBRICATION

- Ecologically friendly minimum quantity lubrication is implemented on the BDL-1250/9D drill line.
- This vegetable oil based lubricant can utilize as little as 5% solution to 95% air when drilling. Parts leave the BDL-1250/9D nearly dry and ready for the next operation in the production process.

AUTOMATIC GREASING SYSTEM

- The BDL-1250/9D is supplied with a automatic greasing system as standard equipment for minimized maintenance.

UNMATCHED CLAMPING

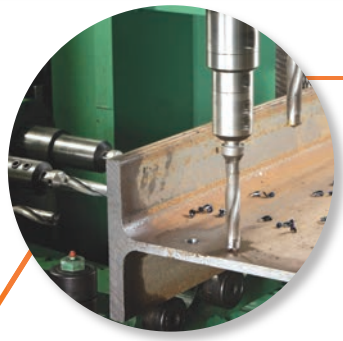
Carbide tooling requires superior structural clamping to maximize tool life. The BDL-1250/9D provides a comprehensive clamping system which includes:

- 2 Vertical web clamps
- 1 Heavy duty underside web clamp/support
- 4-point vertical flange clamping system
- Oversized pinch and drive rollers
- Z-Tower Braking System
- Heavy duty cam rollers for underneath and horizontal surface clamping

MULTI-AXIS CARBIDE SCRIBING

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

4 Axis Scribing

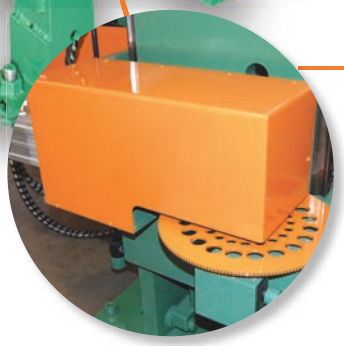


NINE SPINDLE DRILLING

- 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 3 different operations on material surface without the need to change tooling, greatly increasing processing productivity.

SIEMENS ELECTRONICS

- Peddinghaus machines utilize the leading electronics provider, Siemens, for controls, drives and more.
- Siemens components come standard with a 10 year parts availability guarantee.

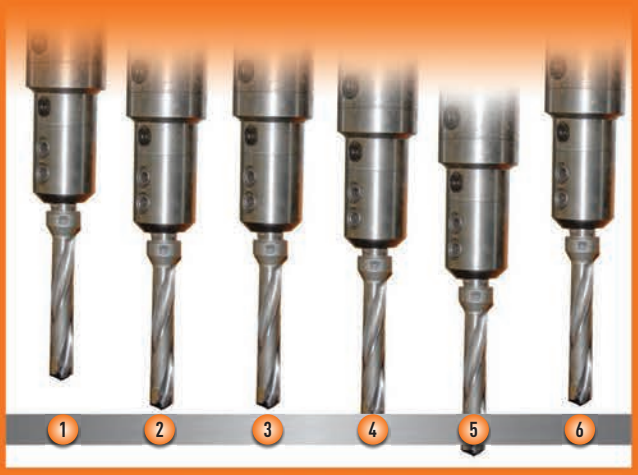


ROLLER FEED MEASUREMENT

- 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.

PATENTED SMART SPINDLE II

Don't guess at drilling operations; finish every hole in a profile as quickly as possible using the Peddinghaus Smart Spindle approach. Not all material is perfect; flanges can be 'toed in', 'toed out' or simply rolled at a varied thickness, this is the nature of structural steel. Before drilling, data is collected to distinguish all dimensions involved, and Smart Spindle II Drilling takes place.



1. Rapid approach
2. Tool probes against material if length is not already established
3. The tool then retracts, spins in open air, and samples 'air drilling' torque
4. Machine enters drilling feeds/speeds and begins hole creation. 90% through theoretical thickness of material (thickness material is supposed to be) the drill begins to monitor spindle torque again
5. Upon breakthrough of material, the machine senses a drop in torque similar to the 'air drilling' reading
6. Tool is rapidly retracted and advances to the next hole in a pattern

UNMATCHED PRODUCTIVITY - CARBIDE DRILLING

The BDL-1250/9D Beam Drill Line has proven to be the highest tonnage drill line available on the market today. The sheer throughput of the machine is perfect for fabricators processing the heaviest sections. Columns in excess of 1,000 kg / Meter (730 lbs/ft) 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.

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 from either side (datum or non datum) 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.

Carbide Drilling

Versatile Installations

Modular Configurations

Peddinghaus Layout Engineers

PEDDINGHAUS' RAPTOR CAD/CAM PLATFORM

Raptor software from Peddinghaus is today's premier structural machine tool CAD/CAM platform. Equipped with versatile modules intended to import, design, and export part programs, Raptor is fully customizable for the unique needs of the individual fabricator.

THE DSTV IMPORT MODULE

Raptor seamlessly integrates with popular Building Information Modeling (BIM) platforms capable of generating DSTV files using the DSTV Import Module. Commonly used BIM platforms include SDS/2 from Design Data, Tekla Structures, StruCad, SteelOffice, Graitec and more.

THE 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 into an intermediary file type.

By referencing part data within a Tekla BIM model, Raptor's Tekla API module is capable of automatically generating scribe marks, and weld locations based on the model's original geometry. Using Raptor's Tekla API, Peddinghaus bridges the gap between design intent and final fabrication. This is ideal for machines which utilize 4-Axis layout marking hardware.

THE 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 information. If part files need to be created, the intuitive design and user friendly interface of the 3D Module allows for powerful programming options.

THE PEDDIMAT LEGACY EXPORT MODULE

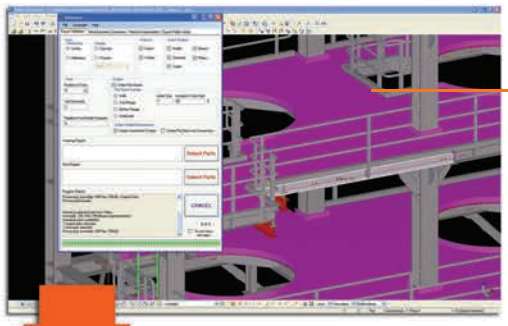
The Peddimat Legacy Export Module provides users the opportunity to create Peddimat files using Raptor. This export option allows users to develop part programs for operation on legacy machines that do not have a Raptor post processor, or do not have an active license of Raptor present at the control.

RAPTOR SOFTWARE MODULES

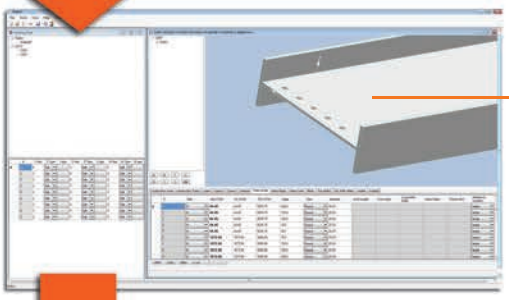
IMPORT	TEKLA API MODULE	DSTV MODULE
MODIFY INSPECT CREATE	3D MODULE	
EXPORT	RAPTOR POST PROCESSOR / PEDDIMAT EXPORT MODULE	

RAPTOR SOFTWARE

LINKING DESIGN TO FABRICATION



Design and Export



Program For Production

Process and Fabricate

SAMUEL GROSSI & SONS - *Bensalem, PA - USA*

"A few words about the new Peddinghaus BDL-D nine spindle drill line: it is a fast, rugged – simply great machine which has dramatically increased our shop throughput.

We estimate it can increase our throughput by 40% because of its speed, Smart Spindle drilling technology, and its rugged clamping design. There is no steel job or project out there that we cannot do."

– Gene Grossi, Jr., Vice President of Engineering

BILLINGTON STRUCTURES LIMITED - *Barnsley, UK*

"We were able to increase our carbide speed and feed rates to 10% above those we set on our other modern carbide drill line, and also 30% above that of the tooling manufacturer's specification while still preserving tool life. The machine does an amazing job eliminating vibration and maintaining high speeds and feeds."

– Kevin Campbell, Production Director

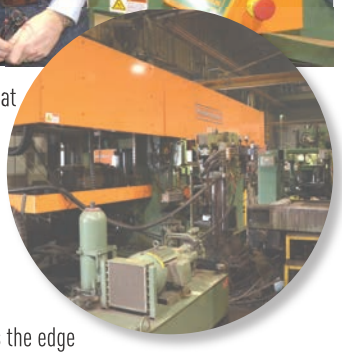
KOSTAS LIAROMATIS - *Patros, Greece*

"Using the BDL-D drilling machine we are capable of drilling our thickest materials 10% to 100% faster than ever before depending on how large the material is. The thicker the material, the greater the benefit. Tool life is outstanding as well with this machine, providing over 1,500 holes per carbide insert. On top of the speed, the reliability is outstanding. The Peddinghaus machines are wonderful for spare parts and service." ***- John Liaromatis, Principle***

NOVEL IRON WORKS, INC - *Greenland, NH - USA*

"We purchased the new Carbide drill model BDL-D from Peddinghaus, and we can honestly say this new drill line has increased our overall production and through-put capability by 40%. We investigated all the other "carbide drill lines" on the market, and I can tell you that Peddinghaus has got it right. They know drilling, and this machine has everything it takes for high speed production. The frame is powerful, and multiple clamping systems are used on the machine to insure the drill never "chatters". The Peddinghaus Carbide drill BDL-1250/D is the fastest thing on the planet for drilling steel: Peddinghaus engineers nailed this one." ***– Bill Gallant, Plant Manager***

WAIWARD STEEL FABRICATORS, LTD. - *Edmonton, AB - Canada*



"If you look at the carbide drilling technology that we employ on our BDL-D drill line and our two HSFDB plate processing machines - it is hard to imagine where we would be, if we had not pursued the latest technologies. We are producing holes now in 2-3 seconds compared to 9-10 seconds.

The productivity speaks for itself, and gives us the edge against competitors using older technology. It is all about producing a quality product faster and more accurately. A quality product remains the benchmark in today's competitive market." ***– Rob Wright, Shop Operations Manager***

STEELFAB, INC. - *Charlotte, NC - USA*

"At SteelFAB we are now drilling 5" (127 mm) flanges on W14x730 beams in around 39 seconds compared to 2 minutes with our previous drill. The BDL-1250/9D is consistently 50% faster than other drilling machines on the market today." ***– Russell Barngrover, Vice President and Plant Manager***

"I remember when landing a 1,000 ton job was a big deal, now we process 1,000 tons in a week! It's amazing what our machines have done for our capabilities in meeting short deadlines and keeping costs down." ***– R. Glenn Sherrill Jr., President/COO***

STEEL SERVICE CORP. - *Jackson, MS - USA*

"Our BDL-1250/9D drill line saves us the most time and money of all of our equipment. The drill lines used to be a bottle neck in our production, and with the addition of this new machine we have difficulty feeding our 2 drills. Every time we have added a Peddinghaus machine we have increased production, no question about it, and the BDL-D is a great example of that."

– Terry Bellis, Maintenance Manager

STRUCTURAL STEEL SERVICES, INC. - *Meridian, MS - USA*

"The BDL-D is five times faster than our previous drill for the heavy industrial work we process. We had one specific job with 350 columns over 500 lbs per foot. These sections were 20 tons per piece! The machine was processing 3 pieces per shift. On two shifts we had 120 tons of steel pass through that drill in a twenty four hour period! Nobody touches that machine."

– Tony Dean, Owner

ON CALL. ON DUTY. ALL THE TIME.

24/7 Service and Support from Peddinghaus

24 HOUR CUSTOMER SERVICE

The Peddinghaus state-of-the-art Service Center continues to grow to serve you even better - and is now available 24 hours a day!

- 60+ trained traveling field service technicians for on site assistance
- 20+ knowledgeable telephone technicians
- Complete training facility for operators and programmers

WEB CAM TROUBLESHOOTING

Each of Peddinghaus' machines are shipped with a simple to use web cam and software. Peddinghaus technicians can view mechanical questions from anywhere in the globe using this latest in customer service technology.

MODERN REMOTE ASSISTANCE

Peddinghaus' 24 hour tech support center is equipped with modern remote assistance technology. This allows Peddinghaus technicians to remotely diagnose machine questions or issues from anywhere in the globe. With the flexibility of the powerful Siemens control and modern remote internet software, Peddinghaus technicians can view the control screen of a machine in question with ease. Nearly 90% of service issues can be solved without the need for a service visit using this technology.

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QUALITY • INNOVATION • SUPPORT

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