

THE **HSFDB-B** HEAVY PLATE PROCESSOR



1800/2500

B I G G E R • F A S T E R • S T R O N G E R



Peddinghaus



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 HSFDB Plate Processor - More Than Just a Machine.

If you're using a burn table you have already experienced how much labor, floor space, and cost is involved with processing plate. In the world of Peddinghaus we develop solutions that provide twice the production of a burn table system. Capable of drilling, tapping, countersinking, plasma/oxy-fuel cutting, part marking, milling, and more; the HSFDB is already installed in numerous shops throughout the world. Whether it's structural components, or manufactured parts, the HSFDB does it all.

In today's world how do you compete when steel can be bought and sold at close to the same price as your competitors? You must minimize the cost to fabricate! The HSFDB can process parts at unbelievable speeds, averaging 1 Ton per hour of plate up to 25 mm thick, and an impressive 2 Tons per hour of plate thicker than 25 mm. Combine this with scrap ratios as low as 5%, using a single operator, in half the floor space of a standard burn table machine. You can quickly see how this method of processing plate is twice as efficient as old fashioned burn table technology. The HSFDB is more than just a machine, it is a solution to cut costs, increase profits, and succeed in today's globalized business climate.

I invite you to take a moment to learn what this machine has done for Peddinghaus customers in all corners of the world. I think you will be impressed with what you discover.

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 HSFDB. 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 "Anton" Peddinghaus
Chief Executive Officer - Peddinghaus Corporation



IDEAL FOR PROCESSING HEAVY PLATE IN AN ARRAY OF INDUSTRIES INCLUDING:

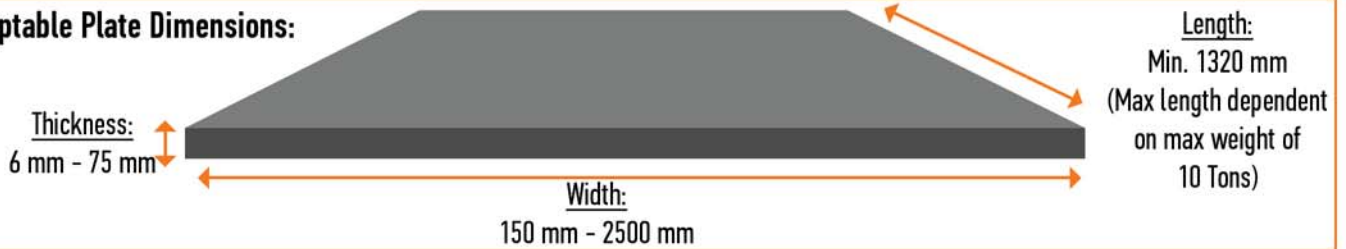
- Structural Steel Fabrication
- Tower Fabrication
- Bridge Fabrication
- Heavy Industrial Fabrication
- Agricultural Manufacturing
- Machinery Manufacturing
- Steel Stockholders/Service Centers
- Ship Yards
- Tank and Vessel Manufacturing
- Food Processing Equipment Manufacturing

HSFDB-B



DRILL | MILL | TAP | COUNTERSINK | OXY-FUEL | PLASMA | LAYOUT MARK

Acceptable Plate Dimensions:



Technical Specifications

Maximum Material Width	1800 mm & 2500 mm Widths Available
Maximum Material Weight	10 Tons
Spindle Power	36 kW
Maximum Drilled Hole Size	75 mm
Spindle Speed	0-2250 RPM
Number of Available Tools in Tool Changer	8

NOTE: Maximum length is dictated by weight restrictions.

WHAT'S THE DIFFERENCE?

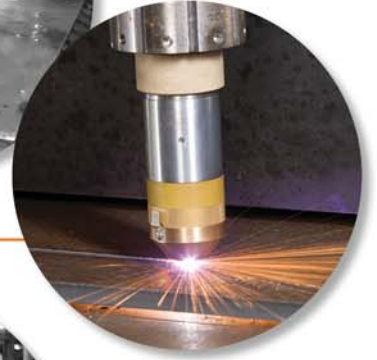
PLATE PROCESSING SOLUTIONS THAT SAVE YOU MONEY!

IMAGINE ONE MACHINE THAT CAN...

- Reduce material handling costs with one pass processing – load, process, unload
- Process plate with as little as 5% scrap
- Perform a variety of functions while taking up a minuscule amount of floor space
- Process 1 ton of plate per hour with only 1 operator
- Minimize the potential for human error by eliminating manual measurement



Old Way-Burn Table



New Way-Plate Processor



Old Way-Manual Labor



New Way-Automation

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

	OLD WAY-BURNTABLE	NEW WAY-HSFDB
Production	1/2 Ton Per Hour	1 to 2 Tons Per Hour
Labor	1 Operator, 1 Handler Minimum	1 Operator
Footprint	Large	Small
Material Handling	Completely Manual	Automated - Load, Process, Unload
Scrap	15-30% of Material	5-15% of Material
Drill Tool Life	Low - Damaged by Slats/Lack of Clamping	High - Ideal Clamping/Collision Free Drilling Zone
Torch Consumable Life	Low - Starts Torch for Each Hole/ Cannot Perform Edge Start	High - Chain Cutting/Common Cutting/ Edge Start Capable
Maintenance	High - Must Maintain Slats/ Remove Slag from Table	Low - No Slats/Scrap Cart and Plenum Chamber Integrated Into Machine



OLD WAY vs. **NEW WAY**

Save Money Using a Smarter, More Modern Approach to Plate Processing.

	BURNTABLE	HSFDB
Cost of 20 Tons of Plate/Week	\$20,000 per week \$1,000 per ton × 20 tons/week	\$20,000 per week \$1,000 per ton × 20 tons/week
Cost of 4 Tons of Scrap/Week	\$4,000 per Week on Scrap Alone Based on 20% Scrap Ratio × \$1,000 per Ton	\$2,000 per Week on Scrap Alone Based on 10% Scrap Ratio × \$1,000 per Ton
Cost of Scrap/Year	\$200,000 per Year \$4,000 per week for scrap × 50 weeks per year	\$100,000 per Year 2,000 per week for scrap × 50 weeks per year
COST	\$200,000 ANNUALLY	\$100,000 ANNUALLY

SAVE \$100,000 EACH YEAR

Twice the Capacity, Half the Labor

	BURNTABLE	HSFDB
Fully Loaded Cost for Workers	2 Workers at \$50/hr (Surveyed Average) 1 Material Handler, and 1 Machine Operator	1 Worker at \$50/hr (Surveyed Average) 1 Operator - Material Handling is Automated
Total Labor Cost per Hour	\$100 \$50/hr × 2 Workers	\$50 \$50/hr × 1 Worker
Number of Hours Each Year	2,000 Surveyed Average	2,000 Surveyed Average
Total Cost of Labor	\$200,000 2,000 Hours × \$100/hr	\$100,000 2,000 Hours × \$50/hr

SAVE \$100,000 EACH YEAR

TOTAL SAVINGS \$200,000



ANOTHER **INDUSTRY FIRST** FROM PEDDINGHAUS

AUTOMATIC TOOL CHANGER

- Rotary tool changer capable of holding up to eight tools
- Eliminates the need to manually change tooling during production
- Tool automatically selected upon program command



SIGNOSCRIPT CARBIDE SCRIBING

- Ideal for part numbering or layout marking
- Capable of marking any character or symbol at various depths and orientations



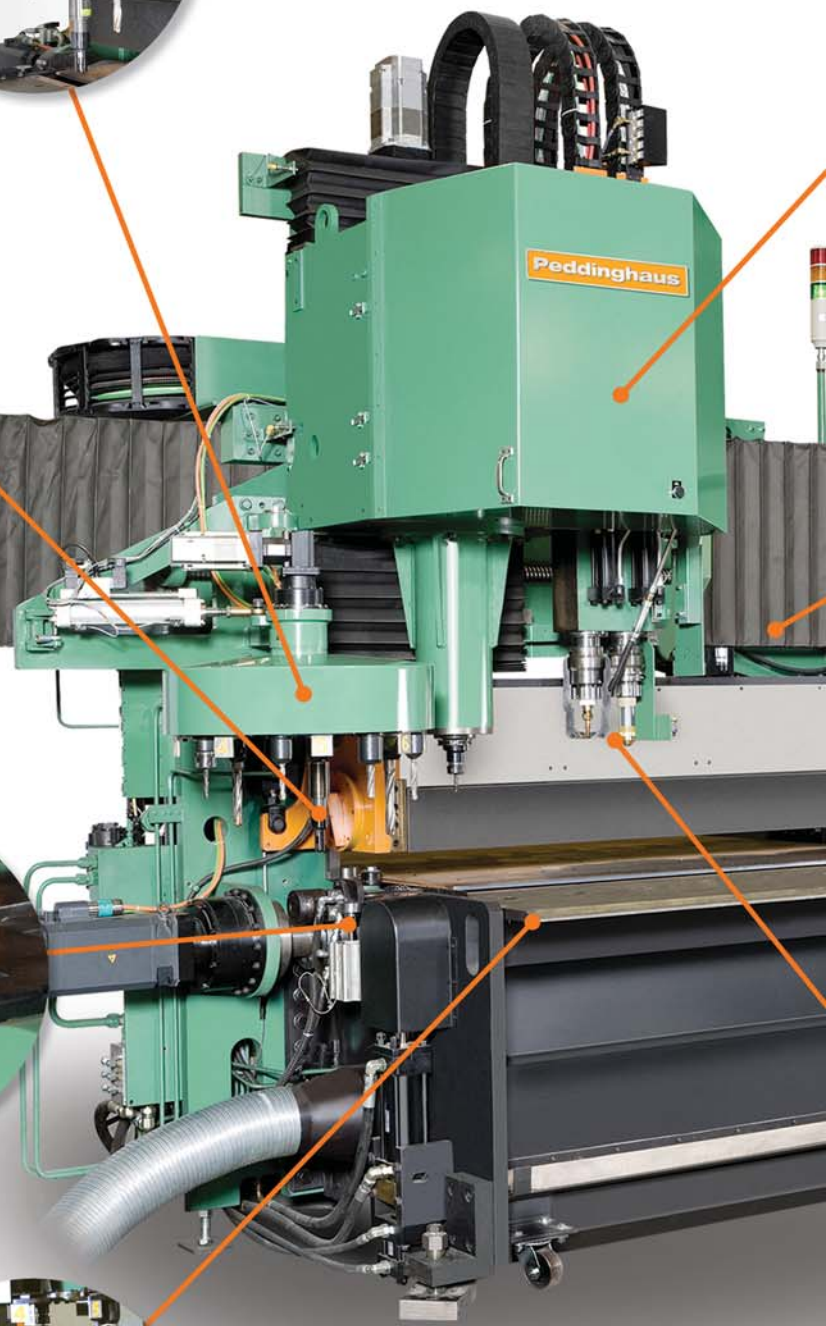
AUTOMATIC TOOL LENGTH MEASUREMENT

- Automatically measures tool length before using in operation
- Tool length is used during the Smart Spindle process, thus expediting production



PLENUM CHAMBER & DUMP TABLE

- Automatic dump table mechanism
- Parts up to 450 kg can be unloaded with ease
- Copper lined plenum chamber is integrated for easy removal/containment of machine byproduct
- Automatic parts handling options available





POWERFUL SIEMENS SPINDLE MOTORS

- High Speed 36 kW Siemens intelligent spindle motor
- Break-neck spindle speeds of up to 2250 RPM



THROUGH THE TOOL MINIMUM QUANTITY LUBRICATION SYSTEM

- 97% air, 3% eco-friendly vegetable oil based lubricant
- Eliminates flood coolant mess
- No need to clean parts before additional fabrication processes (welding, painting, etc.)



AUTOMATED MATERIAL DIMENSIONING

- Plate edge dimensions are detected by a contemporary laser probe system
- Plate thickness is determined by a transducer which is mechanically linked to the vertical clamping, and drive mechanism



ADVANCED SIEMENS ELECTRONICS

- Siemens 840D control panel
- Siemens drives, PLC, servo motors and more



OXY/PLASMA CUTTING

- High speed plasma: 260 or 400 amp plasma system are available
- Oxy-fuel cutting is available as cost effective and versatile alternative to plasma cutting

SPEED AND VERSATILITY COMBINED

The HSFDB is the ideal machine for detail fabricators and manufacturers alike. Equipped with the ability to drill, mill, tap, countersink, deburr, plasma cut, oxy-fuel cut, and layout mark using the latest in tooling technology, the HSFDB combines speed and versatility. The use of high speed carbide tooling, and the 8 station tool changer allows this machine to process plate in the most efficient way possible.

The streamlined flow of finished parts from stock plate to final assembly is just as critical as drilling, cutting, or other ancillary operations. Eliminate unnecessary manual handling with a Peddinghaus plate processing system. This provides unmatched efficiency in all aspects of operations.

MINIMIZE FOOTPRINT - FEED MATERIAL THROUGH AN EXTERNAL WALL

Peddinghaus' Roller Feed design makes it easy to place infeed conveyors 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 parts of production.

THE FRONT END UNLOADING SYSTEM

The Front End Unloader conveyor system is comprised of two roller transfer modules, each 1.8 M length, and a front end unloading belt. This is designed to streamline the handling of finished parts by conveying them from the operating area to a convenient unloading area. This option comes equipped with an automated retract system which allows for easy access to the operating area and scrap cart beneath the machine.

THE SIDE UNLOADING SYSTEM

The Side Unloader parts conveyor is designed to allow finished parts (up to 450 kg) to drop directly onto a hardened steel conveyor which delivers them to an ergonomic unloading height at the operator station. The Side Unloader conveyor option transfers parts while the machine is in continuous operation.

The side unloader integrated with two 1.8 M roller transfer modules facilitates the automated removal of both short and long parts. Smaller parts are unloaded directly onto the side unloader and delivered to the operator station. Longer components are removed by means of the roller transfer module. This option comes equipped with an automated retract system which allows for easy access to the operating area and scrap cart beneath the machine.



The Side Unloading System



The Front End Unloading System



NESTING SOFTWARE

The HSFDB proudly operates with many of today's modern nesting software solutions. These solutions allow fabricators to automatically batch nest existing files, edit on the fly, or create parts at the control console. There are no limitations to your programming needs!

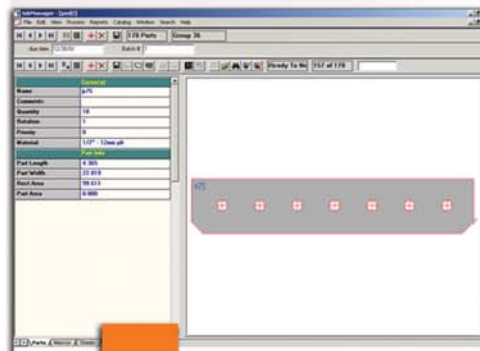
Using a wide array of software solutions, the Peddinghaus HSFDB is able to take full advantage of common cutline, chain cutting, and edge start cutting techniques.

SOFTWARE FEATURES FOR PEDDINGHAUS PLATE MACHINES:

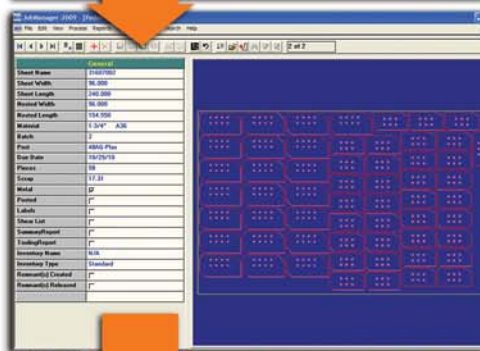
- Automatic Chain Cut Batch Nesting
- Automatic Common Cutline Batch Nesting
- Automatic Edge Start Batch Nesting
- End Milling Support and Automated Programming
- Face Milling Support and Automated Programming
- Remnant Inventory Management
- Automatic Remnant Nesting
- Automatic Pilot Hole Creation - Maximizes Consumable Life
- Customizable Program Macros
- Part within Part Automatic Nesting
- CAD solutions for at-machine program modifications
- Integrated Tool and Drill Management
- Automated Lead-In and Lead-Out Programming
- Integrated Material Database
- Inventory Management
- Production Tracking and Progress Reporting
- Nesting Report Tools which Include Time Estimates, Scrap Estimates, Cost Estimates, and More.
- Automatic Import of Multiple Common File Types which Include DSTV, DXF, etc.



PEDDINGHAUS SOFTWARE
LINKING DESIGN TO FABRICATION



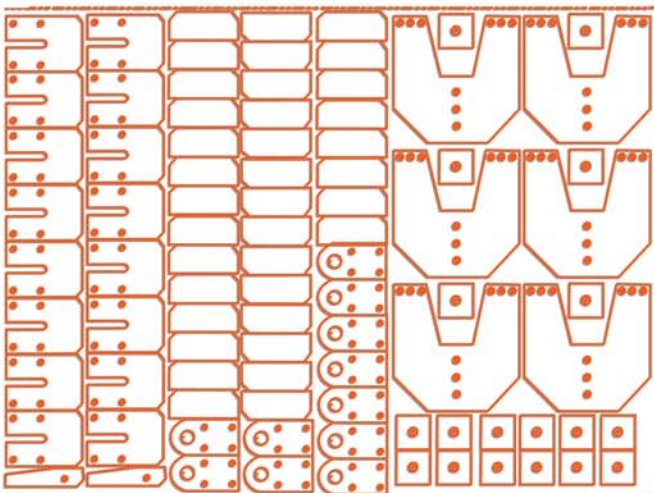
CAD Capabilities



**Automatic
Batch Nesting**



Process and Fabricate



HSFDB USER TESTIMONIALS

BALZER INCORPORATED - Mountain Lake, Minnesota - USA



"We have had other plate processing machines, most recently a punch plasma, and over time they simply needed replacement. Our materials grew from 6 mm to 13 mm thick as our products continued to grow in size. We went to an exhibition looking for a laser or similar machine and learned that the plate processor could do 90% more than any other machine on the market.

Before we had the Peddinghaus in our plant, we were outsourcing as much as \$80,000 of thick plate per month. Even after the outside processing, many of the pieces still required drilling and machining when they had returned to our plant. With the Peddinghaus we get it all. We can do tapping, counterboring, milling, drilling and cutting all in one step.

Floorspace also became a concern at Balzer due to how the company has grown. With the way we have setup our machine the material starts outside and passes through the wall to feed into the operating area. With the new machine we use at least 33% less space than our last plate machine and can do more processes as well."

- Lee Lidtke, Plant Manager

SPERLING INDUSTRIES - Sperling, Manitoba - Canada



"Our plate machine has become a great asset to our organization. It has such a wide variety of options, and is incredibly fast and accurate. We are now dealing with less scrap than we ever have before. With the nesting of the machine, we may see 5 - 10% scrap depending on the shape of parts being cut. The reason we went with Peddinghaus is because we don't have a large infeed material handling or outfeed material handling footprint. We liked the way it handled material and it kept a very small footprint in the plant.

The productivity of this machine has increased the options of our production tremendously within our organization. It's a one man operation with this machine. Once the plate is loaded outside the worker processes all of our connections and such when previously I had at least 5 people doing layout of plate parts, cutting, and trimming using manual processes. Our speed has easily increased 10 to 1 compared to before.

Our customers experience faster turnaround times, and higher quality/higher accuracy parts as a result of our Peddinghaus machines."

- Jeff Nicolajsen, Owner

DENCOL - Denver, Colorado - USA



"DenCol does a lot of work for a number of industries including mining, transportation, buildings, bridges, and a lot of other sorts of first stage fabrication using our Peddinghaus plate machines. We have one HSFDB-2500 plate machine, three FDB-2500 plate machines, and enough work to keep them busy 16 hours a day. We have one FPB-1800 (punching machine), and we run that 18 hours per day.

In the fabrication business you have an awful lot of material handling issues. The Peddinghaus equipment is very efficient because it has a pass through system. You can set material on roller conveyors, run it through the machine, drop the parts, and not have to deal with the unloading of a table system. The handling of the machines has been a great benefit to us, and add an efficiency to our company that burning tables can't offer.

Peddinghaus has helped us develop techniques to become more efficient, and we have showcased their equipment to demonstrate that the machines will indeed do what they say it will do. In the past 10 years, DenCol's relationship with Peddinghaus has allowed us to become a national supplier of first stage plate products, and we value their support."

- DeWayne Deck, Owner

WAIWARD STEEL FABRICATORS -

Edmonton, Alberta - Canada



"We initially purchased an HSFDB-1800, which is a 1800 mm bed, and we quickly we saw how fast that was for our plate production. When the 2500 mm version came on the market we were supposed to return our HSFDB-1800, but we couldn't part with our first machine so now we have both plate processors working in our shop.

We use edge start a lot, and we are able to put as many parts as possible on the sheet. Basically the only scrap created are some of the edges of the plate that need to be cut down so parts are the accurate shapes and sizes. Typically you get around 5% scrap depending on the parts you are processing.

We can go from 6 mm all the way up to 75 mm material, and drill up to 75 mm holes. We have had hardly any issues with the machine since it was installed five years ago - running 5 days a week, 24 hours a day."

- Robi Dosanj, Detail Foreman

CONTRACTORS STEEL CO. -

Livonia, Michigan - USA



"We have had a lot of traditional burning machines in our production. These machines can be retrofitted or upgraded to have a drill spindle included, but the machine isn't really designed for that. It almost seemed like the drill spindle was an afterthought. With the Peddinghaus HSFDB, the design starts with the spindle. It's a drilling machine that also is designed to cut, which means better performance."

-Dennis Blount, Special Projects Manager

"We had seen Peddinghaus before and knew lots of customers who had mentioned them. We understood they have a reputation for reliability, durability, and productivity. Using our Peddinghaus we are able to perform an array of functions and cut parts to shape, all in one machine. This is a lot more efficient, and a lot more profitable than before. The Peddinghaus has enabled us to create a better product for our customers, and get into different markets that we didn't have exposure to in the past."

-Marc Bokas, Jr, COO

WARRIOR MFG. -

Hutchinson, Minnesota - USA



"When we saw the Peddinghaus plate machine design we knew we needed one. Everything happens in one place on the Peddinghaus machine. There is no picking up parts and taking them to a separate station, which used to be common place in our production.

The machine eliminated four additional workstations within our shop. This means there are four people that are no longer spending their time processing plate, and can focus on other tasks such as welding, fit up, or painting. Not only does this make our production more cost effective, but our reaction time is second to none, giving us a real competitive edge when deliveries are concerned.

When I look back at the plate machine purchase experience it was a 'no brainer' decision. This machine made us an even bigger player in our industry. Now that we can process our material faster, with less labor, and at a higher level of quality, the sky is the limit."

- Paul Soukup, President

ON CALL. ON DUTY. ALL THE TIME.

24 Hour 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 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

WEBCAM TROUBLESHOOTING

Each of Peddinghaus' machines are shipped with a simple to use webcam 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 on 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.

**24
HOUR
HELP
DESK**



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ONLINE HERE!!!**



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Peddinghaus in the palm of your hand!!!