



## **Getting up and Running with Peddimat**

The Ocean Avenger comes pre-loaded with Peddimat Software – You also get additional unlimited Peddimat offline software seats so that you can program or import parts at other computers, in the office or at home, and then take out the Peddimat files to the machine (on a floppy disk)

Your machine software will arrive shortly. However we are sending this Peddimat software license to you to familiarize yourself with the software prior to the machine arriving. Please note that this license is made out to Ocean Machinery and we are granting your temporary use until your software arrives.

Please note that, as with all software, the correct training makes software easy to get into, and that attempting to learn software without support might make the software appear difficult to learn. We stress that Peddimat is the easiest machine programming software that we have ever seen. When your machine is installed you will get a thorough training in Peddimat.

Please note that there is an extensive HELP section in Peddimat. When you click the HELP Icon it opens with a hyperlinked window that lets you click on all areas of the workspace and see how they work.

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# Installing Peddimat

## Install Peddimat

Unzip the file  
double click on MDL100.exe  
follow prompts and install at  
C:\Program Files\Peddimat

### **NOTE FOR WINDOWS VISTA USERS**

Windows automatically tries to install Peddimat under Program Files – this does not work under Vista. Please specify the installation directory as the root directory  
C:/Pedimat

## Open Peddimat

Double click the Peddimat Icon to open Peddimat  
Click the New File icon

## Tile your workspace

Once open click the "tile Windows" icon to tile the three windows to your computer screen resolution

## Dimensions

go to "Setup" > "Dimensions" and choose your dimensions mm, inches etc.

## Shape Library

go to "Setup" > "Shape Library" and choose the shape library you want to use

## Standard Tools

Go to "Setup" > "Machine" > "Tools" and add the commonly used tool diameters that you use for drilling

## Setting up your Standard Patterns

Go to "Setup" > "Machine" > "Patterns" > and create your standard patterns  
You can set the default pitch for columns and rows and you can create specific pattern numbers. For instance if you set up a pattern as 5 rows - 1column - with rows at 3" and columns at 3" - when you call out the pattern you will just type in 51 and it will create the pattern

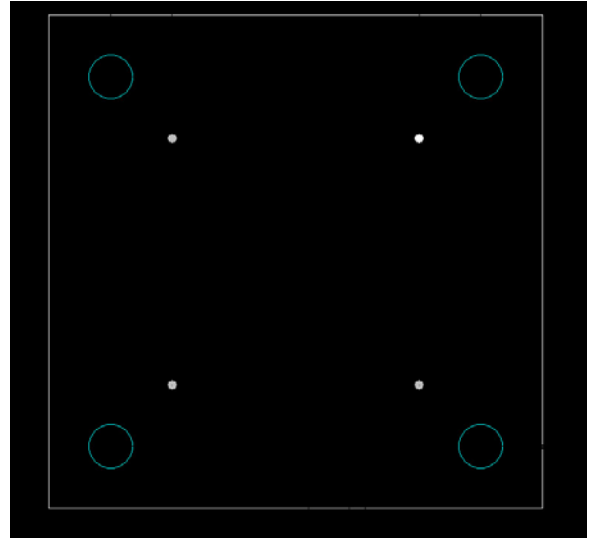
PTO

# How to get started – Programming a Base Plate

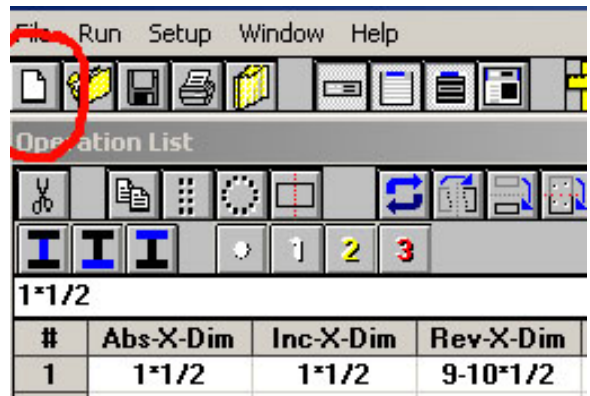
This is a short Example to get you familiarized with the software

This example uses a standard base plate P12x12x1 – that is 12" square 1" thick plate with 4 1-1/16" dia holes at 9"o/c and 4 layout marks at 6"o/c

This is the plate that we will program



Click the "New File" Icon to create a new part

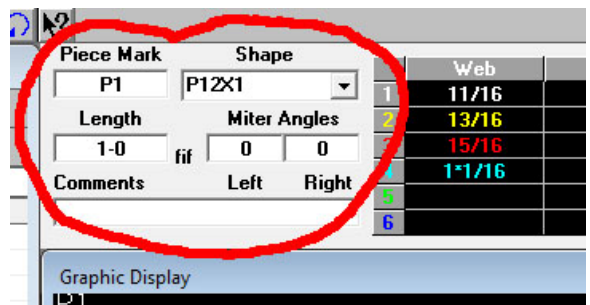


## Go to the Head block section

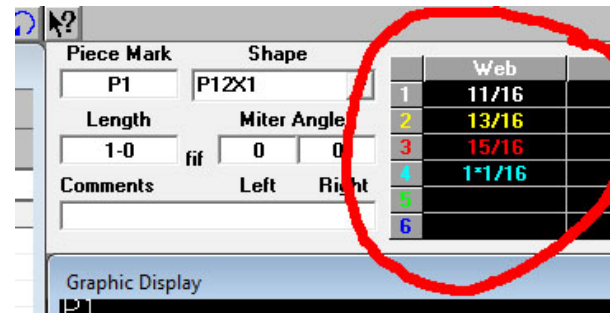
Under **PIECE MARK** type in a part name – P1 (for plate 1)

Under **SHAPE** type in P12x1 for a 12" bar 1" thick

In the **LENGTH** box type in 12 – this indicates a flat bar 12" long – you could also have typed 1- (note the dash indicates ft. Therefore "1-" is the same as 12")



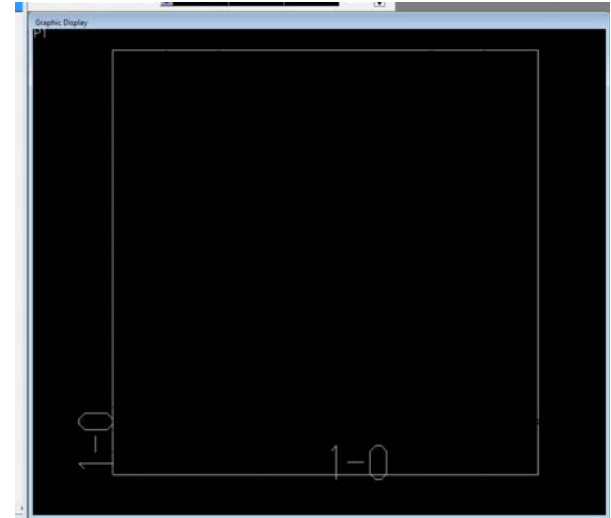
Note that in the standard tools I have 4 tools already setup – diameters from 11/16" through 1-1/16"



Note that specifying the profile and length automatically creates the graphic representation in the graphic display.

Click anywhere on the Graphic Display Window to make it active – the bar at the top will show blue to indicate its active. With the Graphic Display window active you can toggle the "D" key on and off to toggle Dimensions on or off.

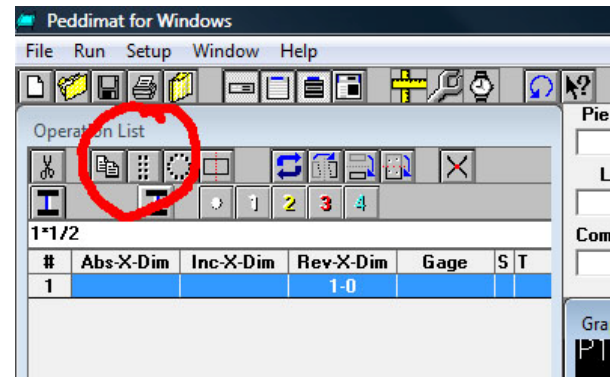
You will see the 1-0 (12") dimensions for X and Y toggle on and off.



### How to create the Base Plate Hole-Pattern

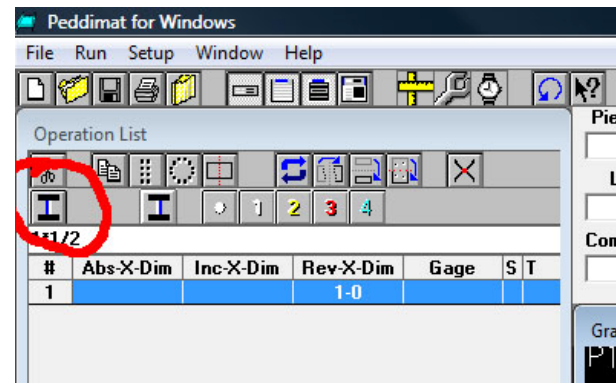
Go to the Operation List

1. Click the pattern icon (Matrix Shift)

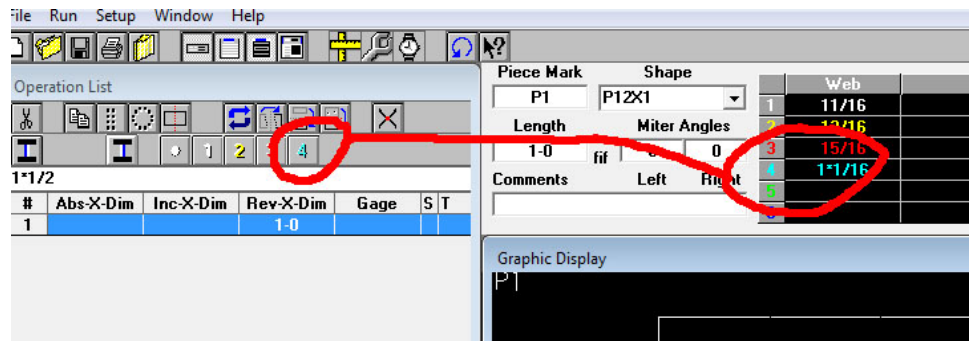


2. Now Click on the surface to be drilled (Web)

Note that since we are drilling pate we only have two surfaces visible (we near side and web far side). We no longer have top flange or bottom flange visible.



- Now click on the Tool number 4 to specify 1-1/16" diameter drill bit



This opens the pattern (matrix) dialogue

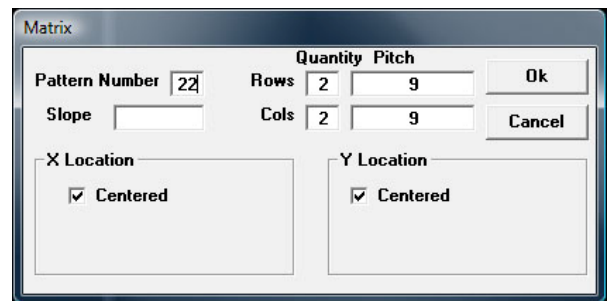
For the holes in the base plate type in the pattern number 22 (for 2 rows and 2 columns)

Under Pitch for Rows type in 9 (for 9")

Under Pitch for Columns type in 9 (for 9")

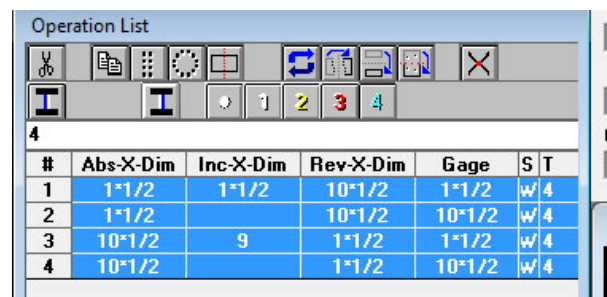
Under X location and Y location make sure that both "centered" boxes are checked. This will put the hole pattern in the center of the plate

- Now Click OK – this will create the 4 hole pattern with holes at 9" o/c.



Note that the holes are highlighted in the Operations List (if they are not, just click the # button to highlight all items again).

With them highlighted you could hit the scissors button to remove (cut) them



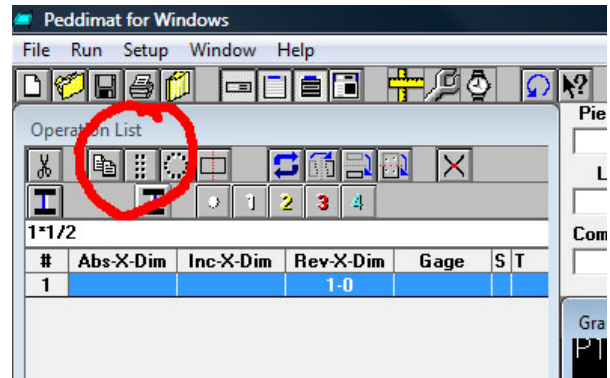
Now that we have the four holes laid out, we now want to layout the 4 marks on the plate that will mark where the column is going to be welded.

**Assuming a 6" x 6" RSS tube, with an OD of say 6.5" we will layout the 4 locating marks as follows.**

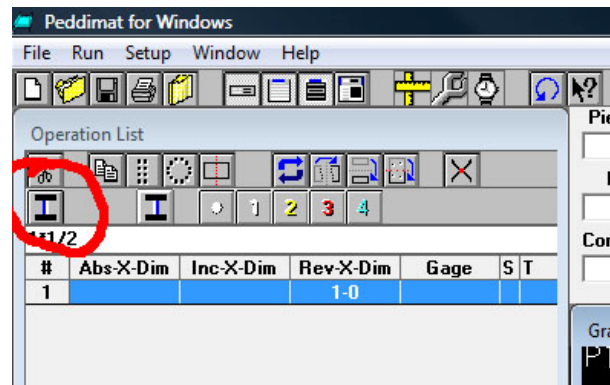
### How to create the Base Plate Layout Marks for locating the Welded Column

Go to the Operation List

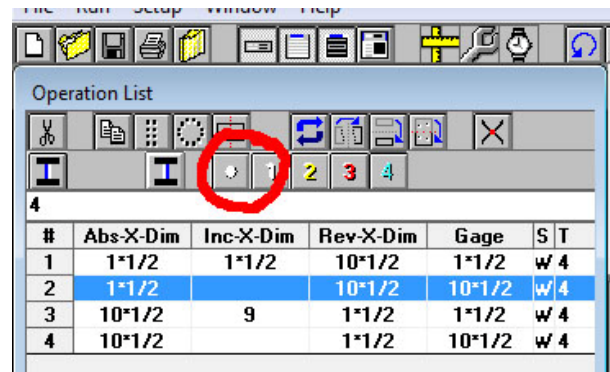
1. Click the pattern icon (Matrix Shift)



2. Now Click on the surface to be drilled (Web)



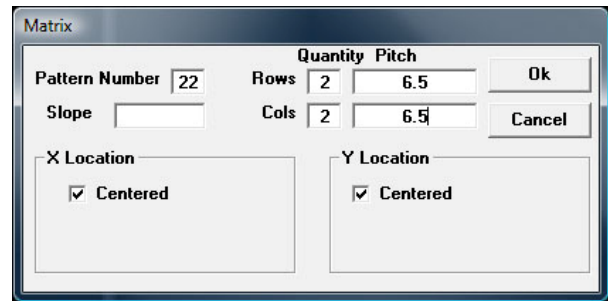
3. Now click on the round layout Mark tool. This tells the drill to go in touch the beam and retract – this leaves a visible center-punch like mark where the columns will be welded



This opens the pattern (matrix) dialogue. For the holes in the base plate type in the pattern number 22 (for 2 rows and 2 columns)

Under Pitch for Rows type in 6.5 (for 6-1/2")  
Under Pitch for Columns type in 6.5 (for 6-1/2")

Under X location and Y location make sure that both "centered" boxes are checked. This will put the layout mark pattern in the center of the plate

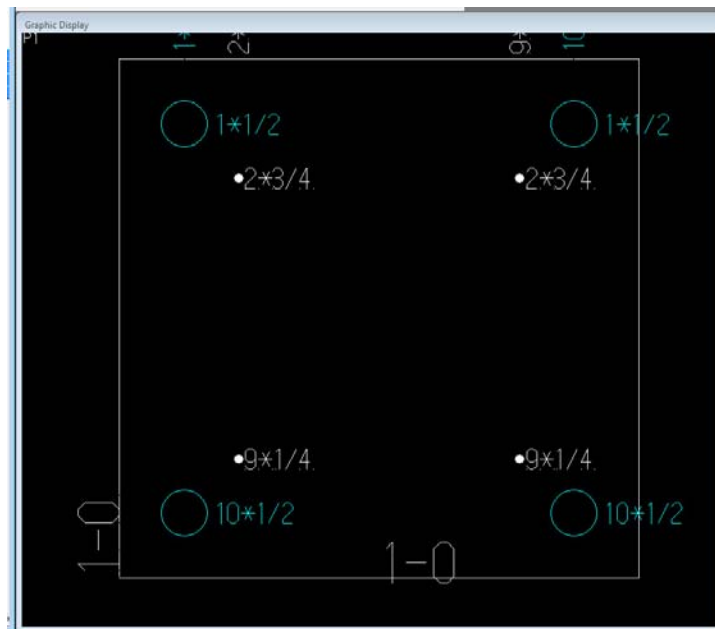


- Now Click OK – this will create the 4 layout marks at 6-1/2" o/c.

Your Operations List will now look like this

#	Abs-X-Dim	Inc-X-Dim	Rev-X-Dim	Gage	S	T
1	1*1/2	1*1/2	10*1/2	1*1/2	w	4
2	1*1/2		10*1/2	10*1/2	w	4
3	10*1/2	9	1*1/2	1*1/2	w	4
4	10*1/2		1*1/2	10*1/2	w	4
5	2*3/4	-7*3/4	9*1/4	2*3/4	w	M
6	2*3/4		9*1/4	9*1/4	w	M
7	9*1/4	6*1/2	2*3/4	2*3/4	w	M
8	9*1/4		2*3/4	9*1/4	w	M

And your Graphic Display will look like this



Best of luck. If you have any problems with the software consult the Help screen and do not hesitate to call or email Ocean Machinery for assistance

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