



## **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

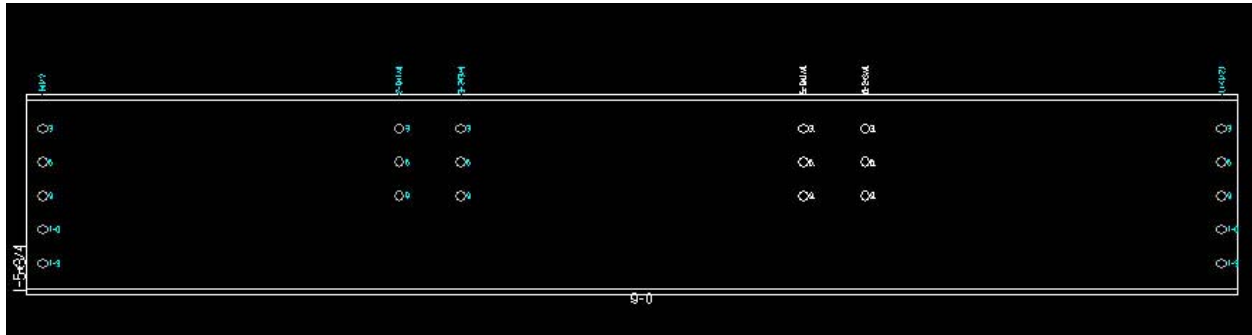
Go to "Setup" > "Machine" > "Patterns" > and create your standard patterns  
You can set the default pitch for columns and rows and you can create specific pattern numbers. For instance if you set up a pattern as 5 rows - 1column - with rows at 3" and columns at 3" - when you call out the pattern you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

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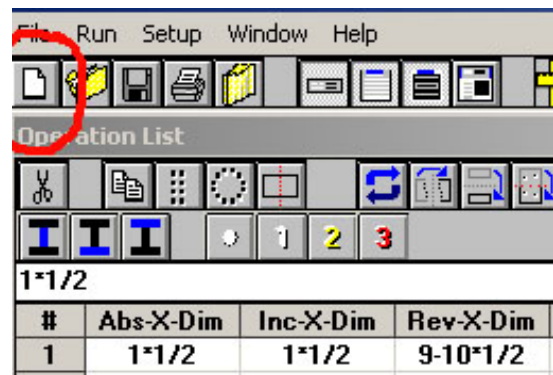
## How to get started – Programming Beams

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

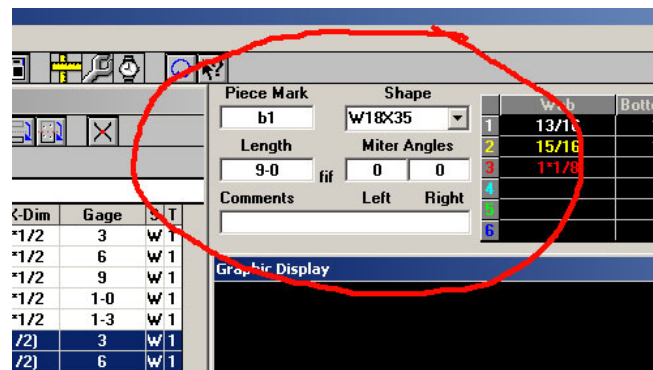
**this example uses the AISC Shapes specifying a 12ft long W18x35 beam**  
This is the beam we will program



Click the “New File” Icon

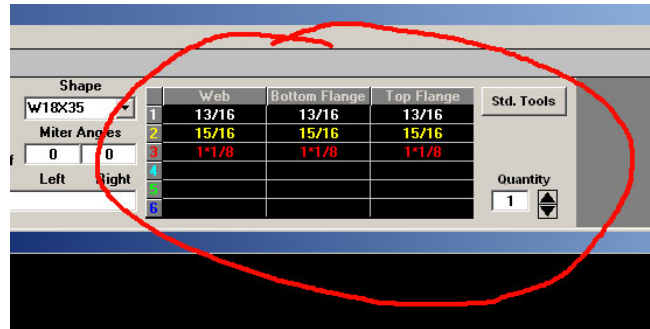


Go to the Headblock section  
Type in a part name – 1B1  
Type in W18x35 or select W18x35 from the drop down menu  
In the Length box type in the 12- (note the dash indicates 12ft – if you typed in 12 it would record that as 12”)



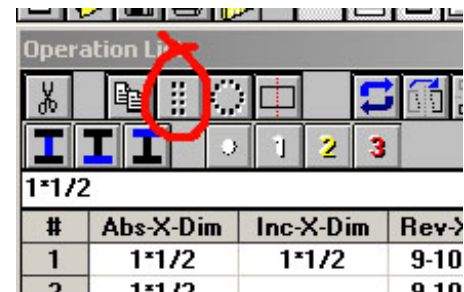
Note that specifying the profile and length automatically creates the graphic representation

With the Graphic display window highlighted (blue at top bar) toggle the "D" key on to toggle Dimensions on or off  
Select Standard Tools

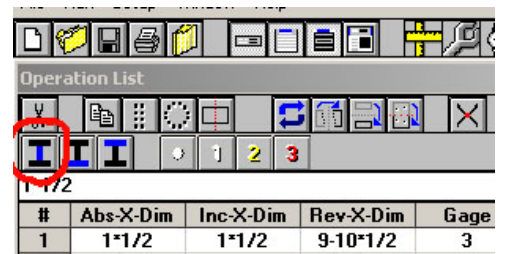


### How to create the Clip Angle Hole Pattern

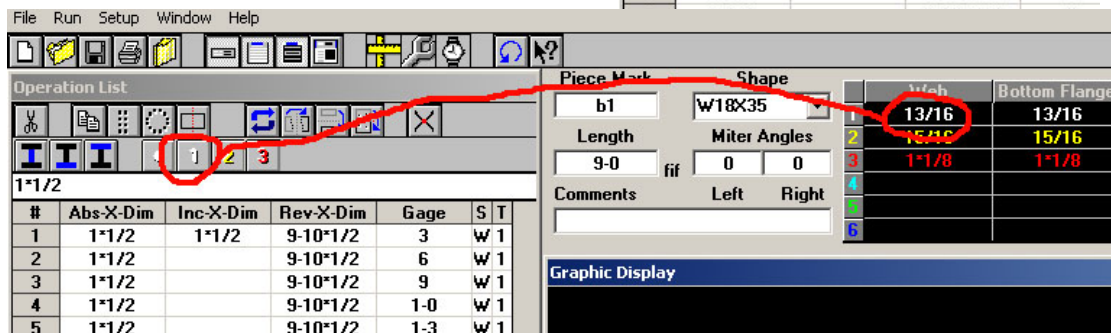
Go to the Operation List  
Click the pattern icon (Matrix Shift)



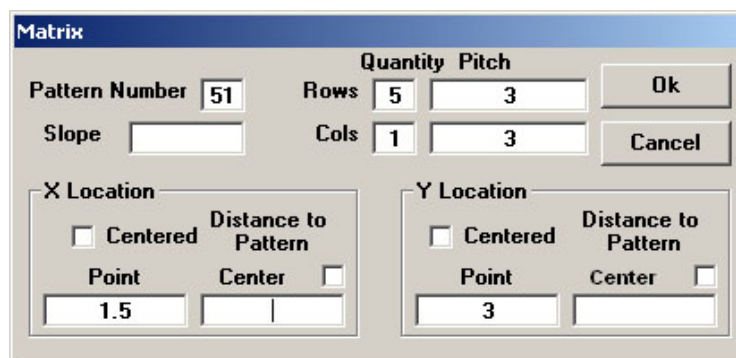
Click on the surface to be drilled (Web) –  
Note that the surface to be drilled is highlighted in blue



Click on the Tool number 1 to specify 13/16" dia

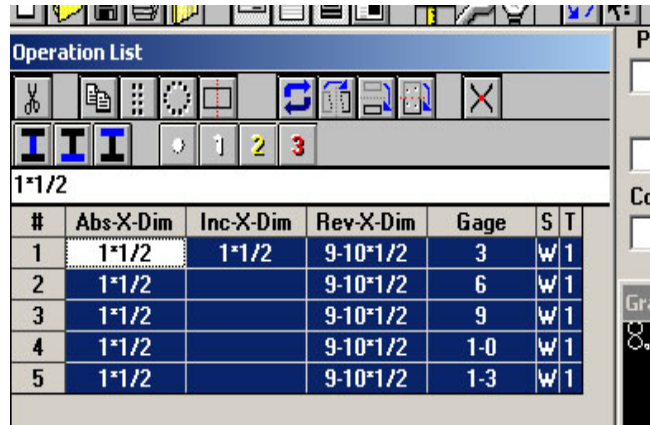


This opens the pattern (matrix) dialogue



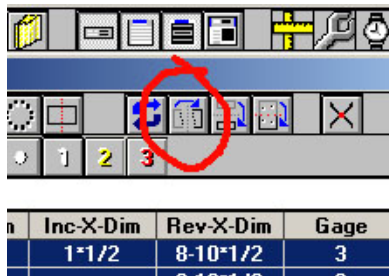
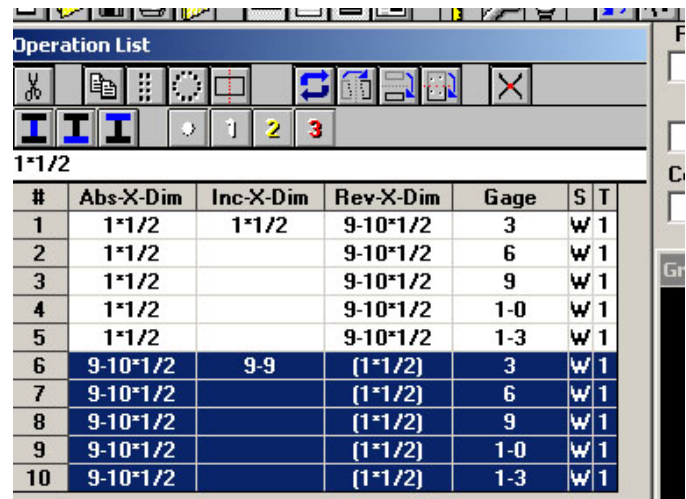
For the holes for clip angles (cleat) on the left hand end of the beam, type in the pattern number 51 (for 5 rows 1 column)  
 Under X location specify 1.5" (how far the pattern is located from the left end of the part)  
 Under Y location specify 3" (how far the pattern is from the top flange)  
 Click OK – this will create the first 5 holes

Note that the holes are highlighted (if they are not, just click on row 1 to highlight row 1 – hold the shift key and click on row 5)



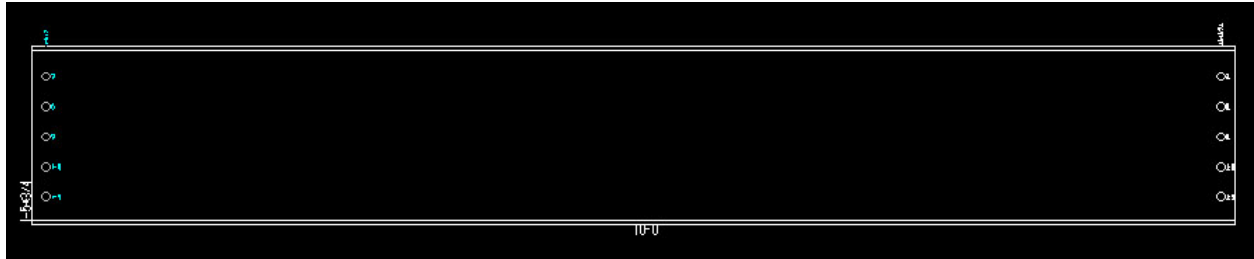
#	Abs-X-Dim	Inc-X-Dim	Rev-X-Dim	Gage	S	T
1	1*1/2	1*1/2	9-10*1/2	3	W	1
2	1*1/2		9-10*1/2	6	W	1
3	1*1/2		9-10*1/2	9	W	1
4	1*1/2		9-10*1/2	1-0	W	1
5	1*1/2		9-10*1/2	1-3	W	1

Now click the Mirror Ends Shift Icon  
 This will create the 5 holes at the right hand side of the beam

#	Abs-X-Dim	Inc-X-Dim	Rev-X-Dim	Gage	S	T
1	1*1/2	1*1/2	9-10*1/2	3	W	1
2	1*1/2		9-10*1/2	6	W	1
3	1*1/2		9-10*1/2	9	W	1
4	1*1/2		9-10*1/2	1-0	W	1
5	1*1/2		9-10*1/2	1-3	W	1
6	9-10*1/2	9-9	(1*1/2)	3	W	1
7	9-10*1/2		(1*1/2)	6	W	1
8	9-10*1/2		(1*1/2)	9	W	1
9	9-10*1/2		(1*1/2)	1-0	W	1
10	9-10*1/2		(1*1/2)	1-3	W	1

your beam now looks like this



To create the holes to receive the beams at 3ft on centers we proceed as follows

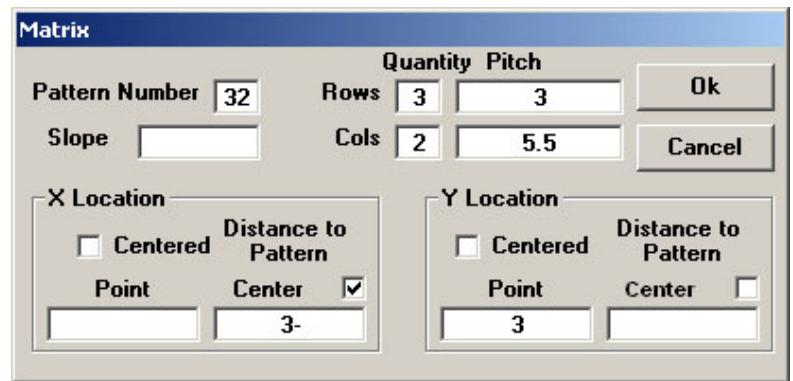
Click on the surface to be drilled (Web) –

Click on the Tool number 1 to specify 13/16" dia

Change the column pitch to 5.5"

In the X location, because we want to detail to the center of the pattern we check off "distance to Pattern Center" and we type in 3- for 3ft

We still want the holes to be 3" down from the top flange in the Y location

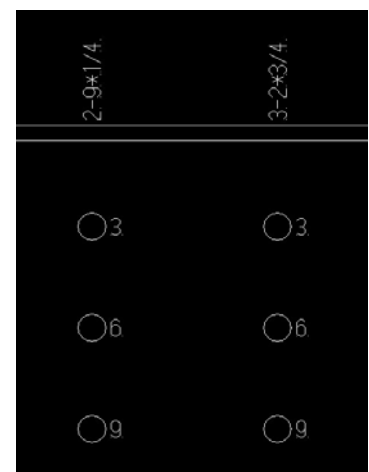


This will create the holes as show in the graphic below –

Splitting the 5.5" pattern equally over the 3' centerline

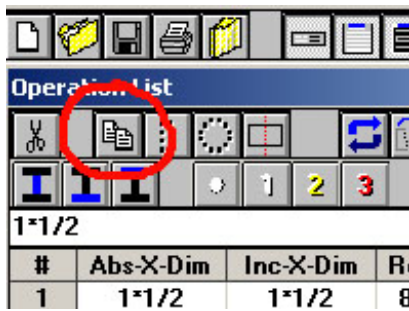
Drag your Mouse cursor over the area in the graphic that you want to highlight

When you create the holes they should always be highlighted- If they are not highlighted, click on row 11 and hold the shift key down and click on row 16 to highlight the rows

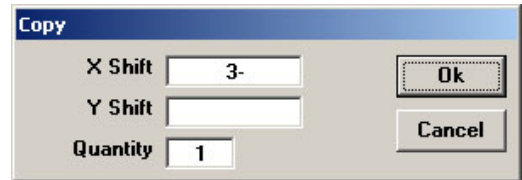


7	8-10 1/2		(1 1/2)	0	W 1
8	8-10 1/2		(1 1/2)	9	W 1
9	8-10 1/2		(1 1/2)	1-0	W 1
10	8-10 1/2		(1 1/2)	1-3	W 1
11	2-9 1/4	-6-1 1/4	6-2 3/4	3	W 1
12	2-9 1/4		6-2 3/4	6	W 1
13	2-9 1/4		6-2 3/4	9	W 1
14	3-2 3/4	5 1/2	5-9 1/4	3	W 1
15	3-2 3/4		5-9 1/4	6	W 1
16	3-2 3/4		5-9 1/4	9	W 1

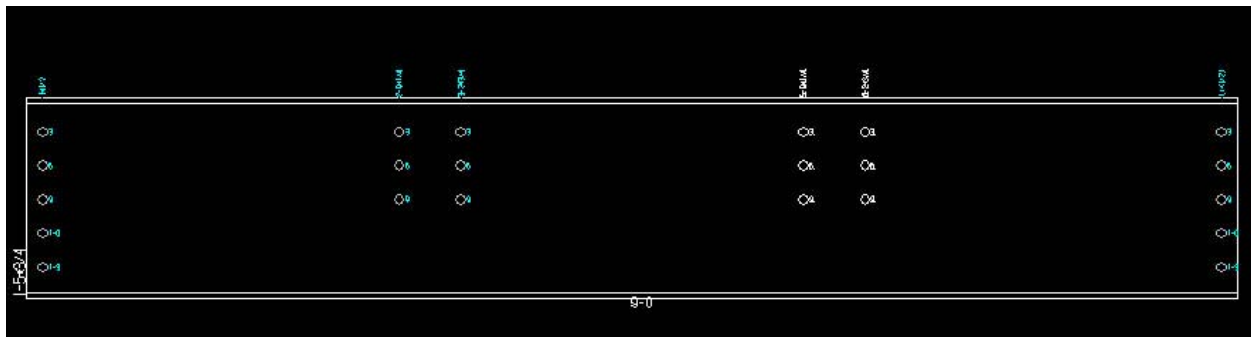
Now hit the Copy Shift Icon



We want to create a single copy of the pattern shifted 3ft in the X direction – nothing in the Y direction, so we complete the copy Shift dialogue as follows



And our beam is complete



Best of luck

If you have any problems with the software consult the Help screen and do not hesitate to call or email me for assistance

Regards

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