Ironworkers

Precision Design...

Traditional Performance...

Proven Durability...

Structural integrity is more than an engineering term – it's the Peddinghaus way of doing business.
Since 1903, Peddinghaus has set international standards of excellence in the design and manufacture of quality machine tools for the structural steel, heavy plate, and related metalworking industries.

Through the years, Peddinghaus has led the industry in numerous patented designs. This engineering provides solid machine tools which deliver consistent quality, high productivity, and profits to our customers throughout the world.

*It’s what’s inside that counts...*
What elevates Peddinghaus above other ironworker machines is our inside story – a precision machined slide which provides a true 90 degree approach to every work piece – punch, shear, or notch. The perpendicular motion of the slide provides distortion free shearing and punching, every time.

Like any quality machine tool, the slide design incorporates machine gib which guarantee long machine life and productivity.

The net result is a smooth, burr-free cut ready for your next operation.
Upper Gibs for Guidance
Assures vertical alignment

Heavy Side Frame Construction
Outstanding machine longevity

Tool Steel Slide
Uniquely engineered for peak performance

Quick Change Punch Unit
High performance punching power

Flat Shear Blade Opening
Large capacity, deformation-free cuts
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<td>14” x 3/8” (356mm x 10mm)</td>
<td>16” x 3/4” (406mm x 19mm)</td>
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<td>5” x 1/2” (127mm x 12mm)</td>
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<td>16-1/2” (419mm)</td>
<td>15-3/4” (400mm)</td>
<td>20-1/4” (514mm)</td>
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<td>30” (762mm)</td>
<td>28-3/4” (730mm)</td>
<td>28-3/8” (721mm)</td>
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<tr>
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<td>2.4 (1550 mm²)</td>
<td>4.75 (2320 mm²)</td>
<td>4.75 (3000 mm²)</td>
<td>5.75 (3500 mm²)</td>
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<tr>
<td>Angles, 90° Cut Rounds Squares</td>
<td>4” x 4” x 3/8” (102mm x 10mm) 1-1/4” and 3/4” (32mm and 19mm) 1-3/16” and 3/4” (30mm and 19mm)</td>
<td>5” x 5” x 1/2” (127mm x 13mm) 1-9/16” and 3/4” (40mm and 19mm) 1-9/16” and 1” (40mm and 25mm)</td>
<td>5” x 5” x 1/2” (127mm x 13mm) 1-9/16” and 3/4” (40mm and 19mm) 1-9/16” and 1” (40mm and 25mm)</td>
<td>6” x 6” x 1/2” (152mm x 13mm) 2” and 1” (40mm and 19mm) 2” and 1-3/16” (51mm and 30mm)</td>
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<tr>
<td>Channels, 90° Cut Working Height (to Center of Blades)</td>
<td>4” (102mm) 41-1/8” (1045mm)</td>
<td>6” (152mm) 45-7/8” (1165mm)</td>
<td>6” (152mm) 43-1/4” (1099mm)</td>
<td>7” (178mm) 45-1/2” (1156mm)</td>
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<tr>
<td>Plate</td>
<td>3/8” (10mm)</td>
<td>1/2” (13mm)</td>
<td>1/2” (13mm)</td>
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<tr>
<td>Angles</td>
<td>2” x 3/8” (51mm x 10mm)</td>
<td>3” x 3/8” (76mm x 10mm)</td>
<td>3” x 3/8” (76mm x 10mm)</td>
<td>3” x 1/2” (76mm x 12mm)</td>
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<tr>
<td>Channels in Flange</td>
<td>3” x 5” (76mm x 127mm)</td>
<td>3” x 5” (76mm x 127mm)</td>
<td>3” x 5” (76mm x 127mm)</td>
<td>3” to 6” (76mm x 152mm)</td>
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<tr>
<td>Notch Width</td>
<td>1-3/4” (44mm)</td>
<td>2” (51mm)</td>
<td>2” (51mm)</td>
<td>2-1/6” (65mm)</td>
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<tr>
<td>Notch Depth</td>
<td>2” (51mm) 3” (76mm)</td>
<td>2” (51mm)</td>
<td>3” (76mm)</td>
<td>3-1/6” (84mm)</td>
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<tr>
<td>Triangular Notcher</td>
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<tr>
<td>Plate</td>
<td>3/8” (10mm)</td>
<td>1/2” (13mm)</td>
<td>1/2” (13mm)</td>
<td>1/2” (13mm)</td>
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<tr>
<td>Angles</td>
<td>2” x 3/8” (51mm x 10mm)</td>
<td>2-1/2” x 3/8” (64mm x 10mm)</td>
<td>2-1/2” x 3/8” (64mm x 10mm)</td>
<td>3” x 3/8” (76mm x 10mm)</td>
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<tr>
<td>Notch Depth</td>
<td>2” (51mm)</td>
<td>2-3/16” (56mm)</td>
<td>2-3/16” (56mm)</td>
<td>2-9/16” (65mm)</td>
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<td>Working Height</td>
<td>40” (1016mm)</td>
<td>44-1/4” (1124mm)</td>
<td>43-1/4” (1099mm)</td>
<td>43-1/4” (1099mm)</td>
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<tr>
<td>Punch Unit</td>
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</tr>
<tr>
<td>Rated Capacity</td>
<td>55 Tons (50 kN)</td>
<td>105 Tons (80 kN)</td>
<td>66 Tons (60 kN)</td>
<td>110 Tons (100 kN)</td>
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<tr>
<td>Punch Capacity</td>
<td>1-1/4” in 1/2” (32mm in 13mm)</td>
<td>1-1/4” in 3/4” (32mm in 19mm)</td>
<td>4” to 15” (102mm to 305mm)</td>
<td>4” to 15” (102mm to 381mm)</td>
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<td>Channels in Flange</td>
<td>3” to 12” (76mm to 305mm)</td>
<td>4” to 15” (102mm to 381mm)</td>
<td>4” to 15” (102mm to 381mm)</td>
<td>1-1/4” thru 1” (32mm thru 25mm)</td>
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<td>Channels in Web</td>
<td>4” to 12” (102mm to 305mm)</td>
<td>4” to 14” (102mm to 356mm)</td>
<td>4” to 15” (102mm to 381mm)</td>
<td>4” to 15” (102mm to 381mm)</td>
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<tr>
<td>Punches with Oversize Punching Attachment</td>
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<tr>
<td>Up to 2-1/2” (64mm)</td>
<td>2-1/2” x 7/32” (64mm x 6mm) 3-1/2” x 5/32” (89mm x 4mm) 8” (203mm)</td>
<td>2-1/2” x 7/16” (64mm x 11mm) 3-1/2” x 11/32” (89mm x 9mm) 10” (254mm)</td>
<td>2-1/2” x 9/32” (64mm x 7mm) 3-1/2” x 3/16” (89mm x 5mm) 16” (406mm)</td>
<td>2-1/2” x 1/2” (64mm x 13mm) 3-1/2” x 11/32” (89mm x 9mm) 20” (508mm)</td>
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<td>Up to 3-1/2” (89mm)</td>
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<tr>
<td>Throat Depth</td>
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<tr>
<td>Working Height</td>
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<td></td>
<td>41-1/8” (1045mm)</td>
<td>44-3/4” (1137mm)</td>
<td>41-1/4” (1048mm)</td>
<td>43-1/4” (1099mm)</td>
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<tr>
<td>Machine Data</td>
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<tr>
<td>Number of Strokes on the Punch Unit at Full Stroke</td>
<td>21</td>
<td>17</td>
<td>26</td>
<td>22</td>
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<tr>
<td>Stroke, Infinitely Adjustable</td>
<td>3/8” to 1-1/4” (10mm to 32mm)</td>
<td>3/8” to 1-5/8” (10mm to 41mm)</td>
<td>3/8” to 2” (10mm to 51mm)</td>
<td>3/8” to 2” (10mm to 51mm)</td>
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<tr>
<td>Power Rating</td>
<td>5.5 HP (4 kW)</td>
<td>5.5 HP (4 kW)</td>
<td>7.5 HP (5.6 kW)</td>
<td>10 HP (7.5 kW)</td>
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<tr>
<td>Charge of Oil</td>
<td>12 Gallons (45 Litres)</td>
<td>12 Gallons (45 Litres)</td>
<td>21 Gallons (80 Litres)</td>
<td>28 Gallons (106 Litres)</td>
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<tr>
<td>Net Weight</td>
<td>1880 lbs. (854 kg)</td>
<td>2550 lbs. (1159 kg)</td>
<td>4200 lbs. (1909 kg)</td>
<td>6500 lbs. (2954 kg)</td>
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<tr>
<td>Machine Dimensions</td>
<td>36-1/2” (927mm) 25-1/2” (648mm)</td>
<td>40-3/4” (1035mm) 26-3/4” (679mm)</td>
<td>65-1/4” (1657mm) 40-1/8” (1019mm)</td>
<td>77-1/4” (1962mm) 40-1/4” (1022mm)</td>
</tr>
<tr>
<td>Length</td>
<td>65-1/4” (1657mm)</td>
<td>72-1/2” (1842mm)</td>
<td>77-1/4” (1962mm)</td>
<td>81-1/4” (2064mm)</td>
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<tr>
<td>Width</td>
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<tr>
<td>Height</td>
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</tbody>
</table>
Universal Ironworker combined section shear, plate shear and miter capability with quick change punch attachment.

The Peddiworker 550 has everything that a Universal Ironworker needs...and at an affordable price!

At a glance:
Combined flat, section and bar stock shear, hydraulically operated, 55 ton rated punching and shearing capacity.

Equipped with:
- Flat shear blades
- Material support table with gauge stops for flat shear and square notcher
- Section shear for angles
- Round and square bar section
- Quick-change punching attachment with die holder
- Moveable stripper with exchangeable plates
- 2-stage foot pedal operation
- Electrical control panel
- Socket for electrical contact length stop
- Integrated hydraulic power-pack
- Capacity to meet all fabricating requirements
Universal Ironworker combined section shear. For stock and bar shear with quick-change punch unit and notcher.

Peddiworker Universal Ironworkers has set international standards for excellence. The new model features a versatile notcher/punch attachment which offers a distinct advantage over other models. This new design allows fabricators to react quickly to varied tasks and produce parts with increased productivity and quality.

**At a glance:**
4-station flat section and bar stock shear with notching attachment and punch unit, hydraulically operated, 105 tons of punching and shearing capacity.

**Equipped with:**
- Flat shear blades
- Material support table with gauge stops for flat shear and square notcher
- Section shear knives for angles
- Round and square bar section
- Square coper or triangular notcher with support table and gauge stops
- Quick-change punching attachment with die holder
- Height-adjustable and moveable stripper with interchangeable plates
- 2-stage foot pedal: low pressure punch spotter with foot pedal operation
- Electrical control panel
- Socket for electrical contact length stop
- Integrated hydraulic power unit
The new Peddimax is equipped with two slides which allows two operators to work independently of one another, yet still ensures ease of operation.

Along with the quick-change, high-performance punch unit, Peddimax Universal Ironworkers feature a plate and flat bar shear with a ledge table, gauge stop, and in-feed guide for accurate shearing to the precise angle, a section shear for shearing angle iron, rounds and squares, and a square or triangular notcher.

Quick-change punching attachment with swing-away stripper and die holder for stock punches and dies up to 1-1/4” (32mm) diameter using standard die block with flat die bolster. Also available upon request with the universal gooseneck dieblock for economic fabrication of structural shape. Oversized punch attachments available.

Square notcher with support table. Also suitable for notching the flanges of channels and I-sections.

Spring mounted hinged support for simple changing of sections knives.
At a glance:
The Peddimax hydraulic Ironworkers are designed for continuous production with features that meet the most demanding applications. Hydraulic power up to 140 tons assures consistent production time.

Equipped with:
- Flat shear blades
- Material support table with gauge stops for flat shear and square notcher
- Section shear knives for angles
- Round and square bar section
- Square coper or triangular notcher with support table and gauge stops
- Quick-change punching attachment with die holder
- Height-adjustable and moveable stripper with interchangeable plates
- 2-stage foot pedal: low pressure punch spotter with foot pedal operation
- Electrical control panel
- Socket for electrical contact length stop
- Integrated hydraulic power unit

Universal die block for punching flanges and welds of structural shapes (optional).
The Peddinghaus hydraulic single end punch is equipped with a powerful hydraulic drive system, and features compact design, state-of-the-art technology and a comprehensive range of accessories and tooling.

**Standard punching attachment consisting of quick change punching attachment up to 1-1/4” (32mm) diameter with flat die bolster.**

**At a glance:**
The versatile 110/20 provides a compact powerful package that maximizes floor space.

**Equipped with:**
- 110 ton rated capacity
- 20” (500mm) throat depth
- Quick change punching attachment that uses stock punches and dies
- Height adjustable swing-away stripper with exchangeable plates
- Hydraulic low pressure spotter for easy foot pedal operation
- Infinitely adjustable stroke from 5/32” to 1-9/16” (4mm to 40mm)

**Model 110/20**

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<th>Model</th>
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<td>Stroke</td>
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<tr>
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<td>5/32”to 2” (10-51mm)</td>
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<td>Number of Strokes at 3/8” (10mm)</td>
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<tr>
<td>Working Height to Die</td>
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<tr>
<td>Throat Depth</td>
<td>20” (510mm)</td>
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<tr>
<td>Width of Flat Die Bolster</td>
<td>11-7/8” (300mm)</td>
</tr>
</tbody>
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**Punches**

- With Flat Die Bolster: 1-1/4” in 1” (31mm in 25mm)
- With Universal Die Block:
  - Channels in Flange: 4” to 14” (100mm to 380mm)
  - Channel in Web: 4” to 16” (100mm to 400mm)
  - I-Beams in Flange: 4” to 12” (100mm to 340mm)
  - I-Beams in Web: 4” to 21” (100mm to 500mm)
- Oversized Punch Attachments:
  - Up to 2-1/2” (65mm): 2-1/2” in 1/2” (65mm in 12mm)
  - Up to 3-1/2” (90mm): 3-1/2” in 11/32” (90mm in 8.5mm)
  - Up to 5-1/8” (130mm): 5-1/8” in 15/64” (130mm in 6mm)

**Machine Data**

- Power Rating: 10 HP (7.5 kW)
- Charge in Oil: 26-1/2 Galloons (100 Litres)
- Net Weight with Oil: 5280 lbs. (2400 kg)
- Machine Dimensions (LxWxH): 49 x 40” x 81” (1788mm x 1022mm x 206mm)
The 110/20 CNC single end punch with CNC gauge table will process material up to 1" (25mm) thick. The CNC control unit operates seamlessly with the Peddimat programming system for plate and angle detail productivity.

At a glance:
The CNC gauge table provides automated efficiency and accuracy at a minimal cost.

Benefits:
- Eliminate manual layout
- Guaranteed CNC accuracy
- Recall previously stored programs easily
- 50% faster than traditional methods
- Easily adaptable to Peddimax 110/140 Steelworker flexible manufacturing cell
The FS800 shear is a uniquely engineered and designed single slide hydraulic flat shear. All forces generated through shearing are equally distributed through the slide and body plates, not through the hydraulic cylinder...thus eliminating shock and stress on the hydraulic system.

At a glance:
The integrated power unit creates a compact yet powerful single cut flat shear designed to shear a variety of materials.

Equipped with:
- Hydraulic flat shear with integrated hydraulic power-pack
- Material support table with two adjustable guides for precision flat cutting
- Electric safety circuit; stroke movements that have been initiated can be interrupted in any position
- Sockets for electrical contact length stop and machine spot lamp
- Rugged plate design; vertical shear movement
- Hydraulic drive system as protection against surcharge
- Hydraulic hold down as optional
- Electrical 39” (1000mm) length stop as standard

Model | FS880 Flat Shear
---|---
Cuts Flat Bar | Up to 16” x 3/4” (406mm x 19mm)
Mitre Cut 45° | Up to 4-1/2” x 3/4” (114mm x 19mm)
Blade Cut Length | 16.7” (425mm)
Working Height | 36” (920mm)

Machine Data

| Number of Strokes at 13/16” (21mm) | 25 |
| Stroke, Adjustable | 3/8” to 1-5/8” (10-42mm) |
| Power Rating | 5.5 HP (4 kW) |
| Charge in Oil | 12 Gallons (45 Litres) |
| Net Weight with Oil | 1860 lbs. (815 kg) |
| Machine Dimensions (LxWxH) | 29”x27”x63” (73mm x 69mm x 160mm) |
**ACCESSORIES**

**Tooling**

510
Conveyor, 10' long, manual height adjustable

513
Detachable front material support table with adjustable side and depth gauge stops 20-1/4" x 25" (520mm x 635mm)

517
Punch work table, short 6' x 15-5/8" (152mm x 397mm)

518
Punch work table, full 13-9/16" x 15-3/4" (344mm x 400mm)

522
Electrical length stop 39", 78", 118" (1m, 2m, 3m)

524
Linear gauge rail 39", 78", 118" (1m, 2m, 3m)

533
Detail of adjustable indexing cams

533 Detail
Detail of adjustable indexing cams

533 Plus
Gauging table system WBL Plus

539
Detachable front gauge table 12-1/4" x 19-5/8" (311mm x 498mm)

542
Gauge table 30" x 40" (762mm x 1016mm) with finger stops

543
CNC 2 axis gauging table

546
Large capacity table with removable front 18-3/4" x 19-5/8" (476mm x 498mm)

548
Short 2 gauge work table

549
Work light with magnetic base

Oversize punch attachment 2-1/2", 3-1/2" (65mm, 90mm)

Punch and dies

CNC flat bar measuring conveyor
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Established in 1903, Peddinghaus has been instrumental in providing quality equipment for virtually every major construction project in the world. As the industry leader in innovative technology for structural steel and heavy plate fabrication, Peddinghaus stands ready to serve our industry partners.