

# P.E.P. TECHNOLOGY<sup>®</sup>

## BEVEL SUCCESS STORY

The part in this document was cut by numerous companies trying to bid on the job. Many of the companies sent us their pictures asking for our help with the job. What impressed us was how crummy the finished parts were when compared to P.E.P.'s results. The company that got the contract purchased the P.E.P.'s Bevel software and agreed to share the photos below as part of a success story.

### Army Project

#### Original Method

Laser Cut Blanks 1.5 hrs

Robotic Bevel edges 2 hrs

Hand Grind 6 hrs

**Total time for 30 parts 9.5hrs**

#### PEP Bevel

#### Approach

Plasma Bevel 30 parts 1.6 hrs

**SAVINGS 7.9hrs**

**OR**

**In the same time it previously took to process 30 parts they can now process 178 parts.**

**500% INCREASE IN PRODUCTIVITY!**



## THE DETAILS OF THE OLD METHOD

### Project 901-46-0547

1/2" plate, 45 degree Y-bevel with 1/16" Land.

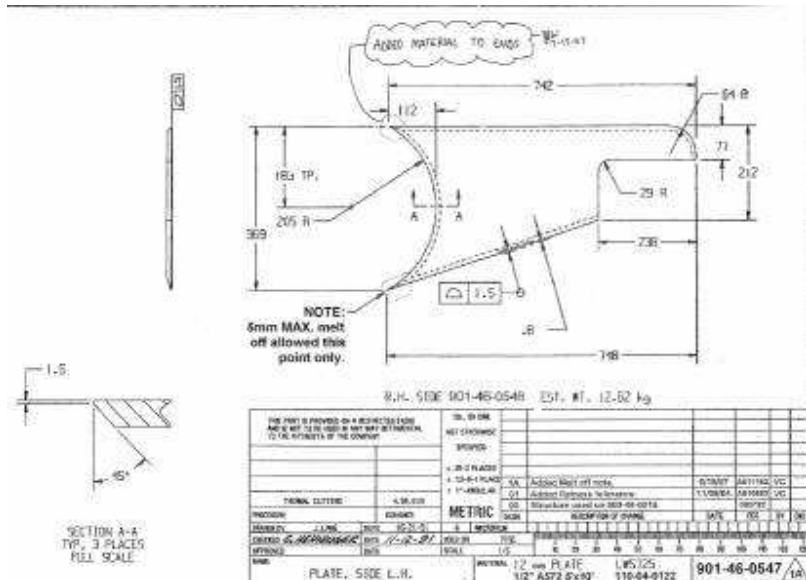
The sharp bevel corners are critical

Original processes before PEP.

1. Laser Cut Blanks
2. Robotic Bevel edges
3. Hand Grind sharp corners

New Process with PEP Bevel

1. Plasma Bevel  
(w/Minimal clean up)



### Step #1

**Laser Cut** – Part blanks are laser cut with extra stock added on sharp corners for gridding to bevel points.

3 min each to Laser Cut  
90 min. to cut a set of 30 parts



### Step #2

**Robotic Beveller** – adds 45 bevel to laser cut part blanks.

Parts are put in a fixture and then the 45 degree bevel is added leaving the 1/16<sup>th</sup> land.

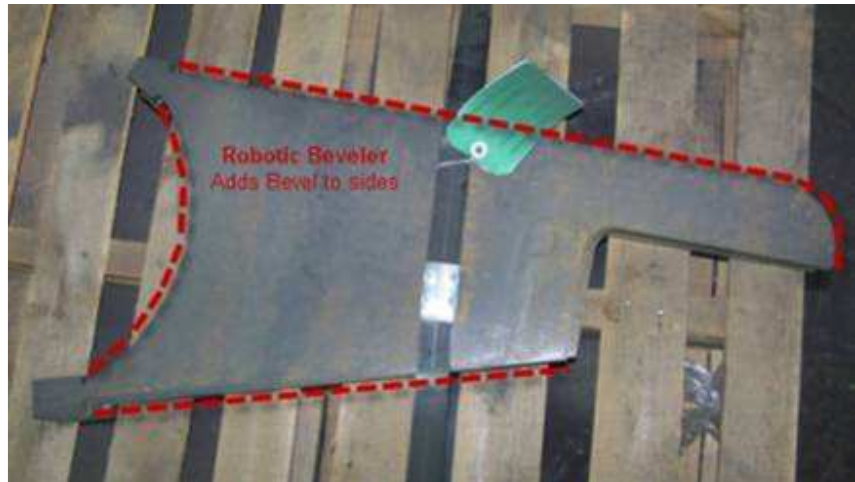
Setup and Bevel cutting 4 min. per part.  
120 min. to bevel a set of 30 parts



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**Robotic Beveller** adds bevels to the sides outlined in red by skipping the sharp corners to be ground down.

2 hours to process 30 parts



### Step #3

**Hand Grinder** – Sharp corners are ground down to the desired beveled points

12 min each to Grind to a point

6 hours to grid the set of 30 parts



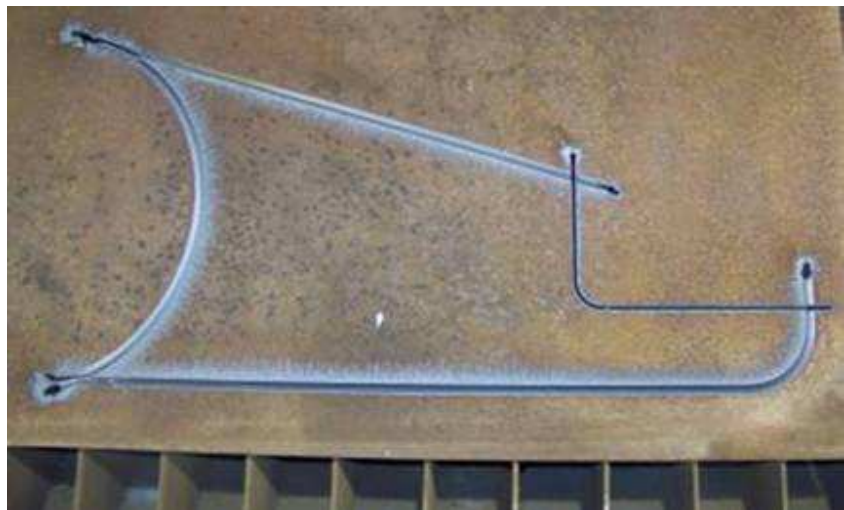
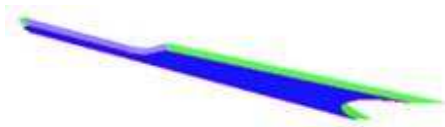
### P.E.P. Bevel Process

**Plasma Beveller** using PEP Bevel application's special single pass technique to cut a 45Y cut with a 1/16" land

3.3 minutes per part

or

30 part run in 1 hour 40 minutes



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## **OLD METHOD**

Was 30 Parts in 8 hours

## **PEP BEVEL APPROACH**

Now 178 Parts in 8 hours!

**PEP Bevel processes run less than  
20% of the original process time.**

