

# P.E.P. TECHNOLOGY<sup>©</sup>

## *Tomorrow's Automated Manufacturing Technology .... Today!*

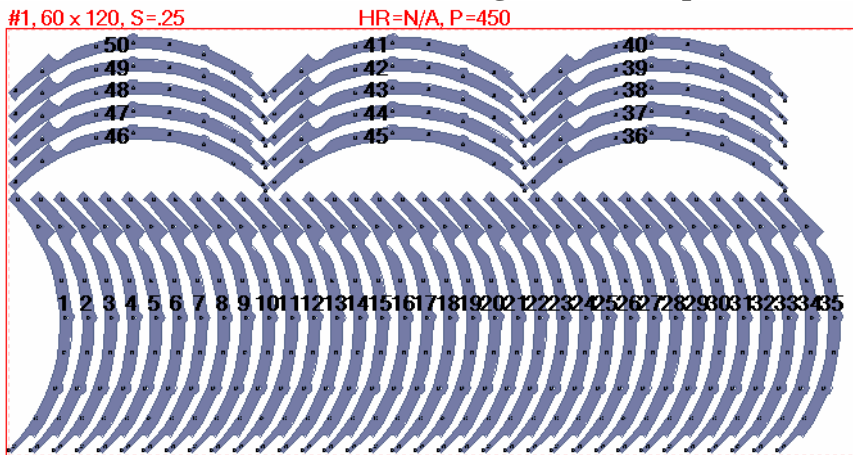
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### AUTOMATIC NESTING WITH MIRRORED PARTS

The P.E.P. Technology Automatic Nesting software will AUTOMATICALLY create a mirrored part from an original part and nest with combinations of both the original and the mirrored part, dramatically increasing the number of parts per sheet. The selection of which parts to be mirrored is controlled by the user in the P.E.P. drawing database.

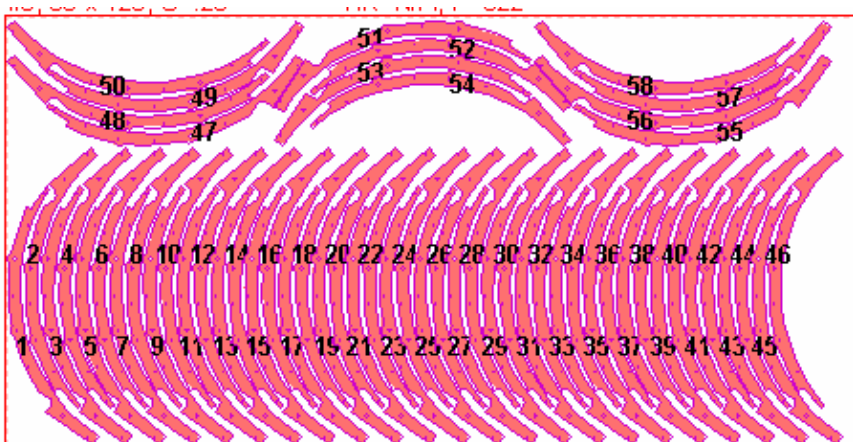
**Here is what you need to know before we get into the details of how it is done.**

**P.E.P. 2007 without Mirror / Drawing: SSM1 / 50 parts were nested**

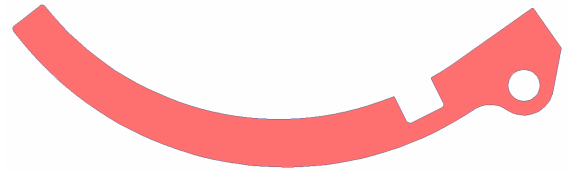


**P.E.P. 2007 “with” Mirror / Drawing: SSM1 / 58 parts were nested**

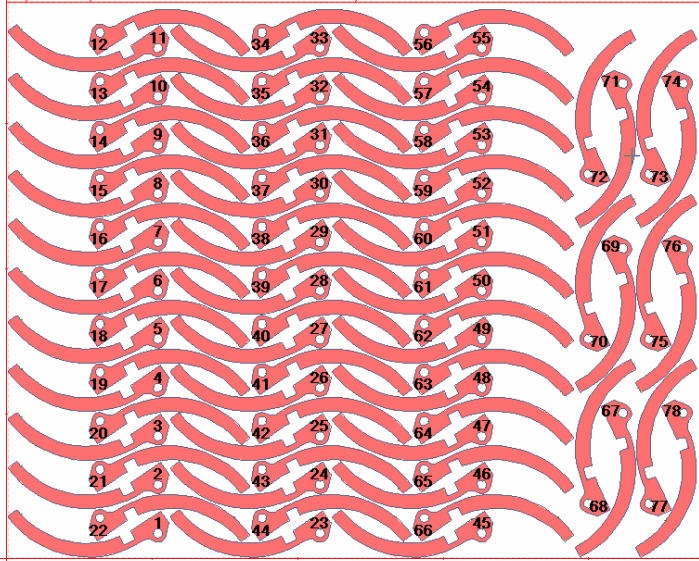
Drawing = SSM1 58 parts ( 16% increase in material yield )



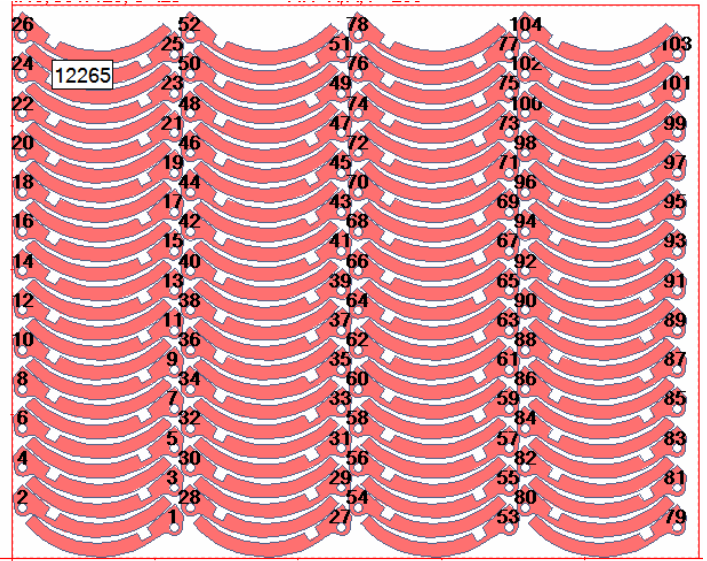
As shown in the nest on the right, 30 more parts per sheet went down by mirroring the original part. This is a 40% increase in material utilization.



Without Mirror / 74 parts



With Mirror / 104 parts



### Setting of the nesting parameters

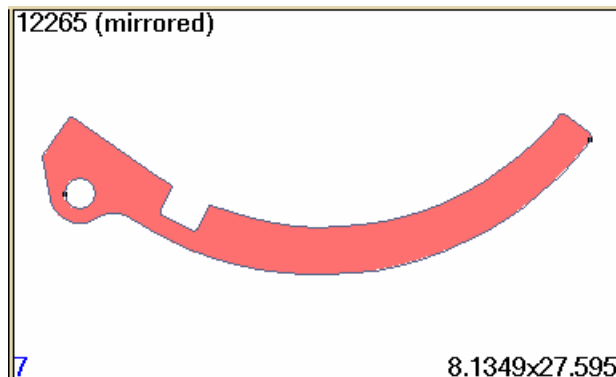
Automatic Nesting with Bullet and or Wip will display the parameters fields shown below.

Entering Y in field #41 will automatically check for the mirror image of all parts. If the analyzing results in more parts going down then the mirrored image is saved as a P.E.P. drawing and the nest accepted.

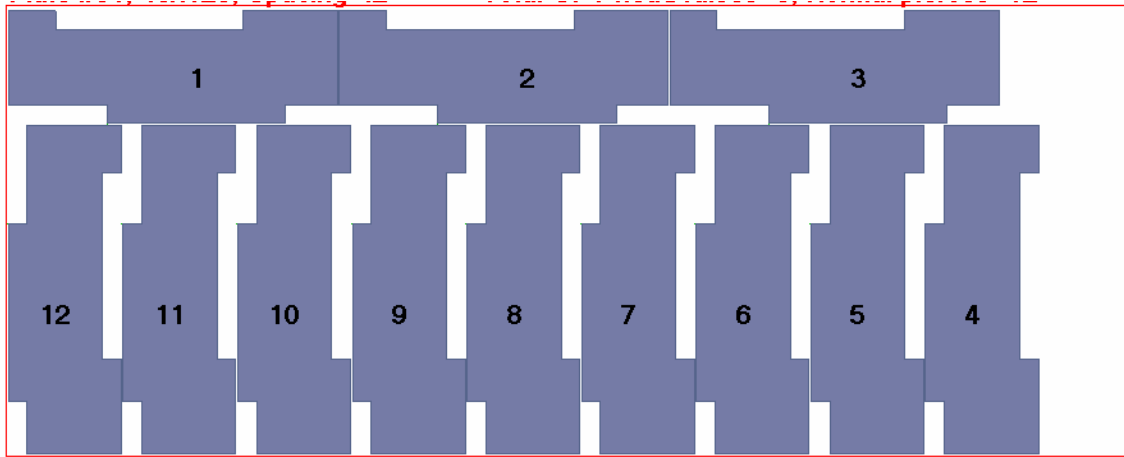
Entering Y in fields #41 and 42 will result in the software checking the drawing database before attempting to nest the part with the mirrored image.

36	Common cut	N	Y=Automatically common cut when possible, N=No common cut
37	Combine cut	N	Y=Automatically combine cut when possible, N=No combine cut
38	Allow gridding	Y	Y=Creates grids of parts, N=Only creates rows and columns
39	Check drawing for common cut	N	Y=Check drawing, N=Don't check drawing
40	Common cut spacing	.01	Common cut spacing defined from material database
41	Auto mirror	Y	Y=Allow auto mirror to maximize plate utilization
42	Use database for auto mirror	N	Check the drawing database to determine if the drawing can be mirror

Parts that have been mirrored are saved to the nest and the drawing directory with the notation that the part is the mirrored image of the original part.



Without Mirror / 12 parts



With Mirror / 14 parts

