

P.E.P. TECHNOLOGY[®]

Tomorrow's Automated Manufacturing Technology Today!

2006 P.E.P. REDUCES LASER RUN TIME AT STREATOR DEPENDABLE

- Streator Dependable updated their P.E.P. 2000 software to 2006 and increased their laser productivity by using:
- . CPT lead-in technology –finds the best location to assign the lead-in eliminating head raises and heat build-up.
 - . CPT rapid technology –analyzes the rapid path and outputs a mandatory head raise where required
 - . CPT cornering technology- analyzes the angles between all types of geometries and outputs a radius
 - . CPT post technology – outputs sprintlas piercing cycles, fixed & partial head raises and variable cutting speeds

THE REST OF THE STORY

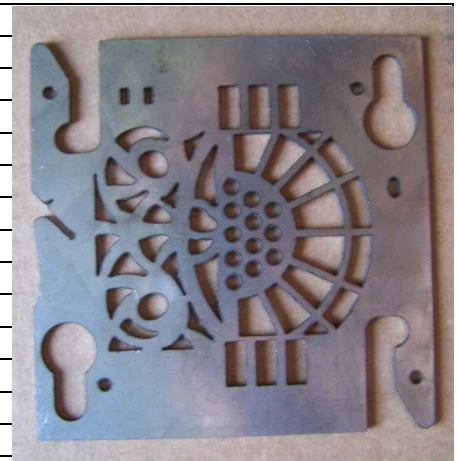
As part of the install Streator cut the 5"x5" part below on their CL-707 Laser and learned the following about the new methods and software capabilities of P.E.P. **The results were outstanding to say the least!**

2000 - Their old method of sequencing, locating the lead-in, assigning straight line lead-ins, cutting without radiusing the corners and posting with their 2000 post took their CL-707 nearly 10 minutes to cut 4 parts.

2006 - Using the 2006 CPT and Post technology the cut time for the same 4 parts was **reduced to 5 minutes.**

Although the feed rate increase was only 24% - from 145 IPM to 180 IPM! The other automated CPT techniques resulted in the part being **cut in half the time it took their 2000 software,** while maintaining the same part quality.

1	Company Name	Streator Dependable
2	Owners name	Chris Walker
3	General Mgr. name	Chris Walker
4	Laser operators experience	Name? 8 years experience
5	Programmers name	Gary Ondrey
6	Machine	CL-707 / Fanuc PC Based / 72*144
7	Type (ex. Hybrid, sheet dragger)	Flying Optics
8	Type of laser head (ex. spoon, non contact)	Non Contact
9	Rapid type (Straight vs. diagonal)	Straight
10	Partial Head Raise Time	1.0 seconds
11	Full Head Raise Time (Seconds / distance)	2.0
12	Percentage of feedrate for arcs	35
13	Location of cutting head on Bridge	Right
14	Name of optics supplier	IIVI
15	Type of machine positioning (straight vs. 45)	Straight
16	Material Description used in benchmark	14 Gage Mild Steel



	Test 1	Test 2	Test 3	Test 4		
	Benchmark Scenarios			Cut Times		
#	Description of test	T1	T2	T3	T4	Feed rate
19	T1...Nest & cut the 4 parts using the Mfr. Software & current parameters	:	----	----	----	
20	T2...Nest & Cut the 4 parts using your current P.E.P. CPT and posting parameters.	----	9:57	----	----	145
21	T3...Use T2 with line arc lead-in and radius all intersections 0-180 deg. w/.015"R	----	-----	:	----	
22	T4...Use T3 and increase the feedrate by 20%	----	----	----	4:55	180
23	Cut Quality (Scale of 1-10)		7.5		7.5	