P.E.P. TECHNOLOGY©

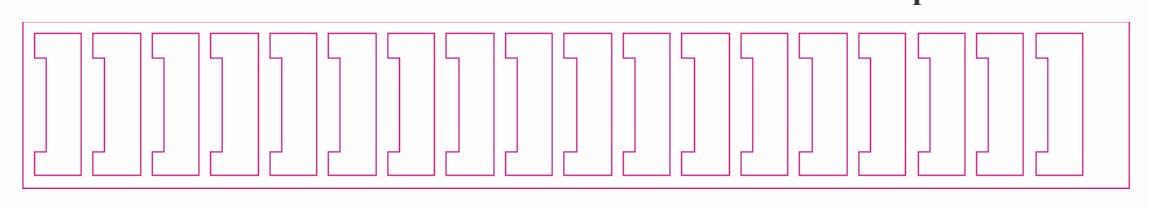
Nesting Technology Matters - Press Braking with P.E.P.

PRODUCTIVITY SUCCESS STORY by Robinson Metals

The attached part we sent is for the job we recently completed using the PEP Mini Nest feature. The part is U shaped, 4" wide with two 1" legs. The order was for 1800 pcs. Each part required two bends which took approximately 30 seconds per part with handling. The total brake time using our old method took 9 hrs. By using the PEP pressbrake feature we ran the same quantity of parts in groups of 18 pcs. per blank. The total time required to brake the 100 blanks (1800 parts) took about 1 hr .

Old way: 9 hrs press time
New way: 1 hr press time / 1/2 hr taking parts out of blank

18 piece mini nest



P.E.P. feature / Cad Converter Pressbrake layer 12-13-01

#	Comments	Part Qty	Old Method	New Method	Savings	Shop Rate	Dollars Saved
1	Pressbrake Operator was bending one part at a time. They now bend multiple parts simultaneously with the pressbrake layer.	1800	9 hours	1 hrs.	8 hrs.	$60.00	$480.00
2	Change in "Setup Time"		20 min.	5 min.	15 min.	$60.00	15.00
3	Change in handling finished parts		0	½ hour		$18.00	-9.00
4	Change in "# of rejects"						0
5	Change in "special tooling"						0
6	Profit from using the press brake mini nest approach					**Sub Total**	$486.00
7	**Remarks:** Breakdown of job using Press Brake Layer / Mini Nest approach to brake parts **Price quoted on 1800 piece job** 9 hrs. @ $ 60. = $540.00 **Estimated billing** **Actual brake work completed** 1 hr. @ $ 540. = $540.00 (in the same 9 hour period) 8 hrs. @ $ 60. = $480.00 **9 hrs. = $1,020. 00 Total billing** Other benefits derived from using the pressbrake layer . Operator safety . Operator's job is easier . Better bend consistency						
8	**Press Brake Summary** Additional annual profit from the "Pressbrake Layer" approach if used once per week. This is the amount of added profit made over and above what was quoted for the jobs.						**$24,960.00**

SAFETY SUCCESS STORY!

Although SAFETY was not mentioned. The 8 hour savings was the minor issue here. The real P.E.P. Success Story was the mental & physical savings of not having to brake each of the 1800 parts twice.

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