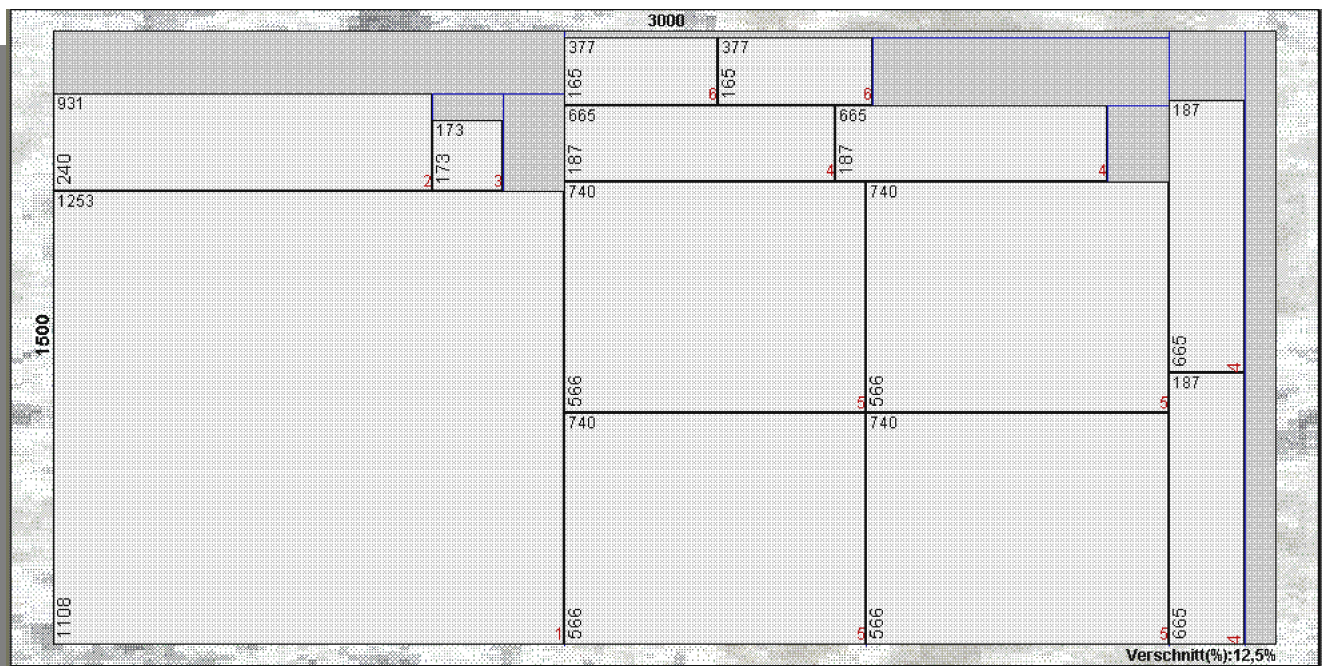


User Manual
LogiTOLE rectangular nesting
LogiBARRE linear nesting



LogiTOLE

LogiBARRE

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Installation of LogiTOLE

Installation from CD-ROM

- Put the CD into the CD-ROM drive and the setup starts within a few seconds.
- If the setup doesn't start automatically click on the START then RUN.
- Type D:\AUTORUN(.EXE), then click on OK. Or click on the CD in the explorer
- Further choose the option "LogiTOLE, LogiBARRE, LogiCOST cutting optimizer " from the menu.
 - Choose „Install version 5”.
 - If you have to enter a password, enter „tol”.
- Then click on next.
 - Confirm the folder C:\Programme\Logitole_V5\ with Next.
 - Confirm the folder C:\Data_Logitole_V5\ with Next.
 - Files will be installed.
- Close all windows and start LogiTOLE by double clicking on the created icon on the desktop.
 - Click on “**password**” in the menu. The following window opens:

The screenshot shows a dialog box titled "Password" with three tabs: "Password", "Transfer license to new PC", and "Apply for password". The "Apply for password" tab is selected. Inside this tab, there is a section "Select your options/version" with four checkboxes: "LogiTOLE: rectangular nesting" (checked), "LogiBARRE: nesting for linear parts", "LogiCOST: Quotation system", and "LogiTOLE Lite: rectangular nesting". To the right of this section are four input fields: "Company", "Town/country", "Name of PC/User" (with the text "PC_XP_03" entered), and "Fax N*". Below these fields are two buttons: "Send per email" and "Send per fax". At the bottom center of the dialog is an "Exit" button.

- Fill in all fields, choose option LogiTOLE and then click on send via email or send via fax.

The best is to send via email. For this start your email software, create a new message and press the <CTRL> and V buttons or „Process“, „Paste“. All information (e.g. Serial No.) are pasted automatically in the email.

Send your email to. info@tolsoftware.com

and fax to: +49 8661 98 396-99

The password will be sent to you per email or fax. Enter it under „Password“.

Transfer license to another PC

Before you can transfer the license to another PC you have to install LogiTOLE on the new PC.

Therefore click under Password on „Transfer license to new PC“.

Three steps are necessary and you need an empty, formatted floppy disk.

The transfer of the licence works only when LogiTOLE is activated **permanently**.

- Step 1 on the new PC: Insert floppy disk and click on step 1.
- Step 2 on the old PC: Insert floppy disk and click on step 2.
- Step 3 on the new PC: Insert floppy disk and click on step 3.

What is LogiTOLE?

LogiTOLE is a nesting software for rectangular parts and can be used for all types of sheet material: metal, glass, plastic, wood etc.

It is possible to enter different parts with a name and xy dimensions.

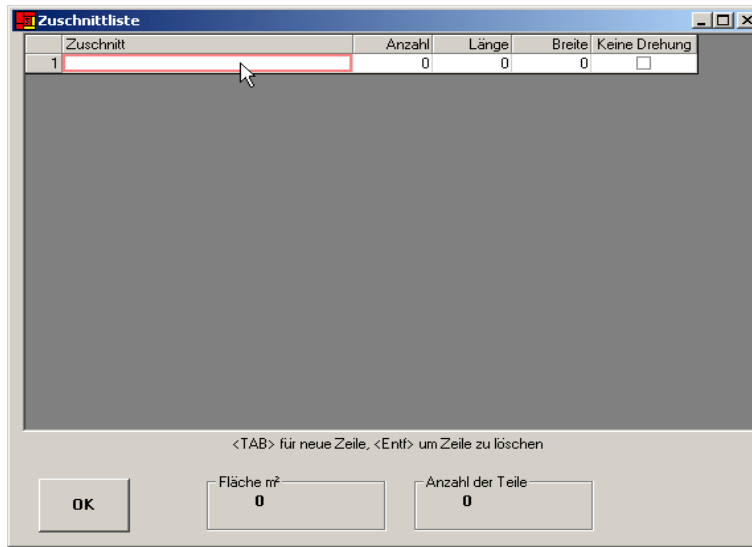
It will keep track of your stock off sheets and nest the parts onto the sheets also trying to use the remnants first.

Using LogiTOLE

Create a new list of parts

Start LogiTOLE.

Click on the icon  (new file) and a window appears:



Zuschnitt	Anzahl	Länge	Breite	Keine Drehung
1	0	0	0	<input type="checkbox"/>

<TAB> für neue Zeile, <Entf> um Zeile zu löschen

OK Fläche m² 0 Anzahl der Teile 0

Enter the necessary parameter.

Use the **TAB** button to jump from field to field or to open a new row.

Part name: Enter name of part.

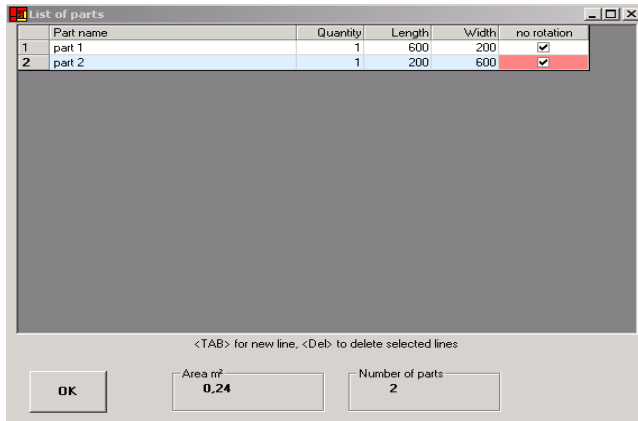
Quantity: Enter number of required parts.

Length: Length of the part in millimetres.

Width: Width of the part in millimetres.

No rotation: With a check mark in this field the parts **can't be rotated** during the nesting (cutting direction, etc.). If **no rotation** is activated the length of the path will always be aligned to the length of the sheet.

Example: Length of sheet is 3000 and width of sheet is 1500. Part 1 has a length of 600 and a width of 200. Part 2 has a length of 200 and a width of 600. If no rotation is activated part 1 will be aligned with the length of 600 to the sheet and part 2 will be aligned with the length of 200. View the picture below:




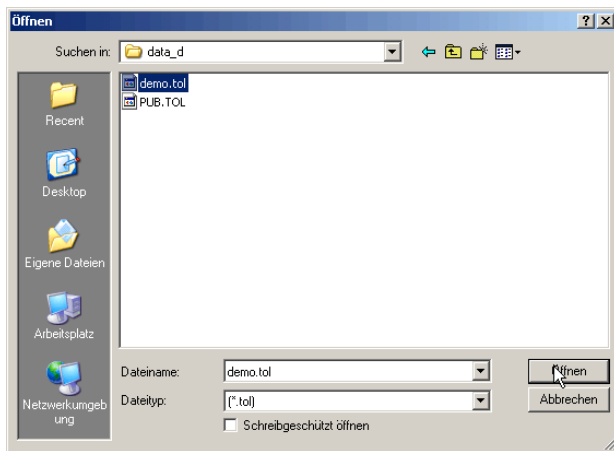
If the list of parts is prepared click on the icon .

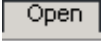
Now it's time to create a new list of sheets.

If you don't want to open an existing parts file skip the following chapter.


Open an existing parts file

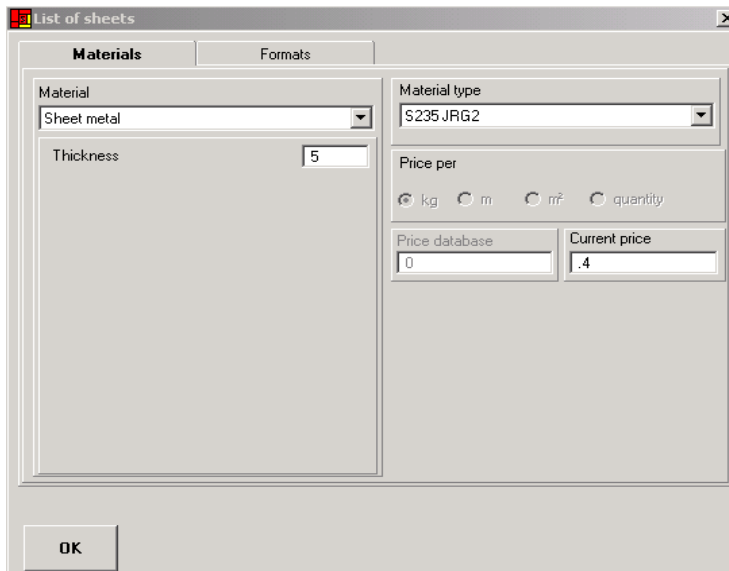
Instead of creating a new list of parts you can also open an existing file of the type *.tol by clicking on  (Open). The following window opens:



After you have chosen the required file click on . The list of parts appears on the screen and it is possible to make changes and to modify it.

Create a new list of sheets


To create a new list of sheets click on this icon  (list of sheets). The following window will be shown:

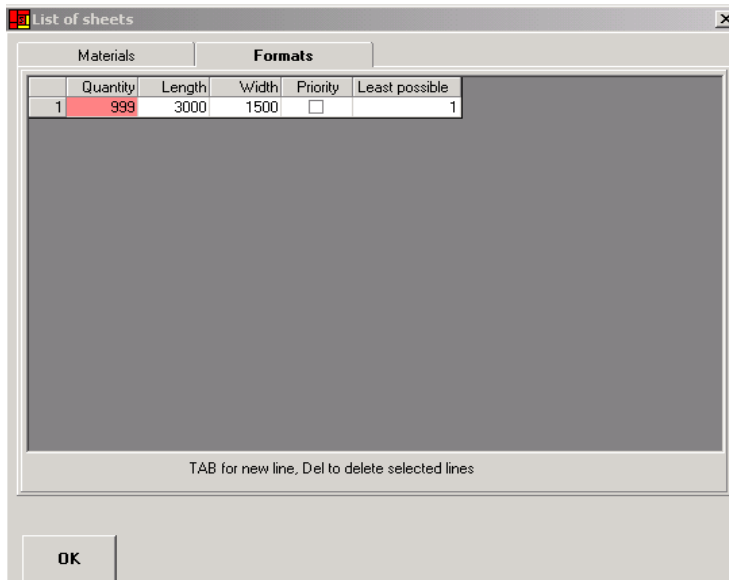


The 'List of sheets' dialog box is shown in the 'Materials' tab. It contains the following fields and controls:

- Material:** A dropdown menu with 'Sheet metal' selected.
- Material type:** A dropdown menu with 'S235JRG2' selected.
- Thickness:** A text input field containing the value '5'.
- Price per:** Radio buttons for 'kg', 'm', 'm²', and 'quantity', with 'kg' selected.
- Price database:** A text input field containing '0'.
- Current price:** A text input field containing '.4'.
- OK:** A button at the bottom left.

You don't have to change all parameter here to calculate a new nesting.

Go on by clicking on .



The 'List of sheets' dialog box is shown in the 'Formats' tab. It displays a table with the following data:

	Quantity	Length	Width	Priority	Least possible
1	999	3000	1500	<input type="checkbox"/>	1

Below the table, there is a text instruction: "TAB for new line, Del to delete selected lines". An "OK" button is located at the bottom left.

Quantity: Number of the existing sheets.


Length: Length of the sheet.

Width: Width of the sheet.


Priority: With a check mark LogiTOLE uses this sheet with priority.

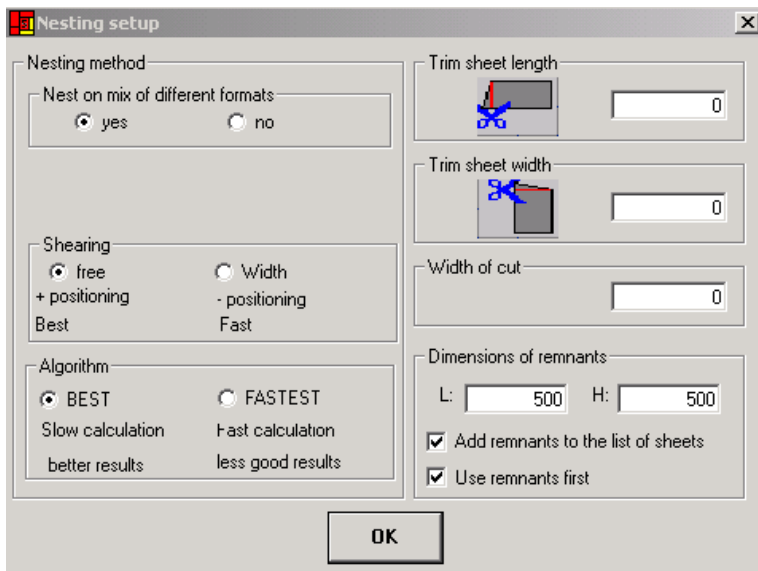
Least possible: Before the calculation starts LogiTOLE calculates the number of sheets that are required at least to nest all parts on this format with a waste of 0%.

Use the **TAB** button to jump from field to field or to open a new row. The button **DEL** deletes an existing row.

If you have defined all parameters click on .

Nesting setup

Having created the list of parts and the list of sheets you can now define the nesting setups. To do this click on this icon  (Nesting setup). The following window will be shown:



IMPORTANT: „Nest on mix of different formats“

YES:

It is possible to nest several formats, the parts can be mixed. As a result it is possible to use remnants.

NO:

Several solutions are calculated, whereas the different sheet formats can't be mixed but the best solution can be chosen.

„Use remnants first “

LogiTOLE nests first on this remnants. You shouldn't forget to activate the priority in the list of sheets in the relevant column.

Shearing, free: LogiTOLE asks you if it is allowed to cut the sheet in both directions or only along the width.

Algorithm: Here you can choose if you want to select a slower, but better calculation or a faster with more waste.

Trim sheet length and width: If you want you can enter a value in millimetres to trim the sheet length or width.

Width of cut: Value for width of tool or 0.

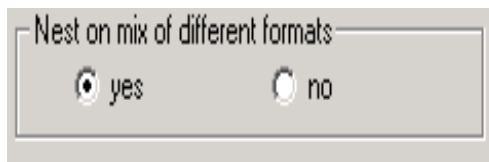
Dimensions of remnants L and H : Values for the length and width of the remnants. All rests which are bigger or the same like this value will be used as remnants.

Add remnants to the list of sheets: With a check mark the rests will be adopted in the list of sheets.

Use remnants first: With a check mark the remnants will be used first at the next nesting.

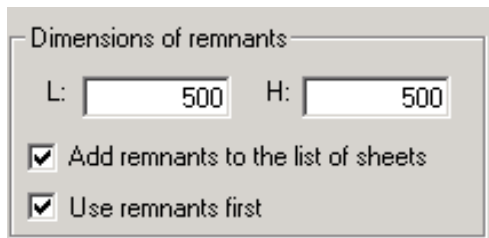
ATTENTION:


If you use this function you have to activate the „**Nest on mix of different formats**“ with „**YES**“.




If you don't want to mix the different formats you have set to „**NO**“.

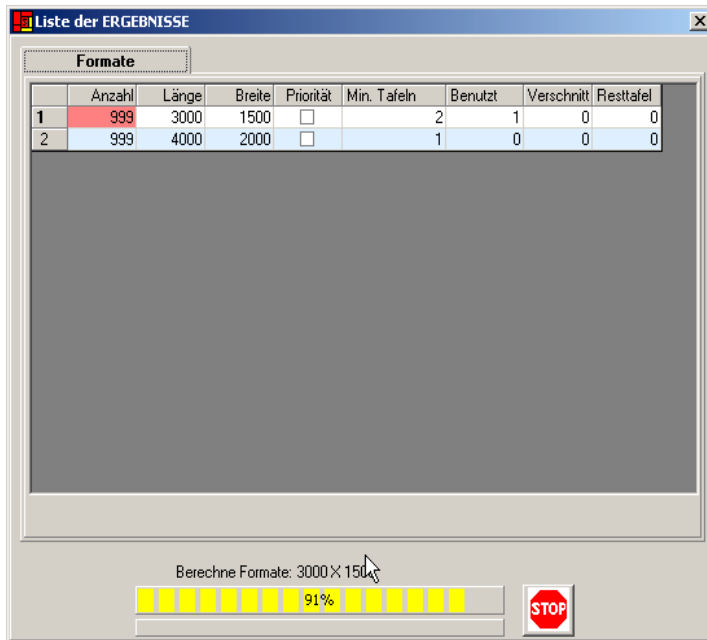
If no remnants were created you probably forgot to enter the dimensions of remnants in the nesting setup:



With a click on  you save the nesting setup.


Nesting


Now you can start the nesting. To do this click on this icon  (Nest). The following picture will be shown:





If the calculation has finished the button  appears.

There are two possibilities :


Did you choose in the settings “**Nest on mix of different formats**” “**YES**” you will get after the calculation and with a click on the button  the nesting window (there is only one possibility for the nesting).

If you choose in the settings “**Nest on mix of different formats**” “**NO**” you will get the different formats with the specific waste. The best nesting is marked red and after clicking on the button  it will be shown. If you want to see the other solutions you have to choose it in the menu of the nesting window.

If you click on  the window will be closed. To open the window again, start again the nesting with a click on the icon .

The nesting window looks like this:

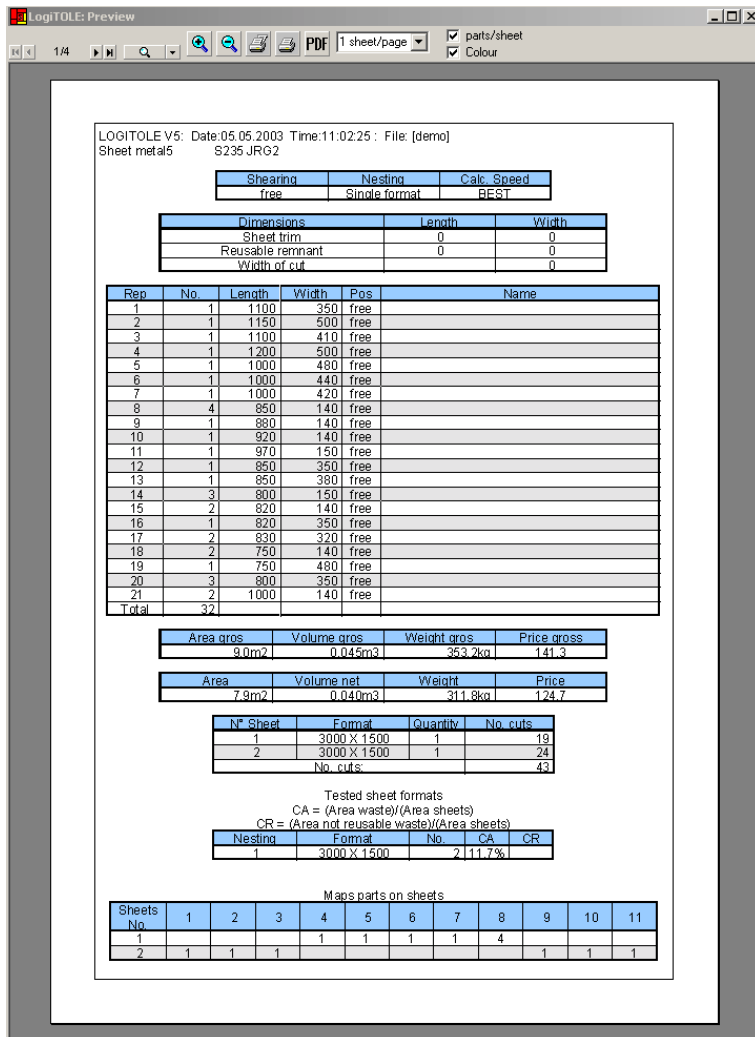
Print results

To do that click on this icon .

The window below will be shown. Here you get the following information:

The nesting settings, the list of parts, the area of all parts in m², the used sheet formats, the remnants and the map parts on sheets, but only if you

have activated it in this field parts/sheet Colour.



LOGITOLE V5: Date:05.05.2003 Time:11:02:25 : File: [demo]
Sheet metals S235 JRG2

Shearing	Nesting	Calc. Speed
free	Single format	BEST

Dimensions	Length	Width
Sheet trim	0	0
Reusable remnant	0	0
Width of cut		0

Rep	No.	Length	Width	Pos	Name
1	1	1100	350	free	
2	1	1150	500	free	
3	1	1100	410	free	
4	1	1200	500	free	
5	1	1000	480	free	
6	1	1000	440	free	
7	1	1000	420	free	
8	4	850	140	free	
9	1	880	140	free	
10	1	920	140	free	
11	1	970	150	free	
12	1	850	350	free	
13	1	850	380	free	
14	3	800	150	free	
15	2	820	140	free	
16	1	820	350	free	
17	2	830	320	free	
18	2	750	140	free	
19	1	750	480	free	
20	3	800	350	free	
21	2	1000	140	free	
Total	32				

Area gros	Volume gros	Weight gros	Price gross
9.0m ²	0.049m ³	353.2kg	141.3

Area	Volume net	Weight	Price
7.9m ²	0.040m ³	311.8kg	124.7

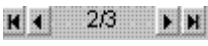
N° Sheet	Format	Quantity	No. cuts
1	3000 X 1500	1	19
2	3000 X 1500	1	24
No. cuts:			43

Tested sheet formats
CA = (Area waste)/(Area sheets)
CR = (Area not reusable waste)/(Area sheets)

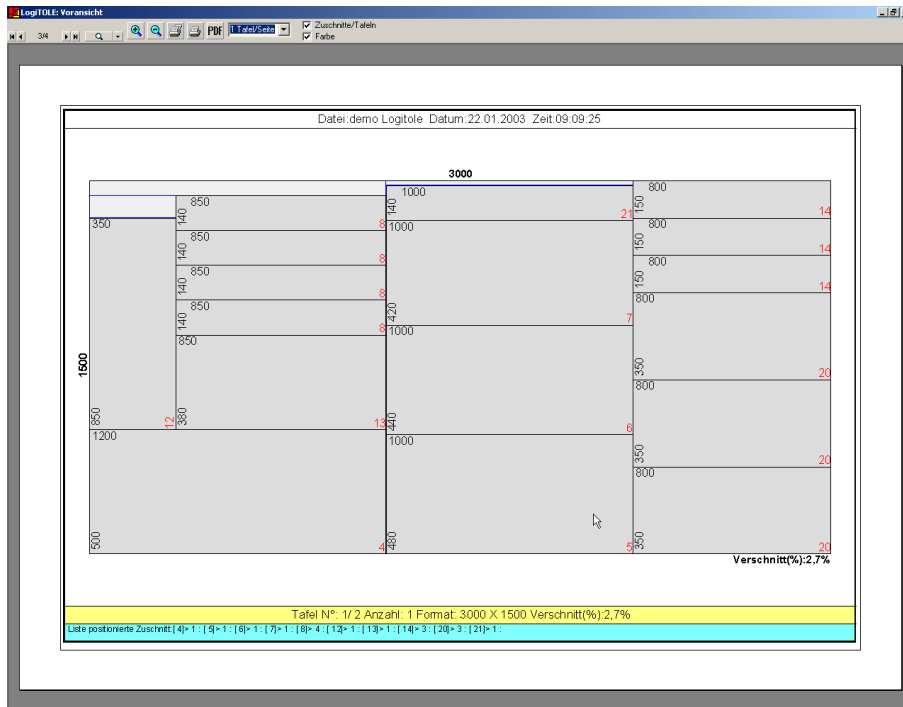
Nesting	Format	No.	CA	CR
1	3000 X 1500		2.111.7%	

Maps parts on sheets

Sheets No.	1	2	3	4	5	6	7	8	9	10	11
1											
2	1	1	1	1	1	1	1	4	1	1	1

To show the next pages use this icon , to change the size of the page take this one .

If you use a colour printer it is possible to choose it here: parts/sheet Colour



To start the print click on one of the these icons:

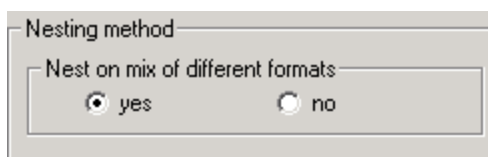


With the first icon you print all pages and with the second only the current page.

Important Hints

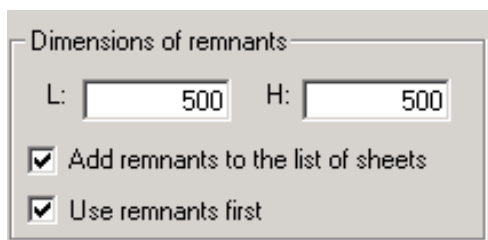
Use remnants first


If you want to use this function for the next nesting you have to go to the nesting settings and there choose the following function:



If you don't want to mix the different formats at set to „NO“.


If no remnants were created you probably forgot to enter the dimensions of remnants in the nesting setup:

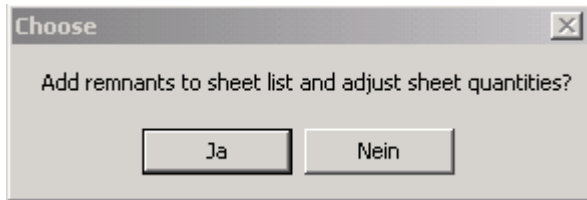


With a click on  you save the nesting setup

Add remnants to the list of sheets

If any rests did remain after the nesting it is possible to take them to the list of sheets and to use them first at the following nesting. To do that click

on the following icon  (Add remnants to the list of sheets).



Confirm with **“YES”**.

Create new material

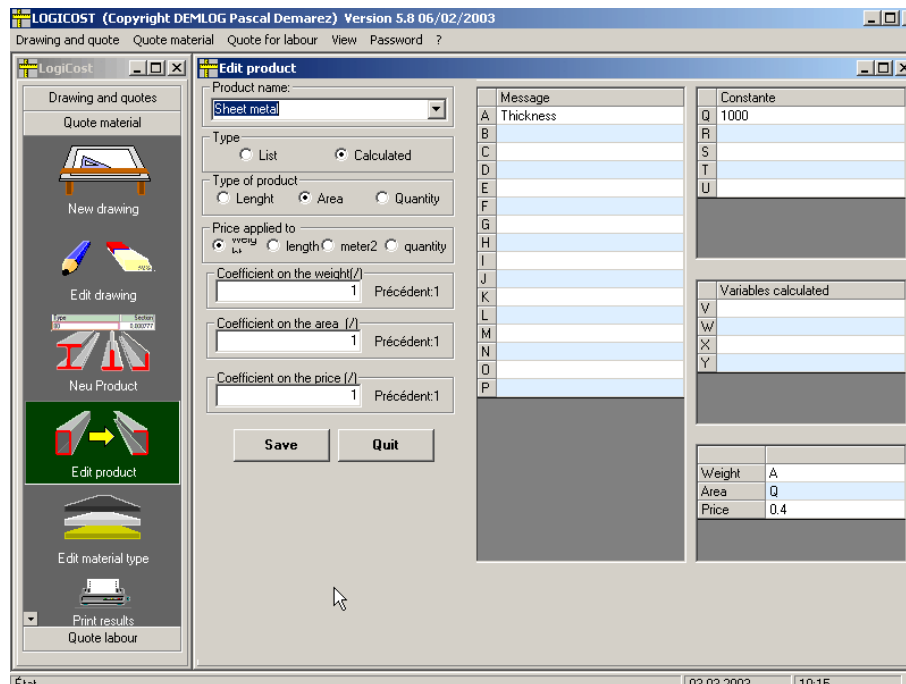
LogiTOLE is delivered with some types of material. To create a new type of material just do the following steps:

Start LogiCOST (a program that is installed automatically if you install LogiTOLE). You will get the message that the program runs in demo mode. Confirm with **“OK”**. Here it is possible to create a new material.

Click on **„Edit product“** and choose an existing product name. To view how the settings have to be made.

Now click on **“Create product”**.

Set the necessary parameters like shown in the following picture:



Click on **„save“** if you have finished. This material can now be used in LogiTOLE.

Interface to administration systems

LogiTOLE has the following interfaces:

To read a list of parts to be cut we can use either an advanced EXCEL CSV file or a simple text file in the following format:

```
File: AUFtrag.tol
Quantity, Length, width, 0=Allow rotation 1=stop rotation,
"Partname"
File can also be produced and read with a more advanced interface
in csv format.
See c:\programme\LogiTOLE_V5\excel-pps.csv as an example.
File starts here

',
1,500,500,0,"Zuschnitt-1"
2,1000,1000,0,"Zuschnitt-2"
```

```
Excel CSV Format
$$=ACEFG (Part Name, Quantity, Length, Width,
Alignment);;;;Column definition Partname is in column A;;
Partname;Free;Quantity;Free;Length;Width;Allignment;$$;Start of
Data
Side Part;a;10;125;750,1;300;0;;
Back plate;b;20;136;300,2;400;1; ;
Rear door;c;5;136;650,3;550;0;$$;End of Data
```

To read a list of sheets and remnants to be used we can read in the list in the following format. The filename is also important.

This file can then be modified by LogiTOLE to contain the corrected number of sheets and new remnants after cutting the job.

```
Filename      Blech5S235JRG2.dat in folder
c:\Data_LogiTOLE_V5\product_d\
Blech         Material
5             Thickness
S235JRG2     Materialtype

File format for transmitting the available format.
At the end of the nesting the file is modified by the program to
contain the new remnants
The quantity of original sheets is also adjusted.
Quantity, Length, Width, Zero=complete sheet 1= Remant
File starts after this line
999,3000,1500,0
998,2500,1250,0
999,2000,1000,0
1,2000,250,1
1,500,750,1
```

Installation of LogiBARRE

Installation from CD-ROM

See chapter „Installation of LogiTOLE“.

Transfer license to another PC

See chapter "Transfer license to another PC" in LogiTOLE

What is LogiBARRE?


LogiBARRE is a program to nest parts that are cut to length. This can be pipes girders or any linear product.

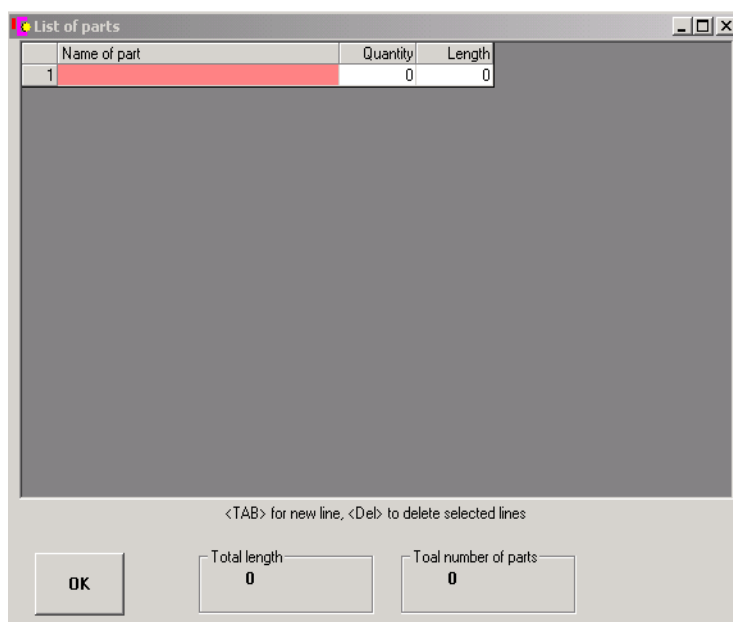
You enter the different parts and lengths and it is also possible to define the width of cutting etc. The parts are optimized on different raw materials with consideration of your stock.

Using LogiBARRE

Create new list of parts

Having started LogiBARRE,

click on the icon  (New list of parts) and the following window will be shown:



Name of part	Quantity	Length
1	0	0

<TAB> for new line, to delete selected lines

OK Total length: 0 Total number of parts: 0

Enter the following parameters.

Use the **TAB** button to get to the next fields.

Name of part:

Enter name of part.


Quantity: Enter number of parts.

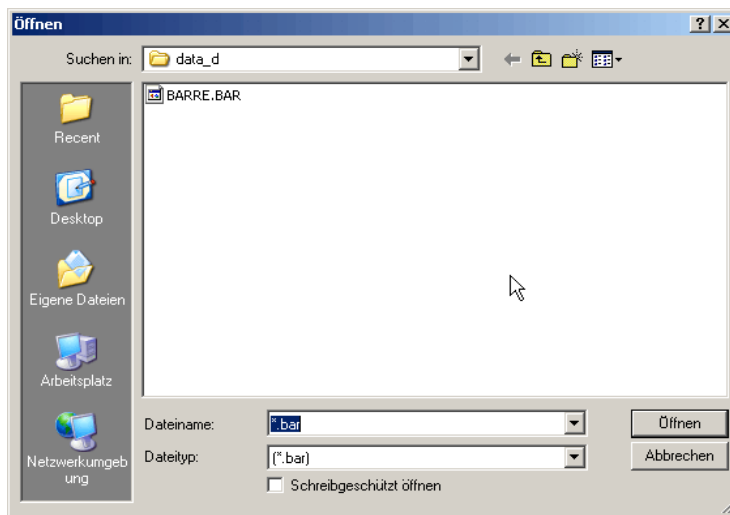
Length: Enter length of parts.


If you have finished click on the button .

It is possible too, to open an existing parts file and to process it. If you don't want to do that skip the following chapter.

Open an existing parts file


To open an existing file (list of parts) click on the icon  (Open). The following window will be shown:

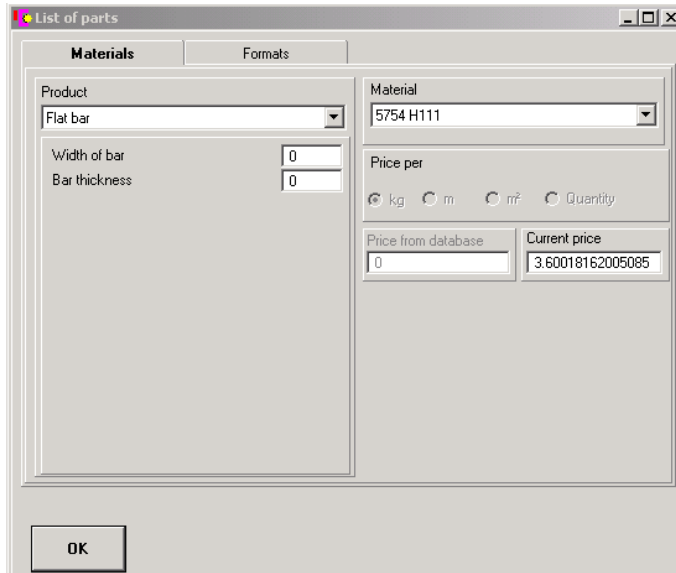


Having chosen a file click on .

The list of parts appears on the screen and it is possible to edit and change it.

List of raw materials

Click on this icon  to open the existing list of raw materials.



Materials

Product: Flat bar

Material: 5754 H111

Width of bar: 0

Bar thickness: 0

Price per: kg m m² Quantity

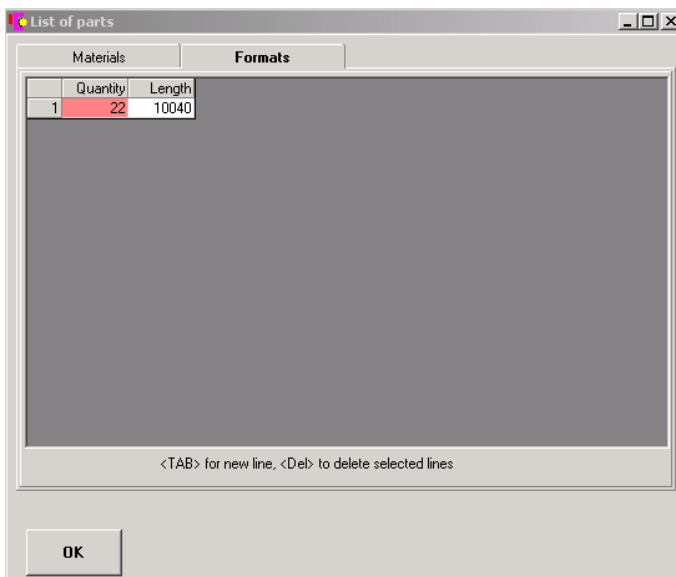
Price from database: 0

Current price: 3.60018162005085

OK

Choose the relevant product. It isn't important to change all parameters here to calculate a nesting.

Further click on .



Formats

Quantity	Length
1	10040


<TAB> for new line, to delete selected lines

OK


Quantity: Number of raw materials you have on inventory.

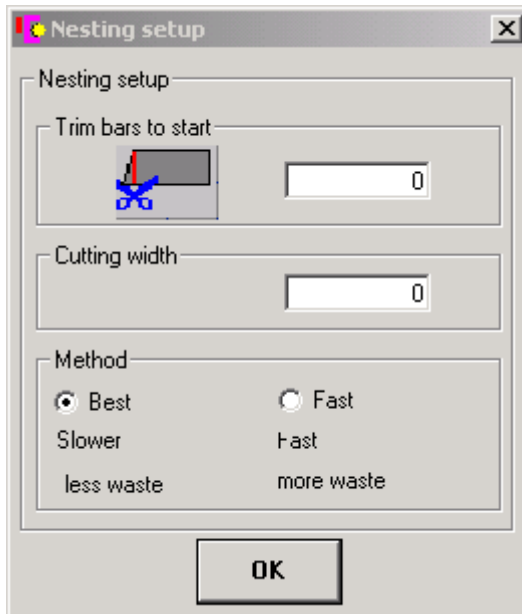
Length: Length of the raw materials.

Use the **TAB** button to jump from field to field or to open a new row. The button **DEL** deletes an existing row.

If all parameters have been defined click on .

Nesting setup


Having created the list of parts and the list of raw materials you can now enter the nesting setup. To do that click on this icon . The following window will be shown:




Trim bars to start: Value in mm. Each raw material will be trimmed with this value.

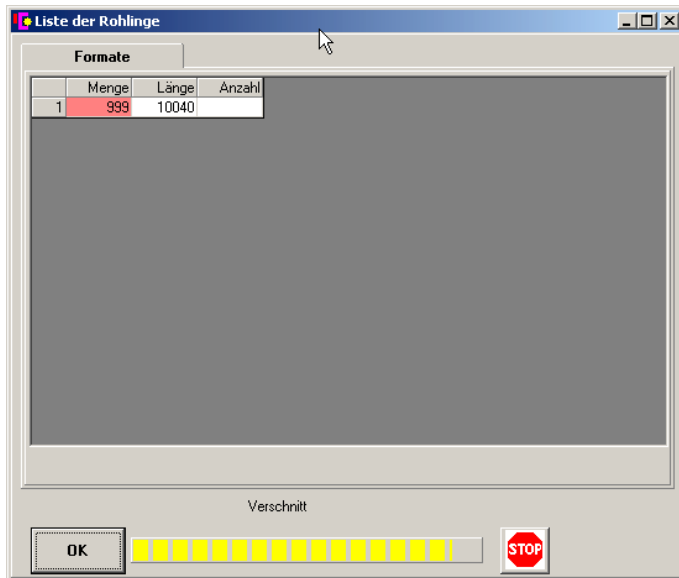
Cutting width: Width of the tool in mm.

Method: Here you can choose the calculation method.


If all parameters have been adjusted click on . Now you can start the nesting.

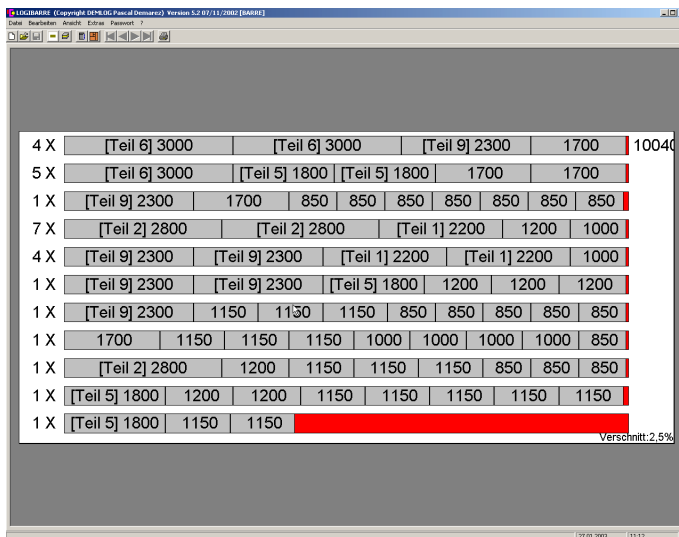
Nesting

To start the nesting click on this icon . The following window will be shown:



If the calculation has finished the button  appears.

Click on  and the nesting will be shown on the screen.



Use icons to browse pages.



: Show first page



: Show previous page



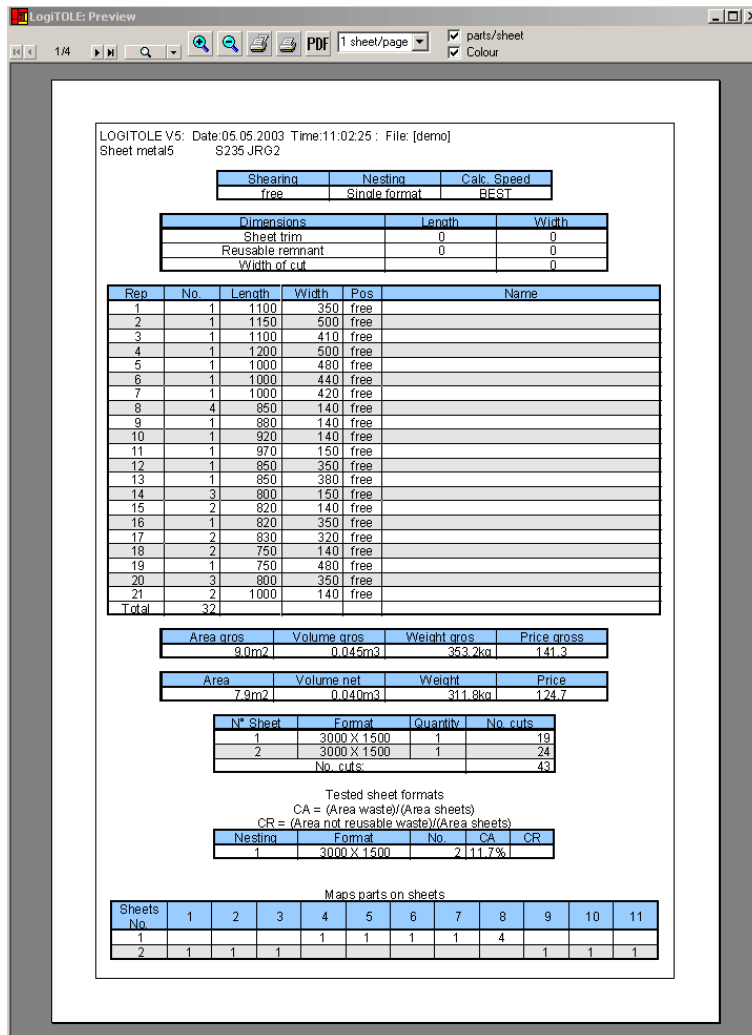
: Show next page



: Show last page

Print results

To print the results click on this icon . The following window will be shown:



LOGITOLE V5: Date:05.05.2003 Time:11:02:25 : File: [demo]
Sheet metal5 S235 JRG2

Shearing	Nesting	Calc. Speed
free	Single format	BEST

Dimensions	Length	Width
Sheet trim	0	0
Reusable remnant	0	0
Width of cut		0

Rep	No.	Length	Width	Pos	Name
1	1	1100	350	free	
2	1	1150	500	free	
3	1	1100	410	free	
4	1	1200	500	free	
5	1	1000	480	free	
6	1	1000	440	free	
7	1	1000	420	free	
8	4	850	140	free	
9	1	880	140	free	
10	1	920	140	free	
11	1	970	150	free	
12	1	850	350	free	
13	1	850	380	free	
14	3	800	150	free	
15	2	820	140	free	
16	1	820	350	free	
17	2	830	320	free	
18	2	750	140	free	
19	1	750	480	free	
20	3	800	350	free	
21	2	1000	140	free	
Total	32				

Area gros	Volume gros	Weight gros	Price gros
9.0m2	0.045m3	353.2kg	141.3

Area	Volume net	Weight	Price
7.9m2	0.040m3	311.8kg	124.7

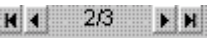

N° Sheet	Format	Quantity	No. cuts
1	3000 X 1500	1	19
2	3000 X 1500	1	24
No. cuts			43

Tested sheet formats
CA = (Area waste)/(Area sheets)
CR = (Area not reusable waste)/(Area sheets)

Nesting	Format	No.	CA	CR
1	3000 X 1500	2	11.7%	



Maps parts on sheets

Sheets No.	1	2	3	4	5	6	7	8	9	10	11
1				1	1	1	1	4			
2	1	1	1						1	1	1

To show the next pages use this icon , to change the size of the page take this  one.

If you use a colour printer it is possible to choose it here:

Parts/bar
 Colour

To start the print click on one of these icons:  

With the first icon you print all pages and with the second only the current page.

About this manual

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