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Bar Nesting Software - PLUS 1D Report

Project Details

| | |
|---------------------|------------------------------------|
| Project Name | Ash grove |
| File Name | C:/PLUS 1D/sample/twomaterials.pld |
| Job Order | 6x356/03 |
| Customer | F/3511 |
| Issued By | Ling |
| Remarks | Champgne Gold |
| Date | Wednesday, October 08, 2003 |

Summary of Optimization Results

| | |
|-----------------------------------|-----------|
| Project Name | Ash grove |
| Number of Layouts | 6 |
| Number of Stock Used | 6 |
| Total Parts Required | 34 |
| Total Parts Nested | 34 |
| Total Utilization | 98.131 |
| Overall Cost | 1976 |
| Minimum Offcut Size | 500 |
| Loss per cut | 4 |
| Total Part Length | 34.68 [m] |
| Total Stock Length | 36.6 [m] |
| Total Stock Weight | 36.6 |
| Total Part Weight | 34.68 |
| Total Offcut Weight | 1.236 |
| Total Scrap Weight | 0.684 |
| Cutting time (in Minutes) | 28 |
| Machine loading time (in Minutes) | 6 |
| Total Machine (in Minutes) | 34 |

Summary of Layouts

| No. | Material | Stock | Size | Qty | Util | Rest | Details [PartLength x Qty] |
|-----|----------------------|-----------|------|-----|-------|--------|-----------------------------|
| 1 | L203 x 203 x 28.6 | 3991_6100 | 6100 | 1 | 99.51 | 6 | 1720x2 940x1 750x1 470x2 |
| 2 | L203 x 203 x 28.6 | 3991_6100 | 6100 | 1 | 98.85 | 54 | 1720x2 1650x1 940x1 |
| 3 | L203 x 203 x 28.6 | 3991_6100 | 6100 | 1 | 93.44 | 384 | 1650x3 750x1 |
| 4 | L203 x 203 | 3991_6100 | 6100 | 1 | 99.61 | (1236) | 1200x2 750x2 470x2 |

| No. | Material | Stock | Size | Qty | Utl | Rest | Details [PartLength x Qty] |
|-----|-------------|-----------|------|-----|-------|------|------------------------------|
| | x 28.6 | | | | | | |
| 5 | W1100 x 499 | 3992_6100 | 6100 | 1 | 98.03 | 96 | 1200x1 1075x2 940x2 750x1 |
| 6 | W1100 x 499 | 3992_6100 | 6100 | 1 | 99.34 | 8 | 940x4 750x2 400x2 |

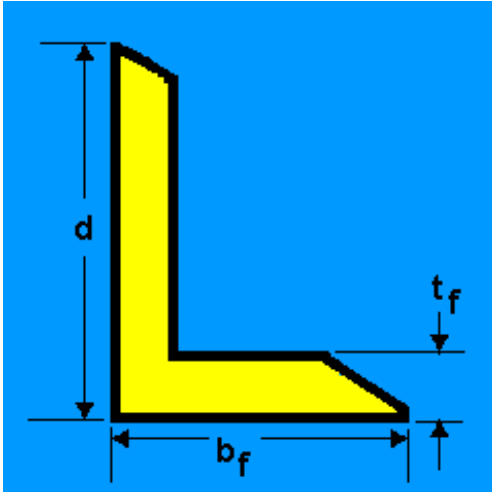
Stock Details[Job Order = 6x356/03]

| Stock | Material | Length | Qty | Cost | Stk Wt [Kg] | Remarks | Used |
|-----------|-------------------|--------|-----|------|-------------|---------|------|
| 3991_6100 | L203 x 203 x 28.6 | 6100 | 100 | 444 | 6.1 | | 4 |
| 3992_6100 | W1100 x 499 | 6100 | 100 | 100 | 6.1 | | 2 |

Part Details

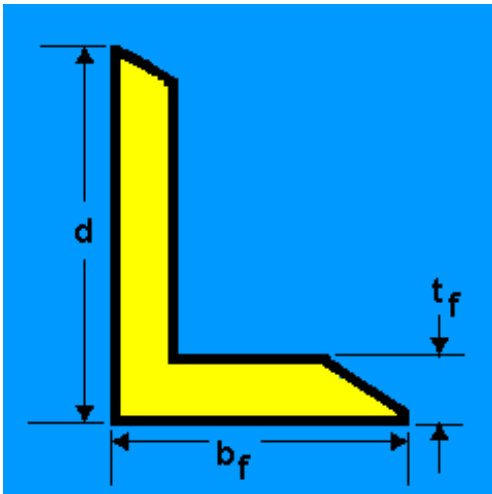
| Part | Material | Length | Qty | Cut | Weight | Remarks |
|------|-------------------|--------|-----|-----|--------|---------|
| a1 | L203 x 203 x 28.6 | 1200 | 2 | 2 | 1.2 | |
| a2 | L203 x 203 x 28.6 | 940 | 2 | 2 | 0.94 | |
| a3 | L203 x 203 x 28.6 | 750 | 4 | 4 | 0.75 | |
| a4 | L203 x 203 x 28.6 | 470 | 4 | 4 | 0.47 | |
| a5 | L203 x 203 x 28.6 | 1720 | 4 | 4 | 1.72 | |
| a6 | L203 x 203 x 28.6 | 1650 | 4 | 4 | 1.65 | |
| b1 | W1100 x 499 | 1200 | 1 | 1 | 1.2 | |
| b2 | W1100 x 499 | 1075 | 2 | 2 | 1.075 | |
| b3 | W1100 x 499 | 940 | 6 | 6 | 0.94 | |
| b4 | W1100 x 499 | 750 | 3 | 3 | 0.75 | |
| b5 | W1100 x 499 | 400 | 2 | 2 | 0.4 | |

Layout 1 of 6



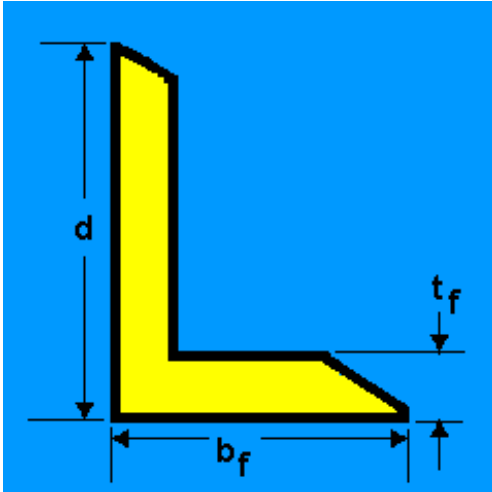
| | | | | | |
|-----------------|----------------------------|-------------|------------|-------------|-----------|
| Stock:3991_6100 | Material:L203 x 203 x 28.6 | Length:6100 | Qty:1 | Utl %:99.51 | No |
| Offcuts | | | | | |
| [a5] 1720x2 | [a2] 940x1 | [a3] 750x1 | [a4] 470x2 | | |
| 1720x2 | 940x1 | 750x1 | 470x2 | | |
| a5 | a5 | a2 | a3 | a4 | a4 |
| 1720 | 1720 | 940 | 750 | 470 | 470 |

Layout 2 of 6



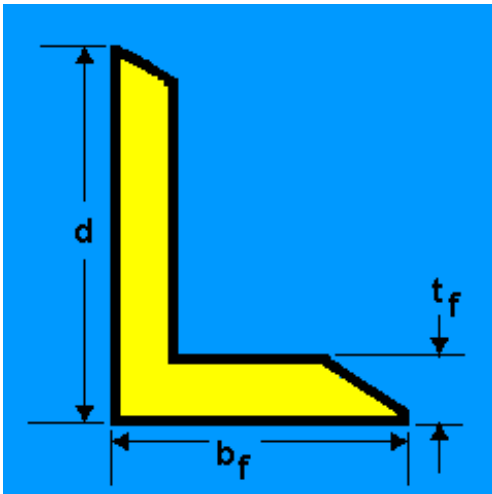
| | | | | | |
|-----------------|----------------------------|-------------|-----------|-------------|----|
| Stock:3991_6100 | Material:L203 x 203 x 28.6 | Length:6100 | Qty:1 | Utl %:98.85 | No |
| Offcuts | | | | | |
| [a5] 1720x2 | [a6] 1650x1 | [a2] 940x1 | | | |
| 1720x2 | 1650x1 | 940x1 | | | |
| a5 | a5 | a6 | a2 | | |
| 1720 | 1720 | 1650 | 940 | | |

Layout 3 of 6



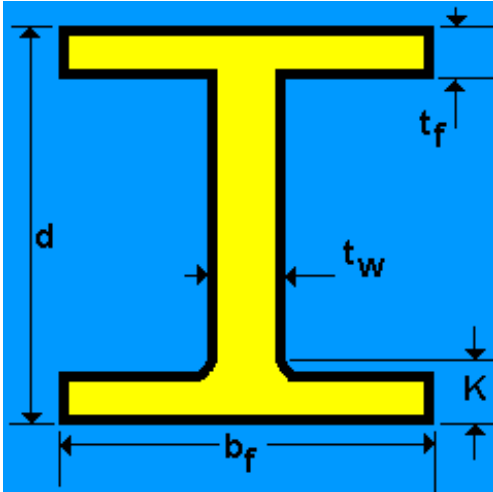
| | | | | | |
|------------------------|----------------------------|-------------|-----------|-------------|----|
| Stock:3991_6100 | Material:L203 x 203 x 28.6 | Length:6100 | Qty:1 | Utl %:93.44 | No |
| Offcuts | | | | | |
| [a6] 1650x3 [a3] 750x1 | | | | | |
| 1650x3 750x1 | | | | | |
| a6 | a6 | a6 | a3 | | |
| 1650 | 1650 | 1650 | 750 | | |

Layout 4 of 6



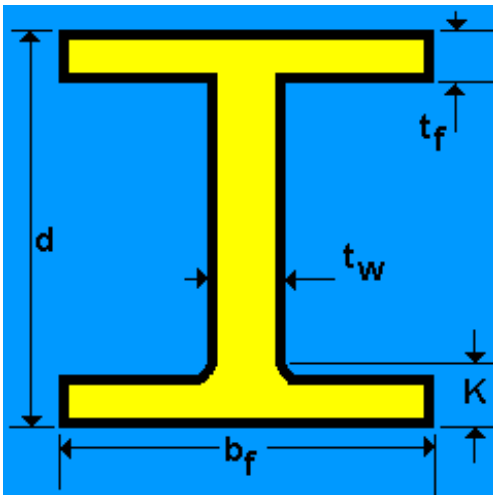
| | | | | | | |
|-----------------------------------|----------------------------|-------------|-----------|-------------|-----------|------------|
| Stock:3991_6100 | Material:L203 x 203 x 28.6 | Length:6100 | Qty:1 | Utl %:99.61 | | |
| Offcut:1236 | | | | | | |
| [a1] 1200x2 [a3] 750x2 [a4] 470x2 | | | | | | |
| 1200x2 750x2 470x2 | | | | | | |
| a1 | a1 | a3 | a3 | a4 | a4 | Off |
| 1200 | 1200 | 750 | 750 | 470 | 470 | 1236 |

Layout 5 of 6



| | | | | | | | |
|------------------------|-------------|-----------------------------|------------|--------------------|--------------|--------------------|-------------------|
| Stock:3992_6100 | | Material:W1100 x 499 | | Length:6100 | Qty:1 | Utl %:98.03 | No Offcuts |
| [b1] 1200x1 | [b2] 1075x2 | [b3] 940x2 | [b4] 750x1 | | | | |
| 1200x1 | 1075x2 | 940x2 | 750x1 | | | | |
| b1 | b2 | b2 | b3 | b3 | b4 | | |
| 1200 | 1075 | 1075 | 940 | 940 | 750 | | |

Layout 6 of 6



| | | | | | | | |
|------------------------|------------|-----------------------------|-----------|--------------------|--------------|--------------------|-------------------|
| Stock:3992_6100 | | Material:W1100 x 499 | | Length:6100 | Qty:1 | Utl %:99.34 | No Offcuts |
| [b3] 940x4 | [b4] 750x2 | [b5] 400x2 | | | | | |
| 940x4 | 750x2 | 400x2 | | | | | |
| b3 | b3 | b3 | b3 | b4 | b4 | b5 | b5 |
| 940 | 940 | 940 | 940 | 750 | 750 | 400 | 400 |

Offcut/Drops List

| No. | From Stock | Size | Qty | Weight | Cost | Material |
|-----|------------|------|-----|--------|--------|-------------------|
| 1 | 3991_6100 | 1236 | 1 | 1.236 | 84.567 | L203 x 203 x 28.6 |