



## Nirvana Technologies Pvt. Ltd.

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### Bar Nesting Software - PLUS 1D Report

#### Project Details

<b>Project Name</b>	
File Name	//Server/dev-nirvanatec.com/downloads/largeparts/plus1d_samples/sample2.p1D
Job Order	
Date	Friday, August 29, 2008
PLUS 1D Version No.	7.54

#### Summary of Optimization Results

<b>Project Name</b>	
Number of Layouts	2
Number of Stock Used	22
Total Parts Required	44
Total Parts Nested	44
Total Utilization	96.692
Overall Cost	173377.776
Minimum Offcut Size	Offcuts Not Allowed
Loss per cut	0
Total Part Length	171.028 [m]
Total Stock Length	176.88 [m]
Total Stock Weight	176.88
Total Part Weight	171.028
Total Scrap Weight	5.852
Cutting time (in Minutes)	22
Machine loading time (in Minutes)	22
Total Machine (in Minutes)	44

#### Summary of Layouts

No.	Stock	Size	Qty	Utl %	Rest	Details [PartLength x Qty]
1	5	8040	11	100	0	6840x1 1200x1
2	5	8040	11	93.38	532	6243x1 1265x1

### Stock Details

Stock	Length	Qty	Used	Remarks
1	12000	500	0	
5	8040	1000	22	

### Part Details

Part	Length	Qty	Cut	Weight	Remarks
1	8105	11	11	8.105	
2	7443	11	11	7.443	

## Splitting Rules

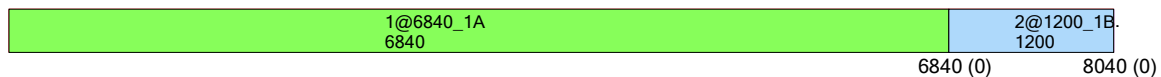
Conditions	Values
Minimum Part Length considered for splitting	6000
Minimum smaller piece Length of part after splitting	1200
Minimum Joint Distance from end for flange	0.200000
Maximum Joint Distance from end for flange	0.333333
Joint Distance from end for web	0.500000
Tolerance allowed for web joint	+/- 250.000000
Maximum joints allowed, in case of multiple joints	2

## Joint Part Details

Part Name	Length	Qty	Cut	Layout_Qty
1	8105	11	11	
1@6840_1A	6840	11	11	1_11
1@1265_1B	1265	11	11	2_11
2	7443	11	11	
2@6243_1A	6243	11	11	2_11
2@1200_1B	1200	11	11	1_11

## Layout 1 of 2

Stock:5	Length:8040	Qty:11	Utl %:100.00
[1@6840_1A] 6840x1	[2@1200_1B] 1200x1		
6840x1	1200x1		

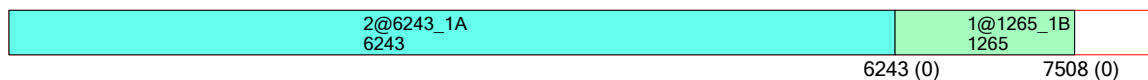


## Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	6840	0	1@6840_1A	0	0
2	8040	0	2@1200_1B	0	0

## Layout 2 of 2

Stock:5	Length:8040	Qty:11	Utl %:93.38
[2@6243_1A] 6243x1	[1@1265_1B] 1265x1		
6243x1	1265x1		



## Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
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Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	6243	0	2@6243_1A	0	0
2	7508	0	1@1265_1B	0	0

### Offcut/Drops List

No.	From Stock	Size	Qty	Weight
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### Material Usage Summary (All Lengths in "[m]")

Section	Used Len	Used Wt	Scrap Len	Total Scrap Weight	Off Len	Total Offcut Weight
Default	176.88	176.88	5.852	5.852	0	0