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PLUS 2D Nesting Software Optimization Report

General Details:

Project Name	
File Name	N:/Plus2D/Samples/S0_R0_T1_M_P7.plj
Job No	
Customer	
CustomerId	
Created By	
Approved By	
Date	Wednesday, July 21, 2010
Material	steel
Thk	6
PLUS 2D Version No.	8.68

Stock Details:

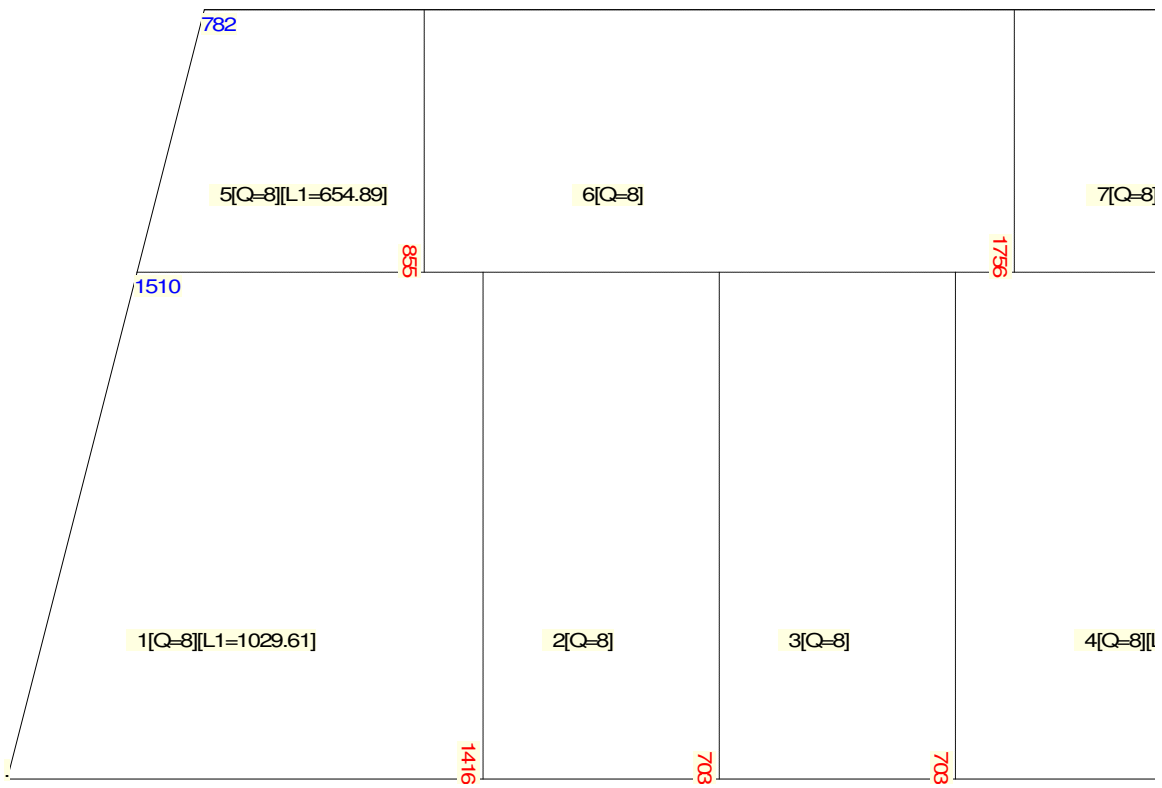
Id	Length	Width	Cost	Qty	Remarks
1	6300	1510	17808.34	14	
2	1710	1510	4833.69	1	

Part Details:

Name	Fin. Length	Fin. Width	Rotn	Qty	Type	Remarks
1	4238	2292	1	[8]	Large	
2	4238	2292	1	[4]	Large	
3	4238	2292	1	[4]	Large	

Large Parts Split Info.

[Name = 1] [L=4238, W=2292, L0=586.5, L1=3065] [Qty=8]

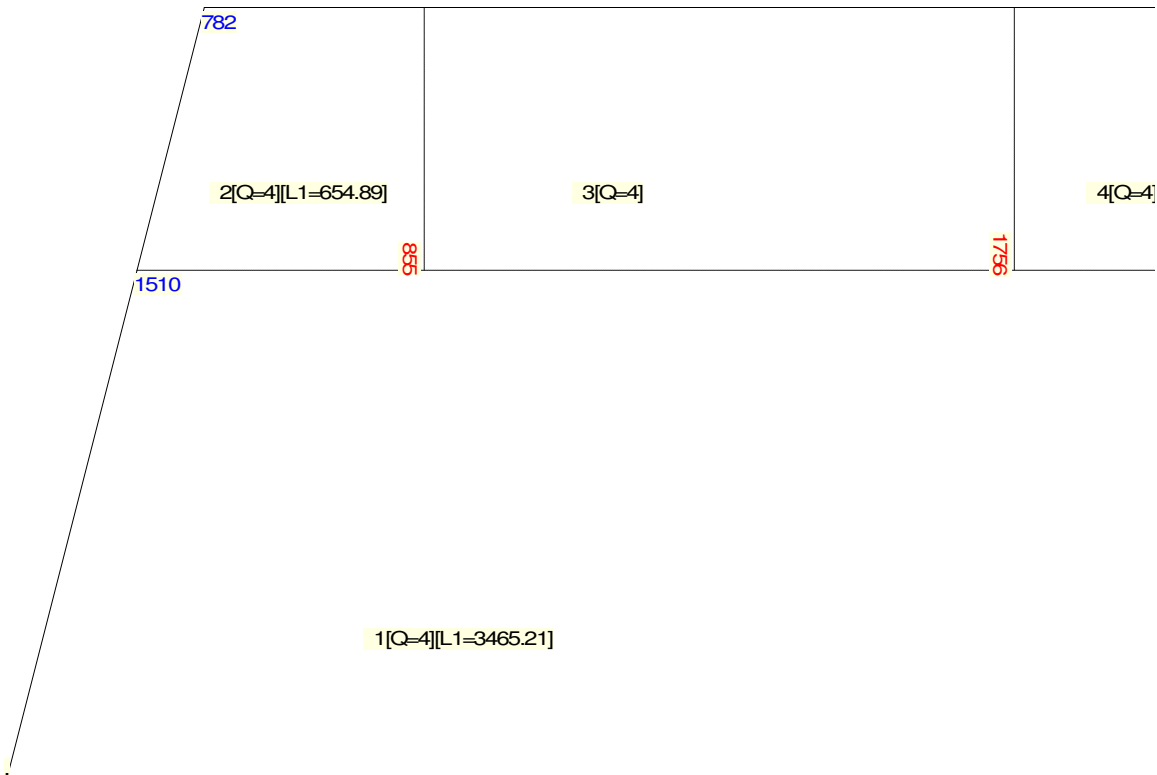


Name	Fin. Length	Fin. Width	Rotn	Qty	Type	Remarks
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Name	Fin. Length	Fin. Width	Rotn	Qty	Type	Remarks
1_1_LP	1416	1510	1	8	LP Piece	Rem
1_2_LP	703	1510	1	8	LP Piece	Rem
1_3_LP	703	1510	1	8	LP Piece	Rem
1_4_LP	1416	1510	1	8	LP Piece	Rem
1_5_LP	855	782	1	8	LP Piece	Rem
1_6_LP	1756	782	1	8	LP Piece	Rem
1_7_LP	854.21	782	1	8	LP Piece	Rem

Cut No	Cut Type	Dim	Rest
1	Horz	1510	782
2	Vert	1416	2822
3	Vert	703	2119
4	Vert	703	1416
5	Horz	782	0
6	Vert	855	2610.21
7	Vert	1756	854.21

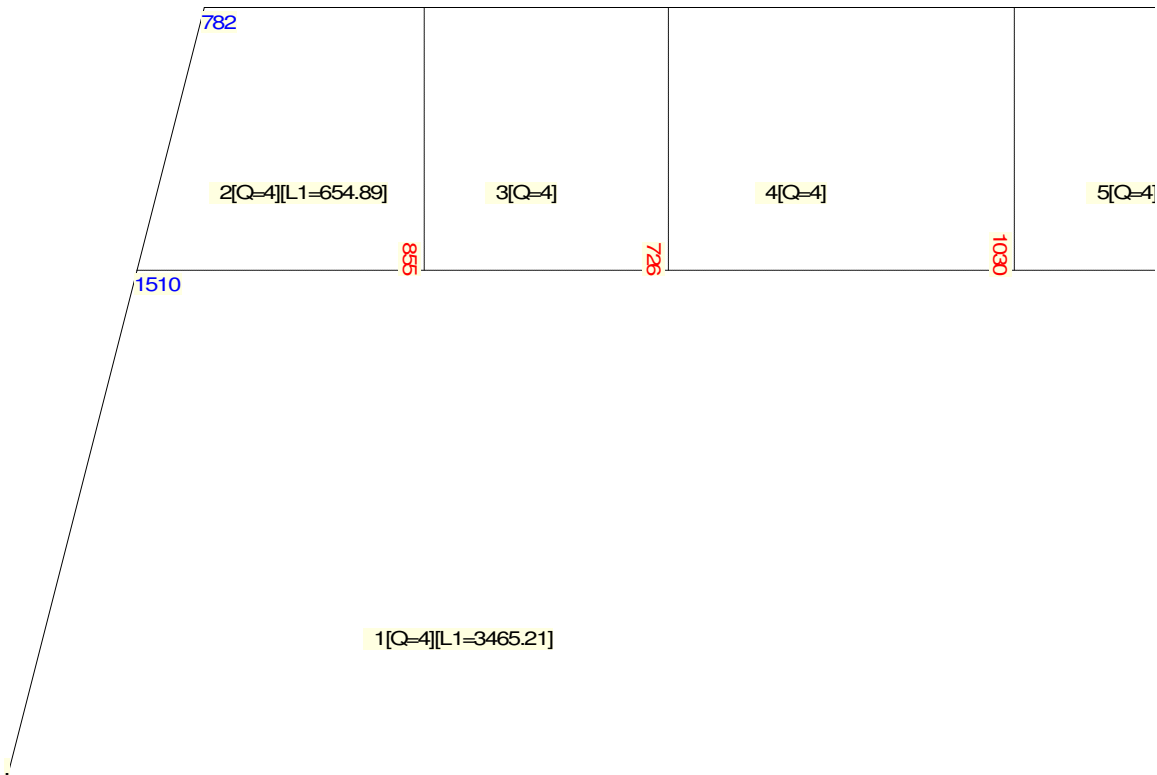
[Name = 2] [L=4238, W=2292, L0=586.5, L1=3065] [Qty=4]



Name	Fin. Length	Fin. Width	Rotn	Qty	Type	Remarks
2_1_LP	4238	1510	1	4	LP Piece	Rem
2_2_LP	855	782	1	4	LP Piece	Rem
2_3_LP	1756	782	1	4	LP Piece	Rem
2_4_LP	854.21	782	1	4	LP Piece	Rem

Cut No	Cut Type	Dim	Rest
1	Horz	1510	782
2	Horz	782	0
3	Vert	855	2610.21
4	Vert	1756	854.21

[Name = 3] [L=4238, W=2292, L0=586.5, L1=3065] [Qty=4]



Name	Fin. Length	Fin. Width	Rotn	Qty	Type	Remarks
3_1_LP	4238	1510	1	4	LP Piece	Rem
3_2_LP	855	782	1	4	LP Piece	Rem
3_3_LP	726	782	1	4	LP Piece	Rem
3_4_LP	1030	782	1	4	LP Piece	Rem
3_5_LP	854.21	782	1	4	LP Piece	Rem

Cut No	Cut Type	Dim	Rest
1	Horz	1510	782
2	Horz	782	0
3	Vert	855	2610.21
4	Vert	726	1884.21
5	Vert	1030	854.21

Summary of Optimization Results:

Summary of Optimization Results:	
Grinding Margin	0
Saw Width	0
Number of Layouts	8
Number of Stock Used	15
Total Utilization	98.63 %
Total Parts Required	92
Total Parts Nested	92
Reusable Offcuts	0
Total Stock Area	135.76
Total Part Area	133.91
Offcut Area	0
Scrap Area	1.86
Total Stock Weight	6353.76
Total Part Weight	6266.89
Total Offcut Weight	0
Total Scrap Weight	86.87
ScrapWt/PartWt	1.39 %

Summary of Layouts:

No	Name	Qty	Util%	Cost	Parts	Offcut Qty - Size
1	2	1	87.95	4833.69	4	0
2	1	4	99.96	71233.34	12	0
3	1	4	99.96	71233.34	12	0
4	1	1	99.24	17808.34	16	0
5	1	1	99.24	17808.34	16	0
6	1	2	96.41	35616.67	16	0
7	1	1	96.41	17808.34	8	0
8	1	1	96.41	17808.34	8	0

Parts Summary Table:

No	Name	Size (L x W)	Nested (Required)	Area	Weight	Remarks
1	1_1_LP	1416 x 1510	8 (8)	14.77	691.3	Rem
2	1_2_LP	703 x 1510	8 (8)	8.49	397.44	Rem
3	1_3_LP	703 x 1510	8 (8)	8.49	397.44	Rem
4	1_4_LP	1416 x 1510	8 (8)	14.77	691.3	Rem
5	1_5_LP	855 x 782	8 (8)	4.72	221.03	Rem
6	1_6_LP	1756 x 782	8 (8)	10.99	514.12	Rem
7	1_7_LP	854.21 x 782	8 (8)	4.72	220.8	Rem
8	1	4238 x 2292	0 (0)	0	0	
9	2_1_LP	4238 x 1510	4 (4)	23.26	1088.74	Rem
10	2_2_LP	855 x 782	4 (4)	2.36	110.52	Rem
11	2_3_LP	1756 x 782	4 (4)	5.49	257.06	Rem
12	2_4_LP	854.21 x 782	4 (4)	2.36	110.4	Rem
13	2	4238 x 2292	0 (0)	0	0	
14	3_1_LP	4238 x 1510	4 (4)	23.26	1088.74	Rem
15	3_2_LP	855 x 782	4 (4)	2.36	110.52	Rem
16	3_3_LP	726 x 782	4 (4)	2.27	106.28	Rem
17	3_4_LP	1030 x 782	4 (4)	3.22	150.78	Rem
18	3_5_LP	854.21 x 782	4 (4)	2.36	110.4	Rem
19	3	4238 x 2292	0 (0)	0	0	
		Total	92 (92)	133.91	6266.89	

Stocks used details:

No	Name	Length	Width	Avail Qty	Utl Qty	Area
1	1	6300	1510	14	14	133.18
2	2	1710	1510	1	1	2.58
	Total				15	135.76

Offcut Details :

Id	Length	Width	Cost	Qty	Area
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Parts Cut List:

Name	Length	Width	Qty	Remarks Layout-Qty
1_1_LP	1416	1510	8	3-4/2-4
1_2_LP	703	1510	8	6-8
1_3_LP	703	1510	8	8-4/7-4
1_4_LP	1416	1510	8	3-4/2-4
1_5_LP	855	782	8	4-8
1_6_LP	1756	782	8	7-2/6-6
1_7_LP	854.21	782	8	4-8
1	4238	2292	0	
2_1_LP	4238	1510	4	2-4
2_2_LP	855	782	4	5-4
2_3_LP	1756	782	4	8-3/7-1
2_4_LP	854.21	782	4	5-4
2	4238	2292	0	
3_1_LP	4238	1510	4	3-4
3_2_LP	855	782	4	5-4
3_3_LP	726	782	4	1-4
3_4_LP	1030	782	4	8-1/7-1/6-2
3_5_LP	854.21	782	4	5-4
3	4238	2292	0	

Detailed table about Stocks & Parts:

No	Stk Length	Stk Width	Stk Area	Prt Length	Prt Width	Qty	Part Area	Name
1	1710	1510	2.58					
				726	782	4	2.27	3_3_LP
			87.95 %				2.27	
2	6300	1510	9.51					
				1416	1510	1	1.85	1_1_LP
				1416	1510	1	1.85	1_4_LP
				4238	1510	1	5.82	2_1_LP
			99.96 %				9.51	
3	6300	1510	9.51					
				1416	1510	1	1.85	1_1_LP
				1416	1510	1	1.85	1_4_LP
				4238	1510	1	5.82	3_1_LP
			99.96 %				9.51	
4	6300	1510	9.51					
				855	782	8	4.72	1_5_LP
				854.21	782	8	4.72	1_7_LP
			99.24 %				9.44	
5	6300	1510	9.51					
				855	782	4	2.36	2_2_LP
				854.21	782	4	2.36	2_4_LP
				855	782	4	2.36	3_2_LP
				854.21	782	4	2.36	3_5_LP
			99.24 %				9.44	
6	6300	1510	9.51					
				703	1510	4	4.25	1_2_LP
				1756	782	3	4.12	1_6_LP
				1030	782	1	0.81	3_4_LP
			96.41 %				9.17	
7	6300	1510	9.51					
				703	1510	4	4.25	1_3_LP
				1756	782	2	2.75	1_6_LP
				1756	782	1	1.37	2_3_LP
				1030	782	1	0.81	3_4_LP
			96.41 %				9.17	
8	6300	1510	9.51					
				703	1510	4	4.25	1_3_LP
				1756	782	3	4.12	2_3_LP
				1030	782	1	0.81	3_4_LP
			96.41 %				9.17	

Details of each Layout:



Layout 1 of 8(Stock:2 Dim:1710 x 1510 Qty:1)

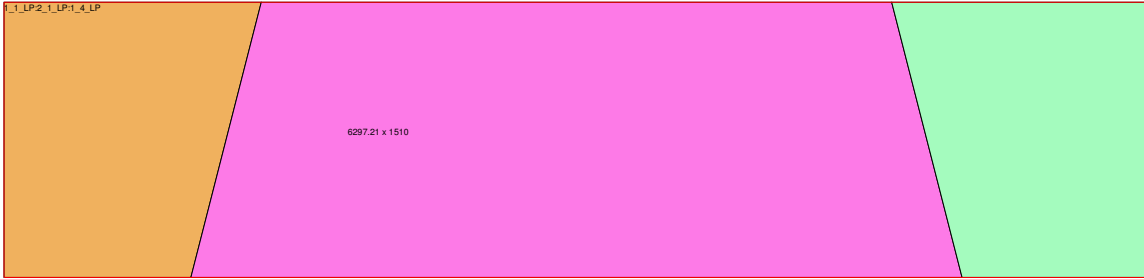
Bill Of Materials:

Name	Length	Width	Qty	Area	Total Qty.	Prod./Re qd.	Remarks
3_3_LP	726	782	4	2.27	4*	0/4	Rem
Total			4	2.27	4		

Cutting Instructions:

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
1	0	726	1710	726

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
2	782	0	782	726
3	1564	0	1564	726
4	0	1452	1710	1452
5	782	726	782	1452
6	1564	726	1564	1452



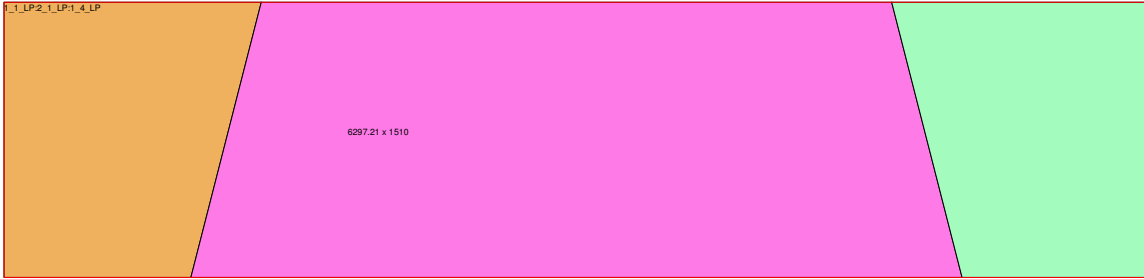
Layout 2 of 8(Stock:1 Dim:6300 x 1510 Qty:4)

Bill Of Materials:

Name	Length	Width	Qty	Area	Total Qty.	Prod./Re qd.	Remarks
1_1_LP	1416	1510	1	1.85	4	0/8	Rem
1_4_LP	1416	1510	1	1.85	4	0/8	Rem
2_1_LP	4238	1510	1	5.82	4*	0/4	Rem
Total			3	9.51	12		

Cutting Instructions:

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
1	6297.21	0	6297.21	1510



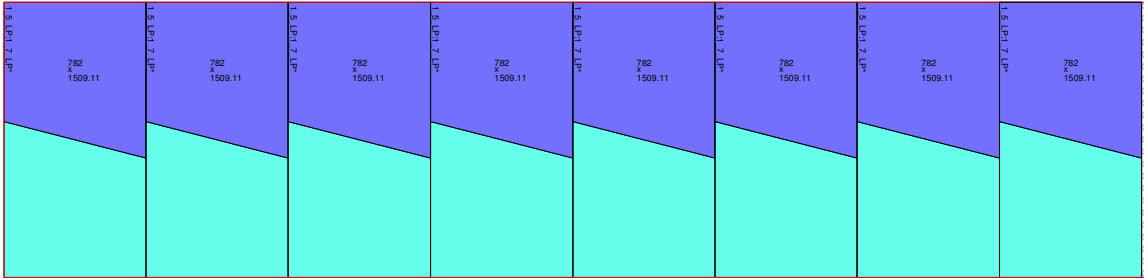
Layout 3 of 8(Stock:1 Dim:6300 x 1510 Qty:4)

Bill Of Materials:

Name	Length	Width	Qty	Area	Total Qty.	Prod./Re qd.	Remarks
1_1_LP	1416	1510	1	1.85	4*	4/8	Rem
1_4_LP	1416	1510	1	1.85	4*	4/8	Rem
3_1_LP	4238	1510	1	5.82	4*	0/4	Rem
Total			3	9.51	12		

Cutting Instructions:

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
1	6297.21	0	6297.21	1510



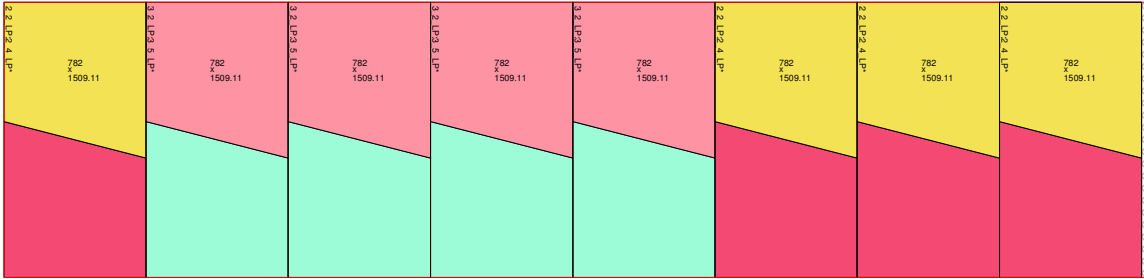
Layout 4 of 8(Stock:1 Dim:6300 x 1510 Qty:1)

Bill Of Materials:

Name	Length	Width	Qty	Area	Total Qty.	Prod./Re qd.	Remarks
1_5_LP	855	782	8	4.72	8*	0/8	Rem
1_7_LP	854.21	782	8	4.72	8*	0/8	Rem
Total			16	9.44	16		

Cutting Instructions:

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
1	782	0	782	1510
2	1564	0	1564	1510
3	2346	0	2346	1510
4	3128	0	3128	1510
5	3910	0	3910	1510
6	4692	0	4692	1510
7	5474	0	5474	1510
8	6256	0	6256	1510
9	5474	1509.11	6256	1509.11



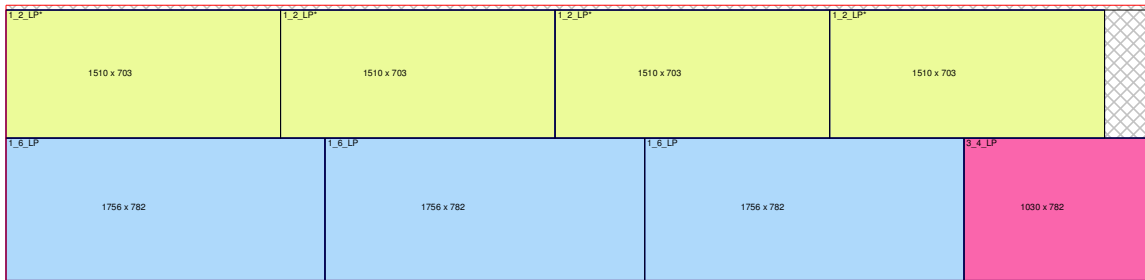
Layout 5 of 8(Stock:1 Dim:6300 x 1510 Qty:1)

Bill Of Materials:

Name	Length	Width	Qty	Area	Total Qty.	Prod./Re qd.	Remarks
2_2_LP	855	782	4	2.36	4*	0/4	Rem
2_4_LP	854.21	782	4	2.36	4*	0/4	Rem
3_2_LP	855	782	4	2.36	4*	0/4	Rem
3_5_LP	854.21	782	4	2.36	4*	0/4	Rem
Total			16	9.44	16		

Cutting Instructions:

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
1	782	0	782	1510
2	1564	0	1564	1510
3	2346	0	2346	1510
4	3128	0	3128	1510
5	3910	0	3910	1510
6	4692	0	4692	1510
7	5474	0	5474	1510
8	6256	0	6256	1510
9	5474	1509.11	6256	1509.11



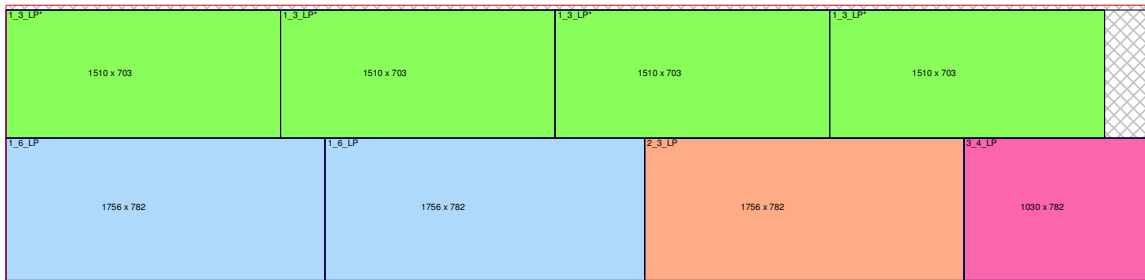
Layout 6 of 8(Stock:1 Dim:6300 x 1510 Qty:2)

Bill Of Materials:

Name	Length	Width	Qty	Area	Total Qty.	Prod./Re qd.	Rema rks
1_2_LP	703	1510	4	4.25	8*	0/8	Rem
1_6_LP	1756	782	3	4.12	6	0/8	Rem
3_4_LP	1030	782	1	0.81	2	0/4	Rem
Total			8	9.17	16		

Cutting Instructions:

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
1	0	782	6300	782
2	1756	0	1756	782
3	3512	0	3512	782
4	5268	0	5268	782
5	6298	0	6298	782
6	0	1485	6300	1485
7	1510	782	1510	1485
8	3020	782	3020	1485
9	4530	782	4530	1485
10	6040	782	6040	1485



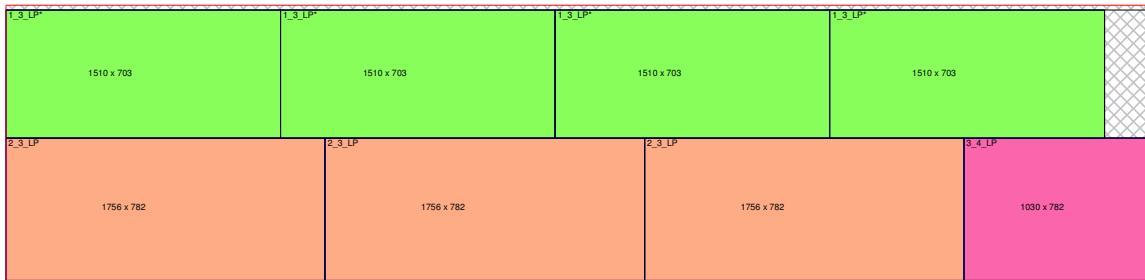
Layout 7 of 8(Stock:1 Dim:6300 x 1510 Qty:1)

Bill Of Materials:

Name	Length	Width	Qty	Area	Total Qty.	Prod./Re qd.	Remarks
1_3_LP	703	1510	4	4.25	4	0/8	Rem
1_6_LP	1756	782	2	2.75	2*	6/8	Rem
2_3_LP	1756	782	1	1.37	1	0/4	Rem
3_4_LP	1030	782	1	0.81	1	2/4	Rem
Total			8	9.17	8		

Cutting Instructions:

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
1	0	782	6300	782
2	1756	0	1756	782
3	3512	0	3512	782
4	5268	0	5268	782
5	6298	0	6298	782
6	0	1485	6300	1485
7	1510	782	1510	1485
8	3020	782	3020	1485
9	4530	782	4530	1485
10	6040	782	6040	1485



Layout 8 of 8(Stock:1 Dim:6300 x 1510 Qty:1)

Bill Of Materials:

Name	Length	Width	Qty	Area	Total Qty.	Prod./Re qd.	Remarks
1_3_LP	703	1510	4	4.25	4*	4/8	Rem
2_3_LP	1756	782	3	4.12	3*	1/4	Rem
3_4_LP	1030	782	1	0.81	1*	3/4	Rem
Total			8	9.17	8		

Cutting Instructions:

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
1	0	782	6300	782
2	1756	0	1756	782
3	3512	0	3512	782
4	5268	0	5268	782
5	6298	0	6298	782
6	0	1485	6300	1485
7	1510	782	1510	1485
8	3020	782	3020	1485
9	4530	782	4530	1485
10	6040	782	6040	1485