



Nirvana Technologies Pvt. Ltd.

E-mail : info@nirvanatec.com Web : <http://www.nirvanatec.com>
Phone: +91-22-21661600 Fax: +91-22-39167297

Bar Nesting Software - PLUS 1D Report

Project Details

Project Name	
File Name	N:/Plus1D/Samples/miter_sample1.p1D
Job Order	
Date	Friday, February 06, 2009
PLUS 1D Version No.	7.55

Summary of Optimization Results

Project Name	
Number of Layouts	26
Number of Stock Used	64
Total Parts Required	576
Total Parts Nested	576
Total Utilization	98.154
Overall Cost	390400
Minimum Offcut Size	500
Loss per cut	0
Total Part Length	380.078 [m]
Total Stock Length	390.4 [m]
Total Stock Weight	390.4
Total Part Weight	20602.203
Total Offcut Weight	3.116
Total Scrap Weight	-20214.919
Cutting time (in Minutes)	512
Machine loading time (in Minutes)	64
Total Machine (in Minutes)	576

Summary of Layouts

No.	Stock	Size	Qty	Utl %	Rest	Details [PartLength x Qty]
1	1	6100	7	98.92	7.265	950x5 637.735x1 732.735x1 [ET=30]
2	1	6100	3	97.52	34.701	637.735x1 960.94x1 735x8 [ET=30]
3	1	6100	1	98.48	33.59	637.735x1 960.94x1 735x1

No.	Stock	Size	Qty	Utl %	Rest	Details [PartLength x Qty]
						960.94x4 725x1 [ET=30]
4	1	6100	2	99.26	15.385	637.735x1 960.94x5 725x1 637.735x1 [ET=30]
5	1	6100	2	92.85	377.18	620x1 960.94x6 [ET=30]
6	1	6100	1	98.67	50.855	620x1 960.94x5 725x1 620x1 [ET=30]
7	1	6100	3	99.32	11.495	620x1 725x8 620x1 [ET=30]
8	1	6100	5	98.83	41.325	620x1 865.47x6 620x1 [ET=30]
9	1	6100	1	98.03	61.325	620x1 865.47x5 732.735x2 [ET=30]
10	1	6100	3	98.22	50	620x1 732.735x8 [ET=30]
11	1	6100	1	98.99	3	620x1 732.735x7 722x1 [ET=30]
12	1	6100	2	99.38	8	810x6 722x1 480x1 [ET=30]
13	1	6100	1	99.44	4	810x4 722x3 660x1 [ET=30]
14	1	6100	9	98.59	56	722x7 480x2 [ET=30]
15	1	6100	1	99.41	6	722x2 660x7 [ET=30]
16	1	6100	6	97.38	130	660x9 [ET=30]
17	1	6100	1	96.72	170	660x4 652x5 [ET=30]
18	1	6100	2	96.2	202	652x9 [ET=30]
19	1	6100	1	98.87	39	652x5 622x3 480x1 425x1 [ET=30]
20	1	6100	6	98.74	47	622x9 425x1 [ET=30]
21	1	6100	1	99.51	0	622x3 480x7 422x2 [ET=30]
22	1	6100	1	94.43	310	480x12 [ET=30]
23	1	6100	1	94.18	325	480x4 425x9 [ET=30]
24	1	6100	1	97.54	120	425x14 [ET=30]
25	1	6100	1	97	153	425x3 422x11 [ET=30]
26	1	6100	1	99.51	(3116)	422x7 [ET=30]

Stock Details

Stock	Length	Qty	End Trim	Used	Remarks
1	6100	100	30	64	

Part Details

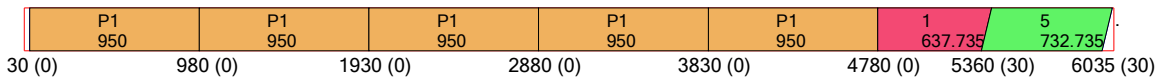
Part	Length	Qty	Cut	Weight	Remarks
P1	950	35	35	80.864	
P2	810	16	16	68.947	
P3	722	71	71	61.457	
P4	660	66	66	56.179	
P5	652	28	28	55.498	
P6	622	60	60	52.945	
P7	480	44	44	40.858	
P8	425	33	33	36.176	
P9	422	20	20	35.921	

Miter Part Details

Part	Base Length	Left Angle	Right Angle	Height	Qty	Cut	Flip	Weight	Remarks
1	580	0	30	100	15	15	Yes	0.638	
2	620	30	0	100	25	25	Yes	0.62	
3	725	30	-60	100	28	28	Yes	0.725	
4	730	-60	30	100	35	35	Yes	0.961	
5	675	30	30	100	40	40	Yes	0.733	
6	750	-30	30	100	35	35	Yes	0.865	
7	735	60	-60	100	25	25	Yes	0.735	

Layout 1 of 26

Stock:1	Length:6100	Qty:7	Utl %:98.92	No Offcuts	End Trim:30
[P1] 950x5	[1] 637.735x1	[5] 732.735x1			
950x5	637.735x1	732.735x1	[ET=30]		

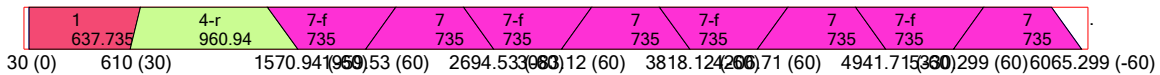


Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	980	0	P1	0	0
3	1930	0	P1	0	0
4	2880	0	P1	0	0
5	3830	0	P1	0	0
6	4780	0	P1	0	0
7	5360	30	1	0	0
8	6035	30	5	0	0

Layout 2 of 26

Stock:1	Length:6100	Qty:3	Utl %:97.52	No Offcuts	End Trim:30
[1] 637.735x1	[4] 960.94x1	[7] 735x8			
637.735x1	960.94x1	735x8	[ET=30]		



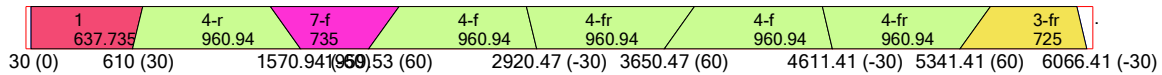
Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	610	30	1	0	0
3	1570.94	-60	4	0	1
4	1959.53	60	7	1	0
5	2694.53	-60	7	0	0

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
6	3083.12	60	7	1	0
7	3818.12	-60	7	0	0
8	4206.71	60	7	1	0
9	4941.71	-60	7	0	0
10	5330.299	60	7	1	0
11	6065.299	-60	7	0	0

Layout 3 of 26

Stock:1	Length:6100	Qty:1	Utl %:98.48	No Offcuts	End Trim:30
[1] 637.735x1	[4] 960.94x1	[7] 735x1	[4] 960.94x4	[3] 725x1	
637.735x1 960.94x1 735x1 960.94x4 725x1 [ET=30]					

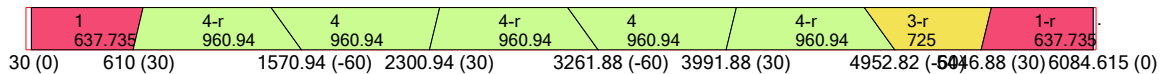


Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	610	30	1	0	0
3	1570.94	-60	4	0	1
4	1959.53	60	7	1	0
5	2920.47	-30	4	1	0
6	3650.47	60	4	1	1
7	4611.41	-30	4	1	0
8	5341.41	60	4	1	1
9	6066.41	-30	3	1	1

Layout 4 of 26

Stock:1	Length:6100	Qty:2	Utl %:99.26	No Offcuts	End Trim:30
[1] 637.735x1	[4] 960.94x5	[3] 725x1	[1] 637.735x1		
637.735x1 960.94x5 725x1 637.735x1 [ET=30]					



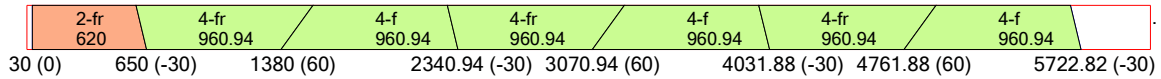
Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	610	30	1	0	0
3	1570.94	-60	4	0	1
4	2300.94	30	4	0	0
5	3261.88	-60	4	0	1
6	3991.88	30	4	0	0
7	4952.82	-60	4	0	1
8	5446.88	30	3	0	1

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
9	6084.615	0	1	0	1

Layout 5 of 26

Stock:1	Length:6100	Qty:2	Utl %:92.85	No Offcuts	End Trim:30
[2] 620x1	[4] 960.94x6				
620x1	960.94x6	[ET=30]			

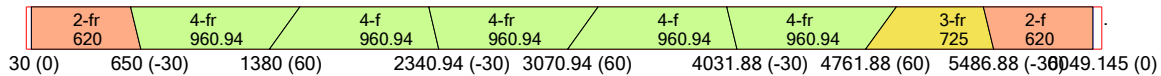


Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	650	-30	2	1	1
3	1380	60	4	1	1
4	2340.94	-30	4	1	0
5	3070.94	60	4	1	1
6	4031.88	-30	4	1	0
7	4761.88	60	4	1	1
8	5722.82	-30	4	1	0

Layout 6 of 26

Stock:1	Length:6100	Qty:1	Utl %:98.67	No Offcuts	End Trim:30
[2] 620x1	[4] 960.94x5	[3] 725x1	[2] 620x1		
620x1	960.94x5	725x1	620x1	[ET=30]	



Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	650	-30	2	1	1
3	1380	60	4	1	1
4	2340.94	-30	4	1	0
5	3070.94	60	4	1	1
6	4031.88	-30	4	1	0
7	4761.88	60	4	1	1
8	5486.88	-30	3	1	1
9	6049.145	0	2	1	0

Layout 7 of 26

Stock:1	Length:6100	Qty:3	Utl %:99.32	No Offcuts	End Trim:30
[2] 620x1	[3] 725x8	[2] 620x1			
620x1	725x8	620x1	[ET=30]		

2-fr 620	3-f 725	3-fr 725	3-f 725	3-fr 725	3-f 725	3-fr 725	3-f 725	3-fr 725	3-f 725	2-f 620
30 (0)	650 (-30)	1144.06 (60)	1869.06 (-30)	2363.12 (60)	3088.12 (-30)	3582.18 (60)	4307.18 (-30)	4801.24 (60)	5526.24 (-30)	6088.505 (0)

Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	650	-30	2	1	1
3	1144.06	60	3	1	0
4	1869.06	-30	3	1	1
5	2363.12	60	3	1	0
6	3088.12	-30	3	1	1
7	3582.18	60	3	1	0
8	4307.18	-30	3	1	1
9	4801.24	60	3	1	0
10	5526.24	-30	3	1	1
11	6088.505	0	2	1	0

Layout 8 of 26

Stock:1	Length:6100	Qty:5	Utl %:98.83	No Offcuts	End Trim:30
[2] 620x1	[6] 865.47x6	[2] 620x1			
620x1	865.47x6	620x1	[ET=30]		

2-fr 620	6 865.47	6-f 865.47	6 865.47	6-f 865.47	6 865.47	6-f 865.47	2-f 620
30 (0)	650 (-30)	1400 (30)	2265.47 (-30)	3015.47 (30)	3880.94 (-30)	4630.94 (30)	5496.41 (-30)

Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	650	-30	2	1	1
3	1400	30	6	0	0
4	2265.47	-30	6	1	0
5	3015.47	30	6	0	0
6	3880.94	-30	6	1	0
7	4630.94	30	6	0	0
8	5496.41	-30	6	1	0
9	6058.675	0	2	1	0

Layout 9 of 26

Stock:1	Length:6100	Qty:1	Utl %:98.03	No Offcuts	End Trim:30
[2] 620x1	[6] 865.47x5	[5] 732.735x2			
620x1	865.47x5	732.735x2	[ET=30]		

2-fr 620	6 865.47	6-f 865.47	6 865.47	6-f 865.47	6 865.47	5 732.735	5 732.735
30 (0)	650 (-30)	1400 (30)	2265.47 (-30)	3015.47 (30)	3880.94 (-30)	4630.94 (30)	5305.94 (30)

Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	650	-30	2	1	1
3	1400	30	6	0	0
4	2265.47	-30	6	1	0
5	3015.47	30	6	0	0
6	3880.94	-30	6	1	0
7	4630.94	30	6	0	0
8	5305.94	30	5	0	0
9	5980.94	30	5	0	0

Layout 10 of 26

Stock:1	Length:6100	Qty:3	Utl %:98.22	No Offcuts	End Trim:30
[2] 620x1	[5] 732.735x8				
620x1	732.735x8	[ET=30]			

2-fr 620	5-f 732.735	5-f 732.735	5-f 732.735	5-f 732.735	5-f 732.735	5-f 732.735	5-f 732.735	5-f 732.735	5-f 732.735
30 (0)	650 (-30)	1325 (-30)	2000 (-30)	2675 (-30)	3350 (-30)	4025 (-30)	4700 (-30)	5375 (-30)	6050 (-30)

Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	650	-30	2	1	1
3	1325	-30	5	1	0
4	2000	-30	5	1	0
5	2675	-30	5	1	0
6	3350	-30	5	1	0
7	4025	-30	5	1	0
8	4700	-30	5	1	0
9	5375	-30	5	1	0
10	6050	-30	5	1	0

Layout 11 of 26

Stock:1	Length:6100	Qty:1	Utl %:98.99	No Offcuts	End Trim:30
[2] 620x1	[5] 732.735x7	[P3] 722x1			
620x1	732.735x7	722x1	[ET=30]		

2-fr 620	5-f 732.735	5-f 732.735	5-f 732.735	5-f 732.735	5-f 732.735	5-f 732.735	5-f 732.735	5-f 732.735	P3 722
30 (0)	650 (-30)	1325 (-30)	2000 (-30)	2675 (-30)	3350 (-30)	4025 (-30)	4700 (-30)	5375 (-30)	6097 (0)

Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	650	-30	2	1	1
3	1325	-30	5	1	0

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
4	2000	-30	5	1	0
5	2675	-30	5	1	0
6	3350	-30	5	1	0
7	4025	-30	5	1	0
8	4700	-30	5	1	0
9	5375	-30	5	1	0
10	6097	0	P3	0	0

Layout 12 of 26

Stock:1	Length:6100	Qty:2	Utl %:99.38	No Offcuts	End Trim:30
[P2] 810x6	[P3] 722x1	[P7] 480x1			
810x6	722x1	480x1	[ET=30]		

P2 810	P2 810	P2 810	P2 810	P2 810	P2 810	P3 722	P7 480
30 (0)	840 (0)	1650 (0)	2460 (0)	3270 (0)	4080 (0)	4890 (0)	5612 (0) 6092 (0)

Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	840	0	P2	0	0
3	1650	0	P2	0	0
4	2460	0	P2	0	0
5	3270	0	P2	0	0
6	4080	0	P2	0	0
7	4890	0	P2	0	0
8	5612	0	P3	0	0
9	6092	0	P7	0	0

Layout 13 of 26

Stock:1	Length:6100	Qty:1	Utl %:99.44	No Offcuts	End Trim:30
[P2] 810x4	[P3] 722x3	[P4] 660x1			
810x4	722x3	660x1	[ET=30]		

P2 810	P2 810	P2 810	P2 810	P3 722	P3 722	P3 722	P4 660
30 (0)	840 (0)	1650 (0)	2460 (0)	3270 (0)	3992 (0)	4714 (0)	5436 (0) 6096 (0)

Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	840	0	P2	0	0
3	1650	0	P2	0	0
4	2460	0	P2	0	0
5	3270	0	P2	0	0
6	3992	0	P3	0	0
7	4714	0	P3	0	0

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
8	5436	0	P3	0	0
9	6096	0	P4	0	0

Layout 14 of 26

Stock:1	Length:6100	Qty:9	Utl %:98.59	No Offcuts	End Trim:30
[P3] 722x7	[P7] 480x2				
722x7	480x2	[ET=30]			

P3 722	P3 722	P3 722	P3 722	P3 722	P3 722	P3 722	P7 480	P7 480
30 (0)	752 (0)	1474 (0)	2196 (0)	2918 (0)	3640 (0)	4362 (0)	5084 (0)	5564 (0) 6044 (0)

Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	752	0	P3	0	0
3	1474	0	P3	0	0
4	2196	0	P3	0	0
5	2918	0	P3	0	0
6	3640	0	P3	0	0
7	4362	0	P3	0	0
8	5084	0	P3	0	0
9	5564	0	P7	0	0
10	6044	0	P7	0	0

Layout 15 of 26

Stock:1	Length:6100	Qty:1	Utl %:99.41	No Offcuts	End Trim:30
[P3] 722x2	[P4] 660x7				
722x2	660x7	[ET=30]			

P3 722	P3 722	P4 660	P4 660	P4 660	P4 660	P4 660	P4 660	P4 660
30 (0)	752 (0)	1474 (0)	2134 (0)	2794 (0)	3454 (0)	4114 (0)	4774 (0)	5434 (0) 6094 (0)

Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	752	0	P3	0	0
3	1474	0	P3	0	0
4	2134	0	P4	0	0
5	2794	0	P4	0	0
6	3454	0	P4	0	0
7	4114	0	P4	0	0
8	4774	0	P4	0	0
9	5434	0	P4	0	0
10	6094	0	P4	0	0

Layout 16 of 26

Stock:1	Length:6100	Qty:6	Utl %:97.38	No Offcuts	End Trim:30
[P4] 660x9					
660x9 [ET=30]					

P4 660	P4 660	P4 660	P4 660	P4 660	P4 660	P4 660	P4 660	P4 660	P4 660
30 (0)	690 (0)	1350 (0)	2010 (0)	2670 (0)	3330 (0)	3990 (0)	4650 (0)	5310 (0)	5970 (0)

Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	690	0	P4	0	0
3	1350	0	P4	0	0
4	2010	0	P4	0	0
5	2670	0	P4	0	0
6	3330	0	P4	0	0
7	3990	0	P4	0	0
8	4650	0	P4	0	0
9	5310	0	P4	0	0
10	5970	0	P4	0	0

Layout 17 of 26

Stock:1	Length:6100	Qty:1	Utl %:96.72	No Offcuts	End Trim:30
[P4] 660x4 [P5] 652x5					
660x4 652x5 [ET=30]					

P4 660	P4 660	P4 660	P4 660	P5 652	P5 652	P5 652	P5 652	P5 652	P5 652
30 (0)	690 (0)	1350 (0)	2010 (0)	2670 (0)	3322 (0)	3974 (0)	4626 (0)	5278 (0)	5930 (0)

Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	690	0	P4	0	0
3	1350	0	P4	0	0
4	2010	0	P4	0	0
5	2670	0	P4	0	0
6	3322	0	P5	0	0
7	3974	0	P5	0	0
8	4626	0	P5	0	0
9	5278	0	P5	0	0
10	5930	0	P5	0	0

Layout 18 of 26

Stock:1	Length:6100	Qty:2	Utl %:96.20	No Offcuts	End Trim:30
[P5] 652x9					
652x9 [ET=30]					

P5 652	P5 652	P5 652	P5 652	P5 652	P5 652	P5 652	P5 652	P5 652	P5 652	
30 (0)	682 (0)	1334 (0)	1986 (0)	2638 (0)	3290 (0)	3942 (0)	4594 (0)	5246 (0)	5898 (0)	

Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	682	0	P5	0	0
3	1334	0	P5	0	0
4	1986	0	P5	0	0
5	2638	0	P5	0	0
6	3290	0	P5	0	0
7	3942	0	P5	0	0
8	4594	0	P5	0	0
9	5246	0	P5	0	0
10	5898	0	P5	0	0

Layout 19 of 26

Stock:1	Length:6100	Qty:1	Utl %:98.87	No Offcuts	End Trim:30
[P5] 652x5	[P6] 622x3	[P7] 480x1	[P8] 425x1		
652x5	622x3	480x1	425x1	[ET=30]	

P5 652	P5 652	P5 652	P5 652	P5 652	P6 622	P6 622	P6 622	P7 480	P8 425
30 (0)	682 (0)	1334 (0)	1986 (0)	2638 (0)	3290 (0)	3912 (0)	4534 (0)	5156 (0)	5636 (0) 6061 (0)

Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	682	0	P5	0	0
3	1334	0	P5	0	0
4	1986	0	P5	0	0
5	2638	0	P5	0	0
6	3290	0	P5	0	0
7	3912	0	P6	0	0
8	4534	0	P6	0	0
9	5156	0	P6	0	0
10	5636	0	P7	0	0
11	6061	0	P8	0	0

Layout 20 of 26

Stock:1	Length:6100	Qty:6	Utl %:98.74	No Offcuts	End Trim:30
[P6] 622x9	[P8] 425x1				
622x9	425x1	[ET=30]			

P6 622	P6 622	P6 622	P6 622	P6 622	P6 622	P6 622	P6 622	P6 622	P6 622	P8 425
30 (0)	652 (0)	1274 (0)	1896 (0)	2518 (0)	3140 (0)	3762 (0)	4384 (0)	5006 (0)	5628 (0)	6053 (0)

Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	652	0	P6	0	0
3	1274	0	P6	0	0
4	1896	0	P6	0	0
5	2518	0	P6	0	0
6	3140	0	P6	0	0
7	3762	0	P6	0	0
8	4384	0	P6	0	0
9	5006	0	P6	0	0
10	5628	0	P6	0	0
11	6053	0	P8	0	0

Layout 21 of 26

Stock:1	Length:6100	Qty:1	Utl %:99.51	No Offcuts	End Trim:30
[P6] 622x3	[P7] 480x7	[P9] 422x2			
622x3	480x7	422x2	[ET=30]		

P6 622	P6 622	P6 622	P7 480	P7 480	P7 480	P7 480	P7 480	P7 480	P7 480	P7 480	P9 422	P9 422
30 (0)	652 (0)	1274 (0)	1896 (0)	2376 (0)	2856 (0)	3336 (0)	3816 (0)	4296 (0)	4776 (0)	5256 (0)	5678 (0)	6100 (0)

Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	652	0	P6	0	0
3	1274	0	P6	0	0
4	1896	0	P6	0	0
5	2376	0	P7	0	0
6	2856	0	P7	0	0
7	3336	0	P7	0	0
8	3816	0	P7	0	0
9	4296	0	P7	0	0
10	4776	0	P7	0	0
11	5256	0	P7	0	0
12	5678	0	P9	0	0
13	6100	0	P9	0	0

Layout 22 of 26

Stock:1	Length:6100	Qty:1	Utl %:94.43	No Offcuts	End Trim:30
[P7] 480x12					
480x12	[ET=30]				

P7 480	P7 480	P7 480	P7 480	P7 480	P7 480	P7 480	P7 480	P7 480	P7 480	P7 480	P7 480	P7 480
30 (0)	510 (0)	990 (0)	1470 (0)	1950 (0)	2430 (0)	2910 (0)	3390 (0)	3870 (0)	4350 (0)	4830 (0)	5310 (0)	5790 (0)

Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	510	0	P7	0	0
3	990	0	P7	0	0
4	1470	0	P7	0	0
5	1950	0	P7	0	0
6	2430	0	P7	0	0
7	2910	0	P7	0	0
8	3390	0	P7	0	0
9	3870	0	P7	0	0
10	4350	0	P7	0	0
11	4830	0	P7	0	0
12	5310	0	P7	0	0
13	5790	0	P7	0	0

Layout 23 of 26

Stock:1	Length:6100	Qty:1	Utl %:94.18	No Offcuts	End Trim:30
[P7] 480x4 [P8] 425x9					
480x4 425x9 [ET=30]					

P7 480	P7 480	P7 480	P7 480	P8 425	P8 425	P8 425	P8 425	P8 425	P8 425	P8 425	P8 425	P8 425	
30 (0)	510 (0)	990 (0)	1470 (0)	1950 (0)	2375 (0)	2800 (0)	3225 (0)	3650 (0)	4075 (0)	4500 (0)	4925 (0)	5350 (0)	5775 (0)

Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	510	0	P7	0	0
3	990	0	P7	0	0
4	1470	0	P7	0	0
5	1950	0	P7	0	0
6	2375	0	P8	0	0
7	2800	0	P8	0	0
8	3225	0	P8	0	0
9	3650	0	P8	0	0
10	4075	0	P8	0	0
11	4500	0	P8	0	0
12	4925	0	P8	0	0
13	5350	0	P8	0	0
14	5775	0	P8	0	0

Layout 24 of 26

Stock:1	Length:6100	Qty:1	Utl %:97.54	No Offcuts	End Trim:30
[P8] 425x14					
425x14 [ET=30]					

P8 425	P8 425	P8 425	P8 425	P8 425	P8 425	P8 425	P8 425	P8 425	P8 425	P8 425	P8 425	P8 425	P8 425
-----------	-----------	-----------	-----------	-----------	-----------	-----------	-----------	-----------	-----------	-----------	-----------	-----------	-----------

30 (0) 455 (0) 880 (0) 1305 (0) 1730 (0) 2155 (0) 2580 (0) 3005 (0) 3430 (0) 3855 (0) 4280 (0) 4705 (0) 5130 (0) 5555 (0) 5980 (0)

Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	455	0	P8	0	0
3	880	0	P8	0	0
4	1305	0	P8	0	0
5	1730	0	P8	0	0
6	2155	0	P8	0	0
7	2580	0	P8	0	0
8	3005	0	P8	0	0
9	3430	0	P8	0	0
10	3855	0	P8	0	0
11	4280	0	P8	0	0
12	4705	0	P8	0	0
13	5130	0	P8	0	0
14	5555	0	P8	0	0
15	5980	0	P8	0	0

Layout 25 of 26

Stock:1	Length:6100	Qty:1	Utl %:97.00	No Offcuts	End Trim:30
[P8] 425x3	[P9] 422x11				
425x3	422x11	[ET=30]			

P8 425	P8 425	P8 425	P9 422	P9 422	P9 422	P9 422	P9 422	P9 422	P9 422	P9 422	P9 422	P9 422	P9 422
-----------	-----------	-----------	-----------	-----------	-----------	-----------	-----------	-----------	-----------	-----------	-----------	-----------	-----------

30 (0) 455 (0) 880 (0) 1305 (0) 1727 (0) 2149 (0) 2571 (0) 2993 (0) 3415 (0) 3837 (0) 4259 (0) 4681 (0) 5103 (0) 5525 (0) 5947 (0)

Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	455	0	P8	0	0
3	880	0	P8	0	0
4	1305	0	P8	0	0
5	1727	0	P9	0	0
6	2149	0	P9	0	0
7	2571	0	P9	0	0
8	2993	0	P9	0	0
9	3415	0	P9	0	0
10	3837	0	P9	0	0
11	4259	0	P9	0	0
12	4681	0	P9	0	0
13	5103	0	P9	0	0
14	5525	0	P9	0	0
15	5947	0	P9	0	0

Layout 26 of 26

Stock:1	Length:6100	Qty:1	Utl %:99.51	Offcut:3116	End Trim:30
[P9] 422x7					
422x7 [ET=30]					

P9 422	P9 422	P9 422	P9 422	P9 422	P9 422	P9 422	
-----------	-----------	-----------	-----------	-----------	-----------	-----------	--

30 (0) 452 (0) 874 (0) 1296 (0) 1718 (0) 2140 (0) 2562 (0) 2984 (0)

Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	30	0	ET	0	0
2	452	0	P9	0	0
3	874	0	P9	0	0
4	1296	0	P9	0	0
5	1718	0	P9	0	0
6	2140	0	P9	0	0
7	2562	0	P9	0	0
8	2984	0	P9	0	0

Offcut/Drops List

No.	From Stock	Size	Qty	Weight
1	1	3116	1	3.116

Material Usage Summary (All Lengths in "[m]")

Section	Used Len	Used Wt	Scrap Len	Total Scrap Weight	Off Len	Total Offcut Weight
	390.4	390.4	4.593	4.593	3.116	3.116
L203 x 203 x 28.6	0	0	0	0	0	0