



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	Fiona
File Name	N:/Plus1D/Samples/singlebed_bom_100.p1D
Job Order	Bed Mfg.
Customer	gb
Date	Monday, November 15, 2004
PLUS 1D Version No.	7.55

Summary of Optimization Results

Project Name	Fiona
Number of Layouts	32
Number of Stock Used	1537
Total Parts Required	10400
Total Parts Nested	10400
Total Utilization	98.655
Overall Cost	153700
Minimum Offcut Size	2000
Loss per cut	3
Total Part Length	9258.04 [m]
Total Stock Length	9398.8 [m]
Total Stock Weight	9398.8
Total Part Weight	9258.04
Total Offcut Weight	14.311
Total Scrap Weight	126.449
Cutting time (in Minutes)	8863
Machine loading time (in Minutes)	1537
Total Machine (in Minutes)	10400

Summary of Layouts

No.	Section	Stock	Size	Qty	Utl %	Rest	Details [PartLength x Qty]
1	12.7MM_ SQ	4	6000	75	99.2	12	496x12
2	12.7MM_ SQ	4	6000	75	99.2	12	496x12

No.	Section	Stock	Size	Qty	Utl %	Rest	Details [PartLength x Qty]
3	19MM_S Q	3	6200	300	98.52	80	1527x4
4	19MM_S Q	3	6200	300	98.52	80	1527x4
5	22MM_S Q	7	6000	63	99.44	9.8	1505.5x2 606x2 460x2 411.6x2
6	22MM_S Q	7	6000	82	99.25	15	1505.5x1 627.7x3 460x2 411.6x4
7	22MM_S Q	7	6000	50	99.48	1.4	1505.5x1 627.7x3 606x2 397.5x2 286.5x2
8	22MM_S Q	7	6000	85	99.36	8.2	1505.5x1 627.7x3 606x1 571x1 411.6x2 286.5x2
9	22MM_S Q	7	6000	53	99.16	11.5	1505.5x1 571x4 397.5x4 142.5x4
10	22MM_S Q	7	6000	10	98.81	17.2	460x2 411.6x8 286.5x4 142.5x4
11	22MM_S Q	7	6000	42	99.23	9.9	627.7x3 606x2 571x1 460x2 397.5x2 286.5x2
12	22MM_S Q	7	6000	14	99.19	3.7	627.7x1 571x4 411.6x6 142.5x4
13	22MM_S Q	7	6000	2	97.38	34.5	142.5x41
14	22MM_S Q	7	6000	1	98.57	67.6	1505.5x3 627.7x2 142.5x1
15	22MM_S Q	7	6000	1	98.32	76.6	1505.5x1 627.7x7
16	22MM_S Q	7	6000	1	98.08	85	606x5 571x5
17	22MM_S Q	7	6000	1	98.8	30.3	460x6 411.6x7 286.5x1
18	22MM_S Q	7	6000	1	98.92	4.5	411.6x5 397.5x4 286.5x5 142.5x6
19	22MM_S Q	7	6000	1	99.85	(5563. 5)	142.5x3
20	24.4x3	2	6200	50	97.1	168	1505x4
21	24.4x3	2	6200	50	97.1	168	1505x4
22	25.4x1.2	1	6200	66	99.56	18.5	2057.5x3
23	25.4x1.2	1	6200	1	99.56	18.5	2057.5x2 2057.5x1
24	25.4x1.2	1	6200	66	99.56	18.5	2057.5x3
25	25.4x1.2	1	6200	1	99.95	(4139. 5)	2057.5x1
26	38MM_S Q	6	6200	50	97.42	148	1510x4
27	50MM_S Q	5	6000	40	96.57	182	818x5 568x3
28	50MM_S Q	5	6000	17	96.57	182	818x5 568x3
29	50MM_S Q	5	6000	4	97.7	111	818x3 568x6

No.	Section	Stock	Size	Qty	Utl %	Rest	Details [PartLength x Qty]
30	50MM_S Q	5	6000	1	97.7	111	818x3 568x5 568x1
31	50MM_S Q	5	6000	33	97.7	111	818x3 568x6
32	50MM_S Q	5	6000	1	99.9	(4608)	818x1 568x1

Stock Details[Job Order = Bed Mfg.]

Stock	Section	Length	Qty	Cost/Piece	Used	Total Cost	Remarks
1	25.4x1.2	6200	250	100	134	13400	
2	24.4x3	6200	200	100	100	10000	
3	19MM_SQ	6200	1000	100	600	60000	
4	12.7MM_SQ	6000	200	100	150	15000	
5	50MM_SQ	6000	100	100	96	9600	
6	38MM_SQ	6200	100	100	50	5000	
7	22MM_SQ	6000	500	100	407	40700	
Total					1537	153700	

Part Details

Part	Section	Length	Qty	Cut	Weight	Remarks
FQB-TB	25.4x1.2	2057.5	200	200	2.058	Tie bar
VEN-TB	25.4x1.2	2057.5	200	200	2.058	Tie bar
FQB-ATB	24.4x3	1505	200	200	1.505	Angle for Tie bar
VEN-ATB	24.4x3	1505	200	200	1.505	Angle for Tie bar
FQB-TP	38MM_SQ	1510	200	200	1.51	Top Pipe
FQB-LP	19MM_SQ	1527	120	120	1.527	Long Pipe
VEN-LP	19MM_SQ	1527	120	120	1.527	Long Pipe
FQB-HPB	22MM_SQ	1505.5	400	400	1.506	Hor Pipe Big
FQB-LBLR	50MM_SQ	818	200	200	0.818	Leg Big L.H.& R.H.
VEN-LBLR	50MM_SQ	818	200	200	0.818	Leg Big L.H.& R.H.
FQB-HPS	22MM_SQ	627.7	800	800	0.628	Hor Pipe Small
VEN-HPS	22MM_SQ	606	400	400	0.606	Hor Pipe Small
VEN-VPB 1	22MM_SQ	571	400	400	0.571	Vrt. Pipe Big
FQB-LSLR	50MM_SQ	568	200	200	0.568	Leg Small L.H.& R.H.
VEN-LSLR	50MM_SQ	568	200	200	0.568	Leg Small L.H.& R.H.
FQB-SP	12.7MM_SQ	496	900	900	0.496	Short Pipe
VEN-SP	12.7MM_SQ	496	900	900	0.496	Short Pipe
VEN-VPS 1	22MM_SQ	460	400	400	0.46	Vrt. Pipe Small
FQB-VPB	22MM_SQ	411.6	800	800	0.412	Vrt. Pipe Big
VEN-VPB 2	22MM_SQ	397.5	400	400	0.398	Vrt. Pipe Big
VEN-VPS 2	22MM_SQ	286.5	400	400	0.287	Vrt. Pipe Small
FQB-VPS	22MM_SQ	142.5	400	400	0.143	Vrt. Pipe Small

Layout 1 of 32

Stock:4	Section:12.7MM_SQ	Length:6000	Qty:75	Utl %:99.20	No Offcuts
[FQB-SP] 496x12					
496x12					

FQB-S 496	FQB-S 496	FQB-S 496	FQB-S 496	FQB-S 496	FQB-S 496	FQB-S 496	FQB-S 496	FQB-S 496	FQB-S 496	FQB-S 496	FQB-S 496
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	499	0	FQB-SP	0	0
2	998	0	FQB-SP	0	0
3	1497	0	FQB-SP	0	0
4	1996	0	FQB-SP	0	0
5	2495	0	FQB-SP	0	0
6	2994	0	FQB-SP	0	0
7	3493	0	FQB-SP	0	0
8	3992	0	FQB-SP	0	0
9	4491	0	FQB-SP	0	0
10	4990	0	FQB-SP	0	0
11	5489	0	FQB-SP	0	0
12	5988	0	FQB-SP	0	0

Layout 2 of 32

Stock:4	Section:12.7MM_SQ	Length:6000	Qty:75	Utl %:99.20	No Offcuts
[VEN-SP] 496x12					
496x12					

VEN-S 496	VEN-S 496	VEN-S 496	VEN-S 496	VEN-S 496	VEN-S 496	VEN-S 496	VEN-S 496	VEN-S 496	VEN-S 496	VEN-S 496	VEN-S 496
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	499	0	VEN-SP	0	0
2	998	0	VEN-SP	0	0
3	1497	0	VEN-SP	0	0
4	1996	0	VEN-SP	0	0
5	2495	0	VEN-SP	0	0
6	2994	0	VEN-SP	0	0
7	3493	0	VEN-SP	0	0
8	3992	0	VEN-SP	0	0
9	4491	0	VEN-SP	0	0
10	4990	0	VEN-SP	0	0
11	5489	0	VEN-SP	0	0
12	5988	0	VEN-SP	0	0

Layout 3 of 32

Stock:3	Section:19MM_SQ	Length:6200	Qty:300	Utl %:98.52	No Offcuts
[FQB-LP] 1527x4					
1527x4					

FQB-LP 1527	FQB-LP 1527	FQB-LP 1527	FQB-LP 1527
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	1530	0	FQB-LP	0	0
2	3060	0	FQB-LP	0	0
3	4590	0	FQB-LP	0	0
4	6120	0	FQB-LP	0	0

Layout 4 of 32

Stock:3	Section:19MM_SQ	Length:6200	Qty:300	Utl %:98.52	No Offcuts
[VEN-LP] 1527x4					
1527x4					

VEN-LP 1527	VEN-LP 1527	VEN-LP 1527	VEN-LP 1527
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	1530	0	VEN-LP	0	0
2	3060	0	VEN-LP	0	0
3	4590	0	VEN-LP	0	0
4	6120	0	VEN-LP	0	0

Layout 5 of 32

Stock:7	Section:22MM_SQ	Length:6000	Qty:63	Utl %:99.44	No Offcuts
[FQB-HPB] 1505.5x2 [VEN-HPS] 606x2 [VEN-VPS 1] 460x2 [FQB-VPB] 411.6x2					
1505.5x2 606x2 460x2 411.6x2					

FQB-HPB 1505.5	FQB-HPB 1505.5	VEN-HP 606	VEN-HP 606	VEN-V 460	VEN-V 460	FQB- 411.6	FQB-VPB 411.6
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	1508.5	0	FQB-HPB	0	0
2	3017	0	FQB-HPB	0	0
3	3626	0	VEN-HPS	0	0
4	4235	0	VEN-HPS	0	0
5	4698	0	VEN-VPS 1	0	0
6	5161	0	VEN-VPS 1	0	0
7	5575.6	0	FQB-VPB	0	0

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
8	5990.2	0	FQB-VPB	0	0

Layout 6 of 32

Stock:7	Section:22MM SQ	Length:6000	Qty:82	Utl %:99.25	No Offcuts
[FQB-HPB] 1505.5x1	[FQB-HPS] 627.7x3	[VEN-VPS 1] 460x2	[FQB-VPB] 411.6x4		
1505.5x1	627.7x3	460x2	411.6x4		

FQB-HPB 1505.5	FQB-HP 627.7	FQB-HP 627.7	FQB-HP 627.7	VEN-V 460	VEN-V 460	FQB- 411.6	FQB- 411.6	FQB- 411.6	FQB- 411.6	VPB
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	1508.5	0	FQB-HPB	0	0
2	2139.2	0	FQB-HPS	0	0
3	2769.9	0	FQB-HPS	0	0
4	3400.6	0	FQB-HPS	0	0
5	3863.6	0	VEN-VPS 1	0	0
6	4326.6	0	VEN-VPS 1	0	0
7	4741.2	0	FQB-VPB	0	0
8	5155.8	0	FQB-VPB	0	0
9	5570.4	0	FQB-VPB	0	0
10	5985	0	FQB-VPB	0	0

Layout 7 of 32

Stock:7	Section:22MM SQ	Length:6000	Qty:50	Utl %:99.48	No Offcuts
[FQB-HPB] 1505.5x1	[FQB-HPS] 627.7x3	[VEN-HPS] 606x2	[VEN-VPB 2] 397.5x2	[VEN-VPS 2] 286.5x2	
1505.5x1	627.7x3	606x2	397.5x2	286.5x2	

FQB-HPB 1505.5	FQB-HP 627.7	FQB-HP 627.7	FQB-HP 627.7	VEN-HP 606	VEN-HP 606	VEN- 397.5	VEN- 397.5	VEN- 286	VEN- 286	VPS 2
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	1508.5	0	FQB-HPB	0	0
2	2139.2	0	FQB-HPS	0	0
3	2769.9	0	FQB-HPS	0	0
4	3400.6	0	FQB-HPS	0	0
5	4009.6	0	VEN-HPS	0	0
6	4618.6	0	VEN-HPS	0	0
7	5019.1	0	VEN-VPB 2	0	0
8	5419.6	0	VEN-VPB 2	0	0
9	5709.1	0	VEN-VPS 2	0	0
10	5998.6	0	VEN-VPS 2	0	0

Layout 8 of 32

Stock:7	Section:22MM_SQ	Length:6000	Qty:85	Utl %:99.36	No Offcuts
[FQB-HPB] 1505.5x1	[FQB-HPS] 627.7x3	[VEN-HPS] 606x1	[VEN-VPB 1] 571x1	[FQB-VPB] 411.6x2	[VEN-VPS 2] 286.5x2
1505.5x1	627.7x3	606x1	571x1	411.6x2	286.5x2

FQB-HPB 1505.5	FQB-HP 627.7	FQB-HP 627.7	FQB-HP 627.7	VEN-HP 606	VEN-VP 571	FQB-VP 411.6	FQB-VP 411.6	VEN-VP 286	VEN-VPS 2 286
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	1508.5	0	FQB-HPB	0	0
2	2139.2	0	FQB-HPS	0	0
3	2769.9	0	FQB-HPS	0	0
4	3400.6	0	FQB-HPS	0	0
5	4009.6	0	VEN-HPS	0	0
6	4583.6	0	VEN-VPB 1	0	0
7	4998.2	0	FQB-VPB	0	0
8	5412.8	0	FQB-VPB	0	0
9	5702.3	0	VEN-VPS 2	0	0
10	5991.8	0	VEN-VPS 2	0	0

Layout 9 of 32

Stock:7	Section:22MM_SQ	Length:6000	Qty:53	Utl %:99.16	No Offcuts
[FQB-HPB] 1505.5x1	[VEN-VPB 1] 571x4	[VEN-VPB 2] 397.5x4	[FQB-VPS] 142.5x4		
1505.5x1	571x4	397.5x4	142.5x4		

FQB-HPB 1505.5	VEN-VP 571	VEN-VP 571	VEN-VP 571	VEN-VP 571	VEN-VP 397.5	VEN-VP 397.5	VEN-VP 397.5	VEN-VP 397.5	FQB-VPS 142.5	FQB-VPS 142.5	FQB-VPS 142.5	FQB-VPS 142.5
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	1508.5	0	FQB-HPB	0	0
2	2082.5	0	VEN-VPB 1	0	0
3	2656.5	0	VEN-VPB 1	0	0
4	3230.5	0	VEN-VPB 1	0	0
5	3804.5	0	VEN-VPB 1	0	0
6	4205	0	VEN-VPB 2	0	0
7	4605.5	0	VEN-VPB 2	0	0
8	5006	0	VEN-VPB 2	0	0
9	5406.5	0	VEN-VPB 2	0	0
10	5552	0	FQB-VPS	0	0
11	5697.5	0	FQB-VPS	0	0
12	5843	0	FQB-VPS	0	0
13	5988.5	0	FQB-VPS	0	0

Layout 10 of 32

Stock:7	Section:22MM_SQ	Length:6000	Qty:10	Utl %:98.81	No Offcuts
[VEN-VPS 1] 460x2	[FQB-VPB] 411.6x8	[VEN-VPS 2] 286.5x4	[FQB-VPS] 142.5x4		
460x2	411.6x8	286.5x4	142.5x4		

VEN-V 460	VEN-V 460	FQB- 411.6	FQB- 411.6	FQB- 411.6	FQB- 411.6	FQB- 411.6	FQB- 411.6	FQB- 411.6	FQB- 411.6	VEN 286	VEN 286	VEN 286	VEN 286	F 14	F 14	F 14	F 14	VPS 142.5
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	463	0	VEN-VPS 1	0	0
2	926	0	VEN-VPS 1	0	0
3	1340.6	0	FQB-VPB	0	0
4	1755.2	0	FQB-VPB	0	0
5	2169.8	0	FQB-VPB	0	0
6	2584.4	0	FQB-VPB	0	0
7	2999	0	FQB-VPB	0	0
8	3413.6	0	FQB-VPB	0	0
9	3828.2	0	FQB-VPB	0	0
10	4242.8	0	FQB-VPB	0	0
11	4532.3	0	VEN-VPS 2	0	0
12	4821.8	0	VEN-VPS 2	0	0
13	5111.3	0	VEN-VPS 2	0	0
14	5400.8	0	VEN-VPS 2	0	0
15	5546.3	0	FQB-VPS	0	0
16	5691.8	0	FQB-VPS	0	0
17	5837.3	0	FQB-VPS	0	0
18	5982.8	0	FQB-VPS	0	0

Layout 11 of 32

Stock:7	Section:22MM_SQ	Length:6000	Qty:42	Utl %:99.23	No Offcuts
[FQB-HPS] 627.7x3	[VEN-HPS] 606x2	[VEN-VPB 1] 571x1	[VEN-VPS 1] 460x2	[VEN-VPB 2]	
397.5x2	[VEN-VPS 2] 286.5x2				
627.7x3	606x2	571x1	460x2	397.5x2	286.5x2

FQB-HP 627.7	FQB-HP 627.7	FQB-HP 627.7	VEN-HP 606	VEN-HP 606	VEN-VP 571	VEN-V 460	VEN-V 460	VEN- 397.5	VEN- 397.5	VEN 286	VEN 286	VPS 2 5
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	630.7	0	FQB-HPS	0	0
2	1261.4	0	FQB-HPS	0	0
3	1892.1	0	FQB-HPS	0	0
4	2501.1	0	VEN-HPS	0	0
5	3110.1	0	VEN-HPS	0	0
6	3684.1	0	VEN-VPB 1	0	0
7	4147.1	0	VEN-VPS 1	0	0
8	4610.1	0	VEN-VPS 1	0	0

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
7	1018.5	0	FQB-VPS	0	0
8	1164	0	FQB-VPS	0	0
9	1309.5	0	FQB-VPS	0	0
10	1455	0	FQB-VPS	0	0
11	1600.5	0	FQB-VPS	0	0
12	1746	0	FQB-VPS	0	0
13	1891.5	0	FQB-VPS	0	0
14	2037	0	FQB-VPS	0	0
15	2182.5	0	FQB-VPS	0	0
16	2328	0	FQB-VPS	0	0
17	2473.5	0	FQB-VPS	0	0
18	2619	0	FQB-VPS	0	0
19	2764.5	0	FQB-VPS	0	0
20	2910	0	FQB-VPS	0	0
21	3055.5	0	FQB-VPS	0	0
22	3201	0	FQB-VPS	0	0
23	3346.5	0	FQB-VPS	0	0
24	3492	0	FQB-VPS	0	0
25	3637.5	0	FQB-VPS	0	0
26	3783	0	FQB-VPS	0	0
27	3928.5	0	FQB-VPS	0	0
28	4074	0	FQB-VPS	0	0
29	4219.5	0	FQB-VPS	0	0
30	4365	0	FQB-VPS	0	0
31	4510.5	0	FQB-VPS	0	0
32	4656	0	FQB-VPS	0	0
33	4801.5	0	FQB-VPS	0	0
34	4947	0	FQB-VPS	0	0
35	5092.5	0	FQB-VPS	0	0
36	5238	0	FQB-VPS	0	0
37	5383.5	0	FQB-VPS	0	0
38	5529	0	FQB-VPS	0	0
39	5674.5	0	FQB-VPS	0	0
40	5820	0	FQB-VPS	0	0
41	5965.5	0	FQB-VPS	0	0

Layout 14 of 32

Stock:7	Section:22MM_SQ	Length:6000	Qty:1	Utl %:98.57	No Offcuts
[FQB-HPB] 1505.5x3	[FQB-HPS] 627.7x2	[FQB-VPS] 142.5x1			
1505.5x3	627.7x2	142.5x1			

FQB-HPB 1505.5	FQB-HPB 1505.5	FQB-HPB 1505.5	FQB-HP 627.7	FQB-HP 627.7	FQB-VPS 142.5
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	1508.5	0	FQB-HPB	0	0

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
2	3017	0	FQB-HPB	0	0
3	4525.5	0	FQB-HPB	0	0
4	5156.2	0	FQB-HPS	0	0
5	5786.9	0	FQB-HPS	0	0
6	5932.4	0	FQB-VPS	0	0

Layout 15 of 32

Stock:7	Section:22MM_SQ	Length:6000	Qty:1	Utl %:98.32	No Offcuts
[FQB-HPB] 1505.5x1	[FQB-HPS] 627.7x7				
1505.5x1	627.7x7				

FQB-HPB 1505.5	FQB-HP 627.7	FQB-HP 627.7	FQB-HP 627.7	FQB-HP 627.7	FQB-HP 627.7	FQB-HP 627.7	FQB-HP 627.7	FQB-HPS 627.7
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	1508.5	0	FQB-HPB	0	0
2	2139.2	0	FQB-HPS	0	0
3	2769.9	0	FQB-HPS	0	0
4	3400.6	0	FQB-HPS	0	0
5	4031.3	0	FQB-HPS	0	0
6	4662	0	FQB-HPS	0	0
7	5292.7	0	FQB-HPS	0	0
8	5923.4	0	FQB-HPS	0	0

Layout 16 of 32

Stock:7	Section:22MM_SQ	Length:6000	Qty:1	Utl %:98.08	No Offcuts
[VEN-HPS] 606x5	[VEN-VPB 1] 571x5				
606x5	571x5				

VEN-HP 606	VEN-HP 606	VEN-HP 606	VEN-HP 606	VEN-HP 606	VEN-VP 571	VEN-VP 571	VEN-VP 571	VEN-VP 571	VEN-VPB.1 571
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	609	0	VEN-HPS	0	0
2	1218	0	VEN-HPS	0	0
3	1827	0	VEN-HPS	0	0
4	2436	0	VEN-HPS	0	0
5	3045	0	VEN-HPS	0	0
6	3619	0	VEN-VPB 1	0	0
7	4193	0	VEN-VPB 1	0	0
8	4767	0	VEN-VPB 1	0	0
9	5341	0	VEN-VPB 1	0	0
10	5915	0	VEN-VPB 1	0	0

Layout 17 of 32

Stock:7	Section:22MM_SQ	Length:6000	Qty:1	Utl %:98.80	No Offcuts
[VEN-VPS 1] 460x6	[FQB-VPB] 411.6x7	[VEN-VPS 2] 286.5x1			
460x6	411.6x7	286.5x1			

VEN-460	VEN-460	VEN-460	VEN-460	VEN-460	VEN-460	FQB-411.6	FQB-411.6	FQB-411.6	FQB-411.6	FQB-411.6	FQB-411.6	FQB-411.6	VEN-286.5	VPS 2
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	463	0	VEN-VPS 1	0	0
2	926	0	VEN-VPS 1	0	0
3	1389	0	VEN-VPS 1	0	0
4	1852	0	VEN-VPS 1	0	0
5	2315	0	VEN-VPS 1	0	0
6	2778	0	VEN-VPS 1	0	0
7	3192.6	0	FQB-VPB	0	0
8	3607.2	0	FQB-VPB	0	0
9	4021.8	0	FQB-VPB	0	0
10	4436.4	0	FQB-VPB	0	0
11	4851	0	FQB-VPB	0	0
12	5265.6	0	FQB-VPB	0	0
13	5680.2	0	FQB-VPB	0	0
14	5969.7	0	VEN-VPS 2	0	0

Layout 18 of 32

Stock:7	Section:22MM_SQ	Length:6000	Qty:1	Utl %:98.92	No Offcuts
[FQB-VPB] 411.6x5	[VEN-VPB 2] 397.5x4	[VEN-VPS 2] 286.5x5	[FQB-VPS] 142.5x6		
411.6x5	397.5x4	286.5x5	142.5x6		

FQB-411.6	FQB-411.6	FQB-411.6	FQB-411.6	FQB-411.6	VEN-397.5	VEN-397.5	VEN-397.5	VEN-397.5	VEN-286	VEN-286	VEN-286	VEN-286	VEN-286	FQB-142.5	FQB-142.5	FQB-142.5	FQB-142.5	FQB-142.5	FQB-142.5	VPS
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	414.6	0	FQB-VPB	0	0
2	829.2	0	FQB-VPB	0	0
3	1243.8	0	FQB-VPB	0	0
4	1658.4	0	FQB-VPB	0	0
5	2073	0	FQB-VPB	0	0
6	2473.5	0	VEN-VPB 2	0	0
7	2874	0	VEN-VPB 2	0	0
8	3274.5	0	VEN-VPB 2	0	0
9	3675	0	VEN-VPB 2	0	0
10	3964.5	0	VEN-VPS 2	0	0
11	4254	0	VEN-VPS 2	0	0
12	4543.5	0	VEN-VPS 2	0	0
13	4833	0	VEN-VPS 2	0	0

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
14	5122.5	0	VEN-VPS 2	0	0
15	5268	0	FQB-VPS	0	0
16	5413.5	0	FQB-VPS	0	0
17	5559	0	FQB-VPS	0	0
18	5704.5	0	FQB-VPS	0	0
19	5850	0	FQB-VPS	0	0
20	5995.5	0	FQB-VPS	0	0

Layout 19 of 32

Stock:7	Section:22MM_SQ	Length:6000	Qty:1	Utl %:99.85	Offcut:5563.5
[FQB-VPS] 142.5x3					
142.5x3					

FQB-VPS 14 14 142.5

Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	145.5	0	FQB-VPS	0	0
2	291	0	FQB-VPS	0	0
3	436.5	0	FQB-VPS	0	0

Layout 20 of 32

Stock:2	Section:24.4x3	Length:6200	Qty:50	Utl %:97.10	No Offcuts
[FQB-ATB] 1505x4					
1505x4					

FQB-ATB 1505	FQB-ATB 1505	FQB-ATB 1505	FQB-ATB 1505
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	1508	0	FQB-ATB	0	0
2	3016	0	FQB-ATB	0	0
3	4524	0	FQB-ATB	0	0
4	6032	0	FQB-ATB	0	0

Layout 21 of 32

Stock:2	Section:24.4x3	Length:6200	Qty:50	Utl %:97.10	No Offcuts
[VEN-ATB] 1505x4					
1505x4					

VEN-ATB 1505	VEN-ATB 1505	VEN-ATB 1505	VEN-ATB 1505
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	1508	0	VEN-ATB	0	0
2	3016	0	VEN-ATB	0	0
3	4524	0	VEN-ATB	0	0
4	6032	0	VEN-ATB	0	0

Layout 22 of 32

Stock:1	Section:25.4x1.2	Length:6200	Qty:66	Utl %:99.56	No Offcuts
[FQB-TB] 2057.5x3					
2057.5x3					

FQB-TB 2057.5	FQB-TB 2057.5	FQB-TB 2057.5
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	2060.5	0	FQB-TB	0	0
2	4121	0	FQB-TB	0	0
3	6181.5	0	FQB-TB	0	0

Layout 23 of 32

Stock:1	Section:25.4x1.2	Length:6200	Qty:1	Utl %:99.56	No Offcuts
[FQB-TB] 2057.5x2 [VEN-TB] 2057.5x1					
2057.5x2 2057.5x1					

FQB-TB 2057.5	FQB-TB 2057.5	VEN-TB 2057.5
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	2060.5	0	FQB-TB	0	0
2	4121	0	FQB-TB	0	0
3	6181.5	0	VEN-TB	0	0

Layout 24 of 32

Stock:1	Section:25.4x1.2	Length:6200	Qty:66	Utl %:99.56	No Offcuts
[VEN-TB] 2057.5x3					
2057.5x3					

VEN-TB 2057.5	VEN-TB 2057.5	VEN-TB 2057.5
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	2060.5	0	VEN-TB	0	0
2	4121	0	VEN-TB	0	0

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
3	6181.5	0	VEN-TB	0	0

Layout 25 of 32

Stock:1	Section:25.4x1.2	Length:6200	Qty:1	Utl %:99.95	Offcut:4139.5
[VEN-TB] 2057.5x1					
2057.5x1					

VEN-TB 2057.5	
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	2060.5	0	VEN-TB	0	0

Layout 26 of 32

Stock:6	Section:38MM_SQ	Length:6200	Qty:50	Utl %:97.42	No Offcuts
[FQB-TP] 1510x4					
1510x4					

FQB-TP 1510	FQB-TP 1510	FQB-TP 1510	FQB-TP 1510	
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	1513	0	FQB-TP	0	0
2	3026	0	FQB-TP	0	0
3	4539	0	FQB-TP	0	0
4	6052	0	FQB-TP	0	0

Layout 27 of 32

Stock:5	Section:50MM_SQ	Length:6000	Qty:40	Utl %:96.57	No Offcuts
[FQB-LBLR] 818x5 [FQB-LSLR] 568x3					
818x5 568x3					

FQB-LBLR 818	FQB-LBLR 818	FQB-LBLR 818	FQB-LBLR 818	FQB-LBLR 818	FQB-LS 568	FQB-LS 568	FQB-LSLR 568
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	821	0	FQB-LBLR	0	0
2	1642	0	FQB-LBLR	0	0
3	2463	0	FQB-LBLR	0	0
4	3284	0	FQB-LBLR	0	0
5	4105	0	FQB-LBLR	0	0
6	4676	0	FQB-LSLR	0	0
7	5247	0	FQB-LSLR	0	0

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
8	5818	0	FQB-LSLR	0	0

Layout 28 of 32

Stock:5	Section:50MM_SQ	Length:6000	Qty:17	Utl %:96.57	No Offcuts
[VEN-LBLR] 818x5 [FQB-LSLR] 568x3					
818x5 568x3					

VEN-LBLR 818	VEN-LBLR 818	VEN-LBLR 818	VEN-LBLR 818	VEN-LBLR 818	FQB-LS 568	FQB-LS 568	FQB-LSLR 568
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	821	0	VEN-LBLR	0	0
2	1642	0	VEN-LBLR	0	0
3	2463	0	VEN-LBLR	0	0
4	3284	0	VEN-LBLR	0	0
5	4105	0	VEN-LBLR	0	0
6	4676	0	FQB-LSLR	0	0
7	5247	0	FQB-LSLR	0	0
8	5818	0	FQB-LSLR	0	0

Layout 29 of 32

Stock:5	Section:50MM_SQ	Length:6000	Qty:4	Utl %:97.70	No Offcuts
[VEN-LBLR] 818x3 [FQB-LSLR] 568x6					
818x3 568x6					

VEN-LBLR 818	VEN-LBLR 818	VEN-LBLR 818	FQB-LS 568	FQB-LS 568	FQB-LS 568	FQB-LS 568	FQB-LS 568	FQB-LSLR 568
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	821	0	VEN-LBLR	0	0
2	1642	0	VEN-LBLR	0	0
3	2463	0	VEN-LBLR	0	0
4	3034	0	FQB-LSLR	0	0
5	3605	0	FQB-LSLR	0	0
6	4176	0	FQB-LSLR	0	0
7	4747	0	FQB-LSLR	0	0
8	5318	0	FQB-LSLR	0	0
9	5889	0	FQB-LSLR	0	0

Layout 30 of 32

Stock:5	Section:50MM_SQ	Length:6000	Qty:1	Utl %:97.70	No Offcuts
[VEN-LBLR] 818x3 [FQB-LSLR] 568x5 [VEN-LSLR] 568x1					
818x3 568x5 568x1					

VEN-LBLR 818	VEN-LBLR 818	VEN-LBLR 818	FQB-LS 568	FQB-LS 568	FQB-LS 568	FQB-LS 568	FQB-LS 568	VEN-LSLR 568
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	821	0	VEN-LBLR	0	0
2	1642	0	VEN-LBLR	0	0
3	2463	0	VEN-LBLR	0	0
4	3034	0	FQB-LSLR	0	0
5	3605	0	FQB-LSLR	0	0
6	4176	0	FQB-LSLR	0	0
7	4747	0	FQB-LSLR	0	0
8	5318	0	FQB-LSLR	0	0
9	5889	0	VEN-LSLR	0	0

Layout 31 of 32

Stock:5	Section:50MM SQ	Length:6000	Qty:33	Utl %:97.70	No Offcuts
[VEN-LBLR] 818x3 [VEN-LSLR] 568x6					
818x3 568x6					

VEN-LBLR 818	VEN-LBLR 818	VEN-LBLR 818	VEN-LS 568	VEN-LS 568	VEN-LS 568	VEN-LS 568	VEN-LS 568	VEN-LSLR 568
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	821	0	VEN-LBLR	0	0
2	1642	0	VEN-LBLR	0	0
3	2463	0	VEN-LBLR	0	0
4	3034	0	VEN-LSLR	0	0
5	3605	0	VEN-LSLR	0	0
6	4176	0	VEN-LSLR	0	0
7	4747	0	VEN-LSLR	0	0
8	5318	0	VEN-LSLR	0	0
9	5889	0	VEN-LSLR	0	0

Layout 32 of 32

Stock:5	Section:50MM SQ	Length:6000	Qty:1	Utl %:99.90	Offcut:4608
[VEN-LBLR] 818x1 [VEN-LSLR] 568x1					
818x1 568x1					

VEN-LBLR 818	VEN-LSLR 568
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	821	0	VEN-LBLR	0	0
2	1392	0	VEN-LSLR	0	0

Offcut/Drops List

No.	From Stock	Size	Qty	Weight	Cost	Material
1	7	5563.5	1	5.564	87.162	22MM_S Q
2	1	4139.5	1	4.14	62.76	25.4x1.2
3	5	4608	1	4.608	72.192	50MM_S Q

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

Section	Used Len	Used Wt	Scrap Len	Total Scrap Weight	Off Len	Total Offcut Weight
12.7MM_SQ	900	900	1.8	1.8	0	0
19MM_SQ	3720	3720	48	48	0	0
22MM_SQ	2442	2442	4.196	4.196	5.564	5.564
24.4x3	620	620	16.8	16.8	0	0
25.4x1.2	830.8	830.8	2.461	2.46	4.14	4.14
38MM_SQ	310	310	7.4	7.4	0	0
50MM_SQ	576	576	14.592	14.592	4.608	4.608