



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	Ash grove
File Name	N:/Plus1D/Samples/twomaterials.p1d
Job Order	6x356/03
Customer	F/3511
Issued By	Ling
Remarks	Champgne Gold
Date	Wednesday, October 08, 2003
PLUS 1D Version No.	7.55

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.	Section	Stock	Size	Qty	Utl %	Rest	Details [PartLength x Qty]
1	L203 x 203 x	3991_6100	6100	1	99.51	6	1720x2 940x1 750x1 470x2

No.	Section	Stock	Size	Qty	Utl %	Rest	Details [PartLength x Qty]
	28.6						
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 x 28.6	3991_6100	6100	1	99.61	(1236)	1200x2 750x2 470x2
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	Section	Length	Qty	Cost/ Piece	Stk Wt [Kg]	Use d	Total Cost	Total Wt [Kg]	Remarks
3991_6100	L203 x 203 x 28.6	6100	100	444	6.1	4	1776	24.4	
3992_6100	W1100 x 499	6100	100	100	6.1	2	200	12.2	
Total						6	1976	36.6	

Part Details

Part	Section	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	Section: 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 1720	a5 1720	a2 940	a3 750	a4 470	a4 470
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	1724	0	a5	0	0
2	3448	0	a5	0	0
3	4392	0	a2	0	0
4	5146	0	a3	0	0
5	5620	0	a4	0	0
6	6094	0	a4	0	0



Layout 2 of 6

Stock: 3991_6100	Section: 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 1720	a5 1720	a6 1650	a2 940
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	1724	0	a5	0	0
2	3448	0	a5	0	0
3	5102	0	a6	0	0
4	6046	0	a2	0	0



Layout 3 of 6

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

a6 1650	a6 1650	a6 1650	a3 750	
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	1654	0	a6	0	0
2	3308	0	a6	0	0
3	4962	0	a6	0	0
4	5716	0	a3	0	0



Layout 4 of 6

Stock:3991_6100	Section: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 1200	a1 1200	a3 750	a3 750	a4 470	a4 470	
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	1204	0	a1	0	0
2	2408	0	a1	0	0
3	3162	0	a3	0	0
4	3916	0	a3	0	0
5	4390	0	a4	0	0
6	4864	0	a4	0	0



Layout 5 of 6

Stock:3992_6100	Section: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 1200	b2 1075	b2 1075	b3 940	b3 940	b4 750
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	1204	0	b1	0	0
2	2283	0	b2	0	0
3	3362	0	b2	0	0
4	4306	0	b3	0	0
5	5250	0	b3	0	0
6	6004	0	b4	0	0



Layout 6 of 6

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

b3 940	b3 940	b3 940	b3 940	b4 750	b4 750	b5 400	b5 400
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Cut Details

Cut No	Cut Position	Angle	Part No	Flipped	Rotated (180)
1	944	0	b3	0	0
2	1888	0	b3	0	0
3	2832	0	b3	0	0
4	3776	0	b3	0	0
5	4530	0	b4	0	0
6	5284	0	b4	0	0
7	5688	0	b5	0	0
8	6092	0	b5	0	0

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

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

Section	Used Len	Used Wt	Scrap Len	Total Scrap Weight	Off Len	Total Offcut Weight
L203 x 203 x 28.6	24.4	24.4	0.444	0.444	1.236	1.236
W1100 x 499	12.2	12.2	0.104	0.104	0	0