



Nirvana Technologies Pvt. Ltd.

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

PLUS 2D Nesting Software Optimization Report

General Details:

Project Name	
File Name	//Server/dev-nirvanatec.com/downloads/plus2d/samples/decoilmtl.plj
Job No	
Customer	
CustomerId	
Created By	
Approved By	
Date	Wednesday, July 21, 2010
Material	steel
Thk	5
PLUS 2D Version No.	8.68

Stock Details:

Id	Width	Cost	Coil Length	Remarks
a	1250	1950	40000	
b	2000	3120	40000	

Part Details:

Name	Fin. Length	Fin. Width	Rotn	Qty	Type	Remarks
a	540	300	1	100	Rect	
b	540	200	1	50	Rect	
c	540	345	1	54	Rect	
d	540	567	1	76	Rect	

Summary of Optimization Results:

Summary of Optimization Results:	
Grinding Margin	0
Saw Width	0
Number of Layouts	6
Number of Stock Used	17
Total Utilization	99.13 %
Total Parts Required	280
Total Parts Nested	280
Reusable Offcuts	0
Total Stock Area	55.41
Total Part Area	54.93
Offcut Area	0
Scrap Area	0.48
Total Stock Weight	2161.03
Total Part Weight	2142.27
Total Offcut Weight	0
Total Scrap Weight	18.76
ScrapWt/PartWt	0.88 %

Summary of Layouts:

No	Name	Length	Qty	Utl%	Cost	Parts	Offcut Qty - Size
1	a	540	3	99.60	3159.00	12	0
2	b	2160	3	100.00	20217.60	84	0
3	b	2179	8	99.20	54387.84	160	0
4	b	1080	1	98.95	3369.60	10	0
5	b	567	1	97.43	1769.04	4	0
6	b	1134	1	93.69	3538.08	10	0

Parts Summary Table:

No	Name	Size (L x W)	Nested (Required)	Area	Weight	Remarks
1	a	540 x 300	100 (100)	16.2	631.8	
2	b	540 x 200	50 (50)	5.4	210.6	
3	c	540 x 345	54 (54)	10.06	392.35	
4	d	540 x 567	76 (76)	23.27	907.52	
		Total	280 (280)	54.93	2142.27	

Stocks used details:

No	Name	Width	Coil Length	Utl Len	Area
1	a	1250	40000	1620	2.02
2	b	2000	40000	26693	53.39
	Total			28313	55.41

Offcut Details :

Id	Length	Width	Cost	Qty	Area
----	--------	-------	------	-----	------

Parts Cut List:

Name	Length	Width	Qty	Remarks Layout-Qty
a	540	300	100	6-1/4-2/3-16/2-72/1-9
b	540	200	50	6-4/4-2/3-32/2-12
c	540	345	54	5-1/4-2/3-48/1-3
d	540	567	76	6-5/5-3/4-4/3-64

Detailed table about Stocks & Parts:

No	Stk Length	Stk Width	Stk Area	Prt Length	Prt Width	Qty	Part Area	Name
1	1250	540	0.68					
				540	300	3	0.49	a
				540	345	1	0.19	c
			99.60 %				0.67	
2	2000	2160	4.32					
				540	300	24	3.89	a
				540	200	4	0.43	b
			100.00 %				4.32	
3	2000	2179	4.36					
				540	300	2	0.32	a
				540	200	4	0.43	b
				540	345	6	1.12	c
				540	567	8	2.45	d
			99.20 %				4.32	
4	2000	1080	2.16					
				540	300	2	0.32	a
				540	200	2	0.22	b
				540	345	2	0.37	c
				540	567	4	1.22	d
			98.95 %				2.14	
5	2000	567	1.13					
				540	345	1	0.19	c
				540	567	3	0.92	d
			97.43 %				1.1	
6	2000	1134	2.27					
				540	300	1	0.16	a
				540	200	4	0.43	b
				540	567	5	1.53	d
			93.69 %				2.12	

Details of each Layout:

a 300 x 540	b 300 x 540	c 300 x 540	d 345 x 540
----------------------	----------------------	----------------------	----------------------

Layout 1 of 6(Stock:a Dim:1250 x 540 Qty:3)

Bill Of Materials:

Name	Length	Width	Qty	Area	Total Qty.	Prod./Re qd.	Remarks
a	540	300	3	0.49	9	0/100	
c	540	345	1	0.19	3	0/54	
Total			4	0.67	12		

Cutting Instructions:

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
1	300	0	300	540
2	600	0	600	540
3	900	0	900	540
4	1245	0	1245	540

a 200 x 540	b 300 x 540	b 300 x 540	b 300 x 540	b 300 x 540	b 300 x 540	b 300 x 540
a 200 x 540	b 300 x 540	b 300 x 540	b 300 x 540	b 300 x 540	b 300 x 540	b 300 x 540
a 200 x 540	b 300 x 540	b 300 x 540	b 300 x 540	b 300 x 540	b 300 x 540	b 300 x 540
a 200 x 540	b 300 x 540	b 300 x 540	b 300 x 540	b 300 x 540	b 300 x 540	b 300 x 540

Layout 2 of 6(Stock:b Dim:2000 x 2160 Qty:3)

Bill Of Materials:

Name	Length	Width	Qty	Area	Total Qty.	Prod/Re qd.	Remarks
a	540	300	24	3.89	72	9/100	
b	540	200	4	0.43	12	0/50	

Name	Length	Width	Qty	Area	Total Qty.	Prod./Re qd.	Remarks
Total			28	4.32	84		

Cutting Instructions:

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
1	0	540	2000	540
2	200	0	200	540
3	500	0	500	540
4	800	0	800	540
5	1100	0	1100	540
6	1400	0	1400	540
7	1700	0	1700	540
8	0	1080	2000	1080
9	200	540	200	1080
10	500	540	500	1080
11	800	540	800	1080
12	1100	540	1100	1080
13	1400	540	1400	1080
14	1700	540	1700	1080
15	0	1620	2000	1620
16	200	1080	200	1620
17	500	1080	500	1620
18	800	1080	800	1620
19	1100	1080	1100	1620
20	1400	1080	1400	1620
21	1700	1080	1700	1620
22	200	1620	200	2160
23	500	1620	500	2160
24	800	1620	800	2160
25	1100	1620	1100	2160
26	1400	1620	1400	2160
27	1700	1620	1700	2160

c* 345 x 540	d* 567 x 540	p 540 x 567	p 540 x 567
c* 345 x 540	d* 567 x 540	p 540 x 567	p 540 x 567
c* 345 x 540	d* 567 x 540	c 540 x 345	c 540 x 345
		a 540 x 300	a 540 x 300
c* 345 x 540	d* 567 x 540	b 540 x 200	b 540 x 200
		b 540 x 200	b 540 x 200

Layout 3 of 6(Stock:b Dim:2000 x 2179 Qty:8)

Bill Of Materials:

Name	Length	Width	Qty	Area	Total Qty.	Prod./Re qd.	Remarks
a	540	300	2	0.32	16	81/100	

Name	Length	Width	Qty	Area	Total Qty.	Prod./Re qd.	Remarks
b	540	200	4	0.43	32	12/50	
c	540	345	6	1.12	48	3/54	
d	540	567	8	2.45	64	0/76	
Total			20	4.32	160		

Cutting Instructions:

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
1	345	0	345	2179
2	0	540	345	540
3	0	1080	345	1080
4	0	1620	345	1620
5	0	2160	345	2160
6	912	0	912	2179
7	345	540	912	540
8	345	1080	912	1080
9	345	1620	912	1620
10	345	2160	912	2160
11	1992	0	1992	2179
12	912	200	1992	200
13	1452	0	1452	200
14	912	400	1992	400
15	1452	200	1452	400
16	912	700	1992	700
17	1452	400	1452	700
18	912	1045	1992	1045
19	1452	700	1452	1045
20	912	1612	1992	1612
21	1452	1045	1452	1612
22	1452	1612	1452	2179



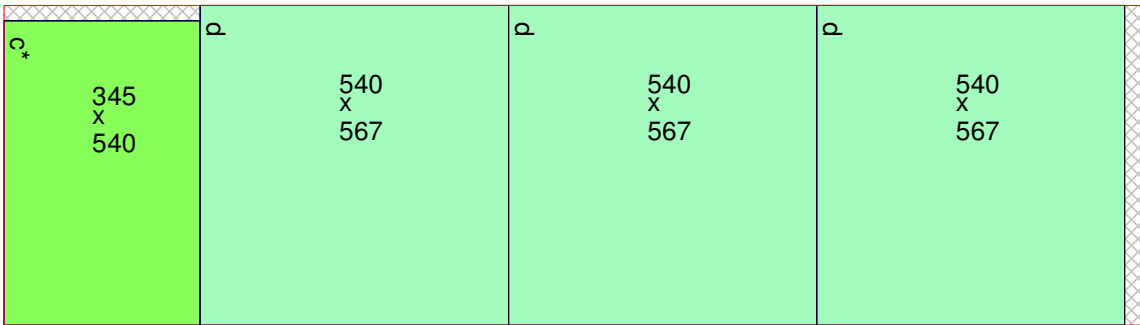
Layout 4 of 6(Stock:b Dim:2000 x 1080 Qty:1)

Bill Of Materials:

Name	Length	Width	Qty	Area	Total Qty.	Prod./Re qd.	Remarks
a	540	300	2	0.32	2	97/100	
b	540	200	2	0.22	2	44/50	
c	540	345	2	0.37	2	51/54	
d	540	567	4	1.22	4	64/76	
Total			10	2.14	10		

Cutting Instructions:

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
1	200	0	200	1080
2	0	540	200	540
3	500	0	500	1080
4	200	540	500	540
5	845	0	845	1080
6	500	540	845	540
7	1412	0	1412	1080
8	845	540	1412	540
9	1979	0	1979	1080
10	1412	540	1979	540



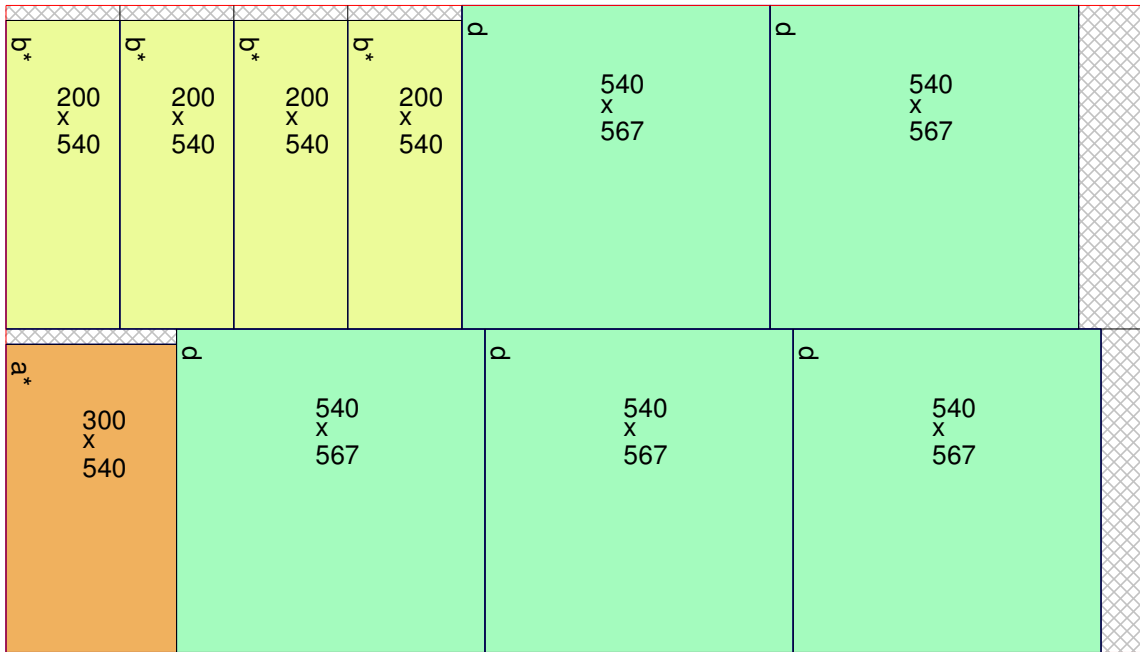
Layout 5 of 6(Stock:b Dim:2000 x 567 Qty:1)

Bill Of Materials:

Name	Length	Width	Qty	Area	Total Qty.	Prod./Re qd.	Remarks
c	540	345	1	0.19	1*	53/54	
d	540	567	3	0.92	3	68/76	
Total			4	1.1	4		

Cutting Instructions:

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
1	345	0	345	567
2	0	540	345	540
3	885	0	885	567
4	1425	0	1425	567
5	1965	0	1965	567



Layout 6 of 6(Stock:b Dim:2000 x 1134 Qty:1)

Bill Of Materials:

Name	Length	Width	Qty	Area	Total Qty.	Prod./Re qd.	Remarks
a	540	300	1	0.16	1*	99/100	
b	540	200	4	0.43	4*	46/50	
d	540	567	5	1.53	5*	71/76	
Total			10	2.12	10		

Cutting Instructions:

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
1	0	567	2000	567
2	300	0	300	567
3	0	540	300	540
4	840	0	840	567
5	1380	0	1380	567
6	1920	0	1920	567
7	200	567	200	1134
8	0	1107	200	1107
9	400	567	400	1134
10	200	1107	400	1107
11	600	567	600	1134
12	400	1107	600	1107

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
13	800	567	800	1134
14	600	1107	800	1107
15	1340	567	1340	1134
16	1880	567	1880	1134