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PLUS 2D Nesting Software Optimization Report

General Details:

Project Name	
File Name	N:/Plus2D/Samples/singlestkmtl.plj
Job No	
Customer	
CustomerId	
Created By	
Approved By	
Date	Wednesday, July 21, 2010
Material	steel
Thk	25.4
PLUS 2D Version No.	8.68

Stock Details:

Id	Length	Width	Cost	Qty	Remarks
s1	1524	1016	2400	1000	

Part Details:

Name	Fin. Length	Fin. Width	Rotn	Qty	Type	Remarks
1	558.8	457.2	1	4	Rect	
2	1016	254	1	2	Rect	
3	330.2	685.8	1	6	Rect	
4	584.2	457.2	1	4	Rect	
5	736.6	203.2	1	8	Rect	
6	406.4	101.6	1	2	Rect	
7	1193.8	228.6	1	2	Rect	
8	482.6	482.6	1	8	Rect	
9	330.2	406.4	1	4	Rect	
10	914.4	406.4	1	8	Rect	

Summary of Optimization Results:

Summary of Optimization Results:	
Grinding Margin	0
Saw Width	0
Number of Layouts	7
Number of Stock Used	8
Total Utilization	92.63 %
Total Parts Required	48
Total Parts Nested	48
Reusable Offcuts	1
Total Stock Area	12.39
Total Part Area	11.16
Offcut Area	0.31
Scrap Area	0.91
Total Stock Weight	2454.13
Total Part Weight	2211.78
Total Offcut Weight	61.35
Total Scrap Weight	180.99
ScrapWt/PartWt	8.18 %

Summary of Layouts:

No	Name	Qty	Util%	Cost	Parts	Offcut Qty - Size
1	s1	2	98.71	4800.00	14	0
2	s1	1	96.33	2400.00	7	0
3	s1	1	94.96	2400.00	6	0
4	s1	1	94.00	2400.00	6	0
5	s1	1	93.17	2400.00	6	0
6	s1	1	84.33	2400.00	5	0
7	s1	1	80.79	2400.00	4	1,[304.8X1016]

Parts Summary Table:

No	Name	Size (L x W)	Nested (Required)	Area	Weight	Remarks
1	1	558.8 x 457.2	4 (4)	1.02	202.47	
2	2	1016 x 254	2 (2)	0.52	102.26	
3	3	330.2 x 685.8	6 (6)	1.36	269.19	
4	4	584.2 x 457.2	4 (4)	1.07	211.67	
5	5	736.6 x 203.2	8 (8)	1.2	237.23	
6	6	406.4 x 101.6	2 (2)	0.08	16.36	
7	7	1193.8 x 228.6	2 (2)	0.55	108.13	
8	8	482.6 x 482.6	8 (8)	1.86	369.14	
9	9	330.2 x 406.4	4 (4)	0.54	106.35	
10	10	914.4 x 406.4	8 (8)	2.97	588.99	
		Total	48 (48)	11.16	2211.78	

Stocks used details:

No	Name	Length	Width	Avail Qty	Utl Qty	Area
1	s1	1524	1016	1000	8	12.39
	Total				8	12.39

Offcut Details :

Id	Length	Width	Cost	Qty	Area
Off_7_2	304.8	1016	480	1	0.31
Total				1	0.31

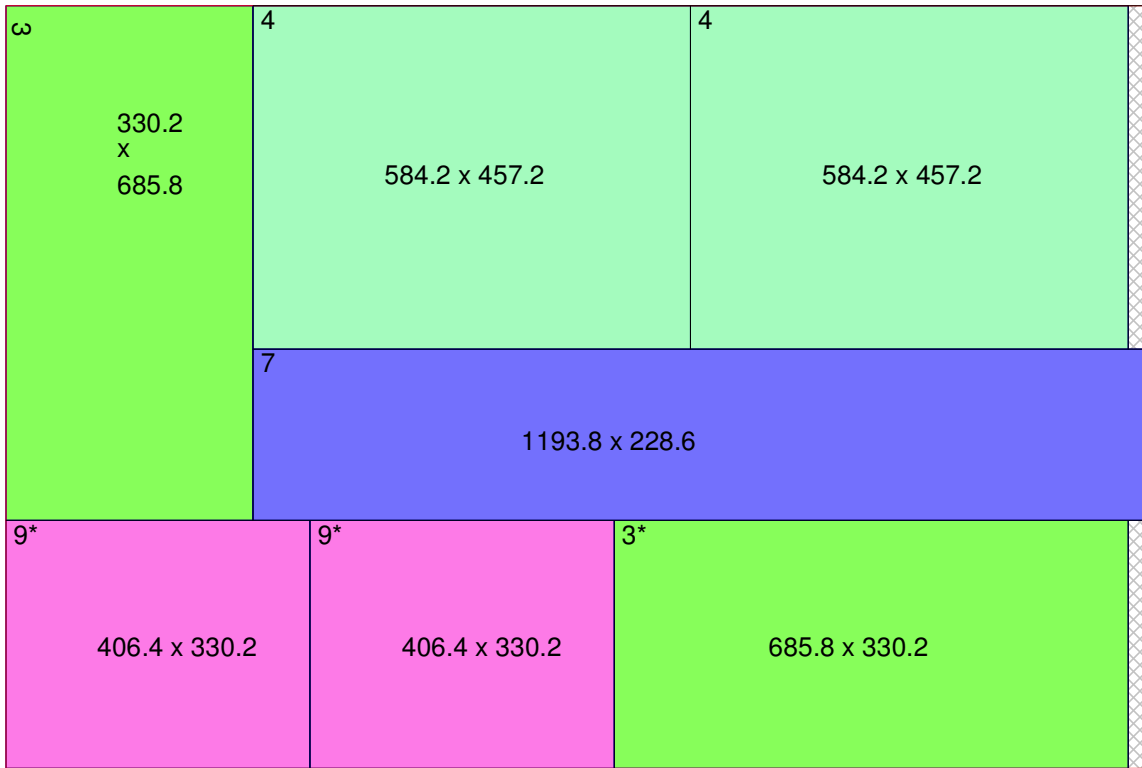
Parts Cut List:

Name	Length	Width	Qty	Remarks Layout-Qty
1	558.8	457.2	4	7-1/5-2/3-1
2	1016	254	2	3-2
3	330.2	685.8	6	7-2/1-4
4	584.2	457.2	4	1-4
5	736.6	203.2	8	6-1/4-2/2-5
6	406.4	101.6	2	6-1/4-1
7	1193.8	228.6	2	1-2
8	482.6	482.6	8	7-1/5-4/3-3
9	330.2	406.4	4	1-4
10	914.4	406.4	8	6-3/4-3/2-2

Detailed table about Stocks & Parts:

No	Stk Length	Stk Width	Stk Area	Prt Length	Prt Width	Qty	Part Area	Name
1	1524	1016	1.55					
				330.2	685.8	2	0.45	3
				584.2	457.2	2	0.53	4
				1193.8	228.6	1	0.27	7
				330.2	406.4	2	0.27	9
			98.71 %				1.53	
2	1524	1016	1.55					
				736.6	203.2	5	0.75	5
				914.4	406.4	2	0.74	10
			96.33 %				1.49	
3	1524	1016	1.55					
				558.8	457.2	1	0.26	1
				1016	254	2	0.52	2
				482.6	482.6	3	0.7	8
			94.96 %				1.47	
4	1524	1016	1.55					
				736.6	203.2	2	0.3	5
				406.4	101.6	1	0.04	6
				914.4	406.4	3	1.11	10
			94.00 %				1.46	
5	1524	1016	1.55					
				558.8	457.2	2	0.51	1
				482.6	482.6	4	0.93	8
			93.17 %				1.44	
6	1524	1016	1.55					
				736.6	203.2	1	0.15	5
				406.4	101.6	1	0.04	6
				914.4	406.4	3	1.11	10
			84.33 %				1.31	
7	1524	1016	1.55					
				558.8	457.2	1	0.26	1
				330.2	685.8	2	0.45	3
				482.6	482.6	1	0.23	8
			80.79 %				0.94	

Details of each Layout:



Layout 1 of 7(Stock:s1 Dim:1524 x 1016 Qty:2)

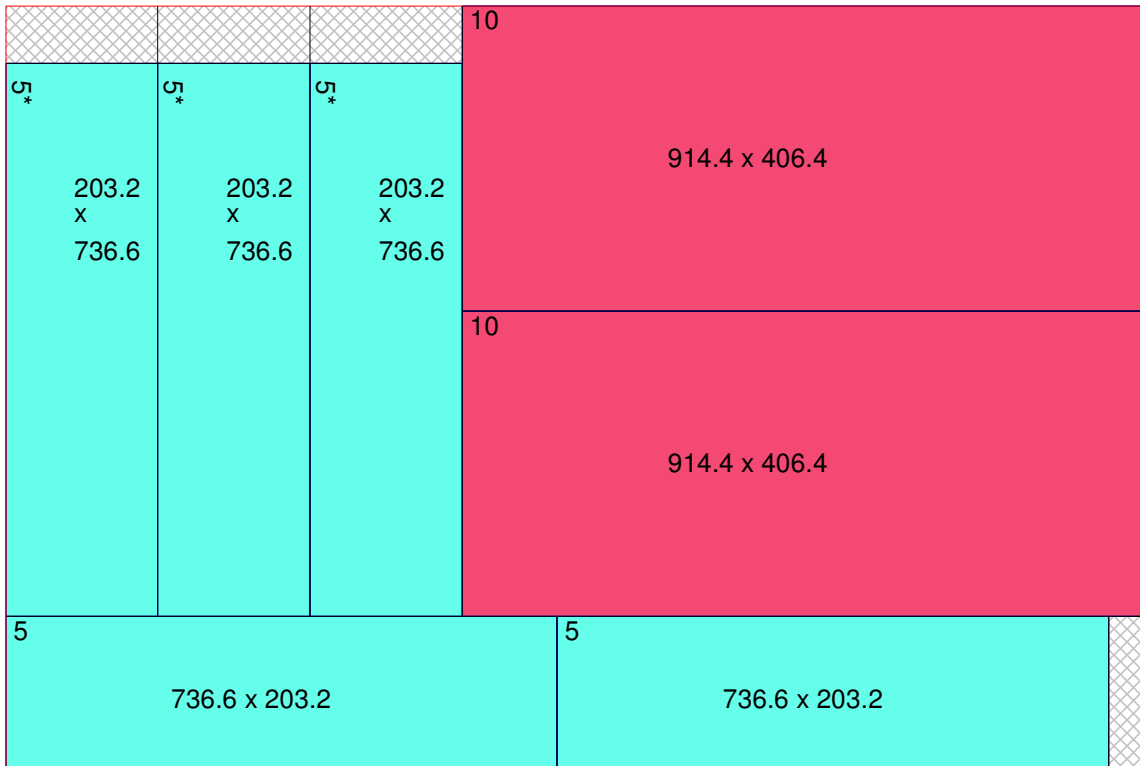
Bill Of Materials:

Name	Length	Width	Qty	Area	Total Qty.	Prod./Re qd.	Remarks
3	330.2	685.8	2	0.45	4	0/6	
4	584.2	457.2	2	0.53	4*	0/4	
7	1193.8	228.6	1	0.27	2*	0/2	
9	330.2	406.4	2	0.27	4*	0/4	
Total			7	1.53	14		

Cutting Instructions:

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
1	0	330.2	1524	330.2
2	406.4	0	406.4	330.2
3	812.8	0	812.8	330.2
4	1498.6	0	1498.6	330.2
5	330.2	330.2	330.2	1016

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
6	330.2	558.8	1524	558.8
7	330.2	1016	1524	1016
8	914.4	558.8	914.4	1016
9	1498.6	558.8	1498.6	1016



Layout 2 of 7(Stock:s1 Dim:1524 x 1016 Qty:1)

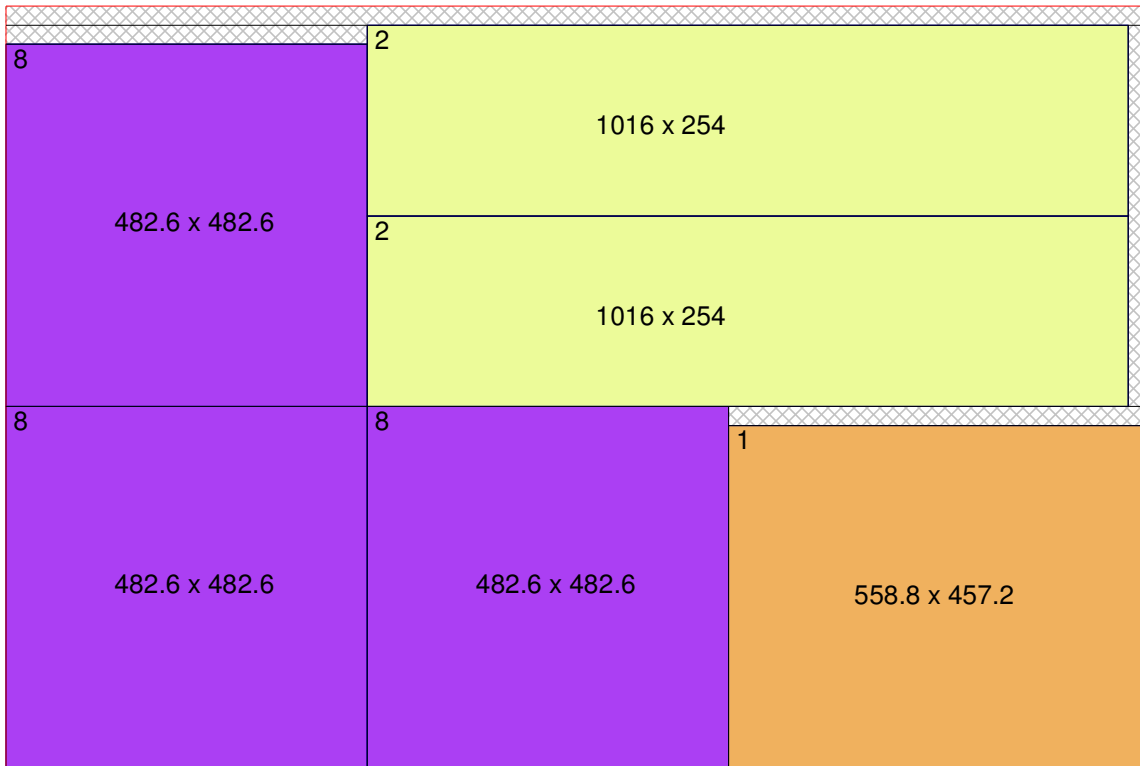
Bill Of Materials:

Name	Length	Width	Qty	Area	Total Qty.	Prod./Re qd.	Remarks
5	736.6	203.2	5	0.75	5	0/8	
10	914.4	406.4	2	0.74	2	0/8	
Total			7	1.49	7		

Cutting Instructions:

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
1	0	203.2	1524	203.2
2	736.6	0	736.6	203.2
3	1473.2	0	1473.2	203.2
4	203.2	203.2	203.2	1016
5	0	939.8	203.2	939.8
6	406.4	203.2	406.4	1016
7	203.2	939.8	406.4	939.8
8	609.6	203.2	609.6	1016
9	406.4	939.8	609.6	939.8
10	1524	203.2	1524	1016

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
11	609.6	609.6	1524	609.6



Layout 3 of 7(Stock:s1 Dim:1524 x 1016 Qty:1)

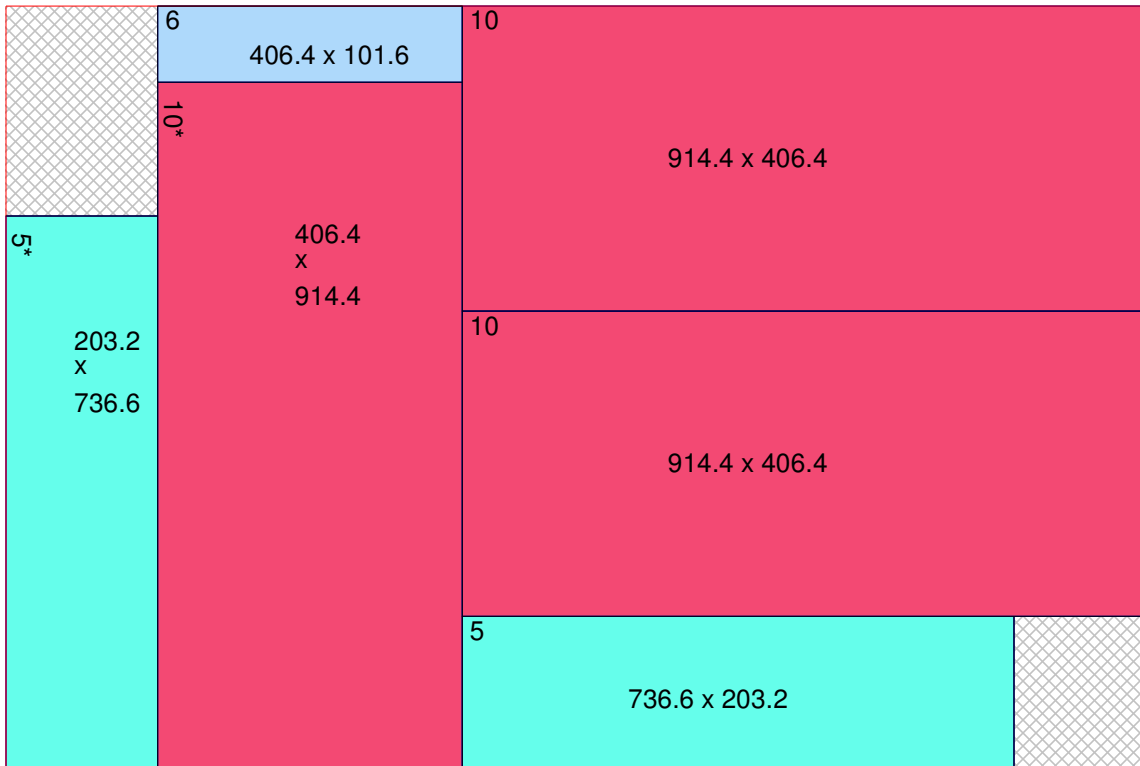
Bill Of Materials:

Name	Length	Width	Qty	Area	Total Qty.	Prod./Re qd.	Remarks
1	558.8	457.2	1	0.26	1	0/4	
2	1016	254	2	0.52	2*	0/2	
8	482.6	482.6	3	0.7	3	0/8	
Total			6	1.47	6		

Cutting Instructions:

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
1	0	482.6	1524	482.6
2	482.6	0	482.6	482.6
3	965.2	0	965.2	482.6
4	1524	0	1524	482.6
5	965.2	457.2	1524	457.2
6	0	990.6	1524	990.6
7	482.6	482.6	482.6	990.6
8	0	965.2	482.6	965.2
9	1498.6	482.6	1498.6	990.6

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
10	482.6	736.6	1498.6	736.6



Layout 4 of 7(Stock:s1 Dim:1524 x 1016 Qty:1)

Bill Of Materials:

Name	Length	Width	Qty	Area	Total Qty.	Prod./Re qd.	Remarks
5	736.6	203.2	2	0.3	2	5/8	
6	406.4	101.6	1	0.04	1	0/2	
10	914.4	406.4	3	1.11	3	2/8	
Total			6	1.46	6		

Cutting Instructions:

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
1	203.2	0	203.2	1016
2	0	736.6	203.2	736.6
3	609.6	0	609.6	1016
4	203.2	914.4	609.6	914.4
5	203.2	1016	609.6	1016
6	609.6	203.2	1524	203.2
7	1346.2	0	1346.2	203.2
8	609.6	609.6	1524	609.6



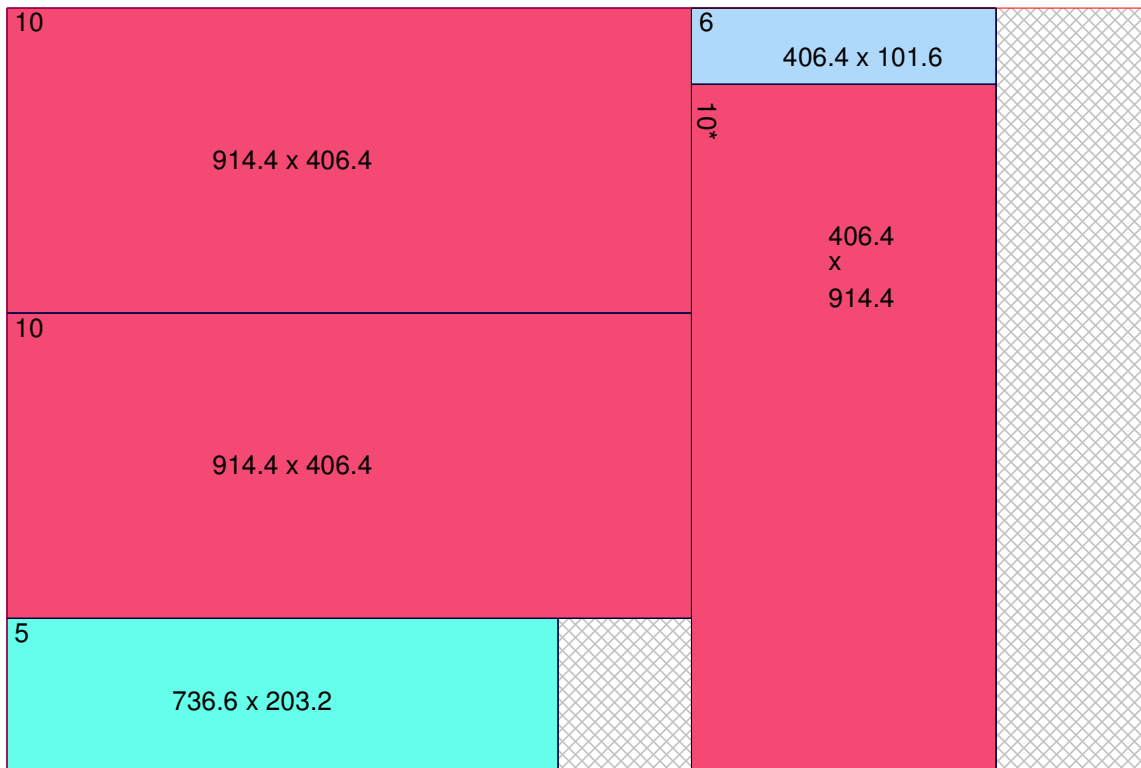
Layout 5 of 7(Stock:s1 Dim:1524 x 1016 Qty:1)

Bill Of Materials:

Name	Length	Width	Qty	Area	Total Qty.	Prod./Re qd.	Remarks
1	558.8	457.2	2	0.51	2	1/4	
8	482.6	482.6	4	0.93	4	3/8	
Total			6	1.44	6		

Cutting Instructions:

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
1	482.6	0	482.6	1016
2	0	482.6	482.6	482.6
3	0	965.2	482.6	965.2
4	965.2	0	965.2	1016
5	482.6	482.6	965.2	482.6
6	482.6	965.2	965.2	965.2
7	1524	0	1524	1016
8	965.2	457.2	1524	457.2
9	965.2	914.4	1524	914.4



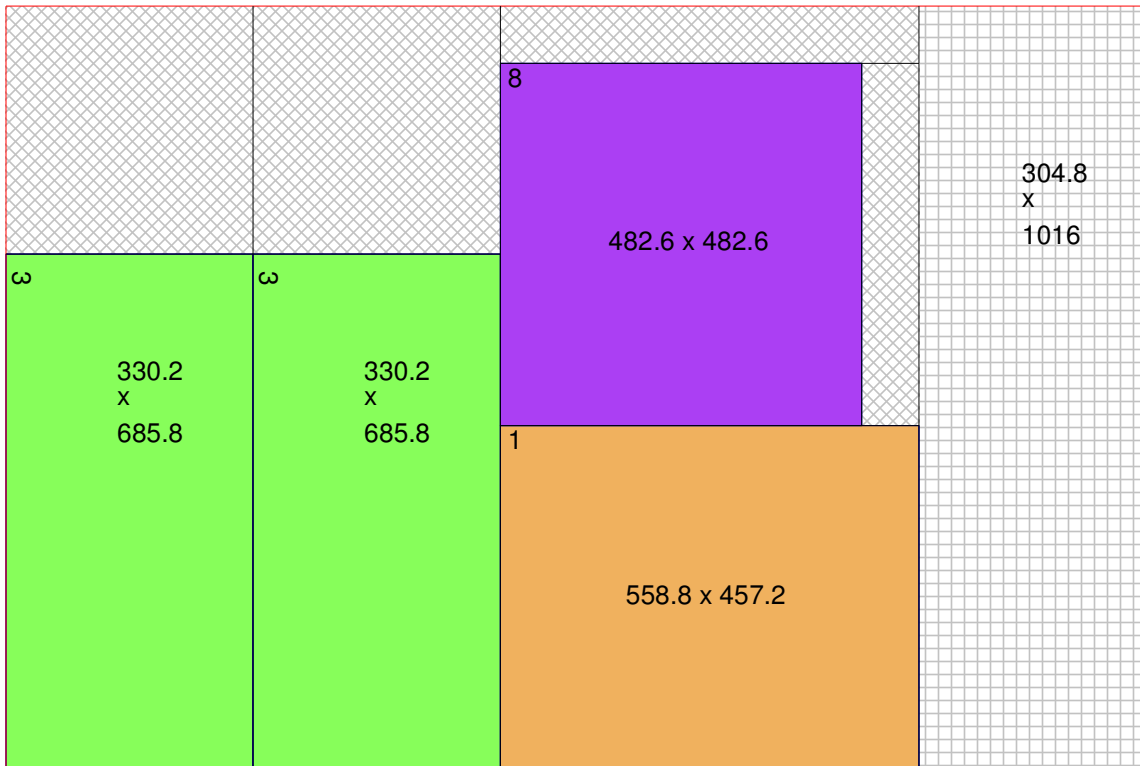
Layout 6 of 7(Stock:s1 Dim:1524 x 1016 Qty:1)

Bill Of Materials:

Name	Length	Width	Qty	Area	Total Qty.	Prod./Re qd.	Remarks
5	736.6	203.2	1	0.15	1*	7/8	
6	406.4	101.6	1	0.04	1*	1/2	
10	914.4	406.4	3	1.11	3*	5/8	
Total			5	1.31	5		

Cutting Instructions:

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
1	914.4	0	914.4	1016
2	0	203.2	914.4	203.2
3	736.6	0	736.6	203.2
4	0	609.6	914.4	609.6
5	1320.8	0	1320.8	1016
6	914.4	914.4	1320.8	914.4
7	914.4	1016	1320.8	1016



Layout 7 of 7(Stock:s1 Dim:1524 x 1016 Qty:1)

Bill Of Materials:

Name	Length	Width	Qty	Area	Total Qty.	Prod./Re qd.	Remarks
1	558.8	457.2	1	0.26	1*	3/4	
3	330.2	685.8	2	0.45	2*	4/6	
8	482.6	482.6	1	0.23	1*	7/8	
Total			4	0.94	4		
Offcuts							
Off_7_2	304.8	1016	1	0.31	1		
Total			1	0.31	1		

Cutting Instructions:

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
1	330.2	0	330.2	1016
2	0	685.8	330.2	685.8
3	660.4	0	660.4	1016
4	330.2	685.8	660.4	685.8
5	1219.2	0	1219.2	1016
6	660.4	457.2	1219.2	457.2

CutIndex	StartPt X	StartPt Y	EndPt X	EndPt Y
7	660.4	939.8	1219.2	939.8
8	1143	457.2	1143	939.8