

Modular V11

Compact Guide

Revision 1.12

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1. Introduction

Welcome to V11



Splash screen

What does V11 do?

V11 is a comprehensive software package that covers most aspects of optimisation and production for the Furniture, Woodworking, and other sheet processing industries. It is Windows software which runs on most computers. It provides all the information to keep control of costs, cut down errors, and cut material efficiently and effectively.

V11 deals with a variety of products.

- Kitchen cabinets
- Office furniture
- Shop fittings
- Doors
- Plastic fabrications
- Caravans
- Bathrooms
- Vanity Units

Enter or import part sizes and quantities and let the program create a set of cutting patterns and cutting instructions. From the cutting patterns send information directly to the saw or machining centre to cut each pattern and machine each part.

The program works in Millimetres, Decimal Inches, or Fractional (Imperial) inches. Part lists can be entered in any measurement and converted.

A quick tour

The basic steps are:-

- Create or Import a list of part sizes
- Optimise
- Review cutting patterns
- Send cutting data to the saw

If the software is not installed read through the tour to get an overview of the program and follow the next section on 'Set up' to install the software

Select User profile

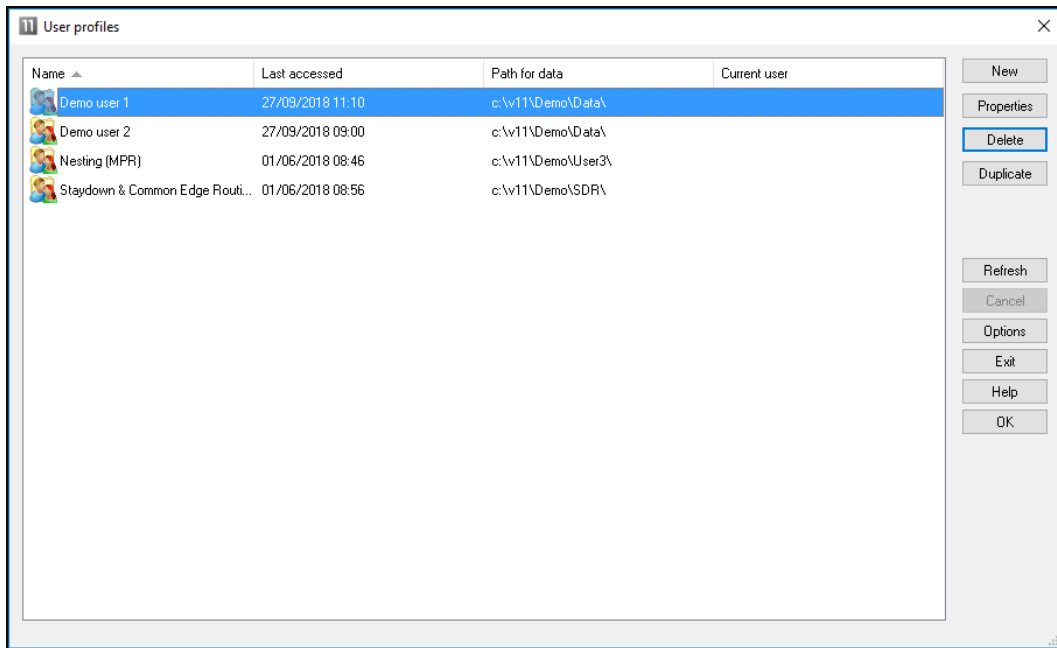


To run the program click on the icon on the desktop

The first screen is a splash screen which appears for a few moments and the program moves to the Main screen.

(If the splash screen does not appear there is a problem - see '*Problems with start-up*').

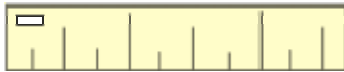
USER PROFILE. Each user has a unique profile (account) where settings and data are stored. On start up the program displays a list of user profiles.



User profiles

- Select a profile (e.g. Demo user 1)
- **OK** to confirm

On install the program includes a set of demo data with several user profiles. By default the program automatically moves to the last user profile used. The program moves to the main screen and display the data for the profile.

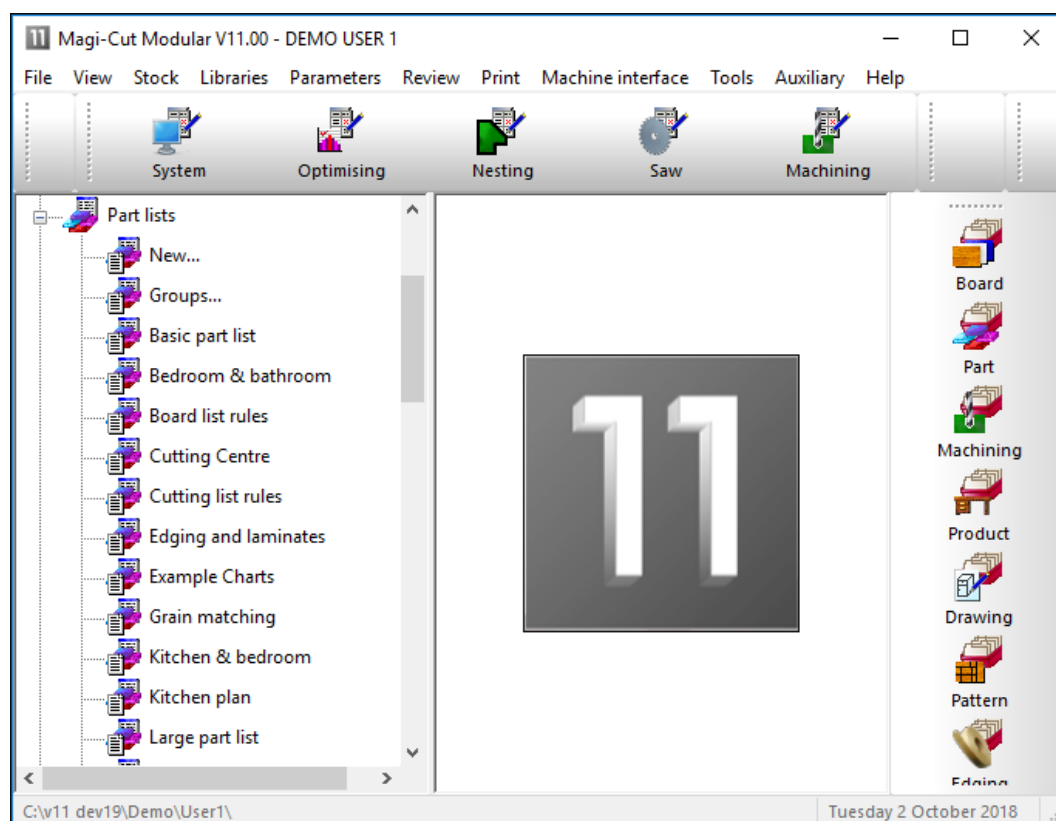


Measurement modes - The software works in either millimetres, fractional inches, or decimal inches. The operation is the same in each case except that fractional inches are displayed and entered in the fractional format (44 x 61-1/4, 96 x 48-1/2).

Note - the demonstration data installed may differ slightly from the examples shown in this guide

Main screen

This is the command centre of the system. Access all the options from here.



Main screen

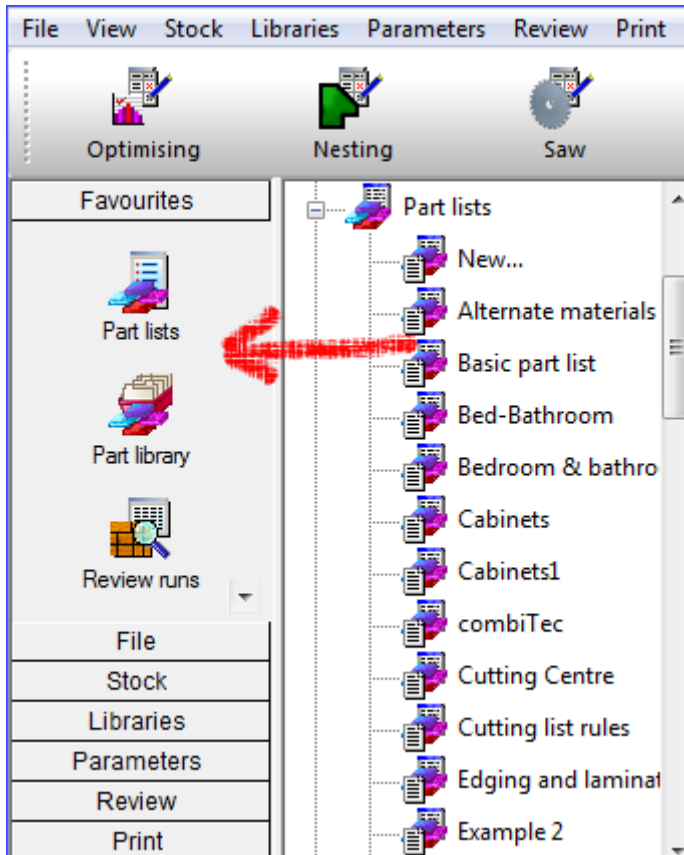
The program name is shown at the top of the screen. There are different names in some countries, for example, Cut-Rite, Magi-Cut, Schnitt-Profi(t). ...

At the left is a tree showing the various options and existing data. Click on an item in the tree to see the files in a category.

There are also traditional menus and buttons to access all the options.

(Arrange the screen to suit your way of working with the *View* menu options).

NAVIGATION BAR. At the left (or right) of the screen is a toolbar with access to all the main program options. This bar can also be set to float at the left/right of the display and is available throughout and on the desktop- giving quick access to any part of the program.



Navigation bar

If the quick navigation bar is not visible - place the mouse cursor over the docking bar.

The docking bar is the thin vertical bar at the far left (or right) of the screen).

The docking bar pops up. Right click on one of the buttons on the navigation bar for a pop up menu of options to re-position the toolbar.

Part lists

A part list is a list of all the part sizes and quantities required for cutting. This might be for a single order or for several different jobs.

(The demo data includes several examples of different sorts of part lists - these may be different from the example shown below).

Select a part list by opening the Part list branch of the file tree and double clicking on a part list.

(The program may prompt: '*Patterns exist - significant changes will delete patterns*' - this happens because in the demo data the part lists are already optimised - ignore this message as the next step is to optimise and re-create the patterns.

The part list contents are displayed.

	Description	Material	Length	Width	Quantity	Over	Under	Grain	Edge Btm	Edge Top
Global						0 %	0 %			
1.	DRESSER-TOP	MFC18-OAK	1000.0	600.0	2	0	0	Y		
2.	DRESSER-END-LE...	MFC18-OAK	600.0	1082.0	2	0	0	Y		
3.	DRESSER-END-RI...	MFC18-OAK	600.0	1082.0	2	0	0	Y		
4.	DRESSER-BACK	MFC18-OAK	964.0	1082.0	2	0	0	Y		
5.	DRESSER-PLINTH	MFC18-OAK	964.0	125.0	2	0	0	Y		
6.	DRESSER-DRAWER	MFC18-OAK	964.0	316.3	6	0	0	Y		
7.	DDC-SIDE-LEFT	MFC18-OAK	564.0	312.3	6	0	0	Y		
8.	DDC-SIDE-RIGHT	MFC18-OAK	564.0	312.3	6	0	0	Y		
9.	DDC-BACK	MFC18-OAK	928.0	312.3	6	0	0	Y		
10.	DDC-BOTTOM	HARDBOARD-4MM	964.0	564.0	6	0	0	N		
11.	W-ROBE-TOP	MFC18-EBONY	1000.0	600.0	7	0	0	Y	OAK-TA...	0
12.	W-ROBE-END-LEFT	MFC18-EBONY	578.0	1782.0	7	0	0	X		
13.	W-ROBE-END-RIG...	MFC18-EBONY	578.0	1782.0	7	0	0	X		
14.	W-ROBE-BASE	MFC18-EBONY	964.0	578.0	14	0	0	Y		
15.	W-ROBE-PLINTH	MFC18-EBONY	964.0	125.0	7	0	0	Y		
16.	W-ROBE-BACK	HARDBOARD-4MM	1000.0	1657.0	7	0	0	N		

Part list

- Review and/or enter the required part list items. The basic information is:-

Description
 Material code
 Length
 Width
 Quantity

At the right of the part list screen there are several other columns - most of these are custom columns which can be used for all the extra data for parts, for example, edging, text for a part label, a tracking number ...

MATERIAL CODE: This is important because it determines the material for that part. The program uses this to extract candidate boards from the board library and create a board list.

The board list is simply the list of available board sizes and quantities for the job.

Multiple part lists – up to 5 part lists can be open at a time. Click on the tabs at the foot of the screen to move to a part list.

The program also supports fractional inches and decimal inches.

	Description	Material	Width	Length	Quantity	Over	Under	Grain	Edge	Inf
Global						0 %	0 %		0000	
1.	BOOKBACK	BENBOARD-1/2INCH	77-51/64	31-33/64	1	0	0	Y	0000	
2.	BOOKBASE	BENBOARD-1/2INCH	11-13/16	31-33/64	1	0	0	Y	0000	
3.	BOOKPARTITION	BENBOARD-1/2INCH	12-41/64	11-5/16	6	0	0	Y	0000	
4.	BOOKSHELF	BENBOARD-1/2INCH	10-45/64	31-27/64	5	0	0	Y	0000	
5.	BOOKTOP	BENBOARD-1/2INCH	11-13/16	31-33/64	1	0	0	Y	0000	
6.	BOOKSIDE	BENBOARD-1/2INCH	77-51/64	10-45/64	2	0	0	Y	0000	
7.	LONEPART	MED-DEN-FIBRE-3/4"	15-3/4	11-3/4	1	0	0	N	0000	
8.	QUPARTBMP	CHIPBOARD-3/4"	6	7-7/8	1	0	0	N	0000	
9.	QUPARTMCH	CHIPBOARD-3/4"	10-7/8	12-3/4	1	0	0	N	0000	
10.	MPRPART	BENBOARD-1/2INCH	76-43/64	29-25/64	1	0	0	Y	0000	
11.	SUNDRYPART	#TEAK-FOIL	12-1/2	12-1/2	1	0	0	Y	0000	
12.	FIXEDMPR	BENBOARD-3/4	25	40	1	0	0	Y	0000	
13.	MPRPART	BENBOARD-1/2INCH	78-51/64	31-33/64	1	0	0	Y	0000	
14.	QUPARTBMP	CHIPBOARD-3/4"	6	7-7/8	1	0	0	N	0000	
15.	QUPARTDRG	CHIPBOARD-3/4"	10-3/4	12-1/2	1	0	0	N	0000	
16.	QUPARTMCH	CHIPBOARD-3/4"	10-7/8	12-3/4	1	0	0	N	0000	
17.	QUPARTMPR	CHIPBOARD-3/4"	12-3/8	14-3/4	1	0	0	N	0000	
18.	QUPARTDRG	CHIPBOARD-3/4"	12-3/4	15-5/8	1	0	0	N	0000	

Part list - fractional inches

Board list



Click on the toolbar symbol to view the Board list

Board list - Bedroom & bathroom										
File Edit View Optimise Help										
Title: Bedroom & bathroom										
	Board	Type	Material	Length	Width	Quantity	Cost	Grain	Description	Material
Global									Description	Picture
1.	MFC18-DAK/01		MFC18-DAK	3050.0	1220.0	428	3.300	Y	Prelaminated - O...	
2.	MFC18-DAK/02		MFC18-DAK	2440.0	1220.0	114	2.970	Y	Prelaminated - O...	
3.	HARDBOARD-4MM...		HARDBOARD-4MM	2440.0	1220.0	782	0.890	N	Hardboard 4mm	
4.	MFC18-EBONY/01		MFC18-EBONY	3050.0	1220.0	805	5.760	Y	Prelaminated - E...	
5.	MFC18-EBONY/02		MFC18-EBONY	2440.0	1220.0	523	5.210	Y	Prelaminated - E...	
6.	MFC18-TEAK/01		MFC18-TEAK	2440.0	1220.0	1020	3.110	Y	Prelaminated - T...	
7.	MFC18-TEAK/02		MFC18-TEAK	3050.0	1525.0	955	3.110	Y	Prelaminated - T...	
8.	X00135/0003	X	MFC18-TEAK	564.0	488.0	2	1.550	Y	Prelaminated - T...	
9.	X00148/0001	X	MFC18-TEAK	950.0	620.0	1	1.550	Y	Prelaminated - T...	
10.	X00125/0001	X	MFC18-TEAK	780.0	1011.0	1	1.550	Y	Prelaminated - T...	
11.	MIRROR-GLASS		MIRROR-GLASS	0.0	0.0	0	3.200	N	Mirror Glass (sun...	
12.	MFC18-BEECH/01		MFC18-BEECH	3050.0	1525.0	1702	3.210	Y	Prelaminated - B...	
13.	MFC18-BEECH/02		MFC18-BEECH	2440.0	1220.0	1628	2.960	Y	Prelaminated - B...	
14.	MEL-CHIP-18MM/01		MEL-CHIP-18MM	3050.0	1220.0	927	3.180	N	Prelaminated - W...	
15.	MEL-CHIP-18MM/02		MEL-CHIP-18MM	2440.0	1220.0	362	3.140	N	Prelaminated - W...	
16.	MFC18-BED/01		MFC18-BED	3050.0	1220.0	30	5.210	N	Prelaminated - B...	

Board list

The Board list is created by the program extracting from the Board library all board sizes (and offcuts if any) matching the material codes used in the Part list against each part.

Note the board list includes information from the Board library describing the material.

Board library

The board library stores the details and quantities of all the sheet material (a library is provided in the demo data).

The screenshot shows the 'Board library' application window. It has a menu bar (File, Edit, View, Help) and a toolbar with various icons. The main area is divided into two sections:

Materials

Material	Description	Thickness	Default grain	Book	Material	Picture	Type	Density
MED-DEN-FIBRE-25MM	Medium Density Fibreboard 25mm	25.0	N	0			MDF	0.650
MEL-CHIP-15MM	Prelaminated - White 15mm	15.0	N	0			MDF.JPG	0.500
MEL-CHIP-18MM	Prelaminated - White 18mm	18.0	N	0				0.500
MFC18-ASH	Prelaminated - Ash 18mm	18.0	Y	0			MFC	0.400
MFC18-BEECH	Prelaminated - Beech 18mm	18.0	Y	0			MFC	0.400
MFC18-BLACK	Prelaminated - Black 18mm	18.0	N	0			MFC	0.400

Boards for material: MFC18-BEECH Prelaminated - Beech 18mm Thickness:18.0 Book:0

Board code	Type	Length	Width	Informal	Stock	Res	Order	Cost	Limit	Bin	Supplier	Min Stk	ReOrd	Grain	Param
MFC18-BEECH/01		3050.0	1525.0		1702	0	215	3.210	0			120	150	Y	
MFC18-BEECH/02		2440.0	1220.0		1630	2	205	2.960	0			120	150	Y	
WKG - CABINET/001	X	3050.0	281.4		1	0	0	1.605	0			0		Y	
WKG - CABINET/002	X	840.0	450.0		1	0	0	1.605	0			0		Y	
WKG - CABINET/003	X	578.0	492.4		1	0	0	1.605	0			0		Y	

Board library

In this example there are two board sizes available for material MFC18-BEECH and also a few offcuts.

The board library can include much information for each sheet size, for example, cost, how to deal with low stock levels, storage etc.

Note - There are a wide range of materials from different suppliers so before using the program for real - an important task is to set up the board library for the materials typically available for the company. For more details see the section: *Board library*

The Board library also supports decimal and fractional inches.

The screenshot shows the 'Board library' window with a menu bar (File, Edit, View, Help) and a toolbar. The main area is divided into two sections. The top section, titled 'Materials', contains a table with columns: Material, Description, Thickness, Default gr, Book, Material parameters, Picture, Type, and Der. The bottom section, titled 'Boards for material: MED-DEN-FIBRE-1\"', contains a table with columns: Board code, Type, Width, Length, Information, Stock, Res, Order, Cost, and Limit.

Material	Description	Thickness	Default gr	Book	Material parameters	Picture	Type	Der
BENBOARD-1INCH	Ben Board 01	1	Y	5				0.
BENBOARD-3/4	Ben Board 03	0-3/4	Y	5				0.
BENPOST-2.5	Table leg material	2-1/2	X	1				0.
CHIPBOARD-3/4"	Chipboard Core 3/4"	0-3/4	N	0				0.
EBONY-LAM-1/32"	Ebony Laminate 1/32"	0-1/32	Y	10				0.
GLASS	Glass Very fragile	0-1/4	N	1				0.
HARDBOARD-1/8"	Hardboard 1/8"	0-1/8	N	8				0.
MED-DEN-FIBRE-1"	Medium Density Fibreboard 1"	1	N	0				0.
MED-DEN-FIBRE-3/4"	Medium Density Fibreboard 3/4"	0-3/4	N	0				0.
MEL-CHIP-3/4"	Melamine - Teak 3/4"	0-3/4	Y	0				0.
MEL-CHIP-5/8"	Melamine - White 5/8"	0-5/8	N	0				0.
OAK-LAM-1/32"	Oak Laminate 1/32"	0-1/32	Y	10				0.

Board code	Type	Width	Length	Information	Stock	Res	Order	Cost	Limit
MED-DEN-FIBRE-1\"/01		72-1/8	120		991	1	0	6.300	0
MED-DEN-FIBRE-1\"/02		80-3/4	100		0	25	25	6.950	9
MED-DEN-FIBRE-1\"/03		48	96		727	0	0	6.300	0

Board library - fractional inches

Optimise

Once the Part list and Board list are created the job is ready to be optimised.

At the Part list screen (or at the Board list screen):-



Select the optimise symbol

The program produces a set of cutting patterns and moves to the 'Review runs' section of the program. This shows all cutting patterns and a set of summary reports.

The first report shown is an overall summary of the job; the *Management Summary*.

The screenshot shows a software window titled 'Review runs' with a menu bar (File, Edit, View, Settings, Summaries, Stock, Help) and a toolbar with various icons. On the left is a 'Favourites' sidebar with options like 'Batch summary', 'Management summary', 'Pattern summary', 'Pattern preview', and 'Pattern'. The main area displays a 'Management summary' report for 'Bedroom & bathroom'. The report includes a table with columns for Description, Quantity, m2, m3, Weight, Percent, Rate, Cost, Statistic, and Value. Key data points include: Required parts (620, 312.61, 4.66, 83.54%), Plus/Over parts (0, 0.00, 0.00, 0.00%), Offcuts (37, 9.83, 0.17, 68.73, 2.63%), Scrap (51.75, 0.61, 13.83%), Core trim (0.00, 0.00, 0.00%), Boards (116, 374.19, 5.44, 2338.74, 100.00%), Net material used (364.36, 5.27, 97.37%, 1082.48), Cutting time (3:25Hr, 50.000, 170.64), Total parts (620, 312.61, 4.66, 1987.73, 83.54%, 4.009, 1253.12), Sundry - unit usage (14, 3.200, 44.80), and Total sundry (44.80). A secondary table on the right lists statistics like Number of patterns (44), Headcut patterns (12), Rotated patterns (1), Recut patterns (20), Number of cycles (44), Cutting length (1492.3), Throughput (M3/Hr) (1.6), Waste (%Parts) (19.70%), and Waste (%Boards) (16.46%). The bottom status bar shows the current report path: Management summary > Dashboard > Output > Patterns.

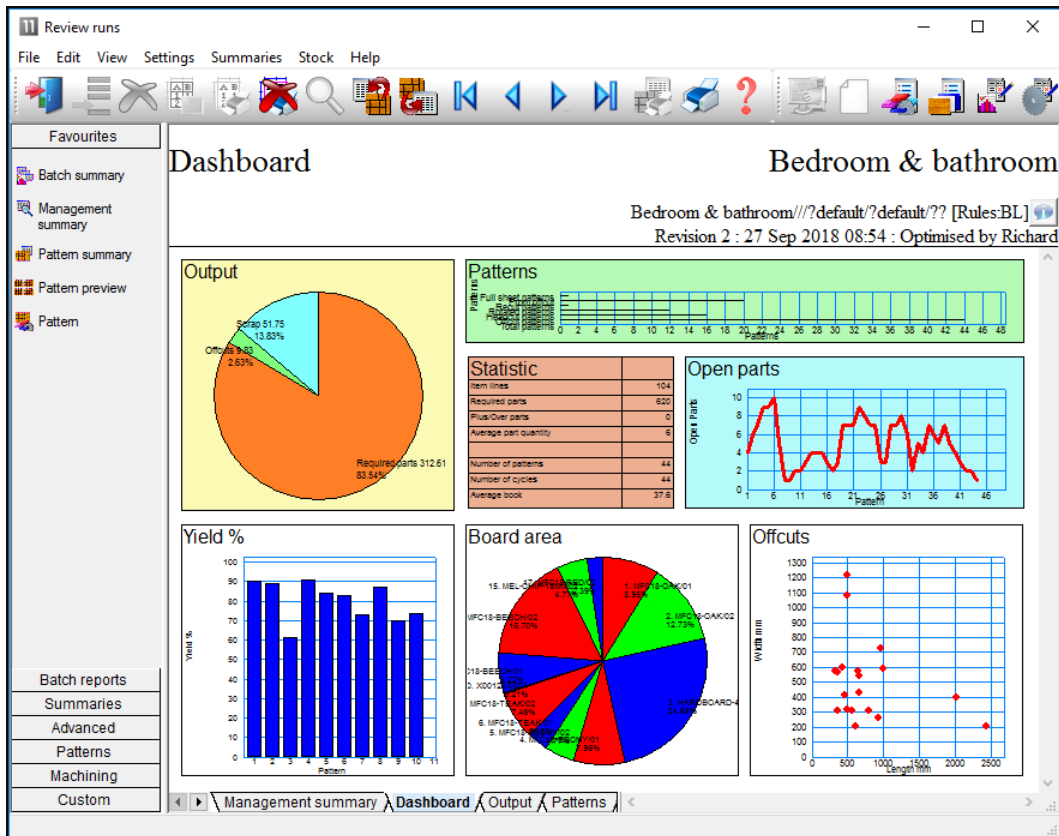
Description	Quantity	m2	m3	Weight	Percent	Rate	Cost	Statistic	Value
Required parts	620	312.61	4.66		83.54%			Number of patterns	44
Plus/Over parts	0	0.00	0.00		0.00%			Headcut patterns	12
Offcuts	37	9.83	0.17	68.73	2.63%			Rotated patterns	1
Scrap	51.75	0.61			13.83%			Recut patterns	20
Core trim		0.00	0.00		0.00%			Number of cycles	44
Boards	116	374.19	5.44	2338.74	100.00%			Cutting length	1492.3
								Throughput (M3/Hr)	1.6
								Waste (%Parts)	19.70%
								Waste (%Boards)	16.46%
Sheets used		373.40	5.43		99.79%		1081.26		
Offcuts used		0.79	0.01		0.21%	1.550	1.22		
Offcuts created		-9.83	-0.17		-2.63%	0.000	0.00		
Net material used		364.36	5.27		97.37%		1082.48		
Cutting time	3:25Hr					50.000	170.64		
Total parts	620	312.61	4.66	1987.73	83.54%	4.009	1253.12		
Sundry - unit usage	14					3.200	44.80		
Total sundry							44.80		

Management summary

This is an overall summary of the job, for example. Total costs, Overall Waste percentage, Net material used ...

Use the Navigation buttons or 'Summaries' menu option to view other reports.

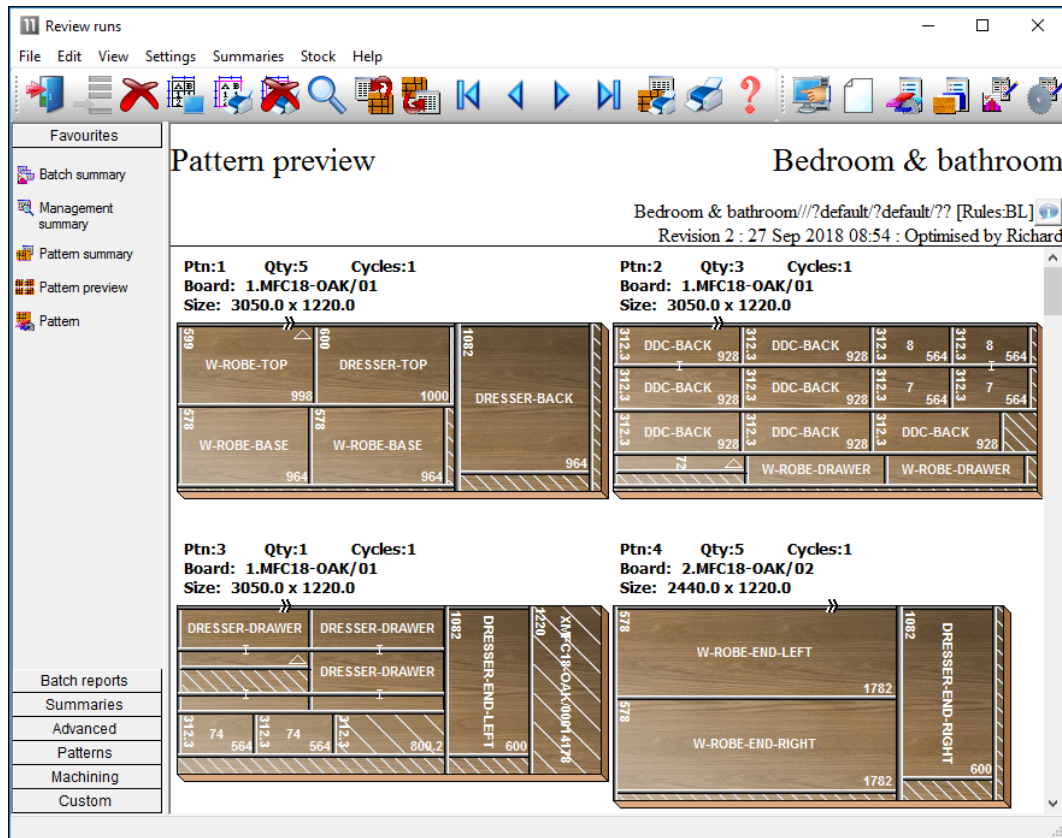
At the foot of the report are a set of tabs with more information. For example, the 'Dashboard' gives a graphical view of the data.



Dashboard

The individual cutting patterns are viewed via the 'Pattern preview' option.

 Pattern preview



Pattern preview

Use the navigation buttons or the Summaries menu to move between patterns and other summaries.



Double click on a thumbnail to view the pattern full screen.

Review runs [Minimize] [Maximize] [Close]

File Edit View Settings Summaries Stock Help

Pattern 6 of 44 **Bedroom & bathroom**

Bedroom & bathroom:///default/?default?? [Rules:BL] [Help]

Revision 2 : 27 Sep 2018 08:54 : Optimised by Richard

Board: MFC18-OAK/02 Waste: 17.06% Size: 2440.0 x 1220.0 x 18.0
 Information: Storage Area 1
 Material: MFC18-OAK Prelaminated - Oak 18mm Boards: 2

DRESSER-END-RIGHT DRESSER-END-LEFT DRESSER-TOP
 W-ROBE-DRAWER W-ROBE-DRAWER DRESSER-PLINTH

Rip saw blade thickness: 4.8 Crosscut saw blade thickness: 4.8 Book height 1 Cycles 1
 Rear rip trim (inc blade): 10.0 Rear crosscut trim (inc blade): 10.0 Retrim (inc blade): 5.0 Grain direction: ⇄

Batch reports
 Summaries
 Advanced
 Patterns
 Machining
 Custom

Pattern Parts Saw simulation

Pattern

The tabs at the foot of the report show more details, for example, a full list of the parts produced by the pattern.

The cuts, waste, offcuts and part information are shown for each pattern.

The program also supports decimal and fractional inches.

Review runs

File Edit View Settings Summaries Stock Help

Pattern 1 of 14

CHIP0.75 standard///?standard/?standard/??*

Revision 1 : 27 Sep 2018 11:35 : Recalculated by Richard

Board: 1 Waste: 48.65% Size: 48 x 96 x 0-3/4

Material: CHIP0.75 * Boards: 1

A 11-1/32 X 13-25/32				A 11-1/32 X 13-25/32				A 11-1/32 X 13-25/32				A 11-1/32 X 13-25/32				XSTANDARD0011 11-1/32 X 39-47/64							
B 14-31/32 X 17-23/32						B 14-31/32 X 17-23/32						C 11-13/16 X 15-3/4				C 11-13/16 X 15-3/4				XSTANDARD0012 14-31/32 X 27-59/64			
T T		C 11-13/16 X 15-3/4				C 11-13/16 X 15-3/4				C 11-13/16 X 15-3/4				C 11-13/16 X 15-3/4				XSTANDARD0018 11-13/16 X 22-3/64					
XSTANDARD0002 9-15/64 X 96																							

Rip saw blade thickness: 3/16 Crosscut saw blade thickness: 3/16 Book height 1 Cycles 1
Rear rip trim (inc blade): 25/64 Rear crosscut trim (inc blade): 25/64 Retrim (inc blade): 9/32

Navigation: < > \Pattern / Parts / Cutting dimensions / Saw simulat <

Pattern - fractional inches

In this example the pattern is shown in an alternative view 'Monochrome'. There are several choices of pattern view.

- Enhanced picture with bitmap or solid colour
- Flat picture with bitmap or solid colour
- Picture with colour for different part type (recut, plus part, offcut ...)
- Monochrom picture

Transfer to Saw or Machining centre

After Optimisation the patterns (cutting instructions) are transferred to the Saw or machining centre.



Saw

The program supports a wide range of saw controllers:-

- CADmatic (all types)
- Compumatic
- Topmatic
- Homag Sawtech (CHxx, NPS400, Ilenia)
- Table saws
- Online PC
- Various other controllers
- Printed patterns and cutting instructions for manual saws

Some of the Machining centre transfer options are:-

- Homag/Weeke WoodWop
- 2D DXF
- Nested DXF
- Busellato AutoLink (DXF)
- Biesse RoverCad (CID)

At the main screen select the Saw transfer or Machining Interface option.

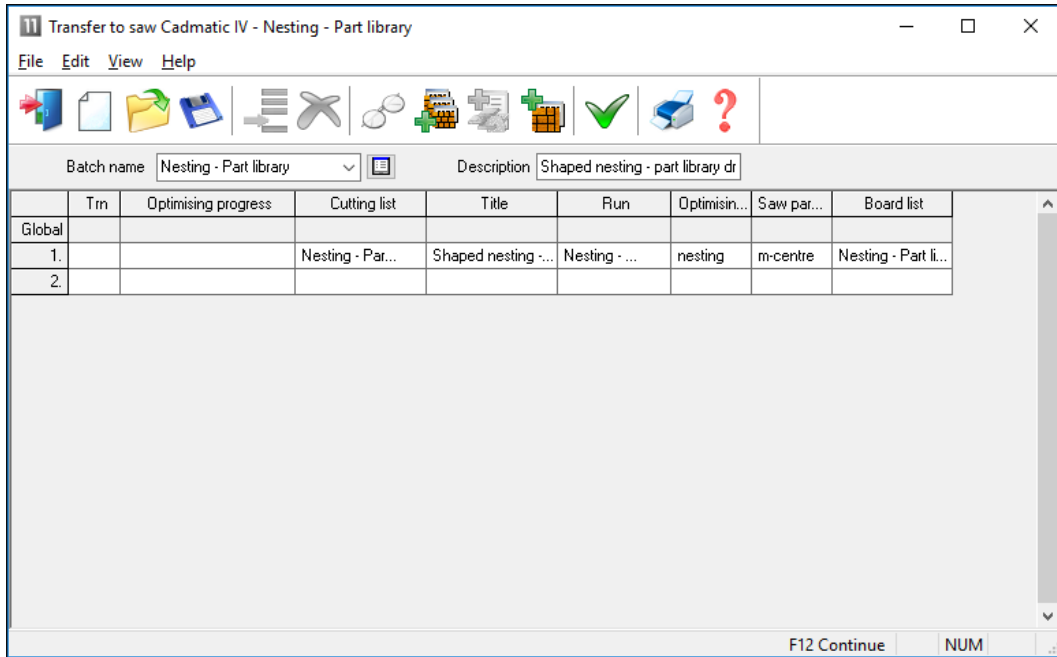


Machining interface



Saw Transfer

For Saw transfer, for example, the program prompts with the current job.

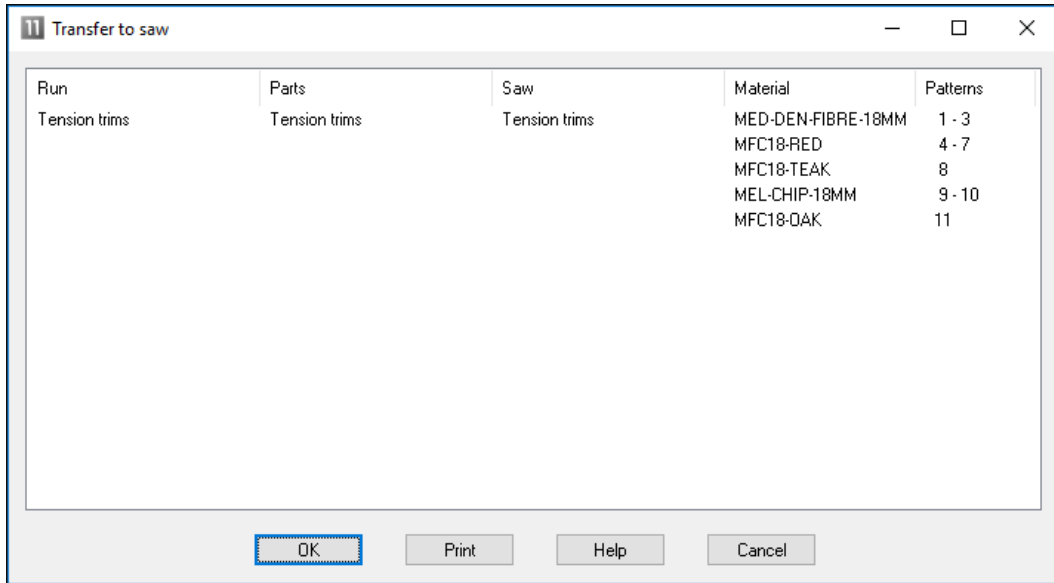


Transfer to saw batch screen



Select the 'Continue' option

The program displays the data to transfer.



Transfer to Saw

- **OK** to confirm

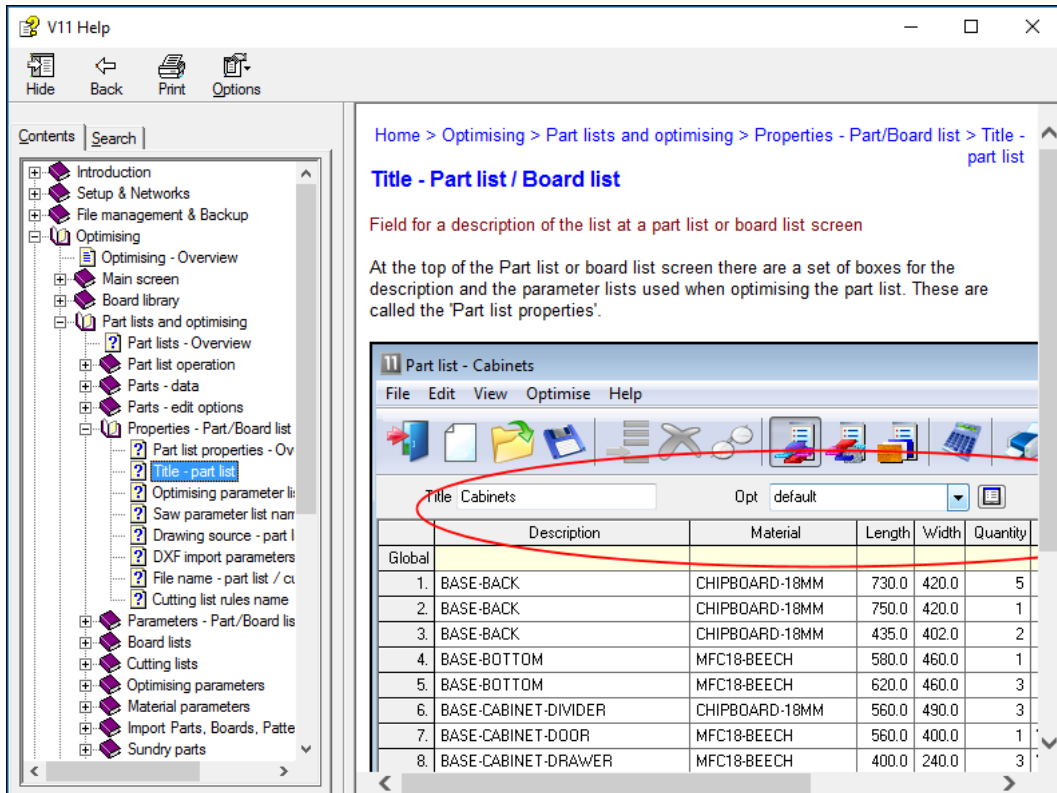
The transfer is finished.

Note - For practical use the saw transfer and machining transfer need to be set up for the company's machines. There are parameters for this and a wide range of options are available.

Typically the saw or machining centre transfer sends data to a location on the Network (Path for Saw data) and a separate program provided by the machinery manufacturer runs and sends the data to the machine. This can all be integrated into the above transfer process.

Help and support

The program is fully supported by integrated, up to date, local help (no need to rely on a web link).



Help system

There is a help menu on most dialogs and screens.

F1 is active for context sensitive help at most boxes, parameters and options.

Part list - Bedroom & bathroom

File Edit View Optimise Help

Title Bedroom & bathroom Opt default Saw default

	Description	Material	Length	Width	Quantity	Over	Under	Grain	Edge Btm
Global						0 %	0 %		
1.	DRESSER-TOP	MFC18-OAK	1000.0	600.0	2	0	0	Y	
2.	DRESSER-END-LEFT	MFC18-OAK	600.0	1082.0	2	0	0	Y	
3.	DRESSER-END-RIGHT	MFC18-OAK	600.0	1082.0	2	0	0	Y	
4.	DRESSER-BACK	MFC18-OAK	964.0	1082.0	2	0	0	Y	
5.	DRESSER-PLINTH	MFC18-OAK	964.0	125.0	2	0	0	Y	
6.	DRESSER-DRAWER	MFC18-OAK	964.0	316.3	6	0	0	Y	
7.	DDC-SIDE-LEFT	MFC18-OAK	564.0	312.3	6	0	0	Y	
8.	DDC-SIDE-RIGHT	MFC18-OAK	564.0	312.3	6	0	0	Y	
9.	DDC-BACK	MFC18-OAK	928.0	312.3	6	0	0	Y	
10.	DDC-BOTTOM	HARDBOARD-4MM	964.0	564.0	6	0	0	N	
11.	W-ROBE-TOP	MFC18-EBONY	1000.0	600.0	7	0	0	Y	OAK-TAPE-22MM

Bedroom & bathroom NUM

Help in context

Full help is available for most topics including 'Overview' and 'How to' topics and there is advice on each parameters and setting.

Optimising parameters - default Standard Optimiser

Trims Rules Offcuts Offcuts 2 Help view >>

Set the parameters for trims

Optimiser type

Saw blade thickness

Rip and crosscut

Minimum rip trim (inc saw blade thickness)

Front 10.0

Minimum crosscut trim (inc saw blade thickness)

Front 10.0

Override rip and crosscut trims

Override rip trim

Override crosscut trim

Retrim after head cut (inc saw blade thickness)

V11 Help

Hide Back Print Options

Contents Search

- Introduction
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- Part library
- Machining Interface
- Material parameters
- Stock control
- Destacking and Palletising
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- Stand alone operation
- Guides and updates
- Errors
- V11.04 changed topics

Home > Saw Optimising > Part lists and optimising > Optimising parameters > Trims > Saw blade thickness

Saw blade thickness

Optimising parameter to set width of material removed by the saw blade

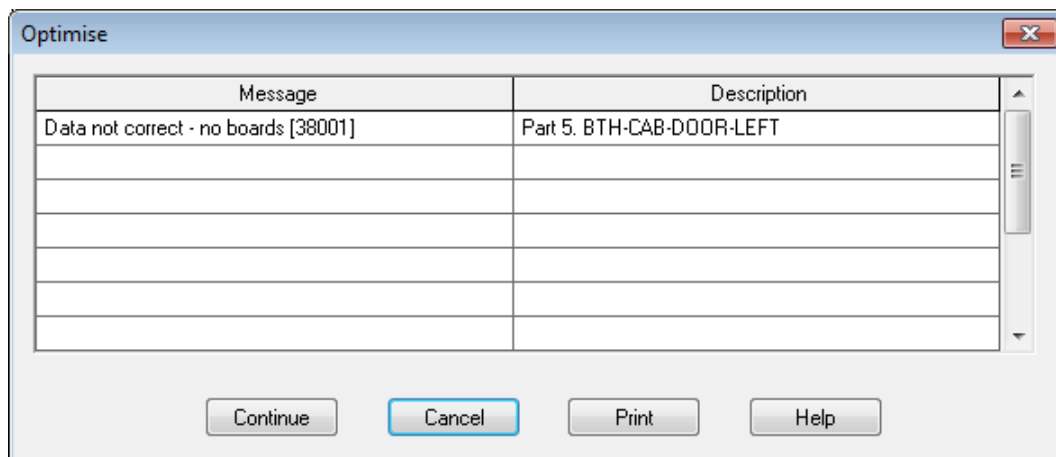
This is the material lost due to the saw blade when cutting. Use the value recommended by the saw manufacturer. Typical values for woodworking are: 4.8mm, 3/16in ... For tight cutting or for materials such as glass or metal the thickness is not significant and can be set to zero if necessary.

- Enter a value for the saw blade thickness

For Module 'PO' with saw models with multiple saw blades the first value is for the 'Rip saw blade thickness' and the second value is for the 'Crosscut saw blade thickness'. The pattern display and data for transfer to the saw automatically take account the multiple saw blade thicknesses. (The rip and crosscut values are often the same).

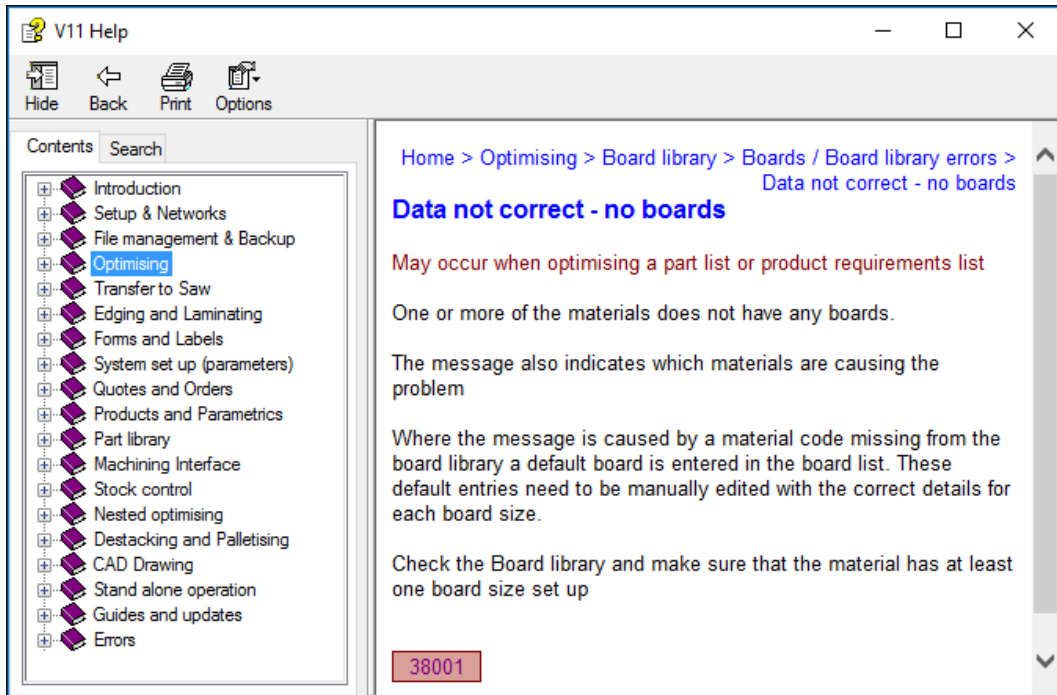
Help for parameters

Where an error is reported there is usually a link to more information in the help.



Error message

Click on the help button for more details:-



Help topic for an error

The number shown is the error number - this can be useful in identifying the exact problem.

Web site

There are links at the main screen to the UK web site for downloads, updates, documentation, latest news ...

There is also a page on the web site for reporting issues.

2. Set up (install)

Set up (single user)

Always install a new version to a NEW location.

Run the old and new version in parallel for a period to get used to the new version before transferring a lot of data to the new version. Also the data between versions is not fully compatible so existing data must be transferred from the old version to the new via the 'Copy / Convert' option.

The program is used in two main configurations:-

- For a single user on a local computer
- For several users running over a network

For the program to run a security key must be plugged into one of the USB ports on a computer or server.



security key

To install the program on a local computer run the set up program: **setup.exe**. Follow the instructions on screen carefully.

Network setup

For a Network decide first where the program runs and where user data is stored; there are many different ways to set up the Network operation. A typical set up is for the program and library data to be at the server and for each user to have a profile on a local computer.

The security key must be plugged into one of the USB ports on a computer on the Network (often the server). In addition the Network key software (called the Licence Manager) has to be running on the computer where the security key is located.

(See section below for details).

Program does not run

If the program does not run there are several possible causes:-

- Security key is missing or not correctly inserted or cannot be found by the program
- Extra configuration file required (for some Networks)
- Language modules are missing
- Some system components are missing
- Minimum specification is not sufficient

Security key missing

The program cannot run without the security key

- Check that the security key is in place and firmly inserted and that it is in the correct port

For a Network key:--

- Make sure the Network is up
- Make sure the Licence Manager is running
- Has the network run out of licences (too many users)

Extra configuration file needed for Network installations

For a small number of Network installations the standard set up is not suitable and the program may not run because the Network key or the licence manager cannot be found.

In these cases a special setup file (NetHasp.ini) has to be used. This is available with the Distribution but needs to be configured for each case - this is usually quite simple to do but requires some experience of different Network layouts.

Contact the supplier for details. See the section below '*Customise Networks*'.

Some system components are missing

On a Network install make sure that a 'Client' install has been done on any local computer that runs the program from the Server. This is needed to install some important components on the local computer.

Language modules are missing

If messages in English appear like the following:-

Error reading language file: 01 Use 00?

Error reading language file: 00

This means that a language module is missing or is not available. The message reports the number of the language module the program is trying to find and suggests an alternative if there is one.

Language modules are files with the extension LNG, for example, 00.LNG, 01.LNG and are usually located in the Program directory (where the program is installed).

The language is set via *System parameters*. This offers the list of available languages, for example, English (UK), English (USA) etc. Each item in the list is provided by one of the LNG files. If the above message(s) occur either there are no language files at all or the file for the choice last set in the program is missing or has been renamed.

Check with the supplier.

Minimum specification is not sufficient


V11 does not require a large amount of resources to run but a computer must meet the minimum specification. This is likely to be a problem with a local computer (or single user computer) rather than a server. To check this:-



Insert the Distribution CD

or



 Move to the directory where the extracted Download is located

(If the CD automatically starts the Setup program - abandon this - right click on the CD icon and select *Explore*)

Use *Windows Explorer* to locate the root directory of the CD-ROM or the root directory of the Download.

- Double click on the program CHECK.EXE

This program runs and displays a screen of information.

From the menu:-

- Select: **Check - Minimum requirements**

A dialog is displayed showing the minimum requirements at the left and the current system values at the right.

Requirement	Minimum	System	Status
Windows	7 SP1	10.0 x64	ok
Processor	1500 MHz	2893 MHz	ok
CPU Benchmark	< 0.25s	0.032s	ok
Security key	Modular	Master	ok
Total physical RAM	1.0 Gb	3.95 Gb	ok
Available physical RAM	0.2 Gb	0.96 Gb	ok
Disk	1.0 Gb	658.4 Gb	ok

Requirement - 3D Mode	Minimum	System	Status
Processor	1995 MHz	2893 MHz	ok
Total physical RAM	4.0 Gb	3.95 Gb	X
OpenGL	V3.2	V4.5	ok

Minimum requirements

OK - indicates the item matches the minimum requirements

Transferring data from a previous version

Once the new version is running Ok some or all of the data from the previous versions may need to be transferred from the old version to the new version.

Always use this option to move data between versions (e.g. V8.03 to V8.10 or V7.18.3 to V8.10, V9.07 to V10.0, V10 to V11)

To move data from an older version to a later one, e.g. V10.04.3 to V11.0, the user data and the common data must be converted for the new version and copied to a new location. Identify the user directory to convert and the new location.

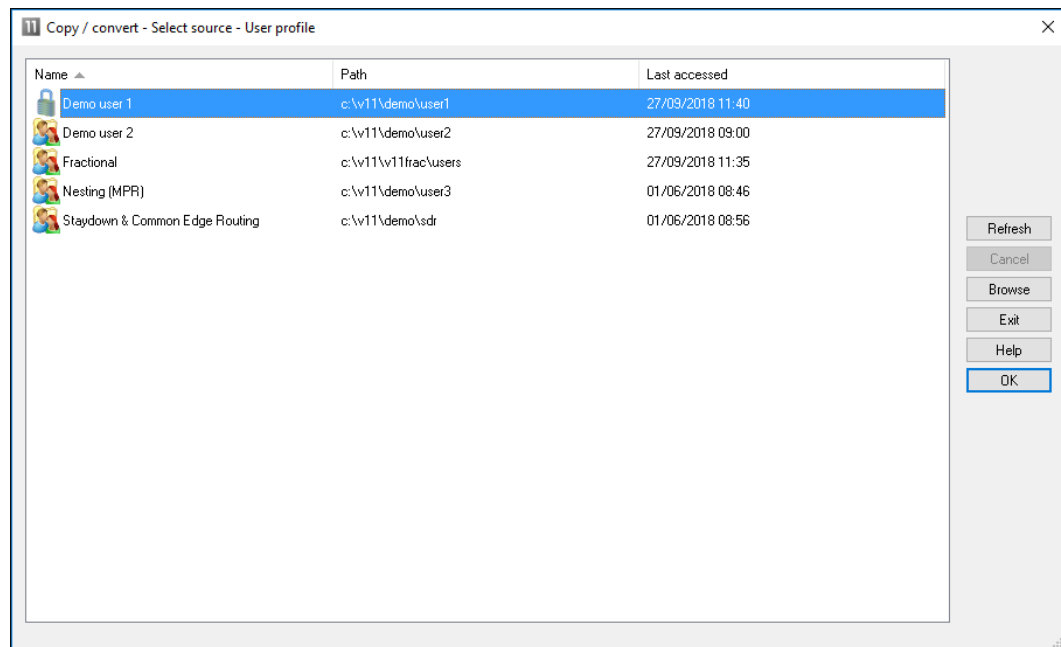
For example, the old data may be located in **c:\V10\DataUser 1** and the new data needs to be in **c:\V11\DataUser 1**.

(Where 'User 1' is the directory for the User profile).

At the main screen of the NEW version:-

- Select: **Tools - Copy / Convert user profile**

The program shows a list of user profiles. Select the profile to convert. Typically the profiles shown are the current profiles for the latest version and the profiles to convert are located elsewhere. Use the **Browse** option to select the user profile to convert.



Copy / Convert

- Select the profile to convert
- OK** - confirm copy/convert user profile

The program moves to the screen to select the location for the new (converted) data.

The paths/folders involved are shown on the screen.

Path	From	Copy / Convert	To
User profile	C:\w11\Demo\User2\	<input checked="" type="checkbox"/>	C:\w11\User2\
Path for data	c:\w11\Demo\Data\	<input checked="" type="checkbox"/>	C:\w11\Data\
Path for part lists		<input type="checkbox"/>	
Path for library data	c:\w11\Demo\Libs\	<input checked="" type="checkbox"/>	C:\w11\Libs\
Path for stock libraries		<input type="checkbox"/>	
Path for customer data	c:\w11\Demo\Libs\	<input checked="" type="checkbox"/>	C:\w11\Libs\
Path for pictures		<input type="checkbox"/>	
Path for forms / labels		<input type="checkbox"/>	
Path for shared control files		<input type="checkbox"/>	
Path for import data	c:\w11\Demo\Import\	<input type="checkbox"/>	
Path for export data	c:\w11\Demo\Export\	<input type="checkbox"/>	
Path for accounts	c:\w11\Demo\Libs\	<input type="checkbox"/>	
Path for import parameters		<input type="checkbox"/>	


Status

OK Help Cancel

Copy / Convert

The directories shown are the full set of directories available. Some may not be in use and in some cases it is not necessary to convert all the data; for example, the library data may already be converted.

- Use the check boxes to select the directories to convert
- Enter the directory to convert to in the 'To' column.

 Use the list button browse and select a directory (in the 'To' column)



Use the mouse to adjust the screen size and column width

- If any of the paths are sub-directories of the user profile these are named automatically.
For example:-

Source user directory c:\v11\
Source path for data c:\v11\data
Source path for library data c:\v11\libs

If the destination user profile is set to c:\v11\ the following paths are set:-

Destination path for data c:\v11\data
Destination path for library data c:\v11\libs

If a source directory has already been converted to the current version the directory is not converted again and the data is only copied.

- Select OK to convert

At the end of the conversion the program prompts:-



Select user profile now

Yes - move to new user profile

No - stay in current user profile

Make a back up of existing data

The program includes a 'Back up' option to take a copy of a User profile. It is best to take a copy when experimenting with data or before moving data, for example, to a new version.

(On a Network version it is best to NOT rely on manual back up but to also make sure that all the program and data directories are included in the standard Network back up processes).

This copies the user profile information and all the user data (batches, runs ...) linked to that profile; this includes any library data linked to the user profile.

- Move to the profile to back up

At the main screen:-

- Select: **File - Back up - current user**

Back-up

Path for back-up: c:\v11\Demo\Backup\

Filename: Demo user 1 2018-09-27 1208 v11backup

Include path for import data:

Include path for MPR(x) files:

Status

OK Help Cancel

Copy / Convert

- Check the path for back up (edit if required)

(The default is set by the System parameter: *Path for Back up*)



Click on the list button to browse the paths and folders

- Check the file name (edit if required)
- **OK** to confirm

The data is copied to a single file (BKP). This is a zipped file containing all the files in a compressed form. When back up is complete program prompts with a message showing number of files and overall size.

Data

Data can often be split over several different directories. For example:-

```
C:\OPT\USER1
N:\OPTIMISING\LIBRARIES
C:\OPT\USER1\CUSTOMER
```

The program uses the System parameters for the User profile to locate the data to Back up including Library data. Back up covers the following Paths:-

```
User profile
Path for Part lists
Path for Library data
Path for Stock libraries
Path for Customer data
```

The name of the BKP file is based on the date and time and is stored in the: Path for Backup. e.g. 2006-03-29 1118 V11BACKUP.BKP. All files from these directories are backed up except for file extensions. ARX, DLL, EXE, HLP, LNG, ISU.

Upgrading a security key

When purchasing extra modules or extra users the security key usually has to be upgraded. This is typically done via an Upgrade file sent via a download or via a disk.

- Copy the upgrade file to a folder on the computer


The upgrade is activated via a program called CHECK.EXE which is part of V11.0



Insert the Distribution CD

or



 Move to the directory where the extracted Download is located

(If the CD automatically starts the Setup program - abandon this - then right click on the CD icon and select *Explore*). Use *Windows Explorer* to locate the root directory of the CD or the root directory of the Download.

- Double click on the program: CHECK.EXE

[*Upgrade key only* - If the new version is already installed and the upgrade is to add modules - use the installed version of the software for the upgrade. At the main screen: Select: *Tools - System Check*]

The System check information screen is displayed. From the menu:-

- Select: **Check - Upgrade key**

or

Select the [**Upgrade**] option

The program displays a dialog to select the path for the Upgrade file.

- Select **OK** to begin the upgrade

The program proceeds to upgrade the key and usually reports:-

Key upgraded successfully

If the upgrade fails the program reports:- '*Upgrade failure*'. Report the failure and any diagnostic number(s) to the supplier

Remove or uninstall the optimising program

It is sometimes necessary to uninstall the program (for example if there was a mistake in the install process). To do this use the Windows options on the control panel.

Follow the Uninstall instructions carefully.

Note - the System files installed at a Workstation on a Network installation do not need to be removed. They are a standard Microsoft update to the Windows operating system. Any shortcuts on the Desktop etc. should be removed manually (*Right click on shortcut - Remove*)

Path for shared control files

With more than one user (either users on a network or users with different profiles on the same computer) it is often useful to co-ordinate processes where a sequential number is used. For example when naming optimised runs, orders, offcuts, tracking parts etc.

This is set by the System parameter: *Path for shared data*

- Enter the full path where the shared control files are stored (for example: n:\server\v11\SharedData). Make sure all users have read/write access to this path.

Parameter options that may use shared control files are:-

Last sequential run number	(system parameters - Rules 1)
Last quote estimate number	(system parameters - Rules 1)
Last saw group number	(system parameters - Rules 1)
Last offcut number	(system parameters - Rules 2)
Last part item tracking number	(system parameters - Rules 2)
Last drawing number	(machining centre parameters - Generation)

If this parameter is set the shared parameters are locked (greyed out) on the parameter pages and the numbering is controlled by the program.

Network key and Network key software - Install


The most common option is to place the Network key and the Network key software on a Network Server. Before installing the Licence manager make sure the existing licence manager (if any) is NOT running



Insert the CD

If the V11 install process starts running - cancel this - look at the CD contents by Right clicking on the CD icon and choosing: 'Explore'. The Network key software is in the directory..\NETWORKS\NETKEY



 - if using a Download version - the set of directories is the same as the CD

- Create a directory to contain the Network key software

Use Windows Explorer to set up a directory on the computer or server. This can be any directory name, for example, N:\NETKEY. If Network key software directories already exist they can be overwritten; this makes sure the Network software is up to date.

- Copy the Network software from CD to computer or server

To do this copy the contents of ..\NETWORKS\NETKEY to the directory set up on the computer or server.

If using a Download version from a self-extracting file - double click on the EXE to extract the files to a temporary location on the computer or server; the files are extracted to a sub-directory. Follow the above steps to copy the Network key software to a separate location on the computer or server.

Set up the Network key Licence Manager on the Computer or Server

The Licence Manager is set up with the program LMSETUP.EXE. To install the Licence Manager:-

- Move to the directory ..\NETWORKS\NETKEY
- Double click on LMSETUP.EXE to run it
- Follow the on-screen instructions for the LMSETUP install program

If the Licence manager has not been used before it is best to install it as an Application and put a link to it in the Start-up folder - this allows the Licence Manager to be easily stopped and started and ensures that it starts automatically. The LMSETUP program prompts for these options and sets up the PC or server. (These choices can be changed later if necessary by running LMSETUP again).

- When installing the Licence Manager for Windows 7 onwards the Licence Manager setup program (lmsetup) must be run under a compatibility mode (Vista Service pack 2).

Install the Network key device driver

- From the Start button on the Windows Taskbar select the Run option
- Run the program HaspUserSetup with the setting -i. e.g.
N:\NETKEY\HaspUserSetup.exe -i

If updating an existing system make sure that any Licence manager services that are running are stopped before installing HaspUserSetup.

It may be necessary to re-start the computer for the settings to take effect

Licence Manager Install - Notes

- Installing the Licence Manager as a service is advisable if the computer hosting the_key is not accessible (for example, a server located in a different office); in this case the Licence Manager runs as soon as the computer starts.
- During installation the LMSETUP program may modify firewall rules and installs an additional device driver
- The Licence Manager cannot be installed without accepting the Licence Manager licence Agreement
- The network key licence manager will only run as a service under Small Business Server 2011. When installing the licence manager (lmsetup.exe), ensure that this option is selected.

Set up for Optimising program (Networks)

Always install a new version to a new directory - data is not directly compatible between versions. It is best to run both the previous and the new version in parallel for a short changeover period.



Insert the CD (at the Server or at a Workstation)

Note - if the setup program does not run automatically - navigate to the root directory of the CD and double click on the program: setup.exe

A series of dialog screens moves through the setup procedure. Follow the instructions carefully.

At the dialog: *Choose Destination Location*

- Enter the path on the Server to install the software to.

At the dialog: *Select Components* a list of items to install is displayed

Program files
System files
TEC Cabinet Library
Metric parameter templates
Metric Demo data

- Uncheck *System files* and leave *Program files* checked

The other components are optional but it is often useful to have the demonstration data at the Server.

Note - installation on the Server does not create a Windows program folder for the Windows Start menu as the Optimising program does not run from the Server console .

- Complete the install process by following the instructions on-screen

Install the 'Client' part of the Optimising program at each Workstation

It is also necessary to set up each Workstation running the Optimising program. Make sure the workstation can access the server.



Insert the CD (at the Workstation)

Note - if the setup program does not run automatically - navigate to the root directory of the CD and double click on the program: setup.exe

A series of dialog screens take you through the setup procedure. Follow the instructions carefully. At the dialog: *Choose Destination Location*

- Enter the path on the Server which the Optimising program was installed to.

Note - the setup program needs this information so that it can create shortcuts and other client information to link to the Server.

At the dialog: *Select Components* a list of items to install is displayed

Program files
 System files
 TEC Cabinet Library
 Metric parameter templates
 Metric Demo data

- Uncheck *Program files* and leave *System files* checked.

Note - The demonstration and other data is usually not needed as this is installed at the Server

A Windows program folder is created for the Workstation - this contains shortcuts to the Optimising Program and other utilities.

- Complete the install process by following the instructions on-screen

Set up for Windows Terminal Server

The set up for the security key is the same as for any other Network set up (see above) but the optimising program is installed differently.

Install the Optimising program (WTS)



Insert the CD (at the Server)

Note - if the setup program automatically starts to run this causes an error with Windows Terminal Server. Cancel the error dialog and cancel the setup.

- Navigate to the root directory on the CD / downloaded distribution
- Double click on the program wtssetup.exe

A series of dialog screens take you through the setup procedure. Follow the instructions with care.

At the dialog: *Choose Destination Location*

- Enter the path on the Server to install the software to.

At the dialog: *Select Components* a list of items to install is displayed

Program files
System files
TEC Cabinet Library
Metric parameter templates
Metric Demo data

- Make sure ALL the components are checked
- Complete the install process by following the instructions on-screen

Install the 'Client' part of the Optimising program at each Terminal

At each Terminal running the optimising program:-

- Login to the WTS server with a unique user name.

Note: the same user name will be used to run V11 in the future

- Insert the CD-ROM (at the Server)

Note - if the setup program automatically starts to run this causes an error with Windows Terminal Server. Cancel the error dialog and cancel the setup.

- Navigate to the root directory on the CD / downloaded distribution
- Double click on the program wtssetup.exe

A series of dialog screens take you through the setup procedure. Follow the instructions with care.

At the dialog: *Choose Destination Location*

- Enter the path on the Server which the Optimising program was installed to.

Note - the setup program needs this information so that it can create shortcuts to this directory for the user profile for this terminal.

At the dialog: *Select Components* a list of items to install is displayed

Program files
System files
TEC Cabinet Library
Metric parameter templates
Metric Demo data

- Check *System files*
- Make sure all the other items are unchecked - they are already installed at the server.

A Program folder for the Windows Start menu is created for the Workstation. This folder contains shortcuts to the Optimising Program and other utilities.

- Complete the install process by following the instructions on-screen

Choosing where Optimising data is stored (networks)

For a Network version there are many different ways of organising the program and data; this depends on each site - some general ideas are given below.

All data at Network Server (Server N:, Workstations C:)

One option is to store the Optimising program and data (Libraries and User profiles) on a Network Server. This layout is flexible and allows users to easily share library and other data and makes it easy to update the Optimising program. It also ensures that all important data can be backed up by the usual Network back-up facilities.

Network server

N:\V11\DATA\LIBS - libraries
N:\V11 - program directory
N:\V11\NETKEY - key software
Network Security key

N:\V11\DATA\USER1 - user profile 1
Path for data N:\V11\DATA\USER1
Path for library data N:\V11\DATA\LIBS

N:\V11\DATA\USER2 - user profile 2
Path for data N:\V11\DATA\USER2
Path for library data N:\V11\DATA\LIBS

Workstation 1

Desktop shortcut to N:\V11\V11.EXE

Workstation 2
 Desktop shortcut to N:\V11\V11.EXE

See the 'System parameters' for each user to set up the paths for each user.

User data on local computers (Server N:, Computers C:)

In this layout each user maintains a user profile on their own Computer/Workstation.
 Libraries are shared on the Network Server

Network server
 N:\V11\DATA\LIBS - libraries
 N:\V11 - program directory
 N:\V11\NETKEY - key software
 Network Security key

Workstation 1
 Desktop shortcut to N:\V11\V11.EXE
 C:\V11\DATA\ME - user profile 1
 Path for data C:\V11\DATA\ME
 Path for library data N:\V11\DATA\LIBS

Workstation 2
 Desktop shortcut to N:\V11\V11.EXE
 C:\V11\DATA\ME - user profile
 Path for data C:\V11\DATA\ME
 Path for library data N:\V11\DATA\LIBS

Program and Data on Workstations. Library data and Network key on server (Server N:, Computers C:)

In this layout the full Optimising program is installed at each Computer/Workstation and only library data is shared.

Network server
 N:\V11\DATA\LIBS - libraries
 N:\V11\NETKEY - key software
 Network Security key

Workstation 1
 Desktop shortcut to C:\V11\V11.EXE
 C:\V11 - program directory

```
C:\V11\DATA\ME - user profile
Path for Data C:\V11\DATA\ME
Path for Library data N:\V11\DATA\LIBS
```

Workstation 2

```
Desktop shortcut to C:\V11\V11.EXE
C:\V11 - program directory
C:\V11\DATA\ME - user profile
Path for Data C:\V11\DATA\ME
Path for Library data N:\V11\DATA\LIBS
```

Customise a Network installation

Most Network setups work Ok with the standard install of the Optimising program and Network key software (Network licence manager). However for some Network setups some fine tuning is necessary.

Whenever the Optimising program is started and randomly whilst it is running the program checks for the security key and that a valid licence is available. To do this the program must look at the computer where the network key is located and the Licence manger software is running.

Some Network setups can cause this search to be slow or prevent it from working reliably if the default Network key setup is used.

These problems are fixed by fine tuning how the Optimising program searches for the security key and how the Licence manager is running on the Network. Two files are used for this.

NetHasp.ini - by default this is NOT installed as it is usually not required. A copy of this file is located on the Optimising program CD or Distribution in the directory:

..\Networks\Other\. To use it take a copy and place it in the Program directory for the Optimising program (where the optimising program is installed).

Nhsrv.ini - this is created automatically by the LMSETUP program when the Network key software is installed and is located on the server or PC where the licence manager is running. Typically in the directory: ..\Program Files\Aladdin\HASP LM

These files control each end of the link between the Optimising program and the Licence manager.

*Optimising program --- NetHasp.ini ---- Nhsrv.ini --- Licence
manager*

It is best to use NetHasp.ini to try and fix any problems - but in some cases both files need adjusting. The files are ASCII/Unicode files that can be edited by a text editor such as 'NotePad' - always take a backup copy of each file before making any changes.

3. Professional and Standard Optimisers (PO & SO)

Optimising is the heart of the system. There are different optimising modules to choose from depending on the type and amount of cutting undertaken.

The **Professional optimiser** is aimed at Larger scale production and with full cost control. This is the most extensive optimising module. It gives full control over costs, cutting constraints and all cutting pattern features including the special requirements of larger scale production. It is fully integrated with the PQ module (where this is used) and includes an interface to a large number of proprietary saws.

The **Standard Optimiser** is designed for cutting batches of jobs on a single axis beam saw. It has the flexibility to deal with a wide range of part lists and part quantities and includes many extra features for dealing with offcuts, complicated cutting patterns and allows the part list to be fully customised via extra custom fields.

The overall process is:-

- *Enter or Import part sizes*
- *Optimise*
- *Send cutting data to saw*

Part sizes

The starting point of optimisation is a list of part sizes. This can be produced in a variety of ways:-

- Enter sizes in the 'Part list' grid
- Calculate part sizes from product requirements (PQ module)
- Import part sizes from external files or systems

The result is a list of Part sizes and requirements.

	Description	Material	Length	Width	Quan...	Over	Un...	Gr...	Edge Btm	Edge Top	Edge Left	Edge Right	Inf
Global						%	%						
1.	F-UNIT-DOOR	495.0	750.0	40.0	0	0	0	N	WHIT...	WHIT...	WHIT...	WHITE...	
2.	F-WALL-UNIT...	474.0	740.0	40.0	0	0	0	N					
3.	F-WALL-UNIT...	464.0	285.0	40.0	0	0	0	N	WHIT...	WHIT...			
4.	F-WALL-UNIT...	464.0	195.0	40.0	0	0	0	N	WHIT...	WHIT...			
5.	F-WALL-UNIT...	285.0	750.0	80.0	0	0	0	N	WHIT...	WHIT...	WHIT...		
6.	F-UNIT-BACK	474.0	710.0	20.0	0	0	0	N					
7.	F-UNIT-BASE	474.0	585.0	20.0	0	0	0	N	WHIT...	WHIT...			
8.	F-UNIT-END-L...	585.0	870.0	20.0	0	0	0	N					
9.	F-UNIT-END-RI...	585.0	870.0	20.0	0	0	0	N					
10.	F-UNIT-PLINTH	500.0	150.0	20.0	0	0	0	N					
11.	F-UNIT-RAIL	474.0	75.0	40.0	0	0	0	N					
12.													

Part list

The part list editor can be used to add items or change sizes and quantities as required.

The part list includes many options for adjusting sizes, calculating edging, and if necessary, dividing lists if they are too large to send to a saw in one go.

The part list can be customised with pre-set and user defined fields - these are often important for volume production in tracking parts, dividing lists, and for getting the correct data on to a label ...

Note more than one list can be open at a time. This is handy for data between lists or for comparing lists. Click on the tabs at the foot of the screen to move between lists.



Optimising parameters are used to describe the type of cutting (trims, re-cuts, headcuts ...). See the '*Parameters*' section for details. Typical parameters are:-

Saw blade thickness

Front Trims

Rear trims

...

The Front trim parameters, for example, allows the specification of the amount of material including saw blade thickness allowed at the front of the board for rips and cross cuts.



Front trim



Saw parameters are used to describe each saw; overall cutting length, position of clamps, size of waste flap ... Typical parameters are:-

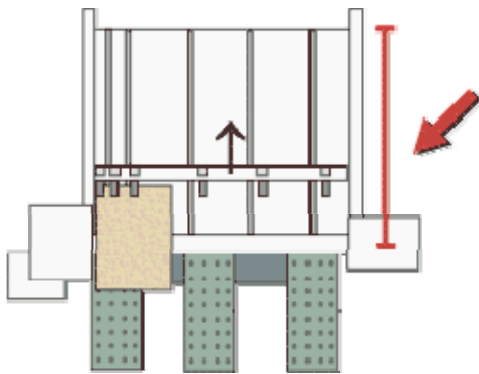
Saw model

Cutting height

Overall cutting length

...

For example, the Overall drawback for a single saw determines how a board is divided and the headcuts that are taken.



Saw bed

Different parameters lists can be set up and used to produce the correct cutting requirements for any list or saw combination. Typically users set up a handful of parameters lists with commonly used settings and add extra lists for one-off or special jobs.

In the above example the optimising parameter list and saw parameter list are the lists named 'Default' from the Demo data.

The program also supports fractional and decimal inches.

	Description	Material	Width	Length	Quantity	Over	Under	Grain	Edge	Inf
Global						0 %	0 %		0000	
1.	BOOKBACK	BENBOARD-1/2INCH	77-51/64	31-33/64	1	0	0	Y	0000	
2.	BOOKBASE	BENBOARD-1/2INCH	11-13/16	31-33/64	1	0	0	Y	0000	
3.	BOOKPARTITION	BENBOARD-1/2INCH	12-41/64	11-5/16	6	0	0	Y	0000	
4.	BOOKSHELF	BENBOARD-1/2INCH	10-45/64	31-27/64	5	0	0	Y	0000	
5.	BOOKTOP	BENBOARD-1/2INCH	11-13/16	31-33/64	1	0	0	Y	0000	
6.	BOOKSIDE	BENBOARD-1/2INCH	77-51/64	10-45/64	2	0	0	Y	0000	
7.	LONEPART	MED-DEN-FIBRE-3/4"	15-3/4	11-3/4	1	0	0	N	0000	
8.	QUPARTBMP	CHIPBOARD-3/4"	6	7-7/8	1	0	0	N	0000	
9.	QUPARTMCH	CHIPBOARD-3/4"	10-7/8	12-3/4	1	0	0	N	0000	
10.	MPPPART	BENBOARD-1/2INCH	76-43/64	29-25/64	1	0	0	Y	0000	
11.	SUNDRYPART	#TEAK-FOIL	12-1/2	12-1/2	1	0	0	Y	0000	
12.	FIXEDMPR	BENBOARD-3/4	25	40	1	0	0	Y	0000	
13.	MPPPART	BENBOARD-1/2INCH	78-51/64	31-33/64	1	0	0	Y	0000	
14.	QUPARTBMP	CHIPBOARD-3/4"	6	7-7/8	1	0	0	N	0000	
15.	QUPARTDRG	CHIPBOARD-3/4"	10-3/4	12-1/2	1	0	0	N	0000	
16.	QUPARTMCH	CHIPBOARD-3/4"	10-7/8	12-3/4	1	0	0	N	0000	
17.	QUPARTMPR	CHIPBOARD-3/4"	12-3/8	14-3/4	1	0	0	N	0000	
18.	QUPARTMCH	CHIPBOARD-3/4"	12-31/32	15-63/64	1	0	0	N	0000	

Part list - fractional inches

Materials

All materials are stored in the Board library. This is a database of all sheet material and includes quantities and costs.



Materials

The optimiser use the Material code against each part in the part list.#

For example, MFC18-BEECH to extract the available boards (of that material) from the Board library and create a Board list for the optimisation.

	Board	Type	Material	Length	Width	Quantity	Cost	Grain	Material		
Global									Description	Picture	Dens
1.	MFC18-OAK/01		MFC18-OAK	3050.0	1220.0	428	3.300	Y	Prelaminated - O...		0.41
2.	MFC18-OAK/02		MFC18-OAK	2440.0	1220.0	114	2.970	Y	Prelaminated - O...		0.41
3.	HARDBOARD-4MM...		HARDBOARD-4MM	2440.0	1220.0	782	0.890	N	Hardboard 4mm		0.71
4.	MFC18-EBONY/01		MFC18-EBONY	3050.0	1220.0	805	5.760	Y	Prelaminated - E...		0.41
5.	MFC18-EBONY/02		MFC18-EBONY	2440.0	1220.0	523	5.210	Y	Prelaminated - E...		0.41
6.	MFC18-TEAK/01		MFC18-TEAK	2440.0	1220.0	1020	3.110	Y	Prelaminated - T...		0.41
7.	MFC18-TEAK/02		MFC18-TEAK	3050.0	1525.0	955	3.110	Y	Prelaminated - T...		0.41
8.	X00135/0003	X	MFC18-TEAK	564.0	488.0	2	1.550	Y	Prelaminated - T...		0.41
9.	X00148/0001	X	MFC18-TEAK	950.0	620.0	1	1.550	Y	Prelaminated - T...		0.41
10.	X00125/0001	X	MFC18-TEAK	780.0	1011.0	1	1.550	Y	Prelaminated - T...		0.41
11.	MIRROR-GLASS		MIRROR-GLASS	0.0	0.0	0	3.200	N	Mirror Glass (sun...		0.01
12.	MFC18-BEECH/01		MFC18-BEECH	3050.0	1525.0	1702	3.210	Y	Prelaminated - B...		0.41
13.	MFC18-BEECH/02		MFC18-BEECH	2440.0	1220.0	1628	2.960	Y	Prelaminated - B...		0.41
14.	MEL-CHIP-18MM/01		MEL-CHIP-18MM	3050.0	1220.0	927	3.180	N	Prelaminated - W...		0.51
15.	MEL-CHIP-18MM/02		MEL-CHIP-18MM	2440.0	1220.0	362	3.140	N	Prelaminated - W...		0.51
16.	MFC18-RED/01		MFC18-RED	3050.0	1220.0	30	5.210	N	Prelaminated - R...		0.41

Board list



Optimising

Once the part list, parameters and board list are set up the job can be optimised to produce the pattern layouts (balancing cutting times and waste) and a set of detailed reports on each job. The results are shown in the section of the program 'Review runs'.

Runs are stored and can be easily recalled for review or adjustments.

Management summary **Bedroom & bathroom**

Bedroom & bathroom:///default/?default?? [Rules:BL]
Revision 2 : 27 Sep 2018 08:54 : Optimised by Richard

Description	Quantity	m2	m3	Weight	Percent	Rate	Cost	Statistic	Value
Required parts	620	312.61	4.66		83.54%			Number of patterns	44
Plus/Over parts	0	0.00	0.00		0.00%			Headcut patterns	12
Offcuts	37	9.83	0.17	68.73	2.63%			Rotated patterns	1
Scrap		51.75	0.61		13.83%			Recut patterns	20
Core trim		0.00	0.00		0.00%			Number of cycles	44
Boards	116	374.19	5.44	2338.74	100.00%			Cutting length	1492.3
								Throughput (M3/Hr)	1.6
								Waste (%Parts)	19.70%
								Waste (%Boards)	16.46%
Sheets used		373.40	5.43		99.79%		1081.26		
Offcuts used		0.79	0.01		0.21%	1.550	1.22		
Offcuts created		-9.83	-0.17		-2.63%	0.000	0.00		
Net material used		364.36	5.27		97.37%		1082.48		
Cutting time	3:25Hr					50.000	170.64		
Total parts	620	312.61	4.66	1987.73	83.54%	4.009	1253.12		
Sundry - unit usage	14					3.200	44.80		
Total sundry							44.80		

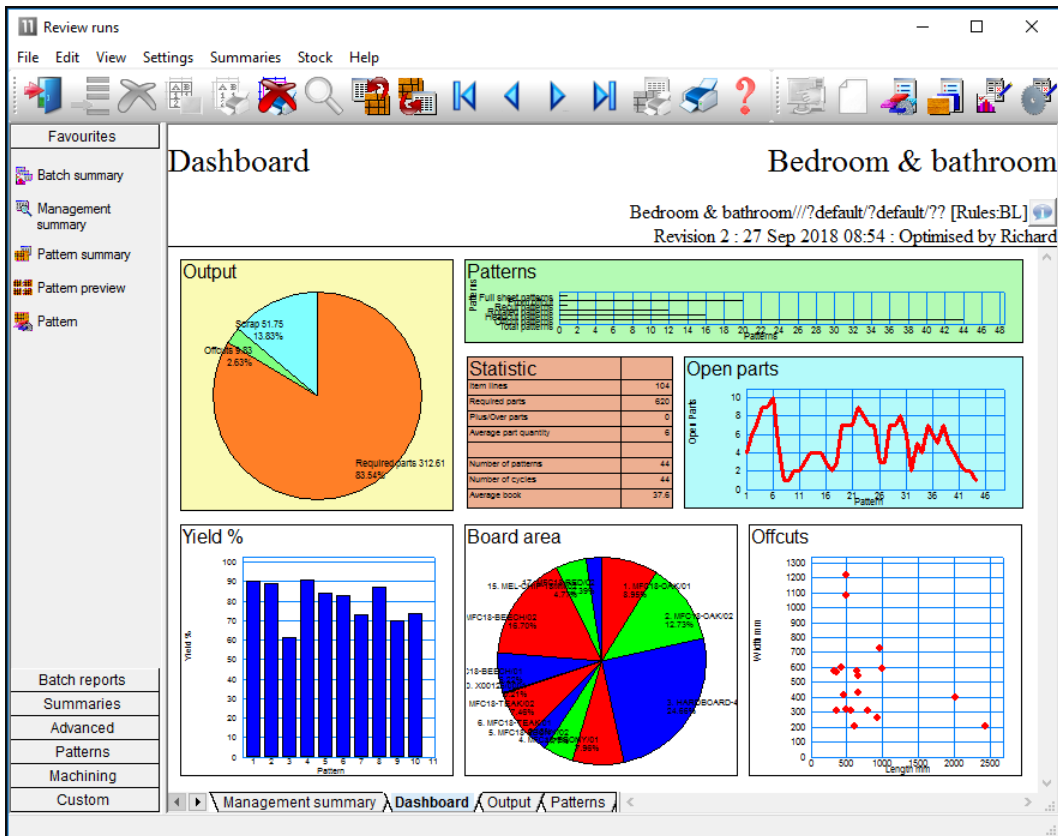
Batch reports
Summaries
Advanced
Patterns
Machining
Custom

Management summary | Dashboard | Output | Patterns

Management summary

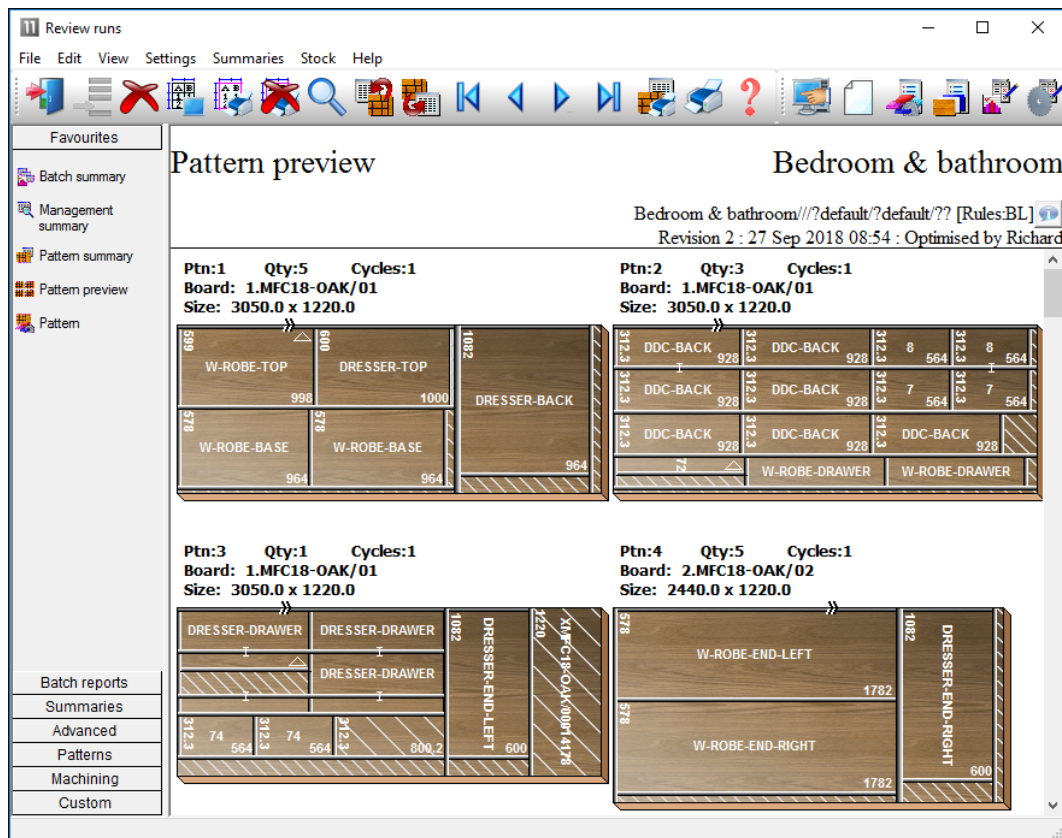
The management summary includes a Dashboard view showing a graphical view of some of the data.

This can be very valuable for larger runs where the reports consist of large numbers of patterns or parts.



Dashboard analysis

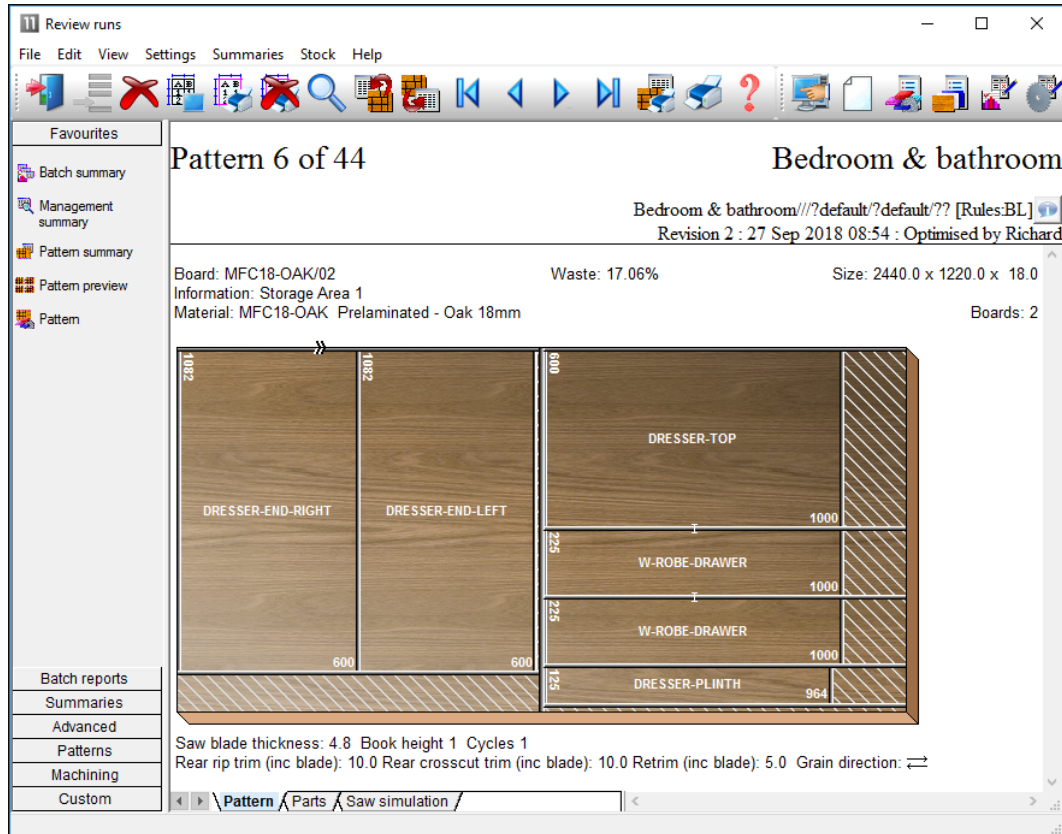
The cutting patterns are shown in a thumbnail overview.



Preview of patterns

Clicking on a thumbnail picture moves to the full screen of each pattern.

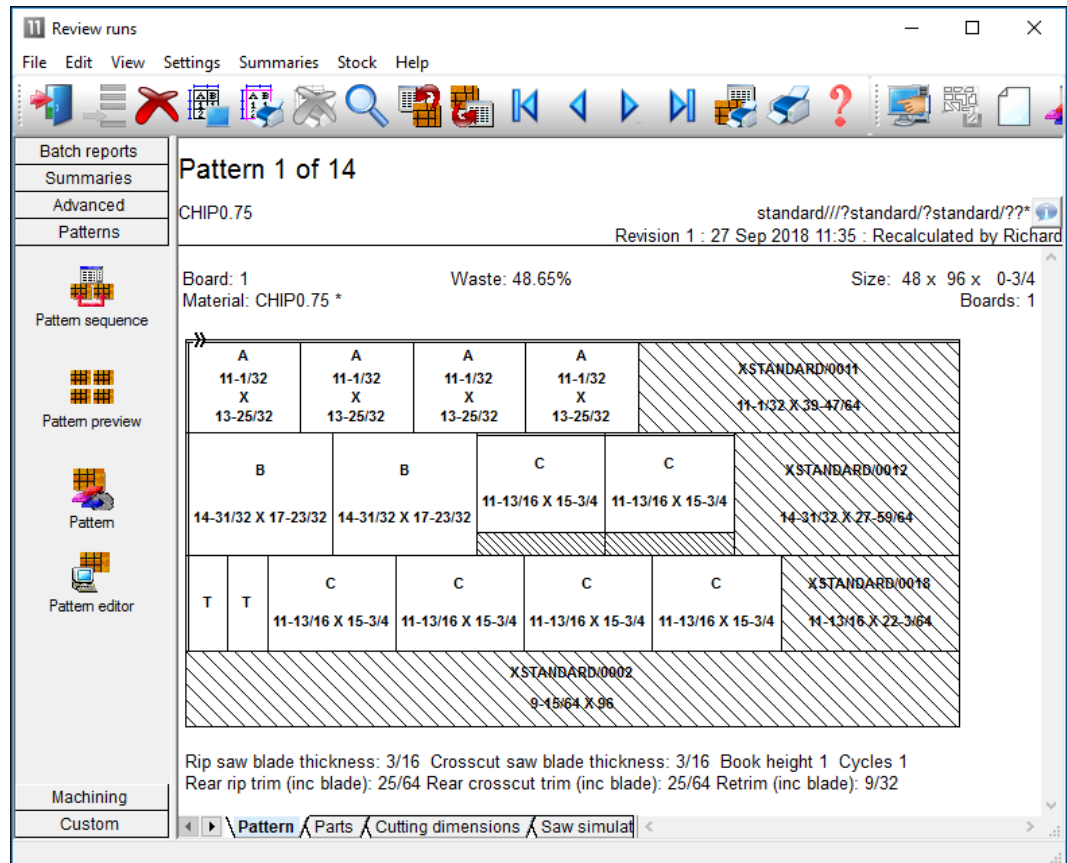
Extra details of each pattern are available on the tabs at the foot of each drawing.



Full details of pattern

All reports can be fully customised and the Form & Design option is available for custom reports - fully integrated into the program.

The program also supports decimal and fractional inches.



Pattern - fractional inches

In this example the pattern is shown in an alternative view 'Monochrome'. There are several choices of pattern view.

- Enhanced picture with bitmap or solid colour
- Flat picture with bitmap or solid colour
- Picture with colour for different part type (recut, plus part, offcut ...)
- Monochrom picture

There are a range of reports on the job, including, offcuts, costs, board usage.

Offcuts

Shows the offcuts produced in a run.

The screenshot shows the 'Review runs' application window. The main area displays an 'Offcut summary' report for a project named 'Bedroom & bathroom'. The report includes a table with columns for 'No', 'Description', 'Type', 'Picture', 'Length mm', 'Width mm', 'Total', 'Area m2', 'Cost m2', 'Cost / Offcut', 'Total Cost', 'Weight', and 'Offcuts per pattern'. The table lists several items, including 'HARDBOARD-4MM*', 'MEL-CHIP-18MM', and 'MFC18-BEECH'. A sidebar on the left contains navigation options like 'Favourites', 'Batch reports', 'Summaries', and 'Advanced'. The top of the window has a menu bar and a toolbar.

No	Description	Type	Picture	Length mm	Width mm	Total	Area m2	Cost m2	Cost / Offcut	Total Cost	Weight	Offcuts per pattern
Offcut value - restocking 17.57 Cost reduction 0.00												
HARDBOARD-4MM* Hardboard 4mm Thickness 4.0 Book 8 Parameters HBD04 Min size 850.0 X 400.0												
1.	XHARDBOARD-4MM/00014169	X		964.0	723.6	1	0.698	0.445	0.310	0.31	2.09	1/17
						1	0.698			0.31	2.09	
MEL-CHIP-18MM Prelaminated - White 18mm Thickness 18.0 Book 5 Min size 300.0 X 200.0												
2.	XMEL-CHIP-18MM/00014170	X		614.0	207.2	4	0.509	1.570	0.200	0.80	4.58	4/41
						4	0.509			0.80	4.58	
MFC18-BEECH Prelaminated - Beech 18mm Thickness 18.0 Book 5 Min size 300.0 X 200.0												
3.	XMFC18-BEECH/00014171	X		928.0	260.9	1	0.242	1.605	0.389	0.39	1.74	1/34
4.	XMFC18-BEECH/00014172	X		320.4	578.0	1	0.185	1.605	0.297	0.30	1.33	1/34
5.	XMFC18-BEECH/00014173	X		564.4	312.3	1	0.176	1.480	0.261	0.26	1.27	1/40
6.	XMFC18-BEECH/00014174	X		359.6	312.3	6	0.674	1.480	0.166	1.00	4.85	6/39
						9	1.277			1.94	9.20	

Review runs Offcut summary

Offcuts can be returned to the board library for use in later runs with the Stock control module.

Boards

Shows the amount of each board size used in a run.

The screenshot shows a software window titled 'Review runs' with a 'Board summary' tab selected. The window displays a table of board materials used in a run for 'Bedroom & bathroom'. The table includes columns for No, Material, Material Description, Board, Type, Length (mm), Width (mm), Qty in Stock, Qty Used, Length (m), Area (m2), and C. The total quantity used is 130, and the total area is 374.19 m2.

No	Material	Material Description	Board	Type	Length mm	Width mm	Qty in Stock	Qty Used	Length m	Area m2	C
3.	HARDBOARD-4MM	Hardboard 4mm	HARDBOARD-4MM/01		2440.0	1220.0	782	31	92.28	0.1	
15.	MEL-CHIP-18MM	Prelaminated - White 18mm	MEL-CHIP-18MM/02		2440.0	1220.0	362	6	17.86	3.0	
12.	MFC18-BEECH	Prelaminated - Beech 18mm	MFC18-BEECH/01		3050.0	1525.0	1702	5	23.26	3.0	
13.	MFC18-BEECH	Prelaminated - Beech 18mm	MFC18-BEECH/02		2440.0	1220.0	1628	21	62.51	2.0	
4.	MFC18-EBONY	Prelaminated - Ebony 18mm	MFC18-EBONY/01		3050.0	1220.0	805	8	29.77	5.0	
5.	MFC18-EBONY	Prelaminated - Ebony 18mm	MFC18-EBONY/02		2440.0	1220.0	523	6	17.86	5.0	
1.	MFC18-OAK	Prelaminated - Oak 18mm	MFC18-OAK/01		3050.0	1220.0	428	9	33.49	3.0	
2.	MFC18-OAK	Prelaminated - Oak 18mm	MFC18-OAK/02		2440.0	1220.0	114	16	47.63	2.0	
17.	MFC18-RED	Prelaminated - Red 18mm	MFC18-RED/02		2440.0	1220.0	14	3	8.93	4.0	
7.	MFC18-TEAK	Prelaminated - Teak 18mm	MFC18-TEAK/02		3050.0	1525.0	955	6	27.91	3.0	
6.	MFC18-TEAK	Prelaminated - Teak 18mm	MFC18-TEAK/01		2440.0	1220.0	1020	4	11.91	3.0	
10.	MFC18-TEAK	Prelaminated - Teak 18mm	X00125/0001	X	780.0	1011.0	1	1	0.79	1.0	
11.	MIRROR-GLASS	Mirror Glass (sundry)	MIRROR-GLASS				0	14		3.0	
Total								130	374.19		

Review runs Board summary

Job costing

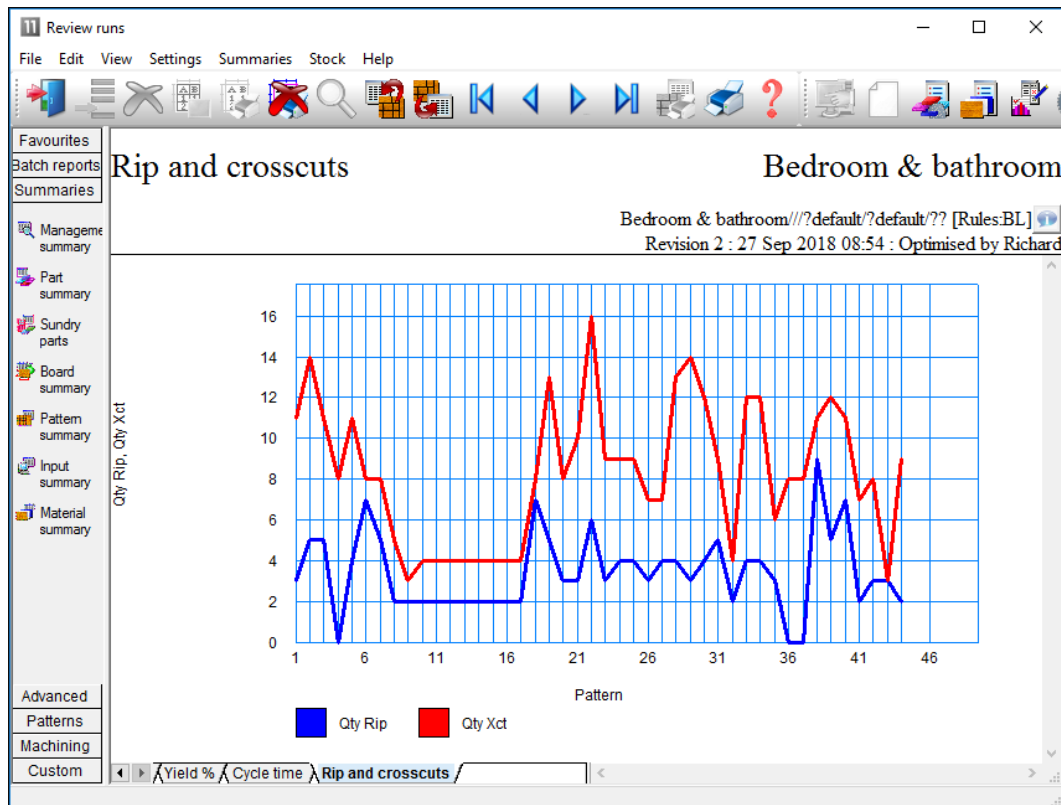
A summary of all the cost centres for a job.

Review runs						
File Edit View Settings Summaries Stock Help						
Job costing Bedroom & bathroom						
Bedroom & bathroom						
Bedroom & bathroom						
Code	Description	Quantity	Linear	Area	Cost	Total
Board		Quantity		Area	Cost/m2	Total
MFC18-OAK/01	MFC18-OAK 3050.0 x 1220.0	9		33.489	3.300	110.514
MFC18-OAK/02	MFC18-OAK 2440.0 x 1220.0	16		47.629	2.970	141.458
HARDBOARD-4MM/01	HARDBOARD-4MM 2440.0 x 1220.0	31		92.281	0.890	82.130
MFC18-EBONY/01	MFC18-EBONY 3050.0 x 1220.0	8		29.768	5.760	171.464
MFC18-EBONY/02	MFC18-EBONY 2440.0 x 1220.0	6		17.861	5.210	93.055
MFC18-TEAK/01	MFC18-TEAK 2440.0 x 1220.0	4		11.907	3.110	37.031
MFC18-TEAK/02	MFC18-TEAK 3050.0 x 1525.0	6		27.907	3.110	86.792
X00125/0001	MFC18-TEAK 780.0 x 1011.0	1		0.789	1.550	1.222
MFC18-BEECH/01	MFC18-BEECH 3050.0 x 1525.0	5		23.256	3.210	74.653
MFC18-BEECH/02	MFC18-BEECH 2440.0 x 1220.0	21		62.513	2.960	185.038
MEL-CHIP-18MM/02	MEL-CHIP-18MM 2440.0 x 1220.0	6		17.861	3.140	56.083
MFC18-RED/02	MFC18-RED 2440.0 x 1220.0	3		8.930	4.820	43.045
		116		374.191		1082.484
Sundry		Quantity	Linear	Area	Cost	Total
MIRROR-GLASS	MIRROR-GLASS	14			3.200	44.800
		14				44.800
Edging		Quantity			Cost/m	Total
OAK-TAPE-22MM	Oak PVC Tape 22mm	47.460			0.840	39.866
EBONY-TAPE	Ebony PVC Tape 22mm	34.980			0.840	29.383
BEECH-TAPE-22MM	Beech PVC Tape 22mm	21.340			0.720	15.365

Review runs job costing

Charts and Analysis

Most reports include options to add a graphical view or chart of the report data. Up to 3 custom charts can be defined for each summary.



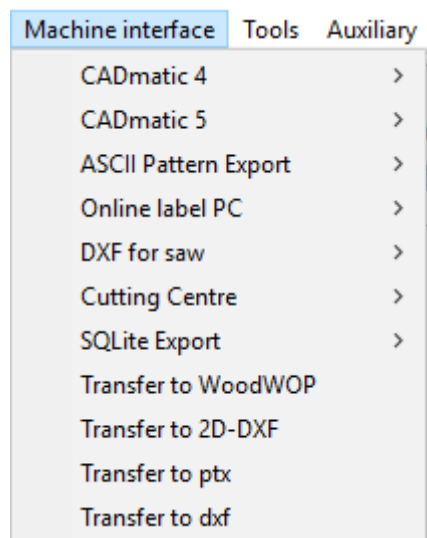
Review runs chart

The data to highlight in this way typically varies from company to company so there are full facilities for defining data to include and style of chart for each report in Review runs (*Settings - Chart settings*)

Saw Interface

Optimising data can be sent directly to many types of saw in proprietary formats. The Professional Optimiser supports most saw types including angular. The Standard Optimiser is typically for single axis beam saws.

Saw transfer parameters are used to set up the transfer for each saw. Users typically transfer to a handful of different saws, for example, two different Homag/Holzma saws.



Saw interface menu

The saw controllers supported are:-

- Direct link – Homag/Holzma Topmatic/Micromatic
- Module programmer
- Online label PC
- Homag/Holzma CADmatic 1
- Homag/Holzma CADmatic 2
- Selco CRLINK
- Homag/Holzma CADmatic 3/4/5
- Homag Sawtech (Espana)
- Giben
- Schelling Commander 2 and 4
- SCM
- SCM Seziona
- ASCII/Unicode PTX
- MDB PTX

This variety of saws includes many different types of saw including full support for Angular systems (Homag/Holzma only) dealing with larger volumes of cutting.

- Single saws
- Angular saws
- Angular saw with turntable
- Separated Rip and Cross cut saws (strip production)
- Saws with split fences (or split fence devices)

The pattern exchange format (PTX) is used by several manufacturers to control other machinery on the production line or send data back to the office.

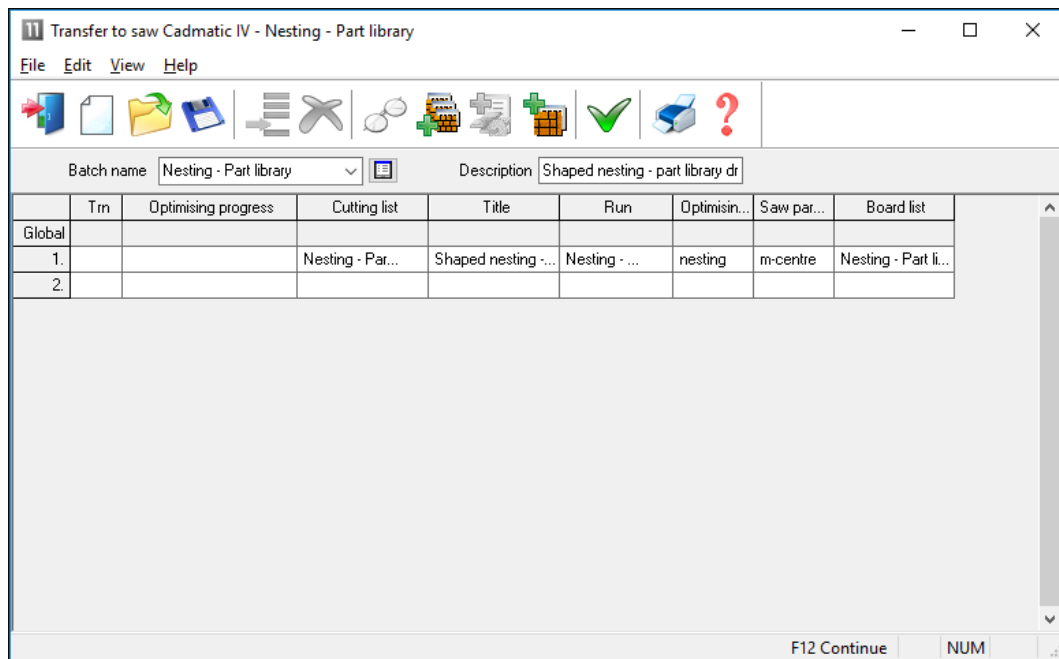
Saw transfer process

Once the details for transfer to a specific saw are set up (Saw transfer parameters) the transfer process is straightforward.



Select the saw transfer option at the main menu

The program displays the current (last used) run or batch of runs.

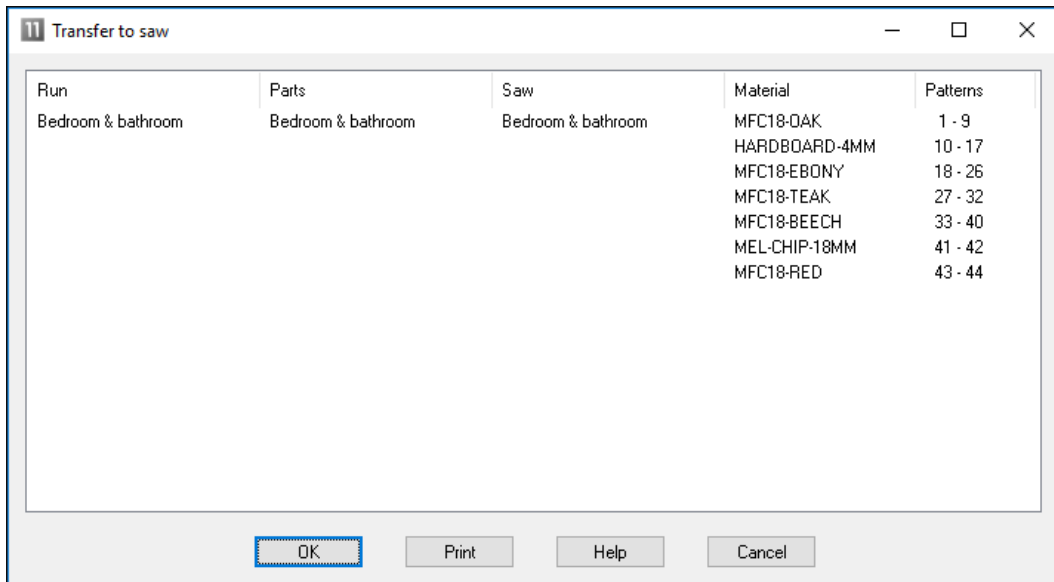


Saw transfer batch screen



Select the 'Continue' option

The details of the data transferred are shown.



Saw transfer details

OK to confirm the transfer

Typically the data is sent to a folder on the Network (set by the system parameter: *Path for saw data*). A separate program from the manufacturer then runs automatically to send the data to the saw. This is all set up and integrated via the *Saw Transfer parameters*.


Batches

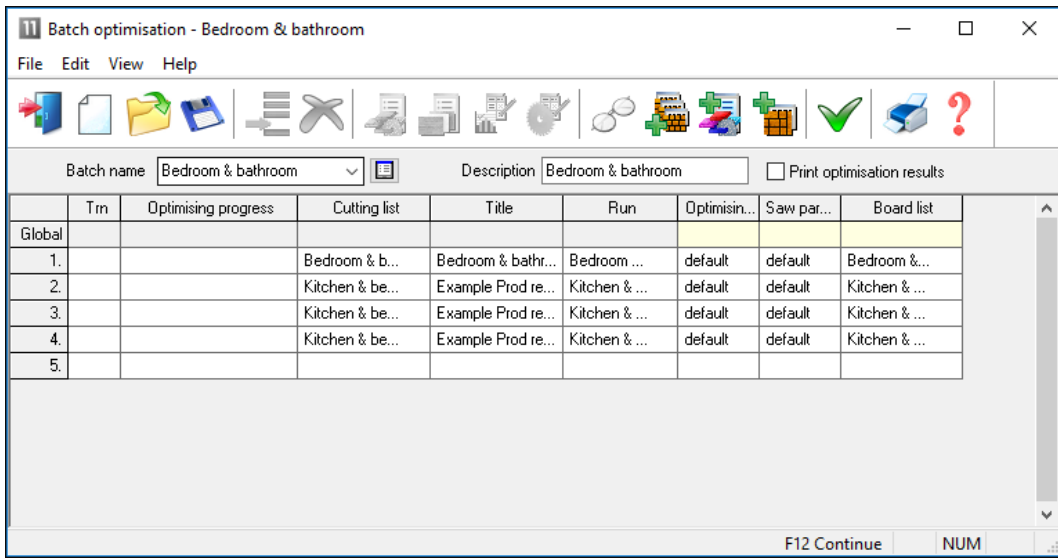
It is often useful to optimise more than one job at a time, for example, to process a set of smaller jobs or even to compare the same data optimised with several different settings in the parameter files. The following example illustrates this.

At the main screen:-

- Select: **Review runs - Batch optimisation**

The program displays the batch screen. Enter the cutting lists to optimise. Parameters can be varied by choosing different parameter files in the 'Optimising parameter' and 'Saw parameter' columns as required.

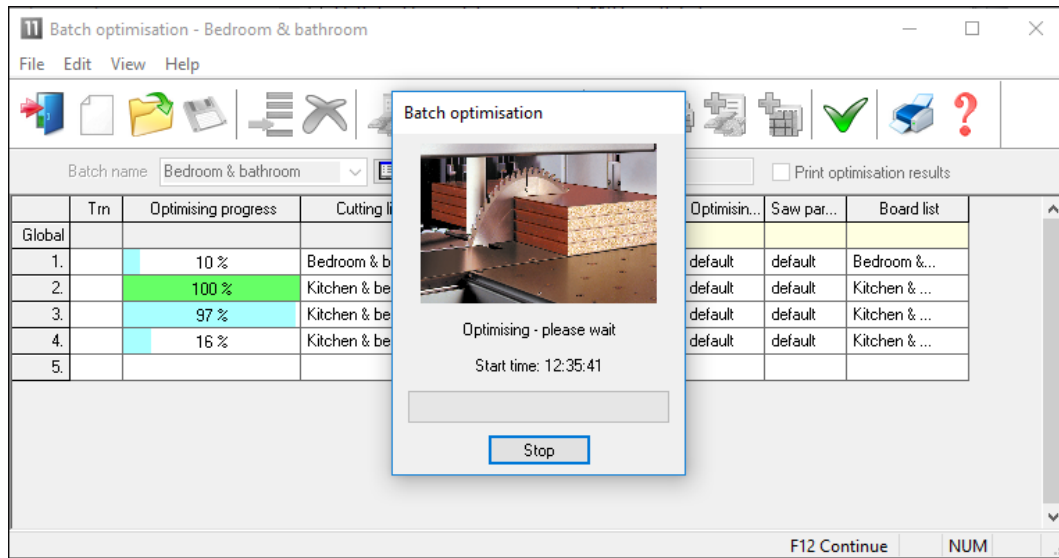
 Select the 'Continue' option



Trn	Optimising progress	Cutting list	Title	Run	Optimisin...	Saw par...	Board list
Global							
1.		Bedroom & b...	Bedroom & bathr...	Bedroom ...	default	default	Bedroom &...
2.		Kitchen & be...	Example Prod re...	Kitchen & ...	default	default	Kitchen & ...
3.		Kitchen & be...	Example Prod re...	Kitchen & ...	default	default	Kitchen & ...
4.		Kitchen & be...	Example Prod re...	Kitchen & ...	default	default	Kitchen & ...
5.							

Multiple batch

The progress of the optimising is shown in the column: *Optimising progress*



The screenshot shows the 'Batch optimisation - Bedroom & bathroom' window. A modal dialog box titled 'Batch optimisation' is open, displaying a progress bar and the text 'Optimising - please wait' and 'Start time: 12:35:41'. The background window shows a table with columns for 'Trn', 'Optimising progress', and 'Cutting list'. The progress bar in the dialog is filled with a blue gradient, indicating the current status of the optimization process.

Trn	Optimising progress	Cutting list
Global		
1.	10 %	Bedroom & b
2.	100 %	Kitchen & be
3.	97 %	Kitchen & be
4.	16 %	Kitchen & be
5.		

Optimising progress

When all runs are complete the program moves to the 'Batch summary' in Review runs.

This shows a one line summary for each job.

Run	Parts produced m2	Boards m2	Total Time	Pattern Cost	Qty Parts	Qty Boards	Sheets used Qty	Offcuts created Qty
Bedroom & bathroom	312.61	374.19	3:25	1253.12	620	116	115	37
Kitchen & bedroom-01	34.20	45.02	1:04	223.72	72	14	14	14
Kitchen & bedroom-02	31.19	39.63	0:56	151.98	81	12	12	7
Kitchen & bedroom-03	35.55	48.37	1:19	189.18	122	16	16	10
	413.55	507.21	6:44	1818.00	895	158	157	68

Batch summary

In this example the 'Runs' pane is switched on. This give a tree of all the batches and run in the User profile; so it is easy to quickly move between runs - this can be useful when quickly comparing one result with another.

- Select a run and choose a summary to move to the details of each run.

Pattern preview **Bedroom & bathroom**

Bedroom & bathroom:///default/?default?? [Rules:BL]
Revision 2 : 27 Sep 2018 08:54 : Optimised by Richard

Pattern	Qty	Cycles	Board	Size
Ptn:1	5	1	1.MFC18-OAK/01	3050.0 x 1220.0
Ptn:2	3	1	1.MFC18-OAK/01	3050.0 x 1220.0
Ptn:3	1	1	1.MFC18-OAK/01	3050.0 x 1220.0
Ptn:4	5	1	2.MFC18-OAK/02	2440.0 x 1220.0

Runs pane - Multiple batch

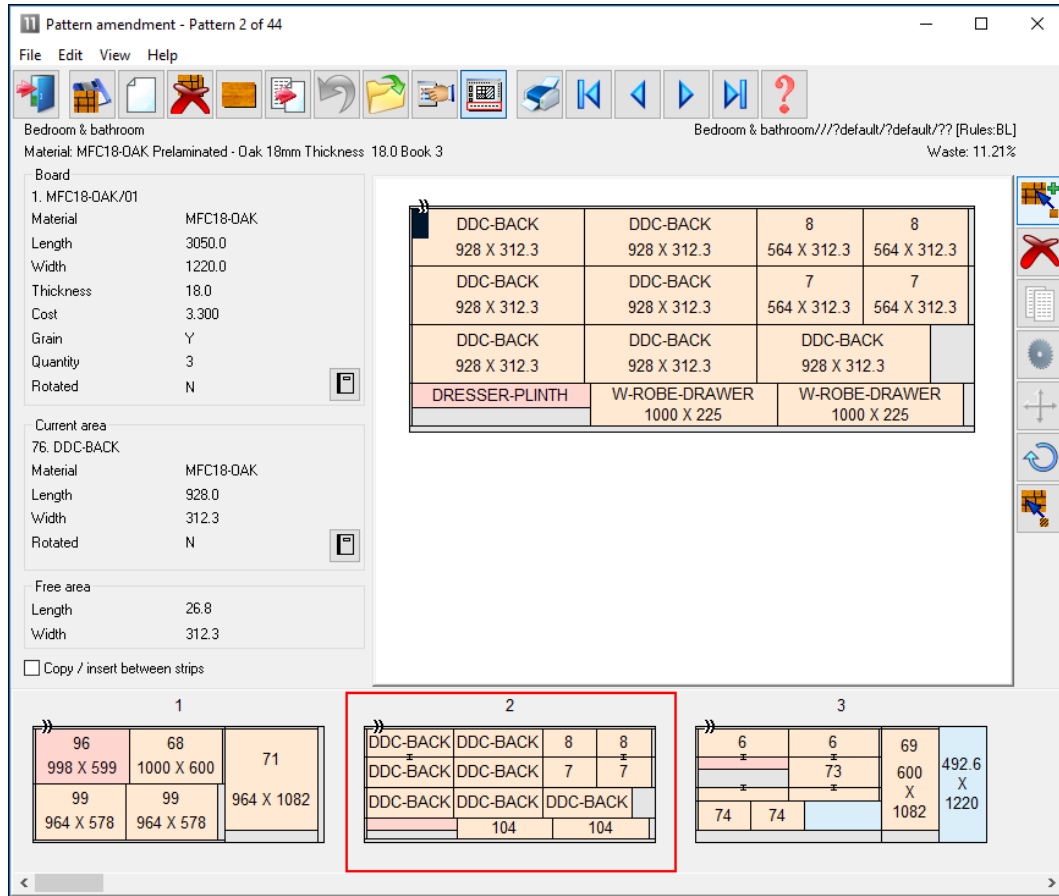
In the above example the 'Runs pane' is turned on - this makes it easy to switch between optimised batches and runs.

Pattern editor

In production there are sometimes last minute changes if materials are not available or an order changes. The optimiser includes a pattern editor and a pattern library. The editor allows changes to each pattern, for example:-

- change the order in which patterns are cut

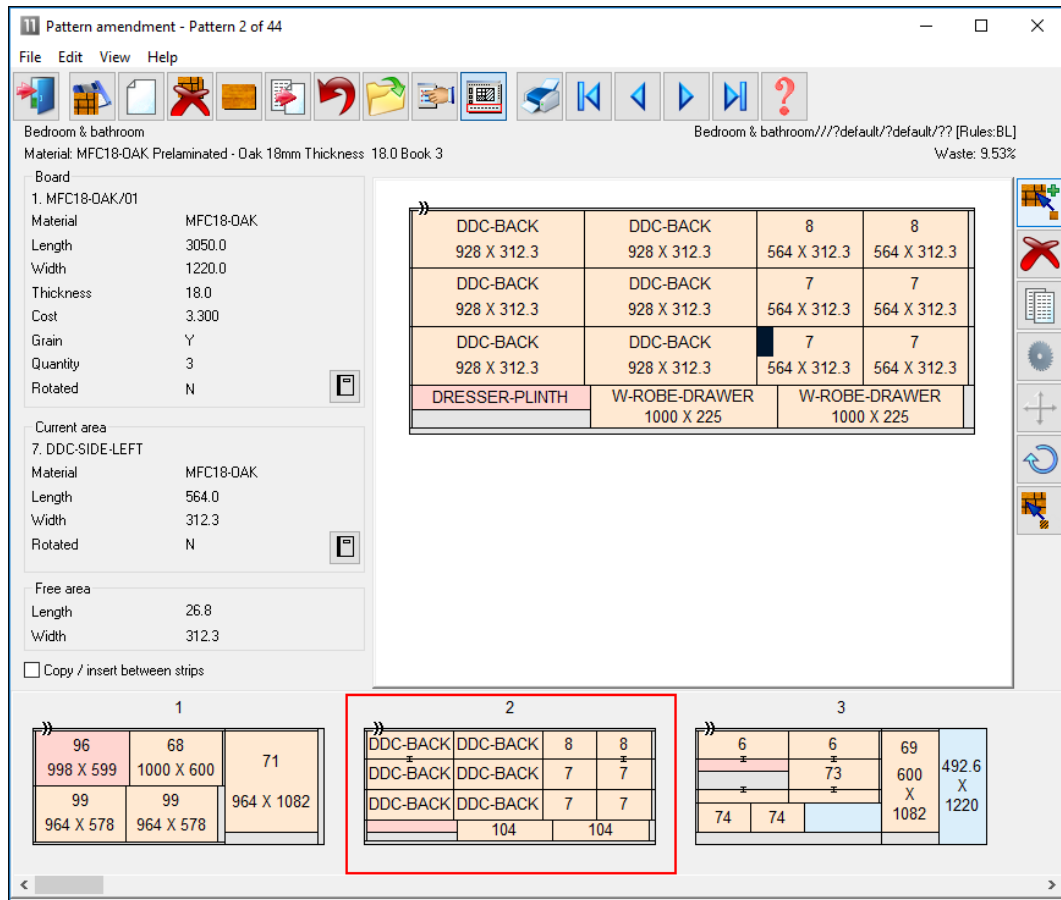
- alter a cut quantity
 - remove a headcut
 - swap parts
 - alter a part size
 - use a different board
- Click on any pattern to move to the editor.



Pattern editor

The thumbnail at the foot of the editor allows patterns to be quickly selected and for parts to be moved between patterns. Once the changes are complete the run is recalculated

and the cutting data can be sent to the saw. The parts in a pattern and/or the run quantities can be changed. In the following example a part is deleted and a run of 2 of a different part have been added.



Pattern editor adjust parts

The editor is easy to use and acts in a similar way to a graphics program. At the right (not shown above) are various editing tools and at the left a set of panels for the board and part properties.

Pattern Library

Quite often the pattern editor is used to adjust patterns for specialist work where the exact pattern or amount of waste is important. Amended patterns can be stored for future use in the Pattern library.

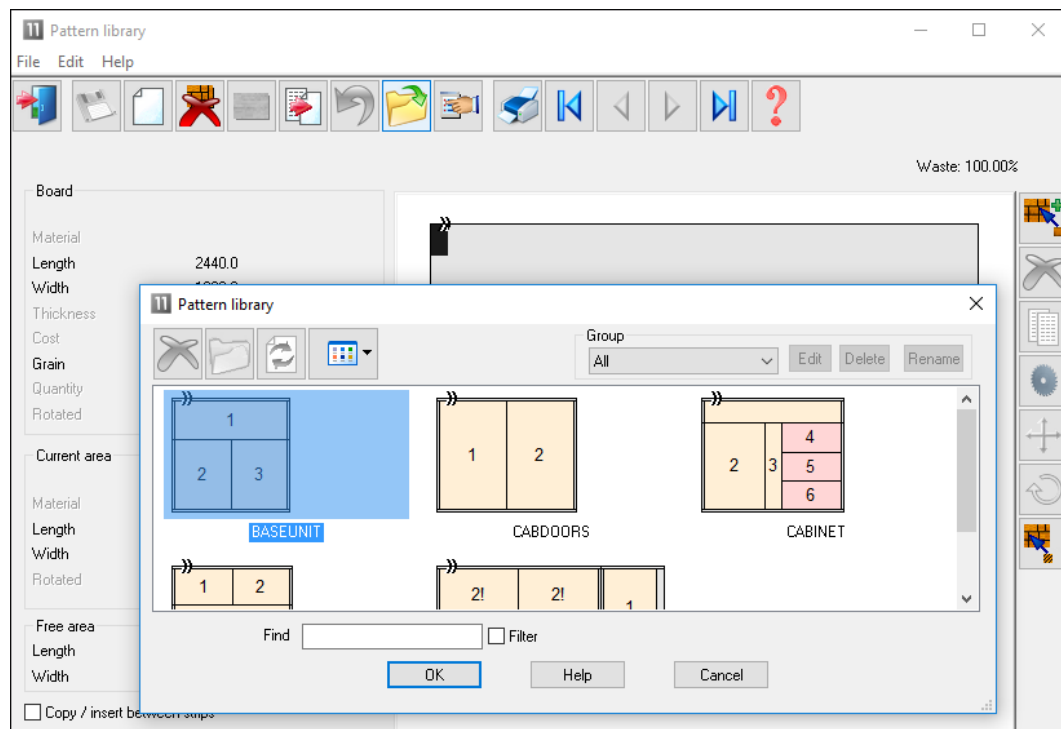
The *Pattern library* is a separate store of patterns and templates for patterns. A common use of the templates is for *Grain matching*. At the main screen:-

- Select: **Libraries - Pattern library**

The screen moves to the Pattern library screen. The pattern library can be used to create new templates and view existing templates.



Click on the list button for a list of the current patterns in the library

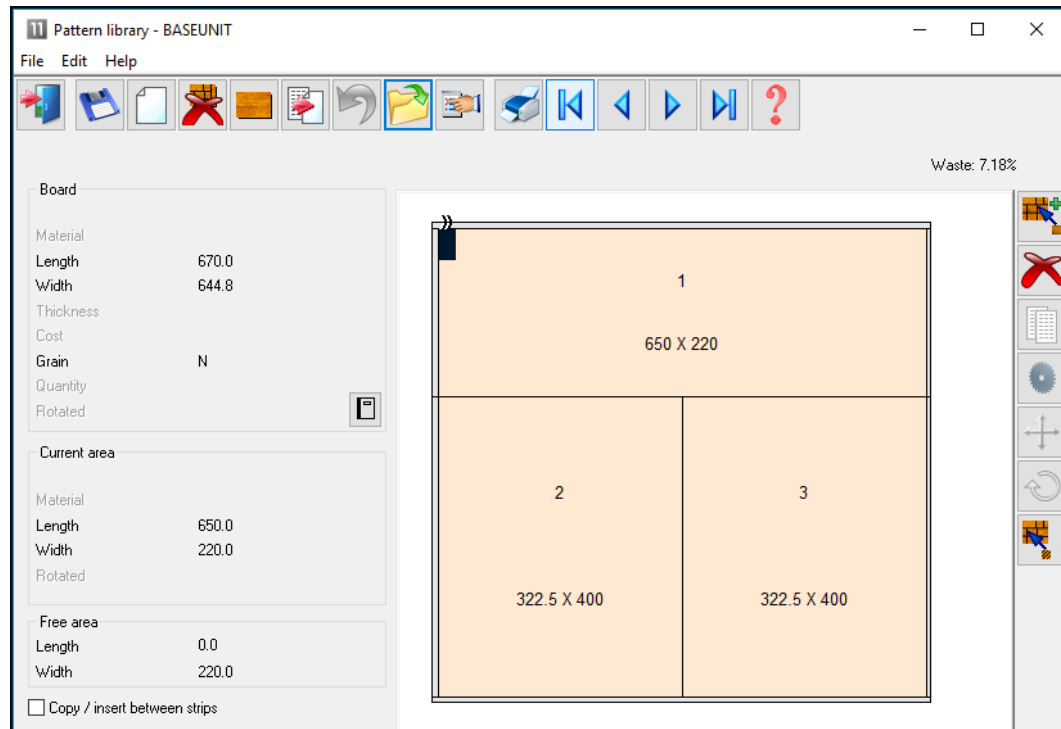


Pattern editor templates

Grain matching

The optimisers include a grain matching option so that parts that are specified for grain matching are kept together in the pattern layouts during optimisation; this is often necessary for items such as drawer fronts and cabinet doors with grained material.

To work in this way use the *Pattern library* to create a template the parts must fit into. This is just a pattern like any other pattern but it is not associated with any particular board size or run. It describes the layout of the parts.



Pattern library - template for grain matching

The template is assigned to the parts as each part is set up in the Part list or Part library.

The information box parameter: *Grain matching* is used for this and it is set up as one of the extra part list fields.

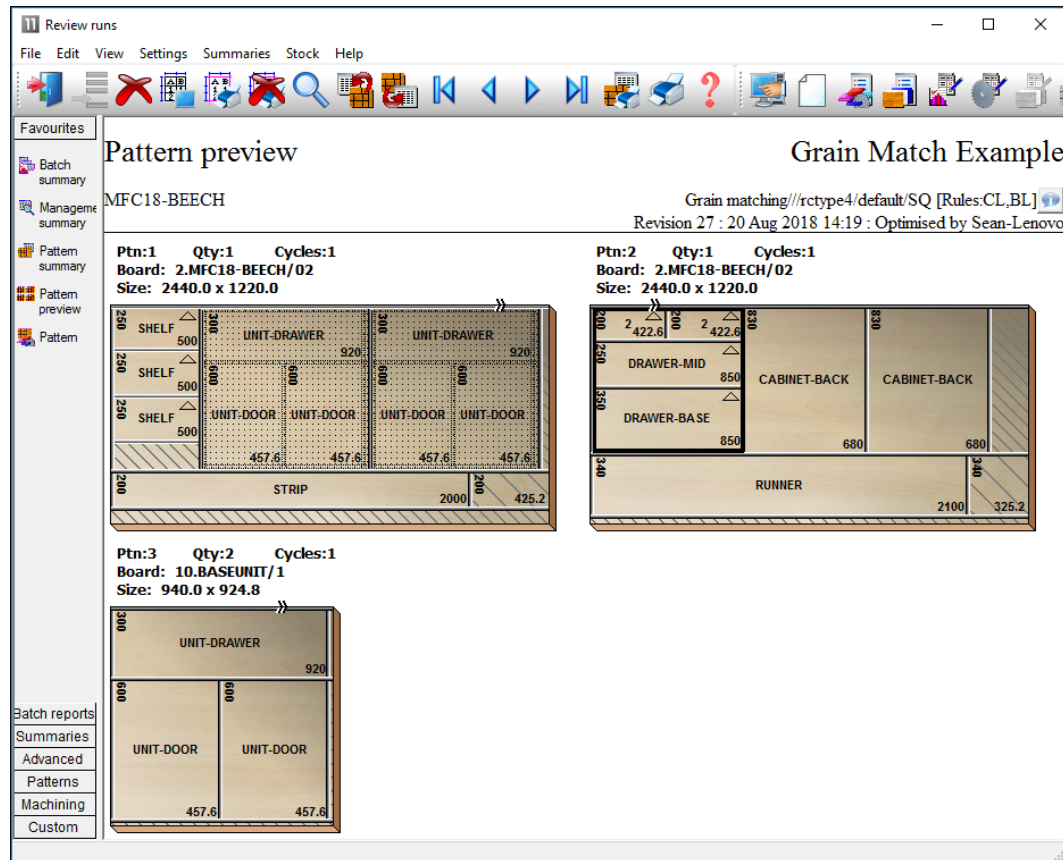
	Description	Material	Length	Width	Quantity	Over	Under	Grain	Grain matching	Inf
Global						50 %	0 %	Y		
1.	CABINET-BACK	MFC18-BEECH	680.0	830.0	2	1	0	Y		
2.	DRAWER-SHORT	MFC18-BEECH	422.6	200.0	2	1	0	Y	DRWFRONT:...	
3.	DRAWER-MID	MFC18-BEECH	850.0	250.0	1	0	0	Y	DRWFRONT:...	
4.	DRAWER-BASE	MFC18-BEECH	850.0	350.0	1	0	0	Y	DRWFRONT:...	
5.	RUNNER	MFC18-BEECH	2100.0	340.0	1	0	0	Y		
6.	SHELF	MFC18-BEECH	500.0	250.0	3	1	0	Y		
7.	UNIT-DOOR	MFC18-BEECH	457.6	600.0	4	2	0	Y	BASEUNIT:2...	
8.	UNIT-DRAWER	MFC18-BEECH	920.0	300.0	2	1	0	Y	BASEUNIT:1.0	
9.	STRIP	MFC18-BEECH	2000.0	200.0	1	0	0	Y		
10.						0	0	Y		

Part list - assign parts to template

Clicking on the 'Grain matching' template pops up a dialog to help assign the parts to the correct position in the template. The result is a list of the assignments in the Grain matching column (as above).

Note - part size does not have to match the size in the template only the layout matters. If there are cabinet doors of different sizes in the list they can all be assigned to the same template.

The pattern below shows how the optimisation allows for a set of parts (drawer fronts, doors ...) arranged in a fixed templates from the pattern library so that the grain matches across the parts.



Pattern - grain match

In this case the first pattern (with the parts shaded) is cut at the saw and in the second pattern (with the bold outline) the parts in the template are cut as a single part and then cut separately.

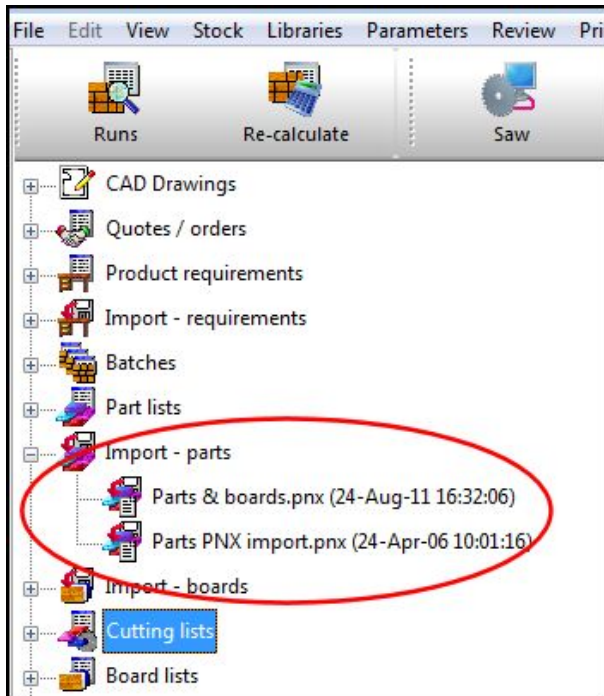
The settings for the template determine how the template and parts are cut in the optimising run.

Import and export cutting data

These days, especially for larger orders, the cutting list may be generated in other systems. The Professional and Standard optimisers include a variety of options for importing and exporting data from the program.

To import a part list, at the Main screen:-

- Open the File tree
- Select the Import area



File tree

- Click on a part list to import

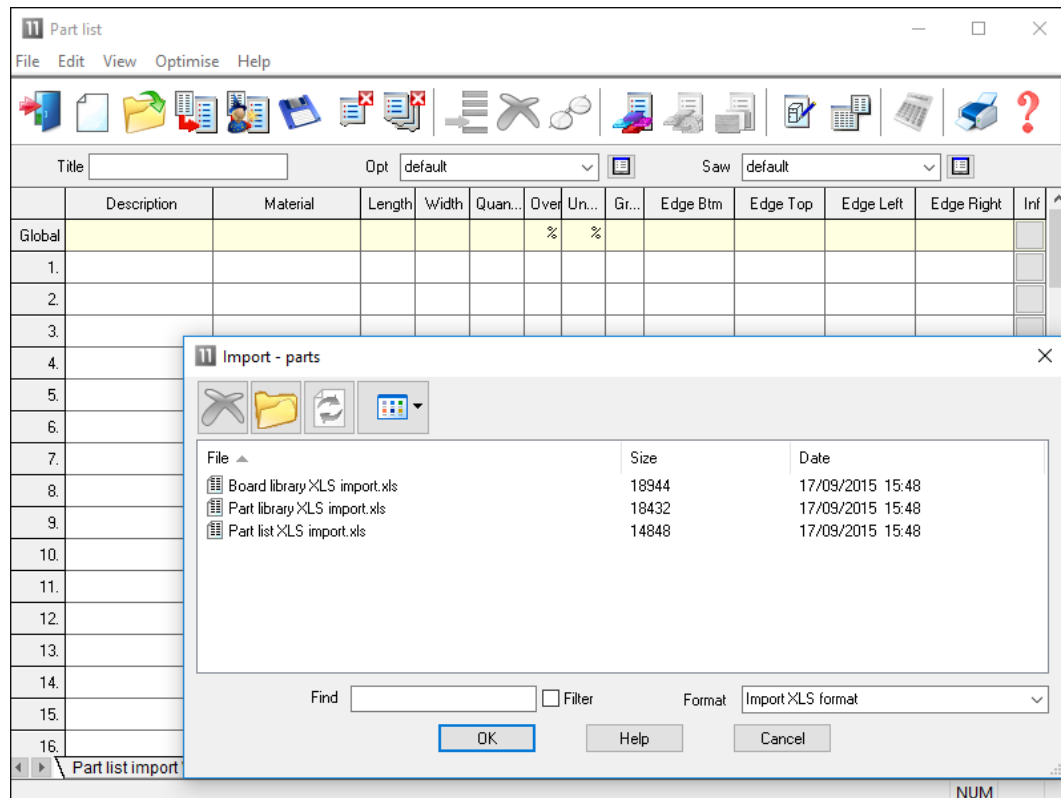
The format of the import files can be customised or set as one of the standard options.

Part list order – ASCII/Unicode CSV (PNX)
Cabinet Vision format
Product Planner format
Code and quantity – ASCII/Unicode CSV (PNX)
Batch - part list order (BTX & PNX)
Batch - Code and quantity (BTX & PNX)
User defined order – ASCII/Unicode CSV
Batch - user defined order (BTX)
Parts & boards – ASCII/Unicode CSV (PTX)
Parts & boards - Access (MDB)
User defined order - Excel (XLS)
User defined order - Excel (XLSX)

There are a variety of options for importing and exporting from the program to work with other software - from importing part lists or product requirements to import and export of full patterns.

Import at the part list

At the part list data can be imported directly (*File – Import*)



Where the format of the external file is not known or needs to be set up – use the Import Wizard (*File – Import Wizard*).

Wizard for importing part lists

Parts

Describe the data in your source file

Starting at the top of your file, how many header lines need to be skipped?

Is your data separated by commas or another character? - please specify

Click required column headings and assign to part list fields

	Material	Description	What's this?	What's this?	What's this?	What's this?	What's this?
1.	Material	Part / Description	Length mm	Width mm	Total Req	Grain	Edge Bottom
2.	MEL-CHIP-15MM	UNIT-BASE	585.00	470.00	13	0	WHITE-TAPE-22MM
3.	MEL-CHIP-15MM	UNIT-END	1740.00	585.00	5	1	
4.	MEL-CHIP-15MM	UNIT-PLINTH	500.00	150.00	2	0	
5.	MEL-CHIP-15MM	UNIT-RAIL	474.00	75.00	5	0	WHITE-TAPE-22MM
6.	MEL-CHIP-15MM	UNIT-SHELF	474.00	395.00	7	0	
7.	MEL-CHIP-18MM	CABINET-BASE	574.00	585.00	3	0	
8.	MEL-CHIP-18MM	HOUSING-PLINTH	600.00	150.00	14	0	WHITE-TAPE-22MM
9.	MEL-CHIP-18MM	CABINET-RAIL	574.00	75.00	6	0	WHITE-TAPE-22MM
10.	MEL-CHIP-18MM	CABINET-TOP	946.00	395.00	3	0	
11.	MEL-CHIP-18MM	HOUSING-END	1000.00	340.00	3	0	
12.	MEL-CHIP-18MM	HOUSING-BACK	1195.00	420.00	1	0	

OK P

The program imports data from any CSV (comma separated values) files and Excel files. You can then work through the fields and assign them to the correct Part list fields name by selecting the field name on the 'What's this' button.

	Description	Material	Length	Width	Quan...	Over...	Un...	Gr...	Edge Btm	Edge Top	Edge Left	Edge Right	Inf
Global						%	%						
1.	UNIT-BASE	MEL-CHIP-15MM	585.0	470.0	13	0	0	N					
2.	UNIT-END	MEL-CHIP-15MM	1740.	585.0	5	0	0	Y					
3.	UNIT-PLINTH	MEL-CHIP-15MM	500.0	150.0	2	0	0	N					
4.	UNIT-RAIL	MEL-CHIP-15MM	474.0	75.0	5	0	0	N					
5.	UNIT-SHELF	MEL-CHIP-15MM	474.0	395.0	7	0	0	N					
6.	CABINET-BASE	MEL-CHIP-18MM	574.0	585.0	3	0	0	N					
7.	HOUSING-PLI...	MEL-CHIP-18MM	600.0	150.0	14	0	0	N					
8.	CABINET-RAIL	MEL-CHIP-18MM	574.0	75.0	6	0	0	N					
9.	CABINET-TOP	MEL-CHIP-18MM	946.0	395.0	3	0	0	N					
10.	HOUSING-END	MEL-CHIP-18MM	1000.	340.0	3	0	0	N					
11.	HOUSING-BACK	MEL-CHIP-18MM	1195.	420.0	1	0	0	N					
12.	CABINET-END	MEL-CHIP-18MM	1150.	585.0	8	0	0	N					
13.	HOUSING-TOP	MEL-CHIP-18MM	1490.	590.0	16	0	0	N					
14.	CABINET-PLIN...	MEL-CHIP-18MM	495.0	150.0	12	0	0	N					
15.	CABINET-BACK	MEL-CHIP-18MM	474.0	710.0	12	0	0	X					
16.	UNIT-BACK	MEL-CHIP-18MM	710.0	574.0	22	0	0	N					

Note – you can also cut and paste directly from a spreadsheet to the part list – for example where the spreadsheet has the data in the same order and format as the part list.

Export reports

For larger runs it is often useful to export run data (summaries) to an external file so that the data can be used in an external system or in a spread sheet, for example, Excel. To do this:-

- Move to any summary

- Select: **File - Export**

Choose one of the export formats:-

ASCII
XLS
XLXS

In the following example a Part list summary was exported to Excel.

No	Part / Descrip	Length mm	Width mm	Total f	From Ov	Total m2 / Par	Total m2	Mat
CHIPBOARD-18MM Chipboard Core 18mm Thickness 18.0 Book 5								
1	BASE-BACK	730.00	420.00	90	0	90	0.31	27.59
2	BASE-BACK	750.00	420.00	80	0	80	0.32	25.20
3	BASE-BACK	435.00	402.00	40	0	40	0.18	7.00
6	BASE-CABINE	559.00	490.00	50	0	50	0.27	13.69
30	WALL-TOP	280.00	239.00	30	0	30	0.07	2.01
31	WALL-TOP	464.00	349.00	30	0	30	0.16	4.86
32	WALL-TOP	614.00	349.00	40	0	40	0.21	8.57
				360	0	360		88.92
MFC18-BEECH Prelaminated - Beech 18mm Thickness 18.0 Book 5								
4	BASE-BOTTOI	580.00	459.00	30	0	30	0.27	7.99
5	BASE-BOTTOI	620.00	459.00	40	0	40	0.29	11.38
7	BASE-CABINE	558.00	398.00	20	0	20	0.22	4.44

Export summary to Excel

Pattern Exchange format (PTX)

As well as sending data to a saw cutting data can also be exported to our standard PTX (Pattern exchange) format; either as an ASCII/Unicode file or MDB database file.

This format has been in use for many years and several manufacturers use it for extracting data for post processing for other machines:-

- transfer to other office or production database systems
- control of destacking machinery
- control of edgebanders
- sending information to other stations in a cutting line.

Full control of imported data and clean part lists

These days it is much more common for part list requirements to be imported from other systems such as an Order system or Sales database. In these cases the data is often in a variety of formats and the incoming data contains records and fields that are not used in optimising.

The *Part list import parameters* allow you to describe the format of almost any external file and to specify the fields required for optimising (part code, length, width quantity etc.)

It often happens, as well, that not all the part sizes can be optimised e.g. thin rails or bought in items. Using the *Cutting list rules* option allows any imported list to be further refined and corrected automatically.

The program can also deal smoothly with converting from data in fractional or decimal inches to millimetres (or vice versa).

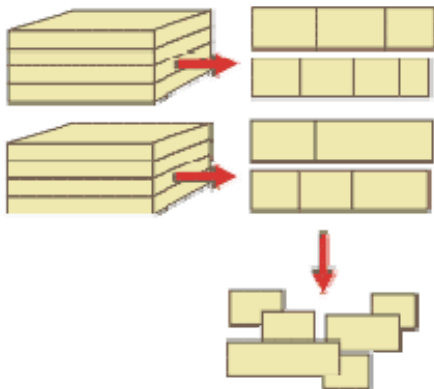
Professional optimiser - other features

The Professional optimiser is designed for larger volumes of parts - up to the very largest; it balances the cutting time and costs against material cost to produce an effective solution.

The optimiser includes many specialist features which are often needed with volume production.

- Over production of parts (up to a full sheet)
- 'Strip production' option to allow ripping and cross cutting to appear on separate patterns.

This is often required where the cutting line separates ripping and cross cutting across separate saws (e.g. Kitchen worktops).



Strip production

- Option to restrict the number of pallet groups.

The number of parts not completed at any time is kept below a fixed value. This helps with offstacking and later production processes where there are large volumes of parts.

- Free cut analysis.

This determines the optimum position for cutting jumbo boards - a free cut to split boards is often an option for those using high board volumes.

- Optimising parameters to control the number of different board sizes used and the order of part production (priority). These are often more important for volume production.

Using Information boxes

A unique feature of the program is the ability to add extra custom and/or pre-defined fields to the part list; called 'Information boxes'. These not only provide extra information for each part (for example for use on labels) but are also used to extend the capabilities of optimising to take account of many production constraints or requirements. For example:-

- Allow for grain matching of parts
- Include custom information on parts
- Create calculated fields or codes for export

- Allow the use of alternative or substitute materials when optimising
- Set a cutting priority for each part or group of parts
- Use longer edging codes
- Deal with 'one off' production rules

One example (see above) is the use of the 'Grain matching' information box.

Alternative materials (Information boxes)

An example of the use of information boxes is in providing the option for optimising to use alternative or substitute materials when creating cutting patterns. These may, for example, be common parts, or dividers or fillers. To do this one of the pre-defined information boxes is added to the part list (*Parameters - Information boxes*)

The information box appears on the part list as one of the fields.

	Description	Material	Length	Width	Quantity	Grain	Alternative material(s)
Global							
1.	A	MED-DEN-FIBRE-18MM	800.0	500.0	4	N	
2.	B	MED-DEN-FIBRE-18MM	600.0	330.0	2	N	CHIPBOARD-18MM
3.	C	MED-DEN-FIBRE-18MM	980.0	650.0	3	N	
4.	D	MED-DEN-FIBRE-18MM	950.0	450.0	6	N	CHIPBOARD-18MM
5.	E	MFC18-ASH	550.0	830.0	19	N	MFC18-EBONY MFC18-DAK
6.	F	MFC18-ASH	427.0	359.0	15	N	MFC18-EBONY
7.							

Part list - Information boxes

In this case the possible alternative materials are added to the Information box.

On optimising the program can place parts G, H, D, B on alternative materials if there is a shortage of the first material. In this case G and H were place on the alternative MFC18-EBONY.

Pattern preview

Alternative materials

Example of alternative materials:///default/default/?? [Rules:BL]

Revision 1 : 27 Sep 2018 14:18 : Optimised by Richard

Ptn:1 Qty:1 Cycles:1
Board: 1.MED-DEN-FIBRE-18MM/01
Size: 3050.0 x 1525.0

Ptn:2 Qty:1 Cycles:1
Board: 1.MED-DEN-FIBRE-18MM/01
Size: 3050.0 x 1525.0

Ptn:3 Qty:2 Cycles:1
Board: 2.MFC18-ASH/01
Size: 2440.0 x 1220.0

Ptn:4 Qty:1 Cycles:1
Board: 4.MFC18-EBONY/01
Size: 3050.0 x 1220.0

Batch reports
Summaries
Advanced
Patterns
Machining
Custom

Patterns - Alternative materials

Cutting list rules (Information boxes)

Very often later stages of production need extra information about the part to control the production process. For example, information on part labels, bar codes or other data for an edgebander. The part list can be extended with extra custom fields to allow for this. For example we might require the following extra data.

- Part area in M2 to export to a database
- Label saying whether a part is grained or not

- A detailed reference for the part label

Custom fields are added to the part list via the Information box parameters. The result is extra fields in the part list. For example:-

- Part graining
- Part area
- Part code & size

The cutting list rules are set to place the data in the custom fields using the 'Cutting list rules' library (Main screen - Libraries - Cutting list rules)

No	Field	Expression	Condition	Apply
1.	Part graining	Grained	[Grain]=Y OR [Grain]=X	At end
2.	Part graining	Non Grained	[Grain]=N	At end
3.	Volume	LOW	[Quantity]>0.0 AND [Quantity]<=10.0	At end
4.	Volume	MED	[Quantity]>10.0 AND [Quantity]<=100.0	At end
5.	Volume	HIGH	[Quantity]>100.0	At end
6.	Small part	Y	[Length]<=250.0 AND [width]<=200.0	At end
7.	Quantity	0	[Length]<50.0 AND [width]<50.0	At end
8.	Part area m2	=[([Length]*[width])/1000000	[Length]>0.0 AND [width]>0.0	At end
9.	Grain	1	[Part code]:GRN	At end
10.	Edgebander	#CELL[Edgebander,[Material code],[Edge]]	[Edge]:0 OR [Edge]:1	At end
11.	Part code & size ref	=STR(LEFT([Part code],7)+[Finished size])	[Part code]:CLR	At end
12.	Material code	=STR((REPLACE(MEL-FACE-CHIP-TEAK,MEL-FACE-CHIP,MFC18))	[Material code]:MEL-FACE-CHIP	At end
13.				
14.				
15.				
16.				
17.				
18.				
19.				
20.				
21.				
22.				

Cutting list - rules

The data for these fields is calculated before optimising. The results are shown in the 'Cutting list' (this is the adjusted part list used for optimising).

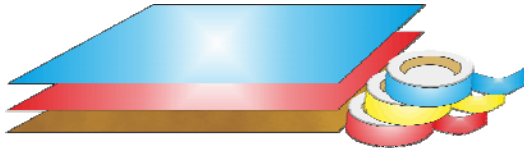


Click on the Cutting list symbol

Cutting list - Cutting list rules										
File Edit View Optimise Help										
Title: Example of cutting list rules Opt: Default Saw: Default										
	Description	Material	Length	Width	Quantity	Grain	Part graining	Part area m2	Part code &...	Inf
Global										
1.	CLR-UNIT-BASE	MEL-CHIP-18MM	585.0	470.0	5	N	Non Grained	0.3	CLR-UNI5...	
2.	CLR-UNIT-DRAWER	MFC18-OAK	870.0	585.0	3	Y	Grained	0.5	CLR-UNI8...	
3.	CLR-UNIT-END	MFC18-OAK	1740.0	585.0	5	Y	Grained	1.0	CLR-UNI1...	
4.	CLR-UNIT-PLINTH	MFC18-OAK	500.0	150.0	4	N	Non Grained	0.1	CLR-UNI5...	
5.	CLR-UNIT-RAIL	MFC18-TEAK	474.0	75.0	5	N	Non Grained	0.0	CLR-UNI4...	
6.	CLR-UNIT-SPACER	MFC18-TEAK	45.0	30.0	0	N	Non Grained	0.0	CLR-UNI4...	
7.	CLR-UNIT-SHELF	MFC18-TEAK	474.0	395.0	8	N	Non Grained	0.2	CLR-UNI4...	
8.	CLR-UNIT-DOOR	MFC18-OAK	570.0	495.0	6	N	Non Grained	0.3	CLR-UNI5...	
9.	CLR-CABINET-PLINTH	MFC18-BEECH	495.0	150.0	5	N	Non Grained	0.1	CLR-CAB4...	
10.	CLR-CABINET-BACK	MFC18-BEECH	474.0	710.0	5	N	Non Grained	0.3	CLR-CAB4...	
11.	CLR-UNIT-BACK	MEL-CHIP-18MM	710.0	574.0	6	N	Non Grained	0.4	CLR-UNI7...	
12.	CLR-UNIT-BACK_GRN	MEL-CHIP-18MM	710.0	574.0	4	Y	Non Grained	0.4	CLR-UNI7...	
13.										

Part list - Information boxes

4. Edges & Laminating

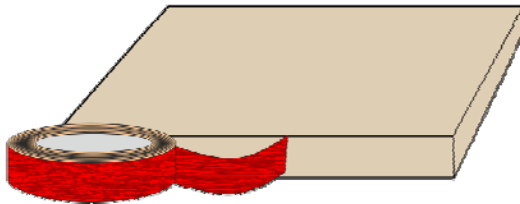


There is a full set of options to deal with edged, trimmed and laminated parts. A wide variety of edging methods are covered:-

- Tape
- Laminate strips
- Solid lipping
- Postform edging
- Bullnose edging
- Laminate front and back
- Core trimming (cutting back before edging)
- Edge before laminating

Edging

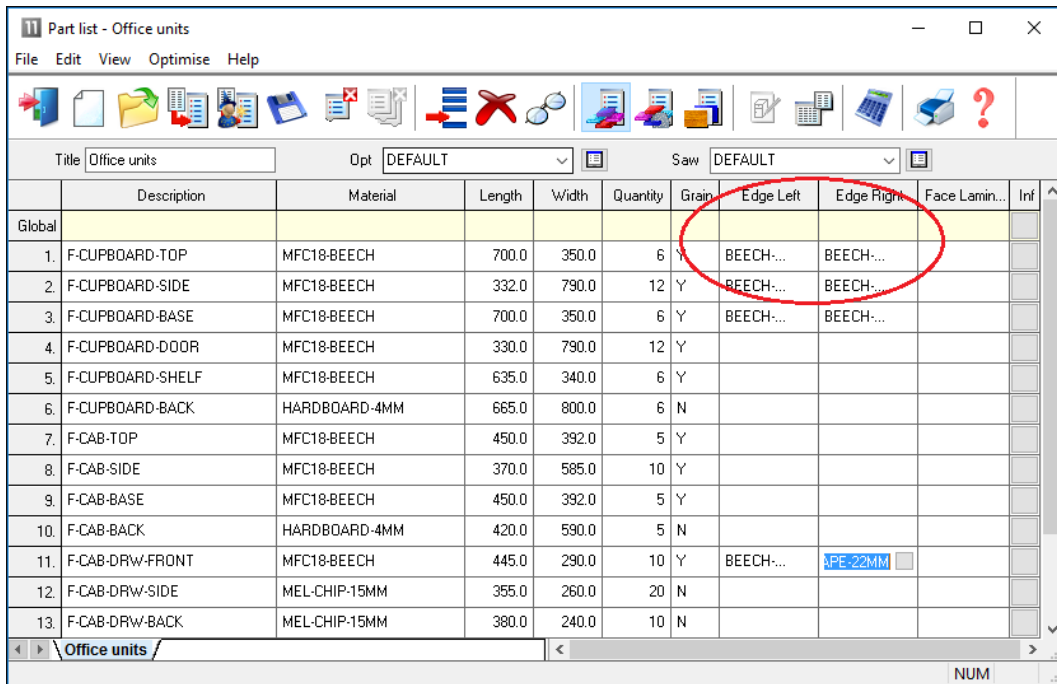
The edging requirement is set at the part list and can be set for each part. The program automatically calculates the correct cutting sizes.



Edging

Sizes are entered (or imported) via the Part list.

These are typically the finished sizes but where there is edging and laminating the finished size has to be adjusted to the cut size before being sent to the saw.



	Description	Material	Length	Width	Quantity	Grain	Edge Left	Edge Right	Face Lamin...	Inf
Global										
1.	F-CUPBOARD-TOP	MFC18-BEECH	700.0	350.0	6	Y	BEECH-...	BEECH-...		
2.	F-CUPBOARD-SIDE	MFC18-BEECH	332.0	790.0	12	Y	BEECH-...	BEECH-...		
3.	F-CUPBOARD-BASE	MFC18-BEECH	700.0	350.0	6	Y	BEECH-...	BEECH-...		
4.	F-CUPBOARD-DOOR	MFC18-BEECH	330.0	790.0	12	Y				
5.	F-CUPBOARD-SHELF	MFC18-BEECH	635.0	340.0	6	Y				
6.	F-CUPBOARD-BACK	HARDBOARD-4MM	665.0	800.0	6	N				
7.	F-CAB-TOP	MFC18-BEECH	450.0	392.0	5	Y				
8.	F-CAB-SIDE	MFC18-BEECH	370.0	585.0	10	Y				
9.	F-CAB-BASE	MFC18-BEECH	450.0	392.0	5	Y				
10.	F-CAB-BACK	HARDBOARD-4MM	420.0	590.0	5	N				
11.	F-CAB-DRW-FRONT	MFC18-BEECH	445.0	290.0	10	Y	BEECH-...	PE-22MM		
12.	F-CAB-DRW-SIDE	MEL-CHIP-15MM	355.0	260.0	20	N				
13.	F-CAB-DRW-BACK	MEL-CHIP-15MM	380.0	240.0	10	N				

Edging - Part list

A set of extra fields (called Information boxes) extend the Part list to allow for the entry of the edging code for each edge of each part. For example, in the above example items such as drawers and doors have edging material on some of the edges.



Click on the cutting list symbol

The correct cutting sizes are produced automatically.

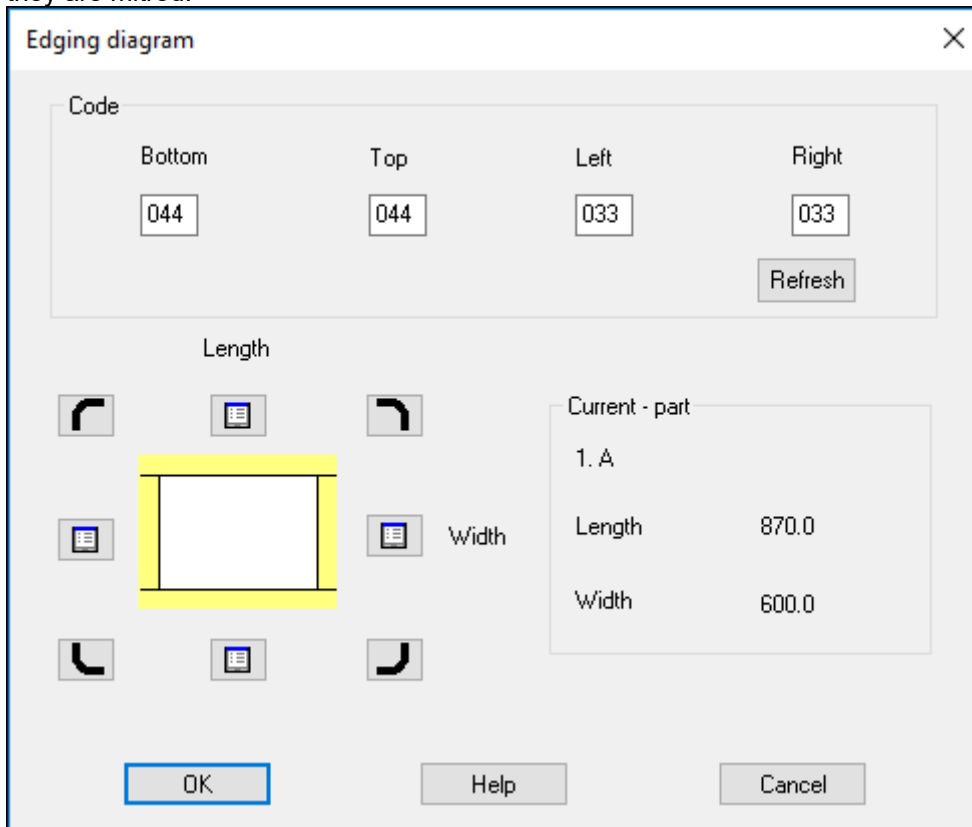
	Description	Material	Length	Width	Quantity	Grain	Edge Left	Edge Right	Face Lamin...	Inf
Global										
1.	F-CUPBOARD-TOP	MFC18-BEECH	698.0	350.0	6	Y	BEECH...	BEECH...		
2.	F-CUPBOARD-SIDE	MFC18-BEECH	330.0	790.0	12	Y	BEECH...	BEECH...		
3.	F-CUPBOARD-BASE	MFC18-BEECH	698.0	350.0	6	Y	BEECH...	BEECH...		
4.	F-CUPBOARD-DOOR	MFC18-BEECH	330.0	790.0	12	Y				
5.	F-CUPBOARD-SHELF	MFC18-BEECH	635.0	340.0	6	Y				
6.	F-CUPBOARD-BACK	HARDBOARD-4MM	665.0	800.0	6	N				
7.	F-CAB-TOP	MFC18-BEECH	450.0	392.0	5	Y				
8.	F-CAB-SIDE	MFC18-BEECH	370.0	585.0	10	Y				
9.	F-CAB-BASE	MFC18-BEECH	450.0	392.0	5	Y				
10.	F-CAB-BACK	HARDBOARD-4MM	420.0	590.0	5	N				
11.	F-CAB-DRW-FRONT	MFC18-BEECH	443.0	290.0	10	Y	BEECH...	BEECH...		
12.	F-CAB-DRW-SIDE	MEL-CHIP-15MM	355.0	260.0	20	N				
13.	F-CAB-DRW-BACK	MEL-CHIP-15MM	380.0	240.0	10	N				

Edging - Cutting list

For example, a finished length of 332.5 mm requires a cutting size of 330.5 mm if the part is edged by (1mm) tape on each length edge.

The part list can include a field for describing the Edge diagram.

This field can be used to set how adjoining edge pieces butt on to each other or whether they are mitred.



Edging diagram

This can be used when printing labels for edging to show on the label (at the Edgebander) exactly how the edging is applied.

Ref: Example 2 Part Code: CAB-DOOR-L	
	Length: 558.0
	Width: 418.0
	Thickness: 18.0
	Total Quantity: 120
	Date: 08/05/2012
Edging details:	
Top: BEECH-TAPE-22MM	
Btm: BEECH-TAPE-22MM	
Left: BEECH-TAPE-22MM	
Right: BEECH-TAPE-22MM	

Edging diagram label

The edging diagram can be included on each part label to show clearly how the edging is produced. This is available with:-

- Printing labels at the Office
- Printing labels at the Saw (Online label PC)
- Printing labels at the Saw (CADmatic saw controller)

For the CADmatic the information is passed to the CADmatic controller on transfer of data to the saw.

- Edging requirements can be printed on a label as a bar code and used for processing at the edgebander after cutting.

Laminating



The part list can also include fields for laminating one or both sides of a part.

Part list - Office units									
File Edit View Optimise Help									
Title Office units Opt DEFAULT Saw DEFAULT									
	Description	Material	Length	Width	Quantity	Grain	Face Laminate	Back Laminate	Inf
Global									
1.	F-CUPBOARD-TOP	MFC18-BEECH	700.0	350.0	6	Y	BEECH-L...	BEECH-L...	
2.	F-CUPBOARD-SIDE	MFC18-BEECH	332.0	790.0	12	Y			
3.	F-CUPBOARD-BASE	MFC18-BEECH	700.0	350.0	6	Y			
4.	F-CUPBOARD-DOOR	MFC18-BEECH	330.0	790.0	12	Y			
5.	F-CUPBOARD-SHELF	MFC18-BEECH	635.0	340.0	6	Y			
6.	F-CUPBOARD-BACK	HARDBOARD-4MM	665.0	800.0	6	N			
7.	F-CAB-TOP	MFC18-BEECH	450.0	392.0	5	Y	BEECH-L...	BEECH-L...	
8.	F-CAB-SIDE	MFC18-BEECH	370.0	585.0	10	Y	BEECH-L...	BEECH-L...	
9.	F-CAB-BASE	MFC18-BEECH	450.0	392.0	5	Y			
10.	F-CAB-BACK	HARDBOARD-4MM	420.0	590.0	5	N			
11.	F-CAB-DRW-FRONT	MFC18-BEECH	445.0	290.0	10	Y			
12.	F-CAB-DRW-SIDE	MEL-CHIP-15MM	355.0	260.0	20	N			
13.	F-CAB-DRW-BACK	MEL-CHIP-15MM	380.0	240.0	10	N			

Laminates - part list

The program automatically adds extra items to the cutting list (cutting requirement) to allow for the laminate pieces required.

The laminate size is adjusted to allow for trimming as required.

Cutting list - Office units									
File Edit View Optimise Help									
Title Office units Opt DEFAULT Saw DEFAULT									
	Description	Material	Length	Width	Quantity	Grain	Face Laminate	Back Laminate	Inf
Global									
1.	F-CUPBOARD-TOP	MFC18-BEECH	698.0	350.0	6	Y	BEECH-L...	BEECH-L...	
2.	L0001	BEECH-LAM	718.0	365.0	6	Y			
3.	L0001	BEECH-LAM	718.0	365.0	6	Y			
4.	F-CUPBOARD-SIDE	MFC18-BEECH	330.0	790.0	12	Y			
5.	F-CUPBOARD-BASE	MFC18-BEECH	698.0	350.0	6	Y			
6.	F-CUPBOARD-DOOR	MFC18-BEECH	330.0	790.0	12	Y			
7.	F-CUPBOARD-SHELF	MFC18-BEECH	635.0	340.0	6	Y			
8.	F-CUPBOARD-BACK	HARDBOARD-4MM	665.0	800.0	6	N			
9.	F-CAB-TOP	MFC18-BEECH	450.0	392.0	5	Y	BEECH-L...	BEECH-L...	
10.	L0007	BEECH-LAM	470.0	407.0	5	Y			
11.	L0007	BEECH-LAM	470.0	407.0	5	Y			
12.	F-CAB-SIDE	MFC18-BEECH	370.0	585.0	10	Y	BEECH-L...	BEECH-L...	
13.	L0008	BEECH-LAM	390.0	600.0	10	Y			
14.	L0008	BEECH-LAM	390.0	600.0	10	Y			

Office units / NUM

Laminates - cutting list

Edging summary and costs

The edging summary gives full details of the edging requirements including the costs.

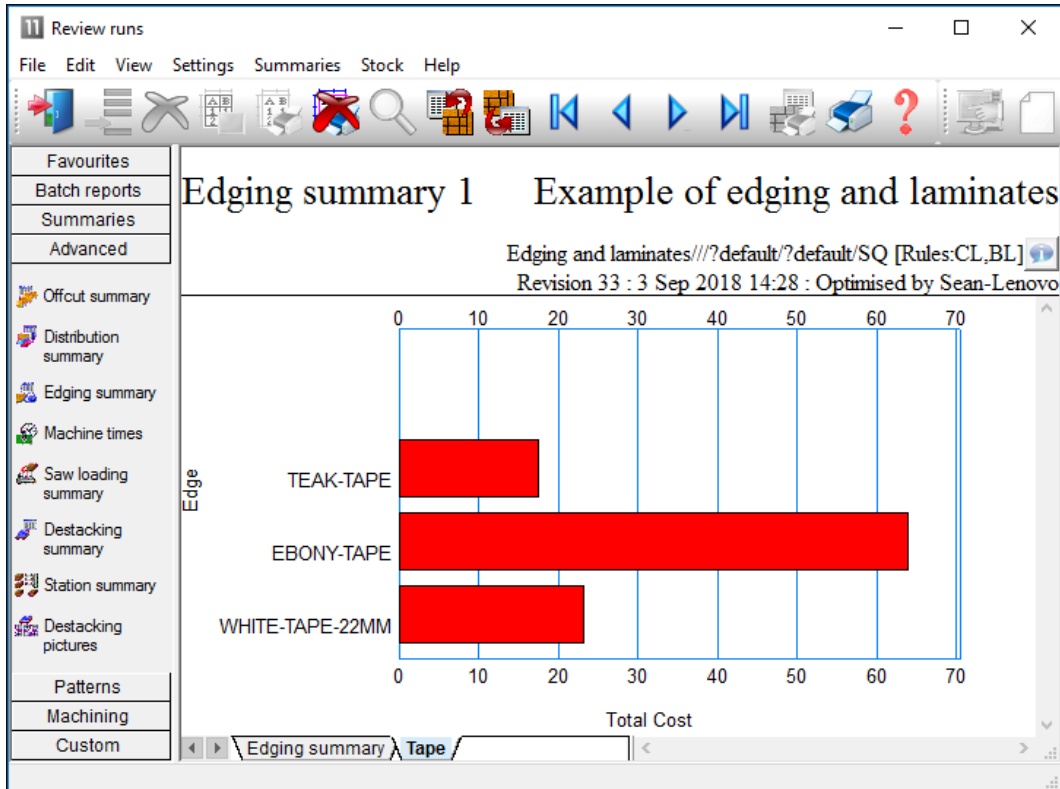
The screenshot shows a software window titled 'Review runs' with a menu bar (File, Edit, View, Settings, Summaries, Stock, Help) and a toolbar. The main area displays an 'Edging summary' report for 'Example of edging and laminates'. The report title is 'Edging and laminates///?default/?default/SQ [Rules:CL,BL]' with a revision of 'Revision 33 : 3 Sep 2018 14:28 : Optimised by Sean-Lenovo'. The report contains a table with the following data:

Code	Description	Material	Thickness	Cost	Total	Total
				m	m	Cost
WHITE-TAPE-22MM	White PVC Tape 22mm		1.0	0.550	42.36	23.30
TEAK-TAPE	Teak PVC Tape 22mm		1.0	0.840	21.00	17.64
EBONY-TAPE	Ebony PVC Tape 22mm		1.0	0.840	76.20	64.01
Total						104.95

The left sidebar contains a list of summary options: Favourites, Batch reports, Summaries, Advanced, Offcut summary, Distribution summary, Edging summary (selected), Machine times, Saw loading summary, Destacking summary, Station summary, Destacking pictures, Patterns, Machining, and Custom. The status bar at the bottom shows the current report is 'Edging summary'.

Edging summary

The Edging summary can include a custom graphic representation of the data.



Edging summary - chart

The printed part costing report includes the cost of edging material and the edgebander costs.

Part costing - full						Edging example		
No	Code / Description	Material / Description	Length	Width	Quantity	Part costing - full		
						Time Use	Rate	Cost
1.	CVR/TP Edge Btm: BEECH-TAPE-22MM Edge Top: BEECH-TAPE-22MM Edge Left: BEECH-TAPE-22MM Finished size: 920.0 x 420.0 Part graining: Grained Volume: LOW Part area m2: 0.4 Edgebander: N/A	MFC18-BEECH	920.0	420.0	1			
	CVR/TP	MFC18-BEECH	919.0	418.0	0.384		3.649	1.402
	BEECH-TAPE-22MM	Beech PVC Tape 22mm			2.320		0.720	1.670
	Saw				0:50	0.014	50.000	0.697
	Edgebander				1:20	0.022	30.000	0.663

					Total cost :			4.432
2.	PRT/END Edge Top: BEECH-TAPE-22MM Edge Left: BEECH-TAPE-22MM Finished size: 750.0 x 420.0 Part graining: Grained Volume: LOW Part area m2: 0.3 Edgebander: N/A	MFC18-BEECH	750.0	420.0	2			
	PRT/END	MFC18-BEECH	750.0	419.0	0.314		3.649	1.147
	BEECH-TAPE-22MM	Beech PVC Tape 22mm			0.770		0.720	0.554
	Saw				0:44	0.012	50.000	0.607
	Edgebander				0:26	0.007	30.000	0.217

					Total cost :			2.526
3.	PRT/TOP Edge Btm: BEECH-TAPE-22MM Edge Top: BEECH-TAPE-22MM Edge Left: BEECH-TAPE-22MM Finished size: 690.0 x 420.0 Part graining: Grained Volume: LOW Part area m2: 0.3 Edgebander: N/A	MFC18-BEECH	690.0	420.0	2			
	PRT/TOP	MFC18-BEECH	689.0	418.0	0.288		3.649	1.051
	BEECH-TAPE-22MM	Beech PVC Tape 22mm			1.860		0.720	1.350
	Saw				0:41	0.011	50.000	0.505
	Edgebander				1:12	0.020	30.000	0.600

					Total cost :			3.506

Edging - part costing

The operational details and costs of each Edgebander are set up in the Edging parameters and the Machining rate parameters. These include options such as:-

- Overlap for edging
- Gap between parts
- Edgebander speed
- Double sided or not
- ...



Edging library

The details of the edging materials and operations are set up in the Edging library. This can be customised to match many different edging methods, for example, whether edging is applied before laminating, whether a core trim is taken, the type of edging ...

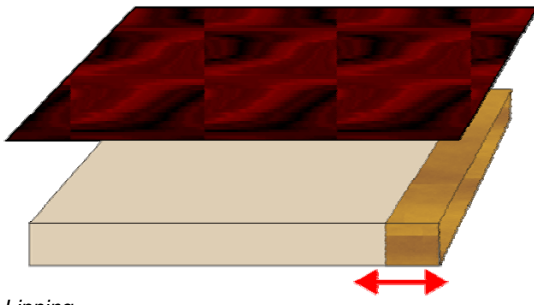
Code	Description	Material	Grain	Fu...	Thick...	Core...	Cost	Edge first ^
▶ ASH-TAPE-22MM	Ash PVC Tape 22mm		N	1	1.5	0.0	0.750	N
BEECH-LAM	Beech Laminate		Y	3	1.0	0.0	1.450	N
BEECH-TAPE-22MM	Beech PVC Tape 22mm		N	1	1.0	0.0	0.720	N
BULLNOSE	Bull nosed edge		N	5	0.0	0.0	0.000	N
CORE-TRIM	Oversize cutting		N	0	0.0	20.0	0.000	N
EBONY-LAM	Ebony Laminate	EBONY-LAM-1MM	Y	3	1.0	0.0	1.450	N
EBONY-TAPE	Ebony PVC Tape 22mm		N	1	1.0	0.0	0.840	N
GREEN-TAPE-22MM	Green PVC Tape 22mm		N	1	1.0	12.0	0.550	N
LBROWN-TAPE	Light Brown Tape		N	1	1.0	0.0	0.730	N
MAHOGANY-LIP	Solid Mahogany lip		N	2	25.0	10.0	1.950	N
OAK-LAM	Oak Laminate	OAK-LAM-1MM	Y	3	1.0	0.0	1.360	N
OAK-TAPE-22MM	Oak PVC Tape 22mm		N	1	1.0	0.0	0.840	N
POSTFORM	Postformed edge		N	4	0.0	0.0	0.000	N
RED-TAPE-22MM	Red PVC Tape 22mm		N	1	1.0	0.0	0.750	N
TEAK-LAM	Teak Laminate	TEAK-LAM-1MM	Y	3	1.0	0.0	1.400	N
TEAK-TAPE	Teak PVC Tape 22mm		N	1	1.0	0.0	0.840	N
WHITE-TAPE-22MM	White PVC Tape 22mm		N	1	1.0	0.0	0.550	N
*								

Edging library

For example, where a core trim is specified, this indicates that the core material is trimmed first before edging is applied. This is quite common, for instance with doors, where solid wood edges are often applied before laminating.

- Where there are a large number of different laminates for example with laminate colours the Board library can be used instead of the edging library for describing the laminates - this is often more convenient for sheet laminates.

The core trim, for example, allows for the removal of core material ready for solid wood lipping.



Lipping

The laminate size is automatically adjusted to take account of the lipping.



Edging parameters

The tolerances and settings for applying edging and laminates are set via the Edging parameters (*Main screen - Parameters - Edging*).

Edging parameters
✕

Laminate Edging
Help view >>

Set the parameters for laminate use

Range
 0 - 999
 Millimetres

Overlap for laminates
 On laminate length (total)

On laminate width (total)

Core oversize for laminating
 On core length (per edge)

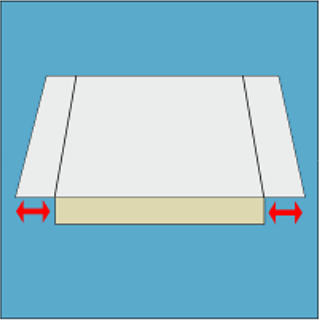
On core width (per edge)

Add to laminate size

Laminate overlap per edge
 On bull nosed edges

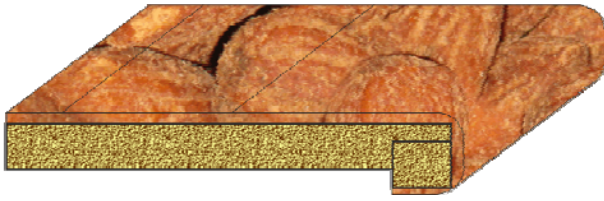
On post formed edges

Overlap for laminates: On laminate length (total)



Edging parameters

This includes the details for more complex edges such as Post form and bullnose edges.



5. Parts & Labels

The software provides a database for parts and used with the form and label designer provides extensive facilities for managing extra data for parts.

It is especially useful where the same parts are used again and again in different cutting lists or where extra information is needed for each part for later processing, admin, or bar codes,

Parts can be added to any cutting list with minimum data entry - this saves times and avoids costly mistakes.

Part library

Parts are defined and stored in the part library. The data entry screen provides an easy way to enter part details. At the main screen:-

- Select: **Libraries - Part library**

or



Select the toolbar option

The part library data entry screen is shown.

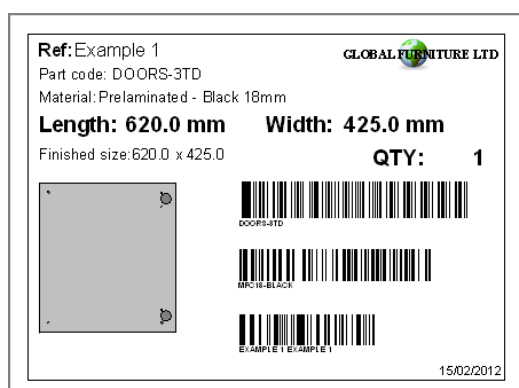
Edge Btm	@EDGING@	<input type="checkbox"/>
Edge Top	@EDGING@	<input type="checkbox"/>
Edge Left	@EDGING@	<input type="checkbox"/>
Edge Right	@EDGING@	<input type="checkbox"/>
Face Laminate		<input type="checkbox"/>
Back Laminate		<input type="checkbox"/>
Edge Diagram		
Finished size		
Drawing name		
Step angle		
Priority		
Mirrored		
Small part		
Alternative material(s)		<input type="checkbox"/>
Part graining		
Volume		
Template - Router		
Part area m2		
Edgebander		

Part library

The part details include the standard items such as material code, length and width but any amount of user defined information can be stored with each part using extra fields (information boxes). This extra data can also be included on labels and reports to help with later processing of the part.

The part library can also include a picture of the part from the Machining library or a graphics file such as BMP, JPG or MPR(X).

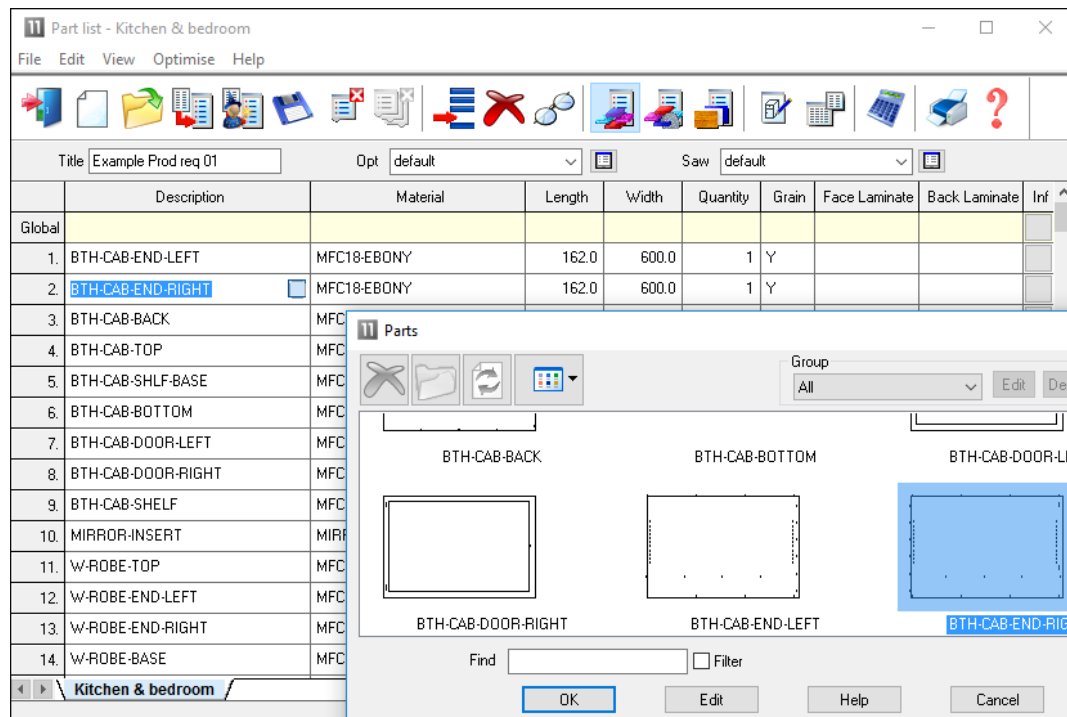
For some parts it is often useful to include a picture of the part on a label to help identify the part quickly.



Part label

At any cutting list the items in the library can be accessed by a single click and the part can be added to the list.

Typically only one or two items of information need to be adjusted such as the quantity required or possibly the material to use.



Cutting list - part library

Form & Label designer

The program includes a designer screen so that almost any style of label (typically a small adhesive label) or a full form (a one page report or a route card) can be set up.

Printing labels at the office and at the saw

These are typically labels or forms for printing in the Office but can also be used with the Online PC module for printing labels at the saw. The designer can also create label designs that can be used/downloaded to the CADmatic saw controller (For the CADmatic the information is passed to the CADmatic controller on transfer of data to the saw).

For other saw controllers the options available for designing and printing labels at the saw depend on the software and capabilities of each controller. The full part list data including any custom information is available in the files sent to the saw but the design must be undertaken via the saw controller.

The data on the form or label can be chosen from any of the data set up for each part in the Part database. For example:-

Material code

Length

Width

...

Part drawing

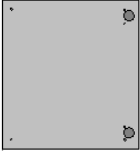

User defined details

Barcodes

Logos

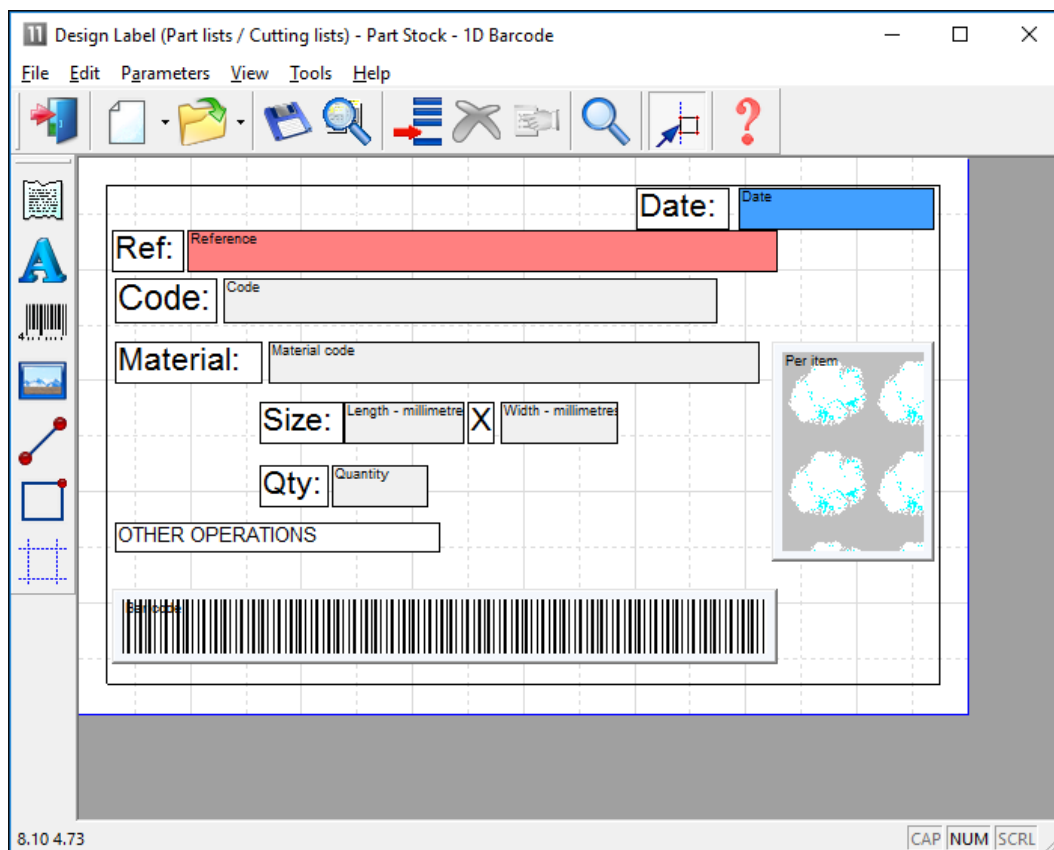
...

The designer allows for the creation of a barcode for any of the items on the form or label, for example, barcodes for the part code and quantity.

Ref: Example 1	GLOBAL FURNITURE LTD
Part code: DOORS-3TD	
Material: Prelaminated - Black 18mm	
Length: 620.0 mm	Width: 425.0 mm
Finished size: 620.0 x 425.0	QTY: 1
	
	
	
	15/02/2012

Part label

The designer screen is easy to use and a variety of templates are already set up to use as a starting point.



Label designer

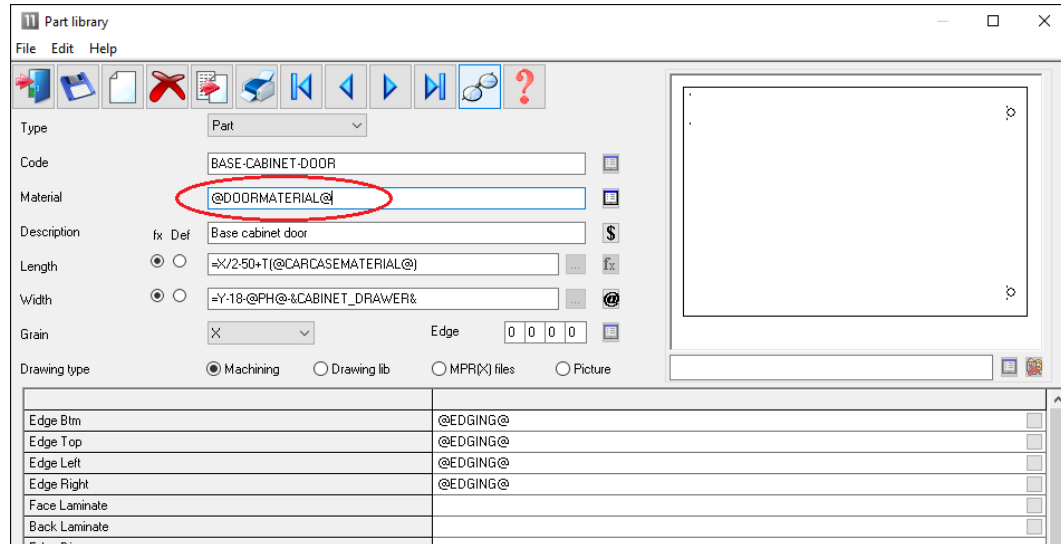
Each label or form is fully customisable. The designers include several options to help create effective designs.

- Grid, guidelines and snap options - to help place items on the design
- Different templates - with alternative designs and styles
- Quick preview - to check the layout
- Data preview - to make an accurate check of the layout

Parts & Labels with Products & Quotes (PQ) module

When used with the PQ module the Part library extends the flexibility of the program since it can be used to define parts using variables and formulae for the part information.

The same part entry in the part library can be used for a range of colours, materials or sizes.



Part library and PQ module

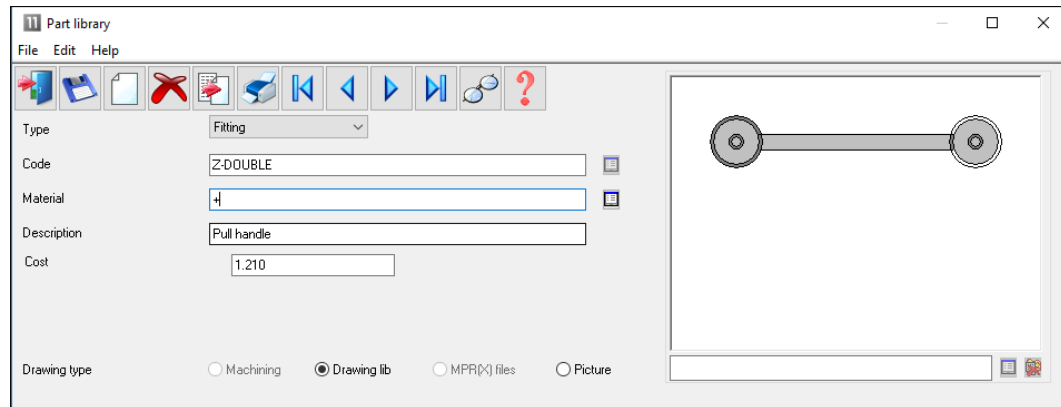
In this example the Material is defined by a variable '@DOORMATERIAL@' and the Length and Width are defined by formulae. This single part library entry can produce the correct specification for a range of cabinet doors in different materials, colours and sizes.

Fittings, Sundry parts, Operations

Requires the PQ module

The parts database can also include fittings (hardware).

Fittings can include typical ironmongery items such handles, hinges and brackets and also larger 'bought in' appliances.



Part library - Fittings

The library can also include 'bought in' or sundry parts that are required but are ready to use.

The screenshot shows the 'Part library' software interface. It features a menu bar with 'File', 'Edit', and 'Help'. Below the menu is a toolbar with icons for file operations and navigation. The main form includes the following fields and options:

- Type:** A dropdown menu set to 'Part'.
- Code:** A text field containing 'ALM-32P'.
- Material:** A text field containing 'ALUMINIUM'.
- Description:** A text field containing 'Aluminium plinth', with 'fx' and 'Def' labels to its left.
- Length:** A text field containing '1340.0', with two radio buttons to its left and a 'fx' icon to its right.
- Width:** A text field containing '168', with two radio buttons to its left and an '@' icon to its right.
- Grain:** A dropdown menu set to 'Variable'.
- Edge:** Four input fields, each containing the number '0'.
- Drawing type:** Four radio buttons labeled 'Machining' (selected), 'Drawing lib', 'MPR(X) files', and 'Picture'.

At the bottom of the form is a table with the following rows:

Edge Btm	
Edge Top	
Edge Left	

Part library - sundry parts

The operations required for each part can also be included in the database.

These are items such as, clamping, assembly, packing - where these can be allocated on a 'per part' basis.

The screenshot shows a software window titled "Part library" with a menu bar (File, Edit, Help) and a toolbar containing icons for file operations and navigation. The main area contains the following fields and options:

- Type: Operation (dropdown menu)
- Code: Y-ASSEMBLY
- Material: -OP
- Description: Cabinet Assembly
- Cost: 6.500

At the bottom, the "Drawing type" section includes four radio button options: Machining, Drawing lib (selected), MPR(X) files, and Picture.

Part library - operations

These items are added to the 'Order' so that a full specification (and costing) of the job is available.

Quotes / orders - Products & parts order

File Edit Options Help

Order: Products & parts order | Order date: 28/05/2012 | Customer code: CS1001 | Customer name: Kitchens Direct | Delivery date: 11/06/2012

Contact: John Smith | Terms: 30 Days | Status: Estimated

Invoice address: Ashford Road, Birmingham | Delivery address: Unit 7, Canal Road, Birmingham

Postcode: B11 2RX | Postcode: B12 4JU

Notes: Credit OK, No Sat Deliveries

Single base unit

Optimising: DEFAULT | Over: 0

No	Code	Information	Product			Part					Qty	Unit price	Total price
			Width	Height	Depth	Material	Length	Width	Grain	Edge			
1	BASE-SINGLE	Single base unit	500.0	870.0	600.0						7	40.00	280.00
2	BASE-SINK	Sink base unit	1000.0	870.0	600.0						2	40.56	81.12
3	WALL-DOUBLE	Double wall unit	1000.0	750.0	300.0						5	34.48	172.40
4	WALL-SINGLE	Single wall unit	500.0	750.0	300.0						3	21.12	63.36
Deliver separately													
5	F-UNIT-DOOR	Fixed size unit door				MFC18...	495.0	570.0	Y	0000	4	3.61	14.44
6	F-UNIT-END-LEFT	Fixed size unit end left				MEL-CH...	585.0	870.0	N	0000	4	4.06	16.24
7	F-UNIT-END-RIGHT	Fixed size unit end right				MEL-CH...	585.0	870.0	N	0000	4	4.06	16.24
8	Z-SINGLE	Single Knob									23	0.95	21.85
9	Y-PACKING	Packing									14	6.00	84.00
10													
11													
12													
13													
14													
15													
16													

Quote / order

Parts & Labels with the Machining Interface

The Part library is fully integrated with the Machining Interface; the part picture can be a machining drawing from the parametric Machining library. So any pictures and details created in the machining library can be passed through to the part label or form.

The part library can also be integrated with:-

- External bitmap (BMP, JPG) drawing
- WoodWop MPR(X) drawings

Parts & Labels with the Online PC option

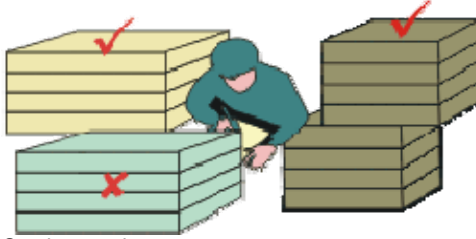
The Online PC option can be used for designing and printing labels at the saw, it is typically used where there is no saw controller or the saw controller only has limited set of options.

Information and labels are automatically sent to the Online PC option to allow the viewing and printing of part information at the Saw.

Printing labels at the saw

Many saw controllers only have limited options for designing and printing labels at the saw so they are not always suitable for detailed labels or for making use of custom label information.

6. Stock Control (SC)



Stock control

A complete stock system for sheet materials - it can also be integrated with external systems such as the Homag Automation SQL server stock management system.

Offcuts generated in one optimisation can be sent back to the board library for use in later runs with customised cost adjustment.

The exact amount of stock can be reserved for future jobs.

The simplest operation is to control the physical stock in the Board library.

- *Optimise run (or batch of runs)*
- *Issue stock for runs*

The sheets required for cutting are removed from the library and any offcuts generated by the run are entered as new items in the library.

Control physical stock

The board inventory is shown in the Board library.

Board library																
File Edit View Help																
Clear Filter																
Materials																
Material	Description	Thickness	Default grain	Book	Material parameters	Picture	Type	Density								
GREEN GLOSS 18MM	Gloss finish - Green 18mm	18.0	N	0			Gloss finish	0.400								
HARDBOARD-4MM	Hardboard 4mm	4.0	N	8	HBD04			0.750								
HARDBOARD-WHITE-4MM	Hardboard 4mm - White	4.0	N	8	HBD04			0.750								
IVORY GLOSS 18MM	Gloss finish - Ivory 18mm	18.0	N	0			Gloss finish	0.400								
MAPLE MDF 18MM	Medium Density Fibreboard - Maple 18mm	18.0	Y	0			MDF	0.650								
MED-DEN-FIBRE-18MM	Medium Density Fibreboard 18mm	18.0	N	0			MDF	0.650								
MED-DEN-FIBRE-25MM	Medium Density Fibreboard 25mm	25.0	N	0			MDF	0.650								
Boards for material: IVORY GLOSS 18MM Gloss finish - Ivory 18mm Thickness:18.0 Book:0																
Board code	Type	Length	Width	Informati	Stock	Res	Order	Cost	Limit	Bin	Supplier	Min Stk	ReOrd	Grain	Parameters	Method
IVORY GLOSS 18MM/0		2440.0	1220.0		52	0	0	5,250	0	225		20	30	N		Area
XIVORY GLOSS 18M...	A	2440.0	664.0		1	0	0	2,700	0			0		N		Area
XIVORY GLOSS 18M...	X	538.0	349.5		1	0	0	2,700	0			0		N		Area
XIVORY GLOSS 18M...	X	664.0	200.7		1	0	0	2,700	0			0		N		Area
NUM																

Stock control - Board library

This includes offcuts generated from earlier jobs (labelled with X ...)

Board library																
Materials																
Material	Description	Thickness	Default grain	Book	Material parameters	Picture	Type	Density								
GREEN GLOSS 18MM	Gloss finish - Green 18mm	18.0	N	0			Gloss finish	0.400								
HARDBOARD-4MM	Hardboard 4mm	4.0	N	8	HBD04			0.750								
HARDBOARD-WHITE-4MM	Hardboard 4mm - White	4.0	N	8	HBD04			0.750								
IVORY GLOSS 18MM	Gloss finish - Ivory 18mm	18.0	N	0			Gloss finish	0.400								
MAPLE MDF 18MM	Medium Density Fibreboard - Maple 18mm	18.0	Y	0			MDF	0.650								
MED-DEN-FIBRE-18MM	Medium Density Fibreboard 18mm	18.0	N	0			MDF	0.650								
MED-DEN-FIBRE-25MM	Medium Density Fibreboard 25mm	25.0	N	0			MDF	0.650								

Boards for material: IVORY GLOSS 18MM Gloss finish - Ivory 18mm Thickness:18.0 Book:0																
Board code	Type	Length	Width	Informati	Stock	Res	Order	Cost	Limit	Bin	Supplier	Min Stk	ReOrd	Grain	Parameters	Method
IVORY GLOSS 18MM		2440.0	1220.0		52	0	0	5,250	0	225		20	30	N		Area
XIVORY GLOSS 18MM	X	2440.0	664.0		1	0	0	2,700	0			0		N		Area
XIVORY GLOSS 18MM	X	538.0	349.5		1	0	0	2,700	0			0		N		Area
XIVORY GLOSS 18MM	X	664.0	200.7		1	0	0	2,700	0			0		N		Area

Stock control - Offcuts

The quantity of boards required for any job is calculated by the optimization.

Review runs [File Edit View Settings Summaries Stock Help]

Pattern preview **Bedroom & bathroom**

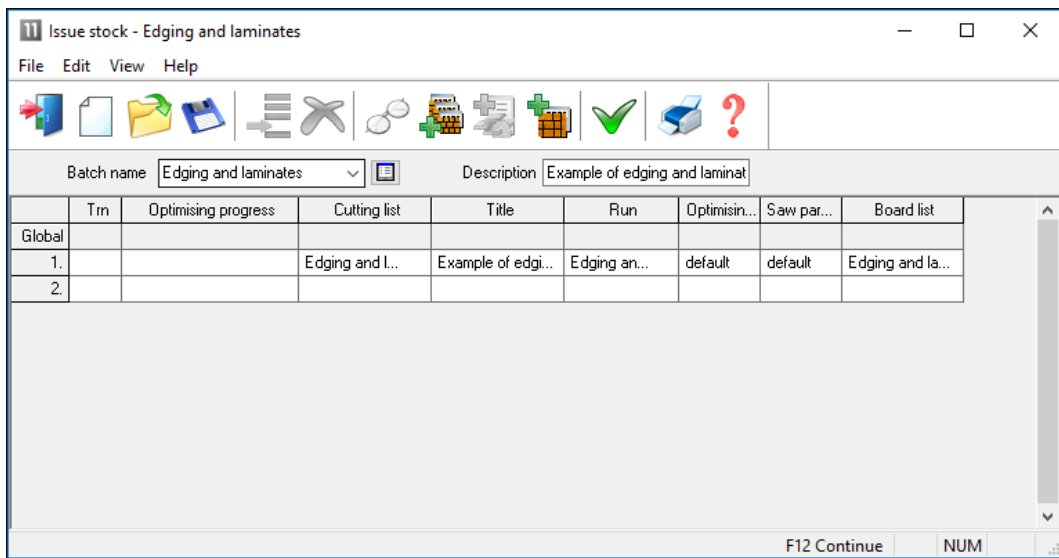
Bedroom & bathroom:///default/?default?? [Rules:BL]
Revision 2 : 27 Sep 2018 08:54 : Optimised by Richard

<p>Ptn:1 Qty:5 Cycles:1 Board: 1.MFC18-OAK/01 Size: 3050.0 x 1220.0</p>	<p>Ptn:2 Qty:3 Cycles:1 Board: 1.MFC18-OAK/01 Size: 3050.0 x 1220.0</p>
<p>Ptn:3 Qty:1 Cycles:1 Board: 1.MFC18-OAK/01 Size: 3050.0 x 1220.0</p>	<p>Ptn:4 Qty:5 Cycles:1 Board: 2.MFC18-OAK/02 Size: 2440.0 x 1220.0</p>

Batch reports
Summaries
Advanced
Patterns
Machining
Custom

Stock control - optimising

Once the run is committed for cutting (data sent to saw) the stock can be updated by the 'Issue stock for runs' options.



Issue stock for runs

The Board library is updated.

The board quantities are reduced and any offcuts are added back to the library.

The screenshot shows the 'Board library' application window. The top menu includes 'File', 'Edit', 'View', and 'Help'. Below the menu is a toolbar with various icons for file operations and a 'Clear Filter' button. The main area is divided into two sections:

Materials

Material	Description	Thickness	Default grain	Book	Material parameters	Picture	Type	Density
GREEN GLOSS 18MM	Gloss finish - Green 18mm	18.0	N	0			Gloss finish	0.400
HARDBOARD-4MM	Hardboard 4mm	4.0	N	8	HBD04			0.750
HARDBOARD-WHITE 4MM	Hardboard 4mm - White	4.0	N	8	HBD04			0.750
IVORY GLOSS 18MM	Gloss finish - Ivory 18mm	18.0	N	0			Gloss finish	0.400
MAPLE MDF 18MM	Medium Density Fibreboard - Maple 18mm	18.0	Y	0			MDF	0.650
MED-DEN-FIBRE-18MM	Medium Density Fibreboard 18mm	18.0	N	0			MDF	0.650
MED-DEN-FIBRE-25MM	Medium Density Fibreboard 25mm	25.0	N	0			MDF	0.650

Boards for material: IVORY GLOSS 18MM Gloss finish - Ivory 18mm Thickness:18.0 Book:0

Board code	Type	Length	Width	Informal	Stock	Res	Order	Cost	Limit	Bin	Supplier	Min Stk	ReOrd	Grain	Parameters	Method
IVORY GLOSS 18MM		2440.0	1220.0		52	0	0	5,250.0	0	225		20	30	N		Area
XIVORY GLOSS 18M...	A	2440.0	664.0		1	0	0	2,700.0	0			0		N		Area
XIVORY GLOSS 18M...	X	538.0	349.5		1	0	0	2,700.0	0			0		N		Area
XIVORY GLOSS 18M...	X	664.0	200.7		1	0	0	2,700.0	0			0		N		Area

NUM

Board library update

The program carefully controls the operation of part lists and optimising - once a run has been used for a stock issue it cannot be manually changed or re-optimised

Stock reservation and receipts

The module includes a full set of options for the reservation and receipt of stock. Reservation can be used after optimising to reserve stock for the job. Receipts are used to record incoming stock and adjust stock levels.

The Board library includes fields for Stock on order and Reserved stock and the optimiser takes account of the reserved stock when optimising so that reserved stock is not used.

Board library

File Edit View Help

Clear Filter

Material	Description	Thickness	Default grain	Book	Material parameters	Picture	Type	Density
GREEN GLOSS 18MM	Gloss finish - Green 18mm	18.0	N	0			Gloss finish	0.400
HARDBOARD-4MM	Hardboard 4mm	4.0	N	8	HBD04			0.750
HARDBOARD-WHITE-4MM	Hardboard 4mm - White	4.0	N	8	HBD04			0.750
IVORY GLOSS 18MM	Gloss finish - Ivory 18mm	18.0	N	0			Gloss finish	0.400
MAPLE MDF 18MM	Medium Density Fibreboard - Maple 18mm	18.0	Y	0			MDF	0.650
MED-DEN-FIBRE-18MM	Medium Density Fibreboard 18mm	18.0	N	0			MDF	0.650
MED-DEN-FIBRE-25MM	Medium Density Fibreboard 25mm	25.0	N	0			MDF	0.650

Boards for material: IVORY GLOSS 18MM Gloss finish - Ivory 18mm Thickness:18.0 Book:0

Board code	Type	Length	Width	Inform	Stock	Res	Order	Cost	Limit	Bin	Supplier	Min Stk	ReOrd	Grain	Parameters	Method
IVORY GLOSS 18MM		2440.0	1220.0		52	0	0	250	0	225		20	30	N		Area
XIVORY GLOSS 18M...	A	2440.0	664.0		1	0	0	2700	0			0		N		Area
XIVORY GLOSS 18M...	X	538.0	349.5		1	0	0	2700	0			0		N		Area
XIVORY GLOSS 18M...	X	664.0	200.7		1	0	0	2700	0			0		N		Area

NUM

Board library - stock levels

Stock can be reserved by 'Stock reservation' (*Stock - Reserve stock*)

Reserve stock - Edging and laminates

File Edit View Help

Batch name: Edging and laminates Description: Example of edging and laminat

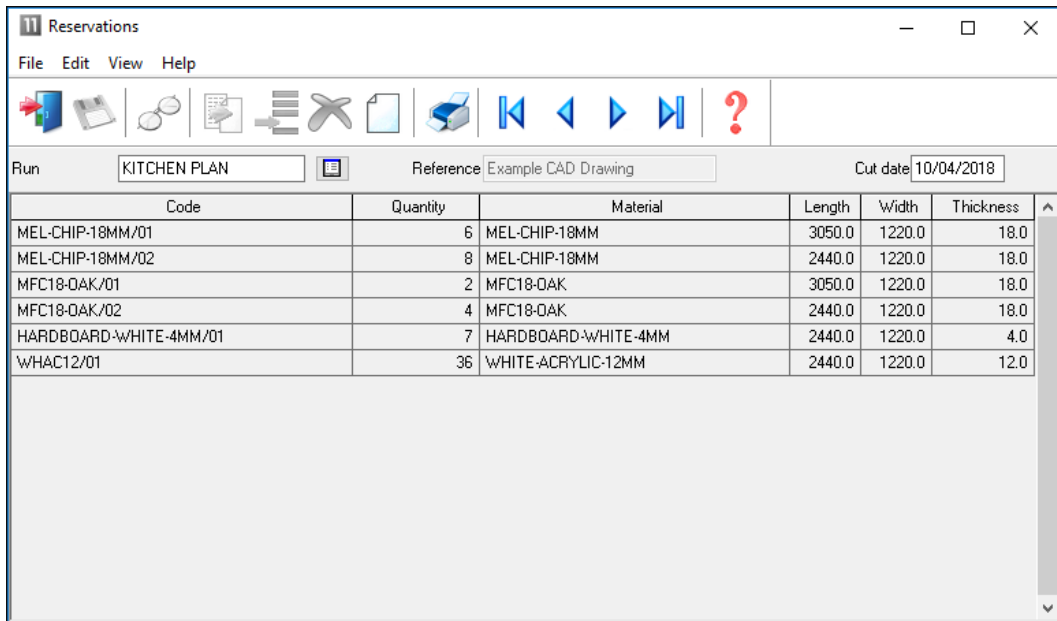
	Trn	Optimising progress	Cutting list	Title	Run	Optimisin...	Saw par...	Board list
Global								
1.			Edging and l...	Example of edgi...	Edging an...	default	default	Edging and la...
2.								

F12 Continue NUM

Reserve stock

The stock for a selected run is reserved.

The details of all the current reservations can be review via: *'Stock Reservations'*



The screenshot shows a software window titled 'Reservations' with a menu bar (File, Edit, View, Help) and a toolbar with various icons. Below the toolbar, there are input fields for 'Run' (containing 'KITCHEN PLAN'), 'Reference' (containing 'Example CAD Drawing'), and 'Cut date' (containing '10/04/2018'). The main area of the window contains a table with the following data:

Code	Quantity	Material	Length	Width	Thickness
MEL-CHIP-18MM/01	6	MEL-CHIP-18MM	3050.0	1220.0	18.0
MEL-CHIP-18MM/02	8	MEL-CHIP-18MM	2440.0	1220.0	18.0
MFC18-OAK/01	2	MFC18-OAK	3050.0	1220.0	18.0
MFC18-OAK/02	4	MFC18-OAK	2440.0	1220.0	18.0
HARDBOARD-WHITE-4MM/01	7	HARDBOARD-WHITE-4MM	2440.0	1220.0	4.0
WHAC12/01	36	WHITE-ACRYLIC-12MM	2440.0	1220.0	12.0

View stock reservations

There is also a full set of screens and options for ordering and receiving stock.

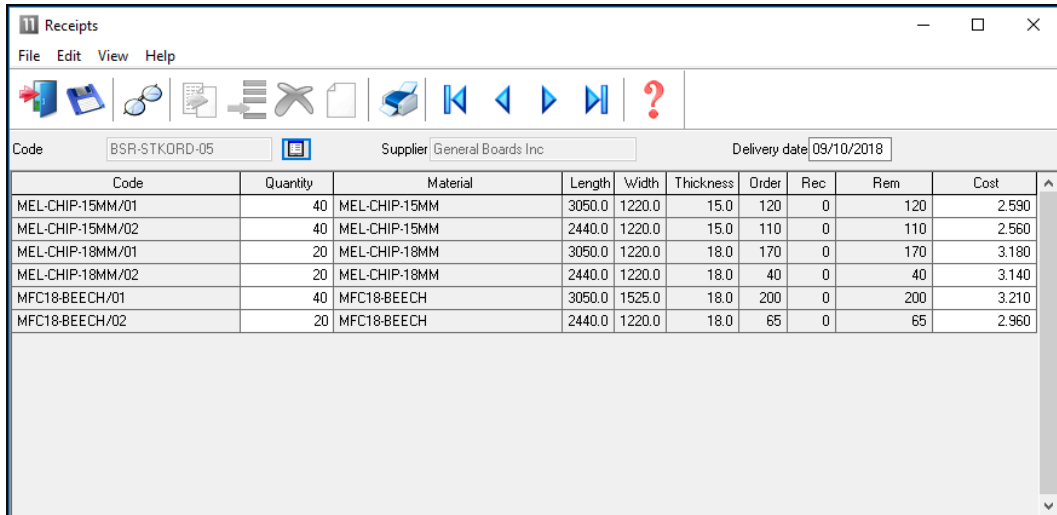
Stock is ordered via the Order screen:-

The screenshot shows a software window titled 'Orders' with a menu bar (File, Edit, View, Help) and a toolbar with various icons. Below the toolbar, there are input fields for 'Code' (BSR-STKORD-05), 'Supplier' (General Boards Inc), and 'Delivery date' (09/10/2018). The main area contains a table with the following data:

Code	Quantity	Material	Length	Width	Thickness	Order	Rec	Rem
MEL-CHIP-15MM/01	120	MEL-CHIP-15MM	3050.0	1220.0	15.0	120	0	120
MEL-CHIP-15MM/02	110	MEL-CHIP-15MM	2440.0	1220.0	15.0	110	0	110
MEL-CHIP-18MM/01	170	MEL-CHIP-18MM	3050.0	1220.0	18.0	170	0	170
MEL-CHIP-18MM/02	40	MEL-CHIP-18MM	2440.0	1220.0	18.0	40	0	40
MFC18-BEECH/01	200	MFC18-BEECH	3050.0	1525.0	18.0	200	0	200
MFC18-BEECH/02	65	MFC18-BEECH	2440.0	1220.0	18.0	65	0	65

Stock orders

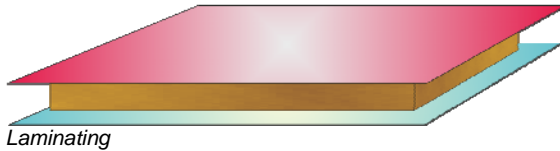
Stock receipts are recorded in the Receipts screen.



Code	Quantity	Material	Length	Width	Thickness	Order	Rec	Rem	Cost
MEL-CHIP-15MM/01	40	MEL-CHIP-15MM	3050.0	1220.0	15.0	120	0	120	2.590
MEL-CHIP-15MM/02	40	MEL-CHIP-15MM	2440.0	1220.0	15.0	110	0	110	2.560
MEL-CHIP-18MM/01	20	MEL-CHIP-18MM	3050.0	1220.0	18.0	170	0	170	3.180
MEL-CHIP-18MM/02	20	MEL-CHIP-18MM	2440.0	1220.0	18.0	40	0	40	3.140
MFC18-BEECH/01	40	MFC18-BEECH	3050.0	1525.0	18.0	200	0	200	3.210
MFC18-BEECH/02	20	MFC18-BEECH	2440.0	1220.0	18.0	65	0	65	2.960

Stock receipts

Pre-laminated material - where boards are laminated prior to cutting the stock update automatically keeps track of both core material and laminate material used.



Laminates and core material are stored in the Board library.

Stock reports

A range of reports are available for monitoring the stock process.

- Orders by material
- Orders by supplier
- Reservations by material
- Stock valuation
- Minimum free stock
- Monthly material summary
- Stock issues summary
- Audit trail report
- Stock history
- End of month/year

Each report can be viewed on screen and printed.

Orders by Material

Board	Length mm	Width mm	Stock	Order	Date	Order Qty	Area m2	Cost / m2	Order Cost
<u>BLUE GLOSS 18MM Gloss finish - Blue 18mm Thickness 18.0 Grain N Book 0</u>									
BLUE GLOSS 18MM/01	2440.0	1220.0	152	MCS-STKORD-01	01/09/15	40	119.07	0.000	212.80
						40	119.07		212.80
<u>CHERRY GLOSS 18MM Gloss finish - Cherry 18mm Thickness 18.0 Grain N Book 0</u>									
CHERRY GLOSS 18MM/01	2440.0	1220.0	80	LMG02-ORD-P5	17/09/15	20	59.54	5.230	311.37
				MCS-STKORD-01	01/09/15	62	184.56		965.26
						82	244.10		1276.63
<u>GREEN GLOSS 18MM Gloss finish - Green 18mm Thickness 18.0 Grain N Book 0</u>									
GREEN GLOSS 18MM/01	3050.0	1525.0	32	MCS-STKORD-01	01/09/15	20	93.03	0.000	106.40
						20	93.03		106.40
<u>MED-DEN-FIBRE-18MM Medium Density Fibreboard 18mm Thickness 18.0 Grain N Book 0</u>									
MED-DEN-FIBRE-18MM/01	3050.0	1525.0	1221	BSR-STKORD-08	31/08/10	155	720.94	4.500	3244.25
						155	720.94		3244.25
<u>MED-DEN-FIBRE-25MM Medium Density Fibreboard 25mm Thickness 25.0 Grain N Book 0</u>									
MED-DEN-FIBRE-25MM/01	2440.0	1220.0	1089	BSR-STKORD-08	31/08/10	190	565.59	6.300	3563.23
						190	565.59		3563.23

Report - orders by material

Minimum free stock

Board	Length mm	Width mm	Stock	Alloc	Free Stock	Min Stk	Order	ReOrder	Supplier
<u>GREEN GLOSS 18MM Gloss finish - Green 18mm Thickness 18.0 Grain N Book 0</u>									
GREEN GLOSS 18...	3050.0	1525.0	32	0	32	50	20	60	Laminate Supply Co
<u>MFC18-OAK Prelaminated - Oak 18mm Thickness 18.0 Grain Y Book 0</u>									
MFC18-OAK/02	2440.0	1220.0	118	4	114	120	42	150	
<u>OAK MDF 18MM Medium Density Fibreboard - Oak 18mm Thickness 18.0 Grain Y Book 0</u>									
OAK MDF 18MM/01	3050.0	1525.0	78	0	78	100	0	120	
OAK MDF 18MM/02	2440.0	1220.0	59	0	59	100	0	120	
<u>OAK-LAM-1MM Oak Laminate 1mm Thickness 1.0 Grain Y Book 10</u>									
OAK-LAM-1MM/01	3050.0	1525.0	78	0	78	100	55	120	Laminate Supply Co
OAK-LAM-1MM/02	2440.0	1220.0	59	0	59	100	40	120	Laminate Supply Co
<u>TEAK MDF 18MM Medium Density Fibreboard - Teak 18mm Thickness 18.0 Grain Y Book 0</u>									
TEAK MDF 18MM/01	2440.0	1220.0	81	0	81	100	0	120	
TEAK MDF 18MM/02	3050.0	1525.0	89	0	89	100	0	120	

Report - Minimum free stock

Stock issues

Stock issues

Range: 29-Jul-10 To 27-Sep-18

Board	Length mm	Width mm	Issue	Area m2	Volume m3	Cost / m2	Total Cost
<u>CHIPBOARD-18MM Chipboard Core 18mm Thickness 18.0 Grain N Book 0</u>							
CHIPBOARD-18MM/01	2440.0	1220.0	14	41.68	0.75	2.950	122.94
				<u>41.68</u>	<u>0.75</u>		<u>122.94</u>
<u>HARDBOARD-4MM Hardboard 4mm Thickness 4.0 Grain N Book 8</u>							
HARDBOARD-4MM/01	2440.0	1220.0	9	26.79	0.11	0.890	23.84
				<u>26.79</u>	<u>0.11</u>		<u>23.84</u>
<u>MED-DEN-FIBRE-18MM Medium Density Fibreboard 18mm Thickness 18.0 Grain N Book 0</u>							
MED-DEN-FIBRE-18MM/01	3050.0	1525.0	6	27.91	0.50	4.500	125.58
				<u>27.91</u>	<u>0.50</u>		<u>125.58</u>
<u>MED-DEN-FIBRE-25MM Medium Density Fibreboard 25mm Thickness 25.0 Grain N Book 0</u>							
MED-DEN-FIBRE-25MM/01	2440.0	1220.0	2	5.95	0.15	6.300	37.51
				<u>5.95</u>	<u>0.15</u>		<u>37.51</u>
<u>MEL-CHIP-15MM Prelaminated - White 15mm Thickness 15.0 Grain N Book 0</u>							
MEL-CHIP-15MM/02	2440.0	1220.0	1	2.98	0.04	2.560	7.62

Report - stock issues

The module includes options to consolidate the library at a period end and has a full audit trail. There are also options to manage stock and update costs etc.

All the stock reports can be fully customized and all have print options.

Orders by material										
Board	Length mm	Width mm	Stock	Order	Date	Order Qty	Area m2	Cost / m2	Order Cost	Weight
<u>MED-DEN-FIBRE-18MM Medium Density Fibreboard 18mm Thickness 18.0 Grain N Book 0</u>										
MED-DEN-FIBRE-18MM/01	3050.0	1525.0	1221	BSR-STKORD...	31/08/10	155	720.94	4.500	3244.25	8435.04
						155	720.94		3244.25	8435.04
<u>MED-DEN-FIBRE-25MM Medium Density Fibreboard 25mm Thickness 25.0 Grain N Book 0</u>										
MED-DEN-FIBRE-25MM/01	2440.0	1220.0	1089	BSR-STKORD...	31/08/10	190	565.59	6.300	3563.23	9190.87
						190	565.59		3563.23	9190.87
<u>MEL-CHIP-15MM Prelaminated - White 15mm Thickness 15.0 Grain N Book 0</u>										
MEL-CHIP-15MM/01	3050.0	1220.0	901	BSR-STKORD...	09/08/10	120	446.52	2.590	1166.49	3348.90
				BSR-STKORD...	23/08/10	55	204.66		530.06	1534.91
						175	651.17		1686.54	4883.81
MEL-CHIP-15MM/02	2440.0	1220.0	729	BSR-STKORD...	09/08/10	110	327.45	2.560	838.27	2455.86
						110	327.45		838.27	2455.86
<u>MEL-CHIP-18MM Prelaminated - White 18mm Thickness 18.0 Grain N Book 0</u>										
MEL-CHIP-18MM/01	3050.0	1220.0	933	BSR-STKORD...	09/08/10	170	632.57	3.180	2011.57	5693.13
				BSR-STKORD...	23/08/10	40	148.84		473.31	1339.56
						210	781.41		2484.88	7032.69
MEL-CHIP-18MM/02	2440.0	1220.0	370	BSR-STKORD...	09/08/10	40	119.07	3.140	373.89	1071.65
						40	119.07		373.89	1071.65
<u>MFC18-BEECH Prelaminated - Beech 18mm Thickness 18.0 Grain N Book 0</u>										
MFC18-BEECH/01	3050.0	1525.0	1699	BSR-STKORD...	09/08/10	200	930.25	3.210	2986.10	8435.04
				BSR-STKORD...	15/08/10	15	69.77		27	3
						215	*****		3	

Printed reports - stock control

For this printed report only the Stock quantity is shown. All the data for printed reports can be exported to an external file.

Integration with external stock systems

These days it is quite common for stock and orders etc. to be held in external systems including mechanical stock handling systems. The module can be integrated with external systems.

- Full integration with the Homag woodStore materials system

- Import/Export options for materials and boards
- Option to run external linking program automatically

This latter allows the Board library to be kept in sync with external databases.

The board library has a full set of editing options to allow manual adjustments and changes.

Stock control of parts

The stock control options include the control of parts so that over produced parts can be stored and taken into account in future lists by reducing the requirement for that part.

Stock control of Fittings and Edging material

With the PQ module the stock control options include the control of fittings (hardware) items in the Part library and Edging material in the Edging library (solid edging and laminate sheets).

7. Products & Quotes (PQ)

The Products & Quotes module is for accurate quotations and processing orders quickly and easily. It is most useful where the cutting requirements arise in producing assembled products, kitchens units, bedroom units, housings, furniture ...

The product library can detail any job:-

- Standard product ranges
- Custom products
- Products with extra parts and fittings
- Can include lipping and bought in items ...

The key to the module is that the product detail is very flexible - a single definition can cover a wide range of customer or production variations.

For each order once the customer request for colour, material, size, fittings are specified the program can calculate the full set of materials, sizes, and quantities for all the parts in the product.

The result is a cutting list ready for the saw or machining centre.

Orders screen

A versatile order screen allows the entry of order for quotes or production.

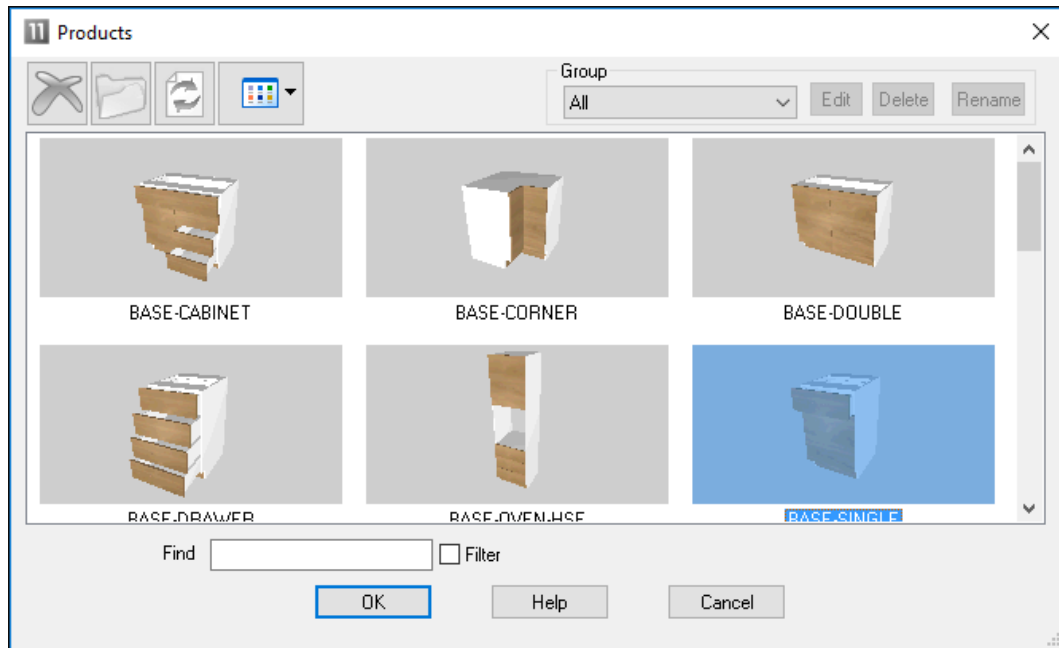
No	Code	Information	Product			Part					Qty	Unit price	Total price	
			Width	Height	Depth	Material	Length	Width	Grain	Edge				Inf
1	BASE-SINGLE	Single base unit	500.0	870.0	600.0							7	40.00	280.00
2	BASE-SINK	Sink base unit	1000.0	870.0	600.0							2	40.56	81.12
3	WALL-DOUBLE	Double wall unit	1000.0	750.0	300.0							5	34.48	172.40
4	WALL-SINGLE	Single wall unit	500.0	750.0	300.0							3	21.12	63.36
		Deliver separately												
5	F-UNIT-DOOR	Fixed size unit door				MFC18...	495.0	570.0	Y	0000		4	3.61	14.44
6	F-UNIT-END-LEFT	Fixed size unit end left				MEL-CH...	585.0	870.0	N	0000		4	4.06	16.24
7	F-UNIT-END-RIGHT	Fixed size unit end right				MEL-CH...	585.0	870.0	N	0000		4	4.06	16.24
8	Z-SINGLE	Single Knob										23	0.95	21.85
9	Y-PACKING	Packing										14	6.00	84.00
10														
11														
12														
13														
14														
15														
16														

Quotes / Orders

The top section allows for the entry of customer details, delivery and invoice address etc. In the grid enter the required products and other items.

Full costs are shown and the system can be set to several different pricing models.


Products and other items are selected from the product library.



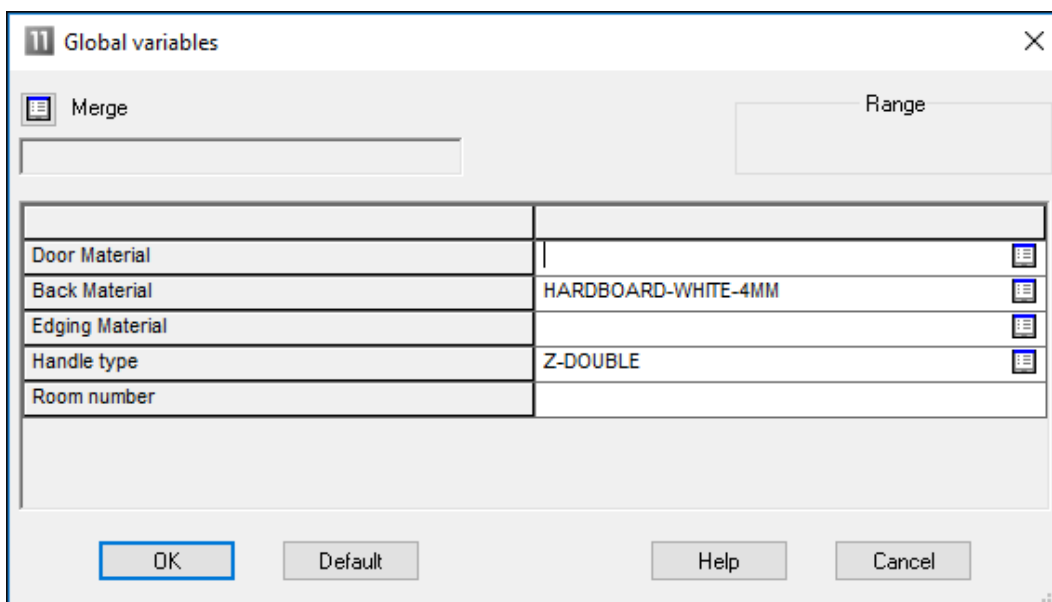
Product selection

Products and Parts can be displayed as 2D or 3D models in the Order screen.



Select  to view a 3D model of your product/part, the product model has to have been created previously via the product library.

Where the product is defined as a parametric (variable) product the Order screen prompts for the customer's requirements (and production requirements).



The image shows a software dialog box titled "Global variables". It features a "Merge" button on the left and a "Range" input field on the right. Below these is a table with five rows. The first row is empty. The second row is "Door Material" with an empty value field. The third row is "Back Material" with the value "HARDBOARD-WHITE-4MM". The fourth row is "Edging Material" with an empty value field. The fifth row is "Handle type" with the value "Z-DOUBLE". The sixth row is "Room number" with an empty value field. At the bottom of the dialog are four buttons: "OK", "Default", "Help", and "Cancel".

Variable	Value
Door Material	
Back Material	HARDBOARD-WHITE-4MM
Edging Material	
Handle type	Z-DOUBLE
Room number	

Variables dialog

The requirements can vary for each product line even for the same style of product.

There are a full set of facilities (variables, look up tables, formulae) with the Product library for creating parametric products.



Once the order is complete the order can be estimated at the single click of a button.

Totals			
Date	28/05/2012		
Discount code	A	Per order discount %	5.0
Tax code	MIDLA	Tax rate	20.0
Overhead	0.0	Percentage for mark up	0.0
Total order cost			817.79
Overhead amount			0.00
Mark up - amount			0.00
Total order amount			817.78
Order discount amount			-40.89
Order amount - including discount			776.89
Carriage			0.00
Invoice total pre tax			776.89
Tax			155.38
Total due			932.27
OK		Cancel	

Estimate dialog

The order status can be tracked and the Form & Label designer can be used to produce customer documents:-

Quotation
 Advice note
 Delivery note
 ...

Once an order is confirmed the order is optimised and the cutting patterns produced ready to send to the saw or machining centre.

Review runs

File Edit View Settings Summaries Stock Help

Pattern preview Example of quote

Products & parts order:///DEFAULT/?DEFAULT/? [Rules:CL,BL] [?](#)



Revision 6 : 27 Aug 2018 14:26 : Recalculated by Sean-Lenovo

<p>Ptn:1 Qty:1 Cycles:1 Board: 1.MEL-CHIP-18MM/01 Size: 3050.0 x 1220.0</p>	<p>Ptn:2 Qty:3 Cycles:1 Board: 2.MEL-CHIP-18MM/02 Size: 2440.0 x 1220.0</p>
<p>Ptn:3 Qty:2 Cycles:1 Board: 2.MEL-CHIP-18MM/02 Size: 2440.0 x 1220.0</p>	<p>Ptn:4 Qty:1 Cycles:1 Board: 2.MEL-CHIP-18MM/02 Size: 2440.0 x 1220.0</p>

Batch reports
 Summaries
 Advanced
 Patterns
 Machining
 Custom

Order - optimise

The production and delivery documents are set up in the Form & Label designer - the program includes many different templates to help with the design of forms.

 <h1 style="margin: 0;">GLOBAL FURNITURE LTD</h1> <p style="margin: 0;">Furniture House, 27 Wood Lane, Bristol, BS1 2XR, UK Telephone: +44 (0)117 933 6323 Fax: +44 (0)117 933 6487</p>						
				Order invoice		
Invoice date: 28/05/2012		Order no. Products & parts order		Our ref.	Your ref.	
 <small>28/05/2012</small>	Customer address Kitchens Direct Ashford Road Birmingham B11 2RX					
Order / item no.	Details			Quantity	Unit £	Total £
Products & parts order/007	Code: F-UNIT-END-RIGHT Length: 585.0 Description: Fixed size unit end right Width: 870.0 Finish: MFC18-OAK			4	4.52	18.08
Products & parts order/008	Code: Z-SINGLE Description: Single Knob Finish:			23	0.95	21.85
Products & parts order/009	Code: Y-PACKING Description: Packing Finish:			14	6.00	84.00

Order - optimise

The module produces a full breakdown of product costing.

Product costing				Example of quote			
Ref	Products & parts order	Description Example of quote					
No	Code	Qty	Information	Width	Height	Over 0 Depth	
1.	BASE-SINGLE	7	Single base unit	500.0	870.0	600.0	
	DOORMATERIAL: MFC18-OAK					CARCASEMATERIAL: MED-DEN-FIBRE-18MM	
	BACKMATERIAL: HARDBOARD-4MM					EDGING: OAK-TAPE-22MM	
	HANDLETYPE: Z-DOUBLE					FE:	
	HINGE: LEFT					SHELFDEPTH: 400.0	
	ROOMNUMBER:					PH: 125.0	
	RH: 150.0					DR: 1	
Code	Qty	Description	Material	Length	Width Time	Item cost Per hour	Total
BASE-END-LEFT	1	Base unit end...	MED-DEN-FIBR...	582.0	870.0	6.322	6.322
		Description: Base unit end left	Material: MED-DEN-FIBRE-18MM				
BASE-END-RIGHT	1	Base unit end...	MED-DEN-FIBR...	582.0	870.0	6.322	6.322
		Description: Base unit end right	Material: MED-DEN-FIBRE-18MM				
BASE-BACK	1	Base unit back	HARDBOARD-4MM	476.0	735.0	0.978	0.978
BASE-BOTTOM	1	Base unit floor	MED-DEN-FIBR...	464.0	582.0	3.463	3.463
		Material: MED-DEN-FIBRE-18MM					
BASE-PLINTH	1	Base unit plinth	MED-DEN-FIBR...	464.0	125.0	1.048	1.048
		Material: MED-DEN-FIBRE-18MM					
BASE-RAIL-FRONT	1	Base unit rail front	MED-DEN-FIBR...	464.0	150.0	1.509	1.509
		Description: Base unit rail front	Material: MED-DEN-FIBRE-18MM				
BASE-RAIL-BACK	1	Base unit rail back	MED-DEN-FIBR...	464.0	150.0	1.009	1.009
		Description: Base unit rail back	Material: MED-DEN-FIBRE-18MM				
BASE-SHELF	1	Base unit shelf	MED-DEN-FIBR...	464.0	400.0	1.345	1.345
		Material: MED-DEN-FIBRE-18MM					
BASE-DRAWER	1	Base unit drawer	MFC18-OAK	500.0	186.3	2.591	2.591
BASE-DOOR	1	Base unit door	MFC18-OAK	500.0	554.8	4.228	4.228
+BUDC	1	Base unit drawer carcass		462.0	148.3	546.0	
BUDC-LEFT	1	Drawer carcass left	WHITE-ACRYLI...	546.0	136.3	1.320	1.320
		Description: Drawer carcass left	Material: WHITE-ACRYLIC-12MM				
BUDC-RIGHT	1	Drawer carcass right	WHITE-ACRYLI...	546.0	136.3	1.320	1.320
		Description: Drawer carcass right	Material: WHITE-ACRYLIC-12MM				
BUDC-BACK	1	Drawer carcass back	WHITE-ACRYLI...	438.0	136.3	1.320	1.320
		Description: Drawer carcass back	Material: WHITE-ACRYLIC-12MM				
BUDC-BOTTOM	1	Drawer carcass base	WHITE-ACRYLI...	462.0	546.0	1.320	1.320
		Description: Drawer carcass base	Material: WHITE-ACRYLIC-12MM				
Z-DRAWER-SCREW	13	Acrylic drawer screw	WHITE-ACRYLI...	0.120			1.560
		Description: Acrylic drawer screw					
Z-DOUBLE	2	Full handle	WHITE-ACRYLI...	1.210			2.420
ZH180-HINGE	2	Hinge 180 HKK...	WHITE-ACRYLI...	0.400			0.800
		Description: Hinge 180 HKK123-321					
Z-DOWEL	22	Dowel	WHITE-ACRYLI...	0.120			2.640
Z-SHELF-SUPPORT	4	Shelf support	WHITE-ACRYLI...	0.190			0.760
Z-RUNNER	2	Drawer runner	WHITE-ACRYLI...	0.430			0.860
ZS40-8-CSUNK-SCREW	8	Csunk Screw 4...	WHITE-ACRYLI...	0.010			0.080
		Description: Csunk Screw 40mm No8					
Y-ASSEMBLY	180	Cabinet Assembly	WHITE-ACRYLI...	6.500			1170.0
2.	BASE-SINK	2	Sink base unit	1000.0	870.0		
	DOORMATERIAL: MFC18-OAK						CARCASEMATERIAL: MED-DEN-FIBRE-18MM

Product costing - print

There is also a full breakdown for the costs of all parts and other items in the order.

Review runs

File Edit View Settings Summaries Stock Help

Job costing Example of quote

Products & parts order

Code	Description	Quantity	Linear	Area	Cost	Total
Board						
	Material	Quantity		Area	Cost/m2	Total
MEL-CHIP-18MM/01	MEL-CHIP-18MM 3050.0 x 1220.0	1		3.721	3.180	11.83;
MEL-CHIP-18MM/02	MEL-CHIP-18MM 2440.0 x 1220.0	6		17.861	3.140	56.08;
HARDBOARD-WHITE-4MM/01	HARDBOARD-WHITE-4MM 2440.0 x 1220.0	4		11.907	0.950	11.31;
MFC18-OAK/02	MFC18-OAK 2440.0 x 1220.0	2		5.954	2.970	17.68;
MFC18-BEECH/01	MFC18-BEECH 3050.0 x 1525.0	3		13.954	3.210	44.79;
MFC18-BEECH/02	MFC18-BEECH 2440.0 x 1220.0	1		2.977	2.960	8.81
		17		56.373		150.51;
Sundry						
	Material	Quantity	Linear	Area	Cost	Total
WHAC12/01	WHITE-ACRYLIC-12MM	28			1.320	36.96;
		28				36.96;
Edging						
	Description	Quantity			Cost/m	Total
OAK-TAPE-22MM	Oak PVC Tape 22mm	60.840			0.840	51.10;
BEECH-TAPE-22MM	Beech PVC Tape 22mm	50.820			0.720	36.59;
WHITE-TAPE-22MM	White PVC Tape 22mm	8.840			0.550	4.86;
		120.500				92.55;
Fitting						
	Description	Quantity			Cost	Total
Z-DOUBLE	Pull handle	31			1.210	37.51;
Z-DOWEL	Dowel	326			0.120	39.12;
7-DRAWFR-SCREW	Acrylic drawer screw	91			0.120	10.92;

Summaries

Advanced

Patterns

Machining

Custom

Job costing



Customer database

The module includes an integrated database for customer details and addresses etc.

Customer code: CS1002

Customer name: Bedrooms Ltd

Invoice address: Ashley House, Wood Green Road, Bristol

Delivery address: Ashley House, Wood Green Road, Bristol

Postcode: BS1 1EX

Postcode: BS1 1EX

Contact: Susan Jones

Telephone: 0117 933 7892

Fax: 0117 934 6632

Notes:

- 1 Check credit limit
- 2 Phone before del.
- 3
- 4
- 5

Payment terms: 60 Days

Discount code: B

Analysis codes:

- 1 WEST
- 2
- 3

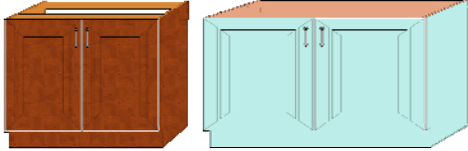
Customer database

This is an Access MDB database - so the data can be easily linked to other systems.

 **Product library**

The heart of the PQ module is the product library for building and storing parametric products.

The product library deals with custom or variable products in product ranges.



Products

A single parametric product record can be defined to cover a wide range of options. The program automatically works out the correct part sizes and quantities based on the customer and/or production requirements.

In the above example there are two products produced from the same template. One with different materials, different sizes and one with no back.

This approach is very efficient and accurate since the program does all the calculating of sizes and quantities as the product requirements change from customer to customer.

The product entry screen allows the product to be detailed.

The screenshot shows the 'Product library' window with the following details:

- Type:** Product
- Code:** BASE-CABINET
- Description:** Base unit - cabinet
- X Width:** 900.0
- Y Height:** 870.0
- Z Depth:** 600.0
- Vertical position:** (Radio buttons for fx, Def)
- Price (fx):** =IF((X<=900),35,32,49,56)
- Answer table:** (Empty table)
- Memo:** 10 empty text boxes

Below the form is a table with the following columns: Part, Quantity / Time, Description, Material, Length, and Width.

Part	Quantity / Time	Description	Material	Length	Width
1. BASE-CABINET-END-LEFT	1	Base cabinet end left	@ENDMAT_L@	=Z-T(@DOORMATERIA...	=Y
2. BASE-CABINET-END-RIGHT	1	Base cabinet end right	@ENDMAT_R@	=Z-T(@DOORMATERIA...	=Y
3. BASE-CABINET-DRAWER-L...	1	Base cabinet long drawer	@DOORMATERIAL@	=X	=&CABINET_DRAWER&
4. BASE-CABINET-DRAWER	3	Base cabinet drawer	@DOORMATERIAL@	=X/2,34	=&CABINET_DRAWER&6
5. BASE-CABINET-DOOR	1	Base cabinet door	@DOORMATERIAL@	=X/2,50+T(@CARCASE...	=Y-18-@PH@-&CABINET_DRAWER&
6. BASE-CABINET-BOTTOM	1	Base cabinet base	@CARCASEMATERIAL@	=&INTERNAL_WIDTH&	=Z-T(@DOORMATERIAL@)
7. BASE-CABINET-RAIL-FRONT	2	Base cabinet rail front	@CARCASEMATERIAL@	=&INTERNAL_WIDTH&	=@RH@
8. BASE-CABINET-RAIL-BACK	1	Base cabinet rail back	@CARCASEMATERIAL@	=&INTERNAL_WIDTH&	=@RH@
9. BASE-CABINET-DIVIDER	1	Base cabinet divider	@CARCASEMATERIAL@	=Z-18-T(@BACKMATERI...	=Y-@PH@-&CABINET_DRAWER&-T[...
10. BASE-CABINET-FASCIA	1	Base cabinet fascia	@DOORMATERIAL@	100.0	=Y-@PH@-&CABINET_DRAWER&-T[...
11. BASE-BACK	1	Base unit back	@BACKMATERIAL@	=&INTERNAL_WIDTH&+...	=&BACK_PANEL_HEIGHT&
12. BASE-PLINTH	1	Base unit plinth	@DOORMATERIAL@	=&INTERNAL_WIDTH&	=@PH@

Product library

The details can include a drawing (from an external file e.g. bmp) or a drawing from the built-in drawing library.

The important point is that the product details such as Material or Length can be defined as variables e.g. @CARCASEMATERIAL@ or formulae &INTERNAL_WIDTH&

The variable is answered at the order screen where the customer material is entered e.g. TEAK or BEECH-18MM.

The formula is pre-defined formula that depends on the material thickness. There are tables for defining variables, lookup tables, and formulae.

No	Name	Description	Formula
1.	SHELFWIDTH	Shelf Width: Bases	=X*(2*T(@CARCASEMATERIAL@))
2.	HANDLE_TYPE	Double=1 or Single=0	=IF(@HANDLETYPE@="Z-DOUBLE")
3.	SHELF_QUANTITY	Number of Shelves	=IF(Y<600,2,IF(Y<1200,3,5))
4.	BACK_PANEL_HEIGHT	Height of back panel	=Y-T(@CARCASEMATERIAL@)-@PH@+8
5.	INTERNAL_WIDTH	Internal width	=X*(2*T(@CARCASEMATERIAL@))
6.	DOOR_HEIGHT	Door height (no drawer)	=Y-2-@PH@
7.	DOOR_HEIGHT_DRAWER	Door height (with drawer)	=Y-4-@PH@-(Y-@PH@)/4
8.	DOOR_HINGE_HOLE	Variable hinge holes	=IF((@DR@),@PH@+&DOOR_HEIGHT_DRAWER&-50,@PH@+&DOOR_HEIGHT&-50)
9.	OVEN_DRAWER	Over drawer height	=((Y-@PH@-6)/3)-4/3
10.	CABINET_DRAWER	Cabinet drawer height	=((Y-8-@PH@)/4)
11.	DRESSER-DRAWER	Dresser drawer height	=Y-T(@CARCASEMATERIAL@)-@PH@-8/3
12.	PDR	Unit price drawer	=CELL(BASE-DRW,@DOORMATERIAL@,STR((INT(X/100+1)*100)))
13.	PNDR	Unit price no drawer	=CELL(BASE-NODRW,@DOORMATERIAL@,STR((INT(X/100+1)*100)))
14.			

Formulae table

The task of building up the product details can be quite a lengthy and complex process - but the program includes many examples and templates to aid the process.

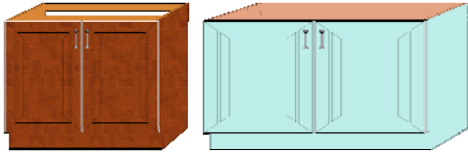
More about custom products

When working with custom products many of the parts or other features of the product are defined by a formula rather than a fixed value and some features of the product are defined as variable items, such as overall size or door material.

The actual size or material is specified when you enter the order details or product requirements for a particular order. This is a big advantage because a single 'Product' definition can be used to cater for a variety of customer preferences, or different options within a style or range. This helps to keep the product library small and easy to maintain.

For example, in the following simple case, TOP and DOORS are the variables for the materials in the product.

To enter an item as a variable surround the variable name with the @ symbol, for example: @TOP@ @DOORS@.



Products

TUDOR/1 Kitchen cabinet 750.0

<u>Code</u>	<u>Qty</u>	<u>Material</u>	<u>Description</u>	<u>Gr</u>	<u>Edge</u>
TOP/1	1	@TOP@	Long work top	Y	1111
DOOR/2	2	@DOORS@	Tudor doors	Y	0000
FT/1234	15	+SCREW	3/4" screws		
FT/006	1	+EXTRA	Inside trays		

Product and part formulae

If you define a product such that some or all of the overall product dimensions are different for each customer then some or all of the individual parts also vary in size. For example, the tops in the above case have different lengths and widths for each product variation.

To deal with this define for each part how its size varies with the overall product dimensions.

In the example above tops this may be quite simple:-

length of top = overall width of product
width of top = overall depth of product

The formulae for the doors may be more complicated:-

length of door = height of product - 35mm
width of door = (width of product-10mm)/2

The overall product dimensions are represented by the following variable names:-

X - overall product width
Y - overall product height
Z - overall product depth

Which you can use in formulae. In the above example the formulae become:-

length of top = X
width of top = Z
length of door = Y-35
width of door = (X-10)/2

A formula can also contain a variable, such as, @PLINTH@. Where the variable stands for a specific value that varies with each product.

Length of door = Y-2*@PLINTH@

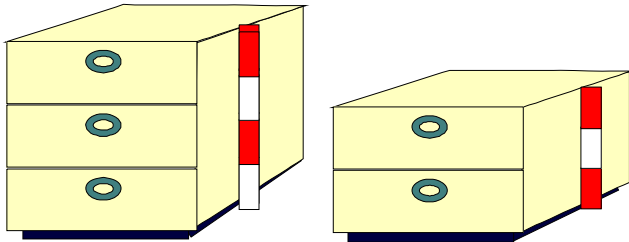
The product requirements calculation replaces the variable @PLINTH@ by the value entered at the optimise products screen.

Conditional statements

A conditional statement is a statement that evaluates to 0 if the statement is false and 1 if the statement is true.

= (X>400)
= ((Z-12)<500)

The statement (X>400) means if X is greater than 400 the statement is set to 1 or if X is less than 400 the statement is set to 0. A typical use of these statements is in the quantity box. On some products the number of drawers may depend on the overall height of the product, for example:-



Formula

2 drawers if product is less than 1000mm in height
3 drawers if product is more than 1000mm in height

The formula for this is: Number of drawers' = 2+1*(Y>=1000)

Making 3D models in the product library

It is possible to construct a 3D model of a product in the product library by specifying how the products parts are connected together.

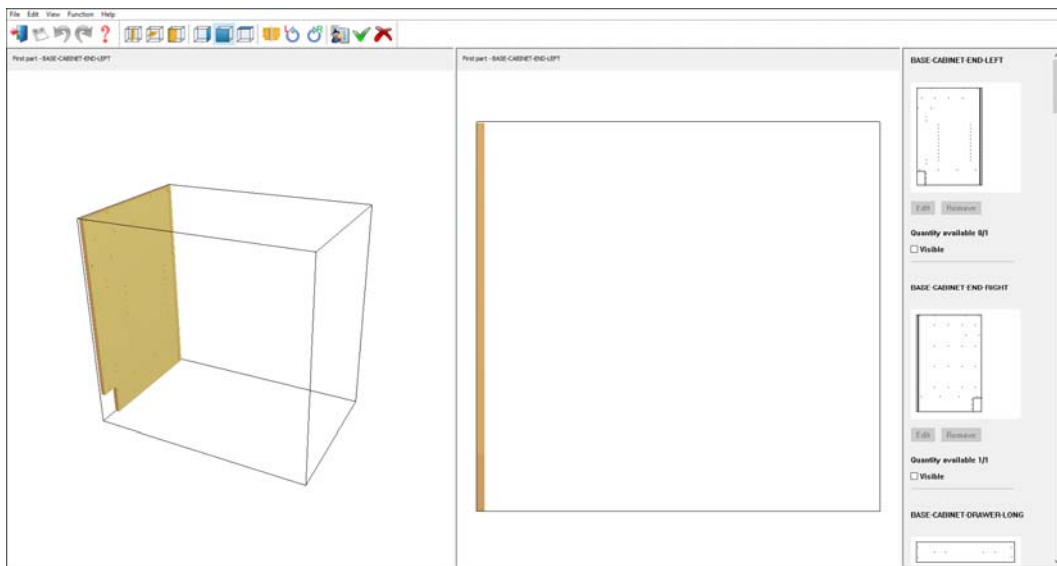
The screenshot shows the 'Product library' window with the following details:

- Type:** Product
- Code:** BASE-CABINET
- Description:** Base unit - cabinet
- Width:** 900.0
- Height:** 870.0
- Depth:** 600.0
- Price (fx):** =IF(X<=900,35.32,49.56)

Part	Quantity / Time	Description	Material	Length	Width
1. BASE-CABINET-END-LEFT	1	Base cabinet end left	@ENDMAT_L@	=Z-T(@DOORMATERIA...	=Y
2. BASE-CABINET-END-RIGHT	1	Base cabinet end right	@ENDMAT_R@	=Z-T(@DOORMATERIA...	=Y
3. BASE-CABINET-DRAWER-L...	1	Base cabinet long drawer	@DOORMATERIAL@	=X	=&CABINET_DRAWER&
4. BASE-CABINET-DRAWER	3	Base cabinet drawer	@DOORMATERIAL@	=X/2-34	=&CABINET_DRAWER&-6
5. BASE-CABINET-DOOR	1	Base cabinet door	@DOORMATERIAL@	=X/2-50+T(@CARCASE...	=Y-18-@PH@-&CABINET_DRAWER&
6. BASE-CABINET-BOTTOM	1	Base cabinet base	@CARCASEMATERIAL@	=&INTERNAL_WIDTH&	=Z-T(@DOORMATERIAL@)
7. BASE-CABINET-RAIL-FRONT	2	Base cabinet rail front	@CARCASEMATERIAL@	=&INTERNAL_WIDTH&	=@RH@
8. BASE-CABINET-RAIL-BACK	1	Base cabinet rail back	@CARCASEMATERIAL@	=&INTERNAL_WIDTH&	=@RH@
9. BASE-CABINET-DIVIDER	1	Base cabinet divider	@CARCASEMATERIAL@	=Z-18-T(@BACKMATERI...	=Y-@PH@-&CABINET_DRAWER&-T(...
10. BASE-CABINET-FASCIA	1	Base cabinet fascia	@DOORMATERIAL@	100.0	=Y-@PH@-&CABINET_DRAWER&-T(...
11. BASE-BACK	1	Base unit back	@BACKMATERIAL@	=&INTERNAL_WIDTH&+...	=&BACK_PANEL_HEIGHT&
12. BASE-PLINTH	1	Base unit plinth	@DOORMATERIAL@	=&INTERNAL_WIDTH&	=@PH@

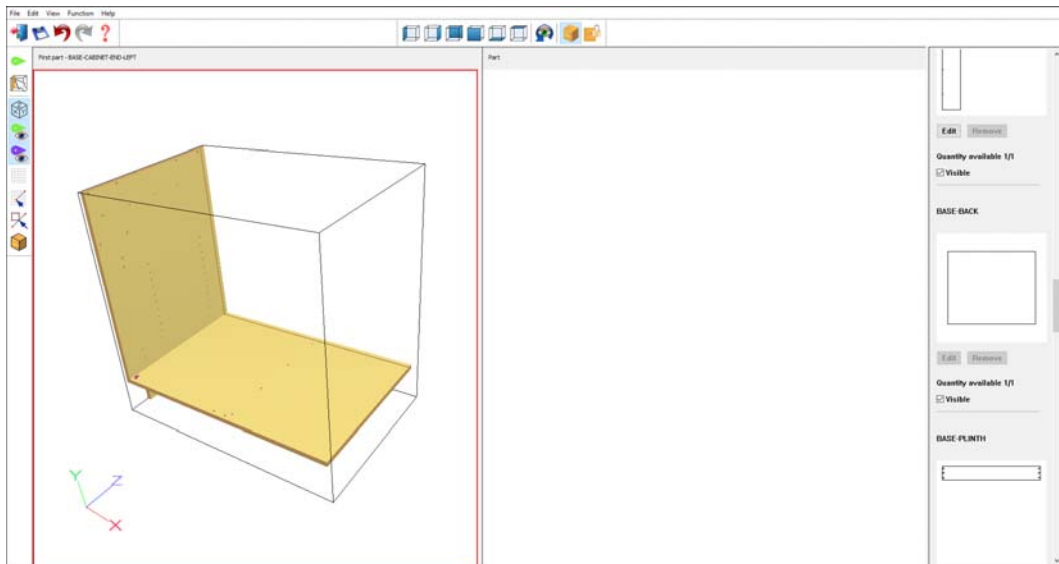
These products can then be viewed in 3D in product requirements or quote. When viewing such products variables answers can be changed to instantly see their effect on the product.

Products are created by specifying a first part in the product and how it is positioned within the product cuboid created to the product size specified in the product library.



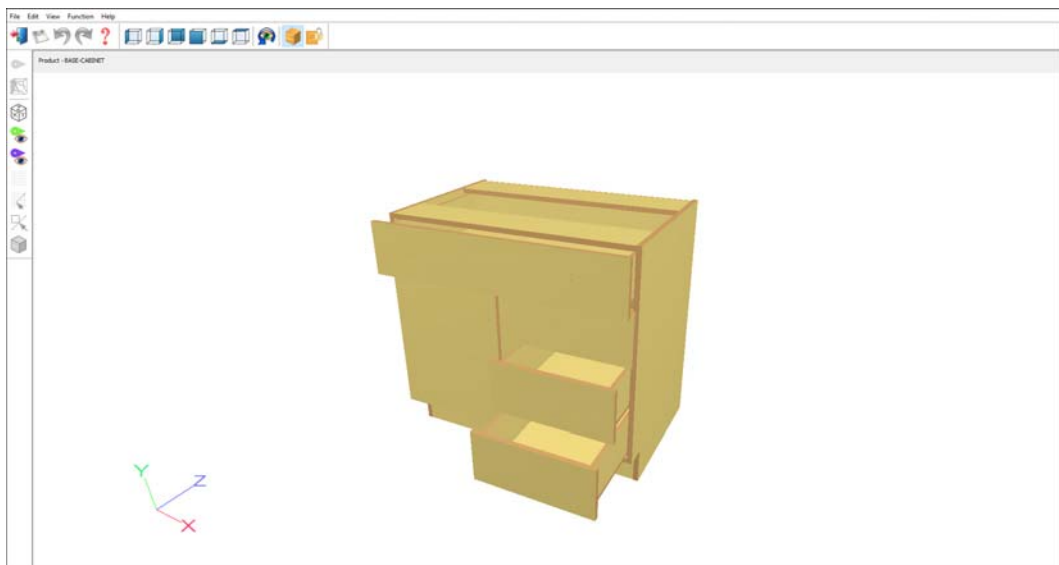
First Part Positioning

Once the first part has been placed the other parts of the product can be added one at a time.



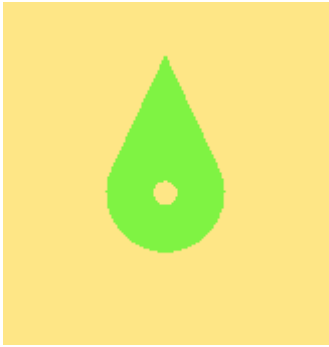
3D Product Builder

Until the product is complete:



3D Completed Product

The products are built using connectors. A connector is attached to each part and then snapped together.



A connector

Connectors positions on their part can be specified parametrically so they will remain in the correct place as the dimensions of the product change.

Product requirements

Product requirements are the quantities of each product required to fulfil an order. The requirements can include values for sizes, finishes and fittings etc. where these are variable items that vary with each order.

With the product and part libraries set up the program can automatically calculate for each product requirement list the type, sizes and quantities of each part required. The result is a cutting list of part sizes for those products. The program optimises the cutting list to produce a set of cutting patterns.

At the Main screen:-

- Select: **File - Product requirements**
- or
- **Click on a file name** (Product requirements section of the File tree)

The product requirement are also available from the main screen at the File menu.

- Select: **File - Product requirements**

The program displays the product requirement screen.


No	Code	Information	Product			Qty
			Width	Height	Depth	
1	BATHROOM-CABINET	Bathroom cabinet	700.0	600.0	180.0	1
2	WARDROBE	Wardrobe - drawer & door	1000.0	1800.0	600.0	1
3	DRESSER	Dressing table	1200.0	1100.0	600.0	1
4	DRESSER	Dressing table	1000.0	1200.0	600.0	1
5	WARDROBE	Wardrobe - drawer & door	1200.0	1900.0	650.0	1
6	BATHROOM-CABINET	Bathroom cabinet	700.0	600.0	180.0	1
7	DRESSER	Dressing table	1000.0	1100.0	600.0	2
8	DRESSER	Dressing table	1000.0	1100.0	600.0	1
9	WARDROBE	Wardrobe - drawer & door	1000.0	1800.0	600.0	1
10	BASE-CABINET	Base unit - cabinet	900.0	870.0	600.0	1
11	BASE-CORNER	Corner cabinet	800.0	870.0	800.0	1
12	BASE-DOUBLE	Double base unit	1000.0	870.0	600.0	1
13	BASE-DRAWER	<input checked="" type="checkbox"/> Drawers-MFC18-OAK	500.0	870.0	600.0	1
14	BASE-OVEN-HSE	Oven Housing	600.0	2350.0	600.0	1
15	BASE-SINGLE	Single base unit	500.0	870.0	600.0	1
16	BASE-SINK	Sink base unit	1000.0	870.0	600.0	1

Product requirements

The screen shows the list of products required and the quantity of each. This might be a list for a customer or batch of items for production.

When reviewing the requirements, products can be displayed as 2D drawings or 3D models.



Select  to view a 3D model of your product, the model has to have been created previously via the product library.

Custom products - For custom products the program prompts for the customised details when products are entered. For example, the overall width, depth or height, finish or material for a product (where these are variable items).

Variable	Value
Door Material	MFC18-OAK
Carcase Material	MEL-CHIP-18MM
End Material - Right	MEL-CHIP-18MM
End Material - Left	MEL-CHIP-18MM
Back Material	HARDBOARD-4MM
Edging Material	
Handle type	Z-DOUBLE
Room number	3

Enter variable values dialog

The 'Copy' option offers a list of pre-defined 'answers' which can be used to quickly set up a product.

The sets of 'answers' are created in the 'Answer table' and can be useful where a product has several different but well defined ranges.

11 Answer table
✕

Reference

Description

Width

Height

Depth

Range

Description	Default
Door Material	MFC18-BEECH
Carcase Material	
End Material - Right	
End Material - Left	
Cabinet Material	
Back Material	HARDBOARD-4MM
Edging Material	BEECH-TAPE-22MM
Handle type	Z-SINGLE

Answer table

In the above example there are a set of pre-defined values for the Beech finish.



Select the Optimise button to create cutting patterns

When optimisation is complete the screen displays the *Management summary*

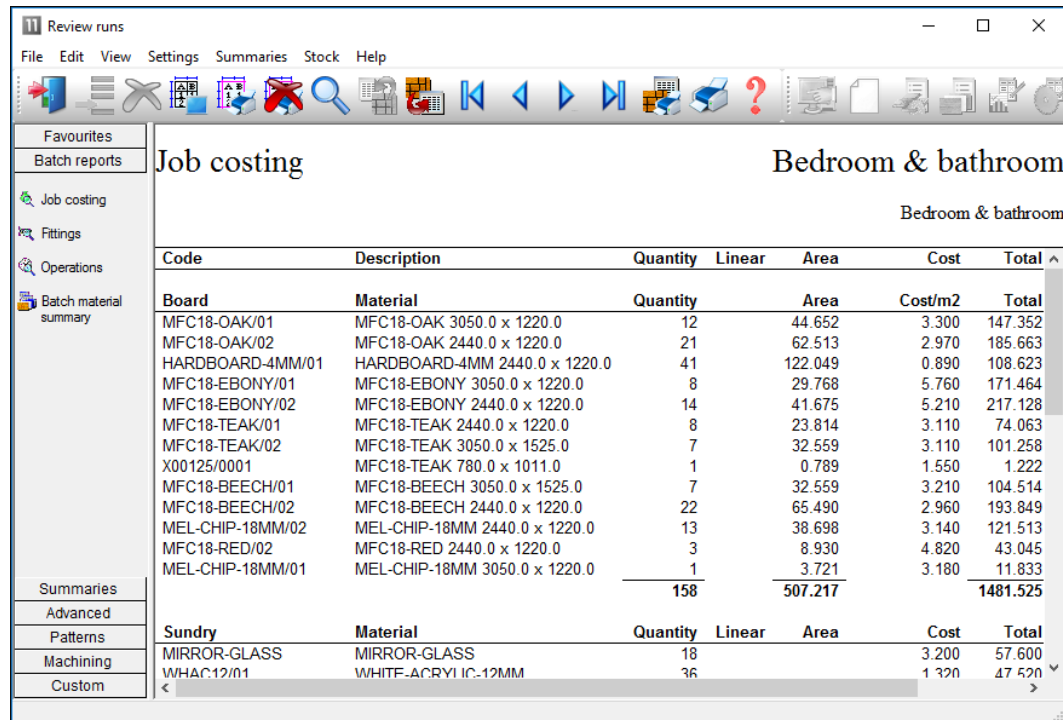
Description	Quantity	m2	m3	Weight	Percent	Rate	Cost	Statistic	Value
Required parts	72	34.20	0.51		75.97%			Number of patterns	14
Plus/Over parts	0	0.00	0.00		0.00%			Headcut patterns	2
Offcuts	14	5.83	0.10	42.00	12.95%			Rotated patterns	0
Scrap		4.99	0.08		11.08%			Recut patterns	8
Core trim		0.00	0.00		0.00%			Number of cycles	14
Boards	14	45.02	0.69	286.67	100.00%			Cutting length	177.8
								Throughput (M3/Hr)	0.6
								Waste (%Parts)	31.64%
								Waste (%Boards)	24.03%
Sheets used		45.02	0.69		100.00%		170.69		
Offcuts used		0.00	0.00		0.00%		0.00		
Offcuts created		-5.83	-0.10		-12.95%	0.000	0.00		
Net material used		39.19	0.59		87.05%		170.69		
Cutting time	1:04Hr					50.000	53.03		
Total parts	72	34.20	0.51	215.33	75.97%	6.542	223.72		
Sundry - unit usage	2					3.200	6.40		
Total sundry							6.40		

Product requirements - Management summary

The patterns and summaries can be reviewed and the data sent to the saw in the usual way.

Requirements report - You can print report for each optimised requirements list. This shows a complete breakdown of the products, parts and quantities for the requirements list.

Job costing report - Another useful report is the job costing report. This shows a full breakdown of the production costs, including material, fittings, edging, assembly operations etc.



Code	Description	Quantity	Linear	Area	Cost	Total
Board		Quantity		Area	Cost/m2	Total
MFC18-OAK/01	MFC18-OAK 3050.0 x 1220.0	12		44.652	3.300	147.352
MFC18-OAK/02	MFC18-OAK 2440.0 x 1220.0	21		62.513	2.970	185.663
HARDBOARD-4MM/01	HARDBOARD-4MM 2440.0 x 1220.0	41		122.049	0.890	108.623
MFC18-EBONY/01	MFC18-EBONY 3050.0 x 1220.0	8		29.768	5.760	171.464
MFC18-EBONY/02	MFC18-EBONY 2440.0 x 1220.0	14		41.675	5.210	217.128
MFC18-TEAK/01	MFC18-TEAK 2440.0 x 1220.0	8		23.814	3.110	74.063
MFC18-TEAK/02	MFC18-TEAK 3050.0 x 1525.0	7		32.559	3.110	101.258
X00125/0001	MFC18-TEAK 780.0 x 1011.0	1		0.789	1.550	1.222
MFC18-BEECH/01	MFC18-BEECH 3050.0 x 1525.0	7		32.559	3.210	104.514
MFC18-BEECH/02	MFC18-BEECH 2440.0 x 1220.0	22		65.490	2.960	193.849
MEL-CHIP-18MM/02	MEL-CHIP-18MM 2440.0 x 1220.0	13		38.698	3.140	121.513
MFC18-RED/02	MFC18-RED 2440.0 x 1220.0	3		8.930	4.820	43.045
MEL-CHIP-18MM/01	MEL-CHIP-18MM 3050.0 x 1220.0	1		3.721	3.180	11.833
		158		507.217		1481.525
Sundry		Quantity	Linear	Area	Cost	Total
MIRROR-GLASS	MIRROR-GLASS	18			3.200	57.600
WHAC12/01	WHITE-ACRYLIC-12MM	36			1.320	47.520

Job costing

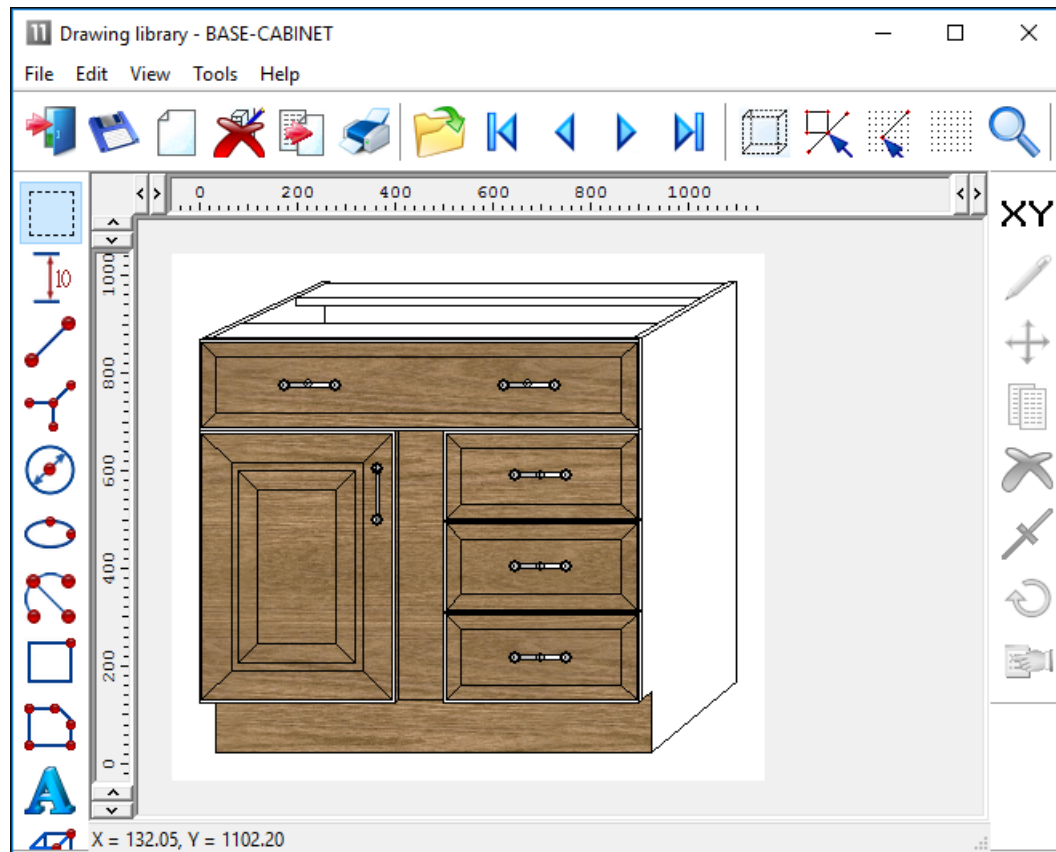
Drawing library

The program includes a drawing library for creating (or importing) drawings of parts and/or products. The advantage of the drawing library (compared to a picture or bitmap) is that the drawing can be scaled and can include more detail.

Drawings can be useful in easily identifying items and can be printed on labels and reports.

Both the part and product library screens have a box for displaying a drawing associated with the part or product. At the main screen:-

- Select: **Libraries - Drawing library**



Drawing library

The drawing library contains a set of general drawing tools to help draw the items and there are also specialist tools to quickly draw cabinets and other items in perspective. The tools include a full range of vector drawing tools, rectangle, arc, ellipse, lines ...

The same drawing can be assigned to one or more products in the product library if necessary.

If the drawing has the same code as a product in the product library is it automatically linked to that product.

The screenshot shows the 'Product library' window. At the top, there's a menu bar (File, Edit, Help) and a toolbar with icons for navigation and actions. The main area is divided into several sections:

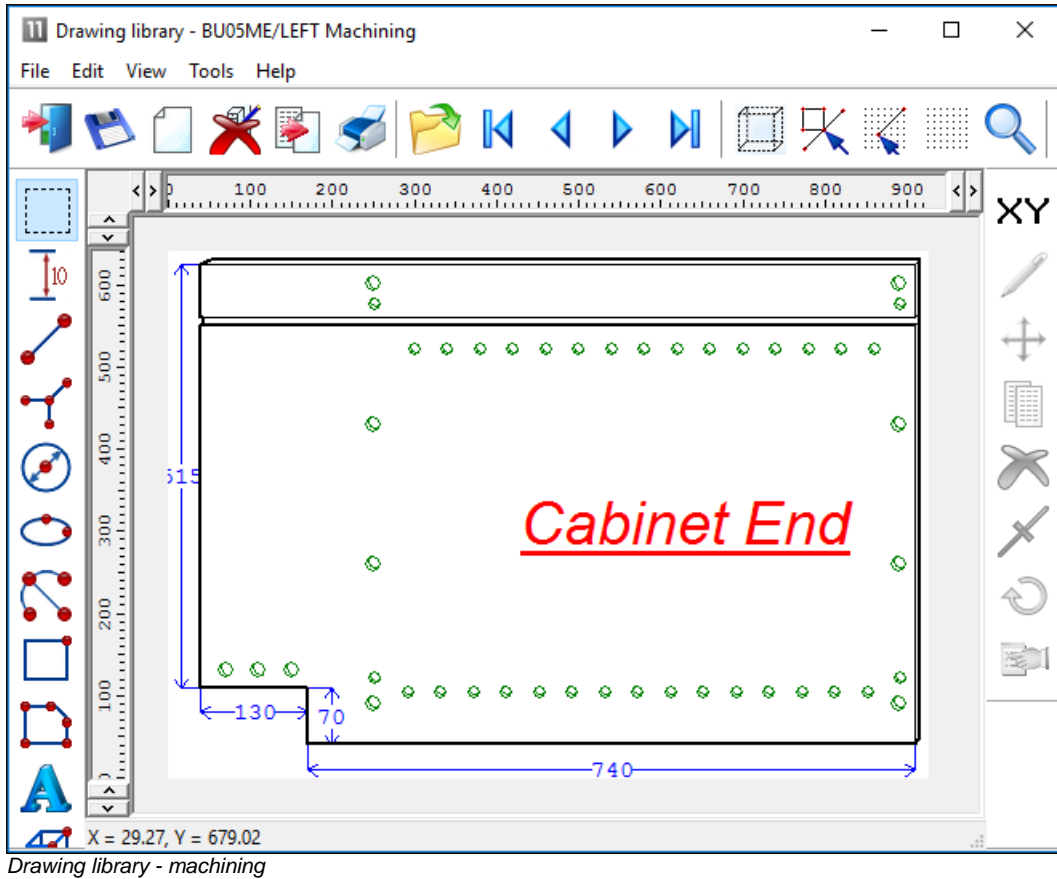
- Type:** Product
- Code:** BASE-CABINET
- Description:** Base unit - cabinet
- Dimensions:** X Width (900.0), Y Height (870.0), Z Depth (600.0)
- Price (fx):** =IF(X<=900,35.32,49.56)
- Memo:** A grid of 10 empty text boxes for notes.
- Buttons:** Add, Insert, Delete, Pats, Subs, fx, \$, View product, Build product
- Table:** A parts list table with columns: Part, Quantity / Time, Description, Material, Length, Width.

Part	Quantity / Time	Description	Material	Length	Width
1. BASE-CABINET-END-LEFT	1	Base cabinet end left	@ENDMAT_L@	=Z-T(@DOORMATERIA...	=Y
2. BASE-CABINET-END-RIGHT	1	Base cabinet end right	@ENDMAT_R@	=Z-T(@DOORMATERIA...	=Y
3. BASE-CABINET-DRAWER-L...	1	Base cabinet long drawer	@DOORMATERIAL@	=X	=&CABINET_DRAWER&
4. BASE-CABINET-DRAWER	3	Base cabinet drawer	@DOORMATERIAL@	=X/2-34	=&CABINET_DRAWER&-S
5. BASE-CABINET-DOOR	1	Base cabinet door	@DOORMATERIAL@	=X/2-50+T(@CARCASE...	=Y-18-@PH@-&CABINET_DRAWER&
6. BASE-CABINET-BOTTOM	1	Base cabinet base	@CARCASEMATERIAL@	=&INTERNAL_WIDTH&	=Z-T(@DOORMATERIAL@)
7. BASE-CABINET-RAIL-FRONT	2	Base cabinet rail front	@CARCASEMATERIAL@	=&INTERNAL_WIDTH&	=@PH@
8. BASE-CABINET-RAIL-BACK	1	Base cabinet rail back	@CARCASEMATERIAL@	=&INTERNAL_WIDTH&	=@PH@
9. BASE-CABINET-DIVIDER	1	Base cabinet divider	@CARCASEMATERIAL@	=Z-18-T(@BACKMATERI...	=Y-@PH@-&CABINET_DRAWER&-T[...
10. BASE-CABINET-FASCIA	1	Base cabinet fascia	@DOORMATERIAL@	100.0	=Y-@PH@-&CABINET_DRAWER&-T[...
11. BASE-BACK	1	Base unit back	@BACKMATERIAL@	=&INTERNAL_WIDTH&+...	=&BACK_PANEL_HEIGHT&
12. BASE-PLINTH	1	Base unit plinth	@DOORMATERIAL@	=&INTERNAL_WIDTH&	=@PH@

Drawing at Product library

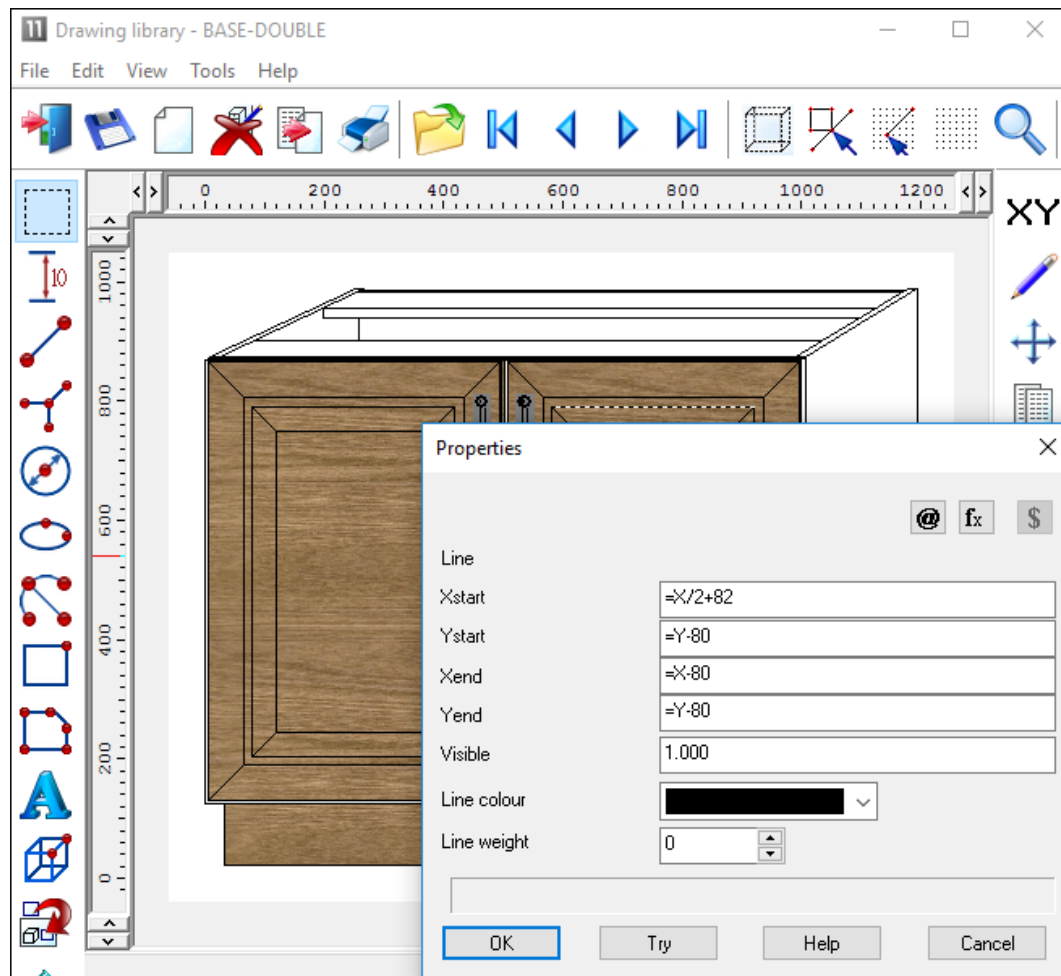
The drawing layout and tools are very flexible so a wide range of accurate drawings are possible.

For example, a perspective view of machining for a part.



The following drawing shows a detailed construction view.

This is a parametric drawing where the drawing is controlled by formula and is an exact representation of that item - including a perspective view



Drawing library - parametric drawing

For a parametric drawing each line is related to the overall product dimensions by a formula (set in the Properties dialog for the line or other drawing object). When the drawing is linked to a product the size of the drawing adjusts automatically.

There are also formula functions to express the perspective so that as the drawing changes size the perspective is still correct.

The drawings can also be exported as images.

8. Machining interface

Where parts contain additional machining such as grooves, routs, drilling and cut-outs the Machining interface module is used to create and store the part drawings (via the Machining library) and also send the correct machining instructions for each part to the CNC machining centres.

Most machining centre formats are supported including DXF, Homag/Weeke WoodWop, and other proprietary formats.

Machining drawings

The machining editor provides full facilities for creating machining drawings. A wide variety of machining functions are provided:-

- Saw groove
- Horizontal drilling
- Vertical drillings
- Cut-outs
- Arc router
- Circle router
- Pockets
- Contours
- Vacuum pods
- ...

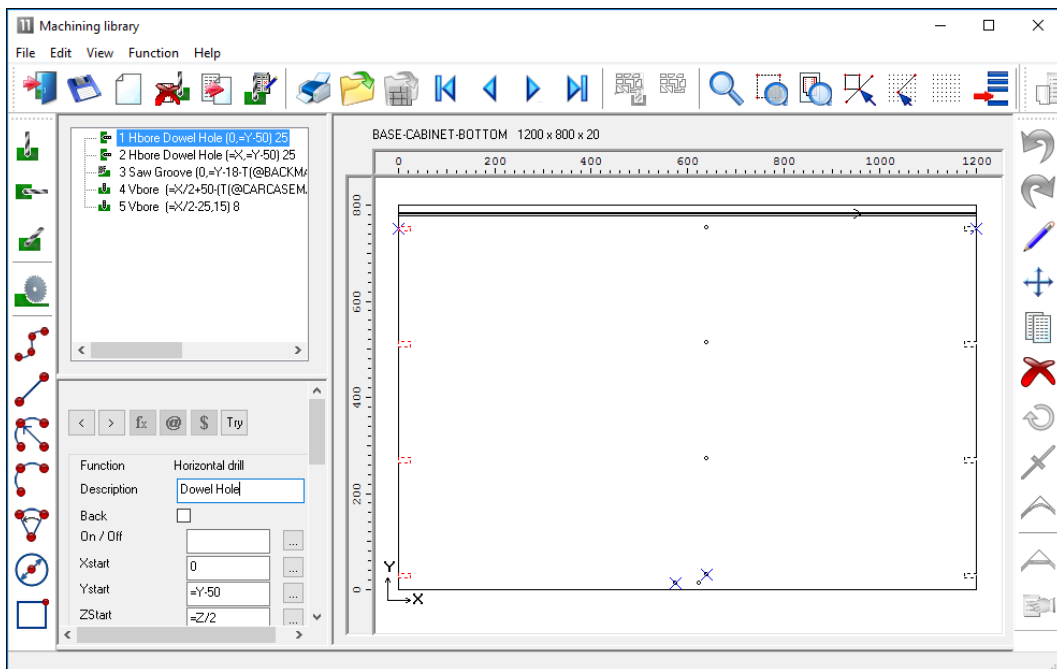
At the main screen:-

- Select: **Libraries - Machining library**
- or



Select the Toolbar symbol

The machining library dialog is displayed. Use the navigation buttons or list box to move to the required part drawing.



Machining library

The panes at the left show the details of each instruction and the full part is shown in the diagram at the right.

Drawings can be set up with formulae so they are fully parametric and automatically adjust if the part size changes. Common machining patterns can be dealt with by one drawing assigned to many different parts.

The above example shows a set of drilling and routing instructions for a part.

Machining Instructions - At the left of the screen is the FUNCTION toolbar to select the type of machining operation (such as drilling or routing).

Enter the details of each operation in the boxes to the right of the toolbar. The part drawing illustrating the machining is shown in the area to the far right of the screen. The drawing is built up as you enter machining operations.

For example, for a vertical drill operation enter the co-ordinates of the first hole - depth and diameter of the hole and the number, separation and direction of the repeated holes.

You can also enter the tool number and other machine specific details.

To move directly to a machine operation (for example to edit the details) click on the relevant part of the drawing. The current instruction is highlighted.

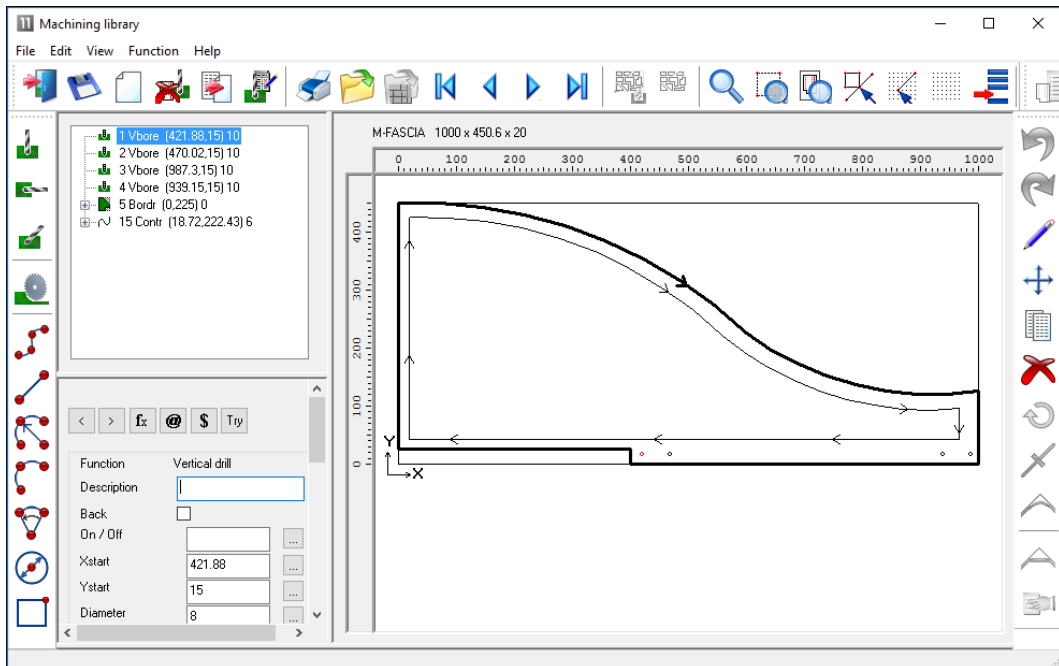
You can also use the mouse to enter instructions, for example, to specify the start and end of a groove.

External drawings – where the drawings are external files such as DXF or Homag/Weeke MPR(X) the Machining editor can still be used to view and adjust drawings and the drawing information is sent to a machining centre via the Machining Interface.

DXF drawings suitably layered can also be imported to the Machining library.

Shaped parts

The drawing editor allows for contours to define shaped parts.



Shaped parts

Each machining instruction can include extra tooling information to allow for tool speeds, tool path compensation etc.



Use the mouse to quickly draw the function and use the boxes at the left to add the detailed measurements where required.



Machining parameters

The transfer of machining data to CNC machines is set up via the following parameters:-

- Machining centre parameters
- Machining centre transfer parameters

The machining centre parameters set up the general features for the machining drawings/instructions such as the Drawing origin, and specific features for proprietary machines such as the 'Park mode' for Homag/Weeke WoodWop.

Machining centre parameters

The Machining centre transfer parameters control the transfer of data to the machining centre. File format, where files are located and whether there are separate files for Front and Back instructions.

No	Name	Type	Post transfer program	Edit
1.	woodWOP	8 - Homag/Weeke Woodwop V4/V5/V6/V7 (MPR/X)		...
2.	Nested	Group transfer		...
3.	Homag	8 - Homag/Weeke Woodwop V4/V5/V6/V7 (MPR/X)		...
4.	Nested DXF	9 - 2D DXF nested layered (DXF)		...
5.				...
6.				...
7.				...
8.				...
9.				...
10.				...
11.				...

Second screen reached via Edit button

Machining centre transfer parameters - 1: woodWOP ✕

Paths and Options General Machining operations Tooling replacement Help view >>

Path	Value	Subfolder
Parts	c:\v11.03\Demo\Mch\MPPR\Parts\	<input checked="" type="checkbox"/>
Back		<input checked="" type="checkbox"/>
Horizontal		<input checked="" type="checkbox"/>
Pattern	c:\v11.03\Demo\Mch\MPPR\Patterns\	<input checked="" type="checkbox"/>
CSV		<input type="checkbox"/>
PNX		<input type="checkbox"/>
Online label PC		<input type="checkbox"/>
Work list (LIS)		<input type="checkbox"/>
ABD (LIS)		<input type="checkbox"/>

Options

Warning None ▼

Parts - Use common transfer name

Back - create separate files

Horizontal - create separate files

Pattern - 8 digit filenames

PNX - encoding ASCII ▼

Machining centre transfer parameters

A wide range of transfer formats are supported:-

Homag/Weeke WoodWop V4/V5/V6/V7 (MPR(X))
Homag Weeke WoodWop V2.5 (MPR)
2D DXF non layered
2D DXF layered
D DXF layered
Biesse RoverCad (CID)
Morbidelli Aspan V3.2 (ASC)
Morbidelli Aspan V4.0 (ASC)
Busellato Autolink (DXF)
ASCII/Unicode PTX
MDB PTX
Machining Program Interface (MPI) file
Xilog (XXL)
Biesse (CIX)

The machining centre transfer parameters also include a 'Tooling replacement table', so that tooling instructions can be translated to a specific format for a machine. This allows for a single set of drawings which can then be interpreted for different CNC machines.

Machining centre transfer parameters - 1: woodWOP [X]

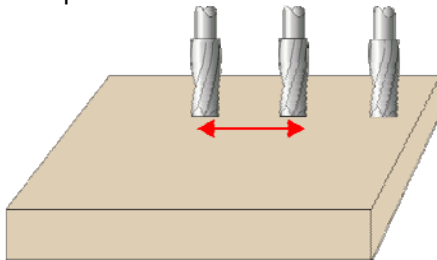
Paths and Options | General | Machining operations | Tooling replacement [Help view >>]

No	Instruction	Replacement	Material
1.	DDWEL	T=7:EM=0	
2.	T=1	T=101	
3.			
4.			
5.			
6.			
7.			
8.			
9.			
10.			
11.			
12.			
13.			
14.			
15.			
16.			
17.			
18.			
19.			
20.			

[OK] [Print] [Help] [Cancel]

Machining centre transfer parameters Tooling

For most parameters there is a clear picture of the setting involved and examples of the set up.



Tooling

Machining summary and costs

The costing for a job includes the machining times and costs.

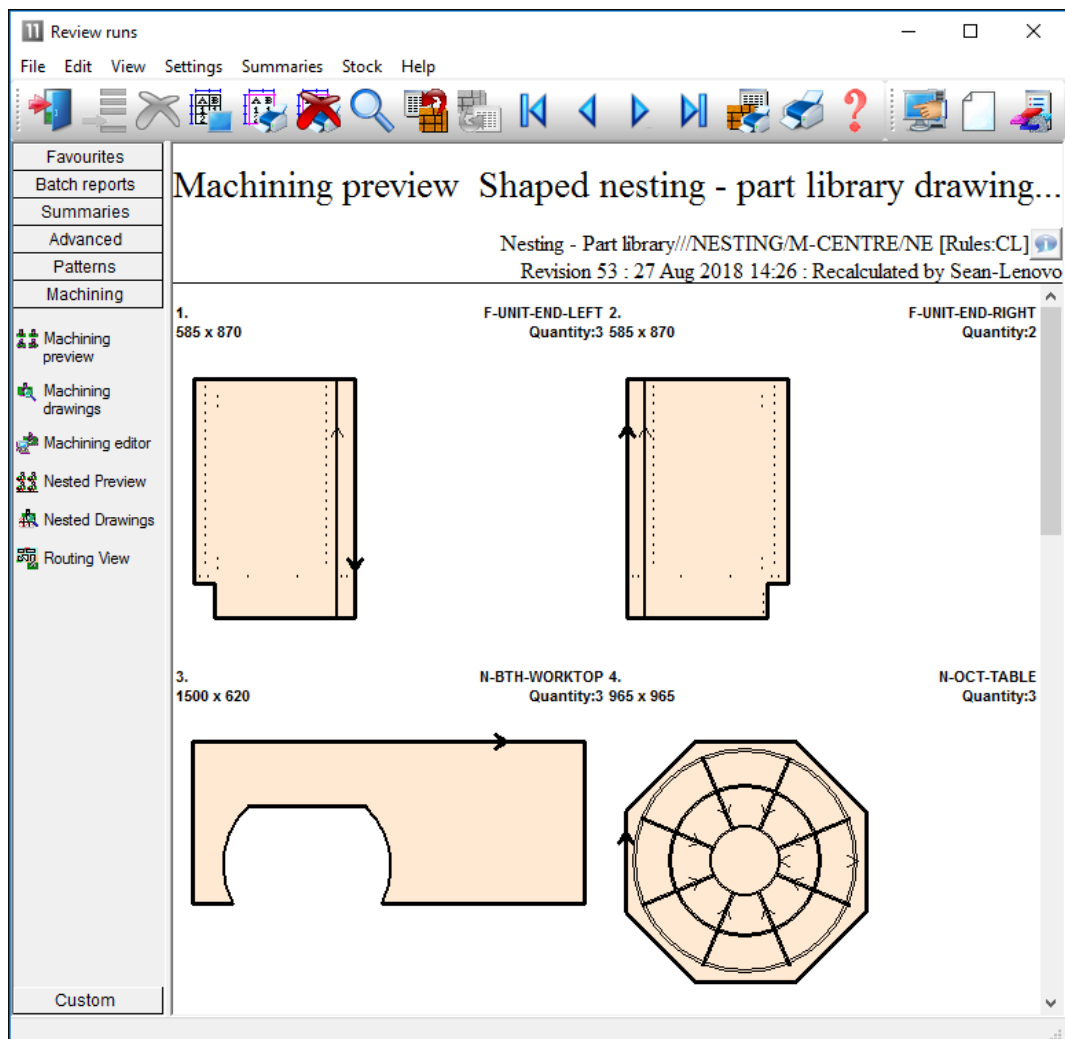
The screenshot shows the 'Review runs' application window. The title bar reads 'Review runs'. The menu bar includes 'File', 'Edit', 'View', 'Settings', 'Summaries', 'Stock', and 'Help'. The toolbar contains various icons for navigation and editing. On the left, a sidebar lists 'Favourites' and 'Batch reports' with sub-items: 'Job costing', 'Fittings', 'Operations', and 'Batch material summary'. The main area displays 'Job costing' for 'ShapedNesting'. Below this, there are two tables. The first table shows material usage for boards, and the second table shows operation times and costs.

Code	Description	Quantity	Linear	Area	Cost	Total
Board	Material	Quantity		Area	Cost/m2	Total
MEL-CHIP-15MM/01	MEL-CHIP-15MM 3050.0 x 1220.0	5		18.605	2.590	48.187
MEL-CHIP-15MM/02	MEL-CHIP-15MM 2440.0 x 1220.0	1		2.977	2.560	7.621
		6		21.582		55.808
Operation	Description	hh:mm		Cost per hour		Total
Nesting		1:10		50.000		58.069
Total						113.877

Machining job costing report

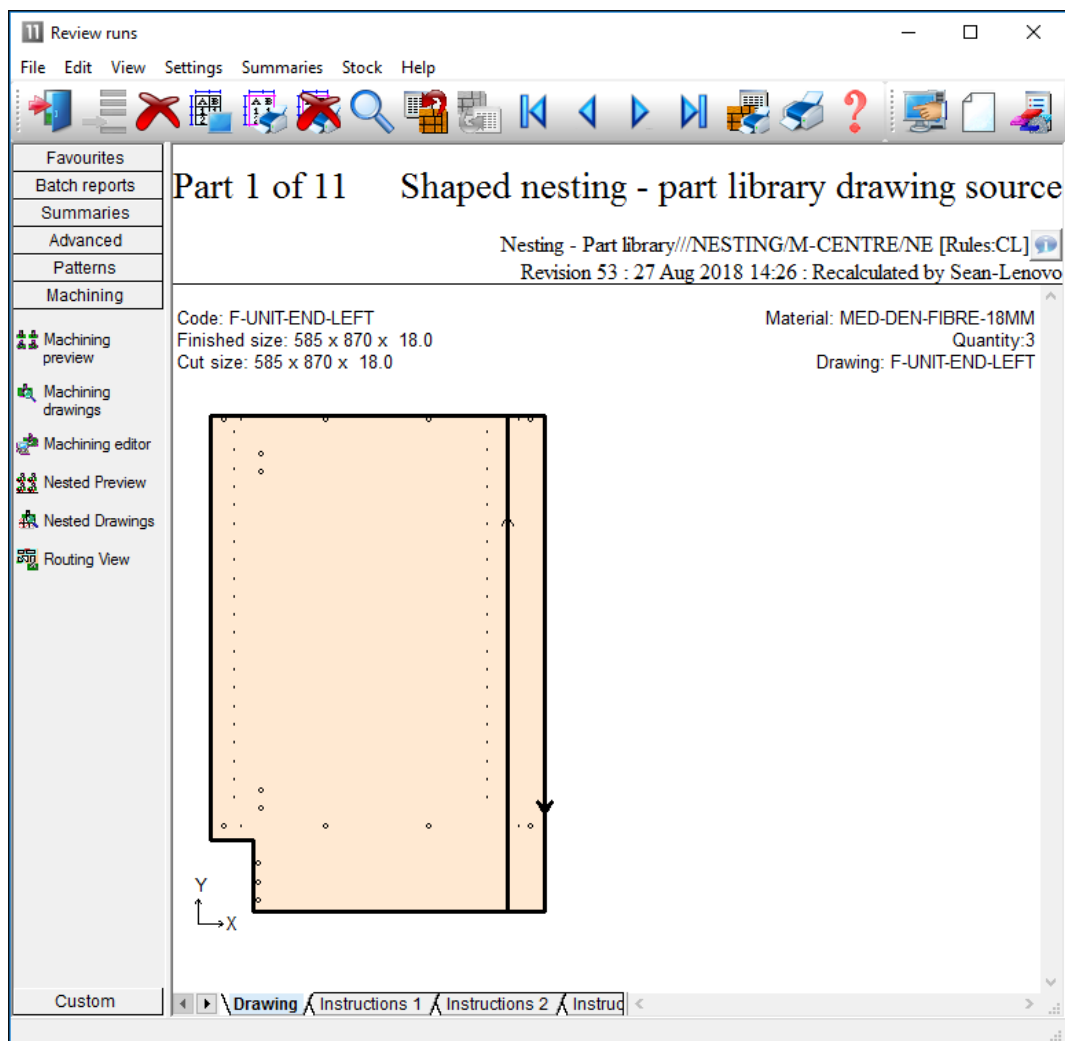
The job summary includes the machining drawings (with all dimensions resolved and calculated) and reports for each type of instruction. The machining can be checked at the Review runs screen:-

- Select: Machining in the stacked ToolBar
- Select: **Machining Preview**



Machining preview

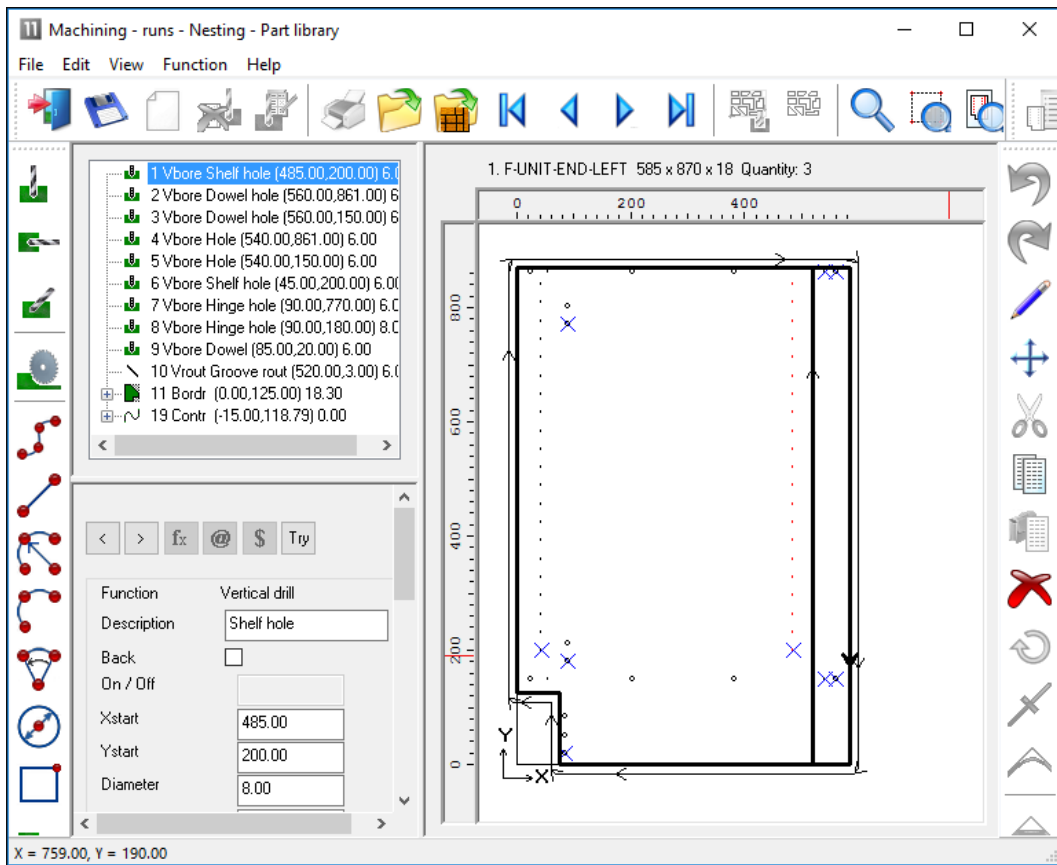
- Click on a part to move to the machining drawing



Machining details for a part

At this stage all the machine instructions have been fully calculated and set to absolute numbers ready for transfer to the machining centre. It is possible to make last minute changes to instructions; e.g. to exclude an instruction or change an offset.

- Click on the drawing to move to the editor.



Machining - edit part drawing

The instruction pane at the left shows how all the instructions are converted to absolute values.









- Click on the tabs at the foot of the part drawing to see more details on the instructions for each part.

The screenshot shows a software window titled "Review runs" with a menu bar (File, Edit, View, Settings, Summaries, Stock, Help) and a toolbar. The main area displays "Part 1 of 11 Shaped nesting - part library drawing source" and "Nesting - Part library///NESTING/M-CENTRE/NE [Rules:CL]". Below this is a table of machining instructions with columns: No, Fn, Description, Xstart, Ystart, Diameter, Wid/ang, Depth, Offset, Rpt, Dir, Tool. The table lists 9 instructions, including Vbore Shelf holes, Dowel holes, and Hinge holes. At the bottom, there are navigation tabs for "Custom", "Drawing", "Instructions 1", "Instructions 2", and "Instrug".

No	Fn	Description	Xstart	Ystart	Diameter	Wid/ang	Depth	Offset	Rpt	Dir	Tool
001	Vbore	Shelf hole	485	200	8		6	32	20	0	
002	Vbore	Dowel hole	560	861	10		6	178.33	3	L	
003	Vbore	Dowel hole	560	150	10		6	178.33	3	L	
004	Vbore	Hole	540	861	8		6	485	1	L	
005	Vbore	Hole	540	150	8		6	485	1	L	
006	Vbore	Shelf hole	45	200	8		6	32	20	0	
007	Vbore	Hinge hole	90	770	10		6	32	1	0	
008	Vbore	Hinge hole	90	180	10		8	32	1	0	
009	Vbore	Dowel	85	20	10		6	32	2	0	

Machining - instructions

Route cards or labels for each machined parts can be printed at the office.

Optimised Parts				
Run: Nesting - Part library				
Edgebander setup time: 0:00		Saw setup time: 0:00		
Part code: F-UNIT-END-LEFT Material code: MED-DEN-FIBRE-18MM Length: 585.0 Width: 870.0 Quantity: 3 Non Grained Ref. Code: MEDF-U3		Bottom edge: Top edge: Left edge: WHITE-TAPE-22MM Right edge:	Drawing name: 0011429F Part Volume: LOW	
Part code: F-UNIT-END-RIGHT Material code: MED-DEN-FIBRE-18MM Length: 585.0 Width: 870.0 Quantity: 2 Non Grained Ref. Code: MEDF-U2		Bottom edge: Top edge: Left edge: Right edge: WHITE-TAPE-22MM	Drawing name: 0011430F Part Volume: LOW	
Part code: N-BTH-WORKTOP Material code: MED-DEN-FIBRE-18MM Length: 1500.0 Width: 620.0 Quantity: 3 Non Grained Ref. Code: MEDN-B3		Bottom edge: Top edge: Left edge: Right edge:	Drawing name: 0011431F Part Volume: LOW	
Part code: N-OCT-TABLE Material code: MED-DEN-FIBRE-25MM Length: 965.0 Width: 965.0 Quantity: 3 Non Grained Ref. Code: MEDN-O3		Bottom edge: Top edge: Left edge: Right edge:	Drawing name: 0011432F Part Volume: LOW	

Machining - parts and labels

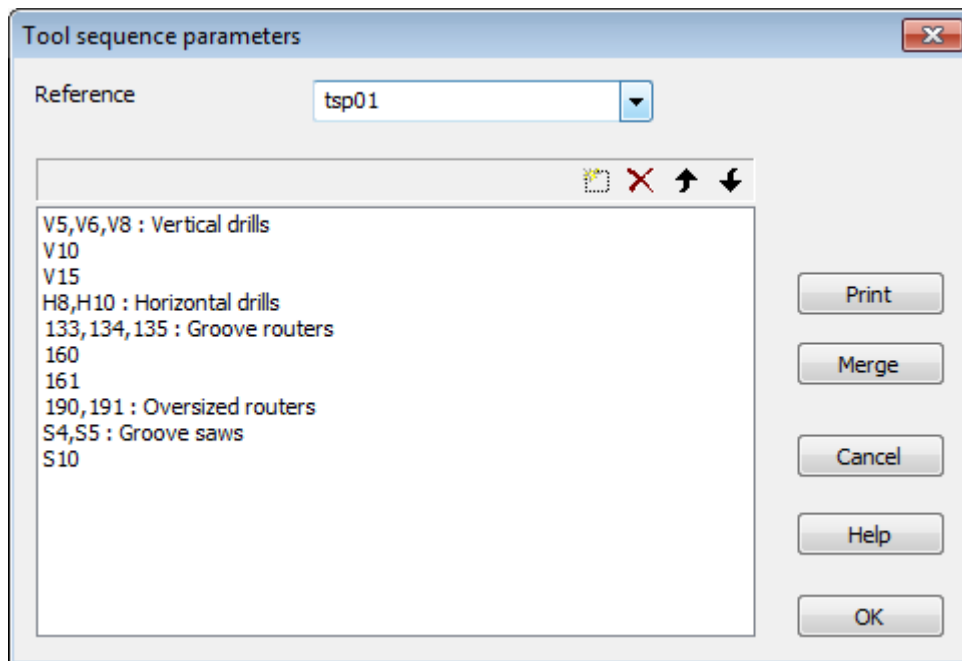
External drawings

The drawing editor and transfer of data to a CNC machine can be integrated with the use of external drawing files such as DXF and MPR(X). In this case the stand-alone drawings can be used with parts so items do not have to be duplicated in the machining library or drawn twice.

After optimisation all the instructions are converted to fixed values so minor adjustments are easy to make and this does not affect the stored drawing in the machining library.

Tool optimisation

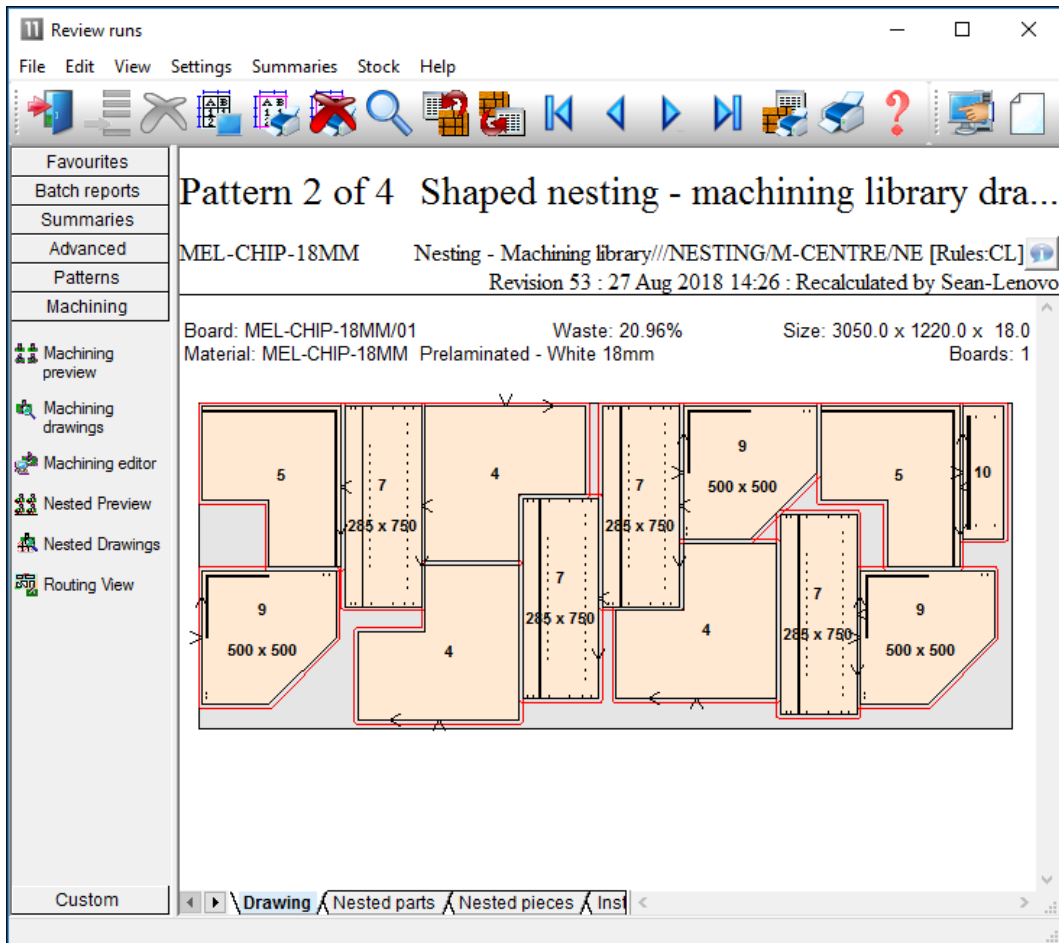
The program includes tool optimisation which minimizes the distance travelled for each set of tooling. This is calculated as the information is transferred to the machining centre. Use the 'Tool Sequence parameters' to set up the rules for tool optimisation.



Tool sequence parameters

9. Nesting Optimiser (NE)

A nested pattern is a pattern which is divided (and parts are machined) at a Machining centre. It can include shaped and non-shaped parts depending on the type of Nesting chosen.



Nesting optimising - pattern

The pattern layouts produced by the nesting optimisers reflect the different cutting methods and parts may include machining instructions.

There are different types of Optimiser used for nesting.

- Rectangular nesting
- Shaped nesting

- For rectangular nesting each part is placed on a pattern within a rectangular area. For shaped nesting parts can overlap the rectangular area around each part and be placed at an angle to each other.

- The choice of Nesting optimiser type is set via the Nesting parameters. Each part list is optimised with a specific nesting parameter list..

- Generated patterns (and parts) can be checked and edited in Review runs.

- For the Nesting optimiser types the patterns are generated for transfer to a *Machining centre*.

The Nesting module provides all the facilities and features to create and use nested patterns..

- *Enter part sizes*
- *Optimise*
- *Send cutting data to machining centre*

Part sizes

The starting point of optimisation is a list of part sizes and/or drawings. This can be produced in a variety of ways

- Use external part files (MPR(X))
- Enter rectangular parts in the Part list grid
- Use parts from the Machining library

The result is a list of part sizes with attached drawings (where required).

	Description	Material	Length	Width	Quantity	Grain	Face Laminate	Back Laminate	Inf
Global									
1.	CORNER-BOTTOM	MEL-CHIP-18MM	520.0	600.0	9	N			
2.	CORNER-BOTTOM	MEL-CHIP-18MM	750.0	700.0	8	N			
3.	CORNER-SHELF	MEL-CHIP-18MM	490.0	570.0	4	N			
4.	CORNER-SHELF	MEL-CHIP-18MM	580.0	600.0	7	N			
5.	CORNER-TOP	MEL-CHIP-18MM	520.0	600.0	6	N			
6.	CORNER-TOP								
7.	F-WALL-UNIT-END								
8.	F-WALL-UNIT-BASE								
9.	N-SHELF-ANGLE-L								
10.	F-UNIT-DRAWER								
11.	N-CS-SPAR								
12.									

Variable	Value	Comment
Door Material	MFC18-OAK	
Carcase Material	MEL-CHIP-18M	
Back Material	HARDBOARD-	
Corner door length	250.0	

Nesting - part list entry










In this example the drawings for parts are stored in the machining library.

The NE optimiser includes the Machining editor and library for creating drawing templates and making changes to drawings but it cannot be used for creating and storing part drawings.



Materials

All materials are stored in the Board library. This is a database of all sheet material and includes quantities and costs. The Board library stores a record for each material and a record for each board size (including any offcuts) for each material type.

Board library													
Materials													
Material	Description	Thickness	Default grain	Book	Material	Picture	Type	Density					
MFC18-ASH	Prelaminated - Ash 18mm	18.0	Y	0			MFC	0.400					
MFC18-BEECH	Prelaminated - Beech 18mm	18.0	Y	0			MFC	0.400					
MFC18-BLACK	Prelaminated - Black 18mm	18.0	N	0			MFC	0.400					
MFC18-EBONY	Prelaminated - Ebony 18mm	18.0	Y	0			MFC	0.400					
MFC18-OAK	Prelaminated - Oak 18mm	18.0	Y	0			MFC	0.400					
MFC18-RED	Prelaminated - Red 18mm	18.0	N	0			MFC	0.400					
MFC18-TEAK	Prelaminated - Teak 18mm	18.0	Y	0			MFC	0.400					
MIRROR-GLASS	Mirror Glass (sundy)	5.0	N	0			Sundy	0.000					
OAK MDF 18MM	Medium Density Fibreboard - Oak 18mm	18.0	Y	0			MDF	0.650					

Boards for material: MFC18-TEAK Prelaminated - Teak 18mm Thickness:18.0 Book:0															
Board code	Type	Length	Width	Informati	Stock	Res	Order	Cost	Limit	Bin	Supplier	Min Stk	ReOrd	Grain	Paramet
MFC18-TEAK/01		2440.0	1220.0		1020	0	120	3.110	0			120	150	Y	
MFC18-TEAK/02		3050.0	1525.0		955	0	0	3.110	0			80	100	Y	
X00125/0001	X	780.0	1011.0		1	0	0	1.550	0			0		Y	
X00135/0003	X	564.0	488.0		2	0	0	1.550	0			0		Y	
X00148/0001	X	950.0	620.0		1	0	0	1.550	0			0		Y	

Nesting - Board library

In this example the material MFC18-TEAK has two available board sizes 3050.0 x 1525.0 and 2440.0 x 1220.0 and several offcuts.

The Material column in the Part list associates each part with the correct material to use and the optimiser selects the optimum board sizes to use for each job.

Nested optimising

Part sizes are optimised to produce a set of patterns for machining. Part lists can be optimised singly or in a batch.

The first summary shown for each job is an overview of cutting and costs.

Management summary Shaped nesting - machining library ...

MEL-CHIP-18MM Nesting - Machining library///NESTING/M-CENTRE/NE [Rules:CL]

Revision 53 : 27 Aug 2018 14:26 : Recalculated by Sean-Lenovo

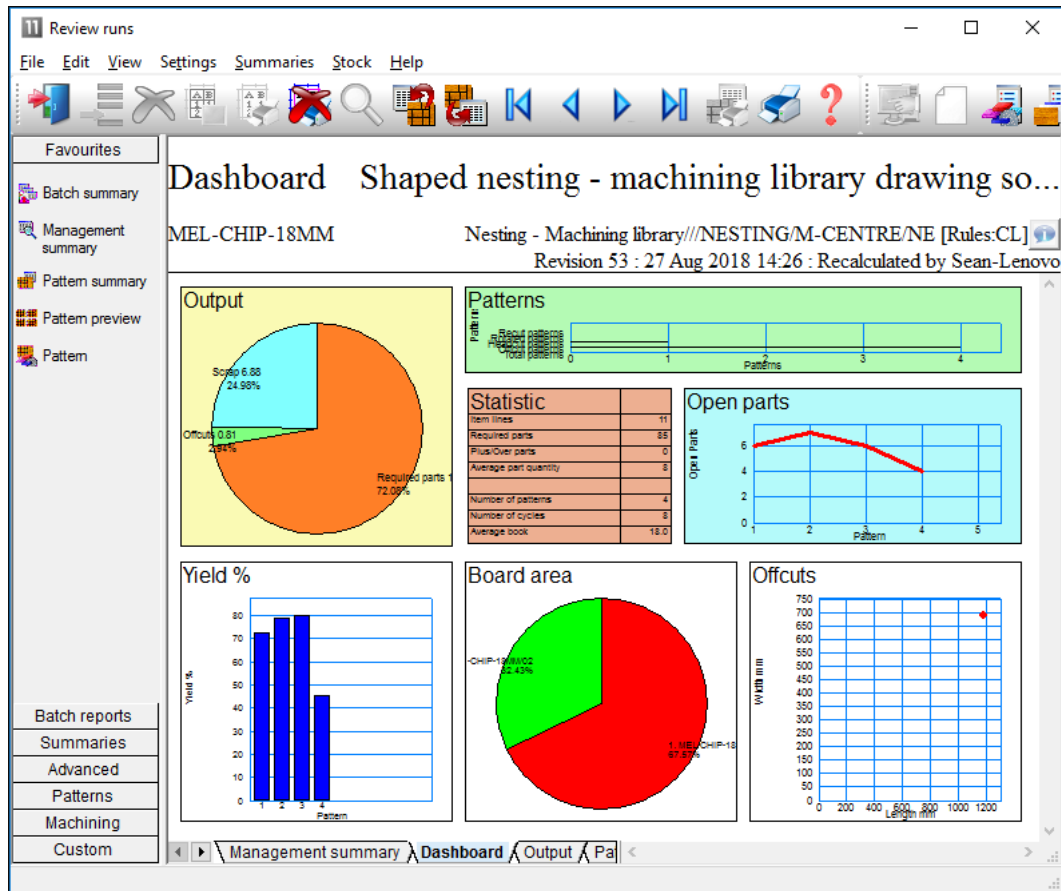
Description	Quantity	m2	m3	Weight	Percent	Rate	Cost	Statistic
Required parts	85	19.85	0.36		72.08%			Number of patterns
Plus/Over parts	0	0.00	0.00		0.00%			Headcut patterns
Offcuts	1	0.81	0.01	7.32	2.94%			Rotated patterns
Scrap	6.88	0.13			24.98%			Recut patterns
Core trim		0.00	0.00		0.00%			Number of cycles
Boards	8	27.54	0.50	247.82	100.00%			Cutting length
								Throughput (M3/Hr)
								Waste (%Parts) 38
								Waste (%Boards) 21
Sheets used		27.54	0.50		100.00%		87.21	
Offcuts used		0.00	0.00		0.00%		0.00	
Offcuts created		-0.81	-0.01		-2.94%	0.000	0.00	
Net material used		26.73	0.49		97.06%		87.21	
Cutting time	1:33Hr					0.000	0.00	
Total parts	85	19.85	0.36	178.65	72.08%	4.393	87.21	

Batch reports
Summaries
Advanced
Patterns
Machining
Custom

Management summary Dashboard Output Pa

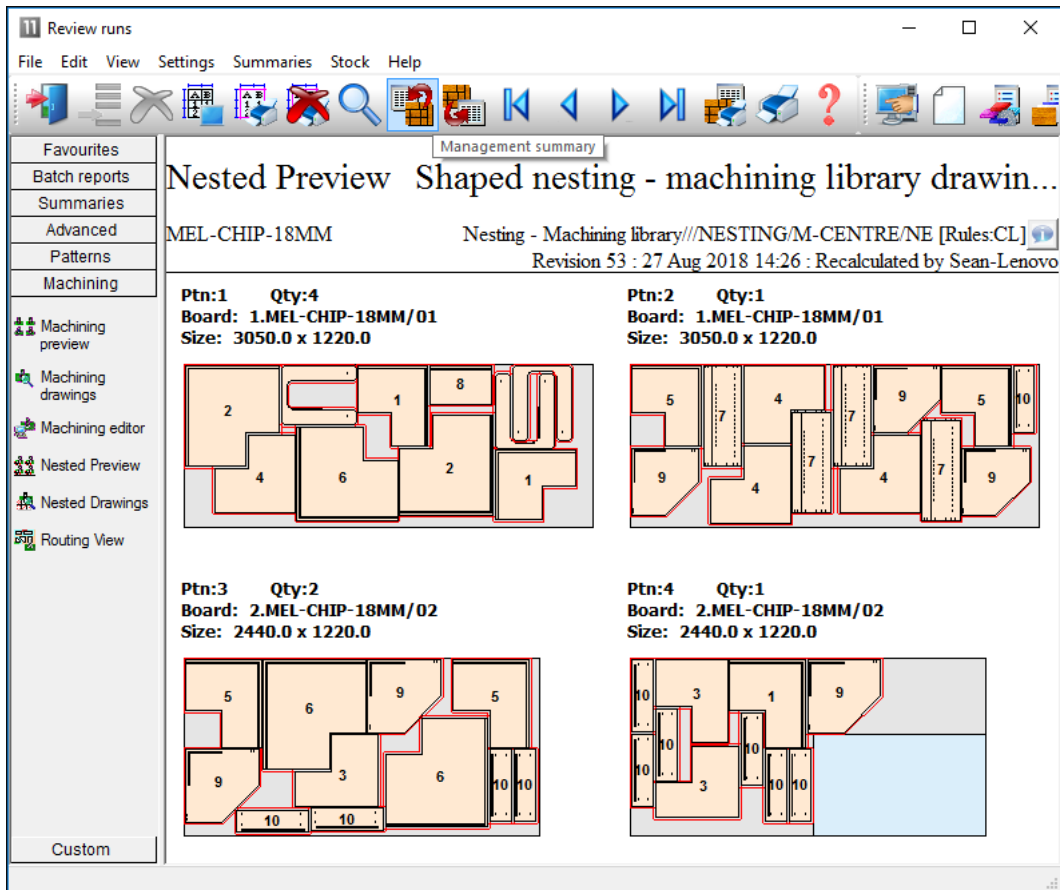
Nesting - Management summary

The summary includes a Dashboard showing charts of selected (custom) portions of the data.



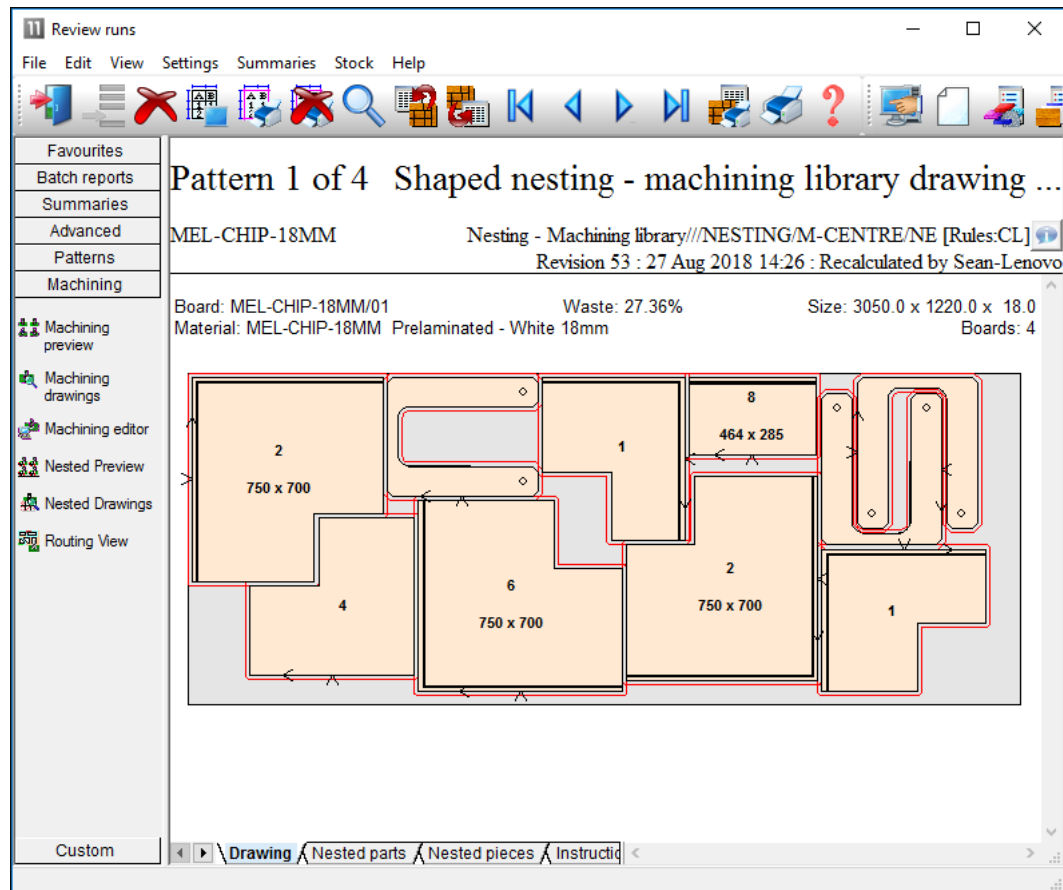
Nesting - Dashboard

The cutting patterns are shown in a thumbnail view.



Nesting - pattern preview

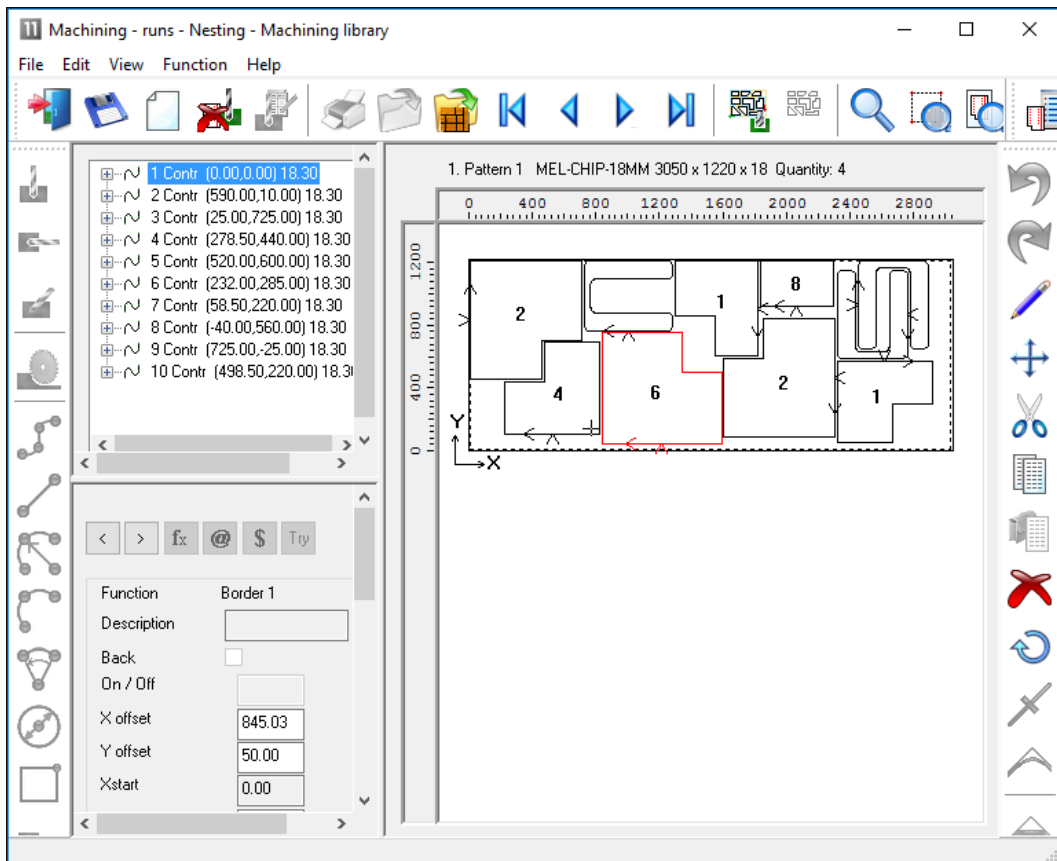
Click on a thumbnail to see the pattern in full screen view.



Nesting - pattern

Further information about the cutting pattern is on the tabs at the foot of the drawing.

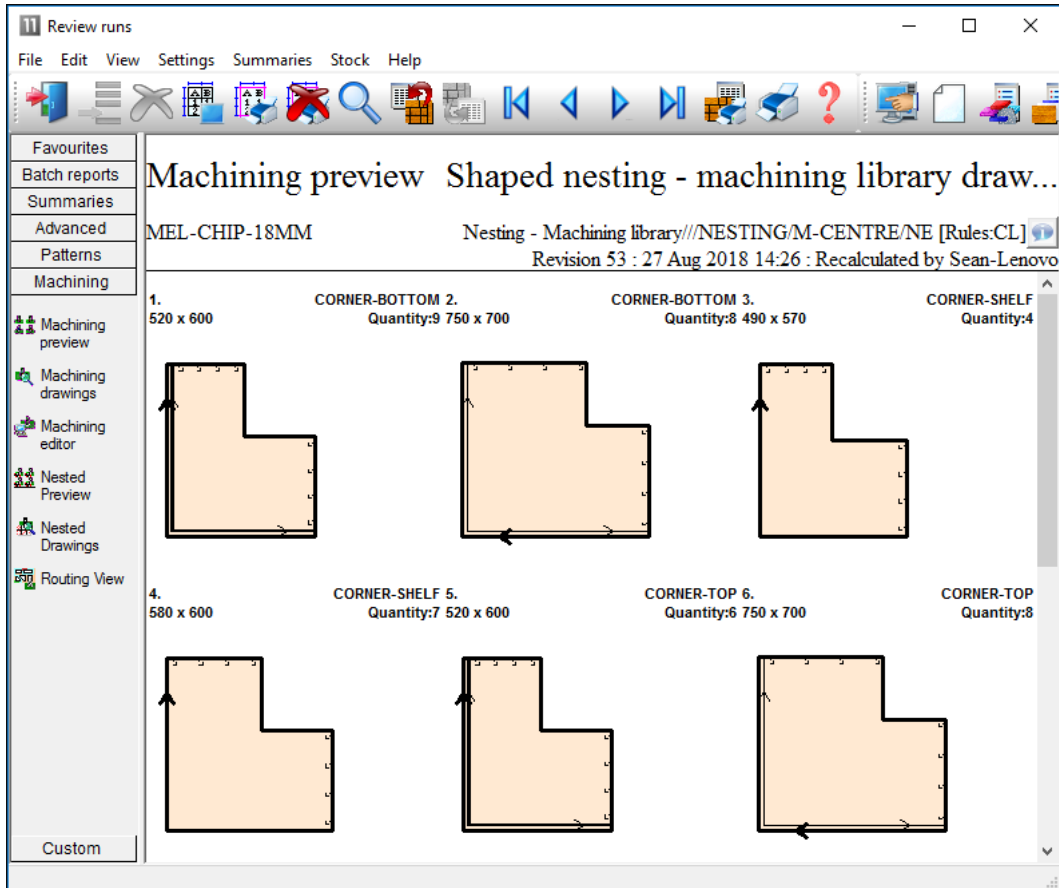
Use the machining editor to check the details and make any last minute changes to the cutting plan.



Nesting - edit pattern

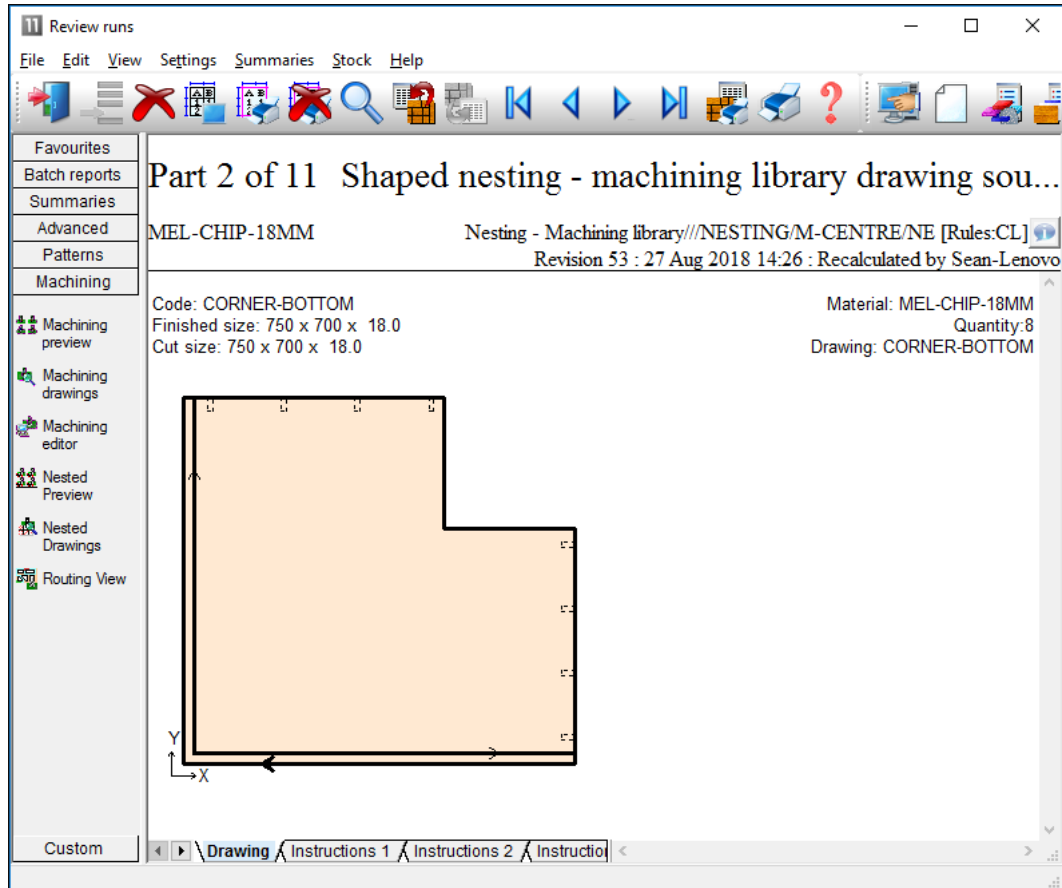
Parts can be moved or deleted and minor changes can be made to the borders. The machining instructions for each part (drilling, routing ...) can also be viewed at each part drawing.

The machining for each part can also be reviewed.



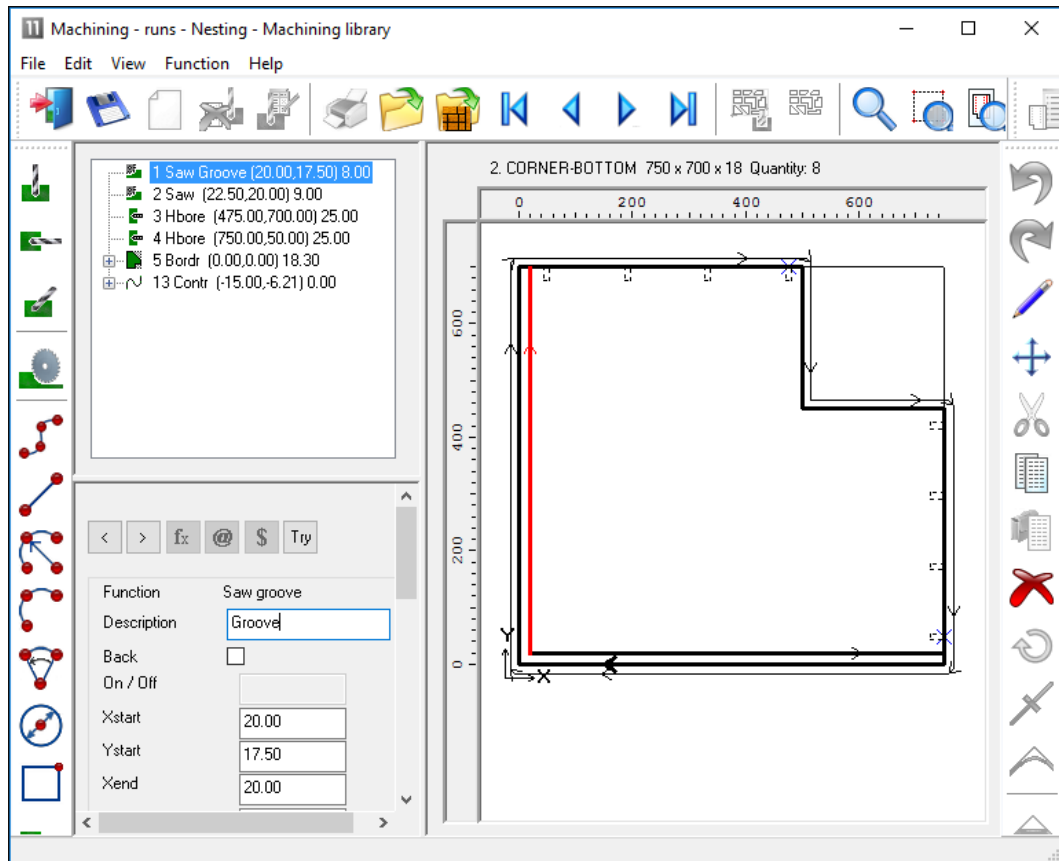
Machining for parts

Click on a part to review the details.



Shaped nesting review

- Click on a part to move to the editor.

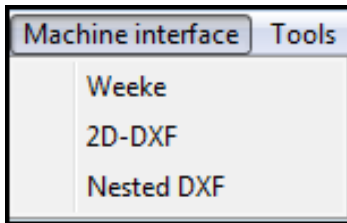


Shaped nesting edit

At this stage all instructions have been converted to absolute values ready for transfer to the machining centre.

Transfer to Machining centre

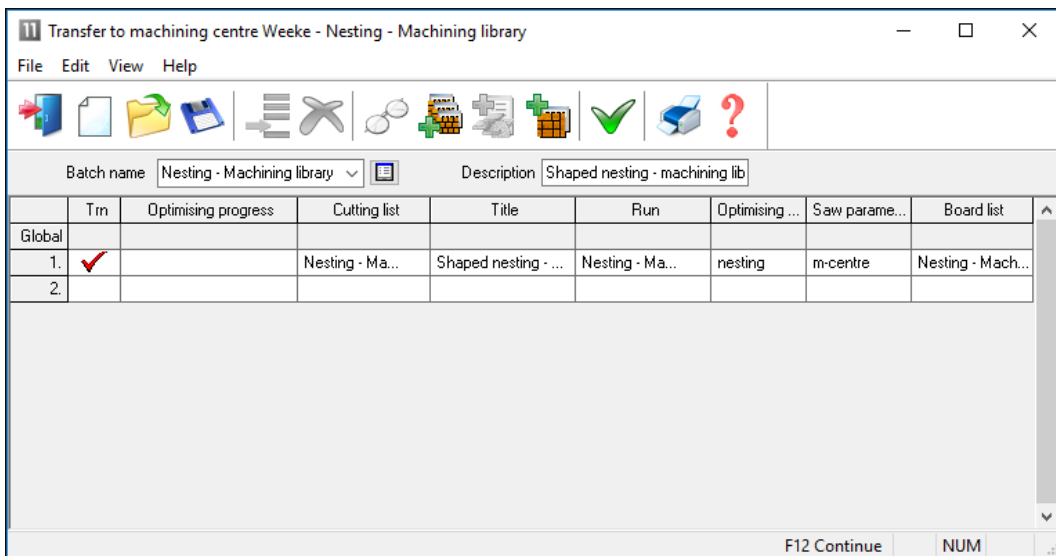
To transfer the drawings to a machining centre at the main screen select 'Machine Interface' and then select the Machining centre, for example, Homag/Weeke.



Machining interface menu

Links to a variety of machining centres are available also to industry standard formats such as 2D Dxf.

The program displays the data to transfer (default is the current batch) - use the options to choose other batches or runs.



Transfer to machining centre

The program keeps track of transfers and a run is marked with a tick if it has already been sent; the rules for tracking can be customised.



Select the tick to continue

After transfer the program returns to the main menu.

Nesting with MPR(X) files



Homag/Weeke WoodWop

The Nesting optimiser is fully integrated with the Homag/Weeke WoodWop system. MPR(X) based parts can be used in the Part list and cutting patterns produced to download to the Machining centre. The part list can be set to use MPR(X) parts as the source.

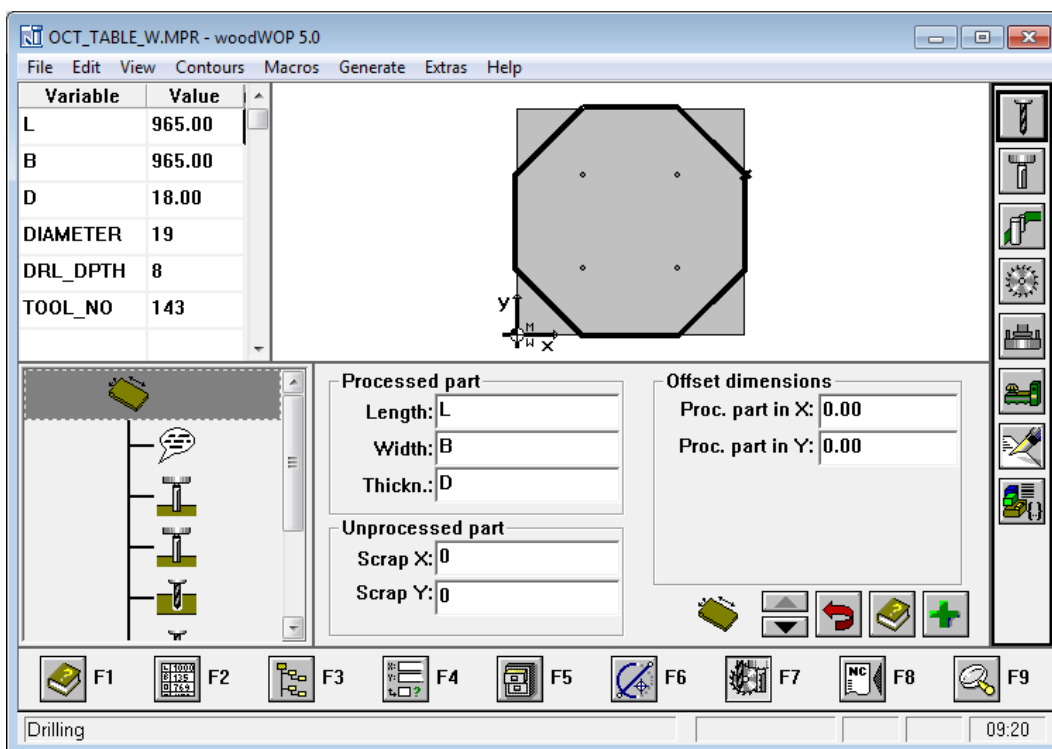
The screenshot shows the 'Part list - MPRShapes01' window with a table of parts and a drawing window for 'N_SHELF_ANGLE_R_W'.

	Description	Material	Length	Width	Quantity	Grain	Edge Left	Edge Right	Inf
Global									
1.	N_SHELF_CUTOUT_W	CHIPBOARD-18MM	670.0	420.0	1	N			
2.	N_SHELF_RECTANGLE_W	CHIPBOARD-18MM	800.0	300.0	1	N			
3.	N_SHELF_ANGLE_R_W	CHIPBOARD-18MM	780.0	300.0	1	N			
4.	N...								
5.	F...								
6.	N...								

Variable	Value	Comment
L	780	length in X
B	300	width in Y
D	18	thickness in Z

Nesting MPR(X) - part list

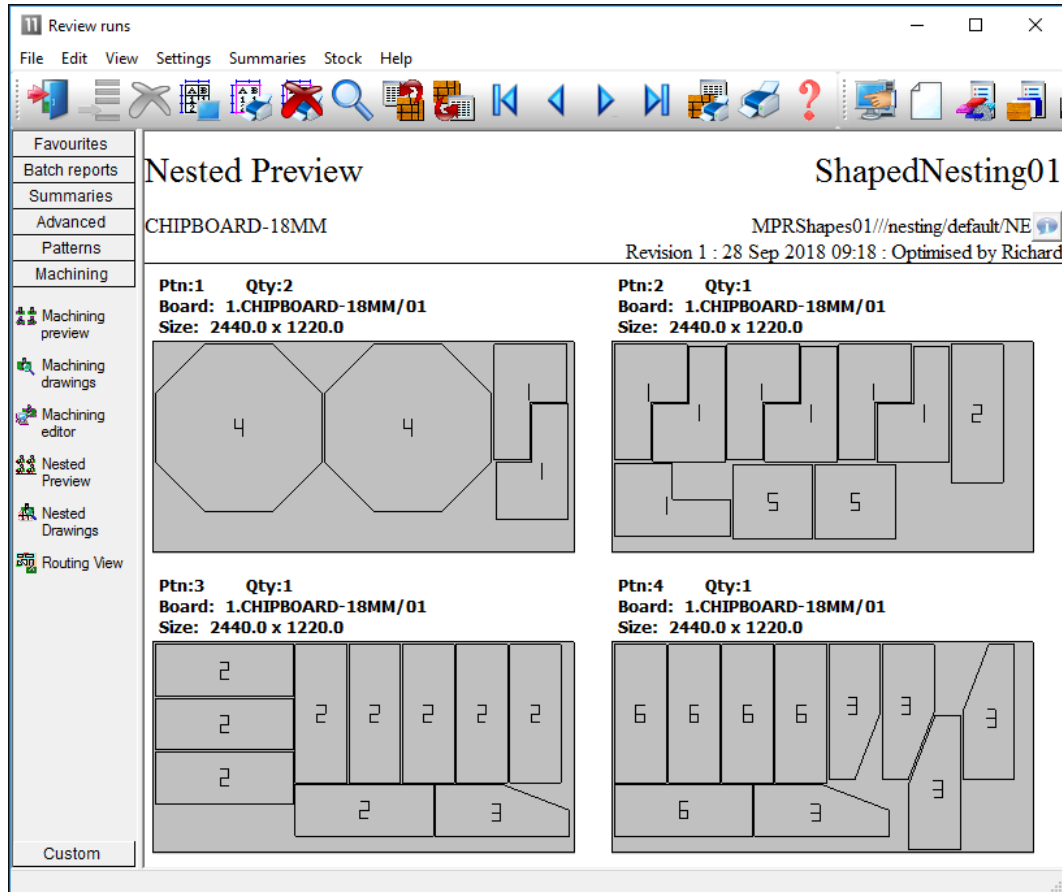
Where the NE module is used with Homag/Weeke WoodWop the program automatically moves to the WoodWop editor when editing individual MPR(X) parts.



Nesting - WoodWop editor

When working in this way the parts are edited via Homag/Weeke WoodWop and the patterns can be adjusted via the Nesting optimiser editor.

The optimised result is a set of cutting patterns including the MPR(X) parts.



Nesting - pattern preview

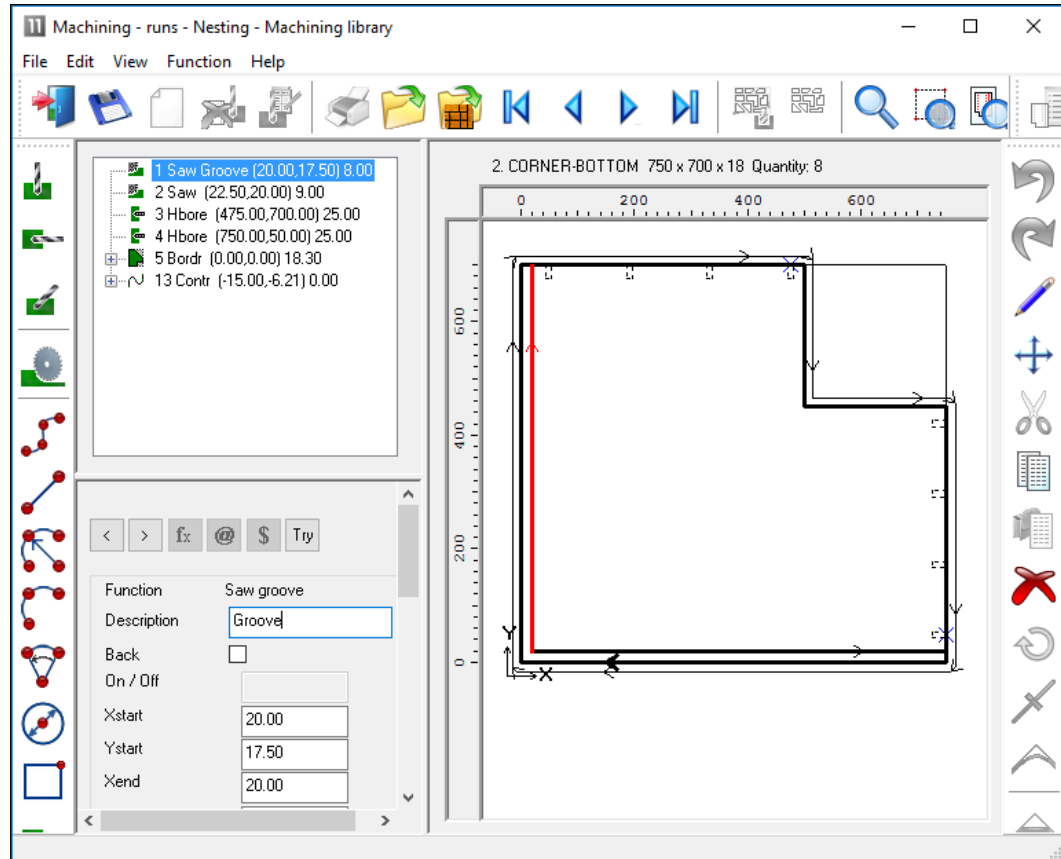
- The editors should only be used for minor or last minute changes - if there are substantial changes then it is better to re-optimize the job as the balance of waste and costs may have changed significantly.

The Power of Nesting optimising

Defining shaped parts

Shaped parts are defined by drawing contours that define the shape of part. This is done at the Machining library or via an MPR(X) file using Homag/Weeke WoodWop.

At the Machining library use the *Border* function to define the shape of the part.



Nesting optimising - define shaped parts

If a Safety border is required this is added as a contour surrounding the shaped part and is set as a safety border by checking the Safety box in the contour function.

For an MPR(X) file two closed contours are required (similar to the above) to define the shape of the part and the safety border. Check the 'Nesting contour' option for the first contour and the 'Nesting safety distance' option for the second contour.

If a safety border is not defined the Nesting parameter 'Nesting safety distance' is used instead to calculate a safety border at a uniform offset around the contour of the shape.

A set of Information box parameters are available for Nesting to control features of each part, for example, Step angle, Priority, Mirrored.

	Description	Material	Length	Width	Quantity	Grain	Edge	Step angle	Priority	Mirrored	Inf
Global											
1.	N_SHELF_RECTANGLE_...	CHIPBOARD-18MM	700.0	350.0	45	N	0000				
2.	N_SHELF_RECTANGLE_...	CHIPBOARD-18MM	1200.0	800.0	25	N	0000				
3.	N_SHELF_RECTANGLE_...	CHIPBOARD-18MM	800.0	300.0	67	N	0000				
4.	N_SHELF_RECTANGLE_...	CHIPBOARD-18MM	800.0	300.0	56	N	0000				
5.	N_SHELF_RECTANGLE_...	CHIPBOARD-18MM	800.0	300.0	21	N	0000				
6.	N_SHELF_RECTANGLE_...	CHIPBOARD-18MM	800.0	300.0	69	N	0000				
7.	N_SHELF_RECTANGLE_...	CHIPBOARD-18MM	800.0	300.0	51	N	0000				
8.	N_SHELF_RECTANGLE_...	MED-DEN-FIBRE-18...	310.0	290.0	74	N	0000				
9.	N_SHELF_RECTANGLE_...	MED-DEN-FIBRE-18...	732.0	348.0	48	N	0000				
10.	N_SHELF_RECTANGLE_...	MED-DEN-FIBRE-18...	420.0	800.0	39	N	0000				
11.	N_SHELF_RECTANGLE_...	MED-DEN-FIBRE-18...	650.0	150.0	62	N	0000				
12.	N_SHELF_RECTANGLE_...	MED-DEN-FIBRE-18...	570.0	210.0	72	N	0000				
13.	N_SHELF_RECTANGLE_...	MED-DEN-FIBRE-18...	510.0	180.0	66	N	0000				
14.	N_SHELF_RECTANGLE_...	MED-DEN-FIBRE-18...	510.0	180.0	47	N	0000				
15.	N_SHELF_RECTANGLE_...	MED-DEN-FIBRE-18...	910.0	500.0	36	N	0000				
16.											

Nesting - part list entry

Information boxes are set from the main screen (*Parameters - Information boxes*).

Nesting parameters

Cutting parts on a Machining centre requires careful control of the pattern layout. The nesting parameters give full control of cutting process for features such as, Board margins, Safety margins, Part separation, Placement of offcuts. Placement of waste cuts ...

Nesting parameters - nesting Nesting optimiser

Nesting 1 Nesting 2 Nesting 3 Offcuts Part division Help view >>

Nesting 1

Range

Optimiser type: Shaped nesting II

Optimiser type: Shaped nesting II

Minimum part separation - mm: 15.0

Board orientation: Lengthways

Nesting origin: Top left

Board margins - mm

Top: 15.0 Bottom: 15.0

Left: 15.0 Right: 15.0

Override margins for large parts

Board dimensions

Min length: 0.0 Max length: 9999.0

Min width: 0.0 Max width: 9999.0

Board pre-cut

Board width: Board width Min: 0.0 Max: 9999.0 Tolerance: 0.0

Small parts

Offset small parts from the edge

Min. area for nesting on the edge - m2: 0.000

Minimum offset from the edge - mm: 100.0

Global step angle

Use global step angle

Angle: 90

Single sheet patterns only

Extended optimiser time

Critical waste margin for rectangular parts: 0.0

OK Save As Print Help Cancel

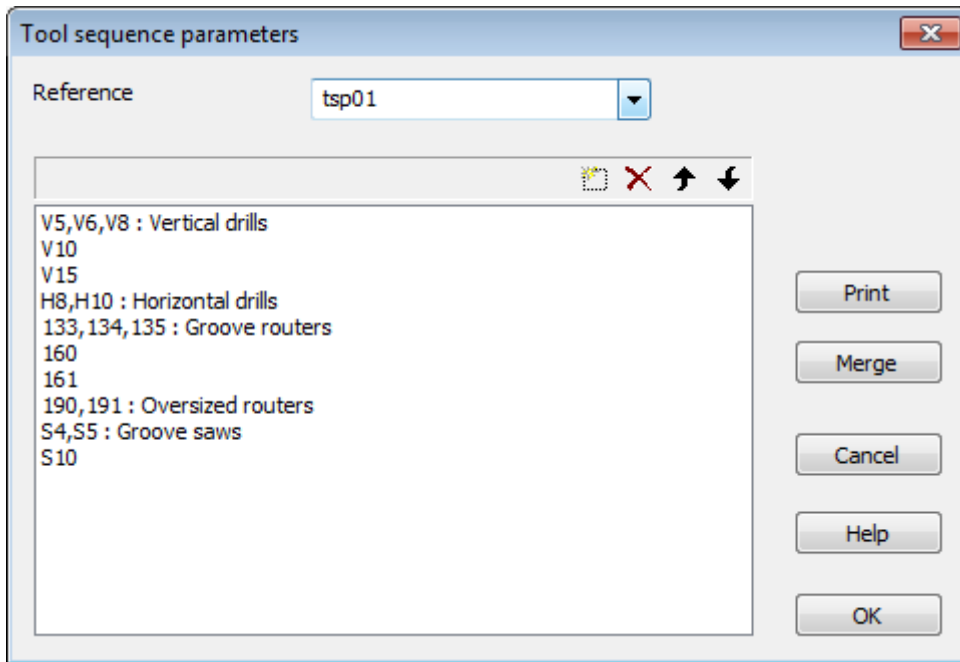
Nesting parameters

The nesting optimiser includes options for:-

- Shaped parts
- Rectangular parts only
- Calculate best position for pre-cutting jumbo boards

Tool optimisation

The program includes tool optimisation for nested patterns which minimizes the distance travelled for each set of tooling. This is calculated as the information is transferred to the machining centre. Use the 'Tool Sequence parameters' to set up the rules for tool optimisation.



Nesting - Tool optimisation

Note – MPR(X) based parts and patterns use the 'Project Manager' option for tool optimisation and do not use the Tool sequence parameters.

Grain matching

Nesting optimising often involves the visible parts of a product so grain matching can be important.

Grain matched parts can be set as a template in the machining editor and the template is used by the optimisers to ensure parts stay together and are cut from adjacent areas of board.

The screenshot displays the 'Review runs' software interface. The main window title is 'Pattern 2 of 3' and 'Grain Match Example'. The material is identified as 'MFC18-BEECH'. The board information includes 'Board: MFC18-BEECH/02', 'Information: Storage Area 2', and 'Material: MFC18-BEECH Prelaminated - Beech 18mm'. The waste is 15.28% and the size is 2440.0 x 1220.0 x 18.0. The revision is 27, dated 20 Aug 2018 14:19, and it was optimized by Sean-Lenovo. The pattern shows a layout of parts: two 'DRAWER-SHORT' parts (422.6 x 330), a 'DRAWER-MID' part (850 x 330), a 'DRAWER-BASE' part (850 x 330), two 'CABINET-BACK' parts (680 x 330), and a 'RUNNER' part (2100 x 340). A red circle highlights the 'DRAWER-MID' and 'DRAWER-BASE' parts, indicating grain matching. The software interface includes a menu bar (File, Edit, View, Settings, Summaries, Stock, Help), a toolbar with various icons, and a sidebar with 'Favourites' and 'Batch reports'.

Board: MFC18-BEECH/02 Waste: 15.28% Size: 2440.0 x 1220.0 x 18.0
 Information: Storage Area 2
 Material: MFC18-BEECH Prelaminated - Beech 18mm Boards: 1

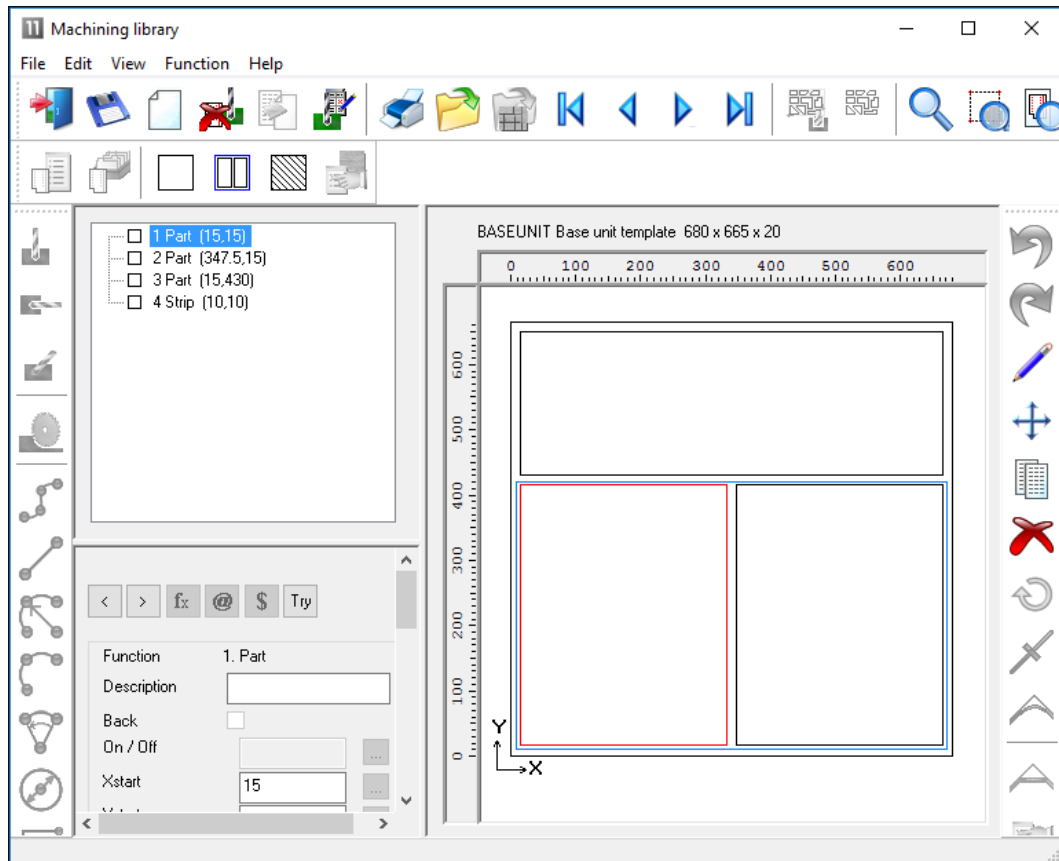
Rip saw blade thickness: 4.8 Crosscut saw blade thickness: 4.8 Book height 1 Cycles 1
 Rear rip trim (inc blade): 10.0 Rear crosscut trim (inc blade): 10.0 Retrim (inc blade): 5.0 Grain direction: ⇄

Nesting - grain matching

Templates for Nesting

The Machining editor can be used to create templates for Nesting patterns. A template sets out how a group of parts are to be cut and is useful, for example, where grain matching is important.

The templates are created and stored in the Machining library and are linked to parts at the Part list.

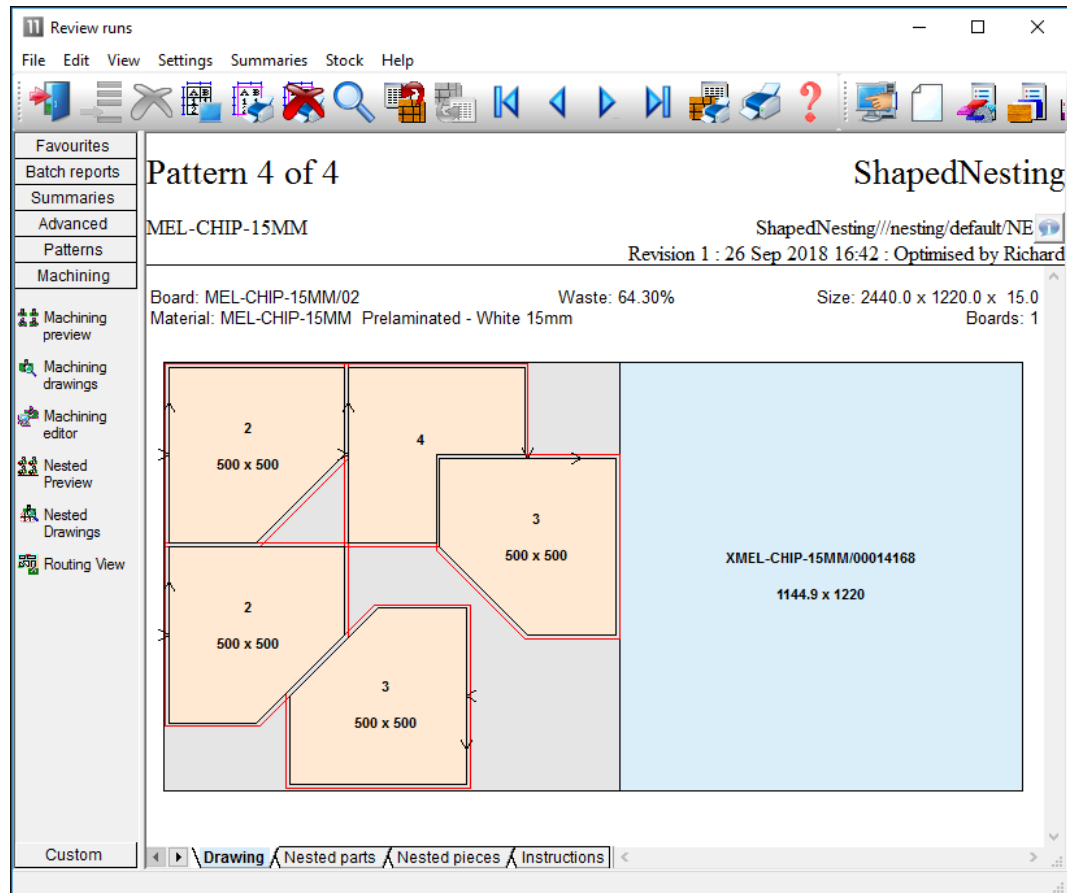


Nesting - pattern templates

The template can include waste parts (spacers) and separate groups of parts. There are Machining library options to add parts, groups or waste parts to a template.

Nested patterns - offcuts

Nested patterns can contain offcuts and follow the parameters for offcuts set in the Optimising parameters.



Nesting - offcuts

Note - Offcuts with duplicate sizes are not aggregated for nested patterns.

When a nested pattern is transferred to the machining centre the offcuts are converted into 1 or 2 rout contours depending on if they are along a whole side or just on a corner.

Working with different types of part drawing

The program can work with different types of part drawing. At the part list the drawing source can be set to any of the following:-

- Part library
- MPR(X)
- DXF
- Machining library
- Drawing library

This can be set for all part lists or per part list.

MPR(X) and DXF options allow the use of parts to be based on separate MPR(X) or DXF files (one drawing per part). An alternative for external files is to import DXF files into the Machining or Part library.

When parts are based on MPR(X) files then the editing of part instructions is done via Homag/Weeke WoodWop. The Homag/Weeke WoodWop program is called automatically when an MPR(X) based part is edited.

Use the 'DXF Import - layer name rules' to describe the DXF format. This format is often user defined for part and machining information.

Machining centre transfer parameters

These parameters are used to set up the link to a Machining centre. Typically they describe the type of Machining centre and the path to send the data to.

Set up a separate entry (one line) for each type of machining centre to transfer to.

No	Name	Type	Post transfer program	Edit
1.	woodWOP	8 - Homag/Weeke Woodwop V4/V5/V6/V7 (MPR/X)		...
2.	Nested DXF	9 - 2D DXF nested layered (DXF)		...
3.	Nested XXL	14 - Xilog (XXL)		...
4.	Nested CIX	15 - Biesse (CIX)		...
5.				...
6.				...
7.				...
8.				...
9.				...
10.				...
11.				...
12.				...
13.				...
14.				...
15.				...

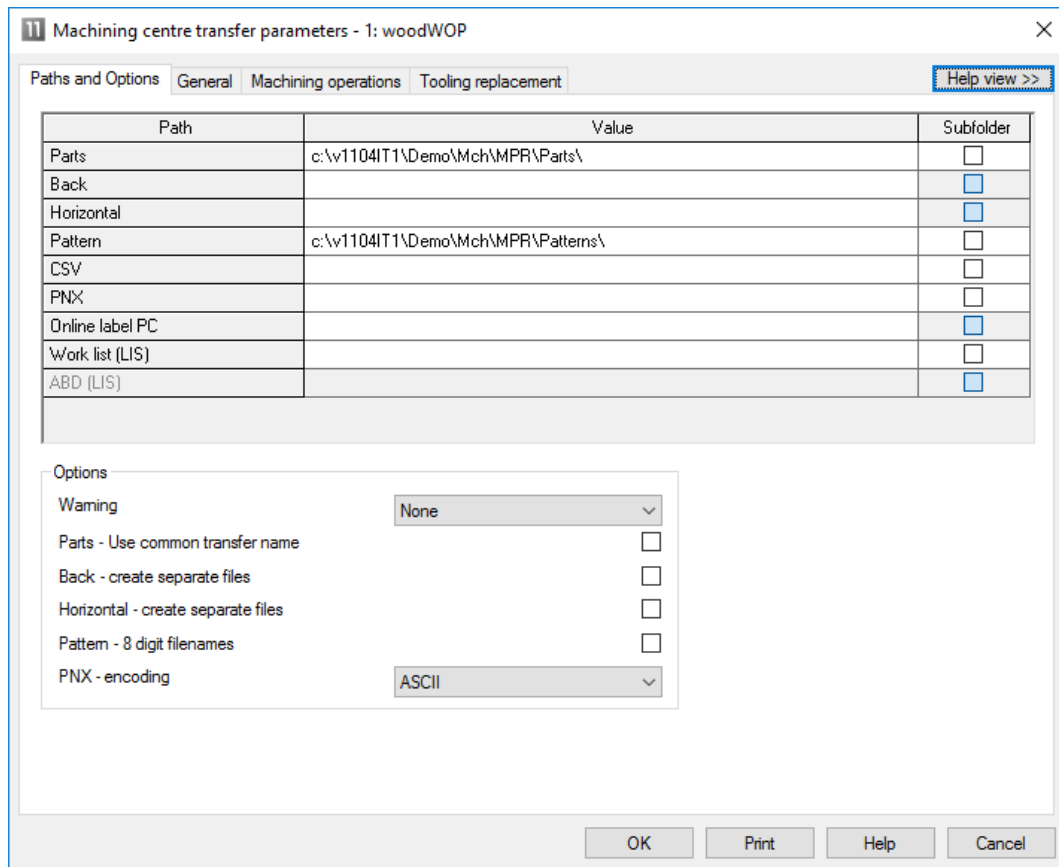
Nesting - Machining centre transfer parameters

There are several different types of transfer available - depends on the machining centre. For example:-

- 0 - 2D DXF Non-layered (DXF)
- 8 - Homag/Weeke WoodWop V4/V5/V6/V7 (MPR(X))
- 9 - 2D DXF nested layered (DXF)
- 11 – ASCII/Unicode PTX

12 - MDB PTX

The edit button is for any extra parameters - these vary as they depend on the type of machining centre and open in a new dialog.

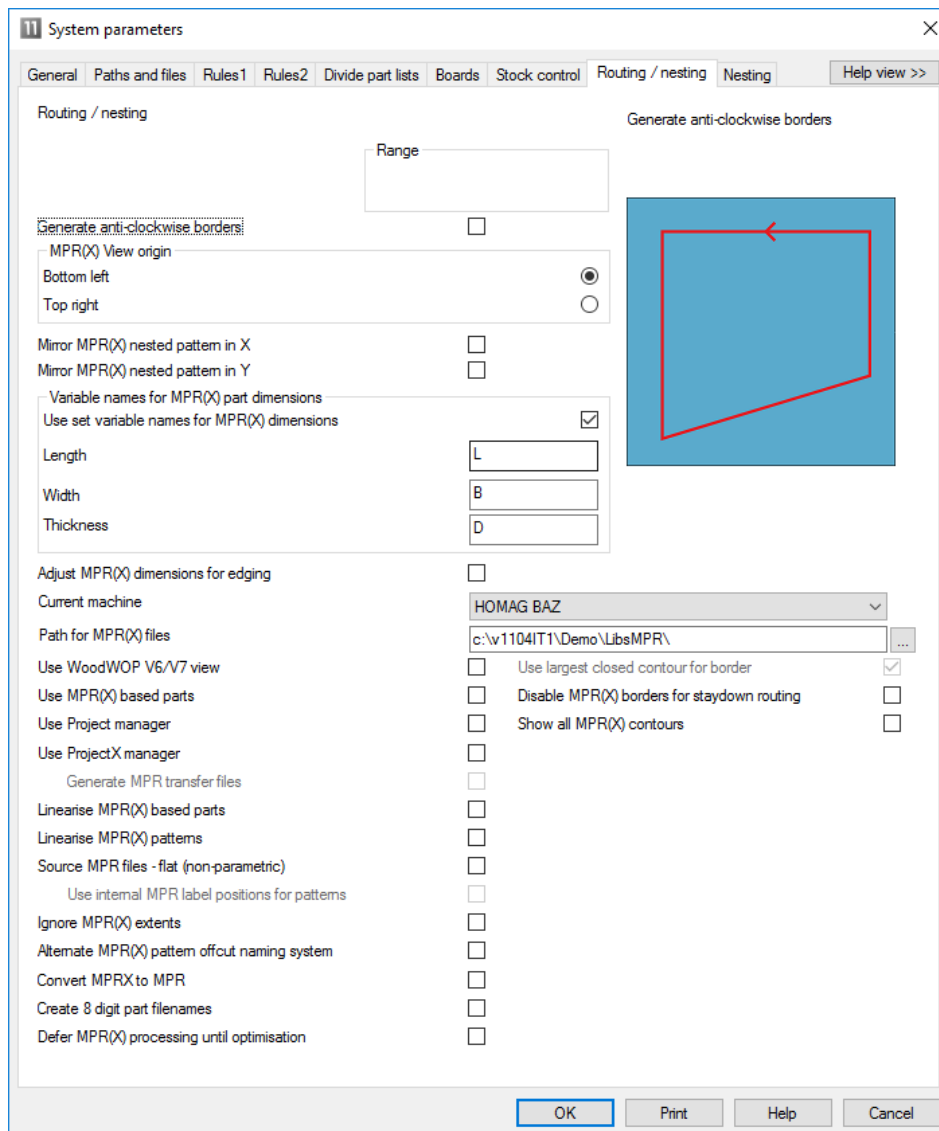


The parameters include a table to set up the rules to convert from one set of machining instructions to another - this allows for transfer to machines with different instruction sets for tooling.

System parameters (Routing/Nesting, Nesting)

The system parameters for Nesting are located on the two tabs (Routing/Nesting and Nesting). At the main screen, for example:-

- Select: **Parameters - System parameters - Nesting tab**



Nesting - System parameters

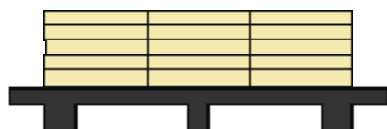
These include settings to identify the paths for external files (such as the WoodNest files), setting the part origin, setting what macros are used etc.

10. Destacking & Palletisation

This provides for the set up and planning of the destacking process so that parts are distributed to pallets or baseboards efficiently after cutting.

Parts can be destacked manually or with specialised destacking equipment. It is flexible enough to cope with many destack situations including the use of automatic machinery.

A straightforward example is where parts are manually destacked on to fixed size pallets around the saw.



Destacking

Each location around the saw is a 'Station'.

The optimisation takes account of the destacking requirements and parts are only destacked to stations that are large enough. The required quantity of each part is completed before the station is cleared ready for the next part.



Destacking parameters

The destacking parameters are used to describe the number, size, and type of each station. Typically there might 4 or 5 stations available.

Destacking parameters
✕

Range
 0-9999.9, 0-9999.9,

	Value			
1. Size of station 1	3000.0	3000.0	A	
2. Size of station 2	3000.0	3000.0	A	
3. Size of station 3	6500.0	6500.0	A	
4. Size of station 4	6500.0	6500.0	A	
5. Size of station 5	1000.0	1000.0	M	
6. Size of station 6	4000.0	4000.0	M	
7. Size of station 7	6500.0	6500.0	S	
8. Size of station 8	6500.0	6500.0		
9. Size of station 9	6500.0	6500.0		
10. Size of station 10	6500.0	6500.0		
11. Size of station 11	6500.0	6500.0		
12. Size of station 12	6500.0	6500.0		
13. Size of station 13	6500.0	6500.0		

Print

Cancel

Help

OK

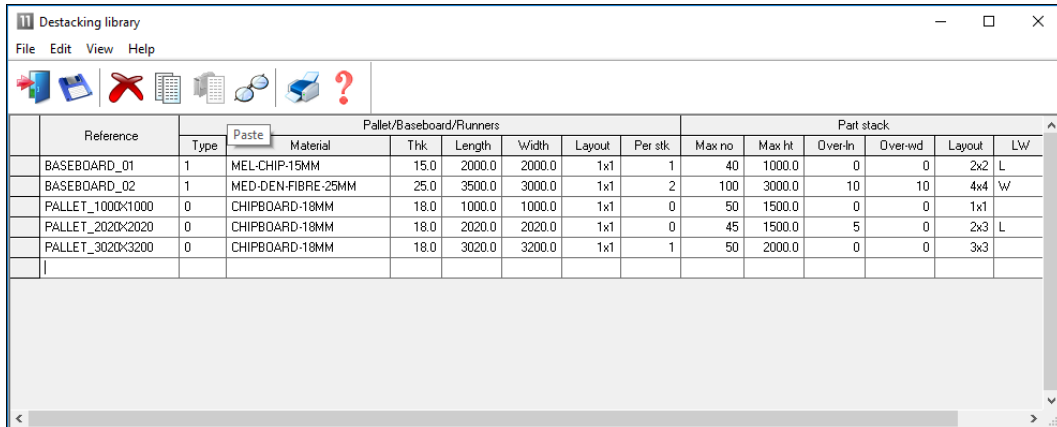
Destacking parameters

The destacking layout to use is set by information in the Part list (Part list information boxes).

Destacking library

The layout for destacking on to a pallet or baseboard is at its simplest the number in the length and the number in the width, for example, 3 x 3 or 2 x 1.

The styles to use are defined in the Destacking library. In this example there are different styles for baseboards and pallets.



The screenshot shows a window titled "Destacking library" with a menu bar (File, Edit, View, Help) and a toolbar. Below the toolbar is a table with the following columns: Reference, Type, Material, Thk, Length, Width, Layout, Per stk, Max no, Max ht, Over-ln, Over-wd, Layout, and LW. The table contains five rows of data representing different styles for baseboards and pallets.

Reference	Type	Pallet/Baseboard/Runners						Part stack					
		Material	Thk	Length	Width	Layout	Per stk	Max no	Max ht	Over-ln	Over-wd	Layout	LW
BASEBOARD_01	1	MEL-CHIP-15MM	15.0	2000.0	2000.0	1x1	1	40	1000.0	0	0	2x2	L
BASEBOARD_02	1	MED-DEN-FIBRE-25MM	25.0	3500.0	3000.0	1x1	2	100	3000.0	10	10	4x4	W
PALLET_1000x1000	0	CHIPBOARD-18MM	18.0	1000.0	1000.0	1x1	0	50	1500.0	0	0	1x1	
PALLET_2020x2020	0	CHIPBOARD-18MM	18.0	2020.0	2020.0	1x1	0	45	1500.0	5	0	2x3	L
PALLET_3020x3200	0	CHIPBOARD-18MM	18.0	3020.0	3200.0	1x1	1	50	2000.0	0	0	3x3	

Destacking library

The library can hold many hundreds of styles but typically only a handful of styles are required. They can be set to match your requirements for stacking and processing.

Optimising and Destacking

The Destacking calculations are part of the optimising process and all the information is calculated during optimisation.

The destacking style to use for each part is set at the Part list using extra fields (Part list information boxes).

	Description	Material	Length	Width	Quantity	Over	Under	Grain	Edge
Global						%	%		
1.	1	MFC18-EBONY	368.9	210.1	17	0	0	Y	0000
2.	2	PARTICLBRD-25MM	446.4	349.0	9	0	0	N	0000
3.	3	SUNDRY-UNIT	268.6	293.2	28	0	0	X	0000
4.	4	MFC18-EBONY	448.6	112.3	38	0	0	X	0000
5.	5	SUNDRY-LINEAR	323.5	260.6	5	0	0	X	0000
6.	6	SUNDRY-LINEAR	291.1	110.4	25	0	0	N	0000
7.	7	SUNDRY-AREA	327.6	397.1	32	0	0	N	0000
8.	8	#TEAK-FOIL	563.9	350.4	7	0	0	X	0000
9.	9	MEL-CHIP-18MM	447.8	361.8	31	0	0	X	0000
10.	10	SUNDRY-UNIT	273.5	352.2	10	0	0	X	0000
11.	11	WHITE-LAM-1MM	273.9	133.9	21	0	0	Y	0000
12.	12	DAK-BEAM	518.6	198.4	3	0	0	N	0000
13.	13	#TEAK-FOIL	329.5	195.6	47	0	0	N	0000
14.	14	EBONY-LAM-1MM	554.2	295.3	48	0	0	X	0000
15.	15	HARDBOARD-4MM	392.8	116.1	21	0	0	X	0000

Destacking - part list

In this example several different pallet layouts are used. In many cases it may be necessary to specify different layouts for different parts, for example, it may dangerous to stack very small parts in a 4 x 4 layout.

The part list is optimised in the usual way. The Destacking information is shown in the 'Review runs summaries'. The optimisation automatically includes an advanced algorithm that ensures optimisation takes account of the stations sizes set in the Destacking parameters.

The Destacking pictures show the layout for each part.

Review runs

File Edit View Settings Summaries Stock Help

Batch reports
Summaries
Advanced

Destacking pictures Small list for batch

00115/DS2 batch test/DS2 batch test/DSMQO-X/single/SQ

<p>Part: 1.1 Stacks: 1 Stn: 1 Baseboard: 1 440.2x757.8 Style: BEN02</p> <table border="1"> <tr><td>1!</td><td>1!</td></tr> <tr><td>368.9</td><td>368.9</td></tr> <tr><td>X</td><td>X</td></tr> <tr><td>210.1</td><td>210.1</td></tr> </table>	1!	1!	368.9	368.9	X	X	210.1	210.1	<p>Quantity: 17 Part: 2.2 Patterns: 1-2 Stacks: 1 Stn: 2 Baseboard: 6 718x912.8 Style: BEN02</p> <p>Quantity: 2</p> <table border="1"> <tr><td>2!</td><td>2!</td></tr> <tr><td>446.4 X 349</td><td>446.4 X 349</td></tr> <tr><td>2!</td><td>2!</td></tr> <tr><td>446.4 X 349</td><td>446.4 X 349</td></tr> </table>	2!	2!	446.4 X 349	446.4 X 349	2!	2!	446.4 X 349	446.4 X 349	<p>Quantity: 9 Patterns: 5</p>
1!	1!																	
368.9	368.9																	
X	X																	
210.1	210.1																	
2!	2!																	
446.4 X 349	446.4 X 349																	
2!	2!																	
446.4 X 349	446.4 X 349																	
<p>Part: 4.4 Stacks: 1 Stn: 4 Baseboard: 4 244.6x917.2 Style: BEN02</p> <table border="1"> <tr><td>4!</td><td>4!</td></tr> <tr><td>4!</td><td>4!</td></tr> </table>	4!	4!	4!	4!	<p>Quantity: 38 Part: 9.9 Patterns: 2-3 Stacks: 1 Stn: 1 Baseboard: 7 743.6x915.6 Style: BEN02</p> <p>Quantity: 2</p> <table border="1"> <tr><td>9!</td><td>9!</td></tr> <tr><td>447.8 X 361.8</td><td>447.8 X 361.8</td></tr> <tr><td>9!</td><td>9!</td></tr> <tr><td>447.8 X 361.8</td><td>447.8 X 361.8</td></tr> </table>	9!	9!	447.8 X 361.8	447.8 X 361.8	9!	9!	447.8 X 361.8	447.8 X 361.8	<p>Quantity: 31 Patterns: 6-7</p> <p>Quantity: 2</p>				
4!	4!																	
4!	4!																	
9!	9!																	
447.8 X 361.8	447.8 X 361.8																	
9!	9!																	
447.8 X 361.8	447.8 X 361.8																	

Offcut summary
Distribution summary
Edging summary
Machine times
Saw loading summary
Destacking summary
Station summary
Destacking pictures

Patterns
Machining

Destacking pictures

These can be used for controlling and checking the destack process.

Two other reports are available:-

Station summary

This shows how each station is loaded and the order of parts arriving at each station.

Review runs										
File Edit View Settings Summaries Stock Help										
Station summary Small list for batch										
00115/DS2 batch test/DS2 batch test/DSMQO-X/single/SQ										
Bsb No	Length mm	Width mm	Bsb Qty	Part No	Part / Description	Part Qty	Part Ln	Part Wd	Part Orientation	Part
<u>Station number 1</u>										
Bsb 1	440.2	757.8	2	1.	1	17	2	2	!	10
Bsb 5	338.8	1014.8	2	17.	17	29	2	2	!	10
Bsb 7	743.6	915.6	2	9.	9	31	2	2	!	10
Bsb 10	430.5	145.9	1	23.	23	6	1	1		1
Bsb 11	610.6	1128.4	2	14.	14	48	2	2	!	10
Bsb 13	642.4	882.8	2	16.	16	26	2	2	!	10
Bsb 14	271.6	1335.0	2	21.	21	2	2	2	!	10
			<u>13</u>			<u>159</u>				
<u>Station number 2</u>										
Bsb 2	735.0	1268.8	2	19.	19	27	2	2	!	10
Bsb 6	718.0	912.8	2	2.	2	9	2	2	!	10
Bsb 8	287.8	567.8	2	11.	11	21	2	2	!	10
Bsb 9	416.8	1057.2	2	12.	12	3	2	2	!	4
			<u>8</u>			<u>60</u>				
<u>Station number 3</u>										
Bsb 3	653.0	1211.8	2	25.	25	37	2	2	!	10
			<u>2</u>			<u>37</u>				
<u>Station number 4</u>										
Bsb 4	244.6	917.2	2	4.	4	38	2	2	!	10
			<u>2</u>			<u>38</u>				
<u>Station number 5 Manual</u>										
Bsb 12	392.8	116.1	1	15.	15	21	1	1		5
Bsb	650.9	372.5	0	20.	20	5	1	1		4
			<u>1</u>			<u>26</u>				

Station summary

Destacking Summary

This shows for each cutting pattern how the parts are produced and the sequence they arrive at stations.

Ptn	Open Parts	No	Part / Description	Length mm	Width mm	Stn	Qty	Group / Pictures
1	3	1. 1		368.9	210.1	1	9	2 2!
		19. 19		624.4	357.5	2	18	2 2!
		25. 25		595.9	316.5	3	36	2 2!
2	4	1. 1		368.9	210.1	1	8*	2 2!
		4. 4		448.6	112.3	4	3	2 2!
		19. 19		624.4	357.5	2	9*	2 2!
		25. 25		595.9	316.5	3	1*	2 2!
3	1	4. 4		448.6	112.3	4	35*	2 2!
4	1	17. 17		497.4	159.4	1	28	2 2!
5	2	2. 2		446.4	349.0	2	9*	2 2!
		17. 17		497.4	159.4	1	1*	2 2!
6	1	9. 9		447.8	361.8	1	24	2 2!
7	1	9. 9		447.8	361.8	1	7*	2 2!
8	1	11. 11		273.9	133.9	2	21*	2 2!
9	2	12. 12		518.6	198.4	2	3*	2 2!
		23. 23		430.5	145.9	1	6*	1 1
10	1	14. 14		554.2	295.3	1	40	2 2!
11	1	14. 14		554.2	295.3	1	8*	2 2!
12	1	15. 15		392.8	116.1	5	21*	1 1
13	1	16. 16		431.4	311.2	1	24	2 2!
14	1	16. 16		431.4	311.2	1	2*	2 2!
15	1	20. 20		640.9	372.5	5	3	1 1
16	1	20. 20		640.9	372.5	5	2*	1 1
17	1	21. 21		657.5	125.8	1	2*	2 2!

Destacking summary

Using Destacking information

- All the reports can be easily printed and used at the Destacking area or for planning.
- For Homag/Holzma/Homag Automation destacking machinery the destacking information can be downloaded (via the Saw interface) for use by automatic destacking machinery.
- Labels for each pallet and/or each stack can be printed in the office.

Baseboards

Many customers offstack to cut to size baseboards rather than pallets. Destacking can be set up for this (or a mixture of both).

	Description	Material	Length	Width	Quantity	Over	Under	Grain	Edge	Destacking Style	Destacking Mode	Ir ^
Global						0 %	0 %					
1.	BU05HK-BACK	HARDBOARD-4MM	474.0	710.0	20	0	0	N	0000	BASE_1	S	
2.	BU05MB-BASE	MEL-CHIP-18MM	474.0	585.0	20	0	0	N	ww00	BASE_1	A	
3.	BU05ME/LEFT	MEL-CHIP-18MM	585.0	870.0	45	0	0	N	00w0	BASE_1	A	
4.	BU05ME/RIGHT	MEL-CHIP-18MM	585.0	870.0	45	0	0	N	000w	BASE_1	A	
5.	BU05MP-PLINTH	MEL-CHIP-18MM	500.0	150.0	20	0	0	N	0000	BASE_1	A	
6.	BU05MR-RAIL	MEL-CHIP-18MM	474.0	75.0	40	0	0	N	0000	BASE_1	A	
7.	BU05MS-SHELF	MEL-CHIP-18MM	474.0	395.0	20	0	0	N	ww00	BASE_1	A	
8.	BU05WD-WHITE-D...	WHITE-LAM-1MM	495.0	570.0	20	0	0	N	www	BASE_1	A	
9.	BU05WW-WHITE...	WHITE-LAM-1MM	495.0	150.0	20	0	0	N	www	BASE_1	A	
10.	HU06HK-BACK	HARDBOARD-4MM	574.0	710.0	25	0	0	N	0000	BASE_2	A	
11.	HU06MB-BASE	MEL-CHIP-18MM	574.0	585.0	25	0	0	N	ww00	BASE_2	M	
12.	HU06MP-PLINTH	MEL-CHIP-18MM	600.0	150.0	25	0	0	N	0000	BASE_2	M	
13.	HU06MR-RAIL	MEL-CHIP-15MM	574.0	75.0	50	0	0	N	0000	BASE_2	M	
14.	SU05HK-BACK	HARDBOARD-4MM	998.0	745.0	30	0	0	N	0000	BASE_1	S	
15.	SU05MB-BASE	MEL-CHIP-18MM	964.0	595.0	30	0	0	N	ww00	BASE_1	S	
16.	SU05ME/LEFT	MEL-CHIP-18MM	580.0	870.0	60	0	0	N	00w0	BASE_2	A	
17.	SU05ME/RIGHT	MEL-CHIP-18MM	580.0	870.0	60	0	0	N	00w0	BASE_1	M	
18.	SU05MF-FASCIA	MEL-CHIP-18MM	1000.0	180.0	15	0	0	N	00ww	BASE_1	M	

Destacking with Baseboards

The destacking pictures show the layout for each part on the baseboards.

Review runs
 File Edit View Settings Summaries Stock Help

Destacking pictures **AUTOMATIC DESTACKING**

00002/BSR50/BSR50/?DESTACK/?SINGLE/M1

Part:1.BU05HK-BACK Stacks:1 Stn:2 Baseboard:948x1420 Style:BASE_1	Quantity:20 Part:2.BU05MB-BASE Patterns:3-4 Stacks:1 Stn:1 Baseboard:948x1170 Style:BASE_1 Quantity:1	Quantity:20 Part:3.BU05ME/LEFT Patterns:10 Stacks:1 Stn:1 Baseboard:1170x1740 Style:BASE_1 Quantity:1	Quantity:45 Patterns:6-8 Quantity:1																
<table border="1"> <tr><td>474 X 710</td><td>474 X 710</td></tr> <tr><td>474 X 710</td><td>474 X 710</td></tr> </table>	474 X 710	474 X 710	474 X 710	474 X 710	<table border="1"> <tr><td>BU05MB-BASE</td><td>BU05MB-BASE</td></tr> <tr><td>474 X 585</td><td>474 X 585</td></tr> <tr><td>BU05MB-BASE</td><td>BU05MB-BASE</td></tr> <tr><td>474 X 585</td><td>474 X 585</td></tr> </table>	BU05MB-BASE	BU05MB-BASE	474 X 585	474 X 585	BU05MB-BASE	BU05MB-BASE	474 X 585	474 X 585	<table border="1"> <tr><td>585 X 870</td><td>585 X 870</td></tr> <tr><td>585 X 870</td><td>585 X 870</td></tr> </table>	585 X 870	585 X 870	585 X 870	585 X 870	
474 X 710	474 X 710																		
474 X 710	474 X 710																		
BU05MB-BASE	BU05MB-BASE																		
474 X 585	474 X 585																		
BU05MB-BASE	BU05MB-BASE																		
474 X 585	474 X 585																		
585 X 870	585 X 870																		
585 X 870	585 X 870																		
Part:4.BU05ME/RIGHT Stacks:1 Stn:2 Baseboard:1170x1740 Style:BASE_1	Quantity:45 Part:5.BU05MP-PLINTH Patterns:10-11 Stacks:1 Stn:2 Baseboard:1000x300 Style:BASE_1 Quantity:1	Quantity:20 Part:6.BU05MR-RAIL Patterns:7 Stacks:1 Stn:2 Baseboard:948x150 Style:BASE_1 Quantity:1	Quantity:40 Patterns:8 Quantity:1																
<table border="1"> <tr><td>585 X 870</td><td>585 X 870</td></tr> <tr><td>585 X 870</td><td>585 X 870</td></tr> </table>	585 X 870	585 X 870	585 X 870	585 X 870	<table border="1"> <tr><td>BU05MP-PLINTH</td><td>BU05MP-PLINTH</td></tr> <tr><td>500 X 150</td><td>500 X 150</td></tr> <tr><td>BU05MP-PLINTH</td><td>BU05MP-PLINTH</td></tr> <tr><td>500 X 150</td><td>500 X 150</td></tr> </table>	BU05MP-PLINTH	BU05MP-PLINTH	500 X 150	500 X 150	BU05MP-PLINTH	BU05MP-PLINTH	500 X 150	500 X 150	<table border="1"> <tr><td>BU05MR-RAIL</td><td>BU05MR-RAIL</td></tr> <tr><td>BU05MR-RAIL</td><td>BU05MR-RAIL</td></tr> </table>	BU05MR-RAIL	BU05MR-RAIL	BU05MR-RAIL	BU05MR-RAIL	
585 X 870	585 X 870																		
585 X 870	585 X 870																		
BU05MP-PLINTH	BU05MP-PLINTH																		
500 X 150	500 X 150																		
BU05MP-PLINTH	BU05MP-PLINTH																		
500 X 150	500 X 150																		
BU05MR-RAIL	BU05MR-RAIL																		
BU05MR-RAIL	BU05MR-RAIL																		

Destacking pictures - Baseboards

The program also provides a cutting list for the Baseboards ready for optimising.

	Description	Material	Length	Width	Quantity	Over	Under	Grain	Edge	Destacking Style	Destacking Mode	Ir
Global						0 %	0 %	N	0000			
1.	20	MEL-CHIP-15MM	948.0	1480.0	1	0	0	N	0000			
2.	14	MEL-CHIP-15MM	1996.0	1490.0	1	0	0	N	0000			
3.	1	MEL-CHIP-15MM	948.0	1420.0	1	0	0	N	0000			
4.	10	MED-DEN-FIBRE-2...	2860.0	2316.0	2	0	0	N	0000			
5.	7	MEL-CHIP-15MM	948.0	790.0	1	0	0	N	0000			
6.	15	MEL-CHIP-15MM	1928.0	1190.0	1	0	0	N	0000			
7.	17	MEL-CHIP-15MM	1160.0	1740.0	1	0	0	N	0000			
8.	3*	MEL-CHIP-15MM	1170.0	1740.0	2	0	0	N	0000			
9.	11	MED-DEN-FIBRE-2...	2360.0	2316.0	2	0	0	N	0000			
10.	5	MEL-CHIP-15MM	1000.0	300.0	1	0	0	N	0000			
11.	16	MED-DEN-FIBRE-2...	3500.0	2340.0	2	0	0	N	0000			
12.	19	MEL-CHIP-15MM	2000.0	300.0	1	0	0	N	0000			
13.	6	MEL-CHIP-15MM	948.0	150.0	1	0	0	N	0000			
14.	12	MED-DEN-FIBRE-2...	620.0	2420.0	2	0	0	N	0000			
15.	2	MEL-CHIP-15MM	948.0	1170.0	1	0	0	N	0000			
16.	18	MEL-CHIP-15MM	2000.0	360.0	1	0	0	N	0000			
17.	8	MEL-CHIP-15MM	990.0	1140.0	1	0	0	N	0000			
18.	9	MEL-CHIP-15MM	990.0	300.0	1	0	0	N	0000			

Destacking - Baseboard picking list

Note - the baseboard cutting list has the same name as the part list with a hyphen added. e.g. 'Cabinets', 'Cabinets-'. This list is found in the 'Cutting list' section.

Flexible Destacking

The destacking options are very flexible and can be set up for:-

- Offstacking to the floor (no station sizes)
- Offstacking to a mix of automatic and manual stations
- Offstacking to include one or more 'Overflow' stations
- Use of 'Pallet groups'

Pallet groups

The program also includes more general options to take account of Pallet groups. For example, a field (information box) is available at the part list to set a pallet group number for each part.

This ensures the optimisers arrange the pattern layouts so parts in the same pallet group are finished before considering parts from other pallet groups. This speeds up later production and assembly operations and helps with delivery times for specific parts.

For example, a customer recently needed to set up their system to produce 1 job at a time and used the Pallet group option for this. The flexibility of the optimisers also allowed 'changeover' patterns where one group finished and the next started so waste was minimised.

11. CAD Drawings

A flexible design tool for laying out jobs e.g. Office spaces, Kitchens, Washrooms ...

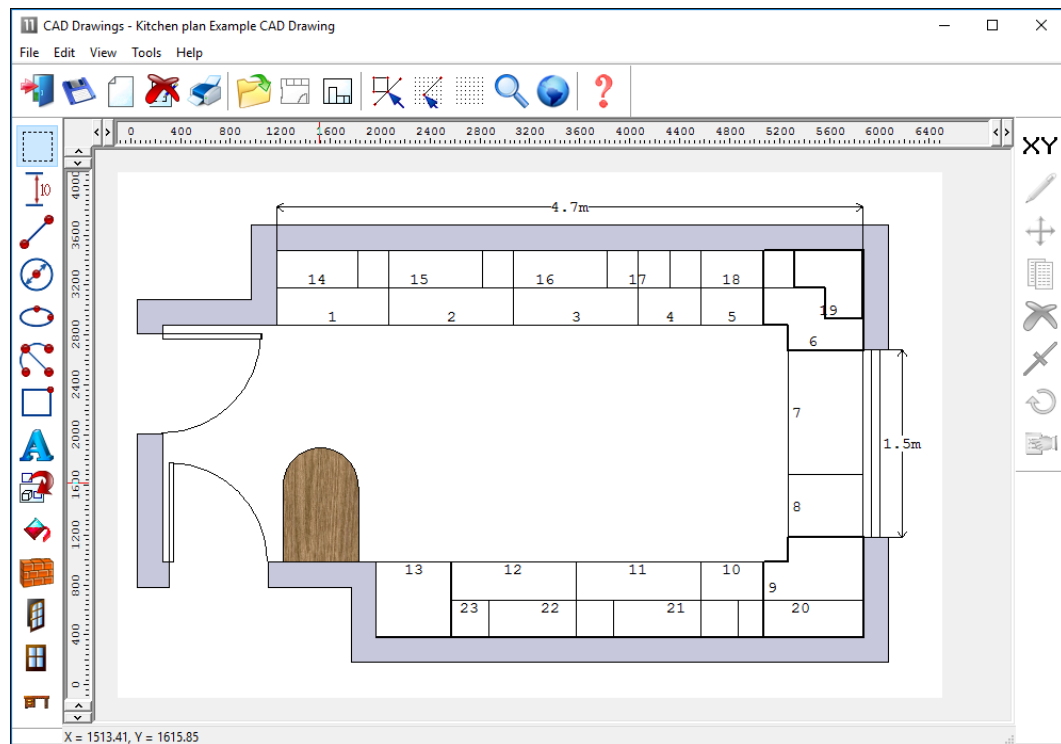
- Create room layout
- Add products
- Optimise

This option provides full costing, drawings and supporting documents. The layouts can be exported in DXF format.



CAD drawing library

Use the screen and integrated tools to produce a space or room layout and position products on the layout.



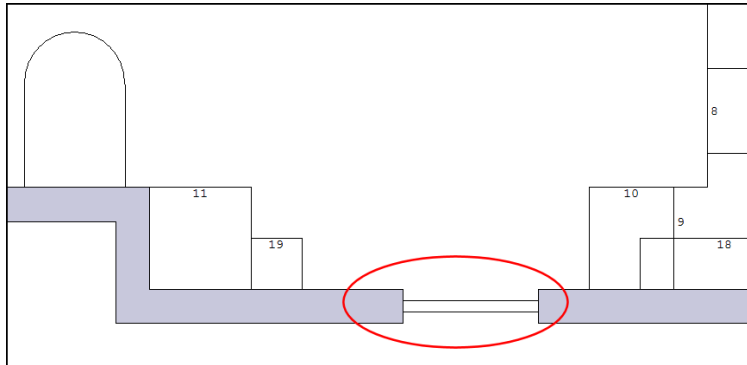
CAD drawings

A set of tools allow for quick and accurate entry of the room details.

Wall
Door
Window

A full set of drawing tools are also included: arc, line, circle, ellipse, text ...

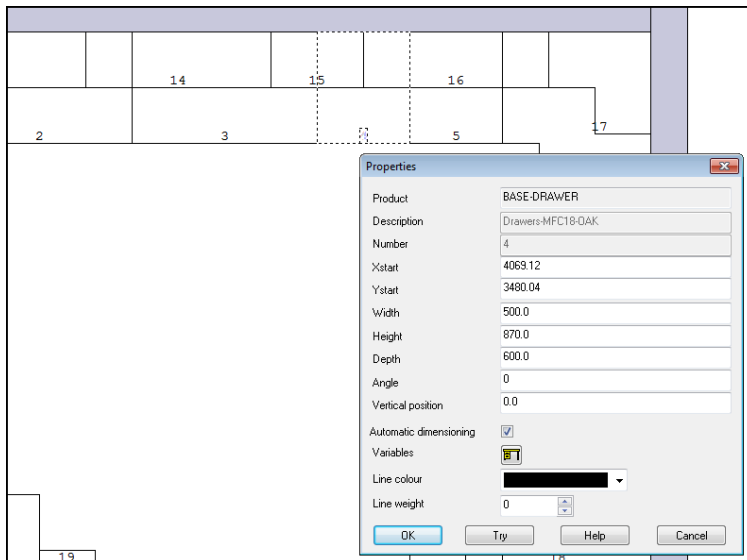
Here the Window tool is used to add a window,



Window tool

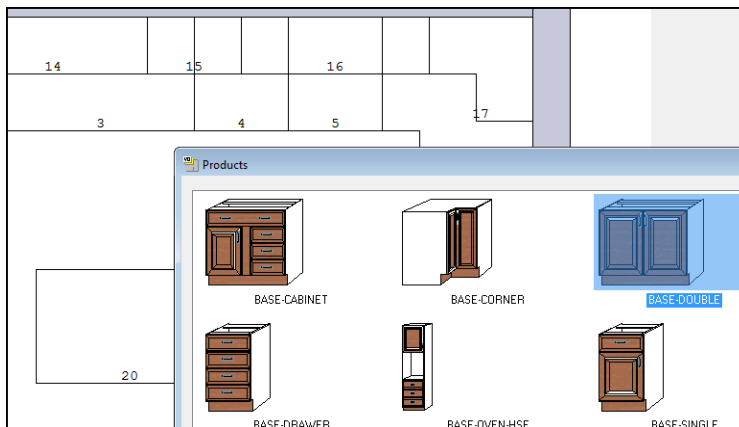
Products were re-positioned as a result of the change.

Details of each product are shown via the Properties pop-up



Window tool - properties

Use the Product tool to add products to the drawing.



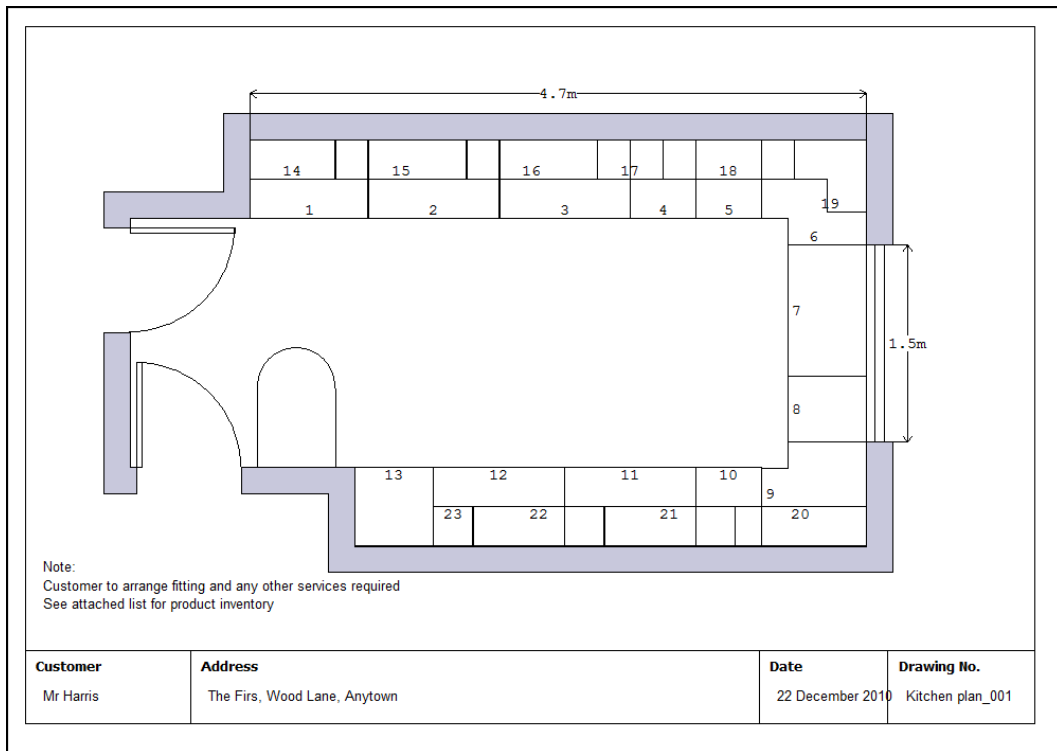
Select product

The view can be switched between the plan view and an elevation along a selected wall.



Wall view

Any drawing can be added to a diagram layout - so that a full annotated drawing can be produced if required.



Layout diagram

Product requirements

Once the drawing is complete the product requirements can be calculated automatically by the program.

No	Code	Information	Product			Qty
			Width	Height	Depth	
1	BATHROOM-CABINET	Bathroom cabinet	700.0	600.0	180.0	1
2	WARDROBE	Wardrobe - drawer & door	1000.0	1800.0	600.0	1
3	DRESSER	Dressing table	1200.0	1100.0	600.0	1
4	DRESSER	Dressing table	1000.0	1200.0	600.0	1
5	WARDROBE	Wardrobe - drawer & door	1200.0	1900.0	650.0	1
6	BATHROOM-CABINET	Bathroom cabinet	700.0	600.0	180.0	1
7	DRESSER	Dressing table	1000.0	1100.0	600.0	2
8	DRESSER	Dressing table	1000.0	1100.0	600.0	1
9	WARDROBE	Wardrobe - drawer & door	1000.0	1800.0	600.0	1
10	BASE-CABINET	Base unit - cabinet	900.0	870.0	600.0	1
11	BASE-CORNER	Corner cabinet	800.0	870.0	800.0	1
12	BASE-DOUBLE	Double base unit	1000.0	870.0	600.0	1
13	BASE-DRAWER	Drawers-MFC18-OAK	500.0	870.0	600.0	1
14	BASE-OVEN-HSE	Oven Housing	600.0	2350.0	600.0	1
15	BASE-SINGLE	Single base unit	500.0	870.0	600.0	1
16	BASE-SINK	Sink base unit	1000.0	870.0	600.0	1

CAD drawings - product requirements

The requirements are then ready for optimising in the usual way. Alternatively the program can produce a full Quotation for the Products and Quotes module.

The requirements or the quotation are optimised in the usual way to produce a set of cutting patterns for the job.

Review runs

File Edit View Settings Summaries Stock Help

Pattern preview **Example CAD Drawing**

Kitchen plan///DEFAULT/DEFAULT/SQ [Rules:CL,BL]
Revision 6 : 27 Aug 2018 14:26 : Recalculated by Sean-Lenovo

Ptn:1	Qty:1	Cycles:1	Ptn:2	Qty:1	Cycles:1
Board: 1.MEL-CHIP-18MM/01 Size: 3050.0 x 1220.0			Board: 1.MEL-CHIP-18MM/01 Size: 3050.0 x 1220.0		

Batch reports
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Custom

CAD drawings - optimisation

12. Board library



The Board library is a record of the Materials in use. The program uses it to select the correct board sizes when a list of parts (or products) is optimised. Setting up the board library with the materials and board sizes is essential for optimising. This can be quite an extensive task but there are options for importing boards from other systems with the Stock control module. Once the library is set up there is then only regular maintenance to allow for new suppliers, materials and price changes.

At the main screen:-

- Select: **Libraries - Board library**

The first screen is a list of MATERIALS. The materials can be, for example, core material such as chipboard or MDF or various laminates.

Materials									
Material	Description	Thickness	Default grain	Book	Material parameters	Picture	Type	Density	
GREEN GLOSS 18MM	Gloss finish - Green 18mm	18.0	N	0			Gloss finish	0.400	
HARDBOARD-4MM	Hardboard 4mm	4.0	N	8	HBD04			0.750	
HARDBOARD-WHITE-4MM	Hardboard 4mm - White	4.0	N	8	HBD04			0.750	
IVORY GLOSS 18MM	Gloss finish - Ivory 18mm	18.0	N	0			Gloss finish	0.400	
MAPLE MDF 18MM	Medium Density Fibreboard - Maple 18mm	18.0	Y	0			MDF	0.650	
MED-DEN-FIBRE-18MM	Medium Density Fibreboard 18mm	18.0	N	0			MDF	0.650	
MED-DEN-FIBRE-25MM	Medium Density Fibreboard 25mm	25.0	N	0			MDF	0.650	

Boards for material: IVORY GLOSS 18MM Gloss finish - Ivory 18mm Thickness:18.0 Book:0																
Board code	Type	Length	Width	Informal	Stock	Res	Order	Cost	Limit	Bin	Supplier	Min Stk	ReOrd	Grain	Parameters	Method
IVORY GLOSS 18MM X		2440.0	1220.0		52	0	0	5,250	0	225		20	30	N		Area
XIVORY GLOSS 18M...	A	2440.0	664.0		1	0	0	2,700	0			0		N		Area
XIVORY GLOSS 18M...	X	538.0	349.5		1	0	0	2,700	0			0		N		Area
XIVORY GLOSS 18M...	X	664.0	200.7		1	0	0	2,700	0			0		N		Area

Board library

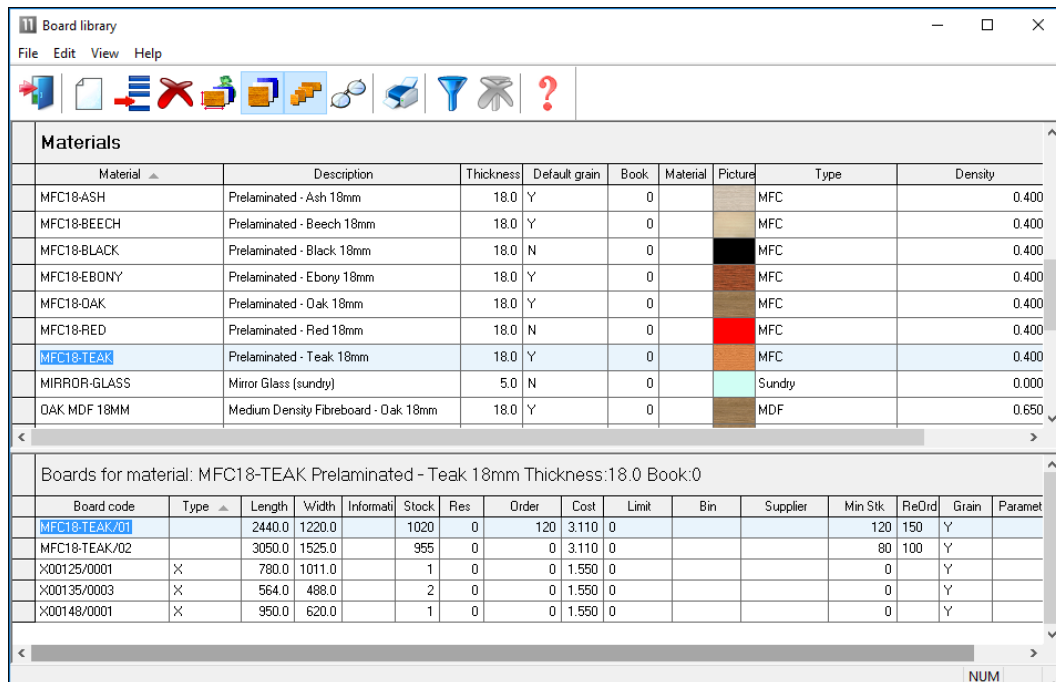
Material code - each material has a unique material code. This is important because the program uses this code to identify the material for each part and find the correct material in the material library.

For each material enter the data for each column: Material code, Description, Thickness, Grain (whether the material has a grain or not), Book (the maximum book height in terms of the number of boards) and Parameters.

Picture - each material can include a picture of the material - this can be a bit map or a colour and can be used to help identify the material and also used to render parts and products using that material in the Part and Product libraries.

Parameters - this is the name of an alternative set of parameters (called MATERIAL PARAMETERS) for the material. These can be useful where different settings are used for cutting different materials, for example, a slower speed or a different blade.

For each material there may be several different board sizes and different quantities of each size available. These are shown, for the current material, in the lower pane.



Board library materials and boards

Board details - to add a new board fill in the values for each column: Board code, length, width, information (this can be any descriptive data about the board) and the cost per

square area of the board, for example, £2.54 per square metre. A realistic cost is important as this is used when the cutting patterns are generated to help decide which are the most effective patterns.

Quantities -There are three columns for quantities (Stock, Res, Order) - enter the boards available in stock under 'Stock'. The other two columns are used with the Stock control module.

Limit - This setting (0-9) determines how the boards are used.

For example, a setting of 8 allows the software to ignore the physical quantity in stock when generating cutting patterns - useful for estimating stock requirements when stocks are low.

With the Stock control module (SC) the library also includes the transactions on each board.

The screenshot shows the 'Board library' application window. It features a menu bar (File, Edit, View, Help) and a toolbar with various icons. The main area is divided into two panes. The left pane, titled 'Materials', contains a table with columns: Material, Description, Thickness, Default grain, and Book. The right pane, titled 'Transactions for board: MEL-CHIP-15MM/0', contains a table with columns: T, Qty, Date, and Ref. Below these panes is a section for 'Boards for material: MEL-CHIP-15MM Prelaminated - White 15mm Thickness:15.0 Book:0', which contains a detailed table with columns: Board code, Type, Length, Width, Informati, Stock, Res, Order, Cost, Limit, Bin, Supplier, Min Stk, ReOrd, Grain, and Paramet.

Material	Description	Thickness	Default grain	Book
MAPLE MDF 18MM	Medium Density Fibreboard - Maple 18mm	18.0	Y	0
MED-DEN-FIBRE-18MM	Medium Density Fibreboard 18mm	18.0	N	0
MED-DEN-FIBRE-25MM	Medium Density Fibreboard 25mm	25.0	N	0
MEL-CHIP-15MM	Prelaminated - White 15mm	15.0	N	0
MEL-CHIP-18MM	Prelaminated - White 18mm	18.0	N	0
MFC18-ASH	Prelaminated - Ash 18mm	18.0	Y	0
MFC18-BEECH	Prelaminated - Beech 18mm	18.0	Y	0
MFC18-BLACK	Prelaminated - Black 18mm	18.0	N	0
MFC18-EBONY	Prelaminated - Ebony 18mm	18.0	Y	0

T	Qty	Date	Ref
8	+8...	29-Jul-10	MEL-CHIP-15MM
66	+1...	30-Jul-10	BSR-STKORD-05:General Boards In
77	-10	30-Jul-10	FLA:Remove damaged board

Board code	Type	Length	Width	Informati	Stock	Res	Order	Cost	Limit	Bin	Supplier	Min Stk	ReOrd	Grain	Paramet
MEL-CHIP-15MM/01		3050.0	1220.0		901	0	175	2,590	0	160	General Boar...	90	120	N	
MEL-CHIP-15MM/02		2440.0	1220.0		729	0	110	2,560	0	162	General Boar...	120	140	N	

Board library stock transactions

Transactions for the current board are shown in a separate pane at the right of the screen.

Board library views

There are several different views of the library data. 'Boards only' shows the list of board sizes and there is a choice of listing offcuts or stock boards.




Boards only

The library includes an alternative layout 'Boards only' which shows all the boards in a single list. This can be convenient when adding or searching for specific board sizes.

Board library - Stock boards										
File Edit View Help										
Boards										
Board code	Type	Material	Length	Width	Thickness	Information	Stock	Res	Order	
BLUE GLOSS 18MM/01		BLUE GLOSS 18MM	2440.0	1220.0	18.0		152	0	40	
CHERRY GLOSS 18MM/01		CHERRY GLOSS 18MM			18.0		80	0	82	
CHIPBOARD-18MM/01		CHIPBOARD-18MM	2440.0	1220.0	18.0		397	0	0	
EBONY MDF 18MM/01		EBONY MDF 18MM	3050.0	1220.0	18.0		240	0	0	
EBONY-LAM-1MM/01		EBONY-LAM-1MM	3050.0	1525.0	1.0		590	0	0	
GREEN GLOSS 18MM/01		GREEN GLOSS 18MM	3050.0	1525.0	18.0		32	0	20	
HARDBOARD-4MM/01		HARDBOARD-4MM	2440.0	1220.0	4.0		782	0	0	
HARDBOARD-WHITE-4MM/01		HARDBOARD-WHITE-4MM	2440.0	1220.0	4.0		195	7	0	
IVORY GLOSS 18MM/01		IVORY GLOSS 18MM	2440.0	1220.0	18.0		52	0	0	
MAPLE MDF 18MM/01		MAPLE MDF 18MM	2440.0	1220.0	18.0		93	0	0	
MED-DEN-FIBRE-18MM/01		MED-DEN-FIBRE-18MM	3050.0	1525.0	18.0		1221	0	155	
MED-DEN-FIBRE-25MM/01		MED-DEN-FIBRE-25MM	2440.0	1220.0	25.0		1089	0	190	
MEL-CHIP-15MM/01		MEL-CHIP-15MM	3050.0	1220.0	15.0		901	0	175	
MEL-CHIP-15MM/02		MEL-CHIP-15MM	2440.0	1220.0	15.0		729	0	110	
MEL-CHIP-18MM/01		MEL-CHIP-18MM	3050.0	1220.0	18.0		933	6	210	
MEL-CHIP-18MM/02		MEL-CHIP-18MM	2440.0	1220.0	18.0		370	8	40	
MFC18-ASH/01		MFC18-ASH	2440.0	1220.0	18.0		2	0	0	
MFC18-BEECH/01		MFC18-BEECH	3050.0	1525.0	18.0		1702	0	215	
MFC18-BEECH/02		MFC18-BEECH	2440.0	1220.0	18.0		1630	2	205	
MFC18-BLACK/01		MFC18-BLACK	2800.0	2070.0	18.0		32	0	0	
MFC18-EBONY/01		MFC18-EBONY	3050.0	1220.0	18.0		805	0	185	
MFC18-EBONY/02		MFC18-EBONY	2440.0	1220.0	18.0		523	0	42	

Board library- Boards only view


Boards only with Offcuts

Board library

File Edit View Help

Boards

Board code	Type	Material	Length	Width	Thickness	Information	Stock	Res	Order
Z-DRAWER-SCREW		Z-FITTINGS	0.0	0.0	0.0		1730	0	0
ZH120-HINGE		Z-FITTINGS	0.0	0.0	0.0		192	0	0
ZH180-HINGE		Z-FITTINGS	0.0	0.0	0.0		322	0	0
Z-HANGING-RAIL		Z-FITTINGS	0.0	0.0	0.0		93	0	0
Z-RUNNER		Z-FITTINGS	0.0	0.0	0.0		328	0	0
ZS25-6-ROUND-SCREW		Z-FITTINGS	0.0	0.0	0.0		2178	0	0
ZS40-8-CSUNK-SCREW		Z-FITTINGS	0.0	0.0	0.0		3249	0	0
Z-SHELF-SUPPORT		Z-FITTINGS	0.0	0.0	0.0		5375	0	0
Z-SINGLE		Z-FITTINGS	0.0	0.0	0.0		452	0	0
Z-SINGLE-BEECH		Z-FITTINGS	0.0	0.0	0.0		210	0	0
Z-SINGLE-BRASS		Z-FITTINGS	0.0	0.0	0.0		186	0	0
Z-SINGLE-DAK		Z-FITTINGS	0.0	0.0	0.0		123	0	0
XIVORY GLOSS 18MM/00005285	A	IVORY GLOSS 18MM	2440.0	664.0	18.0		1	0	0
WK6 - CABINET/001	X	MFC18-BEECH	3050.0	281.4	18.0		1	0	0
WK6 - CABINET/002	X	MFC18-BEECH	840.0	450.0	18.0		1	0	0
WK6 - CABINET/003	X	MFC18-BEECH	578.0	492.4	18.0		1	0	0
X00125/0001	X	MFC18-TEAK	780.0	1011.0	18.0		1	0	0
X00135/0003	X	MFC18-TEAK	564.0	488.0	18.0		2	0	0
X00148/0001	X	MFC18-TEAK	950.0	620.0	18.0		1	0	0
XIVORY GLOSS 18MM/00005286	X	IVORY GLOSS 18MM	538.0	349.5	18.0		1	0	0
XIVORY GLOSS 18MM/00005287	X	IVORY GLOSS 18MM	664.0	200.7	18.0		1	0	0

NUM

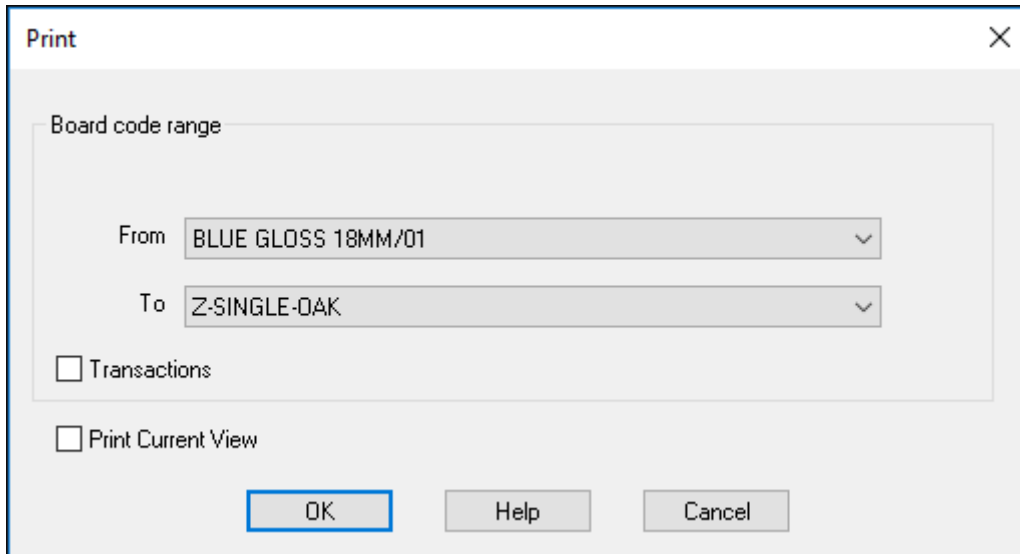
Boards only with offcuts

Board library - Print and Export



There are a range of options to print the Board data

The program prompts for the range of items to print and whether transactions are included.



The image shows a 'Print' dialog box with a title bar containing 'Print' and a close button (X). The dialog is divided into a main area and a footer area. The main area is titled 'Board code range' and contains two dropdown menus: 'From' with the value 'BLUE GLOSS 18MM/01' and 'To' with the value 'Z-SINGLE-OAK'. Below these are two checkboxes: 'Transactions' and 'Print Current View', both of which are currently unchecked. The footer area contains three buttons: 'OK', 'Help', and 'Cancel'. The 'OK' button is highlighted with a blue border.

Boards print

The print out is based on the current view - adjust the columns on screen to alter the print.

Columns can be hidden via the View menu which controls the on-screen display.

Board library										
Board code	Type	Length	Width	Infor...	Stock	Res	Order	Cost	Limit	Bin
BLUE-LAM-1MM	Blue Laminate 1mm Thickness:1.0 Book:10									
BLUE-LAM-1MM/01		2440.0	1220.0		152	0	0	5.320	0	232
CHERRY LAM 1MM	Cherry laminate 1mm Thickness:1.0 Book:10									
CHERRY LAM 1MM/01		2440.0	1220.0		80	0	0	5.230	0	192
CHIPBOARD-18MM	Chipboard Core 18mm Thickness:18.0 Book:0									
CHIPBOARD-18MM/01		2440.0	1220.0	BIN 180	397	0	0	2.950	0	180
EBONY-LAM-1MM	Ebony Laminate 1mm Thickness:1.0 Book:10									
EBONY-LAM-1MM/01		3050.0	1525.0	BIN 221	590	0	0	5.300	0	221
GREEN-LAM-1MM	Green Laminate 1mm Thickness:1.0 Book:10									
GREEN-LAM-1MM/01		3050.0	1525.0		32	0	0	5.320	0	242
HARDBOARD-4MM	Hardboard 4mm Thickness:4.0 Book:8									
HARDBOARD-4MM/01		2440.0	1220.0	BIN 133	782	18	0	0.890	0	133
MAPLE LAM 1MM	Maple laminate 1mm Thickness:1.0 Book:10									
MAPLE LAM 1MM/01		2440.0	1220.0		93	0	0	5.230	0	166
MED-DEN-FIBRE-18MM	Medium Density Fibreboard 18mm Thickness:18.0 Book:0									
MED-DEN-FIBRE-18MM/01		3050.0	1525.0	BIN 127	1221	19	155	4.500	0	127
MED-DEN-FIBRE-25MM	Medium Density Fibreboard 25mm Thickness:25.0 Book:0									
MED-DEN-FIBRE-25MM/01		2440.0	1220.0	BIN 125	1089	0	190	6.300	0	125
MEL-CHIP-15MM	Prelaminated - White 15mm Thickness:15.0 Book:0									
MEL-CHIP-15MM/01		3050.0	1220.0	BIN 160	901	0	175	2.590	0	160
MEL-CHIP-15MM/02		2440.0	1220.0	BIN 162	729	0	110	2.560	0	162
MEL-CHIP-18MM	Prelaminated - White 18mm Thickness:18.0 Book:0									
MEL-CHIP-18MM/01		3050.0	1220.0	BIN 150	933	13	210	3.180	0	150
MEL-CHIP-18MM/02		2440.0	1220.0	BIN 151	370	46	40	3.140	0	151
MFC18-ASH	Prelaminated - Ash 18mm Thickness:18.0 Book:0									
MFC18-ASH/01		2440.0	1220.0		2	0	0	3.450	0	
MFC18-BEECH	Prelaminated - Beech 18mm Thickness:18.0 Book:0									
MFC18-BEECH/01		3050.0	1525.0		1699	2	215	3.210		
MFC18-BEECH/02		2440.0	1220.0		1604	12	205	2.960		
WK6 - CABINETS/0001		3050.0	281.4		1	0	0	1.605		
WK6 - CABINETS/0002		3050.0	450.0		1	0	0	1.605		

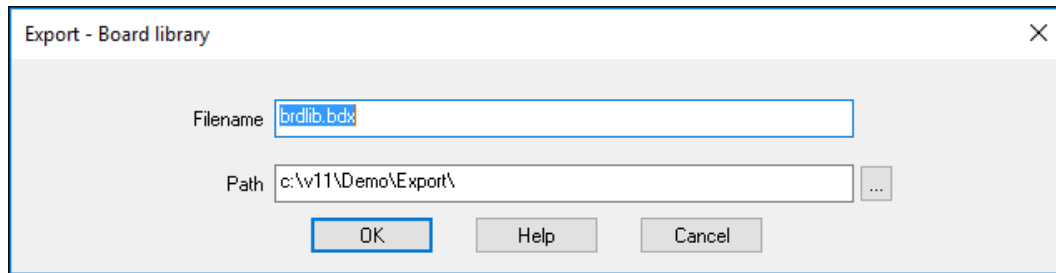
Board library print

Use **File - Print setup** - to select and set up the printer before printing.

Board data can also be exported to an external file.

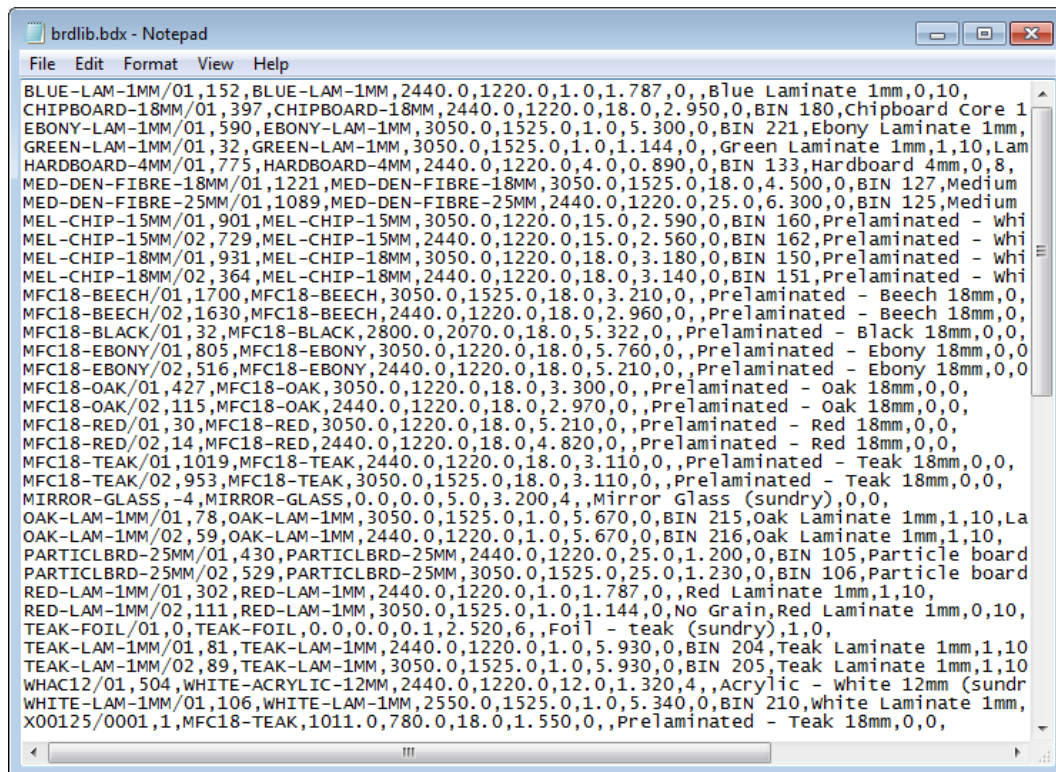
Export Board library

The board library contents can be exported to an ASCII/Unicode file.



Board library print

The file is placed in the path for export data by default.

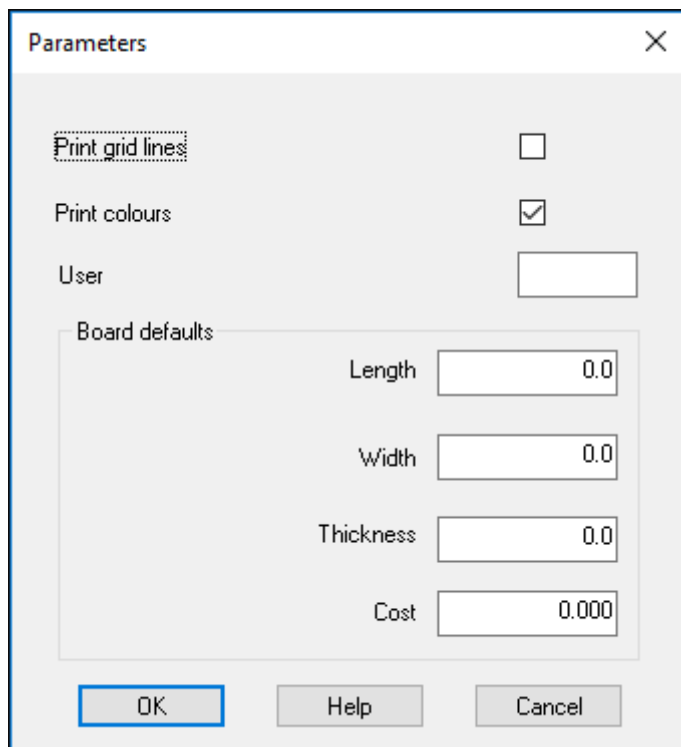


Board library print

There is one line for each board (the material records are not exported). The format is 'bdx' which is an ASCII/Unicode file with the records in a defined order (details of the BDx format are in the online help).

Board library parameters

The parameters are used to set up the board library view and to set up default values for entering board - this can help to speed up data entry.



The screenshot shows a dialog box titled "Parameters" with a close button (X) in the top right corner. The dialog contains the following settings:

- Print grid lines:** An unchecked checkbox.
- Print colours:** A checked checkbox.
- User:** An empty text input field.
- Board defaults:** A group box containing four text input fields:
 - Length:** 0.0
 - Width:** 0.0
 - Thickness:** 0.0
 - Cost:** 0.000

At the bottom of the dialog are three buttons: "OK" (highlighted with a blue border), "Help", and "Cancel".

Board library parameters

Stock control module

Stock transactions are only available with the Stock control module.

With the Stock control module offcuts from optimisation can be added back to the library and a full set of options are available for stock orders, issuing stock, stock receipts etc.

The stock control module can also be integrated with the Homag Automation SQL server stock management system.

13. More about Parameters and settings

Parameters are used for setting up the system. For example, to set up the types of saw in use and types of pattern allowed - using saw parameters; this ensures the patterns produced are suitable for the saw and optimised for it.

In a similar way parameters are used to set up, Machining centres, Destacking machinery, Edgebanders, Costing, Methods of saw transfer, and many other features.

Setting up parameters can be daunting at first, but it is typically a 'once only' task and most suppliers provide a range of examples and templates to use.

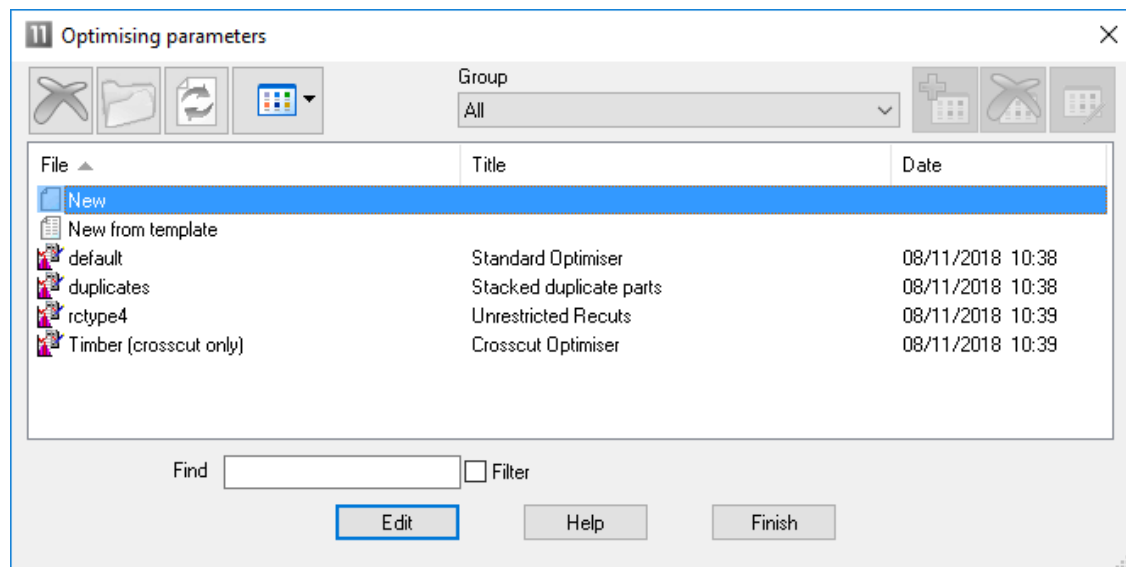
Most users should look at the system, optimising, saw transfer, and saw parameters carefully and then deal with the other lists as they are needed.

Parameter lists at the Main screen

- Optimising parameters
- Nesting parameters
- Saw parameters
- Material parameters
- System parameters
- Saw transfer parameters
- Part list import parameters
- Board list import parameters
- Requirements import parameters
- DXF import - layer name rules
- Edging parameters
- Destacking parameters
- Machining centre parameters
- Machining centre transfer parameters
- Tool sequence parameters
- Machine rate parameters
- Information boxes


How Parameters lists work

For some parameter lists, for example, Optimising, Nesting or Saw parameters there are typically several different lists each stored in a separate file. In this case the program offers a choice of list:-

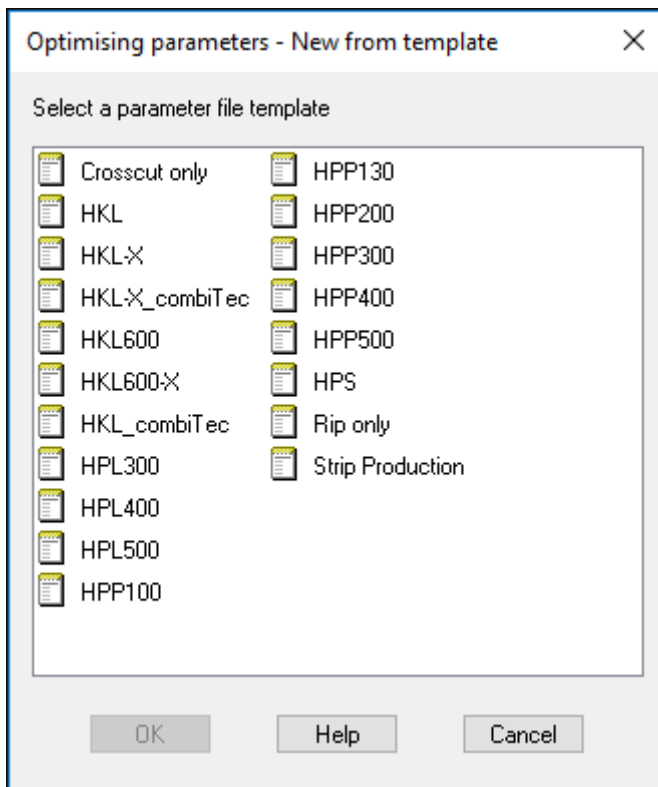


Parameter lists - select

- Select the list required or use New to create a new list of parameters.

 Use the Views option to change the view; the options are: 'Details', 'List', 'Small icons', 'Large icons'.

The 'New from template' option allows the creation of a new list from a previously defined list - this is useful where just a few values need to change. For Saw parameters, suppliers typically provide a template for most of their saw models.



Parameter templates

- Select a suitable template.

Even when using a template check the new list carefully as there may be one or two parameters that need further changes.

On selecting a file the program moves to the Parameter screen (in this example, Optimising parameters).

Optimising parameters

Most parameter screens operate in a similar way to the familiar Windows 'Property pages'. Click on an option or type in a value as necessary.

Many parameters show a diagram which gives a reminder of what the setting is for and how it operates.

- Click on HELP for full details of each parameter.

For some parameter lists such as *Machining centre parameters* or *Edging parameters* there is only one set for the program. In this case the program moves directly to the parameter screen.

Where the parameter screen shows a set of tabs at the top right - this means there are several pages of parameters. Click on the tabs to see the other pages.

Edging parameters

Laminate Edging Help view >>

Set the parameters for laminate use

Range
0 - 999
Millimetres

Overlap for laminates: On laminate length (total)

Overlap for laminates
On laminate length (total) 20.0
On laminate width (total) 15.0

Core oversize for laminating
On core length (per edge) 0.0
On core width (per edge) 0.0

Add to laminate size

Laminate overlap per edge
On bull nosed edges 25.0
On post formed edges 25.0

OK Print Help Cancel

Edging parameters

Some of the tabs only apply if you have a particular set up. For example, with the saw parameters the tabs for Multi-axis saws (are greyed out) if using a Single saw or sliding table saw.

Parameters controlling the look and style of screens and reports

There are also sets of Parameters that deal with the look and style of the reports and screens and how data is exported. These parameters are usually located in the same section of the program where they are used so it is easy to change the parameter and see the effect. The most commonly used are: Part list parameters and Review runs parameters (including export).

Parameters for each report

There are parameters to control the layout and content of each report in Review runs.
Move to a report and select: *Settings - Report settings*


Report settings - Management summary


Layout Font

Content

Available	Chosen
ft2	Description
ft3	Quantity
	m2
	m3
	Weight
	Percent
	Rate
	Cost
	Statistic
	Value

Title

Calculation = 

Decimal places 

Subtotals Total as: Sum

Grand-total Average

Column widths

Use default

Format

OK Help Cancel

Review runs - Report settings

This type of dialog is quite often used (in Review runs and Form design) where you are selecting a few fields from a list of available fields. The Available fields are shown on the left and the ones chosen on the right. In this example the chosen fields are for the Management summary in Review runs.

Changing screen and column sizes



Use the mouse on screens and grids to change the screen and column size - the settings are saved between sessions.

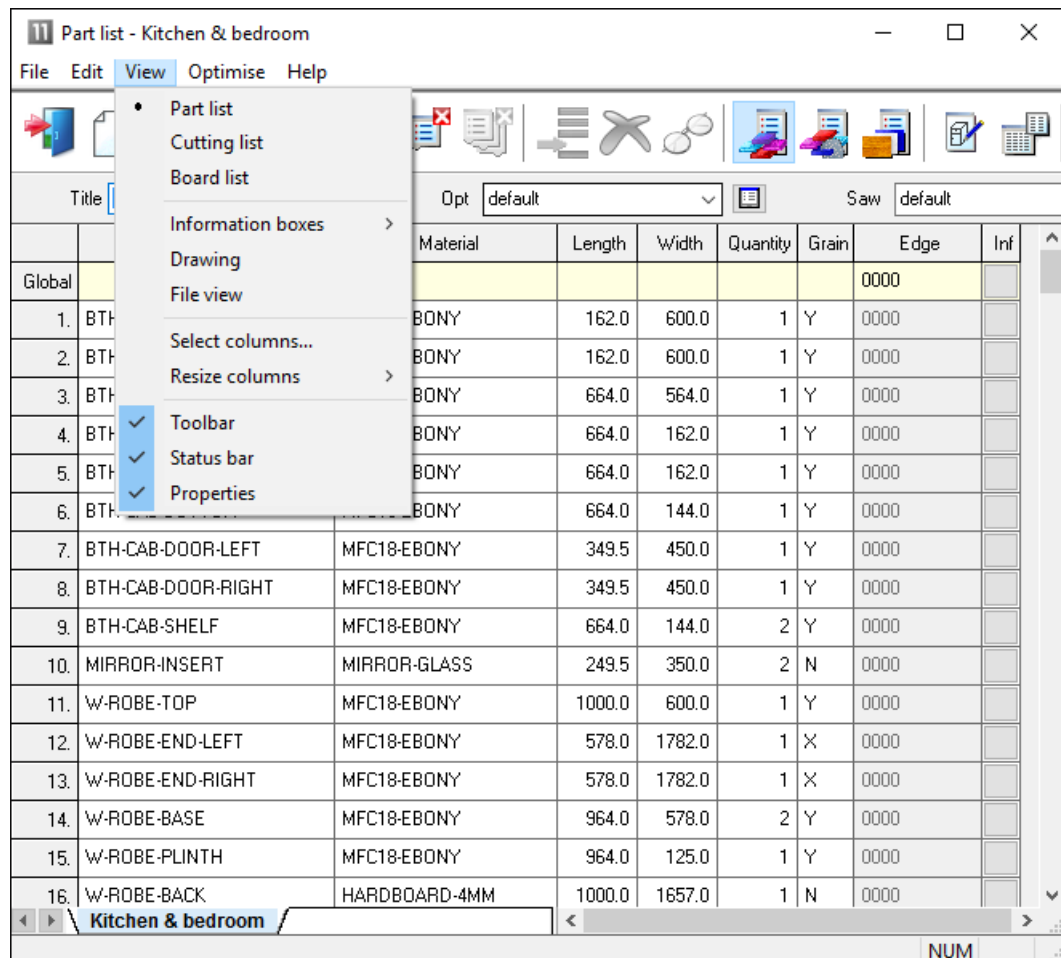
	Description	Material	Length	Width	Quantity	Grain	Edge	Inf
Global							0000	
1.	BTH-CAB-END-LEFT	MFC18-EBONY	162.0	600.0	1	Y	0000	
2.	BTH-CAB-END-RIGHT	MFC18-EBONY	162.0	600.0	1	Y	0000	
3.	BTH-CAB-BACK	MFC18-EBONY	664.0	564.0	1	Y	0000	
4.	BTH-CAB-TOP	MFC18-EBONY	664.0	162.0	1	Y	0000	
5.	BTH-CAB-SHLF-BASE	MFC18-EBONY	664.0	162.0	1	Y	0000	
6.	BTH-CAB-BOTTOM	MFC18-EBONY	664.0	144.0	1	Y	0000	
7.	BTH-CAB-DOOR-LEFT	MFC18-EBONY	349.5	450.0	1	Y	0000	
8.	BTH-CAB-DOOR-RIGHT	MFC18-EBONY	349.5	450.0	1	Y	0000	
9.	BTH-CAB-SHELF	MFC18-EBONY	664.0	144.0	2	Y	0000	
10.	MIRROR-INSERT	MIRROR-GLASS	249.5	350.0	2	N	0000	
11.	W-ROBE-TOP	MFC18-EBONY	1000.0	600.0	1	Y	0000	
12.	W-ROBE-END-LEFT	MFC18-EBONY	578.0	1782.0	1	X	0000	
13.	W-ROBE-END-RIGHT	MFC18-EBONY	578.0	1782.0	1	X	0000	
14.	W-ROBE-BASE	MFC18-EBONY	964.0	578.0	2	Y	0000	
15.	W-ROBE-PLINTH	MFC18-EBONY	964.0	125.0	1	Y	0000	
16.	W-ROBE-BACK	HARDBOARD-4MM	1000.0	1657.0	1	N	0000	

Review runs - Report settings

Move the mouse to a window edge or column edge and use the grab handles (holding down the left mouse button) to drag column, row or windows.

*Note - some screens have a fixed size or fixed minimum size and cannot be changed

On most data screens, for example, the Part list, Review runs summaries, Board list, Board there is also a 'View menu' with various options for changing the screen display and operation.



View menu

The size of the screen and the size of the columns can be changed using the mouse.

Settings menus - Many screens also have a *Settings menu* which can be used to set what is shown on the screen and how it operates..

System parameters

The system parameters are important - these mostly control the overall operation of the program, for example, the measurement mode to use, the language to use, how files are named, the paths for storing data ...

The screenshot shows the 'System parameters' dialog box with the 'General' tab selected. The dialog has a title bar with a close button (X) and a 'Help view >>' button. The tabs include 'General', 'Paths and files', 'Rules1', 'Rules2', 'Divide part lists', 'Boards', 'Stock control', 'Routing / nesting', and 'Nesting'. The 'General' section contains the following settings:

- Language:** English (UK) (dropdown)
- Language for help:** English (UK) (dropdown)
- Measurement mode:**
 - Metric (0.0 - 9999.9 mm)
 - Decimal inches (0.000 - 999.999)
 - Fractional inches (0 - 999-63/64)
- Order of dimensions on screens and printouts:**
 - Parts and boards: Length Width (dropdown)
 - Products: Width Height Depth (dropdown)
- Modules:**
 - PO - Professional optimiser
 - SO - Standard optimiser
 - NE - Nesting optimiser
 - SC - Stock control
 - PQ - Product library / quotes
- Style of date:**
 - Day/Month/Year
 - Month/Day/Year
- Company name:** DEMO USER 1 (text field)

At the bottom of the dialog are buttons for 'OK', 'Print', 'Help', and 'Cancel'.

System parameters - General

There are several pages of parameters each for different aspects of the program.

The second tab covers the paths for storing data.

The screenshot shows the 'System parameters' dialog box with the 'Paths and files' tab selected. The dialog has a title bar with a close button (X) and a 'Help view >>' button. The main area is divided into several sections:

- Paths and files:** A list of 17 file paths, each with a text input field and a browse button (...). The paths are:
 - Path for data: c:\w11\Demo\Data\
 - Path for part lists: (empty)
 - Path for library data: c:\w11\Demo\Libs\
 - Path for stock libraries: (empty)
 - Path for import data: c:\w11\Demo\Import\
 - Path for export data: c:\w11\Demo\Export\
 - Path for accounts: c:\w11\Demo\Libs\
 - Path for customer data: c:\w11\Demo\Libs\
 - Path for pictures: (empty)
 - Path for forms / labels: (empty)
 - Path for shared control files: (empty)
 - Path for machine transfer log file: (empty)
 - Path for stock import: (empty)
 - Path for import parameters: (empty)
 - Path for back-up: c:\w11\Demo\Backup\
- Back-up interval (days):** A spin box set to 0.
- Auto-archiving:** A section with several options:
 - Enable auto-archiving
 - Permanently delete files
 - Runs
 - Quotes
 - Product requirements
 - Files older than (days): 60
 - Path for archive: c:\w11\Demo\Backup\
- Auto-compact board library:**

At the bottom of the dialog are four buttons: OK, Print, Help, and Cancel.

System parameters - Paths and files

Click on a tab to move to that section and check and adjust the parameters.

Once set the system parameters should rarely need to be changed again. The installed program is set up with reasonable defaults - and these are fine for running the program initially - but check the parameters carefully to make sure the program is set up to match your preferences and way of working.

Demo data - the system is provided with several sets of parameter data (and your supplier may have added some others) - these can be used as the base for your setup.

14. More about the Saw Interface

After Optimisation the patterns (cutting instructions) are transferred to the Saw.



Saw interface

The program supports a wide range of saw controllers:-

CADmatic (all types)

Compumatic

Topmatic

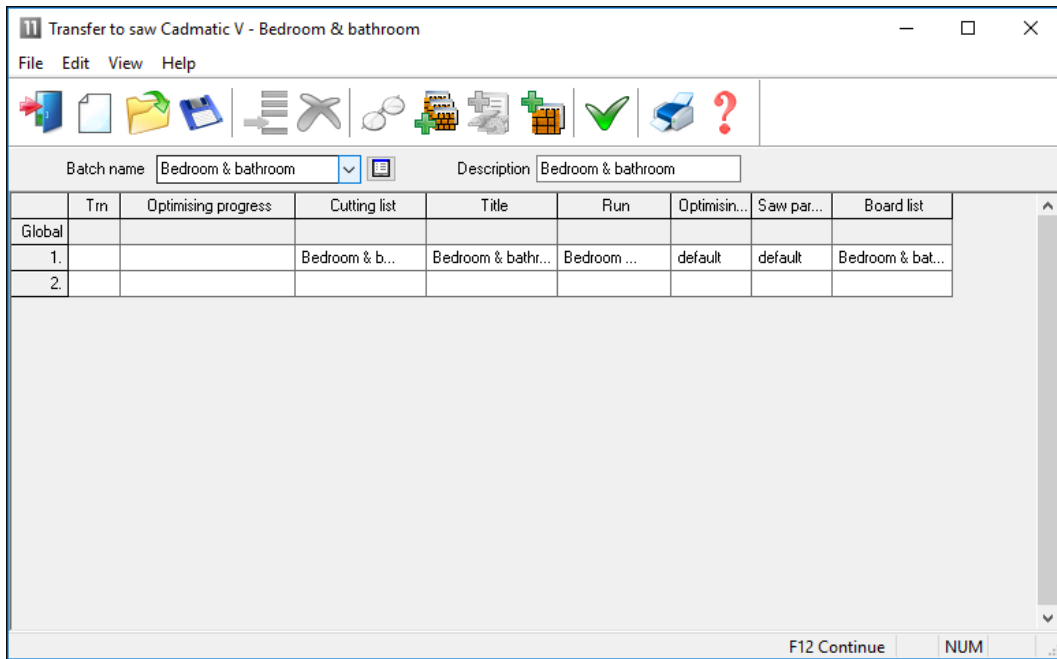
Homag Sawtech (CHxx, NPS400, Ilenia)

- Table saws
- Online PC
- Various other controllers
- Printed patterns and cutting instructions for manual saws



At the main screen select the Saw transfer

For Saw transfer, for example, the program prompts with the current job.

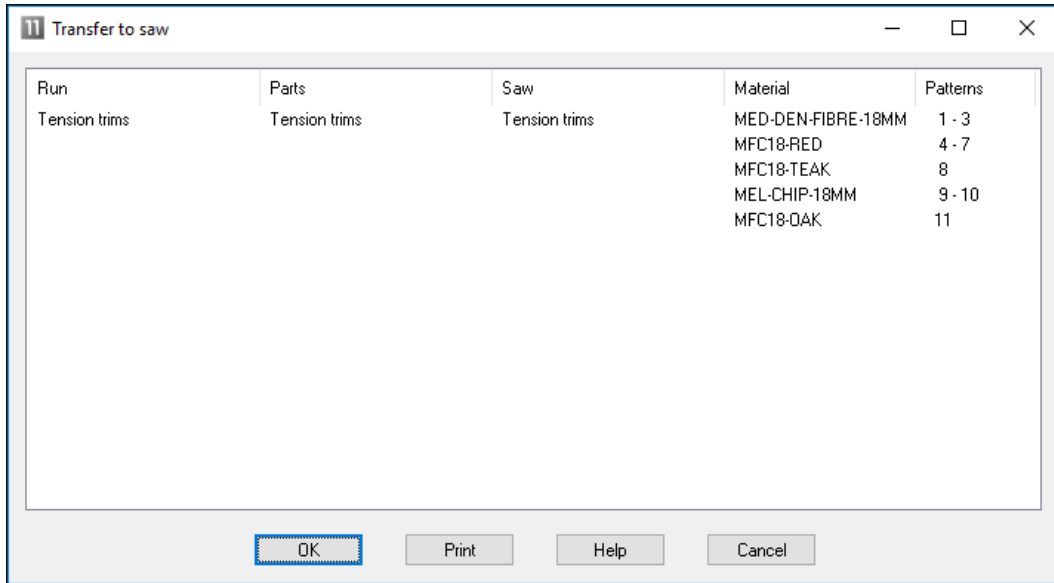


Transfer to saw batch screen



Select the 'Continue' option

The program displays the data to transfer.



Transfer to Saw

- **OK** to confirm

The transfer is finished.

Note - For practical use the saw transfer and machining transfer need to be set up for the company's machines. There are parameters for this and a wide range of options are available.

Typically the saw or machining centre transfer sends data to a location on the Network (Path for Saw data) and a separate program provided by the machinery manufacturer runs and sends the data to the machine. This can all be integrated into the above transfer process.

Analyse Shifts

Some saw controllers can record information as the saw is working. There are reports to analyse this data on a shift basis or to analyse each run. Use this option to analyse the feedback from the saw for each shift. At the main screen:-

- Select: **Machine Interface**
- Select the saw (e.g. CADmatic 4)
- Select: **Analyse shifts**

Click on the Combo box to view the current list of shifts and click on a report to select it.. A summary of the shift is shown.

The screenshot shows a window titled 'Analyse shifts' with a menu bar (File, Help) and a toolbar. A dropdown menu shows '26-SEP-15 (1) 8:13:45 AM'. The main area displays a summary of shift data in a text-based table format.

/ Shift activity / Error summary / Saw activity \					
Shift number	1				
Operator	KJW				
Cycles	100				
		hh:mm		hh:mm	
Start of shift	26-09-15	08:13	Cutting time	7:22	88.17%
End of shift	26-09-15	16:45	Error time	0:12	2.31%
		----	Waiting time	0:30	6.02%
Shift time		8:32	Service time	0:18	3.50%
Break time		0:10	Operating	8:22	100.00%
=====					
Waiting time	hh:mm				
Standstill	0:01				
Unexpected interruption	0:02				
Waiting for material	0:03				
Waiting for destacking area to be cleared	0:02				
Mechanical breakdown	0:03				
Saw blade change	0:00				
Other	0:19				

	0:30				

Analyse shifts summary

At the top are the shift number, operator's initials and the number of saw cycles during the shift. The other information shows the start and end of the shift and the total elapsed shift time. The analysis of the time is split between the following categories:

Shift time - total duration of shift

Cutting time - time that the saw is cutting
 Error time - down time recorded against saw errors
 Service time - time for service operations (e.g. change saw blade)
 Waiting time - saw not in use

Waiting time = Op time - cutting - error - service

Break time - operator's break (for example: meals, rest)

Operating time - shift time less break time: *Op time = shift - break*

At the foot of the report is the material usage during the shift. This shows the area of parts and board processed during the shift.

- Click on the tabs at the top right to see more details. The reports available are:-

- Saw activity - shows the full details of each cutting cycle

- Error summary - shows any errors and the cause

The screenshot shows a software window titled 'Analyse shifts' with a menu bar (File, Help) and a toolbar. A dropdown menu shows 'Shifts' with the selected shift '26-SEP-15 (1) 8:13:45 AM'. At the top right, there are three tabs: 'Shift activity', 'Error summary', and 'Saw activity'. The 'Error summary' tab is active, displaying a table with the following data:

Number	Message	Time (hh:mm:ss)
010	Head cut saw blade obstructed by clamps	0:04:07
016	Excessive vibration of rip saw blade	0:01:16
017	Rip saw waste chute is blocked	0:01:27
031	Pattern too complex	0:00:23
032	Job is too large for available memory	0:04:22
Total		0:11:35

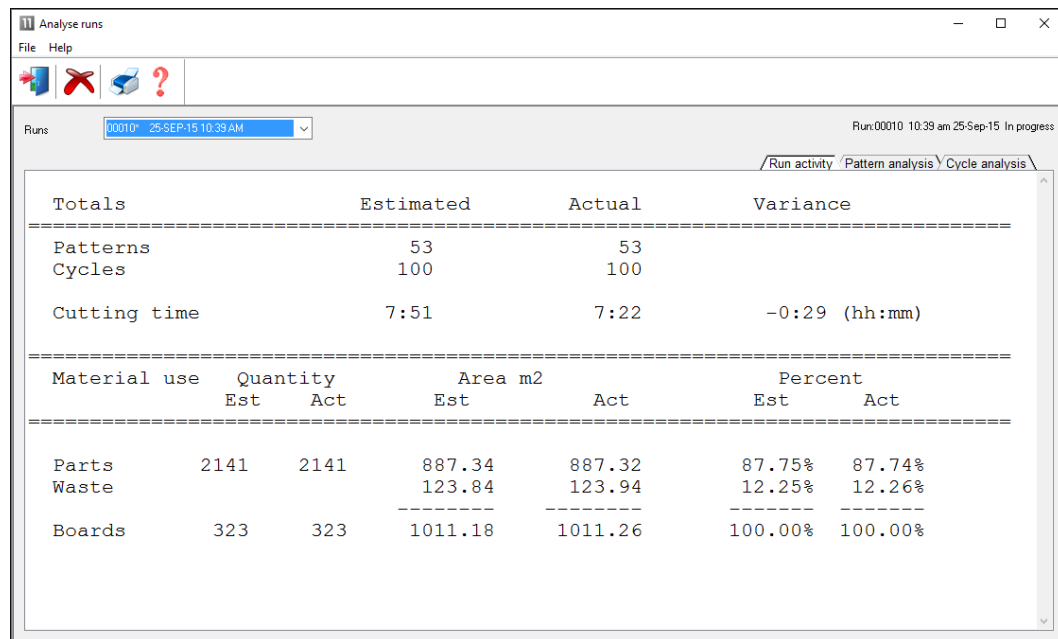
Analyse shifts summary of errors

Analyse runs

The feedback data from the saw can also be analysed in terms of runs, that is, comparing the estimated values for a run with the time actually taken at the saw.

- Select: **Machine Interface**
- Select the saw (e.g. CADmatic 4)
- Select: **Analyse runs**

- Click on the combo box to see a list of the run data available and click on a run to see the details for that run.



The screenshot shows a software window titled 'Analyse runs' with a menu bar (File, Help) and a toolbar. A dropdown menu shows '00010 25-SEP-15 10:39 AM'. The main area displays a summary table for 'Run:00010 10:39 am 25-Sep-15 In progress'. The table has tabs for 'Run activity', 'Pattern analysis', and 'Cycle analysis'. The data is as follows:

Totals	Estimated	Actual	Variance
Patterns	53	53	
Cycles	100	100	
Cutting time	7:51	7:22	-0:29 (hh:mm)

Material use	Quantity		Area m2		Percent	
	Est	Act	Est	Act	Est	Act
Parts	2141	2141	887.34	887.32	87.75%	87.74%
Waste			123.84	123.94	12.25%	12.26%
Boards	323	323	1011.18	1011.26	100.00%	100.00%

Analyse Runs summary

The 'Est' and 'Act' columns show the difference between the estimated values and the actual values. In this case the parts produced and waste were the same but the actual cutting time was shorter than estimated.

- Click on a tab at the top right for more detailed reports, that show the differences on a per pattern and per cycle basis, for example:-

Cycle analysis

Ptn	Cycle	Boards	Parts	Start	End	Waiting time (mm:ss)
1	1	5	30	25-Sep-15 08:15:35	08:21:05	0:00
1	2	5	30	25-Sep-15 08:21:15	08:26:45	0:00
1	3	5	30	25-Sep-15 08:26:55	08:32:25	0:00
1	4	2	12	25-Sep-15 08:32:35	08:38:05	0:00
2	1	5	45	25-Sep-15 08:38:15	08:43:59	0:00
2	2	5	45	25-Sep-15 08:44:09	08:49:53	0:00
3	1	5	20	25-Sep-15 08:50:03	08:55:41	0:00
3	2	2	8	25-Sep-15 08:55:51	09:00:02	0:00
4	1	5	30	25-Sep-15 09:00:12	09:05:15	0:00
4	2	1	6	25-Sep-15 09:05:25	09:11:55	1:27
5	1	4	44	25-Sep-15 09:12:05	09:16:40	0:00
6	1	3	36	25-Sep-15 09:16:50	09:26:28	0:00
7	1	2	26	25-Sep-15 09:26:38	09:35:21	0:00
8	1	1	9	25-Sep-15 09:35:31	09:40:03	0:00
9	1	1	9	25-Sep-15 09:40:13	09:45:10	0:00
10	1	5	20	25-Sep-15 09:45:20	09:48:06	0:00
10	2	5	20	25-Sep-15 09:48:16	09:51:02	0:00
10	3	5	20	25-Sep-15 09:51:12	09:53:58	0:00

Cycle analysis

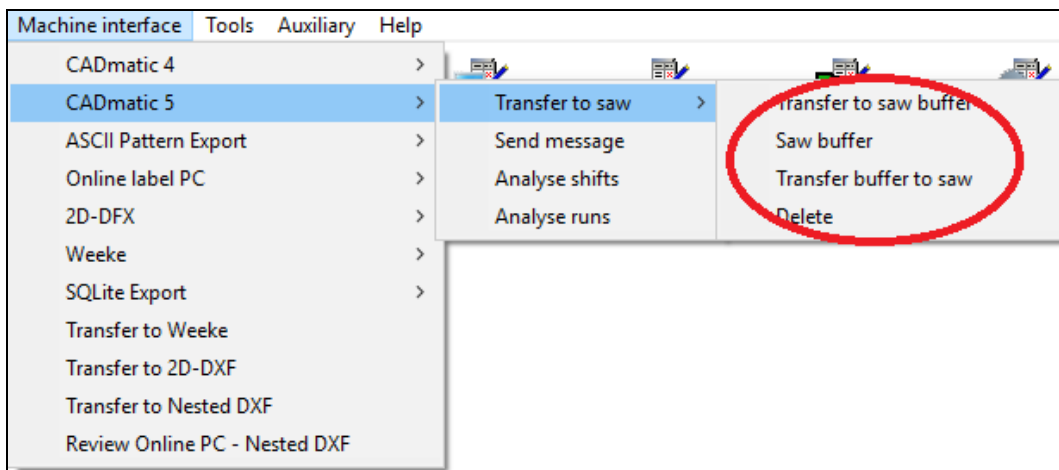
The Saw interface option also includes an option to communicate and send messages to the saw during operation.

Saw Buffer

When transferring data to the Saw with multiple users it can be useful to set up the Saw transfer so that only one user acts as the master location for sending data to the saw. This allows the various incoming runs to be sorted in a buffer and sent to the saw in a more controlled way.

This is set by a Saw transfer parameter: 'Saw buffer'.

If this way of working is set up the saw interface menu (for the master user) contains extra options for managing the saw data.



Buffered transfer to saw

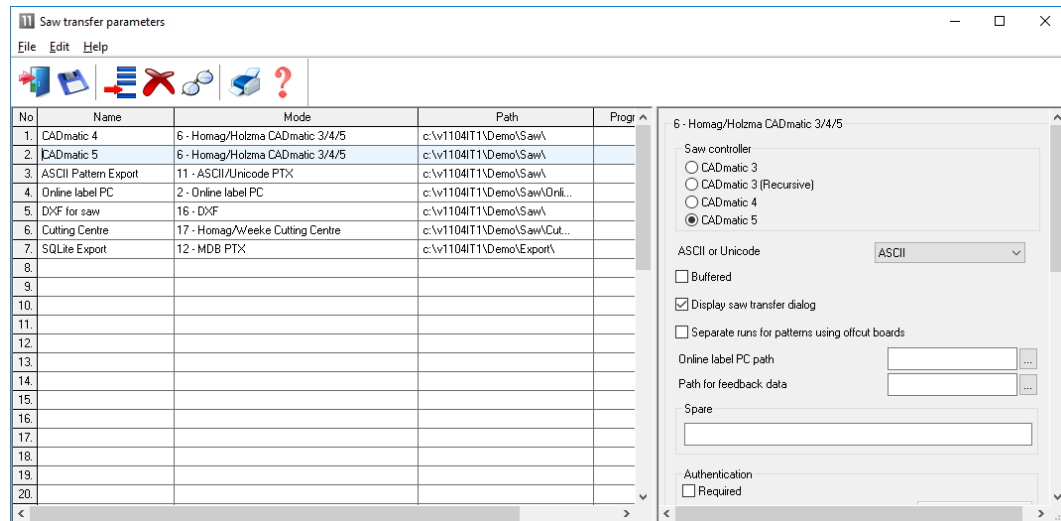
The options are:-

- Transfer to saw buffer
- Saw Buffer
- Transfer buffer to saw
- Delete

Saw transfer parameters

The various links to the saws are set up with the *Saw transfer parameters*. Use one row for each saw.

There are many different types of saw and saw controller and the parameters are often very different for each type. The first thing to set is the MODE which determines the overall type of saw. e.g. Homag/Holzma CADmatic 3/4/5.



Saw transfer parameters

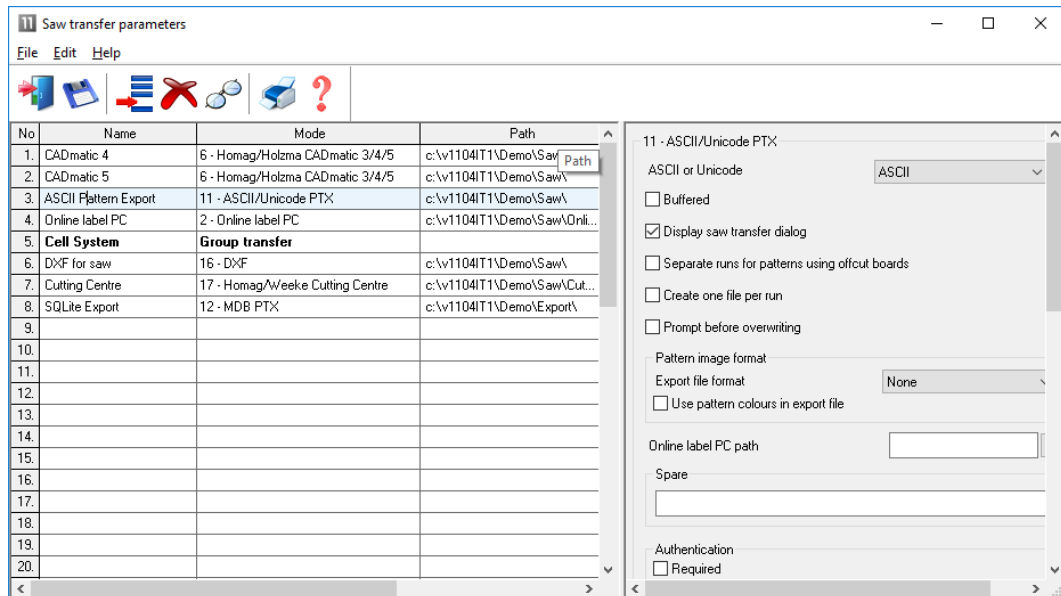
For each row there are extra parameters in the right hand pane to allow for the accurate set up of each saw and its proprietary settings.

All the saw types set up via these parameters are shown as options on the Machine Interface menu.

Most suppliers now provide typical examples of how to set the Saw transfer parameters for their types of saw and controller.

Transfer to Groups

The Saw transfer parameters do not only apply to saws and can be used to transfer data to a group of machines on a flow line, for example, a Homag/Holzma Saw and Homag Automation destacking machine, using the 'Group transfer' option.



Saw transfer parameters - transfer to Group

The machines in the group and the order of the machines are set up via the Saw transfer parameters. There are extra options in the right hand pane to set up the communication link for each machine on the Network.

The Group option appears as an item on the Machine interface menu at the main screen and this can then be used like any other transfer option to send data to all the machines in the group; this ensures the same data is sent to each machine and it is correctly co-ordinated.

This type of transfer is only suitable for transfer modes where export file names are unique and create 'one file per run'. The pattern exchange transfer format (PTX) is typically used for sending data to other machines such as Homag, Homag Automation etc.

15. Managing data, Import data, Export results

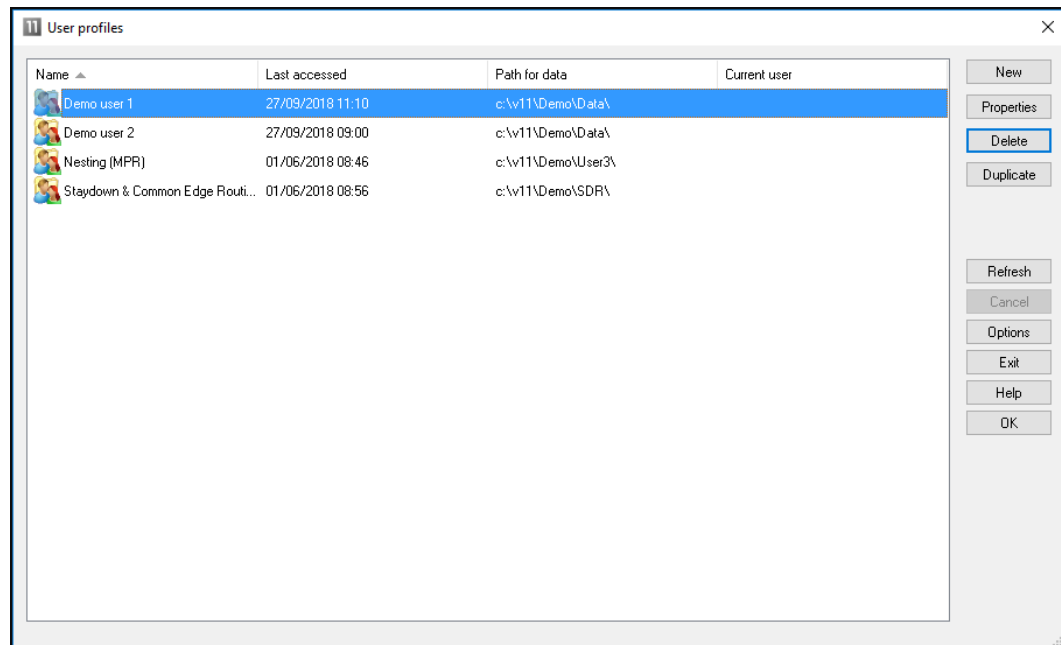
There are several utilities built into the software to help organising data, data backup, and interfacing with external files, databases and systems.

- Manage data and files
- Back up user directories
- Online help
- Importing and exporting data

User Profiles

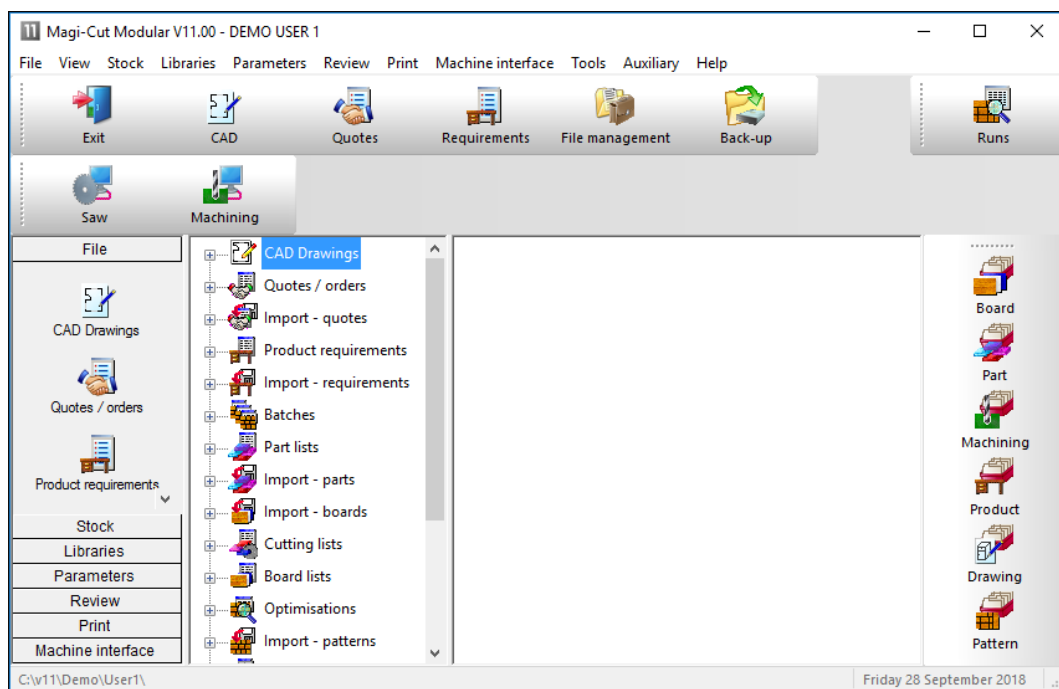
The data is organised around 'User profiles'. Each user has their own 'profile' which stores the various settings they use and is controlled by a password. On entering the program the program moves to the last profile used or prompts with the list of user profiles available. To see all the User profiles, at the Main screen

- Select: **File - User profiles**



User profile list

- Click on a profile to move to it



User profile - main screen

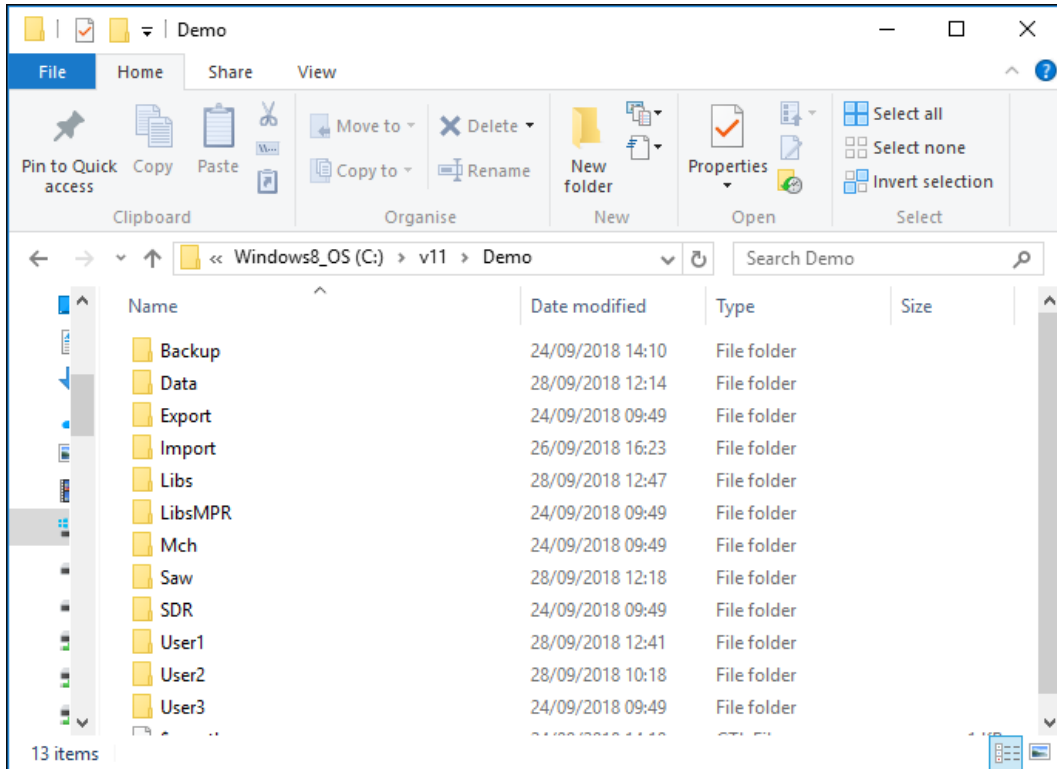
In this example the profile is 'Demo user 1'.

This profile contains all the screen and other default settings, system parameter settings, part lists and optimisations for this user.

This data is spread over a directory structure set by the System parameter: *Paths and files*

Typically any common data between users, such as, Board library, product library, import data, or export data is shared between profiles - so all users access the same common data.

On the computer the data structure often looks similar to the following.



Directory structure

In the above structure 'V11' is the directory where the Program is installed. 'Demo' is the main data directory. Within the main data directory the User profiles are:-

'User1'
'User2'
'User3'

The common data, for example the board library, is located in the 'Libs' directory.

The system parameter tab: *Paths and files* for 'Demo User 1' shows how this profile is mapped on to the data structure.

The screenshot shows the 'System parameters' dialog box with the 'Paths and files' tab selected. The dialog has a title bar with a close button (X) and a 'Help view >>' button. The main area contains several input fields and checkboxes for configuring file paths and auto-archiving settings.

Parameter	Value
Path for data	c:\v11\Demo\Data\
Path for part lists	
Path for library data	c:\v11\Demo\Libs\
Path for stock libraries	
Path for import data	c:\v11\Demo\Import\
Path for export data	c:\v11\Demo\Export\
Path for accounts	c:\v11\Demo\Libs\
Path for customer data	c:\v11\Demo\Libs\
Path for pictures	
Path for forms / labels	
Path for shared control files	
Path for machine transfer log file	
Path for stock import	
Path for import parameters	
Path for back-up	c:\v11\Demo\Backup\
Back-up interval (days)	0
Auto-archiving	
<input type="checkbox"/> Enable auto-archiving	<input checked="" type="checkbox"/> Runs
<input type="checkbox"/> Permanently delete files	<input checked="" type="checkbox"/> Quotes
	<input checked="" type="checkbox"/> Product requirements
Files older than (days)	60
Path for archive	c:\v11\Demo\Backup\
<input type="checkbox"/> Auto-compact board library	

At the bottom of the dialog are buttons for 'OK', 'Print', 'Help', and 'Cancel'.

System parameter: *Paths and files*

In this case the 'Path for library data' points to the 'Libs' directory so the common data is shared.

The 'Path for Data' points to the 'Data' directory - and the part lists and runs etc. are also shared between the users and stored in one place. This allows any user to log on and access any of the part lists for example.

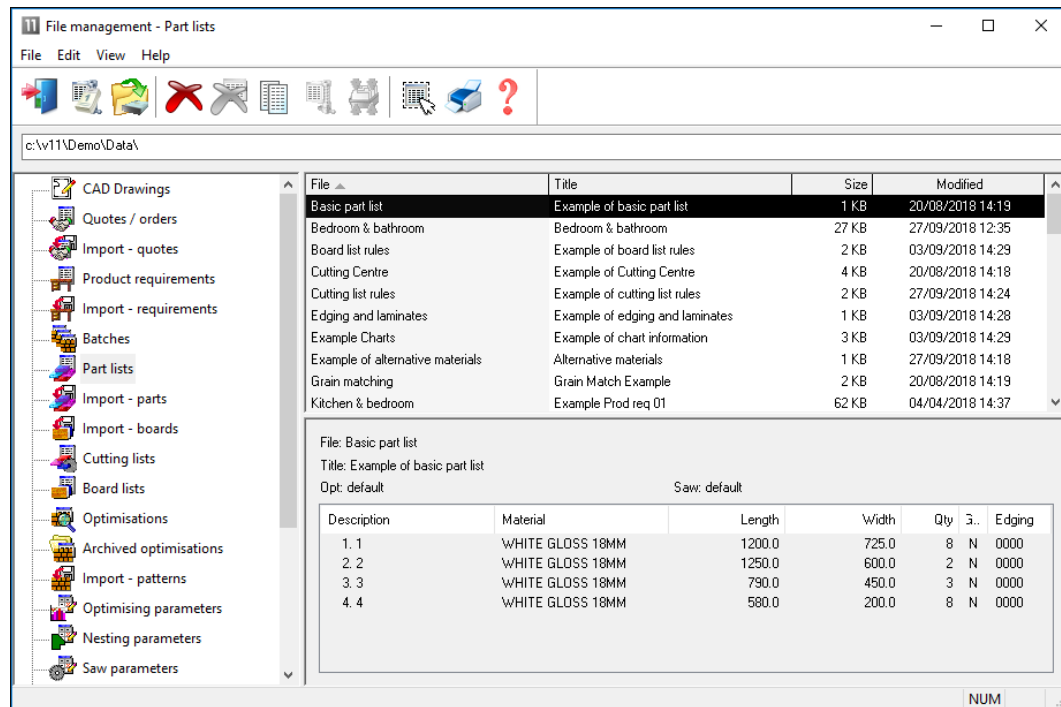
Another very common arrangement is for users to each have their own 'Data' directory so that part lists etc. are reserved for them.

In this example, the users are all using same computer - and a very similar arrangement is often used on Networks but note that the arrangement of data for network use does require some careful planning.

File Management

It is not necessary to use Windows to manage the data and file structure. The program provides a full range of tools for managing files. At the main screen:-

- Select: **File - File management**



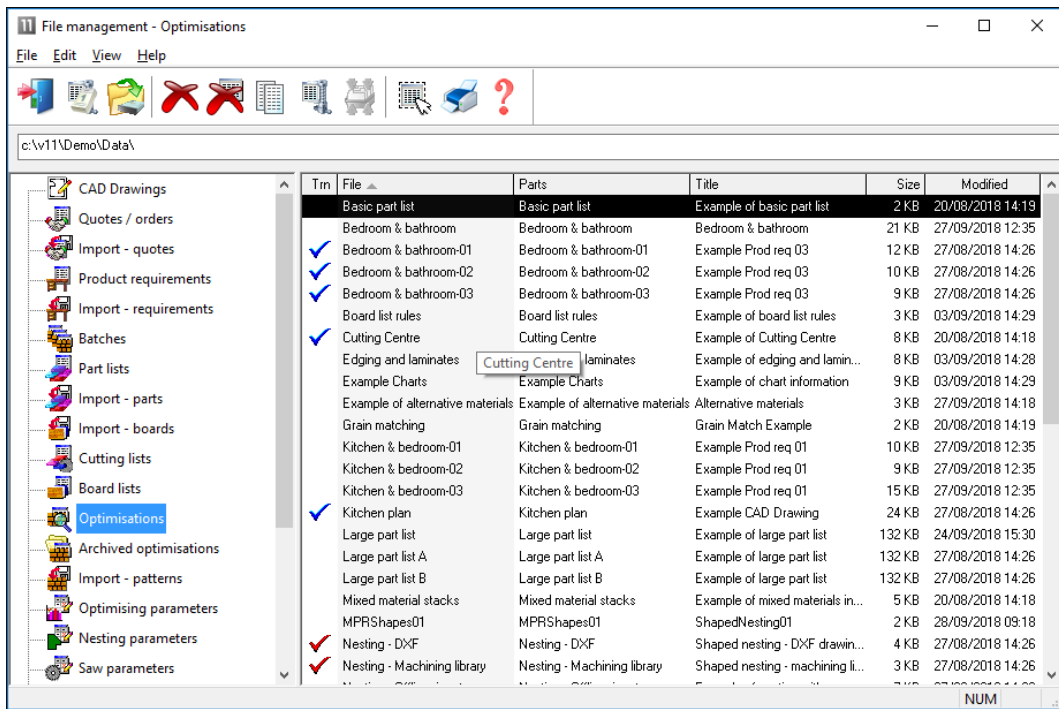
File Management

The pane on the left shows the various file type used by the program, for example, part lists, optimisations (runs), Optimising parameters...

- Select a category from the left pane

The list of files (for example, part lists) is shown at the right. The contents of the current file are shown towards the foot of the screen.

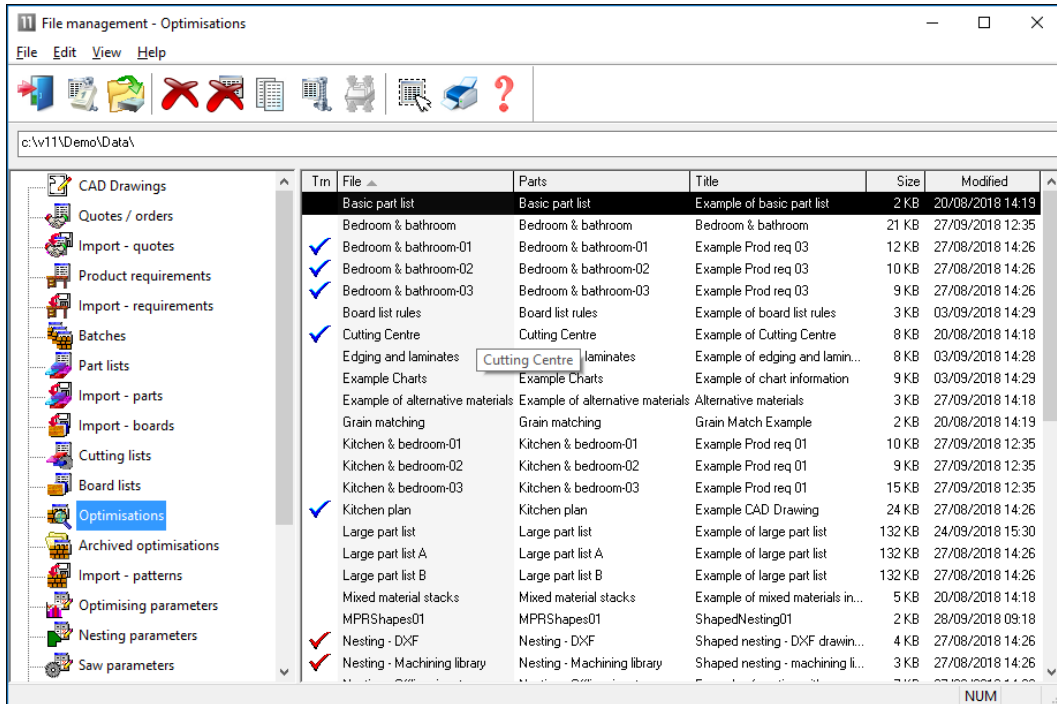
The following screen shows a list of optimisations (Runs).



File Management - optimisations

Note in this case the file contents are not shown - as the run file is not a simple ASCII file also a run e.g. 'Basic part list' is actually a collection of, typically, several different files.

- Use the mouse or navigation buttons to select a file or files.



File management - select files

- Use the tools to delete or copy files as required.



- delete files



- copy files

Windows Explorer - it is also possible to use the regular *Windows Explorer* options to manage data but *File Management* presents the data by type and keeps track of any related or temporary files, for example, extra files produced when optimising (runs).

Back up

The File management screen also includes a link to the back-up options.



Back-up user profile

Back up

The Back-up process makes a copy of the User profile and stores it in a single BKP file. It is a good policy to always take a back up of the user profile before making any substantive changes with File Management.

The backup includes the user profile and the Path for data and the Path for library data - so most of the user data is copied. There are some exceptions, for example, the path for import and export data so check the details in the Online help before using Back up extensively so that it is clear what is safe and what is not.

Note - The Back up option is also available at the main screen.

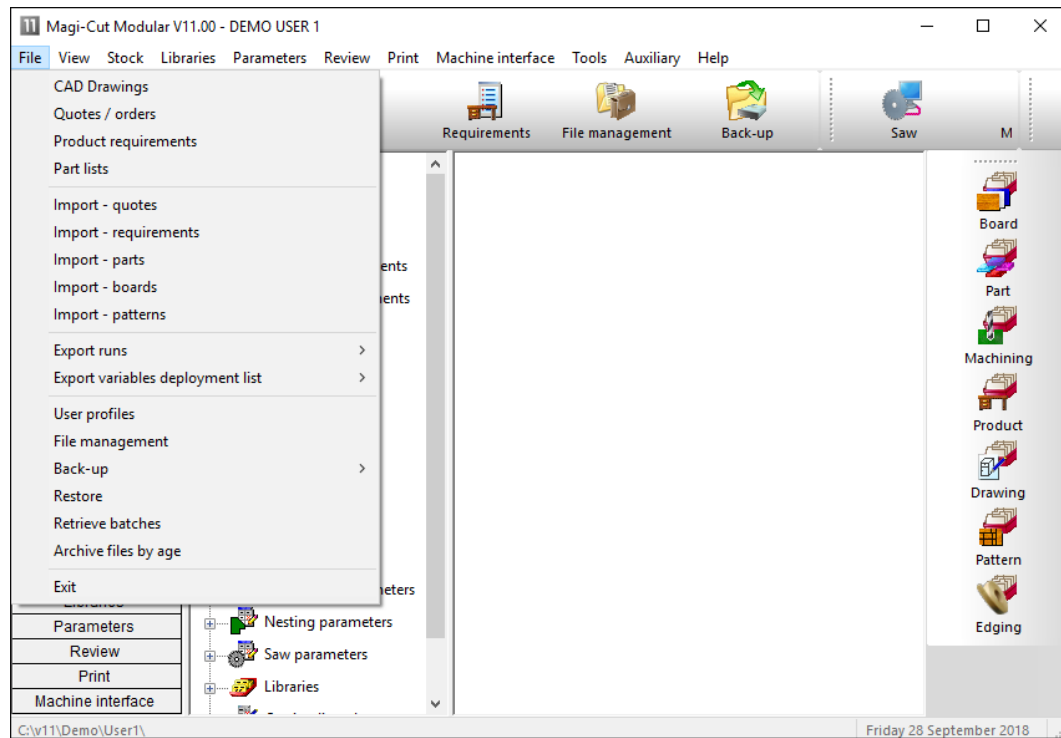
If possible also make sure that the program and data directories are covered by a regular system back up using the Company's own procedures.

Import and Export

These days it is more common for programs to interact with other files and systems. For example, part lists may be created by a separate Sales order system, Boards may need to be imported and exported from a stock control database, and management data for optimised runs may need to be exported to other reporting systems or spread sheets.

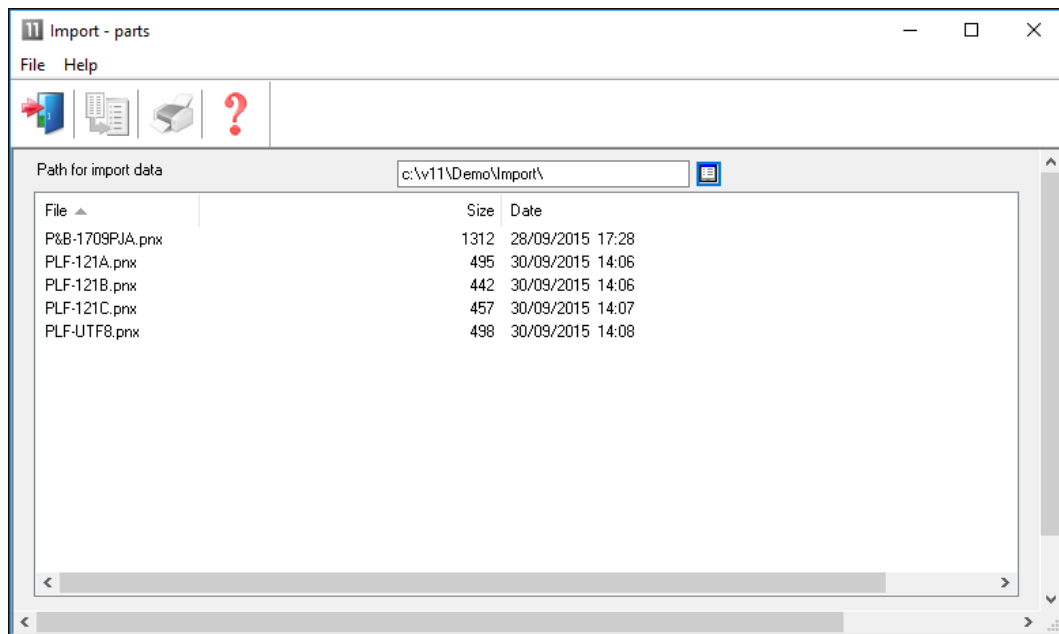
Import parts, boards, product requirements

Part lists, board lists and product requirement lists can be quickly imported. At the main menu these are options on the File menu.



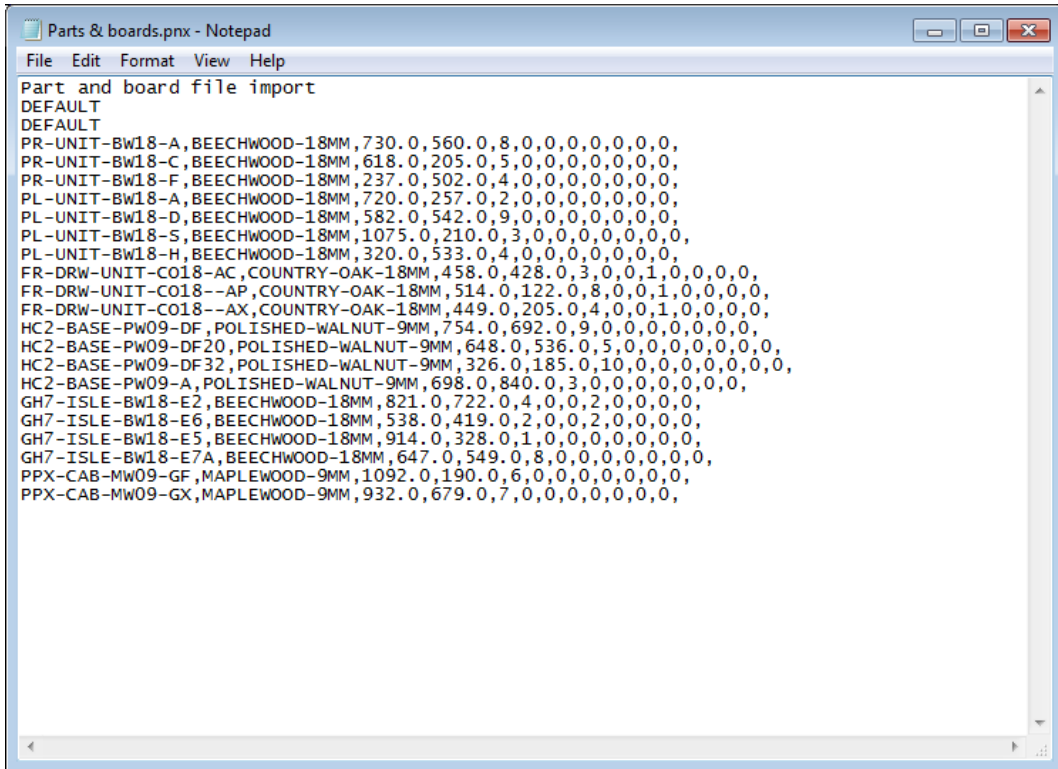
Import parts, boards, requirements

The program moves to the Import screen.



Import parts

Select a file to import. In this example the import format is the program's format of PNx; an ASCII/Unicode file with the fields in a fixed order.



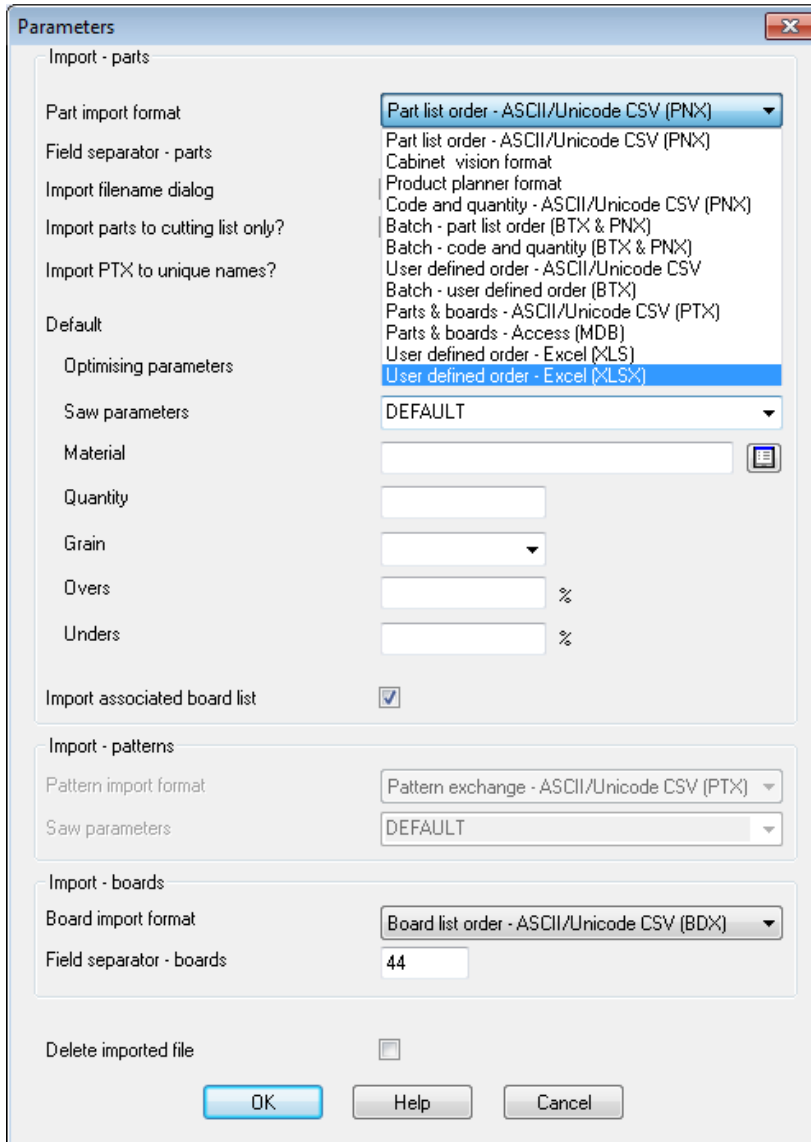
```

Part and board file import
DEFAULT
DEFAULT
PR-UNIT-Bw18-A,BEECHWOOD-18MM,730.0,560.0,8,0,0,0,0,0,0,0,
PR-UNIT-Bw18-C,BEECHWOOD-18MM,618.0,205.0,5,0,0,0,0,0,0,0,
PR-UNIT-Bw18-F,BEECHWOOD-18MM,237.0,502.0,4,0,0,0,0,0,0,0,
PL-UNIT-Bw18-A,BEECHWOOD-18MM,720.0,257.0,2,0,0,0,0,0,0,0,
PL-UNIT-Bw18-D,BEECHWOOD-18MM,582.0,542.0,9,0,0,0,0,0,0,0,
PL-UNIT-Bw18-S,BEECHWOOD-18MM,1075.0,210.0,3,0,0,0,0,0,0,0,
PL-UNIT-Bw18-H,BEECHWOOD-18MM,320.0,533.0,4,0,0,0,0,0,0,0,
FR-DRW-UNIT-CO18-AC,COUNTRY-OAK-18MM,458.0,428.0,3,0,0,1,0,0,0,0,
FR-DRW-UNIT-CO18--AP,COUNTRY-OAK-18MM,514.0,122.0,8,0,0,1,0,0,0,0,
FR-DRW-UNIT-CO18--AX,COUNTRY-OAK-18MM,449.0,205.0,4,0,0,1,0,0,0,0,
HC2-BASE-PW09-DF,POLISHED-WALNUT-9MM,754.0,692.0,9,0,0,0,0,0,0,0,
HC2-BASE-PW09-DF20,POLISHED-WALNUT-9MM,648.0,536.0,5,0,0,0,0,0,0,0,
HC2-BASE-PW09-DF32,POLISHED-WALNUT-9MM,326.0,185.0,10,0,0,0,0,0,0,0,
HC2-BASE-PW09-A,POLISHED-WALNUT-9MM,698.0,840.0,3,0,0,0,0,0,0,0,
GH7-ISLE-Bw18-E2,BEECHWOOD-18MM,821.0,722.0,4,0,0,2,0,0,0,0,0,
GH7-ISLE-Bw18-E6,BEECHWOOD-18MM,538.0,419.0,2,0,0,2,0,0,0,0,0,
GH7-ISLE-Bw18-E5,BEECHWOOD-18MM,914.0,328.0,1,0,0,0,0,0,0,0,0,
GH7-ISLE-Bw18-E7A,BEECHWOOD-18MM,647.0,549.0,8,0,0,0,0,0,0,0,0,
PPX-CAB-Mw09-GF,MAPLEWOOD-9MM,1092.0,190.0,6,0,0,0,0,0,0,0,0,
PPX-CAB-Mw09-GX,MAPLEWOOD-9MM,932.0,679.0,7,0,0,0,0,0,0,0,0,

```

Import file format

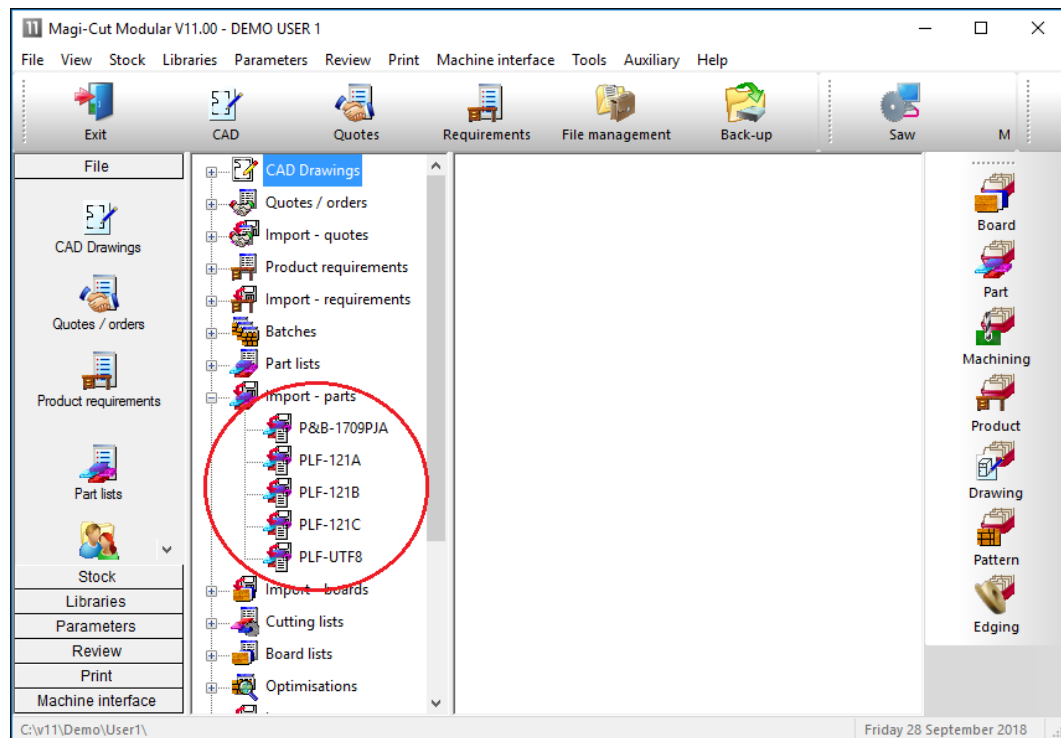
Use the Import parameters to choose a different format. **File - Parameters**



Import parameters

It is also possible to use a custom format (user defined format) - this can be useful where there is limited control on the format of the external file. The '*Part list import parameters*' are used to customise import format. Similar parameters are available for Boards and Product requirements.

Files can also be imported from the File Tree. This is a quicker option once the format has been chosen because the file can be imported and there is no need to go via the Import dialog.



Import from file tree

Pattern exchange - The pattern exchange format (PTX) can be used to import and export pattern data to and from other systems and machine controllers.

Data can also be imported at the Part list.

At the part list data can be imported directly (*File – Import*)

The screenshot displays the 'Part list' application window with an 'Import - parts' dialog box open. The 'Part list' window features a menu bar (File, Edit, View, Optimise, Help) and a toolbar. Below the toolbar are input fields for 'Title', 'Opt' (set to 'default'), and 'Saw' (set to 'default'). The main area is a table with columns: Description, Material, Length, Width, Quantity, Grain, Edge, and Inf. The 'Import - parts' dialog box is overlaid on the table, showing a file list with columns: File, Size, and Date. The file list contains: P&B-1709PJA.pnx (1312, 28/09/2015), PLF-121A.pnx (495, 30/09/2015), PLF-121B.pnx (442, 30/09/2015), PLF-121C.pnx (457, 30/09/2015), and PLF-UTF8.pnx (498, 30/09/2015). The dialog also has a 'Find' field, a 'Filter' checkbox, and a 'Format' dropdown set to 'Part list order - ASCII'.

Description	Material	Length	Width	Quantity	Grain	Edge	Inf
Global							
1.							
2.							
3.							
4.							
5.							
6.							
7.							
8.							
9.							
10.							
11.							
12.							
13.							
14.							
15.							
16.							

File	Size	Date
P&B-1709PJA.pnx	1312	28/09/2015
PLF-121A.pnx	495	30/09/2015
PLF-121B.pnx	442	30/09/2015
PLF-121C.pnx	457	30/09/2015
PLF-UTF8.pnx	498	30/09/2015

Where the format of the external file is not known or needs to be set up – use the Import Wizard (*File – Import Wizard*).

Wizard for importing part lists

Parts

Describe the data in your source file

Starting at the top of your file, how many header lines need to be skipped?

Is your data separated by commas or another character? - please specify

Click required column headings and assign to part list fields

	Material	Description	What's this?	What's this?	What's this?	What's this?	What's this?
1.	Material	Part / Description	Length mm	Width mm	Total Req	Grain	Edge Bottom
2.	MEL-CHIP-15MM	UNIT-BASE	585.00	470.00	13	0	WHITE-TAPE-22MM
3.	MEL-CHIP-15MM	UNIT-END	1740.00	585.00	5	1	
4.	MEL-CHIP-15MM	UNIT-PLINTH	500.00	150.00	2	0	
5.	MEL-CHIP-15MM	UNIT-RAIL	474.00	75.00	5	0	WHITE-TAPE-22MM
6.	MEL-CHIP-15MM	UNIT-SHELF	474.00	395.00	7	0	
7.	MEL-CHIP-18MM	CABINET-BASE	574.00	585.00	3	0	
8.	MEL-CHIP-18MM	HOUSING-PLINTH	600.00	150.00	14	0	WHITE-TAPE-22MM
9.	MEL-CHIP-18MM	CABINET-RAIL	574.00	75.00	6	0	WHITE-TAPE-22MM
10.	MEL-CHIP-18MM	CABINET-TOP	946.00	395.00	3	0	
11.	MEL-CHIP-18MM	HOUSING-END	1000.00	340.00	3	0	
12.	MEL-CHIP-18MM	HOUSING-BACK	1195.00	420.00	1	0	

OK P

The program imports data from any CSV (comma separated values) files and Excel files.

You can then work through the fields and assign them to the correct Part list fields name by selecting the field name on the 'What's this' button.

	Description	Material	Length	Width	Quan...	Over...	Un...	Gr...	Edge Btm	Edge Top	Edge Left	Edge Right	Inf
Global						%	%						
1.	UNIT-BASE	MEL-CHIP-15MM	585.0	470.0	13	0	0	N					
2.	UNIT-END	MEL-CHIP-15MM	1740.	585.0	5	0	0	Y					
3.	UNIT-PLINTH	MEL-CHIP-15MM	500.0	150.0	2	0	0	N					
4.	UNIT-RAIL	MEL-CHIP-15MM	474.0	75.0	5	0	0	N					
5.	UNIT-SHELF	MEL-CHIP-15MM	474.0	395.0	7	0	0	N					
6.	CABINET-BASE	MEL-CHIP-18MM	574.0	585.0	3	0	0	N					
7.	HOUSING-PLI...	MEL-CHIP-18MM	600.0	150.0	14	0	0	N					
8.	CABINET-RAIL	MEL-CHIP-18MM	574.0	75.0	6	0	0	N					
9.	CABINET-TOP	MEL-CHIP-18MM	946.0	395.0	3	0	0	N					
10.	HOUSING-END	MEL-CHIP-18MM	1000.	340.0	3	0	0	N					
11.	HOUSING-BACK	MEL-CHIP-18MM	1195.	420.0	1	0	0	N					
12.	CABINET-END	MEL-CHIP-18MM	1150.	585.0	8	0	0	N					
13.	HOUSING-TOP	MEL-CHIP-18MM	1490.	590.0	16	0	0	N					
14.	CABINET-PLIN...	MEL-CHIP-18MM	495.0	150.0	12	0	0	N					
15.	CABINET-BACK	MEL-CHIP-18MM	474.0	710.0	12	0	0	X					
16.	UNIT-BACK	MEL-CHIP-18MM	710.0	574.0	22	0	0	N					

Note – you can also cut and paste directly from a spreadsheet to the part list – for example where the spreadsheet has the data in the same order and format as the part list.

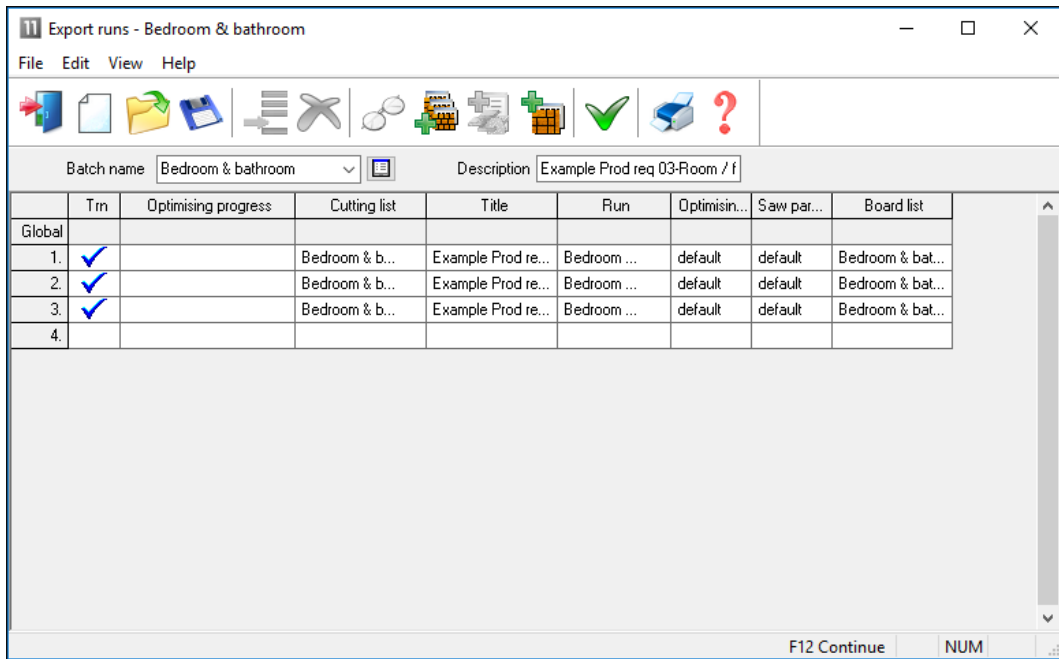
Export

The main use for export is to export results (optimisations) to an external file or system. Individual reports (for example, Pattern summary) can be exported at the screen view or a complete set of results can be exported.

At the main screen:-

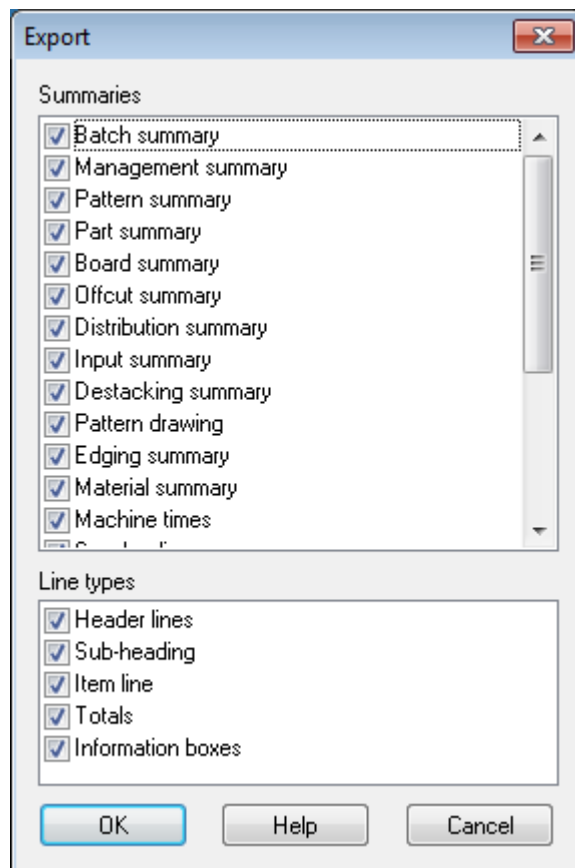
- Select: **File- Export runs**
- Choose the export format (ASCII, MDB, XLS, XLSX)

(XLS and XLSX are Excel formats).



Export runs

The program prompts for the summaries to export and also the type of data to include.



Summaries to Export

In some cases items such as the headings, sub headings and Totals are not required - these can be easily excluded.

The data is sent to the *Path for Export data*

There is also an Export option at each summary – so just that summary can be exported.

In the case of Excel, for example, the reports are sent to a single file with each summary on a separate spreadsheet tab.

The screenshot shows an Excel spreadsheet with the following content:

Description	Quantity	m2	m3	Percent	Rate	Cost
Required parts	7582	2364.00	38.18	91.90%		
Plus/Over parts	0	0.00	0.00	0.00%		
Offcuts	48	13.87	0.21	0.54%		
Scrap		194.46	3.23	7.56%		
Core trim		0.00	0.00	0.00%		
Boards	740	2572.33	41.62	100.00%		
Sheets used		2572.33	41.62	100.00%		6220.00
Offcuts used		0.00	0.00	0.00%		0.00
Offcuts created		-13.87	-0.21	-0.54%	0.00	0.00
Net material used		2558.46	41.41	99.46%		6220.00
Cutting time	31:51Hr				50.00	1592.00
Total parts	7582	2364.00	38.18	91.90%	3.31	7812.40

Export data - Excel

For Export to an ASCII file each report is sent to a separate ASCII file with the data types identified by a token at the start of each line. Here is an example of the board summary data.

```
%1,DEMO USER 1,Modular V11.0, 23 November 2018
%1,Board summary,Kitchen layout
%1,,00009/BSR CD-81/BSR CD-81/?DEFAULT/?DEFAULT/5
%1,No,Board,Length,Width,Information,Qty in Stock,Qty Used,Length m,Area m2,Cost
Rate,Total Cost
%2,HARDBOARD-4MM* Hardboard 4mm Thickness 4.0 Book 8 Parameters HBD04
%3,1.,HARDBOARD-4MM/01,2000.0,1000.0,Spec. Order,795,2,,4.00,0.890,3.56
%3,2.,HARDBOARD-4MM/02,2440.0,1220.0,BIN 133,131,6,,17.86,0.750,13.40
```



```

%4,,,,,,,,8,,21.86,,16.96
%2,MED-DEN-FIBRE-18MM Medium Density Fibreboard 18mm Thickness 18.0 Book 5
%3,3.,MED-DEN-FIBRE-18MM/01,3660.0,1550.0,BIN 127,1090,2,,11.35,4.500,51.06
%3,4.,MED-DEN-FIBRE-18MM/02,2440.0,1220.0,BIN 128,767,12,,35.72,4.350,155.39
%4,,,,,,,,14,,47.07,,206.45
%2,MFC18-OAK Prelaminated - Oak 18mm Thickness 18.0 Book 5
%3,6.,MFC18-OAK/02,2440.0,1220.0,,111,6,,17.86,2.970,53.05
%4,,,,,,,,6,,17.86,,53.05
%2,WHITE-ACRYLIC-12MM Acrylic - White 12mm (sundry) Thickness 12.0 Book 8
%3,7.,WHAC12/01,,,,436,36,,,1.320,47.52
%4,,,,,,,,36,,,,47.52
%4,Total,,,,,64,,86.79,,323.97

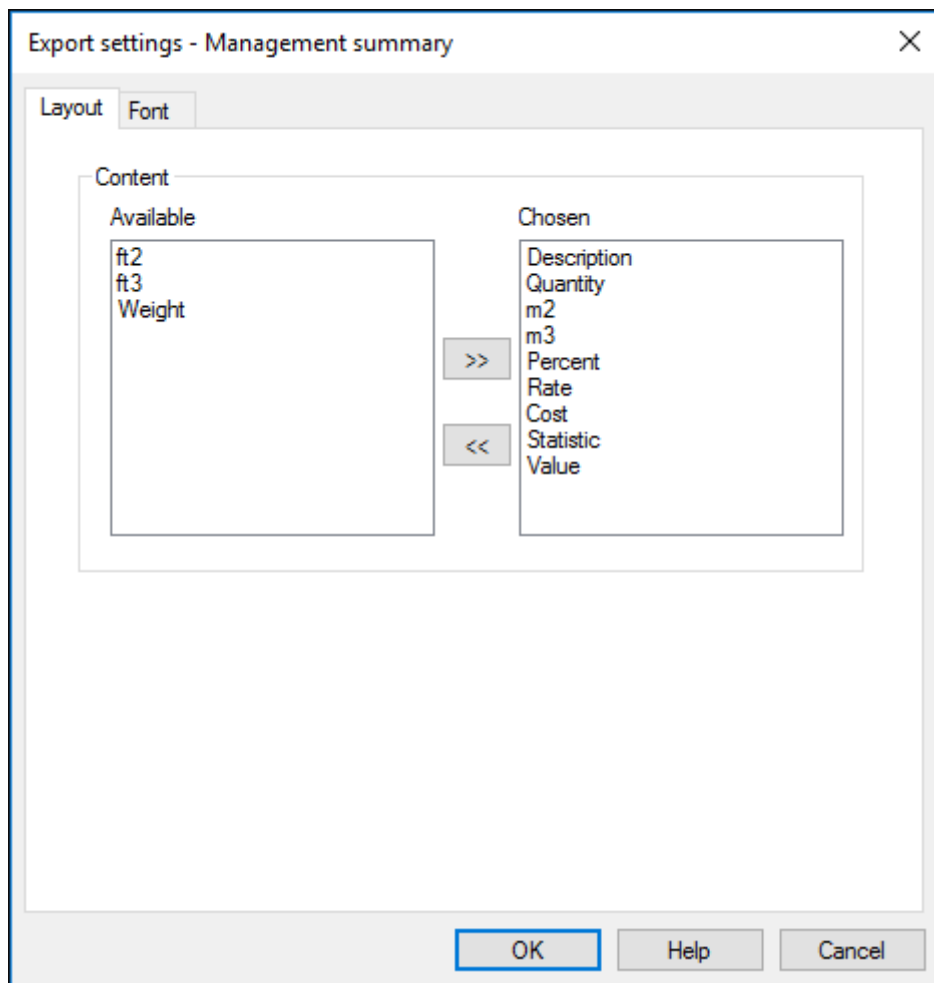
```

Review runs parameters

The data to export can also be customised at the Review Runs screens:-

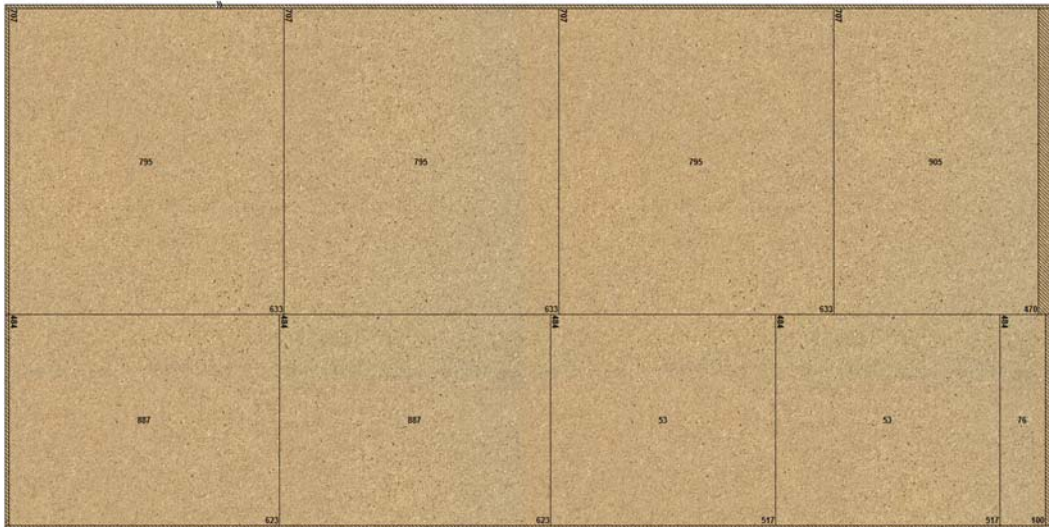
- Locate the report
- Select: **Settings - Export settings**

This shows the Export settings dialog.



Export settings

Pattern images - at any on-screen pattern there is an option to export the pattern image.
File – Export – Pattern



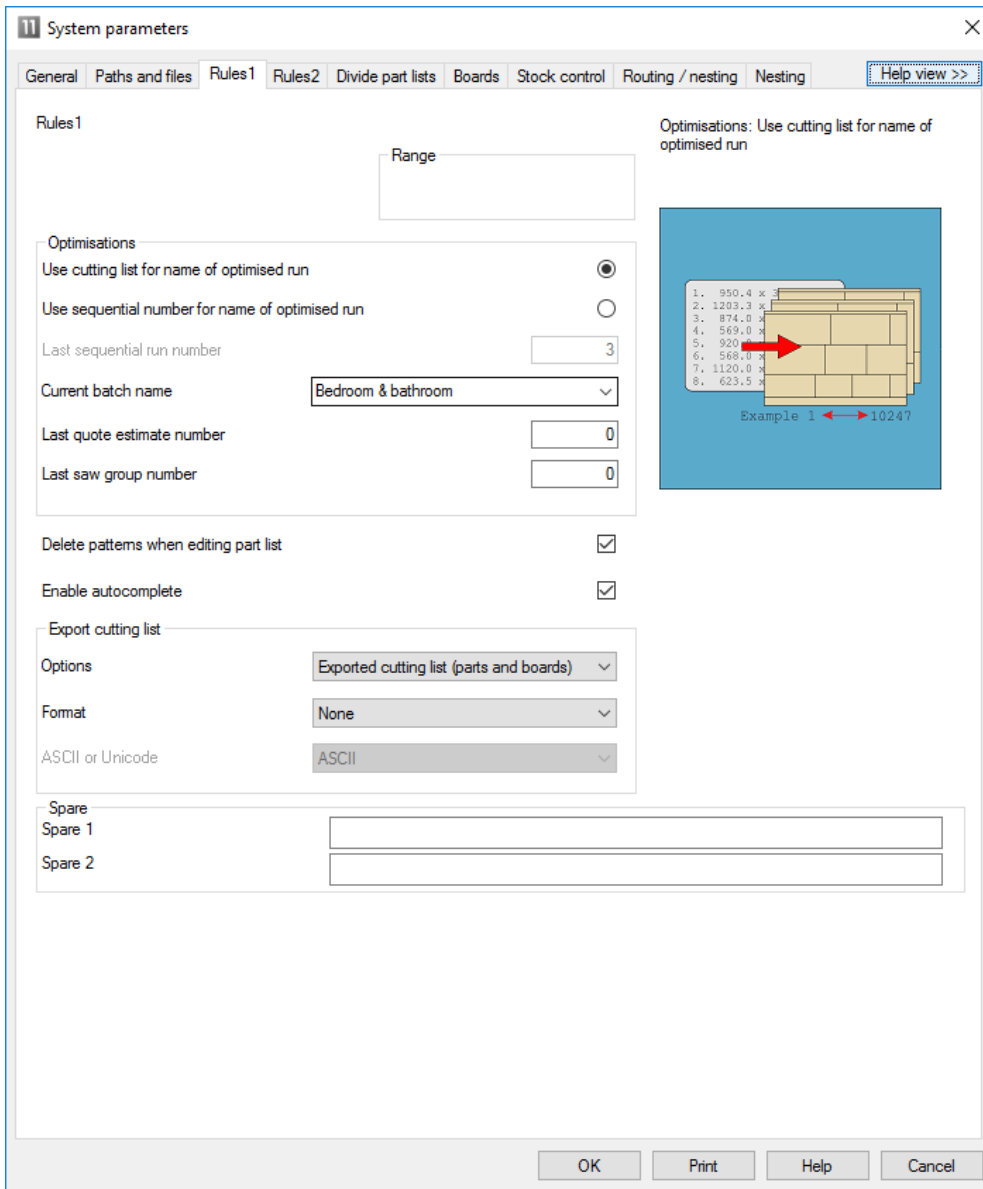
Pattern images

There are also options to export non run based reports:-

- Part costing
- Product costing
- Fittings
- Operations
- Board library data
- Part library data

It is sometimes useful to export the cutting list (for example where it is changed for edging and laminating and the sizes are used elsewhere in production).

This export is included in the optimisation provided that the option is chosen in system parameters.



Create data for

The program creates files in the PNX and BDx (for board sizes) formats.

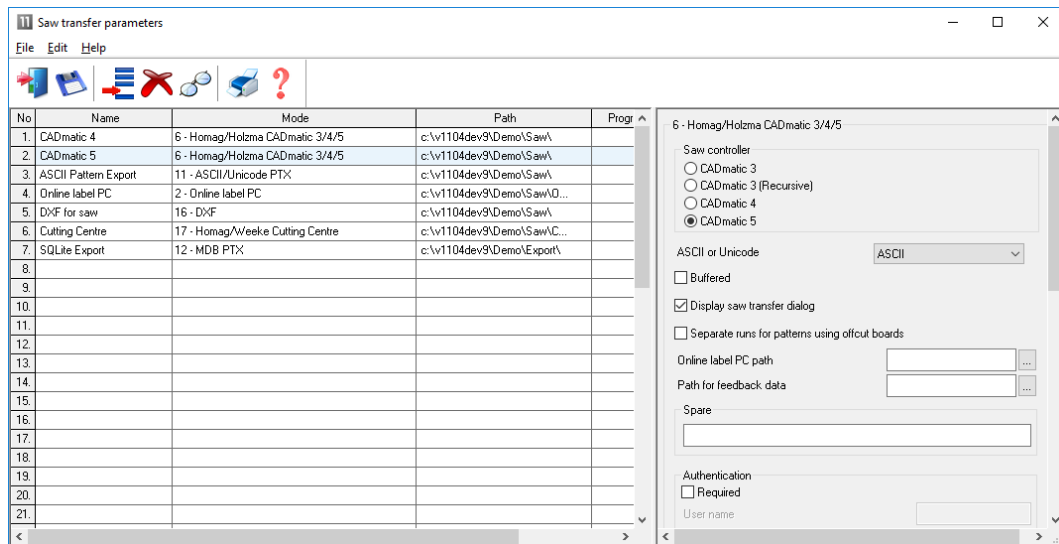
Pattern Exchange Format

The Pattern exchange format contains all the part sizes, board sizes, parameter settings, cutting instructions and drawing information for a run and most of the summary data.

This is the program's proprietary format for patterns (results). It is used by several manufacturers where they want pick up information from the optimisation results (cutting patterns).

It is a public format and fully described in the Interface guide.

All the pattern data and structure is contained in the file in ASCII/Unicode or MDB database format - so it is very useful where custom changes are needed for controlling specific machines or external systems. For example, to update stock control systems, use a special post processor to transfer to a saw.



Saw transfer parameters

Quite often both the standard .saw file and the .ptx file are used by a manufacturer. In this case both files can be exported in a single command by grouping

This option is also available for transfer to Machining centres.

An example of the ASCII/Unicode PTX file:-

```

HEADER,1,06,Kitchen layout,0,0,1
JOBS,1,BSR CD-81,Kitchen layout,,,,1,DEFAULT,DEFAULT,175,13.96
NOTES,1,1,BSR CD-81.ctt/BSR CD-
81.brd/DEFAULT.prm/DEFAULT.spm/HBD04.MPM//00009.ptn/00009.xbd
PARTS_REQ,1,1,BASE-BACK,1,976.0,735.0,1,0,0,0,1
PARTS_REQ,1,2,BASE-BACK,1,476.0,735.0,1,0,0,0,1
PARTS_REQ,1,3,BASE-BACK,1,876.0,735.0,1,0,0,0,1
PARTS_REQ,1,4,BASE-BACK,1,976.0,735.0,1,0,0,0,1
PARTS_REQ,1,5,BASE-BACK,1,976.0,735.0,1,0,0,0,1
PARTS_REQ,1,6,BASE-BACK,1,476.0,735.0,1,0,0,0,1
PARTS_REQ,1,7,BASE-BACK,1,976.0,735.0,1,0,0,0,1
PARTS_REQ,1,8,BASE-BACK,1,976.0,735.0,1,0,0,0,1
PARTS_REQ,1,9,BASE-BACK,1,476.0,735.0,1,0,0,0,1
PARTS_REQ,1,10,BASE-BACK,1,476.0,735.0,1,0,0,0,1
PARTS_REQ,1,11,BASE-BOTTOM,2,564.0,581.0,3,0,0,0,3
PARTS_REQ,1,12,BASE-BOTTOM,2,464.0,581.0,1,0,0,0,1
PARTS_REQ,1,13,BASE-BOTTOM,2,464.0,581.0,1,0,0,0,1
PARTS_REQ,1,14,BASE-BOTTOM,2,464.0,581.0,1,0,0,0,1
PARTS_REQ,1,15,BASE-BOTTOM,2,464.0,581.0,1,0,0,0,1
PARTS_REQ,1,16,BASE-CABINET-BOTTOM,2,864.0,581.0,1,0,0,0,1
PARTS_REQ,1,17,BASE-CABINET-DIVIDER,2,559.0,533.3,1,0,0,0,1
PARTS_REQ,1,18,BASE-CABINET-DOOR,3,398.0,554.8,1,0,0,2,1
PARTS_REQ,1,19,BASE-CABINET-DRAWER,3,398.0,182.3,3,0,0,0,3
PARTS_REQ,1,20,BASE-CABINET-DRAWER-LONG,3,898.0,182.3,1,0,0,0,1
PARTS_REQ,1,21,BASE-CABINET-END-LEFT,2,581.0,870.0,1,0,0,0,1
PARTS_REQ,1,22,BASE-CABINET-END-RIGHT,2,581.0,870.0,1,0,0,0,1
PARTS_REQ,1,23,BASE-CABINET-RAIL-BACK,2,864.0,150.0,1,0,0,0,1
PARTS_REQ,1,24,BASE-CABINET-RAIL-FRONT,2,864.0,149.0,2,0,0,0,2
PARTS_REQ,1,25,BASE-CABINET-SHELF,2,464.0,560.0,1,0,0,0,1
PARTS_REQ,1,26,BASE-DOOR,3,498.0,741.0,1,0,0,2,1
PARTS_REQ,1,27,BASE-DOOR,3,498.0,552.8,1,0,0,2,1
PARTS_REQ,1,28,BASE-DOOR,3,498.0,741.0,1,0,0,2,1
PARTS_REQ,1,29,BASE-DRAWER,3,498.0,182.3,4,0,0,2,4
PARTS_REQ,1,30,BASE-DRAWER,3,598.0,243.2,3,0,0,2,3
PARTS_REQ,1,31,BASE-DRAWER,3,498.0,184.3,1,0,0,2,1
PARTS_REQ,1,32,BASE-END-LEFT,2,581.0,870.0,1,0,0,0,1
PARTS_REQ,1,33,BASE-END-LEFT,2,581.0,870.0,1,0,0,0,1
PARTS_REQ,1,34,BASE-END-LEFT,2,581.0,870.0,1,0,0,0,1
PARTS_REQ,1,35,BASE-END-LEFT,2,581.0,870.0,1,0,0,0,1
PARTS_REQ,1,36,BASE-END-RIGHT,2,581.0,870.0,1,0,0,0,1
PARTS_REQ,1,37,BASE-END-RIGHT,2,581.0,870.0,1,0,0,0,1
PARTS_REQ,1,38,BASE-END-RIGHT,2,581.0,870.0,1,0,0,0,1
PARTS_REQ,1,39,BASE-END-RIGHT,2,581.0,870.0,1,0,0,0,1
PARTS_REQ,1,40,BASE-PLINTH,2,964.0,125.0,1,0,0,0,1
PARTS_REQ,1,41,BASE-PLINTH,2,964.0,125.0,1,0,0,0,1

```

...

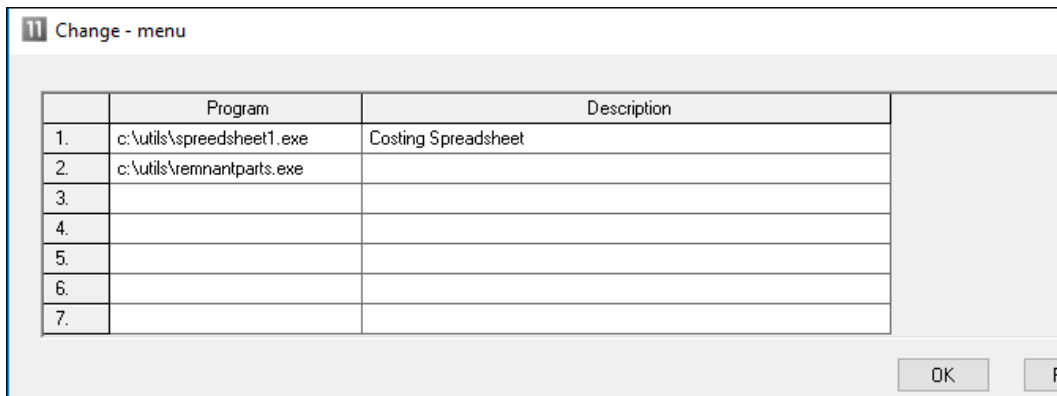
Automating routine operations and commands

There are several options for automating routine operations and commands.

- Auxiliary menu
- Automatic command files
- Stand alone operation

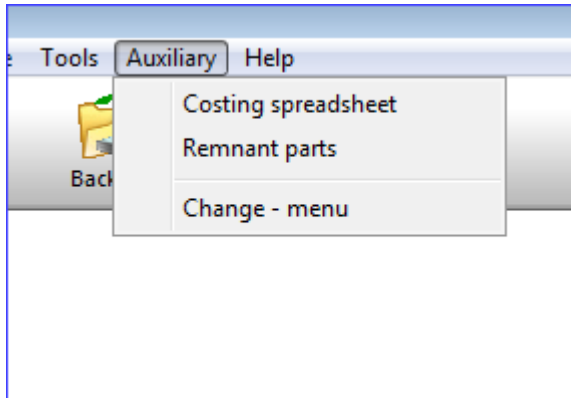
Auxiliary menu

This is a menu option at the main screen. It offers a custom menu. It is typically used for linking to and running other programs but with the convenience of running them from inside the optimising program. For example, run a spread sheet or another production program.



Auxiliary menu

Once set up these options are then available on the Auxiliary menu.



Auxiliary menu example

Automatic command files

It can be useful to automate common jobs, for example:-

- reserve stock after an optimisation
- optimise after importing parts
- remember to copy summary data to another file
- always make a backup at the end of the day
- provide extra reminders after some operations

The automatic command options allow the specification of a command, batch file, or script file which can run automatically when exiting from program activities (e.g. on leaving Review runs).

Automatic command files	
Activity	Program
1. Part list	
2. Product requirements	
3. Import - parts	
4. Import - patterns	
5. Issue stock - runs	
6. Import/Adjust stock from file	
7. Overwrite stock from file	
8. Review runs	cmd /c c:\utils\myallocate.vbs
9. Run calculation	

OK

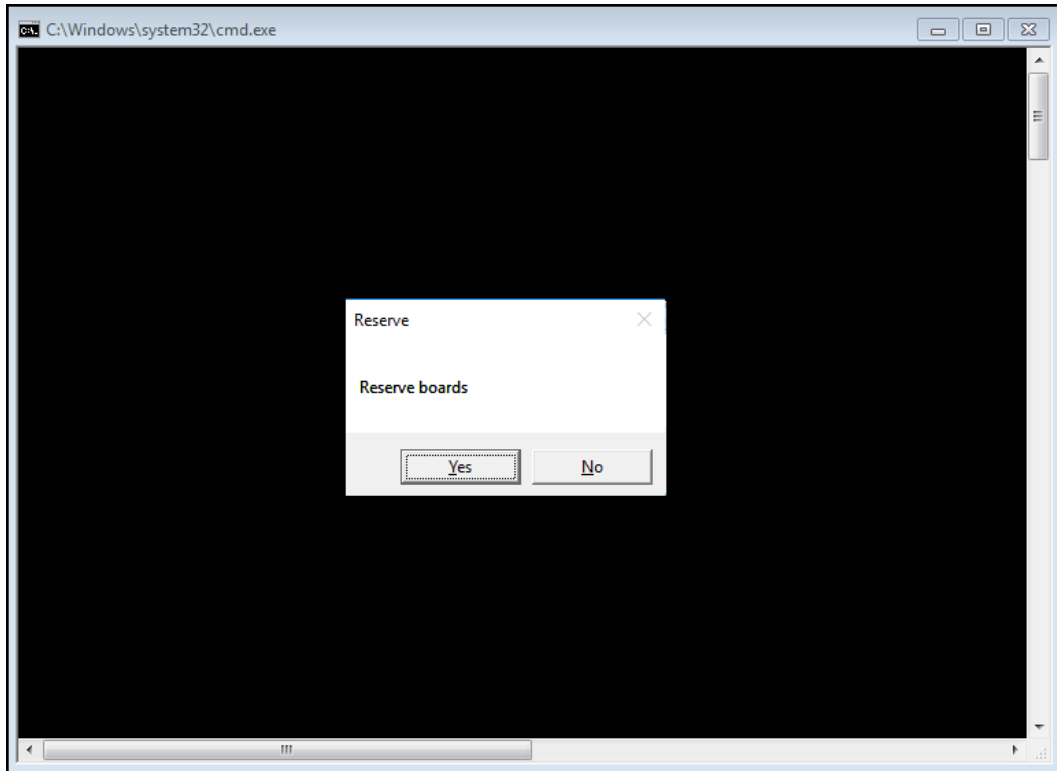
Automatic command files

In the above example the script files MyAllocate.vbs runs on exit from Review runs. This makes sure, for example, that reservations are not missed.

The script file might be something like:-

```
askuser
Sub askuser
Dim ans
Dim wshShell
set wshShell = WScript.CreateObject("WScript.shell")
ans = MsgBox("Reserve boards", vbYesNo, "Reserve")
If ans = vbYes Then
wshShell.CurrentDirectory ="c:\v11\demo\user1\"
wshShell.run "c:\v11\stock.exe /allocstock"
Else
End If
End Sub
```

The result is to prompt for stock reservation each time on exit from Review runs.



Automatic command files example

The program returns to the main screen in the usual way.

Stand alone operation

Another way of automating routine processes is to run sections of the program 'stand alone'; this typically means they run as silent processes and do not require any user input or show any screens. This can be useful for automating routine jobs, for example, importing part lists from another system, updating stock ...

A typical task is to import parts from a PTX file as a stand alone operation. Run the program IMPORT.EXE from a user directory. This can be from a batch file or from a

shortcut or by using the Windows option 'Start - Run'. For example, using a Windows batch file the commands are:-

```
..\import job32.ptx /format:8
```

The command line is used to make the relevant settings (as they would be otherwise set in the program or via parameters. For example, the import command is very flexible with several command line options.

```
IMPORT [filename] [/FORMAT:nn] [/OVERWRITE] [/RENAME] [/DELETE]  
[/NOWRTBRD] [/UDF] [/SEP]
```

There is access to many sections of the program with this method, for example:-

- Back up User profile
- Batch operations
- CADlink
- Export board library
- Import parts, patterns, boards
- Machining library link picker
- Print or export reports
- Product requirements import
- Stock update
- Saw transfer

16. Design Labels and Forms

Use the Design options to create templates for labels and forms. Labels are typically for printing labels in the office for parts or products but also can be used to design labels for the CADmatic saw controllers or the Online PC saw interface for labels at the saw.

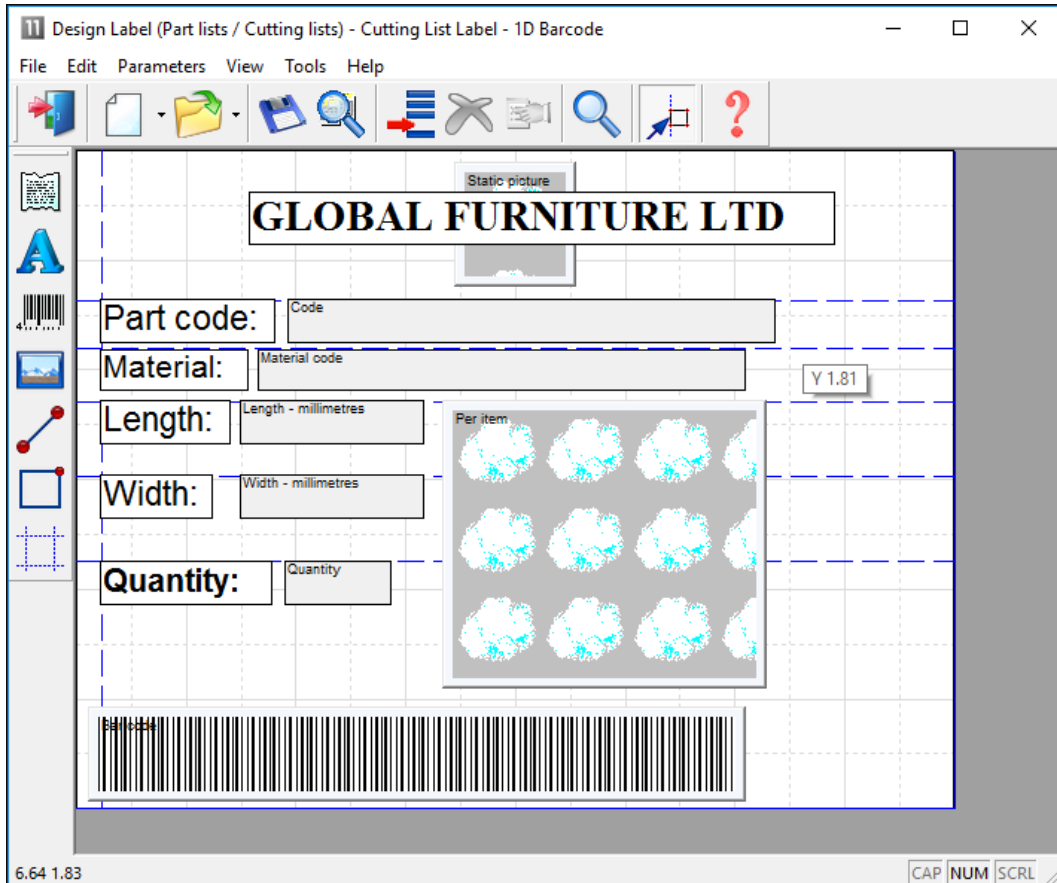
Forms are typically for adding brand new custom forms to Review runs or providing a full set of order or stock documentations; Invoices, despatch notes, worksheets ...

At the main screen:-

- Select: **Tools – Form/Label designer**
- Select **File>New** then either form or label
- Select the type of form or label required:-

Quotes / Orders
Product requirements
Part lists / Cutting lists
Cutting patterns
Runs
Saw (for labels only)

The following example shows a design for a label at the Design screen.



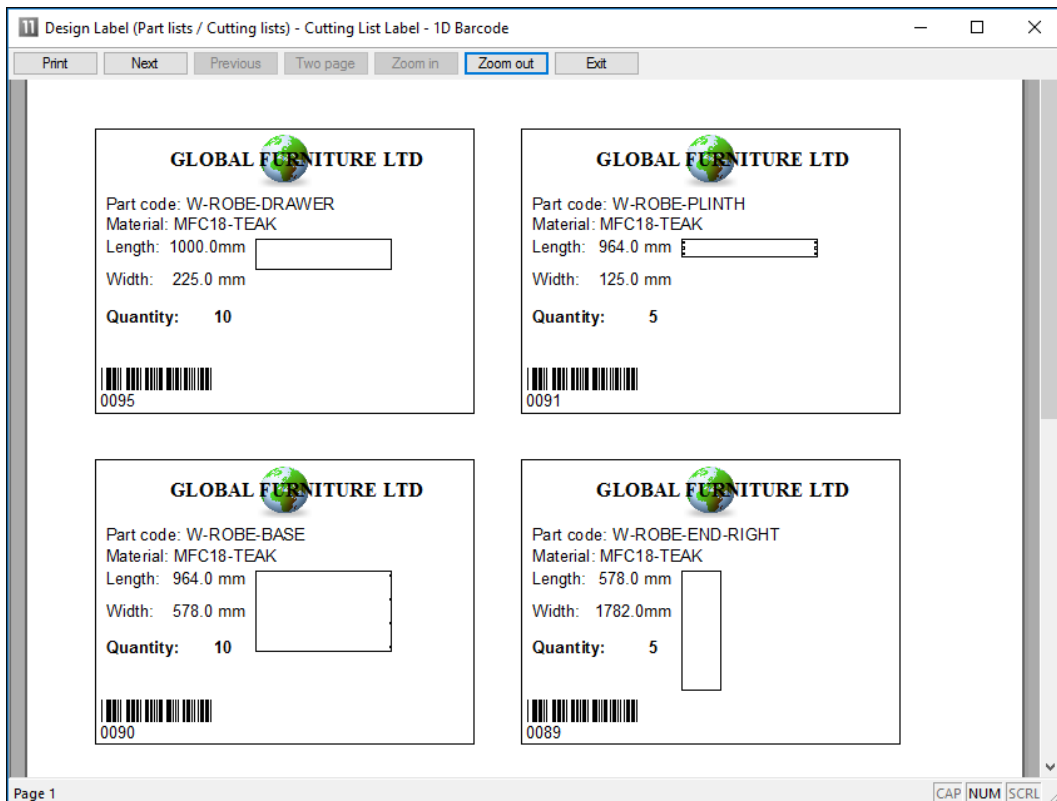
Label design

To design a form or label create a template that describes the items of information (objects) on the label or form; where they are placed and special effects such as pictures or colour. Once the template is saved it can be used by the program for printing that style of label or form.

Many users typically only need one or two templates for all their part and product labels but may need several templates for forms such as invoices, despatch notes, waybills and so on.

Standard templates - There are several standard templates supplied with the software which you can use as a starting point for your templates. Use the SAVE AS option to take a copy of the standard form and always make changes to the copy.

Data Preview - use this to see what the label looks like.



Preview of printed labels

When creating a NEW design use the OBJECT TOOLBAR (at the left) to place label design elements on the label. The main elements are:-

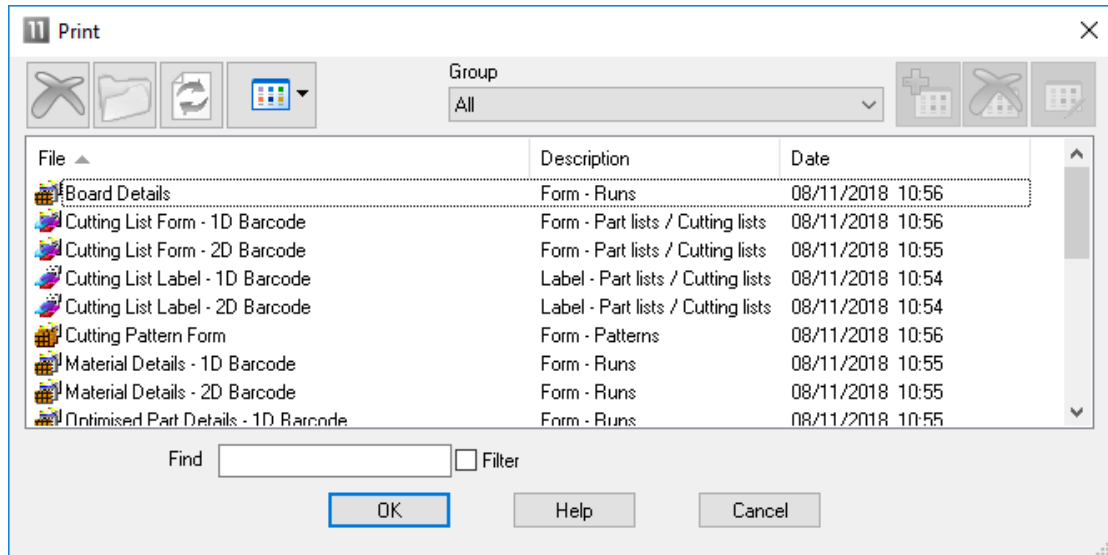
- Text boxes - fixed text to describe the data
- Data boxes - for the variable data (e.g. part codes)
- Lines - to draw lines on the label
- Picture boxes - for part drawings or logos

- Barcode boxes - for bar codes (e.g. bar code for part code and quantity)

Use the properties box to change any features, for example, to fine tune the position of the item.

Print - to print a label for part lists or cutting patterns etc.

- Select the Print menu at the main screen
- Select 'Form / label print' '

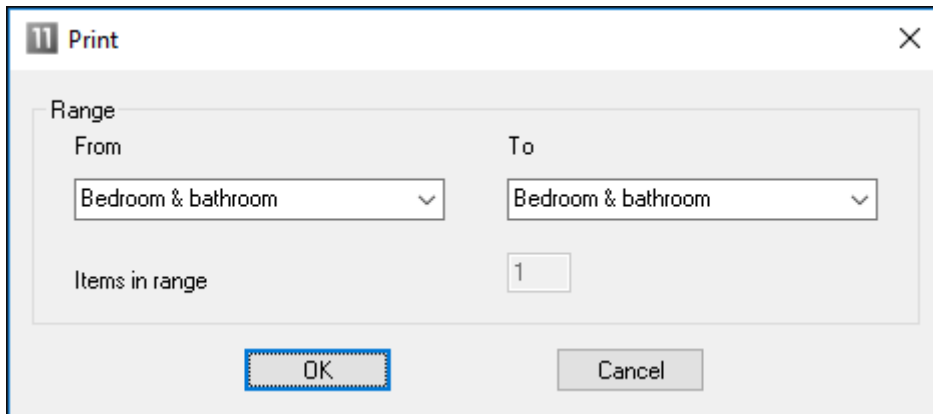


Select label template

- Select the required template

Select **OK** to print

The program prompts for the data to print.



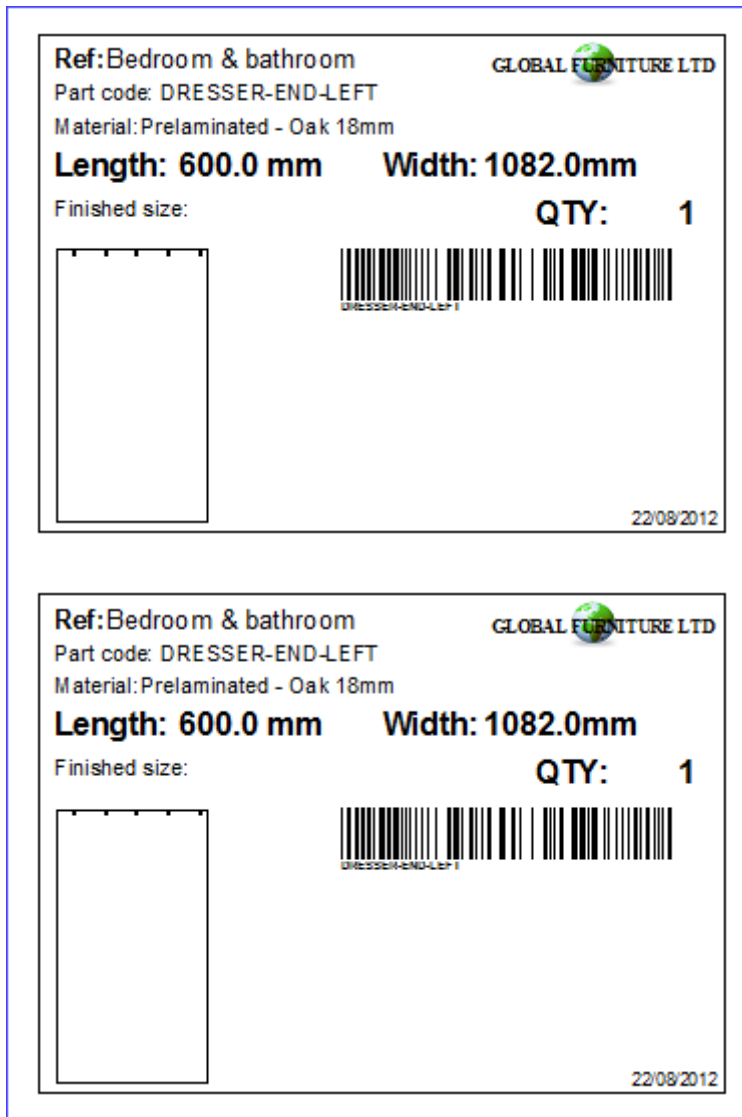
The screenshot shows a 'Print' dialog box with the following elements:

- Title bar: 'Print' with a close button (X).
- Range section:
 - 'From' dropdown menu: 'Bedroom & bathroom'.
 - 'To' dropdown menu: 'Bedroom & bathroom'.
 - 'Items in range' text box: '1'.
- Buttons: 'OK' (highlighted with a blue dashed border) and 'Cancel'.

Select data for label printing

- Check the data and select OK to print labels.

The labels can be set up to print in a wide variety of layouts; continuous, 2 per page ...



Printed labels

Printing labels at the saw

To print labels at the saw, for example, to print labels for each part or each stack as it is cut the data for each label is transferred to the saw when the run is transferred.

Use 'Design labels and forms' to design the template for labels at the Saw.

At the main screen select: *Tools - Label design - Saw*

Then choose the saw type:-

- CADmatic 1
- CADmatic 2
- CADmatic 3
- Homag
- Online PC

Note - not all saws have the same capabilities when printing labels so the Label design may restrict options in some cases.

Use *File - Export* (at the Design screen) to send the design to the saw.

The label design is a file (in the correct format for the saw) which is transferred to the saw. The file name and location depend on the type of saw.

It is also possible to print labels for other saw types - details and capabilities depend on each saw type - check with your supplier.

Forms

Design a form in the same way as a label - the main differences are that a form (like an invoice) usually contains a section with a list of varying data items (e.g. products and prices) and uses page numbers, headings, and continuation pages etc.

The screenshot shows a software window titled "Design Form (Quotes / orders) Initial - Order Estimate - 2D Barcode". The interface includes a menu bar (File, Edit, Parameters, View, Tools, Help) and a toolbar with various design tools. The main workspace displays a form layout on a grid background. At the top, there is a "Static picture" and a "Zoom" tool. The form content includes:

- A large text box containing "GLOBAL FURNITURE LTD".
- A text box containing "Furniture House, 27 Wood Lane, Bristol, BS1 2XR, UK".
- A text box containing "Telephone: +44 (0)117 923 6222 Fax: +44 (0)117 923 6267".
- A box labeled "Order estimate" containing a table with columns: Estimate date, Date, Estimate no., Reference, Our ref., Taken by, Your ref., Customer ref.
- A section for customer information with fields: Customer address, Customer name, Invoice address, and Invoice postcode.
- A table with columns: Item, Code, Information, Width, Height, Depth, Quantity, Unit price, Total price.
- A table with columns: Item, Additional instructions, Information, Part length - m, Part width - m, Quantity, Unit price, Total price.

The bottom right corner of the window shows "CAP NUM SCRL" buttons.

Form design

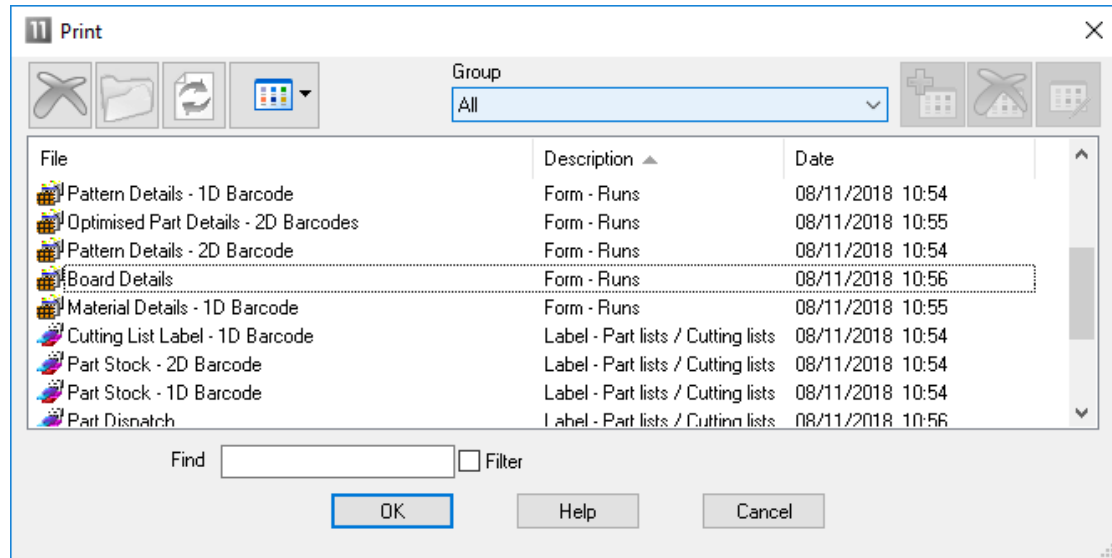
Use the object tool bar for the common items.

Print a form

- Select (at the main screen) **Print**
- Select **Form/Label print**

Choose the type of form to print (Quotes, Product requirements, Part lists, Cutting patterns, Runs).

The program prompts for the template to use:-



Select form template


- Select a template

The program then prompts for the data to print, this varies with the type of data, for example, for a Quotation or order file:-

The screenshot shows a standard Windows-style dialog box titled "Print". It features a close button (X) in the top right corner. The main content area is titled "Range" and contains two dropdown menus labeled "From" and "To", both of which are currently set to "Bedroom & bathroom". Below these dropdowns is a text input field labeled "Items in range" which contains the number "1". At the bottom of the dialog, there are two buttons: "OK" and "Cancel". The "OK" button is highlighted with a blue dashed border.

Select data for form

For a run or cutting patterns the program prompts with the current batch screen, select **OK** to continue. Select **PRINT** to print the data from the preview.

Order / item no.	Details	Quantity	Unit £	Total £
 GLOBAL FURNITURE LTD Furniture House, 27 Wood Lane, Bristol, BS1 2XR, UK Telephone: +44 (0)117 933 6323 Fax: +44 (0)117 933 6487				
Order invoice				
Invoice date: 11/06/2012		Order no. Products & parts order	Our ref.	Your ref.
Customer address				
Kitchens Direct Ashford Road Birmingham B11 2RX				
Products & parts order/001	Code: BASE-SINGLE Width: 500.0 Description: Single base unit Height: 870.0 Finish: MFC18-OAK Depth: 600.0	7	43.34	303.38
Products & parts order/002	Code: BASE-SINK Width: 1000.0 Description: Sink base unit Height: 870.0 Finish: MFC18-OAK Depth: 600.0	2	46.35	92.70
Products & parts order/003	Code: WALL-DOUBLE Width: 1000.0 Description: Double wall unit Height: 750.0 Finish: MFC18-OAK Depth: 300.0	5	38.69	193.45
Products & parts order/004	Code: WALL-SINGLE Width: 500.0 Description: Single wall unit Height: 750.0 Finish: MFC18-OAK Depth: 300.0	3	23.39	70.17
Products & parts order/004	Code: Description: Deliver separately Finish:			
Products & parts order/005	Code: F-UNIT-DOOR Length: 495.0 Description: Fixed size unit door Width: 570.0	4	4.02	16.08

Printed form

Form and label parameters - Use these to set the page size, margins and other general features of each label and form template.

With labels set the frequency with which labels are produced, per part, per part type, per stack etc.

Custom Reports / Summaries

Form design can also be used to create fully customised reports for runs (optimising results). This can be useful for tailoring documents to suit the production process. Emphasising important data, removing details, matching the order of data to the company standard ...

Here is part of a design for a custom report for a cutting list summary.

Design Form (Part lists / Cutting lists) Initial - Cutting List Form - 1D Barcode

File Edit Parameters View Tools Help

GLOBAL FURNITURE LTD

Furniture House, 27 Wood Lane, Bristol, BS1 2XR, UK
Telephone: +44 (0)117 933 6323 Fax: +44 (0)117 933 6487

Job reference

Reference

Title

Description

Date

Code

Cutting list details

Item	Part code	Material details	Part area	Length	Width	Qty
Item	Code	Item Category Material description	Part area	Length - mm	Width - mm	Total Qty
			Part area			Total Qty
			Part area			Total Qty

Page

23.47 0.15

CAP NUM SCRL

Custom report design

The layout and information on the report can be fully customised. The above design produces the following style of report or summary.

Review runs


File Edit View Settings Summaries Stock Help

Cutting List Form - 1D Barcode 1 of 47

Example CAD drawing

Kitchen plan//?default?default/SQ

Revision 1 : 28 Sep 2018 11:37 : Optimised by Sean-Lenovo



GLOBAL FURNITURE LTD






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Job reference:
Kitchen plan

Title:
Example CAD drawing

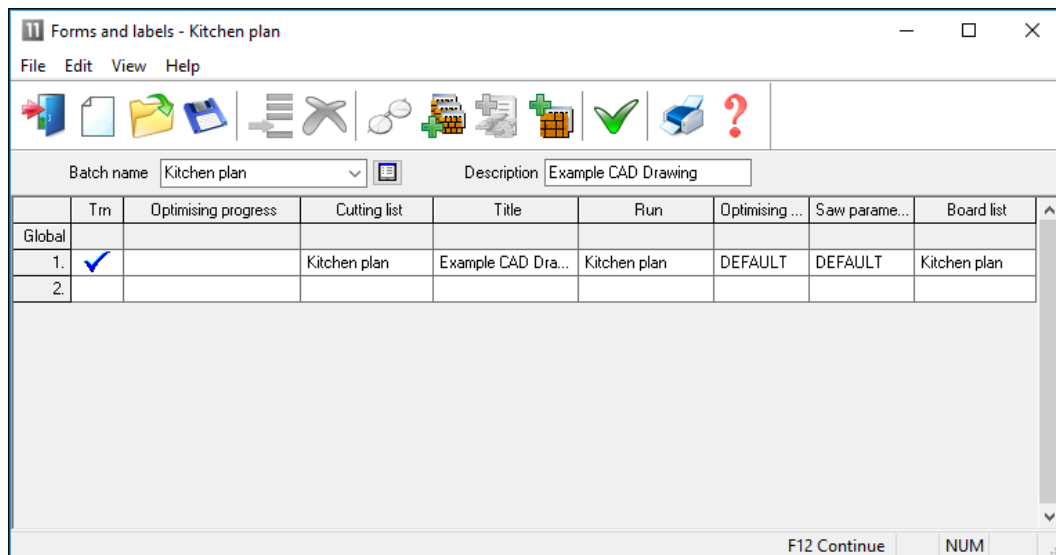
Date:
18/10/2018

Cutting list details

Item	Part code	Material details	Part area m2	Length	Width	Qty
3	BASE-BACK	Material: HARDBOARD-WHITE-4MM Hardboard 4mm - White  HARDBOARD-WHITE-4MM	0.00	476.0	710.0	1
16	BASE-BACK	Hardboard 4mm - White  HARDBOARD-WHITE-4MM	0.00	976.0	710.0	1
26	BASE-BACK	Hardboard 4mm - White  HARDBOARD-WHITE-4MM	0.00	976.0	710.0	1
37	BASE-BACK	Hardboard 4mm - White  HARDBOARD-WHITE-4MM	0.00	976.0	710.0	1
47	BC-BASE-BACK	Hardboard 4mm - White  HARDBOARD-WHITE-4MM	0.00	976.0	710.0	1






Page 1

In this case the program prompts for the run to use for the data.



Select run data for form

The report is printed in the usual way.

 GLOBAL FURNITURE LTD		Job reference: Kitchen plan Title: Example CAD drawing Date: 18/10/2018				
Furniture House, 27 Wood Lane, Bristol, BS1 2XR, UK Telephone: +44 (0)117 933 6323 Fax: +44 (0)117 933 6487						
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Printed report

Custom reports in Review runs

For run based custom reports it is often more convenient to integrate the reports in Review runs so that they appear on the Report bar - like any other report. To do this use the option at the main screen.

Select: **Tools > Form/Label designer**

Select: **File > New > Form**

Finally select a form design which best suits your requirements, the options are:

- Form - Runs Boards
- Form - Runs Materials
- Form - Runs Parts
- Form - Runs Patterns

Any reports created via this option are automatically added to the report bar under the 'Custom' tab.

Review runs

File Edit View Settings Summaries Stock Help

Optimised Part Details - 1D ... Example CAD Drawing

Kitchen plan//?DEFAULT/?DEFAULT/SQ [Rules:CL,BL]

Revision 6 : 27 Aug 2018 14:26 : Recalculated by Sean-Lenovo

Optimised Parts

Run: Kitchen plan Description: Example C

Edgebander setup time: 0:05 Saw setup time: 0:00

Part Code	Material Code	Length	Width	Quantity	Grain	Ref. Code	Bottom edge	Top edge	Left edge	Right edge	Drawing name	Part Volume
BASE-CABINET-END-LEFT	MEL-CHIP-18MM	581.0	870.0	1	Non Grained	MELBAS1	OAK-TAPE-22MM	OAK-TAPE-22MM	OAK-TAPE-22MM	OAK-TAPE-22MM	00014463	LOW
BASE-CABINET-END-RIGHT	MEL-CHIP-18MM	581.0	870.0	1	Non Grained	MELBAS1	OAK-TAPE-22MM	OAK-TAPE-22MM	OAK-TAPE-22MM	OAK-TAPE-22MM	00014464	LOW
BASE-CABINET-DRAWER-LONG	MFC18-OAK	898.0	182.3	1	Grained	MFCBAS1	OAK-TAPE-22MM	OAK-TAPE-22MM	OAK-TAPE-22MM	OAK-TAPE-22MM	00014465	LOW

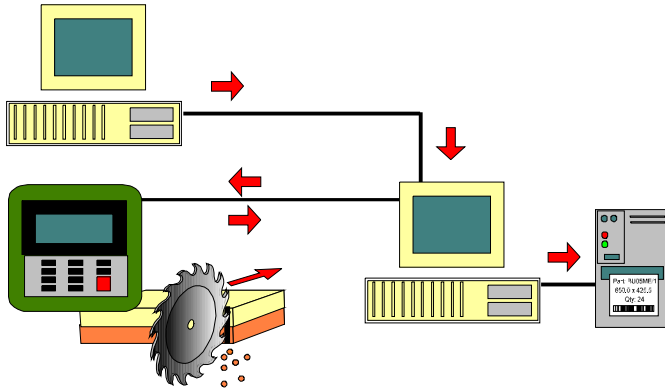
Barcode labels: FIN SIZE 582.0 X 870.0 and FIN SIZE 900.0 X 184.3

Custom report

These reports can also be accessed from the main screen as forms (*Print - Forms - Runs*).

17. Online PC Saw Interface

The Online PC option runs on a computer located next to the saw. This provides a link to the saw for printing labels and sending data to the saw in cases where the saw controller has more limited graphic facilities.



Online PC

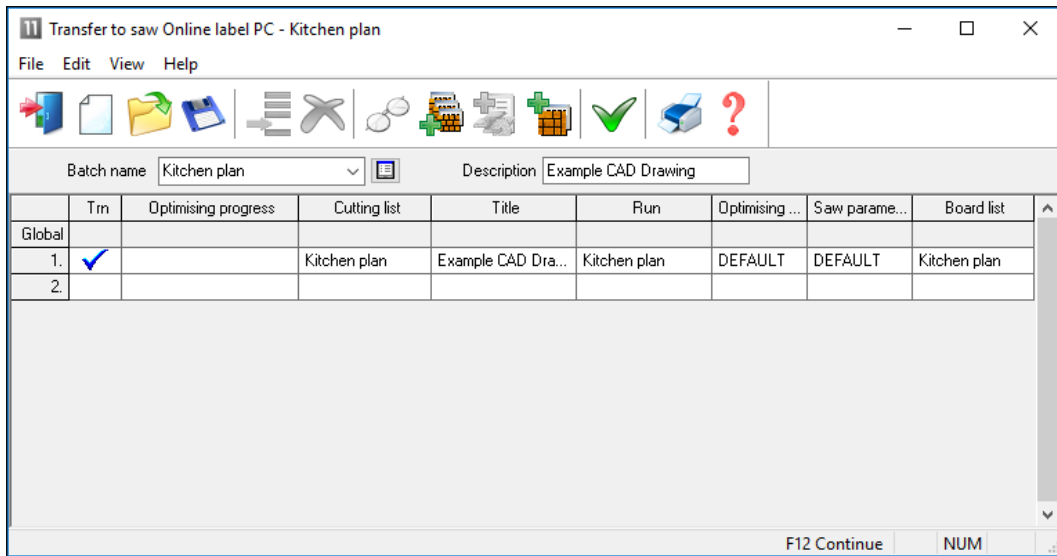
The diagram illustrates one arrangement - several different arrangements are possible.

To use the Online PC option set the Saw Transfer parameters to include a saw type for the Online PC saw type and give the saw type a name like 'OnlinePC'.

- Select (at the main screen) **Machine interface**
- Select the saw type set as the option for Online PC (e.g. OnlinePC)

To transfer runs to the saw select: **Transfer to saw**

The program prompts for the data to transfer (in the usual way).

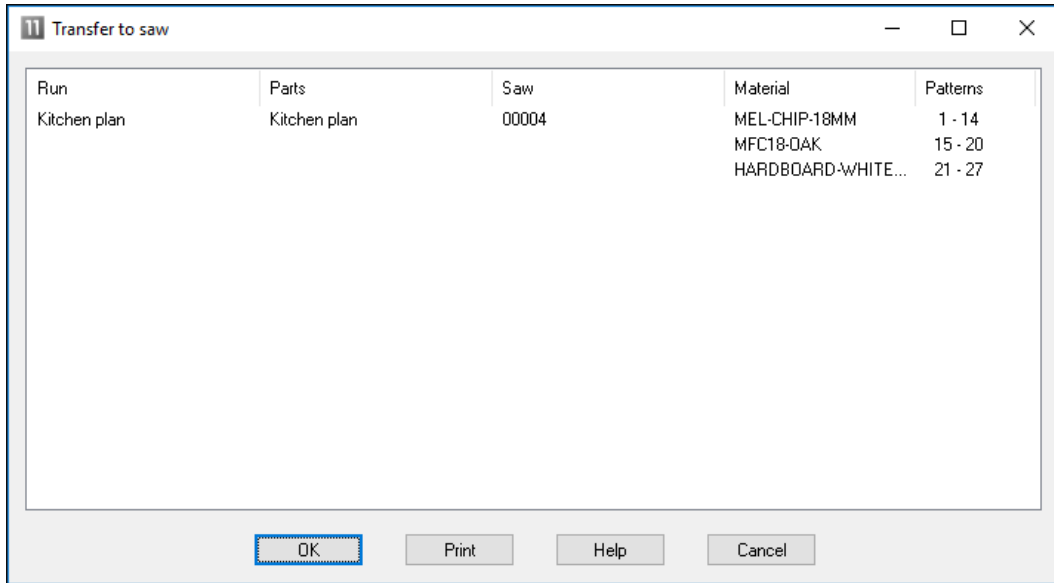


Transfer to saw - Online PC



Select the 'Continue' option

The details of the transfer are shown.



The screenshot shows a dialog box titled "Transfer to saw" with a table of data. The table has five columns: Run, Parts, Saw, Material, and Patterns. The data is as follows:

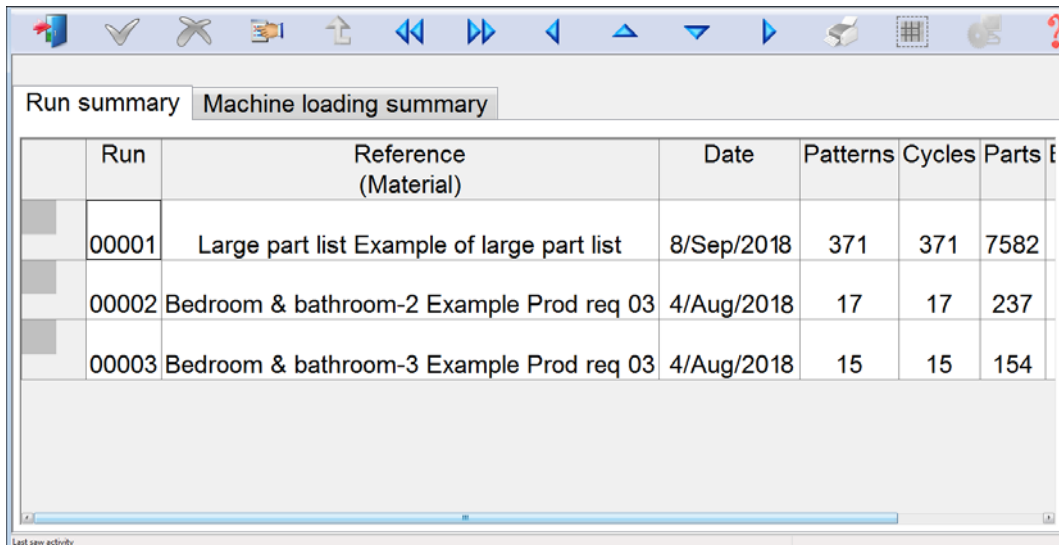
Run	Parts	Saw	Material	Patterns
Kitchen plan	Kitchen plan	00004	MEL-CHIP-18MM	1 - 14
			MFC18-OAK	15 - 20
			HARDBOARD-WHITE...	21 - 27

At the bottom of the dialog box, there are four buttons: OK, Print, Help, and Cancel. The OK button is highlighted with a blue dashed border.

Details of saw transfer - Online PC

The Online PC option includes a set of options for viewing and editing any runs sent to the saw. To review runs at the saw select: **Online PC - operations**

The first screen shows the runs at the saw.



Run	Reference (Material)	Date	Patterns	Cycles	Parts
00001	Large part list Example of large part list	8/Sep/2018	371	371	7582
00002	Bedroom & bathroom-2 Example Prod req 03	4/Aug/2018	17	17	237
00003	Bedroom & bathroom-3 Example Prod req 03	4/Aug/2018	15	15	154

Run summary - Online PC

The font size adjusts automatically to the computer screen resolution so the display fills up the screen so the display is as clear as possible - it is often used with a touch screen.

- Click on a run to see the details of each pattern.

The screenshot displays a software window titled "Example of large part list" with a sub-header "00001 Pattern 1 Of 371". The interface is divided into several sections:

- Toolbar:** Located at the top, it contains various navigation and editing icons such as back, forward, and zoom.
- Part List:** On the left side, there is a list of parts under the heading "Board". The first entry is "1. CHIPBOARD-18MM/01". Below this, the following properties are listed:
 - Material: CHIPBOARD-1...
 - Length: 2440.0
 - Width: 1220.0
 - Thickness: 18.0
 - Quantity: 5
 - Rotated: N
- Current area:** Below the part list, the "Current area" is defined as "795. 795". Its properties are:
 - Material: CHIPBOARD-1...
 - Length: 707.0
 - Width: 633.0
- Layout Diagram:** On the right side, a large rectangular area contains a grid of smaller rectangles representing individual parts. Each rectangle is labeled with its dimensions and quantity. The top row contains four rectangles with dimensions 795, 795, 795, and 905. The bottom row contains five rectangles with dimensions 887, 887, 53, 53, and 76. The bottom-most row contains five rectangles with dimensions 484 X 623, 484 X 623, 517 X 484, 517 X 484, and 484 X 100.

Online PC pattern

Manual label printing - move to the pattern and part required and select PRINT to print the label.

For saws with Compumatic controllers synchronisation of cutting and labels is automatic.

View the details of the parts for each pattern and if appropriate to the saw controller the cutting dimensions.

Example of large part list 00001

Pattern Part sizes Pattern 1 Of 371

	Part Description	Part Length	Part Width	Total Produced	No Per board	Quantity this Pattern	Inf
53	53	517.0	484.0	10	2	10	
76	76	484.0	100.0	20	1	5	
795	795	707.0	633.0	20	3	15	
887	887	484.0	623.0	10	2	10	
905	905	707.0	470.0	5	1	5	

Last saw activity

Online PC Part sizes

The status bar at the foot of the screen shows information from the PC at the saw and the state of the run.

A tab for Cutting dimensions is shown where these are needed for the saw controller