

# SECANT

## Online cutting service



### Overview

The Workshop offers a simple on-line cut planning service that demonstrates the power of SECANT and provides a commercial service for businesses that have an occasional need to cut plan. The Workshop is designed for small cutting operations and provides an appropriate selection from the facilities and cutting controls offered by the full package. Full product specifications of both the bar cutting and sheet cutting products can be found in the download area of our website [www.pslopt.co.uk](http://www.pslopt.co.uk).

### Registration and Subscription

The online cutting service offers two levels of membership.

#### Registration

Becoming a registered user is **free**. As a registered user you may enter cutting requirements and available stock, along with certain cutting controls and submit jobs for cut planning. This level of membership is appropriate for users wishing to evaluate the system. Once the job has been processed you will be able to view details of the stock material needed to meet the cutting requirements and the percentage yield of the patterns the system has generated. As a registered user you are able to test the quality of the plans that SECANT can produce. However you will not be able to view the cutting patterns themselves. To see the cutting patterns you must become a subscribed user.

Follow these three simple steps to become a registered user:

- Select the “**Not registered? Click here**” hyperlink at the bottom of the online cutting login page.
- Create a username for yourself and press the “**Go**” button
- Complete some basic personal details (name, company name, email address, password) and press the “**Go**” button.

NB: PSL will only use this information to contact you regarding your online account and the information will never be shared with third parties.

Your registration is now complete, make a note of your username and password and then select the hyperlink “**click here**” to return to the online cutting workshop.

For details on how to submit your jobs to the system please see the chapter “**Entering a cutting job**” or alternatively continue reading to discover the benefits of becoming a subscribed user.

#### Subscription

Subscription is the second level of membership offered to the online cutting workshop. A subscribed user is able:

- to see the required stock and percentage yield for a cutting job,
- download a PDF file showing the detailed cutting plans and
- receive the saw control files corresponding to the cutting patterns of the job by email.

Saw control files are available for the CPOUT, PTX and DXF formats. If you want automatic emailing of saw control files for each job you submit then contact [registrations@pslopt.co.uk](mailto:registrations@pslopt.co.uk) and state the format required.

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You may subscribe for a whole year at a cost of £150 or for a single month at a cost of £15. Subscriptions do not automatically renew so you are only committing yourself to a single payment. If you don't need to cut plan every month then just pay for the months when you use the service. Monthly subscriptions are made through the PayPal online payments system. Annual subscriptions may be ordered by emailing [registrations@pslopt.co.uk](mailto:registrations@pslopt.co.uk).

To become a subscribed user login to the online system using the username and password you created when you registered. You will then see the option "***To upgrade your account and become a subscribed user please click on the PayPal link***"



Selecting this link will take you to the secure PayPal site where you may create a new PayPal account or use an existing account to purchase your subscription.

You will be notified when you login to your account of the expiry date of your current subscription - if your account has expired simply select the PayPal link again to purchase another month's access to your PDF cutting plans.

### ***Entering a new cutting job***

To use the online cutting service you must first login using the username and password created during your registration.

At this stage, if you are a free registered user you will be given the option to upgrade your account to become a subscribed user. Alternatively you may continue to the online cutting workshop as a free registered user.

You will be taken to the job entry screen:

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### Select your job type

The online cutting workshop offers either bar or panel cutting in either imperial or metric units. Use the drop down box marked “**Choose job type...**” to select which type of job you wish to enter.

### Enter cutting requirements

Enter the details of each item to be cut by completing the Identifier, Length, Width (panel only) and Requirement fields. If you need to add additional pieces simply press the “**Add Row**” button to display a new blank line.

### Enter available stock

In a similar manner to entering the cutting requirements complete the Identifier, Length, Width (panel only) and Available fields for each item of stock which can be used to cut the requirements you have entered. NB: the online service assumes that any cut piece may be cut from any of the stock items entered. Once again, press the “**Add Row**” button to display a new blank line to enter further stock items.

### Settings/Controls

The online service offers a variety of controls to tailor the cutting patterns produced:

#### **Bar cutting controls**

- **Blade loss (swarf)** – this control defines the material which is lost each time a cut is made
- **Trim front and back** – this control defines the material which is lost from both ends of the bar in order to ensure a straight edge is available.
- **Include handling costs** – if this control is checked the system will take into account costs of the job other than merely the material used. It will consider costs associated with picking additional lengths of

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stock, changing the stop position on the saw etc and offset the gains that can be made here against any additional material required.

- **Max bars to be cut to a bundle** – use this control to define the number of bars which may be cut on a single pass of the saw. The system will always try to cut to the full bundle height to make most efficient use of the saw.
- **Keep offcuts** – if this control is checked the system will take into account the value of returning offcuts to stock when it designs its cutting patterns

### Panel cutting controls

- **Blade loss (kerf)** – this control defines the material which is lost each time a cut is made
- **Trim all sides** – this control defines the material which is lost from all edges of a board to ensure that straight edges are available
- **Allow 3<sup>rd</sup> phase cuts** – if this control is checked then the system may design patterns which contain pieces which do not make complete use of the full width of a strip.
- **Max sheets to be cut to a book** - use this control to define the number of sheets which may be cut on a single pass of the saw. The system will always try to cut to the full book height to make most efficient use of the saw. NB: if this control is set then the system may overproduce pieces to make better use of the full cutting height.
- **Pattern type** – use this control to select which patterns may be cut on your saw. The system may produce simple rip patterns (horizontal strips only), rip or head patterns (horizontal or vertical strips) or may permit patterns with a single turn of material (vertical strips followed by horizontal strips)
- **Grain** – check this control if your material is grained. If this control is checked a piece will be planned so that its length dimension is aligned with the length dimension of the stock item.

### Submitting the job

Once you have fully entered your cutting requirement, available stock, and have defined any controls which you require, press the “**Submit Job**” button to send the job to the optimization servers for processing. You will be shown a list of your jobs.

### Managing your job list

Send to site

PSL Job list for Account: PSL000

You may view the results of any job whose status is "Completed" by clicking on the Job ID. Jobs that are "Processing..." will normally complete within a minute or two. If you wish you may return to the Order Entry screen and enter further jobs or return to this site later to view your completed jobs.

If you wish to reload a job into the Order Entry screen then click on the Job ID and then select Reload Job.

Job ID	Time Started	User's Email	Job Type	Job Units	Status
PSL000-000000003	18/12/2007 10:39:28.718	matt.foster@pslopt.co.uk	Bar	Millimetres	Processing...
PSL000-000000002	18/12/2007 10:39:20.159	matt.foster@pslopt.co.uk	Bar	Millimetres	Completed
PSL000-000000001	17/12/2007 15:48:39.769	matt.foster@pslopt.co.uk	Bar	Millimetres	Completed

Back To Order Entry

Your job list will display details of all jobs submitted by you in the last sixty days. You may view details of any job which has completed by clicking on the job name hyperlink. Jobs which are still processing should complete within a minute or two. You may return to the Order Entry screen to submit further jobs by pressing the “**Back to Order Entry**” button – your submitted jobs will continue to process in the background.

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Once you have selected a job by clicking on the job name, you will be taken to the Job Detail screen.

The screenshot shows the 'Job Detail' screen for account PSL000 and job 0000000005. It includes navigation buttons, job details, two data tables, job preferences, and a job output summary.

**Job Details**

Job	PSL000-0000000005
Started	18/11/2007 10:48:59.968
User Email	matt.foster@pslopt.co.uk
Type	Panel
Units	Millimetres
PDF File	You must have a valid account to download file

**Job Details Table 1**

Num	Cut ID	Length	Width	Quantity	Made	Overmake
Cut 1	P1	1250	550	50	50	0
Cut 2	P2	600	250	15	15	0
Cut 3	P3	125	450	15	15	0

**Job Details Table 2**

Num	Stock ID	Length	Width	Qty Available	Qty Used
Stock 1	S1	2500	2000	50	2

**Job Preferences**

Blade Loss (Kerf) (Millimetres)	4
Trim All Sides (Millimetres)	4
Allow 3rd Phase Cuts	Yes
Max Sheets To Be Cut In A Book	1
Pattern Type	Vertical Strip Followed By Horizontal Strip
Grain Type	No

**Job Output Summary**

Messages	0
Patterns	3
Books Cut	3
Offcut %	3.00%
Yield %	93.44%
Waste %	10.55%
Area Used (m <sup>2</sup> )	12.50

This screen (available to both registered and subscribed users) displays the details of your job. The report shows;

- the pieces cut (including any overmake required to make full use of the cutting height of the saw),
- the stock requirement
- summary details of the number of patterns produced, the number of saw cycles required and the percentage yield, offcut and waste.

In addition subscribed users are offered a link to a PDF file containing a full report on the job including detailed cutting patterns.

## ***Modifying and replanning an existing job***

The on-line service stores any job you enter for a period of sixty days. You can save time in submitting future jobs by selecting an existing job and modifying the cutting list or stock availability rather than starting afresh each time.

Log into the on-line service in the normal way and then click on the **Job List** button. Double click on an existing job and then select the **Reload** option. The cutting list and stock availability will be loaded into the job entry form. The job details may be modified and a new job submitted for cut planning.

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### ***Contact information***

If you have any further questions then please contact us at the address given below.

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