



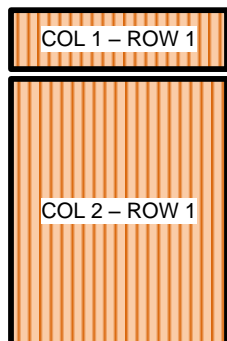
Grouped Panels/Grain Matching in Control Nesting Using the EXCEL FILES Feature

Thermwood has added 4 new columns to the EXCEL FILES worksheet specification. (These new fields are not documented in the EXCEL FILES section of the Control Nesting Help.) These fields are Group_ID, Grain_Direction, Column and Row.

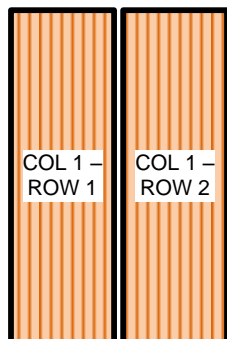
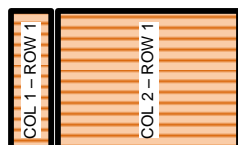
Group_ID must be unique for each group/assembly of panels.

Grain_Direction defines the grain angle through the panels.

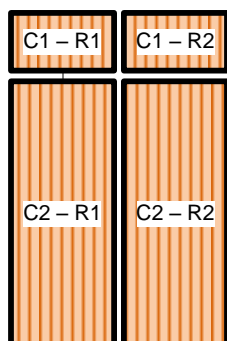
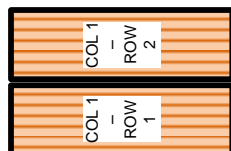
To picture COL and ROW, turn the assembly of panels 90 degrees to the left. ROWs are then horizontal and move upwards. COLs are vertical and go left to right.



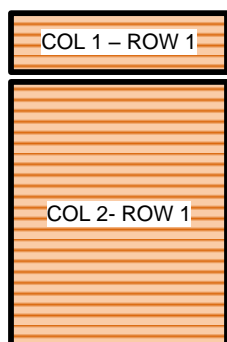
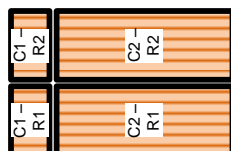
	A	B	C	D	E	F	G	H	I	J	K	L	M
1	Qty	P-Name	P-Width	P-Length	Material	S-Width	S-Length	S-Thick	Grain	Grp_ID	Grain_Ang	Col	Row
2	1	P1	20	6	Mat 1	49	97	0.75	yes	1	0	1	1
3	1	P1	20	24	Mat 1	49	97	0.75	yes	1	0	2	1



	A	B	C	D	E	F	G	H	I	J	K	L	M
1	Qty	P-Name	P-Width	P-Length	Material	S-Width	S-Length	S-Thick	Grain	Grp_ID	Grain_Ang	Col	Row
2	1	P1	10	30	Mat 1	49	97	0.75	yes	1	0	1	1
3	1	P1	10	30	Mat 1	49	97	0.75	yes	1	0	1	2

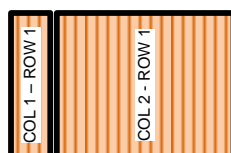


	A	B	C	D	E	F	G	H	I	J	K	L	M
1	Qty	P-Name	P-Width	P-Length	Material	S-Width	S-Length	S-Thick	Grain	Grp_ID	Grain_Ang	Col	Row
2	1	P1	10	6	Mat 1	49	97	0.75	yes	1	0	1	1
3	1	P1	10	6	Mat 1	49	97	0.75	yes	1	0	1	2
4	1	P1	10	24	Mat 1	49	97	0.75	yes	1	0	2	1
5	1	P1	10	24	Mat 1	49	97	0.75	yes	1	0	2	2



	A	B	C	D	E	F	G	H	I	J	K	L	M
1	Qty	P-Name	P-Width	P-Length	Material	S-Width	S-Length	S-Thick	Grain	Grp_ID	Grain_Ang	Col	Row
2	1	P1	20	6	Mat 1	49	97	0.75	yes	1	90	1	1
3	1	P1	20	24	Mat 1	49	97	0.75	yes	1	90	2	1

Same as first example only Grain @ 90.



This and any T-shaped arrangement is not possible due to spacing requirements for Outline router bit.

