Mathematical Models and Heuristic Algorithms for Pallet Building Problems with Practical Constraints

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1 Appendix

This appendix reports the individual average results for the algorithms proposed on paper "Mathematical Models and Heuristic Algorithms for Pallet Building Problems with Practical Constraints" to compare the performance among all strategies in a consistent way. The average results for the algorithms are summarized in Tables 1-6.

By considering the deterministic algorithms EPMH, MEPMHF and EPFULL, we present the Tables 1–3. In the first three columns the table reports, respectively, the information about the algorithm, the total number of pallets in the solution and the total number of layers created. In the six successive columns it reports the minimum, maximum and average pallet utilization and fill factor (2D space of all layers). Next, it reports the average number of single-item, single-family and residual layers. The last column reports the computational time (represented by minutes:seconds.milliseconds).

By considering the GRASP-based algorithms EPMH, MEPMHF and EPFULL, we present the Tables 4–6. In this table, for each algorithm, we report the same information as the previous tables, including, respectively, the minimum, maximum and average values of the objective function, the total number of iterations, the total number of local searches and the ratio between the total number of local searches and the total number of iterations.

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Table 1: EPMH computational results (individual average).

lal]	(RL) (min:sec.mini)			2.00 00:00.020																				4.00 00:00.022	5.00 00:00.021	3.71 00:00.030
Single- R family la	Ŭ			9.00																						15.08
Single- item	layers	31.00	10.00	16.00	1.00	19.00	98.00	38.00	69.00	8.00	13.00	00.9	18.00	15.00	12.00	22.00	29.00	4.00	16.00	21.00	26.00	24.00	28.00	14.00	16.00	23.08
tor	Avg	0.87	0.77	0.84	0.68	0.85	0.88	0.89	0.86	0.81	0.82	0.81	0.84	0.83	0.81	0.87	0.85	0.78	0.86	0.86	0.86	0.83	0.85	0.87	0.83	0.83
2D fill factor	Max	0.98	0.86	0.95	0.96	0.93	0.98	0.95	0.97	0.95	0.93	0.96	0.96	0.95	0.98	0.96	0.95	0.95	0.98	0.95	0.98	0.96	0.97	0.97	0.97	96.0
	Min	0.45	0.58	0.16	0.09	0.27	0.14	0.73	0.56	0.30	0.48	0.27	0.40	0.27	0.19	0.66	0.22	0.64	0.63	0.68	0.05	0.18	0.20	0.40	0.08	0.36
ng	Avg	0.73	0.37	0.66	0.21	0.53	0.74	0.70	0.74	0.62	0.42	0.40	0.57	0.72	0.46	0.74	0.73	0.42	0.52	0.69	0.67	0.71	09.0	0.67	0.64	0.59
Pallet filling	Max	0.85	0.82	0.86	0.50	0.86	0.88	0.91	0.91	0.77	0.81	0.88	0.85	0.80	0.91	0.88	0.89	0.72	0.90	0.86	0.89	0.86	0.88	0.86	0.87	0.84
Pg	Min	0.22	0.09	0.20	0.09	0.00	0.02	0.22	0.24	0.33	0.08	0.09	0.14	0.56	0.04	0.58	0.52	0.10	0.12	0.39	0.14	0.45	0.10	0.30	0.22	0.25
N. of	layers	44.00	17.00	27.00	7.00	30.00	107.00	50.00	91.00	17.00	24.00	20.00	42.00	34.00	33.00	47.00	51.00	17.00	38.00	50.00	55.00	54.00	59.00	44.00	47.00	41.88
N. of	pallets	11.00	7.00	7.00	4.00	8.00	30.00	13.00	20.00	5.00	00.6	8.00	12.00	8.00	11.00	11.00	12.00	00.9	12.00	12.00	14.00	12.00	16.00	11.00	12.00	11.29
Instance		01	02	03	04	05	90	20	80	60	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	AVG

Table 2: MEPMH computational results (individual average).

Instance	N. of	N. of	Pa	Pallet filling	ng	2D	2D fill factor	cor	Single- item	Single- family	Residual layers	Time
	pallets	layers	Min	Max	Avg	Min	Max	Avg	layers	layers	$(ilde{ ext{RL}})$	(min:sec.milli)
	10.00	44.00	0.63	0.91	08.0	0.45	0.98	0.87	31.00	11.00	2.00	00:00.203
	00.9	17.00	0.11	0.78	0.43	0.58	0.86	0.77	10.00	4.00	3.00	920.0000
	00.9	27.00	0.65	0.89	0.78	0.16	0.95	0.84	16.00	9.00	2.00	00:00.041
	4.00	7.00	0.09	0.50	0.21	0.09	0.96	89.0	1.00	2.00	4.00	00:00.010
	7.00	30.00	0.11	0.86	0.00	0.27	0.93	0.85	19.00	9.00	2.00	00:00.137
	30.00	107.00	0.02	0.92	0.74	0.14	0.98	0.88	98.00	4.00	5.00	00:30.123
	11.00	50.00	0.50	0.91	0.83	0.73	0.95	0.89	38.00	10.00	2.00	00:00.171
	19.00	91.00	0.47	0.93	0.78	0.56	0.97	0.86	69.00	18.00	4.00	00:04.105
	4.00	17.00	0.71	0.84	0.77	0.30	0.95	0.81	8.00	7.00	2.00	00:00.021
	8.00	24.00	0.08	0.86	0.48	0.48	0.93	0.82	13.00	7.00	4.00	00.00.292
	00.9	20.00	0.10	0.78	0.53	0.27	0.96	0.81	00.9	11.00	3.00	090:00:00
	11.00	42.00	0.14	0.89	0.63	0.40	0.96	0.84	18.00	20.00	4.00	00:00:965
	8.00	34.00	0.27	0.89	0.72	0.27	0.95	0.83	15.00	16.00	3.00	00:08.782
	00.6	33.00	0.04	0.86	0.56	0.19	0.98	0.81	12.00	17.00	4.00	00:01.417
	10.00	47.00	0.72	0.89	0.82	0.66	0.96	0.87	22.00	22.00	3.00	00:00.101
	11.00	51.00	89.0	0.88	0.79	0.22	0.95	0.85	29.00	19.00	3.00	00:00.154
	00.9	17.00	0.08	0.77	0.42	0.64	0.95	0.78	4.00	10.00	3.00	00.00.073
	11.00	38.00	0.12	0.00	0.57	0.63	0.98	0.86	16.00	16.00	00.9	00:05.749
	11.00	50.00	0.62	0.91	0.76	0.68	0.95	0.86	21.00	24.00	5.00	00.00.119
	13.00	55.00	0.14	0.91	0.72	0.05	0.98	0.86	26.00	23.00	00.9	00:30.039
	11.00	54.00	0.62	0.91	0.77	0.18	0.96	0.83	24.00	26.00	4.00	00:02.431
	15.00	59.00	0.10	0.89	0.64	0.20	0.97	0.85	28.00	25.00	00.9	00.01.866
	10.00	44.00	0.49	0.87	0.73	0.40	0.97	0.87	14.00	26.00	4.00	00:00.788
	11.00	47.00	0.11	0.87	0.69	0.08	0.97	0.83	16.00	26.00	5.00	00:00.945
- F	10.33	41.88	0.32	98.0	99.0	0.36	96.0	0.83	23.08	15.08	3.71	00:03.694

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Table 3: EPFULL computational results (individual average).

$^{ m tl}$ $^{ m Time}$	(min:sec.milli)	02:12:036	00:19.650	01:38.174	00:22.079	01:44.650	01:15.327	03.07.334	03:25.827	01.47.783	01:13.216	02:16.216	02:14.166	02.46.520	02:33.528	04.07.588	03:29.289	02.09.711	03:13.187	04:32.811	05:31.439	05:25.681	06:36.848	06.25.965	05:28.801	03:04.909
Residua	(B.L.)	3.00	3.00	1.00	3.00	2.00	4.00	2.00	4.00	2.00	4.00	2.00	4.00	3.00	3.00	2.00	3.00	3.00	5.00	4.00	5.00	3.00	5.00	4.00	2.00	3.29
Single-	laminy	23.00	4.00	14.00	2.00	11.00	16.00	23.00	26.00	8.00	11.00	17.00	22.00	18.00	17.00	31.00	28.00	11.00	20.00	31.00	29.00	36.00	38.00	32.00	33.00	20.88
Single-	lavers	19.00	10.00	11.00	1.00	16.00	86.00	25.00	61.00	00.9	9.00	0.00	17.00	12.00	12.00	13.00	20.00	2.00	13.00	14.00	19.00	13.00	15.00	7.00	00.9	16.96
or	Ave	0.85	0.77	0.87	0.79	0.88	0.89	0.89	0.86	0.86	0.82	0.85	0.82	0.86	0.84	0.89	0.85	0.83	0.86	0.88	06.0	0.86	0.87	0.89	0.89	98.0
2D fill factor	Max	0.95	98.0	96.0	0.96	0.93	0.98	0.94	0.95	0.96	0.95	0.96	0.95	0.96	0.98	0.96	0.93	0.94	0.98	0.96	0.94	0.96	0.95	0.96	0.95	0.95
2D	Min	0.10	0.58	89.0	0.34	0.50	0.50	0.35	0.56	0.40	0.33	0.57	0.11	0.23	0.44	0.66	0.02	0.31	0.34	0.00	0.73	0.50	0.57	0.71	0.58	0.45
ng	Ave	0.80	0.43	0.78	0.21	0.00	0.77	0.83	0.78	0.77	0.48	0.53	0.57	0.64	0.63	0.82	0.79	0.51	0.57	0.76	0.78	0.77	0.74	0.81	0.69	0.67
Pallet filling	Max	0.86	0.82	0.84	0.51	0.86	0.92	0.91	06.0	0.81	0.87	0.89	0.87	0.83	0.94	0.90	0.88	0.79	0.87	0.89	0.90	0.91	0.89	0.89	0.92	98.0
Pa	Min	0.64	0.09	0.61	0.05	0.11	0.00	0.51	0.32	0.73	0.05	0.10	0.12	0.13	0.09	0.74	0.56	0.09	0.13	0.50	0.17	0.48	0.18	0.74	0.16	0.31
N. of	layers	45.00	17.00	26.00	00.9	29.00	106.00	50.00	91.00	16.00	24.00	19.00	43.00	33.00	32.00	46.00	51.00	16.00	38.00	49.00	53.00	52.00	58.00	43.00	44.00	41.13
N. of	pallets	10.00	00.9	00.9	4.00	7.00	29.00	11.00	19.00	4.00	8.00	00.9	12.00	9.00	8.00	10.00	11.00	5.00	11.00	11.00	12.00	11.00	13.00	9.00	11.00	10.13
0000	IIIstanice	01	02	03	04	05	90	20	80	60	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	AVG

Table 4: GREP computational results (individual average).

N. of		Pali	Pallet filling	გი	2D f	2D fill factor	r	Single- item	Single- family	Residual lavers	Object	Objective function	uo	Total it- erations	Total local searches	Ratio
pallets	s layers	Min	Max	Avg	Min	Max	Avg	layers	layers	(RL)	Min	Max	Avg	(TI)	(LS)	LS/11
11.00	45.00	0.41	0.88	0.73	0.56	0.95	0.85	32.00	12.00	1.00	0.6727	0.6727	0.6727	4148.00	643.47	0.1551
00.9		0.12	0.82	0.43	0.58	0.86	0.77	10.00	4.00	3.00	0.5397	0.5397	0.5397	16991.13	2395.13	0.1410
7.00		0.49	0.77	0.66	0.51	0.92	0.75	20.80	8.20	1.00	0.6486	0.6486	0.6486	11600.53	1649.93	0.1422
3.00	0.00	0.12	0.59	0.28	0.66	0.94	0.79	1.00	2.00	3.00	0.4562	0.4562	0.4562	24652.27	3500.60	0.1420
8.00		0.06	0.86	0.53	0.27	0.93	0.85	19.00	9.00	2.00	0.6300	0.6300	0.6300	10380.87	1528.53	0.1472
29.00		0.13	0.88	0.77	0.67	0.98	0.88	99.00	4.00	4.00	0.6024	0.6024	0.6024	1489.27	251.40	0.1688
13.00		0.22	0.91	0.70	0.73	0.95	0.89	38.00	10.00	2.00	0.6476	0.6476	0.6476	6900.47	960.47	0.1392
20.00		0.24	0.91	0.74	0.56	0.97	0.86	69.00	18.00	4.00	0.6118	0.6118	0.6118	3787.87	517.40	0.1366
5.00		0.25	0.85	0.62	0.53	0.93	0.81	7.93	8.07	1.00	0.6494	0.6494	0.6494	12332.47	1734.80	0.1407
8.00		0.13	0.81	0.48	09.0	0.91	0.82	13.00	7.93	3.07	0.5444	0.5675	0.5659	15494.47	1225.27	0.0791
00.9		0.12	0.87	0.53	0.65	0.96	0.85	2.00	10.00	2.00	0.6127	0.6127	0.6127	8160.80	1143.33	0.1401
12.00		0.14	0.85	0.57	0.40	0.96	0.84	18.00	20.00	4.00	0.5762	0.5762	0.5762	6857.87	951.93	0.1388
8.00		0.56	0.79	0.72	0.10	0.95	0.83	15.00	16.00	3.00	0.809.0	0.6080	0.6080	9297.93	1302.53	0.1401
10.00		0.07	0.84	0.51	0.31	0.98	0.79	14.13	15.73	4.00	0.5539	0.5588	0.5546	4041.53	684.07	0.1693
11.00		0.58	0.88	0.74	0.66	0.96	0.87	22.00	22.00	3.00	0.6228	0.6228	0.6228	5495.07	951.33	0.1731
12.00		0.52	0.89	0.73	0.21	0.95	0.85	29.00	19.00	3.00	0.6162	0.6162	0.6162	6798.87	942.67	0.1387
00.9		0.07	0.86	0.42	0.46	0.95	0.83	3.00	10.00	3.00	0.5517	0.5517	0.5517	10067.93	1623.13	0.1612
11.00		0.13	0.91	0.57	0.61	0.98	0.83	18.00	17.00	4.00	0.5744	0.5744	0.5744	3775.07	520.20	0.1378
12.00		0.27	0.87	0.69	0.68	0.95	0.86	21.00	24.00	5.00	0.5845	0.5845	0.5845	5680.67	731.00	0.1287
13.07		0.15	0.88	0.72	0.68	0.98	0.88	26.20	23.00	4.93	0.5915	0.5936	0.5917	4203.93	581.53	0.1383
12.00		0.45	0.86	0.71	0.19	0.96	0.83	24.00	26.00	4.00	0.5965	0.5965	0.5965	4380.93	609.73	0.1392
14.26		0.17	0.90	0.68	0.27	0.97	0.84	28.80	25.00	5.73	0.5715	0.5792	0.5725	3478.13	561.27	0.1614
11.00		0.30	0.86	0.67	0.40	0.97	0.87	14.00	26.00	4.00	0.5973	0.5973	0.5973	4616.53	637.07	0.1380
11.00	48.00	0.51	0.90	0.69	0.58	0.95	0.81	21.00	23.00	4.00	0.5867	0.5867	0.5867	4686.07	675.13	0.1441
10.80	(42.02	0.26	0.85	0.62	0.49	0.95	0.84	23.79	15.00	3.24	0.5936	0.5952	0.5946	7888.28	1096.75	0.1390

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Table 5: MGREP computational results (individual average).

Fotal local Ratio			_	_	_	70.07 0.1518	_	_	_	_	_	_	_	_	_	_	_	_	_	_	_	_	_	_	147.27 0.1456	06.56 0.1447
. 02	<u>T</u>)				_	1779.20				_																5573.50
on	Avg	0.6782	0.5302	0.6553	0.4562	0.6379	0.6023	0.6516	0.6035	0.6632	0.5532	0.6100	0.5789	0.6060	0.5642	0.6276	0.6187	0.5517	0.5766	0.5843	0.5905	0.5962	0.5749	0.6049	0.5915	0.5962
Objective functior	Max	0.6803	0.5397	0.7159	0.4562	0.6420	0.6162	0.6607	0.6154	0.6704	0.5675	0.6127	0.5833	0.6080	0.5678	0.6302	0.6230	0.5517	0.5823	0.5913	0.5977	0.6032	0.5893	0.6049	0.5984	0.6045
Object	Min	0.6496	0.4921	0.6486	0.4562	0.6238	0.5980	0.6154	0.5876	0.6342	0.5382	0.5724	0.5559	0.5931	0.5416	0.6172	0.5864	0.5517	0.5580	0.5702	0.5749	0.5865	0.5666	0.6049	0.5830	0.5794
Residual layers	(RL)	1.07	3.20	0.93	3.00	2.00	3.93	2.00	4.00	1.20	3.60	2.07	4.07	3.00	4.07	2.80	3.00	3.00	4.20	5.00	4.73	4.00	4.87	4.00	3.93	3.24
Single- family	layers	11.93	3.87	8.13	2.00	8.67	4.00	10.20	17.53	8.27	7.47	9.93	19.53	16.00	16.60	21.80	18.60	10.40	17.13	23.33	22.53	25.00	24.93	26.00	23.47	14.89
Single- item	layers	31.93	10.13	20.73	1.00	20.07	99.53	39.20	74.13	7.33	13.00	7.07	18.67	15.40	12.47	23.60	30.27	2.60	17.73	23.00	28.67	26.13	32.47	14.00	21.00	24.59
ır	Avg	0.85	0.76	0.76	0.79	0.83	0.87	0.87	0.82	0.82	0.81	0.85	0.83	0.82	0.81	0.85	0.84	0.83	0.83	0.84	0.85	0.81	0.81	0.87	0.81	0.83
2D fill factor	Max	96.0	0.85	0.92	0.91	0.93	0.98	0.95	0.97	0.94	0.92	0.95	0.96	0.95	0.98	0.95	0.95	0.95	0.98	0.96	0.97	0.96	0.96	0.97	0.95	0.95
2D	Min	0.57	0.53	0.53	0.68	0.38	0.67	0.68	0.41	0.53	0.51	0.63	0.43	0.17	0.27	0.65	0.26	0.55	0.58	0.61	0.67	0.37	0.44	0.40	0.57	0.50
50	Avg	08.0	0.42	0.67	0.28	0.61	0.77	0.80	0.76	0.77	0.48	0.53	0.61	0.72	0.55	0.79	0.78	0.42	0.61	0.74	0.73	0.74	0.67	0.73	0.74	99.0
t filling	Max	98.0	0.81	0.79	0.58	0.86	0.88	0.89	0.89	0.85	0.84	0.87	0.87	0.89	0.86	0.87	0.87	0.84	0.88	0.89	0.88	0.88	0.88	0.87	0.87	0.85
Pallet fil	Min	89.0	0.09	0.49	0.13	0.13	0.13	0.42	0.51	0.69	0.10	0.12	0.13	0.50	90.0	0.64	0.66	0.10	0.12	0.48	0.15	0.53	0.14	0.49	0.55	0.34
N. of	layers -	44.93	17.20	29.80	00.9	30.73	107.47	51.40	95.67	16.80	24.07	19.07	42.27	34.40	33.13	48.20	51.87	16.00	39.07	51.33	55.93	55.13	62.27	44.00	48.40	42.71
N. of	pallets	10.00	6.20	6.93	3.00	6.93	29.07	11.60	19.60	4.00	8.00	00.9	11.33	8.00	9.20	10.40	11.20	00.9	10.27	11.33	12.80	11.47	14.27	10.00	10.33	10.33
Instance		01	02	03	04	05	90	20	80	60	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	AVG

Table 6: GREPFULL computational results (individual average).

Ratio	11/27	0.1842	0.1508	0.2459	0.1565	0.2222	0.1478	0.2329	0.2796	0.1667	0.2253	0.1429	0.2000	0.3286	0.2973	0.3478	0.2419	0.1429	0.5000	0.4286	0.5152	0.5000	0.5000	0.4412	0.4286	0.2108
Total local searches	(LS)	1.40	6.67	2.00	00.9	2.00	2.00	1.13	1.73	1.33	2.73	1.00	1.33	1.53	1.47	1.07	1.00	1.00	1.67	1.20	1.13	1.00	1.00	1.00	1.20	1.82
Total it- erations	(II)	7.60	44.20	8.13	38.33	9.00	13.53	4.87	6.20	8.00	12.13	7.00	6.67	4.67	4.93	3.07	4.13	7.00	3.33	2.80	2.20	2.00	2.00	2.27	2.80	8.62
uc	Avg	0.6510	0.5397	0.6895	0.4180	0.6518	0.6044	0.6622	0.6251	0.6342	0.5869	0.6127	0.5978	0.6360	0.6100	0.6577	0.6514	0.5698	0.5725	0.6137	0.5996	0.6305	0.5931	0.6102	0.5920	0.6087
Objective function	Max	0.6546	0.5397	0.6895	0.4180	0.6614	0.6044	0.6652	0.6381	0.6342	0.5869	0.6127	0.6031	0.6471	0.6104	0.6597	0.6514	0.5698	0.5755	0.6226	0.6016	0.6334	0.5966	0.6180	0.6066	0.6125
Object	Min	0.6496	0.5397	0.6895	0.4180	0.6483	0.6044	0.6607	0.6154	0.6342	0.5869	0.6127	0.5833	0.6137	0.6044	0.6302	0.6514	0.5698	0.5626	0.6109	0.5915	0.6294	0.5874	0.5935	0.5876	0.6031
Residual layers	(RL)	2.00	3.00	1.00	3.00	2.00	4.00	2.00	3.60	2.00	3.00	2.00	3.27	2.33	3.00	2.07	2.00	3.00	5.00	4.00	5.00	3.00	5.00	4.07	4.93	3.09
Single- family	layers	16.67	4.07	14.47	2.00	14.40	12.27	28.00	22.67	8.20	9.60	14.53	22.87	17.73	17.87	32.60	29.80	12.80	19.80	30.47	33.13	37.80	36.40	35.20	32.80	21.09
Single- item	layers	25.07	9.93	10.53	1.00	12.60	89.73	19.67	64.07	5.80	10.40	2.47	15.87	12.27	10.20	11.40	18.20	0.20	12.27	14.33	14.93	10.93	15.73	3.73	6.87	16.59
or	Avg	0.87	0.77	0.87	0.79	0.88	0.89	0.00	0.87	0.86	0.85	0.85	0.84	0.88	0.86	0.89	0.87	0.83	0.88	0.88	0.00	0.87	0.88	0.89	0.87	98.0
2D fill factor	Max	96.0	0.87	0.95	0.96	0.94	0.98	0.94	0.96	0.96	0.94	0.96	0.95	0.96	0.98	0.96	0.95	0.95	0.98	0.95	0.96	0.96	0.96	0.96	0.96	0.95
2D	Min	0.67	0.51	0.65	0.35	0.57	0.55	0.50	0.55	0.48	0.61	0.65	0.52	0.43	0.57	0.58	0.60	0.22	0.59	0.67	0.62	0.49	0.55	0.62	0.35	0.54
ъn	Avg	0.80	0.43	0.78	0.21	0.63	0.77	0.83	0.80	0.77	0.54	0.53	0.63	0.72	0.63	0.82	0.79	0.51	0.61	0.78	0.76	0.77	0.71	0.75	0.75	0.68
Pallet filling	Max	0.88	0.79	0.86	0.51	0.87	0.90	0.90	0.90	0.84	0.87	0.83	0.86	0.89	0.89	0.90	0.90	0.81	0.89	0.89	0.91	0.89	0.91	0.00	0.89	98.0
Pall	Min	0.64	0.11	0.65	0.06	0.17	0.10	0.52	0.57	0.70	0.12	0.12	0.13	0.18	0.15	0.70	0.68	0.11	0.12	0.49	0.16	0.53	0.16	0.36	0.41	0.33
N. of	layers	43.73	17.00	26.00	00.9	29.00	106.00	49.67	90.33	16.00	23.00	19.00	42.00	32.33	31.07	46.07	50.00	16.00	37.07	48.80	53.07	51.73	57.13	43.00	44.60	40.78
N. of	ballets	10.00	00.9	00.9	4.00	6.73	29.00	11.00	18.60	4.00	7.00	00.9	11.00	8.00	8.00	10.00	11.00	5.00	10.33	10.73	12.27	11.00	13.53	9.80	10.20	9.97
Instance		01	02	03	04	02	90	20	80	60	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	AVG