## 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, MEPMH and EPFULL, we present the Tables 1–3. In the first three columns the tables report, respectively, the instance identifier, 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 seconds).

For what concerns the GRASP-based algorithms GREP, MGREP and GREP-FULL, we present the Tables 4–6. In these tables, we report the same information as the previous ones, 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 total number of local searches and the total number of iterations.

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Table 1: EPMH computational results (individual average).

pallets 1 11.00 7.00	5	3	0	o	1	100001	5	item	family	layers	Seconds
0 -	layers	Min	Max	Avg	Min	Max	Avg	layers	layers	$(\mathring{\mathrm{RL}})$	
	44.00	0.22	0.85	0.73	0.45	0.98	0.87	31.00	11.00	2.00	0.131
2	17.00	0.09	0.82	0.37	0.58	0.86	0.77	10.00	4.00	3.00	0.013
00	27.00	0.20	0.86	0.66	0.16	0.95	0.84	16.00	9.00	2.00	0.020
00	7.00	0.09	0.50	0.21	0.09	0.96	89.0	1.00	2.00	4.00	800.0
00	30.00	90.0	0.86	0.53	0.27	0.93	0.85	19.00	9.00	2.00	0.029
.00	107.00	0.02	0.88	0.74	0.14	0.98	0.88	98.00	4.00	5.00	0.081
00:	50.00	0.22	0.91	0.70	0.73	0.95	0.89	38.00	10.00	2.00	0.028
00:	91.00	0.24	0.91	0.74	0.56	0.97	0.86	00.69	18.00	4.00	0.043
00:	17.00	0.33	0.77	0.62	0.30	0.95	0.81	8.00	7.00	2.00	0.012
00.	24.00	0.08	0.81	0.42	0.48	0.93	0.82	13.00	7.00	4.00	0.017
.00	20.00	0.09	0.88	0.40	0.27	0.96	0.81	00.9	11.00	3.00	0.019
00.3	42.00	0.14	0.85	0.57	0.40	0.96	0.84	18.00	20.00	4.00	0.028
00:	34.00	0.56	0.80	0.72	0.27	0.95	0.83	15.00	16.00	3.00	0.016
00.1	33.00	0.04	0.91	0.46	0.19	0.98	0.81	12.00	17.00	4.00	0.025
1.00	47.00	0.58	0.88	0.74	0.66	0.96	0.87	22.00	22.00	3.00	0.024
5.00	51.00	0.52	0.89	0.73	0.22	0.95	0.85	29.00	19.00	3.00	0.023
.00	17.00	0.10	0.72	0.42	0.64	0.95	0.78	4.00	10.00	3.00	0.013
5.00	38.00	0.12	0.00	0.52	0.63	0.98	0.86	16.00	16.00	00.9	0.031
5.00	50.00	0.39	0.86	0.69	0.68	0.95	0.86	21.00	24.00	5.00	0.025
4.00	55.00	0.14	0.89	0.67	0.05	0.98	0.86	26.00	23.00	00.9	0.029
5.00	54.00	0.45	0.86	0.71	0.18	0.96	0.83	24.00	26.00	4.00	0.025
9.00	59.00	0.10	0.88	0.60	0.20	0.97	0.85	28.00	25.00	00.9	0.029
00.	44.00	0.30	0.86	0.67	0.40	0.97	0.87	14.00	26.00	4.00	0.022
00.	47.00	0.22	0.87	0.64	0.08	0.97	0.83	16.00	26.00	2.00	0.021
11.29	41.88	0.22	0.84	0.59	0.36	96.0	0.83	23.08	15.08	3.71	0.030

Table 2: MEPMH computational results (individual average).

pallets     layers     Min     Max     Avg     Min     Max     Avg     Min     Max     Avg     Min     May     May     Min     May     Min     May     Min     Min     May     Min	00404040	N. of	N. of	Pa	Pallet filling	ng	2D	fill factor	or	Single-	Single-	Residual	Coconda
44.00     0.63     0.91     0.80     0.45     0.98     0.87     31.00       17.00     0.11     0.78     0.43     0.58     0.86     0.77     10.00       27.00     0.055     0.89     0.78     0.16     0.95     0.84     16.00       30.00     0.011     0.86     0.60     0.27     0.93     0.85     19.00       107.00     0.011     0.86     0.60     0.27     0.93     0.88     19.00       107.00     0.020     0.92     0.74     0.93     0.88     198.00       50.00     0.50     0.91     0.84     0.74     0.95     0.89     98.00       17.00     0.71     0.84     0.74     0.95     0.89     98.00       24.00     0.07     0.78     0.78     0.96     0.81     8.00       24.00     0.10     0.78     0.53     0.27     0.96     0.81     15.00       24.00     0.11     0.89     0.63     0.48     0.	rance	pallets	layers	Min	Max	Avg	Min	Max	Avg	layers	laminy layers	(RL)	Seconds
17.00     0.11     0.78     0.43     0.58     0.86     0.77     10.00       27.00     0.65     0.89     0.78     0.16     0.95     0.84     16.00       7.00     0.09     0.50     0.21     0.09     0.96     0.88     1.00       30.00     0.011     0.86     0.60     0.27     0.93     0.88     1.00       107.00     0.02     0.92     0.74     0.14     0.98     0.88     19.00       107.00     0.02     0.92     0.74     0.14     0.98     0.88     19.00       17.00     0.71     0.84     0.77     0.95     0.89     0.89     0.80       24.00     0.71     0.84     0.77     0.96     0.81     8.00       20.00     0.10     0.78     0.56     0.95     0.81     18.00       24.00     0.80     0.86     0.48     0.48     0.95     0.81     15.00       24.00     0.14     0.89     0.63     0.40	01	10.00	44.00	0.63	0.91	08.0	0.45	0.98	0.87	31.00	11.00	2.00	0.203
27.00     0.65     0.89     0.78     0.16     0.95     0.84     16.00       7.00     0.09     0.50     0.21     0.09     0.96     0.68     1.00       30.00     0.11     0.86     0.60     0.27     0.93     0.85     19.00       107.00     0.11     0.86     0.69     0.95     0.88     19.00       50.00     0.50     0.91     0.83     0.73     0.95     0.89     38.00       17.00     0.71     0.84     0.77     0.30     0.95     0.89     38.00       24.00     0.08     0.86     0.48     0.48     0.93     0.82     13.00       24.00     0.10     0.78     0.78     0.74     0.96     0.81     8.00       20.00     0.10     0.78     0.53     0.27     0.96     0.81     18.00       47.00     0.14     0.89     0.63     0.40     0.96     0.81     15.00       33.00     0.04     0.86     0.50	02	00.9	17.00	0.11	0.78	0.43	0.58	0.86	0.77	10.00	4.00	3.00	0.076
7.00     0.09     0.50     0.21     0.09     0.68     1.00       30.00     0.11     0.86     0.60     0.27     0.93     0.85     19.00       107.00     0.01     0.86     0.60     0.27     0.93     0.85     19.00       107.00     0.020     0.91     0.83     0.73     0.95     0.89     38.00       17.00     0.47     0.93     0.78     0.56     0.97     0.89     98.00       24.00     0.04     0.84     0.77     0.30     0.95     0.81     13.00       24.00     0.01     0.78     0.78     0.48     0.98     0.80     13.00       24.00     0.14     0.86     0.48     0.48     0.98     0.81     15.00       47.00     0.14     0.86     0.56     0.19     0.98     0.81     15.00       47.00     0.72     0.89     0.72     0.27     0.98     0.81     15.00       51.00     0.68     0.88     0.79 <td>03</td> <td>00.9</td> <td>27.00</td> <td>0.65</td> <td>0.89</td> <td>0.78</td> <td>0.16</td> <td>0.95</td> <td>0.84</td> <td>16.00</td> <td>9.00</td> <td>2.00</td> <td>0.041</td>	03	00.9	27.00	0.65	0.89	0.78	0.16	0.95	0.84	16.00	9.00	2.00	0.041
30.00     0.11     0.86     0.60     0.27     0.93     0.85     19.00       107.00     0.02     0.92     0.74     0.14     0.98     0.88     98.00       50.00     0.50     0.91     0.83     0.73     0.95     0.89     38.00       91.00     0.47     0.93     0.73     0.95     0.89     38.00       17.00     0.71     0.84     0.77     0.30     0.95     0.81     8.00       24.00     0.01     0.78     0.78     0.48     0.93     0.82     13.00       20.00     0.10     0.78     0.78     0.95     0.81     18.00       20.00     0.10     0.78     0.73     0.96     0.81     18.00       34.00     0.27     0.89     0.72     0.27     0.98     0.81     15.00       47.00     0.72     0.89     0.72     0.96     0.81     15.00       51.00     0.68     0.88     0.79     0.22     0.95     0.82 <td>04</td> <td>4.00</td> <td>7.00</td> <td>0.09</td> <td>0.50</td> <td>0.21</td> <td>0.00</td> <td>96.0</td> <td>89.0</td> <td>1.00</td> <td>2.00</td> <td>4.00</td> <td>0.010</td>	04	4.00	7.00	0.09	0.50	0.21	0.00	96.0	89.0	1.00	2.00	4.00	0.010
107.00     0.02     0.92     0.74     0.14     0.98     0.88     98.00       50.00     0.50     0.91     0.83     0.73     0.95     0.89     38.00       91.00     0.47     0.93     0.78     0.56     0.97     0.86     69.00       17.00     0.71     0.84     0.77     0.30     0.95     0.81     8.00       24.00     0.10     0.78     0.78     0.78     0.95     0.81     18.00       20.00     0.11     0.86     0.48     0.48     0.99     0.81     18.00       34.00     0.14     0.89     0.72     0.96     0.81     18.00       47.00     0.72     0.89     0.82     0.66     0.86     0.81     15.00       47.00     0.72     0.89     0.82     0.66     0.96     0.81     15.00       51.00     0.68     0.88     0.79     0.22     0.95     0.85     29.00       17.00     0.68     0.88     0.79 <td>05</td> <td>7.00</td> <td>30.00</td> <td>0.11</td> <td>0.86</td> <td>09.0</td> <td>0.27</td> <td>0.93</td> <td>0.85</td> <td>19.00</td> <td>9.00</td> <td>2.00</td> <td>0.137</td>	05	7.00	30.00	0.11	0.86	09.0	0.27	0.93	0.85	19.00	9.00	2.00	0.137
50.00     0.50     0.91     0.83     0.73     0.95     0.89     38.00       91.00     0.47     0.93     0.78     0.56     0.97     0.86     69.00       17.00     0.71     0.84     0.77     0.30     0.95     0.81     8.00       24.00     0.08     0.86     0.48     0.48     0.93     0.82     13.00       20.00     0.14     0.89     0.53     0.27     0.96     0.84     18.00       42.00     0.14     0.89     0.72     0.96     0.84     18.00       33.00     0.04     0.89     0.72     0.96     0.84     18.00       47.00     0.72     0.89     0.72     0.99     0.81     15.00       47.00     0.72     0.89     0.82     0.66     0.96     0.81     15.00       51.00     0.68     0.88     0.79     0.22     0.95     0.85     25.00       17.00     0.08     0.77     0.42     0.64     0.95	90	30.00	107.00	0.02	0.92	0.74	0.14	0.98	0.88	98.00	4.00	5.00	30.123
91.00     0.47     0.93     0.78     0.56     0.97     0.86     69.00       17.00     0.71     0.84     0.77     0.30     0.95     0.81     8.00       24.00     0.08     0.86     0.48     0.48     0.93     0.82     13.00       20.00     0.10     0.78     0.53     0.27     0.96     0.81     18.00       34.00     0.27     0.89     0.62     0.84     18.02     18.00       33.00     0.04     0.89     0.72     0.96     0.81     15.00       47.00     0.72     0.89     0.82     0.66     0.86     0.81     15.00       51.00     0.68     0.88     0.79     0.22     0.95     0.85     29.00       17.00     0.68     0.88     0.79     0.22     0.95     0.85     16.00       50.00     0.12     0.90     0.57     0.64     0.95     0.78     4.00       38.00     0.14     0.91     0.72     0.63	20	11.00	50.00	0.50	0.91	0.83	0.73	0.95	0.89	38.00	10.00	2.00	0.171
17.00     0.71     0.84     0.77     0.30     0.95     0.81     8.00       24.00     0.08     0.86     0.48     0.48     0.93     0.82     13.00       20.00     0.10     0.78     0.53     0.27     0.96     0.81     16.00       42.00     0.14     0.89     0.63     0.40     0.96     0.84     18.00       34.00     0.27     0.89     0.72     0.95     0.83     15.00       47.00     0.72     0.82     0.09     0.81     12.00       47.00     0.72     0.82     0.96     0.81     12.00       51.00     0.68     0.88     0.79     0.22     0.95     0.85     22.00       17.00     0.68     0.88     0.79     0.22     0.95     0.85     22.00       17.00     0.08     0.77     0.42     0.64     0.95     0.78     4.00       38.00     0.12     0.90     0.57     0.63     0.98     0.86     16.00	80	19.00	91.00	0.47	0.93	0.78	0.56	0.97	0.86	00.69	18.00	4.00	4.105
24.00     0.08     0.86     0.48     0.48     0.93     0.82     13.00       20.00     0.10     0.78     0.53     0.27     0.96     0.81     6.00       42.00     0.14     0.89     0.63     0.40     0.96     0.84     18.00       33.00     0.27     0.89     0.72     0.95     0.81     15.00       47.00     0.72     0.86     0.56     0.19     0.98     0.81     15.00       51.00     0.68     0.77     0.42     0.64     0.95     0.85     22.00       17.00     0.08     0.77     0.42     0.64     0.95     0.78     4.00       38.00     0.12     0.90     0.57     0.63     0.98     0.86     16.00       50.00     0.62     0.91     0.76     0.68     0.95     0.86     21.00       55.00     0.14     0.91     0.77     0.18     0.96     0.83     24.00       59.00     0.10     0.89     0.64	60	4.00	17.00	0.71	0.84	0.77	0.30	0.95	0.81	8.00	7.00	2.00	0.021
20.00     0.10     0.78     0.53     0.27     0.96     0.81     6.00       42.00     0.14     0.89     0.63     0.40     0.96     0.84     18.00       34.00     0.27     0.89     0.72     0.27     0.95     0.83     15.00       33.00     0.72     0.86     0.19     0.98     0.81     12.00       47.00     0.72     0.82     0.66     0.96     0.87     22.00       51.00     0.68     0.77     0.42     0.64     0.95     0.85     29.00       17.00     0.08     0.77     0.42     0.64     0.95     0.86     16.00       38.00     0.12     0.90     0.57     0.63     0.98     0.86     16.00       50.00     0.62     0.91     0.76     0.68     0.95     0.86     21.00       55.00     0.14     0.91     0.77     0.18     0.96     0.83     24.00       59.00     0.10     0.89     0.64     0.20	10	8.00	24.00	0.08	0.86	0.48	0.48	0.93	0.82	13.00	7.00	4.00	0.292
42.00     0.14     0.89     0.63     0.40     0.96     0.84     18.00       34.00     0.27     0.89     0.72     0.27     0.95     0.83     15.00       33.00     0.04     0.86     0.56     0.19     0.98     0.81     15.00       47.00     0.72     0.89     0.82     0.66     0.96     0.87     22.00       51.00     0.68     0.88     0.79     0.22     0.95     0.85     29.00       17.00     0.08     0.77     0.42     0.64     0.95     0.88     16.00       38.00     0.12     0.90     0.57     0.63     0.98     0.86     16.00       50.00     0.62     0.91     0.76     0.98     0.86     20.00       55.00     0.14     0.91     0.77     0.18     0.96     0.83     24.00       59.00     0.10     0.89     0.64     0.20     0.97     0.85     28.00       44.00     0.49     0.87     0.73 <td>11</td> <td>00.9</td> <td>20.00</td> <td>0.10</td> <td>0.78</td> <td>0.53</td> <td>0.27</td> <td>96.0</td> <td>0.81</td> <td>00.9</td> <td>11.00</td> <td>3.00</td> <td>0.060</td>	11	00.9	20.00	0.10	0.78	0.53	0.27	96.0	0.81	00.9	11.00	3.00	0.060
34.00     0.27     0.89     0.72     0.27     0.95     0.83     15.00       33.00     0.04     0.86     0.56     0.19     0.98     0.81     15.00       47.00     0.72     0.89     0.82     0.66     0.96     0.87     22.00       51.00     0.68     0.88     0.79     0.22     0.95     0.85     29.00       17.00     0.08     0.77     0.42     0.64     0.95     0.85     29.00       17.00     0.08     0.77     0.42     0.64     0.95     0.86     16.00       50.00     0.12     0.90     0.57     0.63     0.98     0.86     16.00       50.00     0.14     0.91     0.76     0.98     0.86     26.00       50.00     0.14     0.91     0.77     0.18     0.96     0.83     24.00       50.00     0.10     0.89     0.64     0.20     0.97     0.87     14.00       47.00     0.11     0.89     0.66 <td>12</td> <td>11.00</td> <td>42.00</td> <td>0.14</td> <td>0.89</td> <td>0.63</td> <td>0.40</td> <td>0.96</td> <td>0.84</td> <td>18.00</td> <td>20.00</td> <td>4.00</td> <td>0.965</td>	12	11.00	42.00	0.14	0.89	0.63	0.40	0.96	0.84	18.00	20.00	4.00	0.965
33.00     0.04     0.86     0.56     0.19     0.98     0.81     12.00       47.00     0.72     0.89     0.82     0.66     0.96     0.87     22.00       51.00     0.68     0.88     0.79     0.22     0.95     0.85     29.00       17.00     0.08     0.77     0.42     0.64     0.95     0.78     4.00       38.00     0.12     0.90     0.57     0.63     0.98     0.86     16.00       50.00     0.62     0.91     0.76     0.68     0.95     0.86     26.00       55.00     0.14     0.91     0.77     0.18     0.96     0.83     24.00       59.00     0.10     0.89     0.64     0.20     0.97     0.85     28.00       44.00     0.49     0.87     0.73     0.09     0.97     0.87     14.00       41.88     0.37     0.86     0.66     0.96     0.83     16.00	13	8.00	34.00	0.27	0.89	0.72	0.27	0.95	0.83	15.00	16.00	3.00	8.782
47.00     0.72     0.89     0.82     0.66     0.96     0.87     22.00       51.00     0.68     0.88     0.79     0.22     0.95     0.85     29.00       17.00     0.08     0.77     0.42     0.64     0.95     0.78     4.00       38.00     0.12     0.90     0.57     0.63     0.98     0.86     16.00       50.00     0.62     0.91     0.76     0.68     0.95     0.86     20.00       55.00     0.14     0.91     0.77     0.18     0.96     0.83     24.00       59.00     0.10     0.89     0.64     0.20     0.97     0.85     28.00       44.00     0.49     0.87     0.73     0.09     0.97     0.87     14.00       47.00     0.11     0.89     0.66     0.08     0.97     0.83     16.00       41.88     0.37     0.86     0.66     0.83     0.96     0.83     16.00	14	9.00	33.00	0.04	0.86	0.56	0.19	0.98	0.81	12.00	17.00	4.00	1.417
51.00     0.68     0.88     0.79     0.22     0.95     0.85     29.00       17.00     0.08     0.77     0.42     0.64     0.95     0.78     4.00       38.00     0.12     0.90     0.57     0.63     0.98     0.86     16.00       50.00     0.62     0.91     0.76     0.68     0.95     0.86     21.00       55.00     0.14     0.91     0.77     0.18     0.96     0.83     24.00       59.00     0.10     0.89     0.64     0.20     0.97     0.85     28.00       44.00     0.49     0.87     0.73     0.09     0.85     14.00       47.00     0.11     0.87     0.66     0.08     0.97     0.83     16.00       41.88     0.37     0.86     0.66     0.86     0.86     0.83     16.00	15	10.00	47.00	0.72	0.89	0.82	0.66	0.96	0.87	22.00	22.00	3.00	0.101
17.00 0.08 0.77 0.42 0.64 0.95 0.78 4.00   38.00 0.12 0.90 0.57 0.63 0.98 0.86 16.00   50.00 0.62 0.91 0.76 0.68 0.95 0.86 21.00   55.00 0.14 0.91 0.77 0.05 0.98 0.86 26.00   54.00 0.62 0.91 0.77 0.18 0.96 0.83 24.00   59.00 0.10 0.89 0.64 0.20 0.97 0.85 28.00   44.00 0.49 0.87 0.73 0.40 0.97 0.87 14.00   47.00 0.11 0.87 0.66 0.08 0.96 0.83 16.00   41.88 0.32 0.86 0.66 0.86 0.87 23.08	16	11.00	51.00	0.68	0.88	0.79	0.22	0.95	0.85	29.00	19.00	3.00	0.154
38.00 0.12 0.90 0.57 0.63 0.98 0.86 16.00 50.00 0.62 0.91 0.76 0.68 0.95 0.86 21.00 55.00 0.14 0.91 0.72 0.05 0.98 0.86 21.00 54.00 0.62 0.91 0.77 0.18 0.96 0.83 24.00 59.00 0.10 0.89 0.64 0.20 0.97 0.85 28.00 44.00 0.49 0.87 0.73 0.40 0.97 0.87 14.00 47.00 0.11 0.87 0.66 0.08 0.97 0.83 16.00 41.88 0.37 0.86 0.66 0.83 0.96 0.83 0.97 0.85	17	00.9	17.00	0.08	0.77	0.42	0.64	0.95	0.78	4.00	10.00	3.00	0.073
50.00     0.62     0.91     0.76     0.68     0.95     0.86     21.00       55.00     0.14     0.91     0.72     0.05     0.98     0.86     26.00       54.00     0.62     0.91     0.77     0.18     0.96     0.83     24.00       59.00     0.10     0.89     0.64     0.20     0.97     0.85     28.00       44.00     0.49     0.87     0.73     0.40     0.97     0.87     14.00       47.00     0.11     0.87     0.69     0.08     0.97     0.83     16.00       41.88     0.32     0.86     0.66     0.83     0.97     0.83     16.00	18	11.00	38.00	0.12	0.00	0.57	0.63	0.98	0.86	16.00	16.00	00.9	5.749
55.00 0.14 0.91 0.72 0.05 0.98 0.86 26.00 54.00 0.62 0.91 0.77 0.18 0.96 0.83 24.00 59.00 0.10 0.89 0.64 0.20 0.97 0.85 28.00 44.00 0.49 0.87 0.73 0.40 0.97 0.87 14.00 47.00 0.11 0.87 0.69 0.08 0.97 0.83 16.00	19	11.00	50.00	0.62	0.91	0.76	0.68	0.95	0.86	21.00	24.00	5.00	0.119
54.00 0.62 0.91 0.77 0.18 0.96 0.83 24.00 59.00 0.10 0.89 0.64 0.20 0.97 0.85 28.00 44.00 0.49 0.87 0.73 0.40 0.97 0.87 14.00 47.00 0.11 0.87 0.69 0.08 0.97 0.83 16.00 41.88 0.37 0.86 0.66 0.36 0.96 0.83 23.08	20	13.00	55.00	0.14	0.91	0.72	0.05	0.98	0.86	26.00	23.00	00.9	30.039
59.00 0.10 0.89 0.64 0.20 0.97 0.85 28.00 44.00 0.49 0.87 0.73 0.40 0.97 0.87 14.00 47.00 0.11 0.87 0.69 0.08 0.97 0.83 16.00 41.88 0.32 0.86 0.66 0.36 0.96 0.83 23.08	21	11.00	54.00	0.62	0.91	0.77	0.18	0.96	0.83	24.00	26.00	4.00	2.431
44.00     0.49     0.87     0.73     0.40     0.97     0.87     14.00       47.00     0.11     0.87     0.69     0.08     0.97     0.83     16.00       41.88     0.37     0.86     0.66     0.36     0.96     0.83     23.08	22	15.00	59.00	0.10	0.89	0.64	0.20	0.97	0.85	28.00	25.00	00.9	1.866
47.00 0.11 0.87 0.69 0.08 0.97 0.83 16.00 41.88 0.32 0.86 0.66 0.36 0.96 0.83 23.08	23	10.00	44.00	0.49	0.87	0.73	0.40	0.97	0.87	14.00	26.00	4.00	0.788
4188 032 086 066 036 096 083	24	11.00	47.00	0.11	0.87	0.69	0.08	0.97	0.83	16.00	26.00	5.00	0.945
00:0	4VG	10.33	41.88	0.32	98.0	99.0	0.36	96.0	0.83	23.08	15.08	3.71	3.694

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Table 3: EPFULL computational results (individual average).

01 10.00 02 6.00 03 6.00 04 4.00 05 7.00 06 29.00 07 11.00 08 19.00 09 4.00	-	SVers							111001			2000
01 10.0 02 6.00 03 6.00 04 4.00 05 7.00 06 29.0 07 11.0 08 19.1 09 4.00			Min	Max	Avg	Min	Max	Avg	layers	layers	(RL)	
02 6.00 03 6.00 04 4.00 05 7.00 06 29.0 07 11.0 08 19.0		15.00	0.64	0.86	08.0	0.10	0.95	0.85	19.00	23.00	3.00	132.036
03 6.00 04 4.00 05 7.00 06 29.C 07 11.C 08 19.C		12.00	0.09	0.82	0.43	0.58	0.86	0.77	10.00	4.00	3.00	19.650
04 4.00 05 7.00 06 29.C 07 11.C 08 19.C		56.00	0.61	0.84	0.78	0.68	0.96	0.87	11.00	14.00	1.00	98.174
05 7.00 06 29.0 07 11.0 08 19.0 4.0		00.9	0.05	0.51	0.21	0.34	0.96	0.79	1.00	2.00	3.00	22.079
06 29.0 07 11.0 08 19.0 09 4.0		29.00	0.11	0.86	0.60	0.50	0.93	0.88	16.00	11.00	2.00	104.650
07 11.0 08 19.0 09 4.0		00.90	0.09	0.92	0.77	0.50	0.98	0.89	86.00	16.00	4.00	75.327
08 19.0 09 4.0'		50.00	0.51	0.91	0.83	0.35	0.94	0.89	25.00	23.00	2.00	187.334
09 4.0		91.00	0.32	0.90	0.78	0.56	0.95	98.0	61.00	26.00	4.00	205.827
		00.91	0.73	0.81	0.77	0.40	0.96	0.86	00.9	8.00	2.00	107.783
10 8.00		24.00	0.05	0.87	0.48	0.33	0.95	0.82	9.00	11.00	4.00	73.216
11 6.00		19.00	0.10	0.89	0.53	0.57	0.96	0.85	0.00	17.00	2.00	136.216
12 12.C		13.00	0.12	0.87	0.57	0.11	0.95	0.82	17.00	22.00	4.00	134.166
13 9.00		33.00	0.13	0.83	0.64	0.23	0.96	0.86	12.00	18.00	3.00	166.520
14 8.00		32.00	0.09	0.94	0.63	0.44	0.98	0.84	12.00	17.00	3.00	153.528
15 10.0		16.00	0.74	0.90	0.82	0.66	0.96	0.89	13.00	31.00	2.00	247.588
16 11.0		51.00	0.56	0.88	0.79	0.02	0.93	0.85	20.00	28.00	3.00	209.289
17 5.00		16.00	0.09	0.79	0.51	0.31	0.94	0.83	2.00	11.00	3.00	129.711
18 11.0		38.00	0.13	0.87	0.57	0.34	0.98	0.86	13.00	20.00	2.00	193.187
19 11.0		19.00	0.50	0.89	0.76	0.60	0.96	0.88	14.00	31.00	4.00	272.811
20 12.0		53.00	0.17	0.90	0.78	0.73	0.94	0.90	19.00	29.00	5.00	331.439
21 11.0		52.00	0.48	0.91	0.77	0.50	0.96	0.86	13.00	36.00	3.00	325.681
22 13.C		58.00	0.18	0.89	0.74	0.57	0.95	0.87	15.00	38.00	2.00	396.848
23 9.00		13.00	0.74	0.89	0.81	0.71	0.96	0.89	7.00	32.00	4.00	385.965
24 11.0		14.00	0.16	0.92	0.69	0.58	0.95	0.89	00.9	33.00	5.00	328.801
AVG 10.13		41.13	0.31	98.0	29.0	0.45	0.95	98.0	16.96	20.88	3.29	184.909

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