

# Installation Guide

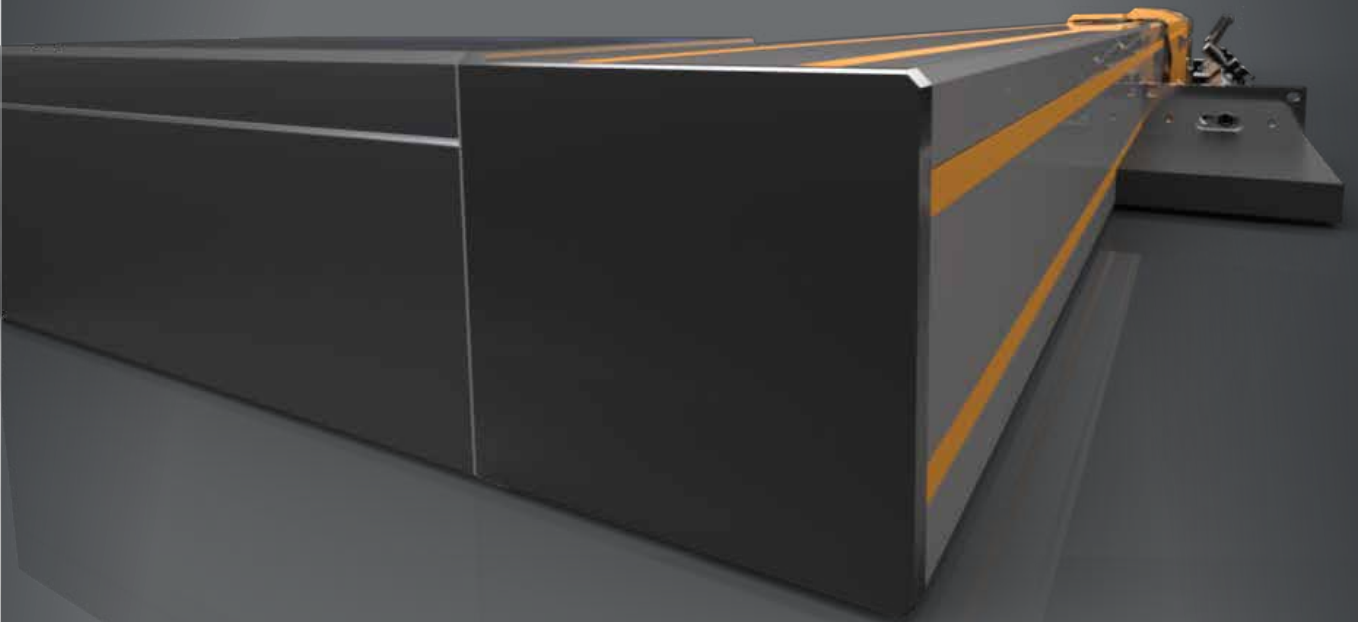
2017 TigerStop, LLC®



**TigerStop®**  
fast and accurate...every time

## Users Guide

Versions 5.00 - 5.60



February 2017 Mk2



# Safety First!

IMPORTANT SAFETY INFORMATION. READ ALL WARNINGS BEFORE OPERATING THIS PRODUCT.



## GENERAL WARNINGS

WARNING: Installation of your TigerStop Product must be done by a person trained in the safe design and installation of automation products, and in the safe operation of power equipment. Ensure that such installation meets all legally required safety requirements and guidelines, and that proper guarding and safety devices are provided on all sides of the equipment to preclude unintended access during operation. Consult with and follow the recommendations of a qualified safety engineer.

WARNING: TigerStop Products are components intended for use in conjunction with potentially dangerous machinery. The use of TigerStop Products does not make other machinery safe. TigerStop Products are not intended to substitute, in any manner, for safe operating practices in general, or for safety features present in other machines designed to make those machines as safe as possible. **TIGERSTOP PRODUCTS, IF USED OR INSTALLED IMPROPERLY, MAY CAUSE PERSONAL INJURY OR DEATH AND SHOULD ONLY BE OPERATED BY PERSONS TRAINED IN THEIR SAFE OPERATING PROCEDURES.** Illustrations of TigerStop Products in use do not show, and are not intended to show, all safety features and practices necessary for their safe operation.



## INSTALLATION WARNINGS

WARNING: TigerStop Products must be installed in accordance with all local, state, and federal regulations. Only personnel properly trained in the safe design and installation of automation machinery and related power equipment should install TigerStop Products onto other equipment, to ensure a safe and proper work station. TigerStop Products should not be operated without proper training, both in the operation of TigerStop Products, and in the operation of related equipment.

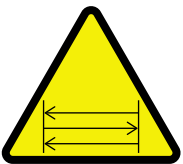
### IMPORTANT CAUTION:

The motor box (compartment) contains DC voltage with potentially FATAL amperage. NEVER attempt any unauthorized actions inside the motor box.



## INTERCONNECTS

WARNING: Using a TigerStop interconnect does not relieve you of the responsibility for making sure that your saw or other tool has all the necessary safety equipment in place. All installations must meet all legally required safety requirements and guidelines. Installation and training should be done following the recommendations of a qualified safety engineer.



## OPERATION

DANGER: This machine can start, move and stop automatically. Keep hands and loose clothing clear of moving parts while operating. Moving parts can crush and cut. When used with a saw or other cutting equipment, bodily injury and death may result if operated without safety guards on all machines. Do not operate with guards removed. Operators must wear adequate eye and ear protection.

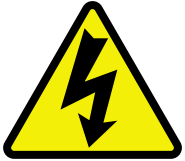


DANGER! Don't get pinched by the push feeder. Keep your hands away when in motion!

**IMPORTANT SAFETY INFORMATION. READ ALL WARNINGS BEFORE OPERATING THIS PRODUCT.**



Keep the work area clean and well lighted to avoid accidental injury.



Do not use TigerStop machines in a dangerous environment. Using power tools in damp or wet locations or in rain can cause shock or electrocution.



Do not operate near flammable liquids or in gaseous or explosive atmospheres!



Wear proper apparel, no loose clothes, long hair or jewelry which could get pulled into moving machinery or materials.  
Wear non slip footwear, safety glasses, ear protection and a dust mask.



Use only 3- wire extension cords that have 3-prong grounding type plugs and 3-pole receptacles that accept the tools plug for 120VAC. Use only 5-wire cords and plugs when using 3 phase.



Do not open motor compartment or controller keypad. DC Voltage with potentially FATAL amperage!  
Disconnect power before servicing. No user-serviceable parts inside.

DO NOT operate this or any machine under the influence of drugs or alcohol!



No one should operate this machine except for fully qualified personnel.  
Read the manual!



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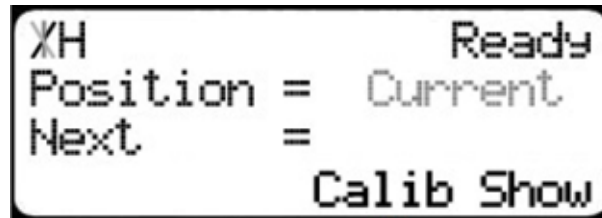
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# The Home Routine

## Home Routine Explained

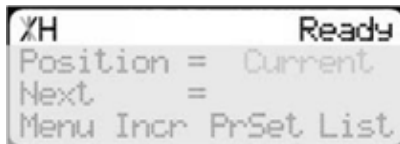
Every time TigerStop is powered up, it performs the 'Home Routine'. The Home Routine is a 3 step process where TigerStop will move to its farthest possible position.

1. Press **START** to run the Home Routine.
2. When movement stops, TigerStop will display the Ready Screen.



```
%H Ready
Position = Current
Next =
Calib Show
```

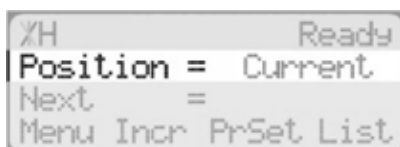
The Ready Screen is the starting point for all TigerStop functions. Let's take a look at the screen.



```
%H Ready
Position = Current
Next =
Menu Incr PrSet List
```

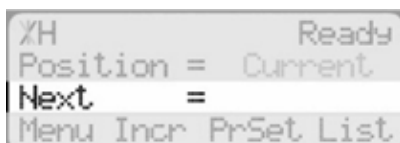
Line 1 displays the "heartbeat". The heartbeat is a line that rotates and lets you know that TigerStop is functioning normally. The letter next to the heartbeat is the drive indicator. This tells you what the motor is doing.

Drive Indicator	Meaning
H	Holding Still
A	Accelerating
C	Moving at Constant Speed
D	Decelerating
W	Waiting
S	Stopping
T	Waiting for Text Entry
X	E-stop Error
N	Communication Error



```
%H Ready
Position = Current
Next =
Menu Incr PrSet List
```

Line 2 shows the current position of TigerStop. The position will show with 'in' when in inches mode and 'mm' when in metric mode.



```
%H Ready
Position = Current
Next =
Menu Incr PrSet List
```

Line 3 shows the next position of TigerStop. This is where user input is shown.

```

XH          Ready
Position =   Current
Next       =
Menu Incr PrSet List

```

Line 4 displays the soft key prompts. These prompts tell you what the soft key button below it does. These can change when you access different screens.

# Basic TigerStop Functions

## Manual Movement

To manually move TigerStop to a position, enter the length you want TigerStop to move to on the keypad. This length can be entered as a decimal or a fractional value.

### Entering Decimals

```

XH          Ready
Position =   Current
Next       =
Calib Show

```

1. Start at the Ready Screen.

```

XH          Ready
Position =   Current
Next       = 24.5
Calib Show

```

2. Enter a length at the controller.

Example: To enter 24 1/2 as a decimal, enter **2 4 . 5**.

3. Press **START** to move TigerStop.

### Entering Fractions

```

XH          Ready
Position =   Current
Next       =
Calib Show

```

1. Start at the Ready Screen.

```

XH          Ready
Position =   Current
Next       = 24 1/2
Calib Show

```

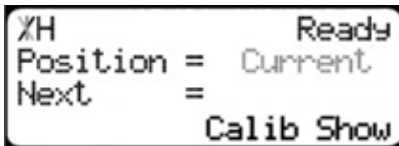
2. Enter a length at the controller.

Example: To enter 24 1/2 as a fraction, enter **2 4 [Frac] 1 [Frac] 2**.

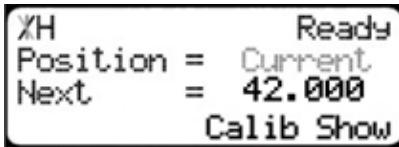
3. Then press **START** to move TigerStop.  
Notice that even though you entered a fraction, TigerStop will display the position as a decimal once it has moved. TigerStop cannot display fractions in the 'Position' field.

## Calculator Mode

TigerStop has a calculator function that can be used to do simple math problems.



1. Start at the Ready Screen.



2. Just like a normal calculator, you can use the math function keys to enter math problems.

Example: I want to add 12 inches to 30 inches.

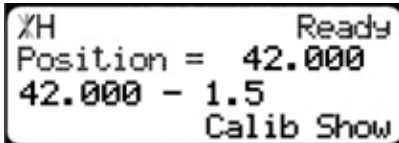
3. Press **1** **2** **+** **3** **0** **=**.

The answer will appear in the 'Next' field.

4. Press **START** and TigerStop will move to the calculated position.

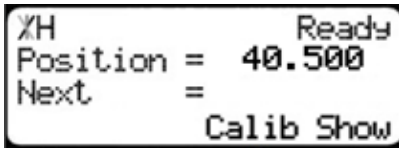
You can also do math functions on the current position.

Example: I want to subtract 1.5 inches from my current position of 42 inches.



1. Press **-** **1** **.** **5** **=**.

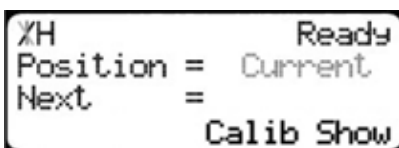
The answer will appear in the 'Next' field.





2. Press **START** and TigerStop will move.

## Jog

TigerStop can be manually jogged in or out. When activated, TigerStop will move until you let go of the jog button. It will then glide to a gentle stop.



1. Start at the Ready Screen.

2. At the top of the TigerStop controller, you have a  and a . To jog, press and hold one of these buttons.

Note: If the jog buttons move TigerStop in the wrong direction, you can use the 'Jog Reverse' setting in the 'Setup' menu to reverse the movement. See "Jog Reverse" on page 20.

## Increment

The increment function is a push feed mode used to step TigerStop through a series of movements.

Increment...

- Can be a positive value that will move TigerStop towards the tool.
- Can be a negative value that will move TigerStop away from the tool.
- Will compensate for kerf automatically using the 'Kerf' setting in the 'Setup' menu.
- Can only store one increment value at a time.

```

XH          Ready
Position =  Current
Next      =
          Calib Show

```

```

XH          Ready
Position =  Current
Next      =
Menu Incr PrSet List

```

```

TH      Enter  Incr
Position = 42.000
Incr Size=

```

```

\H      Incr Move Incr
Position = 42.000in
Next      = 38.875in
Incr Size= 2.000in

```

```

XH          Ready
Position =  Current
Next      =
Menu Incr PrSet List

```


1. Start at the Ready Screen.

2. Press the [Show] soft key to display more options.


3. A new set of options have appeared. Press the [Incr] soft key to access the Increment menu.

4. Enter the size you want to increment and press .  
For this example, I am going to use an increment of 2 inches.

5. The current position is 42. If that is where you want to start,

press  to begin incrementing. If you need to move TigerStop to

load your stock, enter the position and press .

TigerStop will move to position. Load your stock and press  to begin incrementing.

6. When you are finished, press  to return to the Ready Screen.

## PreSet

The PreSet function is a set of 100 programmable hot keys used to quickly access common lengths. PreSets...

- Can be used in Set Point, Pusher or Increment mode.
- Can be programed in PreSet slots number 1 - 100.

Note: PreSet functionality can be changed using the 'PreSet' setting in the Part List menu.

## PreSet Programming

```

XH          Ready
Position =  Current
Next      =
          Calib Show

```

```

XH          Ready
Position =  Current
Next      =
Menu Incr PrSet List

```

```

TH      Enter  PrSet
Pre-Set#
Press START to move.
View Edit Clear

```

1. From the Ready Screen, press the [Show] soft key to show the menu options.

2. A new set of soft key options have appeared. Press the [PrSet] soft key to access the PreSet feature.

3. Enter the number of the preset you want to program and press the [Edit] soft key.

For this example, I am going to program PreSet number 1.

```


TH  <Edit 1> PrSet
Pre-Set = Empty
New Value=15 15/16
View Clear

```

```

XH  <Edit 1> PrSet
Pre-Set = 15.937in
New Value=
View Clear

```

4. Enter the length you want the PreSet to move TigerStop to, and press .

For this example, I want to move to 15 15/16 inches.

5. The PreSet value is now set.

6. Press  to go back to the Ready Screen.

## Using PreSets

```

XH  Ready
Position = Current
Next =
Menu Incr PrSet List

```

```

TH  Enter PrSet
Pre-Set#
Press START to move.
View Edit Clear

```

```

XH  Ready
Position = 15.937
Next =
Menu Incr PrSet List

```

1. Start at the Ready Screen.

2. Press the [PrSet] soft key to access the PreSet menu.

3. Enter the PreSet number you wish to use and press .

4. TigerStop will move to the PreSet position.

## Deleting PreSets

```

XH  Ready
Position = Current
Next =
Menu Incr PrSet List

```

```

TH  Enter PrSet
Pre-Set#
Press START to move.
View Edit Clear

```

```

XH  <Clear 1> PrSet
Pre-Set = 15.937in
Press OK to clear.
View Edit

```

1. Start at the Ready Screen.

2. Press the [PrSet] soft key to access the PreSet menu.

3. Enter the PreSet number you wish to delete and press the [Clear] soft key.

4. Press  to clear.

5. TigerStop has now deleted the PreSet.

## Quick Calibration

Quick Calibration is a shortcut to the calibration setting. This allows advanced TigerStop users to quickly calibrate TigerStop. This option can be disabled from the Options menu.

```

XH  Ready
Position = Current
Next =
Calib Show

```

1. Start at the Ready Screen.

Note: if you viewing the expanded options, press .

```

%H    Calib    Ready
Enter distance
from zero=
                                     Done

```

2. Measure how far the TigerStop is from your tool's zero point. Enter this measurement and press the [Done] soft key.
3. TigerStop is now calibrated.

# TigerStop Menus

The TigerStop menu screen is the gateway to all TigerStop settings. The menu screen is password protected. Most critical settings are double password protected.

## Accessing TigerStop Menus

```

%H                                Ready
Position = Current
Next      =
                                     Calib Show

```

1. Start at the Ready Screen. Press the [Show] soft key to display more options.

```

%H                                Ready
Position = Current
Next      =
Menu Incr PrSet List


```

2. Press the [Menu] soft key to access the menu select screen.

```

%H                                Menu
Password =

```

3. TigerStop requires a password to access the menu screen. Enter your TigerStop password and press .

*Note: By default, the TigerStop password is set to the serial number.*

TigerStop will display the menu select screen.

```

%H  < Select > Menu
A-Setup  C-Options
B-Offset D-PartList
A      B      C      D

```

```



%H  < Select > Menu
A-Motion C-SysInfo
B-Timer  D-Laser
A      B      C      D

```

```

%H  Select      Menu
A-Debus
< A                                     >

```

TigerStop has 9 menus spanning 3 menu select screens. You can scroll through the menu options by pressing  or . Each menu name tells you what kind of settings are in the menu.

**Setup Menu** - Settings that control TigerStop calibration and installation.

**Offset Menu** - Allows you to set an offset.

**Options Menu** - Settings that control optional accessories or processes.

**Part List Menu** - Contains settings that control how part lists work.

**System Info Menu** - Overall system settings.

**Laser Menu** - Settings that control laser defecting upgrades.

**Motion Menu** - Contains settings that control how TigerStop moves.

**Timer Menu** - Contains Timers that control how Interconnect Kits work.

**Debug Menu** - Contains tools that TigerStop Customer Service uses to troubleshoot issues.

# Parameter Default Values

Menu	Parameter	SW Version	TigerStop	TigerFence/ TigerCrossCut	TigerTurbo	HeavyDuty 2	TigerRack
Setup Menu	Calibrate	5.00	Set by user when installed				
	CrossCut	5.00	N/A	60.000 TigerCrossCut Only	N/A	N/A	N/A
	Home Routine	5.50	This is a routine. See page # for details.				
	Kerf	5.00	.125				
	Find Limit	5.00	This is a routine. See page 18 for details.				
	Auto Setup	5.00	This is a routine. See page 18 for details.				
	Minimum Limit	5.00	Default values are related to the machine working length and are set automatically by running the Find Limit or Auto Setup routines.				
	Maximum Limit	5.00					
	Scale	5.00	2.36205	8.000	2.54099	2.550	2.550
	Lash	5.00	.050	.100	.050	.050	.050
	Auto Detect	5.00	This is a routine. See page 19 for details.				
	Jog Reverse	5.41	No				
Offset Menu	Offset	5.00	This is a routine. See page 20 for details.				
Options Menu	Language	5.00	Standard English				
	Password	5.00	Set to the TigerStop serial number at the factory.				
	Sleep	5.00	0 Seconds				
	Units	5.00	Inches				
	MM Conversion	5.00	25.400				
	Contrast	5.00	100%				
	Print Type	5.00	None				



Menu	Parameter	SW Version	TigerStop	TigerFence/ TigerCrossCut	TigerTurbo	HeavyDuty 2	TigerRack
Options Menu	Print Name	5.00	None				
	Print Cut	5.00	None				
	Print Bar Code	5.30	None				
	Inkjet Offset	5.43	0.000				
	CrossCut Alarm	5.00	N/A	Off TigerCrossCut Only	N/A	N/A	N/A
	Safe Zone	5.00	N/A	0.000	N/A	N/A	N/A
	Feed Hazard	5.00	0.000	N/A	0.000	0.000	0.000
	Show Calibration	5.41	On				
	Show Unit	5.41	Off				
	Backoff	5.00	0.000				
	Retract	5.00	0.000				
	Retract Offset	5.00	0.000				
	Retract Type	5.50	Standard				
Part List Menu	Head Cut	5.00	2.000 in				
	Tail Cut	5.00	2.000 in				
	Outfeed	5.00	0.000 in				
	Load Offset	5.00	0.000 in				
	Unload	5.03	0.000 in				
	Max SPL	5.00	178.000 in				
	Waste	5.00	Last				
	Pre-Sets	5.00	Set Point				
	Drop Box	5.40	2.000 in				
	Salvage	5.40	2.000 in				
	Clear All	5.00	This is a routine. See page 30 for details.				
	Opt Score	5.00	2.000				
	Opt Time	5.00	2000 ms				
	Opt Pen	5.00	1.000				
	Clamp 1	5.00	5.000 in				
	Clamp 2	5.00	-5.000 in				
	Swing Clamp	5.30	0.000 In				
	Download Style	5.24	Pri-Global				

Menu	Parameter	SW Version	TigerStop	TigerFence/ TigerCrossCut	TigerTurbo	HeavyDuty 2	TigerRack
Part List Menu	Infinite	5.25	No				
	PET	5.30	0.000 in				
	Banana 1	5.30	24.000 in				
	Banana 2	5.30	36.000 in				
	Drill	5.30	No				
	Group Count	5.40	0				
	TigerMeasure	5.41	Off				
	TM Offset	5.41	18.000 in				
	Quantity	5.50	Standard				
	MM Only	5.41	No				
	HC Jog	5.51	Set by user when using TigerRip 1000				
	Width Cal	5.51	Set by user when using TigerRip 1000				
	Width Scale	5.51	Set by user when using TigerRip 1000				
	Panel Min	5.51	Set by user when using TigerRip 1000				
	Panel Max	5.51	Set by user when using TigerRip 1000				
Motion Menu	In Speed	5.00	25.000	5.000	35.000	35.000	25.000
	Out Speed	5.00	25.000	5.000	35.000	35.000	25.000
	In Accel	5.00	75.000	10.000	50.000	50.000	50.000
	Out Accel	5.00	75.000	10.000	50.000	50.000	50.000
	In Decel	5.00	75.000	10.000	50.000	50.000	50.000
	Out Decel	5.00	75.000	10.000	50.000	50.000	50.000
	Move Delay	5.00	0 ms				
	P Gain	5.00	2.000	4.000	1.200	1.200	1.200
	I Gain	5.00	.750	1.00	.250	.250	.250
	D Gain	5.00	20.000	25.000	4.000	4.000	4.000
	Pd Gain	5.40	.500				
	Pq Gain	5.40	.500				
	Id Gain	5.40	0.000				
	Iq Gain	5.40	0.000				
	Dither	5.00	50 ms	50 ms	0 ms	0 ms	0 ms
	Throttle LVM	5.30	600				
	Throttle LVB	5.30	10000.10				
	Throttle HVM	5.30	325				
	Throttle HVB	5.30	15000.015				
	Stall MEP	5.30	2.000				
	Stall MES	5.30	2.000				
	Run MEP	5.30	2.000				



Menu	Parameter	SW Version	TigerStop	TigerFence/ TigerCrossCut	TigerTurbo	HeavyDuty 2	TigerRack
Motion Menu	Run MES	5.30	.200	.200	.400	.400	.400
	Brake Vel	5.30	32.000				
	Brake Gain	5.30	30.000				
	Find Vel	5.30	0.000				
	Find Trig	5.30	300.000				
Timer Menu	Clamp On Delay	5.00	100 ms				
	Saw On Delay	5.00	100 ms				
	DM Off Time Out	5.00	5000 ms				
	Cycle Time Out	5.52	5000 ms				
	TA Off Time Out	5.00	5000 ms				
	DM On Time Out	5.00	5000 ms				
	Clamp Off Delay	5.00	100 ms				
	Saw Cycle Delay	5.00	100 ms				
	RSD Ready Time Out	5.00	2000 ms				
	PET Delay	5.30	200 ms				
	Outfeed Delay	5.60	200 ms				
System Info Menu	SN & EC	5.00	This is a routine. See page 45 for details.				
	Software Version	5.00	This is a routine. See page 45 for details.				
	Zero End	5.00	Motor End				
	Set TIK	5.00	None				
	Baud Rate	5.00	9600				
	I/O Panel Baud Rate	5.40	9600				
	Motor Type	5.00	Standard	Rev Enc	Depends on orientation	Depends on orientation	Depends on orientation
	Brake	5.43	N/A	N/A	N/A	N/A	None
	Brake Time Out	5.43	N/A	N/A	N/A	N/A	18000 ms 15

Menu	Parameter	SW Version	TigerStop	TigerFence/ TigerCrossCut	TigerTurbo	HeavyDuty 2	TigerRack
Laser Menu	Laser Marking	5.21	Off				
	Defect Only	5.40	Off				
	Laser Error	5.21	.200 in				
	Laser Count	5.21	3				
	Laser Location	5.43	Motor End				
	Laser Limit	5.21	Set to maximum limit of TigerStop at factory.				
	Laser Reference	5.21	5.000 in				
	Crayon	5.50	Off				
	PF Offset	5.50	29.250 in				
	IR Offset	5.50	1.950 in				
	PF Down	5.50	24.000 in				
	Margin	5.51					
Debug Menu	I/O Test	5.00	This is a routine. See page 51 for details.				
	Drive Test	5.00	This is a routine. See page 51 for details.				
	I/O Mask	5.00	This is a routine. See page 52 for details.				
	Debug Mode	5.00	Off				

# Setup Menu

The Setup menu contains settings that you will use when calibrating TigerStop.

```
%H < Select > Menu
A-Setup   C-Options
B-Offset  D-PartList
  A      B      C      D
```

1. At the menu select screen, press the [Setup] soft key to access the Setup menu.
2. Press  or  to scroll through the settings.

## Calibrate

```
%H < Calib > Setup
Enter distance
from zero= ##.###in
                        Done
```

Calibration sets the distance that TigerStop is from the zero point of your tool. This setting will need to be set when installed, then checked periodically.

### To calibrate TigerStop...

1. Cut a sample piece and carefully measure it.
2. Enter the length of the sample piece.
3. Press the [Done] soft key to save the parameter.

## CrossCut

```
%H <CrossCut> Setup
Enter Stop 2
offset   = 60.000in
                        Done
```

CrossCut is only available on TigerCrossCut. CrossCut is the offset between stop 1 and stop 2.

### To change CrossCut...

1. Measure from the front of stop 1 to the front of stop 2.
2. Enter the length you measured, then press the [Done] soft key to save the parameter.

## Home Routine

```
%H <Home TS > Setup
Run Home Routine?
Press START to run
```

The Home Routine setting makes TigerStop perform its Home Routine, as if it were just powered up. See "The Home Routine" on page 6.

**Note:** TigerStop will move!

## Kerf

```
%H < Kerf > Setup
Kerf      = 0.125in
New Value=
                        Done
```

Kerf tells TigerStop how much material your saw blade destroys when it makes a cut. This is important if you are using push feed lists, pattern lists or the increment feature.

## To measure Kerf...

1. Cut a sample piece and measure it with a caliper. Record your measurement.
2. Cut this piece in half.
3. Put the two pieces together as if they were one piece and measure with a caliper.
4. The difference between the measurement on step 1 and step 3 will be your kerf value.
5. Enter your kerf value and press the [Done] soft key to save the parameter.

Note: It is important to measure your kerf every time the saw blade is changed.

## Find Limit

```
%H <FindLim> Setup
Find the end limits?
Press START to run
```

The Find Limit routine automatically finds the minimum and maximum limits of travel. TigerStop will move to the home end and then to the zero end during this routine.

### To run the Find Limits routine...

1. Ensure TigerStop can move its entire travel without obstruction.

2. Press **START** to start the routine.

Note: TigerStop will move!

## Auto Setup

```
%H <RunSetup> Setup
Run the Auto Setup
routine?
Press START to run
```

Auto Setup is a routine that tunes TigerStops accuracy. It is a combination of Find Limit and the Scale procedure. Take care when running this routine. Mistakes made while running the Auto Setup can greatly effect TigerStops accuracy and may even cause damage.


### To run the Auto Setup routine...

1. Press [Start] to begin the routine.
2. TigerStop will perform a Find Limits routine. When finished, TigerStop will move to a position.

Note: TigerStop will move!

```
%H <RunSetup> Setup
Cycle the tool.
Measure the part.
Press OK to continue
```

3. TigerStop will ask the user to cut a sample piece and measure the part.

4. Press  when the measurement is made.

```
%H <RunSetup> Setup
Enter measured value
New value=
Press START to move.
```

5. Enter the measured value and press **START**.

6. TigerStop will now move to a second position and will repeat steps 3 and 4.

7. When the routine is finished, you will be returned to the Run Setup screen. Press the [Done] soft key to return to the Ready Screen.

## Min Limit

```
%H <Min Lim → Setup
Min Limit=  #.###in
Password =
Done
```

The Minimum Limit is the shortest position TigerStop will move to. This value can be changed manually or set automatically by running the Find Limits routine.

### To run the Minimum Limit...

1. Enter the password and press .

Note: By default, the TigerStop password is set to the serial number.

2. Enter the new Minimum Limit value.
3. Press the [Done] soft key to save the parameter.

Note: Be careful when setting the Minimum Limit. TigerStop may be damaged if set incorrectly.

## Max Limit

```
%H <Max Lim → Setup
Max Limit=  #.###in
Password =
Done
```

The Maximum Limit is the longest position TigerStop will move to. This value is set automatically during the Find Limit routine and should not be changed. Changing this setting could greatly effect machine accuracy and may even cause damage.

## Scale

```
%H < Scale → Setup
Scale =  #.#####
Password =
Done
```

The Scale setting tells TigerStop how many encoder counts are equal to 0.001 inches. It may be necessary to change this setting when troubleshooting accuracy problems, but must always be changed with help from TigerStop Customer Service.

## Lash

```
%H < Lash → Setup
Lash =  #.###in
Password =
Done
```

The Lash setting sets the backlash compensation. Take care when setting the Lash. An improper value can greatly effect TigerStop accuracy.

### To change Lash...

1. Enter the password and press .

Note: By default, the TigerStop password is set to the serial number.

2. Enter the new Lash value.
3. Press the [Done] soft key to save the parameter.


## Auto Detect

```
%H < Detect → Setup
Auto-detect your
Tool Interconnect?
Press OK to begin.
```

Auto Detect is a routine that will detect your interconnect type, if you are using a Standard or Advanced Interconnect Kit. You will typically run this routine during machine installation.


## To run the Auto Detect routine...

1. Ensure your Standard or Advanced Interconnect Kit is installed.

2. Press  to begin the routine.


```
%H < Detect -> Setup
The tool may cycle
during this process.
Press OK to continue
```

3. TigerStop will warn you that your tool may cycle during this routine. Keep the cutting area clear!


4. Press  when the saw is clear and it is safe to cycle.

```
%H < Detect -> Setup
Keep the footswitch
pressed, if present.
Press OK to continue
```

5. If you are detecting an Advanced Interconnect Kit, press and hold the supplied foot switch.



6. Press  when you are holding down the foot switch.

```
%H < Detect -> Setup
No Tool IK
Tool IK detected!
Press OK to continue
```

7. TigerStop will now display the Interconnect Kit it has detected. If this display is incorrect, try to run the procedure again. If its correct, press  to return to the Setup menu.

## Jog Reverse

```
%H < JogReverse -> Setup
Reverse direction of
Jog:      NO
      ↑      ↓   Done
```

The Jog Reverse setting controls the direction that the  and  buttons move the TigerStop when using the Jog feature.

## To change Jog Reverse...

1. Press [B] or [C] to toggle the setting.



2. Press the [Done] soft key to save the parameter.

# Offset Menu

The Offset menu allows you to offset the calibration of TigerStop. There are 99 programmable offsets.



```
%H < Select -> Menu
A-Setup    C-Options
B-Offset   D-PartList
  A      B      C      D
```

1. At the menu select screen, press the [Offset] soft key to access the Offset menu.

2. Press  or  to scroll through the offsets.

## Programming an Offset

```
%H < Off#1 -> 0-Set
Offset = 0.000in
New Value=
  Use GoTo
```

1. Use the  and  to select the offset number you want to program.


*Note: Offset 1 is the default offset and cannot be changed.*



```

%H <Off#2 > 0-Set
Offset = 8.000in
New Value=
Use GoTo

```

2. Enter the value of the offset and press  to save the setting.  
 Note: A positive offset will SUBTRACT from the calibration. A negative offset will ADD to the calibration.
3. Press the [Use] soft key to use the offset and return to the Ready Screen. TigerStop will use this offset until you choose to use a different offset.  
 Note: Use offset 1 to return to normal operation.

## Go To an Offset

The Go To function allows you to quickly jump to a given offset number.

```

%H <Off#1 > 0-Set
Offset = 0.000in
New Value=24
Use GoTo

```

```

%H <Off#24 > 0-Set
Offset = 6.000in
New Value=
Use GoTo

```

1. At the Offset screen, enter the offset number you want to go to.
2. Press the [GoTo] soft key.
3. You will be taken to the offset number you entered. Press the [Use] soft key to use this offset.



# Options Menu

The Options menu contains settings that allow you to configure optional accessories and processes.

```

%H <Select > Menu
A-Setup C-Options
B-Offset D-PartList
A B C D

```

1. At the menu select screen, press the [Options] soft key to access the Options menu.
2. Press  or  to scroll through the settings.

## Language

```

%H <Language> Optns
The current language
is: StdEnglish
    ↑   ↓   Done

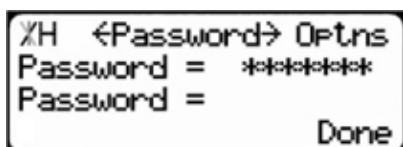
```

The Language setting allows you to change the display language.

### To change Language...

1. Press [B] or [C] to toggle the Language.
2. Press the [Done] soft key to save the parameter.

## Password




The Password setting allows you to view and change your TigerStop password. This password is needed anytime you enter the menus and is required to change critical TigerStop settings.

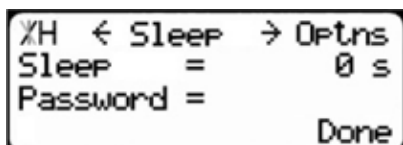
### To change Password...

1. Enter the current password and press .

Note: By default, the TigerStop password is set to the serial number.

2. The password will now be displayed.
3. Enter a new numeric password and press .
4. Press the [Done] soft key to save the parameter.

## Sleep Mode



Sleep Mode will power down the TigerStop screen and motor when left idle for a specified amount of time. This does NOT power down TigerStop. Do NOT attempt any repairs or adjustments while in sleep mode.

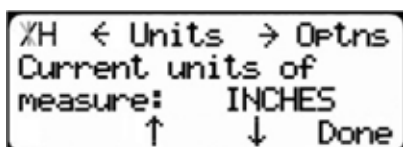
### To change Sleep Mode...

1. Enter the password and press .

Note: By default, the TigerStop password is set to the serial number.

2. Enter the time, in seconds, that you want TigerStop to wait before it goes into sleep mode.
3. Press the [Done] soft key to save the parameter.

## Units

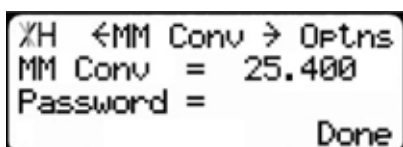


The Units setting allows you to change the display units from Inches to Metric.

### To change Units...

1. Press [B] or [C] to toggle Units.
2. Press the [Done] soft key to save the parameter.

## Millimeter Conversion



Millimeter Conversion controls the conversion math from Millimeters to Inches. This parameter should not be changed unless you are using the automatic angle adjustment on the TigerAngle saw system.

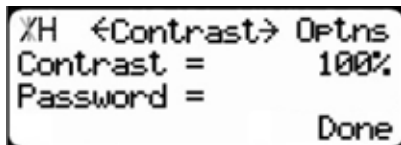
## To change Millimeter Conversion...

1. Enter the password and press .

Note: By default, the TigerStop password is set to the serial number.

2. Enter a new Millimeter Conversion value.
3. Press the [Done] soft key to save the parameter.

## Contrast



Contrast controls the brightness of the screen. The minimum setting for Contrast is 70%.

Note: A contrast of 70% will make the screen unreadable.

## To change Contrast...

1. Enter the password and press .

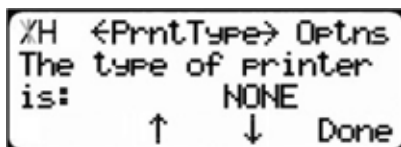
Note: By default, the TigerStop password is set to the serial number.

2. Enter a new Contrast value and press .

Note: The screen contrast will now change.

3. Press the [Done] soft key to save the parameter.

## Printer Type

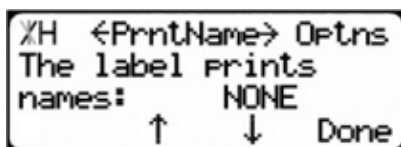


Printer Type is used to tell TigerStop what style of printer it has. This setting will be available if you have the TigerStop printing upgrade.

## To change Printer Type...

1. Press [B] or [C] until the printer you have is displayed.
2. Press the [Done] soft key to save the parameter.

## Print Name

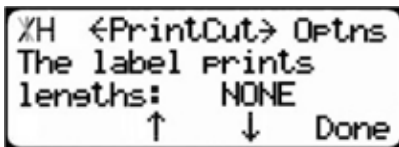


Print Name is used to print the part list name on your label when running a downloaded part list. This setting will be available if you have the TigerStop printing upgrade, but will not be usable without the TigerStop downloading upgrade.

## To change Printer Type...

1. Press [B] or [C] to toggle Print Name.
2. Press the [Done] soft key to save the parameter.

## Print Cut

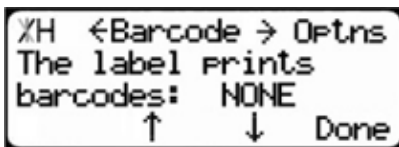
A screenshot of a handheld device screen showing the 'Print Cut' menu. The text on the screen reads: '%H <PrintCut> Optns', 'The label prints', 'lengths: NONE', and at the bottom, an up arrow, a down arrow, and the word 'Done'.

Print Cut tells TigerStop to print length and part quantity information on your label. This setting will be available if you have the TigerStop printing upgrade.

### To change Print Cut...

1. Press [B] or [C] to toggle the Print Cut setting.
2. Press the [Done] soft key to save the parameter.

## Barcode

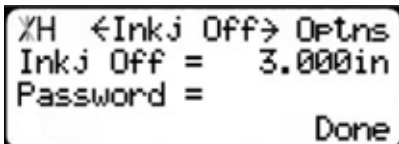
A screenshot of a handheld device screen showing the 'Barcode' menu. The text on the screen reads: '%H <Barcode> Optns', 'The label prints', 'barcodes: NONE', and at the bottom, an up arrow, a down arrow, and the word 'Done'.

Barcode tells TigerStop to print bar coded data on your label. This setting will be available if you have the TigerStop printing upgrade.

### To change Barcode...

1. Press [B] or [C] to toggle the Barcode setting.
2. Press the [Done] soft key to save the parameter.

## Inkjet Offset

A screenshot of a handheld device screen showing the 'Inkjet Offset' menu. The text on the screen reads: '%H <Inkj Off> Optns', 'Inkj Off = 3.000in', 'Password =', and at the bottom, the word 'Done'.

Inkjet Offset is only used for TigerStop saw systems that use an ink jet printer. The Inkjet Offset sets the distance the ink jet printer head is from the saw blade of the TigerStop saw system.

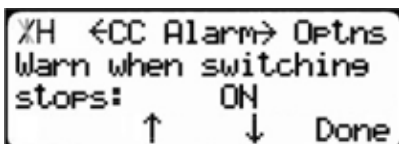
### To change Inkjet Offset...

1. Enter the password and press .

Note: By default, the TigerStop password is set to the serial number.

2. Measure from the saw blade to the ink jet printer head.
3. Enter this measurement.
4. Press the [Done] soft key to save the parameter.

## CrossCut Alarm

A screenshot of a handheld device screen showing the 'CrossCut Alarm' menu. The text on the screen reads: '%H <CC Alarm> Optns', 'Warn when switching', 'stops: ON', and at the bottom, an up arrow, a down arrow, and the word 'Done'.

CrossCut alarm will warn the user anytime TigerCrossCut switches stops. This setting will only be available if you have a TigerCrossCut.

### To change CrossCut Alarm...

1. Enter the password and press .

Note: By default, the TigerStop password is set to the serial number.

2. Press [B] or [C] to toggle the setting.
3. Press the [Done] soft key to save the parameter.

## Safe Zone

```
%H <SafeZone> Optns
SafeZone = 3.000in
Password =
Done
```

Safe Zone sets the minimum distance that TigerFence can go without giving the user a warning before moving. This setting will only be available if you have a TigerFence.

### To change Safe Zone...

1. Enter the password and press .

Note: By default, the TigerStop password is set to the serial number.

2. Enter a new Safe Zone value.
3. Press the [Done] soft key to save the parameter.

## Feed Hazard

```
%H <FeedHaz> Optns
FeedHaz = 0.000in
Password =
Done
```

The Feed Hazard setting will warn the user if they try to push more than the set amount material through the tool. This is used if the stock coming out of the out feed will hit something if too much is pushed out at once.

### To change Feed Hazard...

1. Enter the password and press .

Note: By default, the TigerStop password is set to the serial number.

2. Enter a new Feed Hazard value.
3. Press the [Done] soft key to save the parameter.

## Show Calibration

```
%H <Show Cal> Optns
Calibrate is shown
on softkey ON
↑ ↓ Done
```

Show Calibration allows you to remove the quick calibration button from the Ready Screen. Also see "Quick Calibration" on page 10.

### To change Show Calibration...

1. Press [B] or [C] to toggle the setting.
2. Press the [Done] soft key to save the parameter.

## Show Units

```
%H <ShowUnit> Optns
Units toggle shown
on softkey OFF
↑ ↓ Done
```

Show Units adds a soft key to the Ready Screen that allows you to quickly toggle between Inches and Metric measurement modes.

### To change Show Units...

1. Press [B] or [C] to toggle the setting.
2. Press the [Done] soft key to save the parameter.

## Backoff

```
%H <Backoff> PList
Backoff = 0.000in
New Value=
Done
```

Backoff is a global parameter that applies to all pusher and pattern part lists. It also applies to manual moves if using a TigerStop Interconnect Kit. If TigerStop moves to a length smaller than the Backoff value, it will back up to the Backoff value and wait until the tool cycle is complete. This is used to back out of the way of clamps or other devices. Backoff cannot be larger than 40 in.

### To change Backoff...

1. Enter the new Backoff value.
2. Press the [Done] soft key to save the parameter.

## Retract

```
%H <Retract> PList
Retract = 0.000in
New Value=
Done
```

Retract is a global parameter that applies to all pusher and pattern part lists. It also applies to manual moves if using a TigerStop Interconnect Kit. After TigerStop has moved to position, TigerStop will back up by the value of the Retract setting and wait until the tool cycle is complete before it moves to the next position.

### To change Retract...

1. Enter the new Retract value.
2. Press the [Done] soft key to save the parameter.

## Retract Offset

```
%H <RetOff> PList
RetOff = 0.000in
New Value=
Done
```

Retract Offset works with the Retract setting. At the end of every Retract move, TigerStop will move forward to meet the part before it pushes to the next length. The Retract Offset offsets this movement. This is useful when the position of the part changes due to the tool cycle.

### To change Retract Offset...

1. Enter the new Retract Offset value.
2. Press the [Done] soft key to save the parameter.

*Note: This will be how much to part moves during the tool cycle.*

## Retract Type

```
%H <Ret Type> Optns
Retract Type is:
Standard
↑ ↓ Done
```

Retract Type works with the Retract and the Retract Offset settings. It tells TigerStop when to apply the Retract move.

### Options

Standard - The Retract move will happen as soon as TigerStop moves material to position.

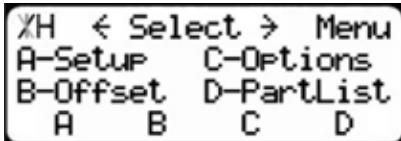
DM Only - The Retract move will happen as soon as the DM circuit opens when using a TigerStop Interconnect Kit.



### To change Retract Type...

1. Press [B] or [C] to toggle the Retract Type.
2. Press the [Done] soft key to save the parameter.

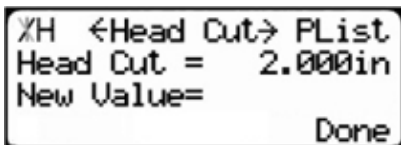
# Part List Menu

The Part List menu contains settings that allow you to change how part lists work.



1. At the menu select screen, press the [PartList] soft key to access the Part List menu.
2. Press  or  to scroll through the settings.

## Head Cut

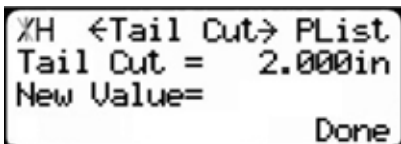


The Head Cut setting is used when you apply a global head cut to pusher, pattern or pull part lists. A head cut is a trim cut at the beginning of the stock, used to remove potential defects and square the end.

### To change Head Cut...

1. Enter the new Head Cut value.
2. Press the [Done] soft key to save the parameter.

## Tail Cut

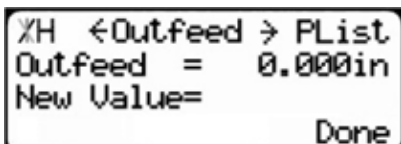


The Tail Cut setting is used when you apply a global tail cut to pusher, pattern or pull part lists. A tail cut is a trim cut at the end of the stock, used to remove potential defects and square the end.

### To change Tail Cut...

1. Enter the new Tail Cut value.
2. Press the [Done] soft key to save the parameter.

## Outfeed



Outfeed is a global parameter that applies to all pusher and pattern part lists. After the last cut is made, the Outfeed setting will send TigerStop past the zero point by the value of the Outfeed setting. This helps push the remaining material out of the tool cutting envelope.

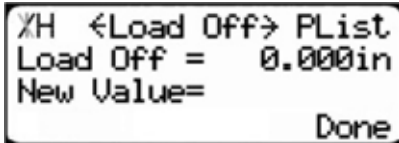
## To change Outfeed...

1. Enter the new Outfeed value.

Note: Outfeed must always be a negative number.

2. Press the [Done] soft key to save the parameter.

## Load Offset



Load Offset is a global parameter that applies to all pusher and pattern lists. Load Offset will add to the load position to give the operator more room to load the stock. When using a TigerSaw saw system with crayon defect marking, Load Offset is the load position of the pusher foot before the defect scanning operation. If you are using the TigerMeasure upgrade, the Load Offset will start at the TigerMeasure Offset position.

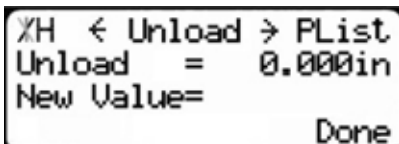
## To change Load Offset...

1. Enter the new Load Offset value.

Note: Ensure the stock material length plus the Load Offset do not exceed the Maximum Limit.

2. Press the [Done] soft key to save the parameter.

## Unload

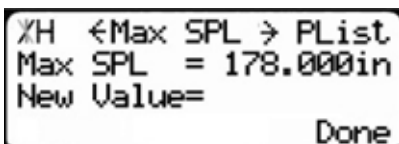


Unload is a global parameter that applies to all pull part lists. Unload is the amount of space that is needed to safely unload material in front of a fully retracted stop when using a pull list. The unload value is added to the stock length and TigerStop moves to the resulting position at the end of a pull list cycle.

## To change Unload...

1. Enter the new Unload value.
2. Press the [Done] soft key to save the parameter.

## Max SPL



Max SPL is a global setting that applies to all optimized set point part lists. The Max SPL is the largest stock length that TigerStop will allow you to enter. This is to prevent entering a very large stock length value by mistake.

## To change Max SPL...

1. Enter the new Max SPL value.
2. Press the [Done] soft key to save the parameter.



## Waste



```
%H <Waste> PList
Part List waste is
processed: FIRST
      ↑      ↓   Done
```

Waste is a global setting that applies to all optimized part lists. The Waste setting tells TigerStop where to put the unused material from a cut list.

### Options

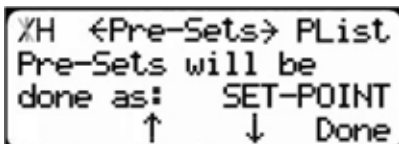
**First** - TigerStop will put the unused material at the beginning of the stock. The waste will be cut instead of the head cut.

**Last** - TigerStop will put the unused material at the end of the stock. The waste will be cut instead of the tail cut.

### To change Waste...

1. Press [B] or [C] to toggle the setting.
2. Press the [Done] soft key to save the parameter.

## Pre-Sets



```
%H <Pre-Sets> PList
Pre-Sets will be
done as: SET-POINT
      ↑      ↓   Done
```

The Pre-Sets option controls how the Pre-Set function works.

### Options

**Setpoint** - Sends TigerStop to an absolute value, like a manual movement does.

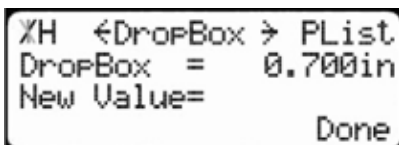
**Increment** - TigerStop will increment by the preset value, but will not compensate for kerf.

**Pusher** - TigerStop will increment by the preset value and will compensate for kerf, using the Kerf setting in the Setup menu.

### To change Pre-Sets...

1. Press [B] or [C] to toggle to an option.
2. Press the [Done] soft key to save the parameter.

## Dropbox



```
%H <DropBox> PList
DropBox = 0.700in
New Value=
                        Done
```

Dropbox tells TigerStop to cut your waste pieces into smaller pieces that can fit into your scrap drop box, if you have one.

### To change Dropbox...

1. Enter the new Dropbox value.
2. Press the [Done] soft key to save the parameter.

## Salvage

```
%H <Salvage> PList
Salvage = 0.200in
New Value=
Done
```

Salvage works with the Dropbox setting and tells TigerStop to not cut waste pieces larger than the Salvage setting into small Dropbox pieces. You can now keep the longer waste pieces and use them for another job.

### To change Salvage...

1. Enter the new Salvage value.
2. Press the [Done] soft key to save the parameter.


## Clear All

```
%H <ClearAll> PList
Permanently delete
ALL Parts Lists?
Press OK to begin.
```

Clear All will clear all saved part lists from TigerStop memory. Clear All does not clear settings.

### To run the Clear All routine...

```
%H <ClearAll> PList
Permanently delete
ALL Parts Lists?
Press OK to begin.
```

1. Press  to begin the routine.

```
%H <ClearAll> PList
Are you sure? This
is not reversible.
Press OK to continue
```

2. TigerStop will confirm that you want to clear all the part lists.

*Note: The part lists cannot be recovered once cleared.*

```
%H Clear All PList
Success!
```

3. TigerStop will display "Success!" once the clear is complete.

## Opt Score

```
%H <OptScore> PList
OptScore = 2.000
New Value=
Done
```

Opt Score is a global setting that applies to all optimized part lists. Opt Score sets the score that an optimizer solution must reach to be considered a good solution. A lower Opt Score value gives a better optimized solution, but will take longer to do so. A higher Opt Score value gives you a faster solution, but may contain more waste. The default of 2.000 is the optimal choice for most applications.

### To change Opt Score...

1. Enter the new Opt Score value.
2. Press the [Done] soft key to save the parameter.

## Opt Time

```
%H <OptTime> PList
OptTime = 2000ms
New Value=
Done
```

Opt Time is a global setting that applies to all optimized part lists. Opt Time sets the time that the optimizer has to find a solution. If it takes longer than the Opt Time setting, TigerStop will use the best solution it has found. The default of 2000 ms (2 seconds) is the optimal choice for most applications.

### To change Opt Time...

1. Enter the new Opt Time value.
2. Press the [Done] soft key to save the parameter.

## Opt Pen

```
%H <OptPen> PList
OptPen = 1.000
New Value=
Done
```

Opt Pen is a global setting that applies to all optimized part lists. Opt Pen sets a penalty for optimized solutions that contain more than one part. The effect of this is that TigerStop will try to process longer parts first. A lower Opt Pen value will give you faster optimization with more short parts processed first. A higher Opt Pen will give you a slower optimization with longer parts processed first. The default of 1.000 is the optimal choice for most applications.

### To change Opt Pen...

1. Enter the new Opt Pen value.
2. Press the [Done] soft key to save the parameter.

## Clamp 1

```
%H <Clamp 1> PList
Clamp 1 = 5.000in
New Value=
Done
```

Clamp 1 sets the distance that the in feed clamp is from your tools zero point, when using one of the TigerStop Clamping options.

### To change Clamp 1...

1. Measure from the tools zero point to the in feed clamp.
2. Enter the measurement.
3. Press the [Done] soft key to save the parameter.

## Clamp 2

```
%H <Clamp 2> PList
Clamp 2 = -5.000in
New Value=
Done
```

Clamp 2 sets the distance that the out feed clamp is from your tools zero point, when using one of the TigerStop Clamping options.

## To change Clamp 2...

1. Measure from the tools zero point to the out feed clamp.
2. Enter the measurement.  
*Note: Clamp 2 should be a negative value.*
3. Press the [Done] soft key to save the parameter.

## Swing Clamp

```
%H <SwngClmp> PList
SwngClmp = 0.000in
New Value=
Done
```

The Swing Clamp setting is used to trigger the Swing Clamp output on the TigerStop I/O panel. This output is used by a clamp that gives continuous pressure to the material throughout processing. The Swing Clamp setting will turn the clamp off when it gets within the set value. A value of 0.000 disables the swing clamp output.

## To change Swing Clamp...

1. Determine where in the TigerStop travel you want the swing clamp to retract.
2. Enter the measurement.
3. Press the [Done] soft key to save the parameter.

## Download Style

```
%H <DL Style> PList
Part lists are
viewed: Pri-Global
        ↑      ↓ Done
```

Download Style sets the default download type when using the TigerStop downloading upgrade.

### Options

**Pri-Global** - Download from the global folder and display the part lists by priority.

**Pri-Local** - Download from the local folder and display the part lists by priority.

**WO#-Global** - Download from the global folder and search the lists by an entered work order number.

**WO#-Local** - Download from the local folder and search the lists by an entered work order number.

## To change Download Style...

1. Press [B] or [C] to toggle DL Style
2. Press the [Done] soft key to save the parameter.

## Infinite

```
%H <Infinite> PList
Part lists ignore
quantity : NO
        ↑      ↓ Done
```

When set to "Yes", the Infinite setting will give you the option to treat every length in a part list as having an infinite quantity. Once the setting is set, the option will appear when programming a part list.

## To change Infinite...

1. Press [B] or [C] to toggle Infinite.
2. Press the [Done] soft key to save the parameter.

## Precision End Trim

```
%H < PET > PList
PET      = 0.250in
New Value=
                               Done
```

Precision End Trim (PET) controls the distance TigerStop has to move to cut a split in the end of the board being processed when using the Precision End Trim upgrade.

## To change PET...

1. Enter the new PET value.
2. Press the [Done] soft key to save the parameter.

## Banana 1

```
%H <Banana 1> PList
Banana 1 = 24.000in
New Value=
                               Done
```

Banana 1 is a setting that works with the Precision End Trim upgrade. If you are processing warped material, Banana 1 sets the maximum length that you want to cut from that material. This ensures only short lengths are cut from this material.

## To change Banana 1...

1. Enter the new Banana 1 value.
2. Press the [Done] soft key to save the parameter.

## Banana 2

```
%H <Banana 2> PList
Banana 2 = 36.000in
New Value=
                               Done
```

Banana 2 is a setting that works with the Precision End Trim upgrade. If you are processing warped material, Banana 2 sets a maximum length that you want to cut from that material. This works with Banana 1 to give you two Banana options while using the PET upgrade.

## To change Banana 2...

1. Enter the new Banana 2 value.
2. Press the [Done] soft key to save the parameter.

## Drill

```
%H < Drill > PList
Run setpoints like
Pushers:  NO
          ↑  ↓  Done
```

Drill tells TigerStop to run set point lists as pusher lists. This is most commonly used in drilling applications.

## To change Drill...

1. Press [B] or [C] to toggle the Drill setting.
2. Press the [Done] soft key to save the parameter.

## Group Count

```
%H <GroupCnt> PList
GroupCnt =      0
New Value=
Done
```

Group Count numbers multiple cuts as part of a group when printing. This option is available when you are using the TigerGauge accessory.

### To change Group Count

1. Enter the number of pieces in a group as the new Group Count value.
2. Press the [Done] soft key to save the parameter.

## TigerMeasure

```
%H <TMeasure> PList
TigerMeasure mode
is:      OFF
      ↑   ↓   Done
```

The TigerMeasure setting is used with the TigerMeasure length measuring sensor. This setting turns the sensor on or off.

### To change TigerMeasure...

1. Press [B] or [C] to toggle the TigerMeasure setting.
2. Press the [Done] soft key to save the parameter.

## TigerMeasure Offset

```
%H <TMOffset> PList
TMOffset = 0.000in
New value=
Done
```

TigerMeasure Offset tells TigerStop how far the TigerMeasure sensor is from the zero point. This setting must be set when the TigerMeasure sensor is installed.

### To change TigerMeasure Offset...

1. Measure from your tools zero point to the TigerMeasure sensor.
2. Enter the measurement.
3. Press the [Done] soft key to save the parameter.

## Quantity

```
%H <Quantity> PList
Quantity field is:
      Standard
      ↑   ↓   Done
```

Quantity is a global parameter that applies to all part lists. The Quantity setting changes the way TigerStop counts parts as complete when running a parts list.

### Options

**Standard** - This option makes the quantity field work normally.

**Pack** - This allows the user to pack multiple pieces of material when running a parts list.

**Panel** - This option allows the user to use the panel layup feature on TigerSaw saw systems.

## To change Quantity...

1. Enter the password and press .

Note: By default, the TigerStop password is set to the serial number.

2. Press [B] or [C] to toggle the Quantity setting.
3. Press the [Done] soft key to save the parameter.

## MM Only

```
/H < MM Only > Plist
Lists are only ever
metric:      NO
      ↑      ↓ Done
```

MM only is used when you are processing part lists exclusively in metric mode.

## To change MM Only...

1. Press [B] or [C] to toggle the MM Only setting.
2. Press the [Done] soft key to save the parameter.

## HC Jog

```
/H < HC Jog > Plist
HC Jog = 0.250in
New Value=
                        Done
```

HC Jog is used with TigerRip 1000 saw system only. It controls how far the TigerRip 1000 fence jogs when the trim button is pressed on the joy stick.

## To change HC Jog...

1. Enter the new HC Jog value.
2. Press the [Done] soft key to save the parameter.

## WidthCal

```
/H < WidthCal > Plist
WidthCal = 0.000in
New Value=
                        Done
```

WidthCal controls the calibration of the width laser on a TigerRip 1000 saw system.

## To change WidthCal...

1. Enter the new WidthCal value.
2. Press the [Done] soft key to save the parameter.

## Width Scale

```
/H < W. Scale > Plist
W. Scale = 2.000in
New Value=
                        Done
```

Width Scale controls how the width laser moves on a TigerRip 1000 saw system. This setting should not be adjusted unless instructed by TigerStop Customer Service.

## To change Width Scale...

1. Enter the new Width Scale value.
2. Press the [Done] soft key to save the parameter.

## Panel Min

```
/H <PanelMin> Plist
PanelMin = 2.000in
New Value=
Done
```

Panel Min controls the minimum width a piece can be when using the panel layup feature on a TigerRip 1000 saw system.

## To change Panel Min...

1. Enter the new Panel Min value.
2. Press the [Done] soft key to save the parameter.

## Panel Max

```
/H <PanelMax> Plist
PanelMax = 2.000in
New Value=
Done
```

Panel Max controls the maximum width a piece can be when using the panel layup feature on a TigerRip 1000 saw system.

## To change Panel Max...

1. Enter the new Panel Max value.
2. Press the [Done] soft key to save the parameter.

# Motion Menu



The Motion menu contains settings that control how TigerStop moves.

```
/XH <Select> Menu
A-Setup C-Options
B-Offset D-PartList
A B C D
```

1. At the menu select screen, press  to view menu select screen 2.

```
/XH <Select> Menu
A-Motion C-SysInfo
B-Timer D-Laser
A B C D
```

2. Press the [Motion] soft key to access the Motion menu.

3. Press  or  to scroll through the settings.

## In Speed

```
/XH <In-Speed> Mtion
In-Speed = 5.000
New Value=
Done
```

In Speed controls the top speed that TigerStop can achieve when moving in towards the zero point of the tool.

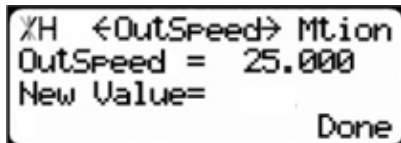
Note: In Speed is set to a default value from the factory. Moving faster than the default speed can cause premature failure.



### To change In Speed...

1. Enter the new In Speed value.
2. Press the [Done] soft key to save the parameter.

### Out Speed



A screenshot of a control panel screen for the 'OutSpeed' parameter. The screen shows the parameter name 'OutSpeed' with a right arrow, the current value '25.000', and a 'New Value=' field. At the bottom right is a 'Done' button.

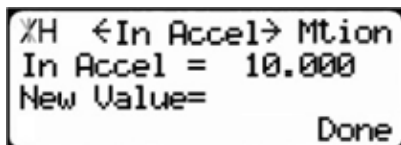
Out Speed controls the top speed that TigerStop can achieve when moving away from the zero point of the tool.

*Note: Out Speed is set to a default value from the factory. Moving faster than the default speed can cause premature failure.*

### To change Out Speed...

1. Enter the new Out Speed value.
2. Press the [Done] soft key to save the parameter.

### In Acceleration



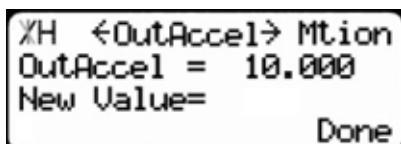
A screenshot of a control panel screen for the 'In Accel' parameter. The screen shows the parameter name 'In Accel' with a right arrow, the current value '10.000', and a 'New Value=' field. At the bottom right is a 'Done' button.

In Acceleration controls how fast TigerStop accelerates when moving toward the zero end.

### To change Out Acceleration...

1. Enter the new Out Acceleration value.
2. Press the [Done] soft key to save the parameter.

### Out Acceleration



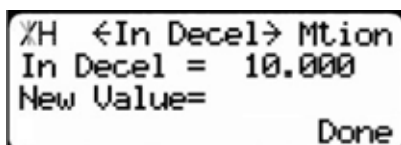
A screenshot of a control panel screen for the 'OutAccel' parameter. The screen shows the parameter name 'OutAccel' with a right arrow, the current value '10.000', and a 'New Value=' field. At the bottom right is a 'Done' button.

Out Acceleration controls how fast TigerStop accelerates when moving away from the zero end.

### To change Out Acceleration...

1. Enter the new Out Acceleration value.
2. Press the [Done] soft key to save the parameter.

### In Deceleration



A screenshot of a control panel screen for the 'In Decel' parameter. The screen shows the parameter name 'In Decel' with a right arrow, the current value '10.000', and a 'New Value=' field. At the bottom right is a 'Done' button.

In Deceleration controls how fast TigerStop decelerates when coming to position towards the zero end.

### To change In Deceleration...

1. Enter the new In Deceleration value.
2. Press the [Done] soft key to save the parameter.

## Out Deceleration

```
%H <OutDecel> Mtion
OutDecel = 10.000
New Value=
Done
```

Out Deceleration controls how fast TigerStop decelerates when coming to position away from the zero end.

### To change Out Deceleration...

1. Enter the new Out Deceleration value.
2. Press the [Done] soft key to save the parameter.

## Move Delay

```
%H <MoveDly> Mtion
MoveDly = 0ms
New Value=
Done
```

Move Delay will make TigerStop wait for a set amount of time before moving after it receives a move command.

### To change Move Delay...

1. Enter the new Move Delay value.
2. Press the [Done] soft key to save the parameter.

## P Gain

```
%H <P Gain> Mtion
P Gain = 4.000
Password =
Done
```

P Gain is a hidden setting that controls how TigerStop moves. Do not change this setting unless told to do so by TigerStop Customer Service.

*Note: P Gain is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.*

## I Gain

```
%H <I Gain> Mtion
I Gain = 1.000
Password =
Done
```

I Gain is a hidden setting that controls how TigerStop moves. Do not change this setting unless told to do so by TigerStop Customer Service.

*Note: I Gain is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.*

## D Gain

```
%H <D Gain> Mtion
D Gain = 25.000
Password =
Done
```

D Gain is a hidden setting that controls how TigerStop moves. Do not change this setting unless told to do so by TigerStop Customer Service.

*Note: D Gain is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.*

## Pd Gain

```
%H <Pd Gain> Mtion
Pd Gain = 0.500
New Value=
Done
```

Pd Gain is a hidden setting that controls how TigerStop moves. Do not change this setting unless told to do so by TigerStop Customer Service.

*Note: Pd Gain is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.*

## Pq Gain

```
%H <Pq Gain> Mtion
Pq Gain = 0.500
New Value=
Done
```

Pq Gain is a hidden setting that controls how TigerStop moves. Do not change this setting unless told to do so by TigerStop Customer Service.  
**Note:** Pq Gain is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.

## Id Gain

```
%H <Id Gain> Mtion
Id Gain = 0.000
New Value=
Done
```

Id Gain is a hidden setting that controls how TigerStop moves. Do not change this setting unless told to do so by TigerStop Customer Service.  
**Note:** Id Gain is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.

## Iq Gain

```
%H <Iq Gain> Mtion
Iq Gain = 0.000
New Value=
Done
```

Iq Gain is a hidden setting that controls how TigerStop moves. Do not change this setting unless told to do so by TigerStop Customer Service.  
**Note:** Iq Gain is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.

## Dither

```
%H <Dither> Mtion
Dither = 930ms
Password =
Done
```

Dither is a hidden setting that controls how TigerStop moves. Do not change this setting unless told to do so by TigerStop Customer Service.  
**Note:** Dither is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.

## Throttle

TigerStop uses a throttle system to limit the amount of drive given to the motor. The default settings are optimal for most applications, but the throttle can be adjusted. Throttle uses the equation  $Y=MX+B$ , where X is the TigerStop speed, M is the ThrotLVM or ThrotHVM setting and B is the ThrotLVB or ThrotHVB setting. TigerStop uses two sets of settings for throttle, depending on what the input voltage to TigerStop is. For 120 VAC, TigerStop will use the ThrotLVM and ThrotLVB settings. For 220 VAC, TigerStop will use the ThrotHVM and ThrotHVB settings.

You can determine the throttle using the Throttle settings and solving for Y. It is important that the throttle is always below 31000. Anything higher than that and the throttle will not be limiting the drive.

## Throttle LVM

```
%H <ThrotLVM> Mtion
ThrotLVM = 600.000
New Value=
Done
```

Throttle LVM is the low voltage (120 VAC) M value that is used in the throttle equation.  
**Note:** Throttle LVM is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.

### Throttle LVB

```
%H <ThrotLVB> Mtion
ThrotLVB =5000.000
New Value=
Done
```

Throttle LVB is the low voltage (120 VAC) B value that is used in the throttle equation.

Note: Throttle LVB is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.

### Throttle HVM

```
%H <ThrotHVM> Mtion
ThrotHVM = 300.000
New Value=
Done
```

Throttle HVM is the high voltage (220 VAC) M value that is used in the throttle equation.

Note: Throttle HVM is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.

### Throttle HVB

```
%H <ThrotHVB> Mtion
ThrotHVB =8000.000
New Value=
Done
```

Throttle HVB is the high voltage (220 VAC) B value that is used in the throttle equation.

Note: Throttle HVB is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.

### Stall MEP

```
%H <StallMEP> Mtion
StallMEP = 1.000
New Value=
Done
```

Stall MEP is a hidden setting that controls how TigerStop moves. Do not change this setting unless told to do so by a TigerStop Customer Service.

Note: Stall MEP is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.

### Stall MES

```
%H <StallMES> Mtion
StallMES = 1.000
New Value=
Done
```

Stall MES is a hidden setting that controls how TigerStop moves. Do not change this setting unless told to do so by a TigerStop Customer Service.

Note: Stall MES is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.

### Run MEP

```
%H <Run MEP > Mtion
Run MEP = 1.000
New Value=
Done
```

Run MEP is a hidden setting that controls how TigerStop moves. Do not change this setting unless told to do so by a TigerStop Customer Service.

Note: Run MEP is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.

### Run MES

```
%H <Run MES > Mtion
Run MES = 0.200
New Value=
Done
```

Run MES is a hidden setting that controls how TigerStop moves. Do not change this setting unless told to do so by TigerStop Customer Service.

Note: Run MES is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.

## Brake Velocity

```
%H <BreakVel>Mtion
BreakVel = 32.000
New Value=
Done
```

Brake Velocity is a hidden setting. Do not change this setting unless told to do so by TigerStop Customer Service.

Note: Brake Velocity is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.

## Brake Gain

```
%H <Break Gn>Mtion
Break Gn = 30.000
New Value=
Done
```

Brake Gain is a hidden setting. Do not change this setting unless told to do so by TigerStop Customer Service.

Note: Brake Gain is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.

## Find Velocity

```
%H <FindVel>Mtion
FindVel = 0.000
New Value=
Done
```

Find Velocity is a hidden setting. Do not change this setting unless told to do so by TigerStop Customer Service.

Note: Find Velocity is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.

## Find Trigger

```
%H <FindTrig>Mtion
FindTrig = 300.000
New Value=
Done
```

Find Trigger is a hidden setting. Do not change this setting unless told to do so by TigerStop Customer Service.

Note: Find Trigger is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.

# Timer Menu



The Timer menu contains timers that control the Advanced Interconnect Kit.

```
%H < Select > Menu
A-Setup C-Options
B-Offset D-PartList
A B C D
```

```
%H < Select > Menu
A-Motion C-SysInfo
B-Timer D-Laser
A B C D
```

1. At the menu select screen, press  to view menu select screen 2.

2. Press the [Timer] soft key to access the Timer menu.

3. Press  or  to scroll through the settings.

## Clamp On Delay

```
%H <ClampOnD> Timer
ClampOnD = 100ms
Password =
Done
```

Clamp On Delay is a timer that waits a set amount of time after TigerStop has come to position, to turn on the clamps, if you are using one of the TigerStop clamping options.

### To change Clamp On Delay...

1. Enter the password and press .

Note: By default, the TigerStop password is set to the serial number.

2. Enter the new Clamp On Delay value.
3. Press the [Done] soft key to save the parameter.

## Saw On Delay

```
%H <Saw On-D> Timer
Saw On-D = 100ms
Password =
Done
```

Saw On Delay is the time that TigerStop waits to cycle the tool after the clamps have been turned on when using an Advanced Interconnect Kit.

### To change Saw On Delay...

1. Enter the password and press .

Note: By default, the TigerStop password is set to the serial number.

2. Enter the new Saw On Delay value.
3. Press the [Done] soft key to save the parameter.

## DM Off Time Out

```
%H <DM OffTO> Timer
DM OffTO = 5000ms
Password =
Done
```

DM Off Time Out is the time the tool is given to come off the DM sensor after TigerStop has activated the tool when using an Advanced Interconnect Kit.

### To change DM Off Time Out...

1. Enter the password and press .

Note: By default, the TigerStop password is set to the serial number.

2. Enter the new DM Off Time Out value.
3. Press the [Done] soft key to save the parameter.

## Cycle Time Out

```
%H <Cycle-TO> Timer
Cycle-TO = 5000ms
Password =
Done
```

Cycle Time Out set the length of time TigerStop will cycle the tool for. This is used to adjust the saw cycle height when using an Advanced Interconnect Kit.

## To change Cycle Time Out...

1. Enter the new Cycle Time Out value.
2. Press the [Done] soft key to save the parameter.

## TA Off Time Out

```
%H <TA OffTO> Timer
TA OffTO = 5000ms
Password =
Done
```

TA Off Time Out is the time the tool is given to get off the TA sensor after TigerStop has turned off the output to cycle the tool when using an Advanced Interconnect Kit.

## To change TA Off Time Out...

1. Enter the password and press .

Note: By default, the TigerStop password is set to the serial number.

2. Enter the new TA Off Time Out value.
3. Press the [Done] soft key to save the parameter.

## DM On Time Out

```
%H <DM On-TO> Timer
DM On-TO = 5000ms
Password =
Done
```

DM On Time Out is the time the tool is given to get back to the DM sensor after the TA sensor turns off when using an Advanced Interconnect Kit.

## To change DM Off Time Out...

1. Enter the password and press .

Note: By default, the TigerStop password is set to the serial number.

2. Enter the new DM Off Time Out value.
3. Press the [Done] soft key to save the parameter.

## Clamp Off Delay

```
%H <ClmpOffD> Timer
ClmpOffD = 100ms
Password =
Done
```

Clamp Off Delay is the time that TigerStop waits after the DM comes back on to turn off the clamps when using an Advanced Interconnect Kit.

## To change Clamp Off Delay...

1. Enter the password and press .

Note: By default, the TigerStop password is set to the serial number.

2. Enter the new Clamp Off Delay value.
3. Press the [Done] soft key to save the parameter.



## Saw Cycle Delay

```
%H <SawCyc-D> Timer
SawCyc-D = 100ms
Password =
Done
```

Saw Cycle Delay is the time that TigerStop will wait to move after the clamps have turned off if you are using one of the TigerStop clamping options.

### To change Saw Cycle Delay...

1. Enter the password and press .

Note: By default, the TigerStop password is set to the serial number.

2. Enter the new Saw Cycle Delay value.
3. Press the [Done] soft key to save the parameter.

## RSD Ready Time Out

```
%H <RSDRdyTO> Timer
RSDRdyTO = 200ms
Password =
Done
```

RSD Ready Time Out is a time out on the internal communication of TigerStop. Do not change this setting unless told to do so by TigerStop Customer Service.

## PET Delay

```
%H <PET-D> Timer
PET-D = 5000ms
New Value=
Done
```

PET Delay is the time that TigerStop will wait to move after making a Precision End Trim move, when using the Precision End Trim upgrade.

### To change PET Delay...

1. Enter the new PET Delay value.
2. Press the [Done] soft key to save the parameter.

## Outfeed Delay

```
%H <Outfeed -D> System
Outfeed-D=
New Value=
↑ ↓ Done
```

Outfeed delay is a delay timer on the Outfeed move (page 27). This can be helpful if your tool needs more time to unclamp after a cycle.

### To change Outfeed Delay...

1. Enter the new Outfeed Delay value.
2. Press the [Done] soft key to save the parameter.

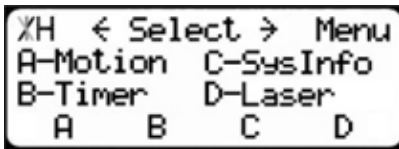
# System Information Menu

The System Information menu contains information about TigerStop.

```
%H < Select > Menu
A-Setup C-Options
B-Offset D-PartList
A B C D
```

1. At the menu select screen, press  to view menu select screen 2.

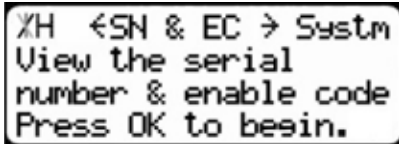




2. Press the [SysInfo] soft key to access the System Information menu.

3. Press or to scroll through the settings.

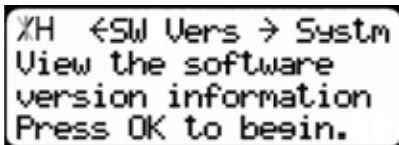
## Serial Number & Enable Code



SN & EC will show you the TigerStop serial number and enable code.

Press to view.

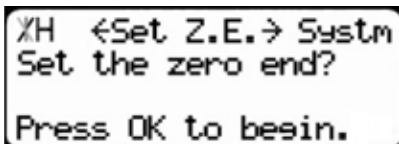
## Software Version



Software Version will display the system software versions.

Press to view.

## Set Zero End

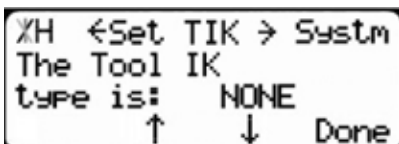


Zero End tells TigerStop which end the tool zero point is in relation to the TigerStop beam.

### To change Zero End...

1. Press .
2. Press or to toggle the Zero End.
3. Press , then follow the screen prompts to complete the Home Routine.

## Set Tool Interconnect Kit



Set Tool Interconnect Kit allows you to manually set your Interconnect type. The Auto Detect setting in the Setup menu will do this automatically. See "Auto Detect" on page 19.

### To change Tool Interconnect Kit...

1. Enter the password and press .
- Note: By default, the TigerStop password is set to the serial number.*
2. Press [B] or [C] to toggle the Tool Interconnect Kit setting.
  3. Press the [Done] soft key to save the parameter.

## Baud Rate

```
/H <BaudRate> Systm
Amplifier serial
baud rate: 9600bps
      ↑   ↓   Done
```

Baud Rate lets you set the baud rate that the TigerStop uses to communicate with computers via the 9 pin serial port.

### To change Baud Rate...

1. Enter the password and press .

*Note: By default, the TigerStop password is set to the serial number.*

2. Press [B] or [C] to toggle the Baud Rate setting.
3. Press the [Done] soft key to save the parameter.

## I/O Panel Baud Rate

```
/H <IOP Rate> Systm
IO Panel serial
baud rate: 9600bps
      ↑   ↓   Done
```

I/O Panel Baud Rate sets the baud rate that the TigerStop I/O panel uses when communicating out of its "Aux" 9 pin serial port.

### To change I/O Panel Baud Rate...

1. Enter the password and press .

*Note: By default, the TigerStop password is set to the serial number.*

2. Press [B] or [C] to toggle the I/O Panel Baud Rate setting.
3. Press the [Done] soft key to save the parameter.

## Motor Type

```
%H <MotrType> Systm
The motor type is:
      Standard
      ↑   ↓   Done
```

Motor Type tells TigerStop what kind of a motor it has. Do not change this setting unless told to do so by TigerStop Customer Service or you are instructed to by a TigerStop parts manual.

*Note: Motor Type is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.*

## Brake

```
/H <Brake> Systm
Brake type is:
      None
      ↑   ↓
```

Brake is a setting that controls how the brakes work on a TigerRack system.

*Note: Brake is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.*

## Options

**Pusher** - The brakes will engage after the tool has started its cycle, when the DM circuit opens (Standard or Advanced Interconnect Kits).

**Setpoint** - The brakes will engage as soon as TigerRack has stopped moving.

## To change Brake...

1. Press [B] or [C] to toggle the Brake setting.
2. Press the [Done] soft key to save the parameter.

### Brake Time Out

```
%H < BreakTO > System
BreakTO = 18000ms
New Value=
Done
```

Brake Time Out is a timer that momentarily turns off the TigerRack brake. This helps TigerRack maintain accuracy when a large load is being driven into it.

*Note: Brake Time Out is a hidden setting. Debug mode must be ON to see this setting. See "Debug Mode" on page 52.*

## To change Brake Time Out...

1. Enter the new Brake Time Out Value.
2. Press the [Done] soft key to save the parameter.

# Laser Menu



The Laser Menu contains settings that control TigerSaw systems and Laser Defecting systems.

```
%H < Select > Menu
A-Setup C-Options
B-Offset D-PartList
A B C D
```

1. At the menu select screen, press  to view menu select screen 2.

```
%H < Select > Menu
A-Motion C-SysInfo
B-Timer D-Laser
A B C D
```

2. Press the [Laser] soft key to access the Laser menu.

3. Press  or  to scroll through the settings.

### Laser Marking

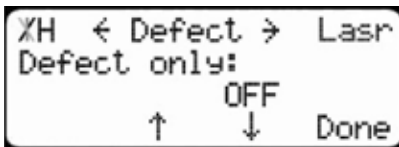
```
%H < Laser > Lasr
Laser marking:
      OFF
      ↑ ↓ Done
```

Laser Marking turns the laser defecting system on or off.

## To change Laser Marking...

1. Press [B] or [C] to toggle the Laser Marking setting.
2. Press the [Done] soft key to save the parameter.

## Defect Only

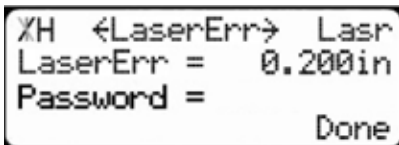


When using a TigerSaw system, Defect Only allows the user to cut just defects from material.

### To change Defect Only...


1. Press [B] or [C] to toggle the Defect Only setting.
2. Press the [Done] soft key to save the parameter.

## Laser Error

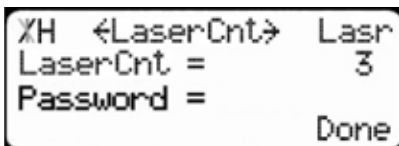


Laser Error is the distance that you have to move away from the last defect scan to count as another defect scan when using the laser defecting system or the TigerSaw crayon defecting system.

### To change Laser Error...


1. Enter the password and press .
- Note: By default, the TigerStop password is set to the serial number.*
2. Enter the new Laser Error value.
3. Press the [Done] soft key to save the parameter.

## Laser Count

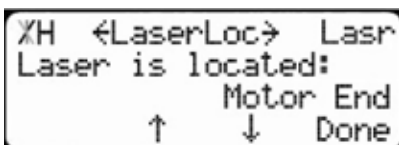


Laser Count is the number of laser reads you need for a position to count as a laser mark. The lower the number, the faster the laser will read a mark. A higher Laser Count may reduce accidental scans.

### To change Laser Count...

1. Enter the password and press .
- Note: By default, the TigerStop password is set to the serial number.*
2. Enter the new Laser Count value.
3. Press the [Done] soft key to save the parameter.

## Laser Location



Laser Location tells TigerStop where the laser is physically mounted.

### To change Laser Location...

1. Enter the password and press .
- Note: By default, the TigerStop password is set to the serial number.*


2. Enter the new Laser Error value.
3. Press the [Done] soft key to save the parameter.

### Laser Limit

```
%H  <LaserLim>  Lasr
LaserLim = 144.000in
Password =
Done
```

Laser Limit is the maximum scan length that TigerStop will accept. Set to a length that is smaller than the backstop that the laser ends at.

#### To change Laser Limit...


1. Enter the password and press .
- Note: By default, the TigerStop password is set to the serial number.*
2. Enter the new Laser Limit value.
3. Press the [Done] soft key to save the parameter.

### Laser Reference

```
%H  <LaserRef>  Lasr
LaserRef = 5.000in
Password =
Done
```

Laser Reference sets the end of the laser reference zone. A scan in this zone signals the end of a stock length.

#### To change Laser Reference...


1. Measure from the lens of the defecting laser to the end of the paddle stop.
2. Enter the password and press .
- Note: By default, the TigerStop password is set to the serial number.*
3. Enter the measurement.
4. Press the [Done] soft key to save the parameter.

### Crayon

```
%H  <Crayon>  Lasr
Crayon marking is:
OFF
↑      ↓      Done
```

The Crayon setting activates the TigerSaw crayon marking system.

#### To change Crayon...


1. Enter the password and press .
- Note: By default, the TigerStop password is set to the serial number.*
2. Press [B] or [C] to toggle the Crayon setting.
3. Press the [Done] soft key to save the parameter.

## PF Offset

```
%H <PFOffset> Lasr
PFOffset = 29.250in
New Value =
Done
```

PF Offset tells a TigerSaw saw system the distance from the end of the pusher foot to the infrared length sensor when using crayon defect marking.

### To change PF Offset...


1. Measure from the end of the pusher foot to the middle of the infrared sensor.
2. Enter the password and press .
- Note: By default, the TigerStop password is set to the serial number.*
3. Enter the measurement.
4. Press the [Done] soft key to save the parameter.

## IR Offset

```
%H <IROffset> Lasr
IROffset = 1.950in
New Value =
Done
```

IR Offset tell a TigerSaw saw system the distance from the ultraviolet sensor to the infrared length sensor when using crayon defect marking.

### To change IR Offset...

1. Measure from the middle of the infrared sensor to the middle of the ultraviolet sensor.
2. Enter the password and press .
- Note: By default, the TigerStop password is set to the serial number.*
3. Enter the measurement.
4. Press the [Done] soft key to save the parameter.

## PF Down

```
%H <PF Down> Lasr
PF Down = 24.000in
New Value =
Done
```

PF Down sets the distance from zero that the TigerSaw scanning pusher foot will start to lower when moving towards the saw. Setting the PF Down too low will cause the pusher foot to crash into the saw.

### To change PF Down...

1. Enter the password and press .
- Note: By default, the TigerStop password is set to the serial number.*
2. Enter the new PF Down value.
3. Press the [Done] soft key to save the parameter.

## Margin

```
%H <Margin> Lasr
Margin = 0.000in
New Value=
Done
```

The Margin setting will make a TigerSaw saw system cut a set distance from the crayon mark when using the crayon defecting system.

## To change Margin...

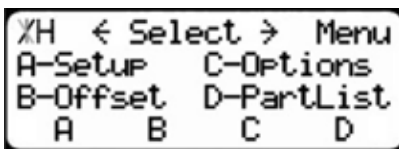
1. Enter the password and press .

Note: By default, the TigerStop password is set to the serial number.

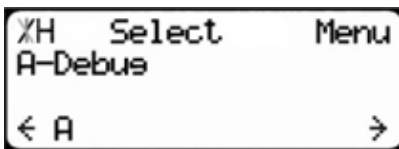
2. Enter the new Margin value.
3. Press the [Done] soft key to save the parameter.



# Debug Menu

The Debug Menu contains various debugging tools used by TigerStop Customer Service.

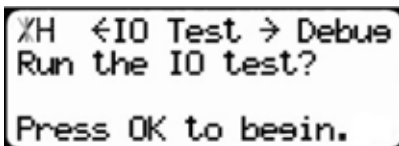


1. At the menu select screen, press  twice to view menu select screen 3.





2. Press the [Debug] soft key to access the Laser menu.
3. Press  or  to scroll through the settings.

## I/O Test

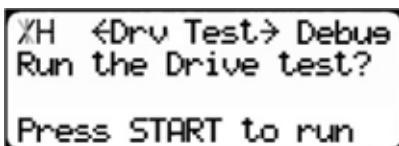


The I/O Test is a diagnostic test that checks the inputs and outputs on the TigerStop motor box. This test will run for 1 minute and then display errors.

## To run the I/O Test...

1. Unplug the I/O cable going to the TigerStop motor box.
2. Press  to run the I/O test.
3. The I/O test will run for 1 minute. Once complete, TigerStop will display the results.
4. Press  to exit the test.

## Drive Test



The Drive Test measures how much force it takes to move the TigerStop carriage through the beam. Once started, the routine will move the carriage automatically. **Stay clear!** Once finished, TigerStop will display the peak drive in both directions.

## To run the Drive Test...

1. Ensure the area is clear. TigerStop will move automatically during this test.
2. Press **START** to run the test.  
*Note: TigerStop will move between its end limit sensors.*
3. TigerStop will display the test results.
4. Press **STOP** to exit the test.

## I/O Mask

```
%H  <IO Mask> Debus
Configure the IO
bits?
Press OK to begin.
```

The I/O Mask allows you to reverse the way that the I/O points work. Masked bits will remain masked, even when powered down.

## To set the I/O Mask...

1. Press **OK** to begin.

```
%H  IO Mask  Debus
Set which IO mask?
A-Input      C-Output
A            C
```

2. Choose to mask Inputs or Outputs.

3. Select the bit you want to mask by using **←** or **→**.

```
%H  IO Mask  Debus
Bits:      1234
Inverted:  x
Press CANCEL to exit
```

4. Press **OK** to mask the bit.

5. Press **CANCEL** to exit the I/O Mask.

## Debug Mode

```
%H  < Debus > Debus
Debug Mode is:
          OFF
          ↑  ↓  Done
```

Debug Mode is used by TigerStop Customer Service to access hidden parameters. Contact Customer Service if you need to access Debug Mode.

# Lists

The TigerStop List function allows you to run, view, edit and clear part lists from TigerStop memory.

```
%H                      Ready
Position = Current
Next     =
          Calib Show
```

1. Start at the Ready Screen.
2. Press the [Show] soft key.



```

XH                      Ready
Position = Current
Next      =
Menu Incr PrSet List

```

3. Press the [List] soft key.

```

TH  Enter      List
Partlist#=
Press START to run
View Edit Clear DnLd

```

4. You are now at the List function.

There are 4 types of lists that you can enter.

### Pusher

A pusher list will push material into the tool when cutting parts. When programming a pusher list, you will enter all of your finished part sizes and TigerStop will tell you when you need to load material. Pusher lists can be optimized if you have the TigerStop optimizing upgrade.

### Set Point

A set point list will make TigerStop act as a back stop. When programming a set point list, you will enter absolute positions from the zero point of your tool. Set point lists can be optimized if you have the TigerStop optimizing upgrade.

### Pattern

A pattern list will tell TigerStop to process one material lengths worth of parts in a push feed fashion. It will process this one pattern over and over, pushing the material into the tool until it is told to stop. Pattern lists cannot be optimized from the controller.

### Pull

A pull list will process one material lengths worth of parts, but will pull away from the tools zero point. This is useful when pulling parts through a punch or other similar applications. Pull lists cannot be optimized.

TigerStop can hold 100 part lists. Each one can be programed by hand at the TigerStop controller or can be downloaded using TigerLink 6 downloading software.

## Programming a Pusher List

```

TH  Enter      List
Partlist#=
Press START to run
View Edit Clear DnLd

```

1. At the list interface, enter the list number you wish to program and press the [Edit] soft key.

*Note: List number is a memory slot where the list will be saved in TigerStop memory.*

```

XH  SelectType #1
A-Pusher  C-Pattern
B-Setpoint D-Pull
A      B      C      D

```

2. Press the [Pusher] soft key.

```

XH  Select Opt #1
Optimize Part List?
A-Yes  C-No
A      C

```

3. If you have the TigerStop optimizing upgrade you will be asked if you want to optimize this list. Choose [Yes] or [No] to continue.

*Note: If you do not have the optimizing upgrade, TigerStop will skip this step.*

```

XH  Select H&T  #1
Head & Tail cuts?
A-Global  C-Local
  A        C

```

### Global Head and Tail Cut

Uses the Head and Tail cut setting from the Part List menu as the head and tail cut values.

### Local Head and Tail Cut

Allows you to set a custom head and tail cut that is used for this list only.

```

XH  Line 1>  #1
Length = 0.000in
Quantity= 0
Done

```

```

XH  Line 1>  #1
Length = 24.000in
Quantity=5
Done

```

```

XH  <Line 2>  #1
Length = 0.000in
Quantity= 0
Done


```


```

XH  Complete  #1
Part List saved!
Press START to run
Press CANCEL to exit



```

4. Select if you want to use a Global or a Local head and tail cut.  
*Note: Head and tail cuts are trim cuts at the beginning and end of your material.*

5. You will now be taken to the programming screen. Enter the first part length you wish to process and press .

6. The cursor will drop down to the quantity line. Enter how many parts you want and press .

7. You will now be taken to Line 2. Repeat steps 5 and 6 until you have entered all the parts you want to process. Press the [Done] soft key when you have entered all the parts you wish to process.

8. The list has now been saved. You can press  to run the list or  to exit and return to the Ready Screen.

### Running a Pusher List

```

XH  Ready
Position = Current
Next =
Calib Show

```

```

XH  Ready
Position = Current
Next =
Menu Incr PrSet List

```

```

TH  Enter  List
Partlist#=
Press START to run
View Edit Clear DnLd

```

```

TH  Enter  #1
Enter Stock
Length = 0.000in


```

1. At the Ready Screen, press the [Show] soft key.

2. Press the [List] soft key to access the List interface.

3. Enter the part list number you wish to run followed by .

4. TigerStop will ask for the length of your material.

5. Enter the length and press .

6. TigerStop will now move to a Load Offset position.

*Note: This position will be the entered stock length plus the value of the Load Offset setting in the Part List menu.*

7. Load the material and press **START** to begin processing.

```
TH  Enter      #1
Enter Stock
Length  =  0.000in
```

8. When TigerStop has finished processing all the parts it can fit on one stock length, you will be asked to enter a new stock length.

9. Enter the length and press **START** to continue.

```
%H  Run  1  List
Part List is empty
A-Reset  C-Exit
A         C
```

10. When TigerStop has processed all the parts, you will be asked if you want to reset the list from the beginning or if you want to exit to the Ready Screen.

Note: When running a Pusher list, you are required to have a minimum limit of 0 or less than 0. If you have a minimum limit greater than 0, TigerStop will subtract the value of your minimum limit from the stock length.

## Programming a Set Point List

```
TH  Enter      List
Partlist#=
Press START to run
View Edit Clear DnLd
```

1. At the list interface, enter the list number you wish to program and press the [Edit] soft key.

Note: List number is a memory slot where the list will be saved in TigerStop memory.

```
%H  SelectType #1
A-Pusher  C-Pattern
B-Setpoint D-Pull
A         B         C         D
```


2. Press the [Setpoint] soft key.

```
%H  Select Opt #1
Optimize Part List?
A-Yes      C-No
A          C
```


3. If you have the TigerStop optimizing upgrade you will be asked if you want to optimize this list. Choose [Yes] or [No] to continue.

Note: If you do not have the optimizing upgrade, TigerStop will skip this step.

```
%H  Line 1> #1
Length  =  0.000in
Quantity=  0
Done
```

4. You will now be taken to the programming screen. Enter the first part length you wish to process and press .


```
%H  Line 1> #1
Length  =  24.000in
Quantity=5
Done
```

5. The cursor will now drop down to the quantity line. Enter how many parts you want and press .

```
%H  <Line 2> #1
Length  =  0.000in
Quantity=  0
Done
```

6. You will now be taken to Line 2. Repeat steps 4 and 5 until you have entered all the parts you want to process. Press the [Done] soft key when you have entered all the parts you wish to process.

```
%H  Complete #1
Part List saved!
Press START to run
Press CANCEL to exit
```

7. The list has now been saved. You can press **START** to run the list. Press  to exit and return to the Ready Screen.

## Running a Set Point List

```
%H      Ready
Position = Current
Next     =
Calib Show
```

1. At the Ready Screen, press the [Show] soft key.

```
%H      Ready
Position = Current
Next     =
Menu Incr PrSet List
```

2. Press the [List] soft key to access the List interface.

```
TH      Enter      List
Partlist# =
Press START to run
View Edit Clear DnLd
```

3. Enter the part list number you wish to run followed by **START**.

```
TH      Enter      #1
Enter Stock
Length  = 0.000in
```

4. If you have the TigerStop optimizing upgrade, you will be asked to enter the stock material length. Enter the length and press **START**.

*Note: If you do not have the optimizing upgrade, TigerStop will skip this step.*

5. TigerStop will act as a back stop and will treat each length you entered as an absolute value from the tools zero point. Cycle your tool and press **START** to move to the next length.

```
%H      Run 1      List
Part List is empty
A-Reset  C-Exit
A         C
```

6. When TigerStop has processed all the parts, you will be asked if you want to reset the list from the beginning or if you want to exit to the Ready Screen.

## Programming a Pattern List

Pattern lists push material into the tool, but will cut the same pattern of parts on every stock length.

Pattern lists follow specific rules:

- Patterns can only use a local head and tail cut.
- Patterns can only have one stock length worth of parts.
- The stock length cannot change in the middle of the list.
- Patterns cannot be optimized.

```
TH      Enter      List
Partlist# =
Press START to run
View Edit Clear DnLd
```

1. At the list interface, enter the list number you wish to program and press the [Edit] soft key.

*Note: List number is a memory slot where the list will be saved in TigerStop memory.*


```
%H      SelectType #1
A-Pusher  C-Pattern
B-Setpoint D-Pull
A         B         C         D
```

2. Press the [Pattern] soft key.


```
%H      Head Out  #1
Head Out = 0.000in
New value=
```

3. Enter your head cut value and press .

```
%H Tail Cut #1
Tail Cut = 0.000in
New value=
```


4. Enter your tail cut value and press .

```
TH Enter #1
Enter Stock
Length = 0.000in
```


5. TigerStop will now ask you for your material length. Enter the stock length followed by .

Note: When running a Pattern list, you are required to have a minimum limit of 0 or less than 0. If you have a minimum limit greater than 0, TigerStop will subtract the value of your minimum limit from the stock length.

```
%H < Line 1 > #1
Remainder= 88.125in
Length = 0.000in
Quantity = 0 Done
```

6. You will now be taken to the programming screen. Enter the first part you wish to process and press .

```
%H < Line 1 > #1
Remainder= 88.125in
Length = 0.000in
Quantity = 0 Done
```

7. The cursor will now drop down to the quantity line. Enter how many parts you want and press .

Note: When programming, Pattern lists keep a running count of how much material you have left. This is displayed as the remainder. The remainder takes head cuts, tail cuts and kerf into its calculation.

## Running a Pattern List

```
%H Ready
Position = Current
Next =
Calib Show
```

1. At the Ready Screen, press the [Show] soft key.


```
%H Ready
Position = Current
Next =
Menu Incr PrSet List
```

2. Press the [List] soft key to access the List interface.

```
TH Enter List
Partlist#=
Press START to run
View Edit Clear DnLd
```

3. Enter the part list number you wish to run followed by .

```
%H Enter List
Done= 0
Goal= 0
Press START to move.
```

TigerStop will display the Goal screen. This screen shows how many patterns you have done and how many you want to do. To set the goal, enter the number of times you want to run this pattern and press .

4. Press  to start the list.

Note: The number of Done patterns will not save if you exit the list.

5. TigerStop will now move to a Load Offset position.

Note: This position will be the entered stock length plus the value of the Load Offset setting in the Part List menu.


6. Load the material and press  to begin processing.

```

XH   Enter      List
Done=    1
Goal=    0
Press START to move.

```

When the pattern is finished you will be taken back to the Goal screen.

The done line will increment by 1. Press  to exit to the Ready Screen.

## Programming a Pull List

Pull lists pull material away from the tool, but will process the same pattern on every stock length. Pull lists follow specific rules:

- Pull lists can only use a local head and tail cut.
- Pull lists can only have one stock length worth of parts.
- The stock length cannot change in the middle of the list.
- Pull lists cannot be optimized.

```

TH   Enter      List
Partlist# =
Press START to run
View Edit Clear DnLd

```

1. At the list interface, enter the list number you wish to program and press the [Edit] soft key.

*Note: List number is a memory slot where the list will be saved in TigerStop memory.*

```

XH   SelectType #1
A-Pusher  C-Pattern
B-Setpoint D-Pull
A         B         C         D


```

2. Press the [Pull] soft key.

```

XH   Head Cut   #1
Head Cut = 0.000in
New value=


```

3. Enter your head cut value and press .

```

XH   Tail Cut   #1
Tail Cut = 0.000in
New value=


```

4. Enter your tail cut value and press .

```

TH   Enter      #1
Enter Stock
Length = 0.000in

```


5. TigerStop will now ask you for your material length. Enter the stock length followed by .

*Note: When running a Pull list, you are required to have a minimum limit of 0 or less than 0. If you have a minimum limit greater than 0, TigerStop will subtract the value of your minimum limit from the stock length.*

```

XH   < Line 1 > #1
Remainder= 88.125in
Length = 0.000in
Quantity = 0 Done


```

6. You will now be taken to the programming screen. Enter the first part you wish to process and press .

```

XH   < Line 1 > #1
Remainder= 88.125in
Length = 0.000in
Quantity = 0 Done

```

7. The cursor will now drop down to the quantity line. Enter how many parts you want and press .

*Note: When programming, Pull lists keep a running count of how much material you have left. This is displayed as the remainder. The remainder takes head cuts, tail cuts and kerf into its calculation.*



## Running a Pull List

```
%H          Ready
Position =   Current
Next       =
          Calib Show
```

```
%H          Ready
Position =   Current
Next       =
Menu Incr PrSet List
```

```
TH  Enter    List
Partlist#=
Press START to run
View Edit Clear DnLd
```

```
%H  Enter    List
Done=    0
Goal=    0
Press START to move.
```

1. At the Ready Screen, press the [Show] soft key.

2. Press the [List] soft key to access the List interface.

3. Enter the part list number you wish to run followed by **START**.

4. TigerStop will display the Goal screen. This screen shows how many pull cycles you have done and how many you want to do. To set the goal, enter the number of times you want to run this pull list and press **=**.

5. Press **START** to start the list.

Note: The number of Done pull lists will not save if you exit the list.

6. TigerStop will now move to a Load Offset position.

Note: This position will be the entered stock length plus the value of the Load Offset setting in the Part List menu.

7. Load the material and press **START** to begin processing.

```
%H  Enter    List
Done=    1
Goal=    0
Press START to move.
```

When the pull list is finished you will be taken back to the Goal screen.

The done line will increment by 1. Press **STOP** to exit to the Ready Screen.

## Editing Lists

```
%H          Ready
Position =   Current
Next       =
          Calib Show
```

```
%H          Ready
Position =   Current
Next       =
Menu Incr PrSet List
```

```
TH  Enter    List
Partlist#=
Press START to run
View Edit Clear DnLd
```

1. At the Ready Screen, press the [Show] soft key.

2. Press the [List] soft key to access the List interface.

3. Enter the part list number you wish to edit and press the [Edit] soft key.

```

/H  ChanseType  #1
Pusher Part List
A-Cont.  C-Chanse
A        C

```

4. If you want to edit the part list type, press the [Change] soft key. Press the [Continue] soft key to continue.

```

/H  Chanse Opt  #1
Non-optimized PL
A-Cont.  C-Chanse
A        C

```



5. If you have the TigerStop optimizing upgrade you will be asked to turn on or off the optimization. Press the [Change] soft key to edit. Press the [Continue] soft key to continue.



```

/H  Chanse H&T  #1
H&T Cuts = Global
A-Cont.  C-Chanse
A        C

```

6. If you want to edit the head or tail cut, press the [Change] soft key. Press the [Continue] soft key to continue.

7. You will now be able to edit individual part lengths and quantities. Use  and  to scroll through the parts.

Once you have found one that you want to edit, enter the new length and press . The cursor will jump down to the quantity. Enter a new quantity and press . Press the [Done] soft key to save and exit the list.

## Deleting Lists from Memory

```

/H                      Ready
Position = Current
Next     =
Calib Show

```

1. At the Ready Screen, press the [Show] soft key.

```

/H                      Ready
Position = Current
Next     =
Menu Incr PrSet List

```

2. Press the [List] soft key to access the List interface.

```

/TH  Enter      List
Partlist#=
Press START to run
View Edit Clear DnLd


```

3. Enter the part list number you wish to delete and press the [Clear] soft key.

```

/H  Clear 1 → List
Pusher, 15cuts
Press OK to clear.
←      View Edit      →

```

4. TigerStop will show you a summary of the list. Press  to clear the list.



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