

# Entering Cut Lists

TigerStop has a versatile part list feature that allows users to enter large lists of part for use with the TigerStop Dynamic Optimization upgrade. This lets the user run, view, edit, clear and optimize lists of parts, then processes the parts quickly and accurately.

There are 4 types of lists that you can enter.

## Pusher

A pusher list will tell TigerStop to push the material into the tool. You can enter as many parts as you like into a pusher list and TigerStop will tell you when it needs another piece of material. Pusher lists can be optimized if you have the TigerStop Dynamic Optimizing upgrade.

## Set Point

A set point list will tell TigerStop to act as a stop. It will treat each length you enter as an absolute value from your zero point. Set point lists can be optimized if you have the TigerStop Dynamic Optimizing upgrade.

## Pattern

A pattern list will tell TigerStop to process one stock lengths worth of parts in a push feed fashion. It will run the same pattern of parts until its told to stop. Pattern lists cannot be optimized.

## Pull

A pull list works just like a pattern except it pulls away from the zero point instead of pushing towards it. Pull lists cannot be optimized.

## Programming a List

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

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

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

2. A new set of soft key options have appeared. Press the [List] soft key to access the List interface.

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

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

*Note: the list number is a memory slot that houses the list. You can choose numbers 1 - 100.*

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

4. Select the type of list you would like to program.

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

5. TigerStop will ask you if you want to optimize the list for material yield. If you choose no, TigerStop will process the list exactly as entered and will NOT optimize for material yield.


```
%H Change H&T #1
H&T Cuts = Global
A-Cont. C-Change
A C
```

6. 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 ends of your material.*


**Global** - Uses the head and tail cut setting from the Part List menu

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

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

7. You will now be taken to the programming screen for line 1. Enter the length of the part you wish to process and press . In this example, I will tell TigerStop I want to cut a 24 inch part.

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

8. The cursor will now drop to the quantity. Enter how many parts you want, followed by . In this example, I will tell TigerStop that I want 5 parts.

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

9. You will now be taken to line 2. Repeat steps 7 and 8 until you have entered all the parts you want to process.

*Note: You can also download all the parts straight from your design file. Downloading is a faster way of importing parts for use with the TigerStop Optimizer.*

10. Press the [Done] soft key when all parts are entered.

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

11. The list has now been saved.

12. Press  to run the list.

### Creating a Backboard Defecting & Optimizing List

Backboard Defecting & Optimizing is a process that allows you to quickly and easily cut around material defects while optimizing the clear stock for better material yield. It is accomplished using a standard Set Point list, TigerStop's Dynamic Optimization upgrade and a back fence ruler.

#### Program a Set Point List

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

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

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

2. A new set of soft key options have appeared. Press the [List] soft key to access the List interface.

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

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

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

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

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

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

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


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


*Note: the list number is a memory slot that houses the list. You can choose numbers 1 - 100.*

4. Choose Set Point list.

5. TigerStop will ask if you want to optimize. Choose Yes.

*Note: If you do not see this option, contact TigerStop Customer Service.*


6. You will now be taken to the programming screen for line 1. Enter the length of the part you wish to process and press . In this example, I will tell TigerStop I want to cut a 24 inch part.

7. The cursor will now drop to the quantity. Enter how many parts you want, followed by . In this example, I will tell TigerStop that I want 5 parts.

8. You will now be taken to line 2. Repeat steps 6 and 7 until you have entered all the parts you want to process.

*Note: You can also download all the parts straight from a design file. Downloading is a faster way of importing parts for use with TigerStop Dynamic Optimization.*

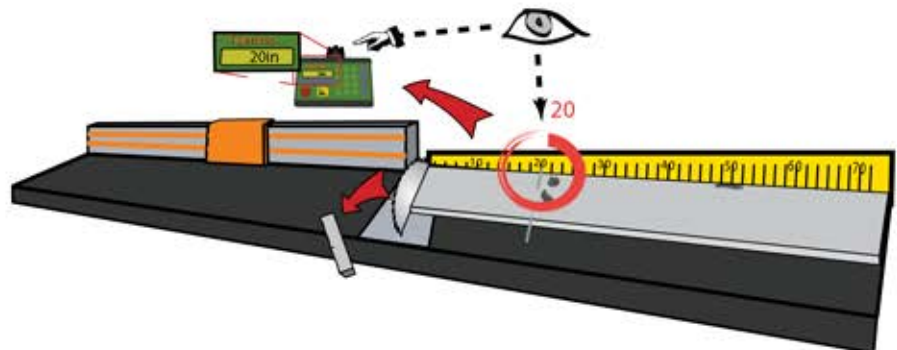
9. Press the [Done] soft key once you have entered all parts.

10. The list has now been saved. Press  to run the list.

## Running the list

1. First, make your trim cut. After the trim cut, measure up to your first defect.

*Note: If no defect is present, measure up to the end of the material.*



TH Enter #1  
Enter Stock  
Length = 0.000in

2. TigerStop will ask you to enter the stock length. Enter what you measured and press **START**.

3. TigerStop will optimize the material up to the defect and will use as much of the material as mathematically possible.

Note: If you are using the Standard Interconnect Kit, TigerStop will move to the next part length when tool cycle is complete.

4. Cut out your defect.

5. TigerStop will once again ask you to enter the stock length. Measure up to the next defect, enter this

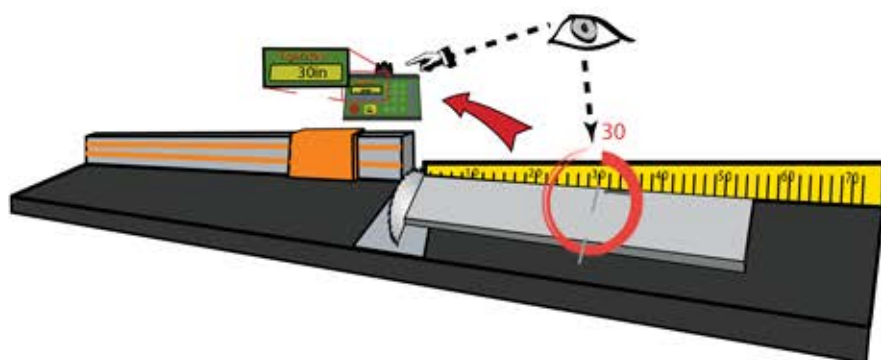
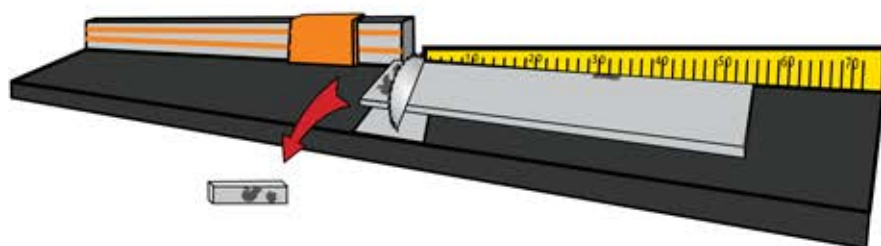
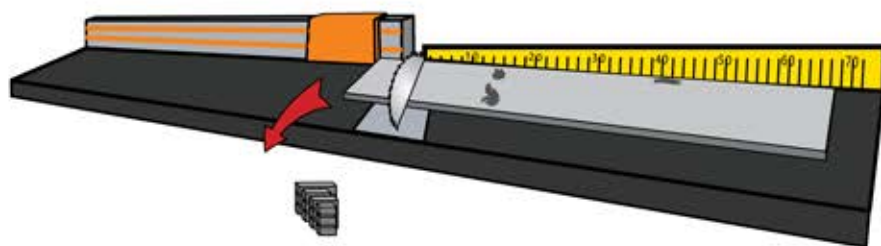
measurement and press

**START**

Note: If no defect is present, measure up to the end of the material.

6. TigerStop will optimize the material up to the defect and will use as much of the material as possible.

7. Continue in this fashion until the entire stock is used. If you have more parts to cut, start at step 1 with a new piece of material.



## Why Use BackBoard Defecting & Optimizing?

- Dynamic Optimization™ determines the best use of material, so the operator (unskilled worker or pro fabricator) only has to focus on feeding parts and cutting.
- TigerStop® moves to the correct position up to .004" so the operator never has to use a tape measure or set a manual stop ever again.
- TigerStop® reduces station setup time between different cut lengths and allows the operator to optimize for defects like forklift stabs, shipping damage, dents, or aesthetic blemishes, while getting optimal yield.
- TigerStop® increases accuracy. The operator doesn't have to worry about cutting errors or the associated costs of rework. Quality control concerns are no longer a bottleneck.
- Dynamic Optimization™ reduces scrap waste and shelving costs. Purchase less raw footage while

sending fewer pounds back to the recycler.

- A TigerStop® Dynamic Optimizing™ station can even be used by an unskilled worker. Top paid Fabricators and skilled workers can better use their time managing the shop or doing work requiring greater expertise.

**Contact TigerStop Customer Service to Enable Your Optimizing Upgrade!**  
**(360) 254-0661**  
**[service@tigerstop.com](mailto:service@tigerstop.com)**