

Gangstop



Fig. 1

Description and Use

The Gangstop is a versatile, heavy-duty attachment composed of an extension sleeve (red, Fig. 2) and a pusher (blue, Fig. 3), designed to provide additional width for both push feed and set point stop applications. It has an overall maximum length (including extension sleeve) of 38¼", a height of 3", and a width of 10". It comes from the factory fully assembled (Fig. 1).

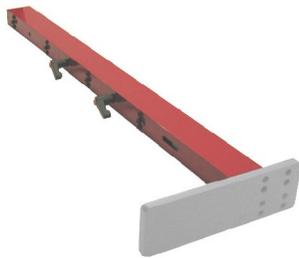


Fig. 2

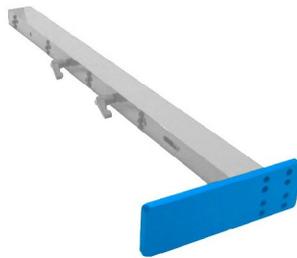


Fig. 3

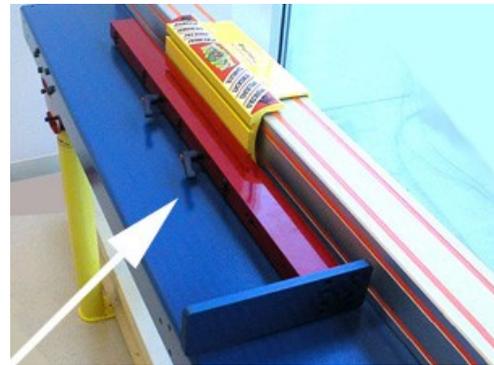


Fig. 4

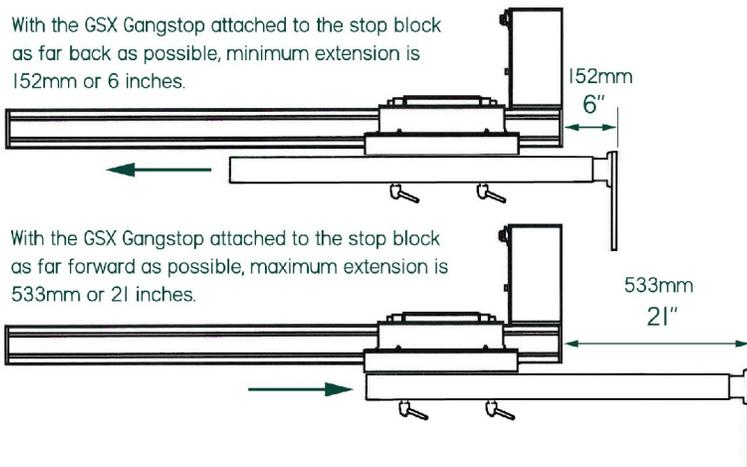


Fig. 5

The Gangstop can be attached to the flip-away stop as far back as possible for a minimum extension of 152mm or 6 inches beyond the end of the TigerStop beam, or as far forward as possible for a maximum extension of 533mm or 21 inches (Fig. 5). After adjusting the Gangstop to the desired position, it is locked down by means of ratchet handles (Fig. 4).

► **IMPORTANT! After adding a gangstop...**

- Version 5.03+, **Run Auto Setup 3 times** to re-zero your machine (page 3).
- Version 3.5 ~ 4.72, **Calibrate** your machine to re-zero it (page 4).



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Gangstop Closeup

Parts Specifications

Component parts of the Gangstop can be ordered from TigerStop Customer Service in case of damage or loss.

The Gangstop is assembled using the hardware and other parts as shown (Figs. 6, 7).

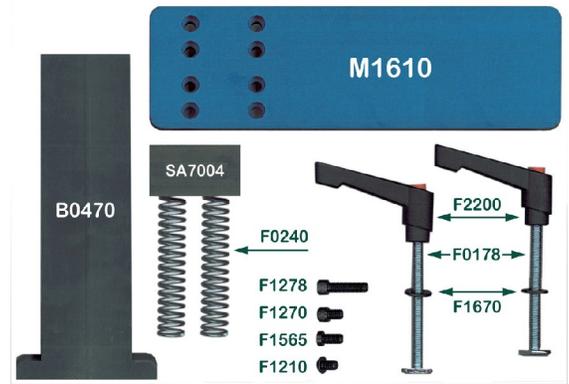


Fig. 6

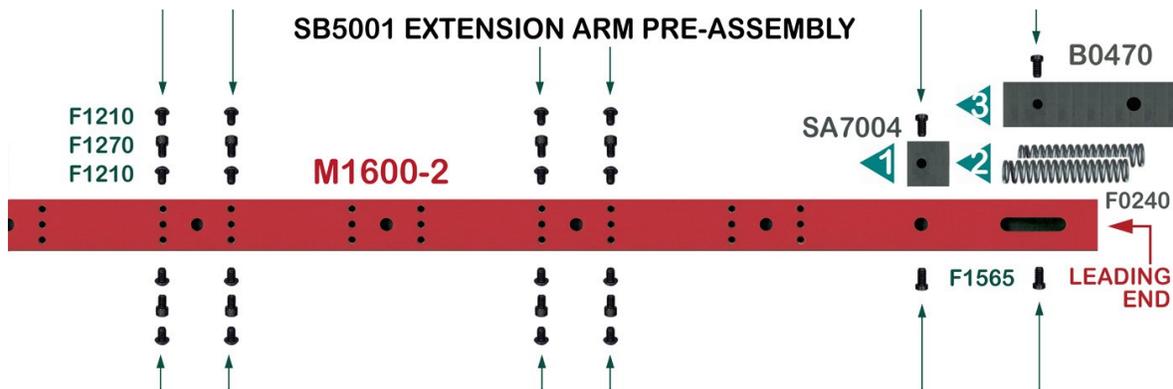


Fig. 7

Assembly Instructions

The Gangstop comes fully assembled from the factory, but if it is necessary to disassemble and reassemble it, follow these steps:

1. Insert the SA7004 block, spring divots facing out, into the leading end of M1600-2 tube. Slide it along until the holes line up with the holes in the tube. Insert and tighten down (2) F1565 screws, one on each side of the tube.
2. Insert the (2) springs into the M1600-2 tube, and make sure they are seated in the divots in the SA7004 block.
3. Insert the B0470 Gangstop plate attachment block into the leading end of the M1600-2 tube. Push hard on it, until you see the holes in the foot through the slotted holes in the tube. Insert and tighten down (2) F1565 screws, one on each side of the tube.
4. Insert and tighten down the (16) F1210 screws in the outer holes of the 2nd and 4th hole sets, eight on each side of the tube.
5. Insert and tighten down the (8) F1270 screws in the center holes of the 2nd and 4th hole sets, four on each side of the tube.
6. Assemble the M1610 gangstop plate to the B0470 foot using (4) F1278 screws. Fully tighten the screws.
7. Assemble the (2) F2200 handles with the F1670 washers and F0178 T-bolts, and screw them into the holes at the desired positions.



Version 5.03+

Run Auto Setup 3 times for maximum accuracy

```
XH Ready
Position = Current
Next =
Menu Incr PrSet List
  A   B   C   D
```

1. At the Ready screen press [A] to select **Menu**.

```
XH Menu
Password =
```

2. Enter the password and press  **OK**.

The TigerStop password is set to the serial number at the factory.

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

3. Press [A] to access **Setup**.

4.  |  to scroll to Auto Setup.

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

Make sure the feed table is clear. Nothing should lie in the path of the stop.

5. Press [START] to run auto setup.

```
XH <RunSetup> Setup
Position = ##.###in
Movine to first
calibration point.
```

The stop moves into position for the user to make a sample cut.

```
XH <RunSetup> Setup
Cycle the tool.
Measure the Part.
Press OK to continue
```

6. When the stop is in position, cut the sample piece and measure it. It should be close to the display length.

7. Press  **OK** to continue.

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

8. Enter the actual length of the sample cut.

9. Press [START] to continue.

```
XH <RunSetup> Setup
Position = ##.###in
Movine to second
calibration point.
```

The stop moves to a second position for another sample cut.

```
XH <RunSetup> Setup
Cycle the tool.
Measure the Part.
Press OK to continue
```

10. When the stop is in position, cut the sample piece and measure it. It should be close to the display length.

11. Press  **OK** to continue.

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

12. Enter the actual length of the sample cut.

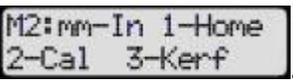
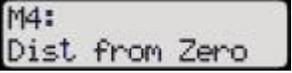
13. Press [START] to continue. The display flashes "Success!" and then quickly reverts to the Auto Setup screen.

14. Press [STOP] to exit Menu.

Version 3.5 ~ 4.72

Calibrate TigerStop

Calibrate TigerStop to re-set its distance from zero after adding an attachment to the flip-away stop.

1. From a position at least 12" out, enter a length of 10". Press   . The stop moves inbound to a position 10" from the saw blade.
2. Cut a piece of stock at this length and carefully measure it. It should be right on 10". If it is accurate, no need to calibrate. Be sure to use an accurate measuring tool. TigerStop can be only as accurate as you make it!
3. If the sample cut measured 10¼" instead of 10", the machine must be calibrated.
4. Press  . The M2 menu displays .
5. Press . The M4 menu displays . You enter the actual measured length of your sample piece at this screen.
6. Press       . This will save the original position of 10" as 10.25", correcting the inaccuracy.
7. Cut another sample piece using the same procedure, starting at step 1 above.
8. If the sample piece measures the same as the position shown on screen, TigerStop is calibrated. If it is still off, repeat the process.