

TigerStop[®] TigerLink[®] 3.2

May 2006

User Guide



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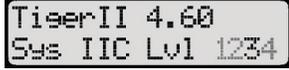
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TigerLink 3.2



Requirements

- TigerStop® with Level 3 or higher software.

- MicroSoft Windows 95 , 98 or NT.
- An available Com Port is also needed on your Windows PC.

Install TigerLink 3.2 from the CD

1. Insert the TigerLink 3.2 CD into the drive on your computer.
2. Create a TigerLink folder on your computer.
3. Copy the contents of the CD to the folder you just created.



4. Create a shortcut to TigerLink 3.2 on your desktop .

Run TigerLink 3.2



Fig. 1



Fig. 2

1. Run TigerLink 3.2 from the shortcut on your desktop.

The main screen (Fig. 1) displays the status of your TigerStop and other important information. The status display will reflect the cut list information, or the fact that the TigerStop was not detected. The first time you run TigerLink, Status will display "Tiger not found."

2. Select the proper comm port setting from the pull down menus (Fig. 2), and TigerLink will search for the TigerStop again. When communication is successful, Status will display the status of your selected cut list.

Start a new link

1. To start a new link, select New Link under the File menu. This will open a new window (Fig. 3) to browse for the file that you want to link. Setup will have placed a Jobs folder on your desktop where Sample1.csv will be. Browse to find this file, click on it, and click Open.

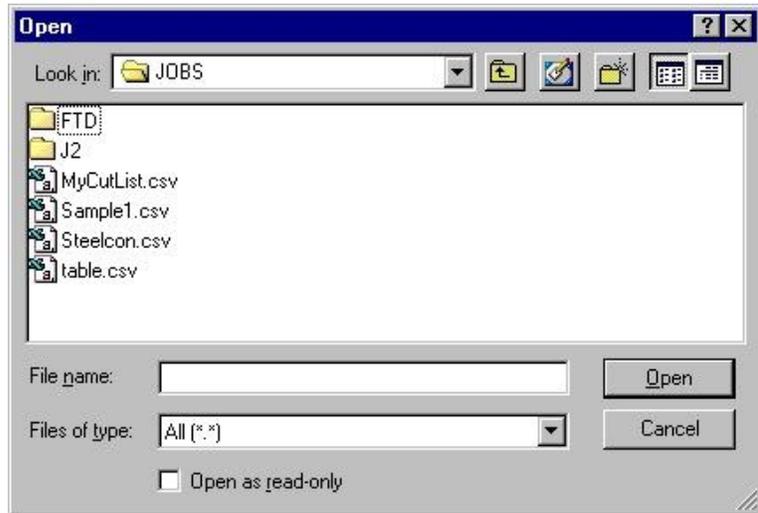


Fig. 3

2. TigerLink will confirm the path to your file (Fig. 4). If the data displayed is correct, click Accept. Otherwise, you can browse until you locate the file you want.



Fig. 4

3. Click Next to continue.

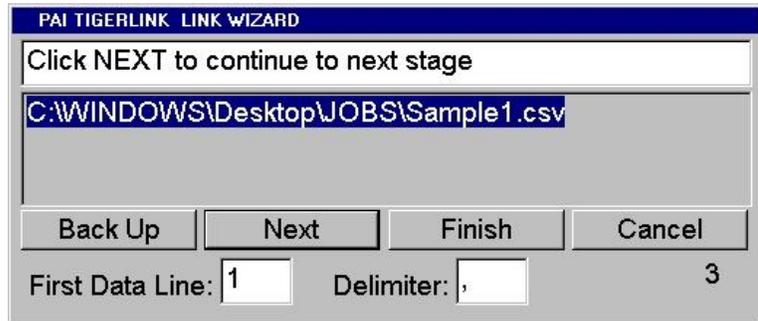


Fig. 5

4. Select the first line of the file with actual data. TigerLink will ignore any data above your start point. Many cut list programs have a title line (Fig. 6).

Do NOT select this line.

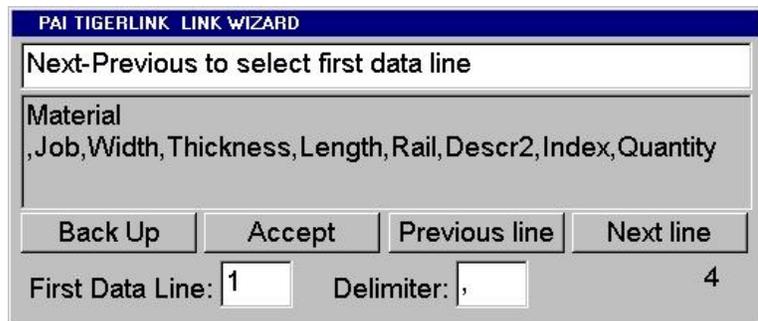


Fig. 6

5. Use the Previous Line and Next line buttons (click on them) to find the first line of the file with actual data (Fig. 7), and click Accept.
6. Click Next to move to the next screen.

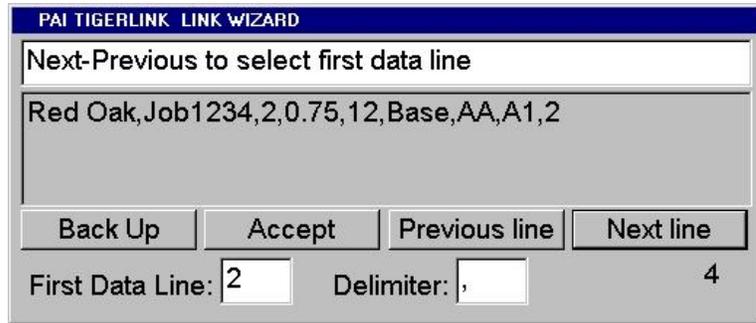


Fig. 7

7. TigerLink also needs to have the **data delimiter** selected (Fig. 8). In most files the comma (,) is used. Use the [<] [>] buttons to select the delimiter character used in your data. The cursor will jump from item to item in the line. When the cursor is on the delimiter, click Accept.



Fig. 8

8. Click Next to move to the next screen.
9. TigerLink will ask you if all the fields listed at the bottom of the window are OK (Fig. 9).
10. If these are correct click Finish. If you have to make changes, click Restart.



Fig. 9

11. A name window will appear (Fig. 10) asking you to enter the Link name.

The default that TigerLink uses is the extension.

12. Click OK to accept that name.



Fig. 10

Organize your cut list

Data	Description	Print Order	Header
Red Oak	Material #1	#1	Material
Job1234	-	-	-
2	Material #2	#4	-
0.75	Material #3	#5	-
12	Length	#2	Length
Base	-	-	-
AA	-	-	-
A1	-	-	-
2	Quantity	#3	Qty

Fig. 11

When the Data Manager (Fig. 11) first appears, there will be only dashes in the three columns Description, Print Order, and Header. In the example above, the dashes have already been changed to the field names selected using the procedure described below beginning at step 1.

TigerLink displays the first line of Data in columnar format (Fig. 11) so you can organize and sort your cut list. You must select at least one material field, one length field, and one quantity field for TigerLink to process and sort the data in your cut list. The material fields will allow sorting of cuts into separate, different aspects of the cut list.

1. Click the dash in the Description column at the line beginning with 2 which is the last line of the list. This is the Quantity field. The Material Select window (Fig. 12) will open to let you select the field name which will be inserted in place of the dash.
2. Select Quantity and click OK. The field name Quantity (Fig. 11) now appears under Description.



Fig. 12

You must select at least one material field, but you can select up to three different materials. Selecting more than one material field will narrow the detail of the cut list you send to TigerStop.

If you are not printing, ignore the Print Order and Header columns. Leave them as dashes.

3. Click OK (Fig. 12) to advance to the Job Manager. Continue at Use the Job Manager.

If you ARE printing to labels, continue at Organize for Label Printing.

Organize for label printing

Data	Description	Print Order	Header
Red Oak	Material #1	#1	Material
Job1234	.	.	.
2	Material #2	#4	.
0.75	Material #3	#5	.
12	Length	#2	Length
Base	.	.	.
AA	.	.	.
A1	.	.	.
2	Quantity	#3	Qty

Fig. 13

For printing labels using TigerStop Level 4 you also need to select the fields under Print Order and Header columns (Fig. 13). If you do not set this information, the only fields that will print are the cut list name, the part length, and the quantity. To print any fields from TigerLink, set the Print Order for each field that you want printed on the label.

1. Click the dash under Print Order that is on the same line as the data that you want printed. The fields default to the line item number, so Line 1 will default to Print Order #1. To change this, use the Up/Down arrow keys in the Print Order window (Fig. 14) to select the desired number. Once you have set all of the fields that you want printed, and the order in which they will print, you can identify the Header information.



Fig. 14



Fig. 15

2. Click the dash under Header across from the Print Order number, and the Printer Header window (Fig. 15) will open to let you to type in the text that you want to be printed on the label. In the above example (Fig. 13), the label would print out as shown in Fig. 16.
3. Click OK (Fig. 15) to advance to the Job Manager.

```
Sample1
0.75 1/2
Material=RedOak
Length =12
Qty    =2
      =2
      =0.75
```

Fig. 16

Use the Job Manager

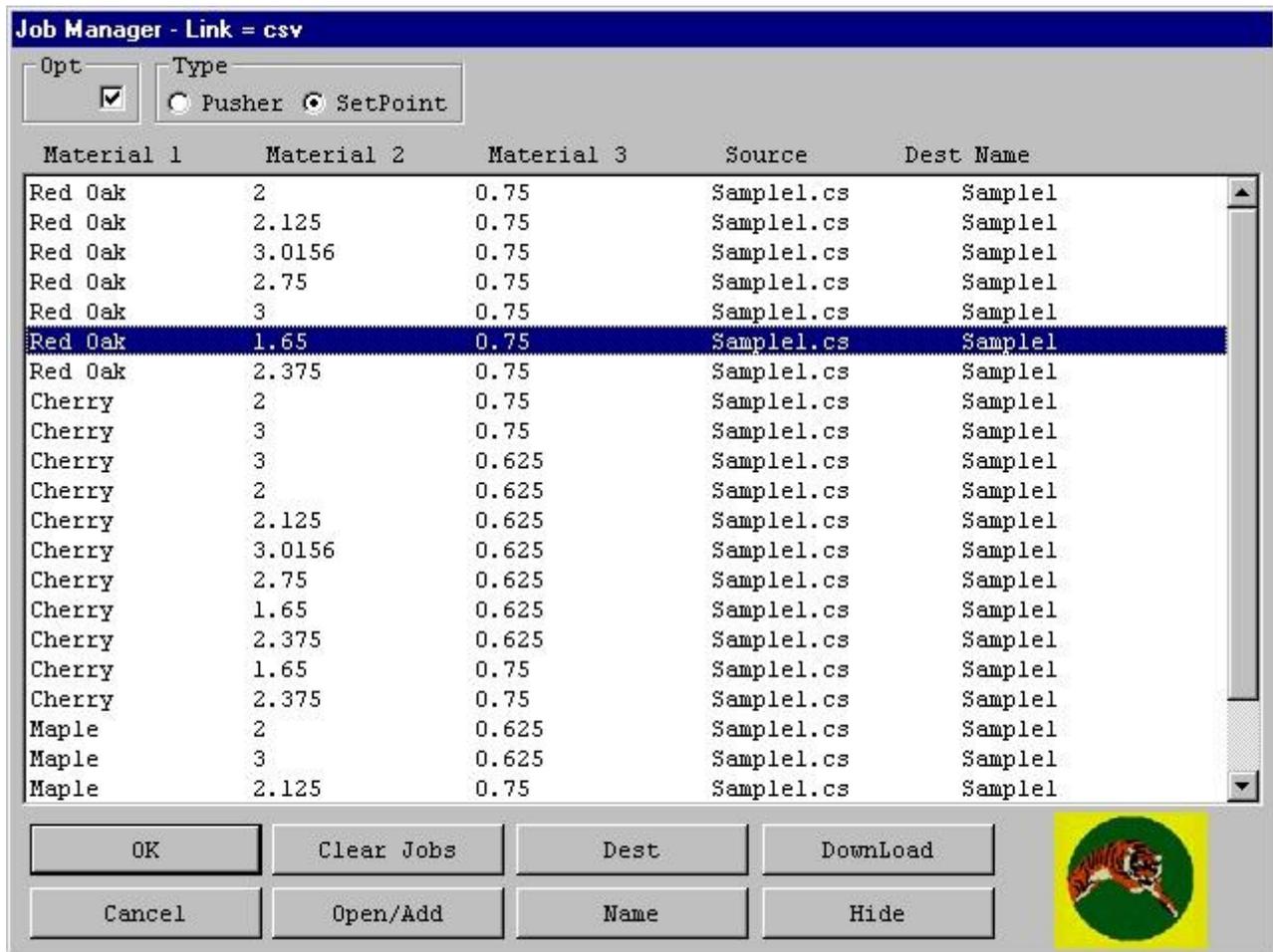


Fig. 17

Concept The Job Manager lets you group multiple lines of data and send them to a cut list in the TigerStop controller.

In the example (Fig. 17), the data has been sorted by Materials 1 and 2.

1. Select the first line with Red Oak and Material 2.

This line has grouped all line items in the cut list that are Red Oak, 2" wide, and 3/4" thick.

2. Next, click the Dest button.

A window will open (Fig. 18) to let you assign a Cut List number in TigerStop memory.

3. Enter a Cut List #, or scroll up to the number you want, and click OK.

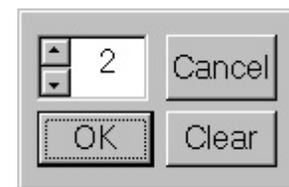


Fig. 18

The Job Manager will record the Cut List number under Dest. You can use standard Windows key strokes for multiple selections.

4. After specifying the Cut List numbers (destinations), click the Download button to send the data to the TigerStop controller.

If there is already data in the cut list number specified, TigerLink will confirm that you want to replace it. TigerLink will then send the data to TigerStop, and it will be ready for you to access at the controller.

 Click the Hide button (Fig. 17) to hide all unassigned data. When the unassigned data is hidden, the button displays Show. In that case, click the Show button to display all data.

Concept  TigerLink will sort the data by the Material selection in the Job Manager. To send the entire cut list (space permitting) to a single cut list, you would sort by the job number. If you have a part number assigned to each piece, sorting by that field would display each part.

The TigerLink 3.2 Main Screen



Fig. 1

Concept → When you start TigerLink it will query TigerStop for status. If the two can communicate, the Main Screen (Fig. 1) displays the status of the cut list, the name (if any) and the mode. TigerStop does not have to be connected to use TigerLink functions that do not interact with the TigerStop controller.

→ The only field you can modify on the main screen is the Cut List box with arrow keys allowing you to scroll through the cut list numbers. If TigerStop is turned on and connected to the computer, the Optimize, Mode, Kerf, Name, and Status fields will change as you scroll through programmed cut list numbers.

Main Screen Functions

File Drop-Down Menu

Comm Drop-Down Menu

Units Drop-Down Menu

Links Menu

Data Man Drop-Down Menu

Job Man Drop-Down Menu

Delete a Cut List with TigerLink

File Drop-Down Menu



Click File and view the drop-down menu.

- New Link (Ctrl+N) lets you start the link process with a new file or new type of cut list.
- Add Link (Ctrl+A) adds a file to a link that has already been established. This lets you set up the same type of file for alternate printing or sorting setups. The linking process is identical to that described in Start a New Link, except that when you get to the Link Name you must select a different name for your new link.
- Lang DownLoad lets you update the language file in your controller.
- OnLine takes an Internet Explorer 4.0 or higher enabled computer with an internet connection to www.Tigerstop.com.
- Exit quits the TigerLink 3.2 program.

Comm Drop-Down Menu



Click Comm and view the drop-down menu.

- The Comm menu lets you setup the communications settings for TigerLink.
- Click on the comm port that you have used to connect TigerStop to the computer. (A check mark will appear at your selection.) TigerLink will look at this port for TigerStop.
- Click Connect to have TigerLink look for the controller's response.

Units Drop-Down Menu



Click Units and view the drop-down menu.

- The Units menu selects the measurement system you are using.
- Be sure to set the units at the TigerStop controller as well.

Links Menu

Click Links and view the screen.

- This screen displays information about all the links you have set up.
- The index tabs at the top of the screen (csv, ccv) are the names that you chose while linking the file.
- The screen displays the available information on the file. From this you can quickly identify all your links, especially if you have one file linked in several different ways.

From this screen you can also delete a link that you have finished using.

- Select the link you no longer need and click Delete.

There is no undoing this action.



➡ The Print Order fields display the line number of the first 4 fields, so you can see quickly how you are printing different labels or sorting the data in your links.

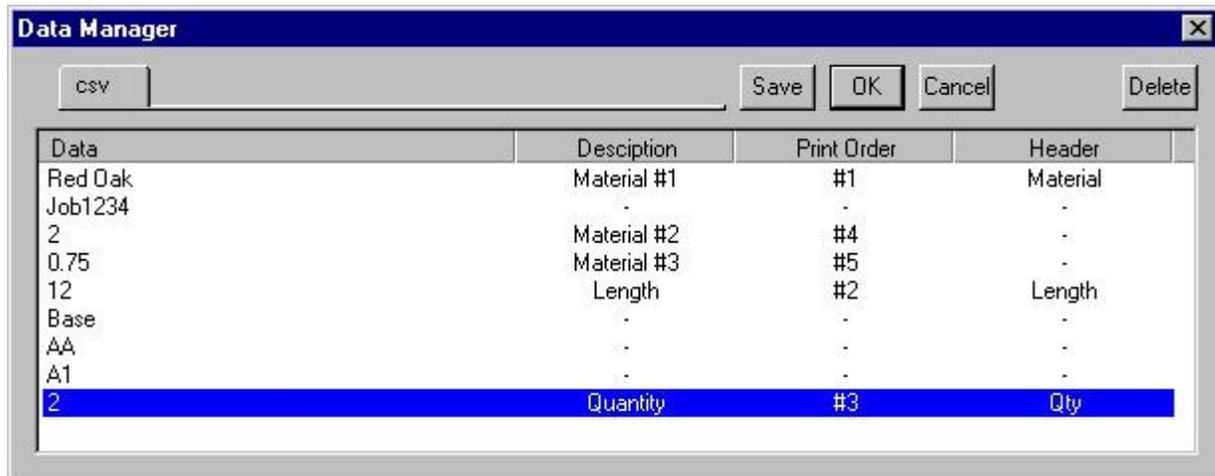
Selecting the Active Link

- If you have several links, the index tab which you click on comes to the front. This is your active link, and the Job Manager will perform its operations using this link.
- Be sure you have the correct link selected at this screen.
- The Job Manager will also display the active link at the top of the window.

Adding a New Link

- To add a new link you must start from the Main Screen and select Add Link (Ctrl+A). Follow the instructions in Start a New Link until you get to the Name step, and select a different name. It will then advance you into the Data Manager and let you set up the actual link fields.

Data Manager



Data	Description	Print Order	Header
Red Oak	Material #1	#1	Material
Job1234	-	-	-
2	Material #2	#4	-
0.75	Material #3	#5	-
12	Length	#2	Length
Base	-	-	-
AA	-	-	-
A1	-	-	-
2	Quantity	#3	Qty

In the Data Manager you have three columns to assign.

- The two on the right (Print Order, Header) are printing fields. If you have a TigerStop Level 3 (TigerOptimizer) this is not used and may be left blank.
- The Data column will display your first line of data only.
- Under the Description column you can identify the material field which will be used to sort the data, the length, and the quantity.
- Clicking on a dash (-) in the Description column will bring up a dialog box.
- Select the correct description for the item and click OK. This dialog box can also be used to clear any previous selection.
- In the Print Order column the dialog box will call up a number. This is the order that information will be printed on the label. If you do not select a Print Order, the field will not print. The Print Order defaults to the line item number. Use the arrow keys to select the number that you want.
- The Header column determines how the printer field will be defined. Field #2 would print out Length = 12. If you do not assign a descriptor, the field will still print but it will only print out the = 12.

Job Manager

Job Manager - Link = csv

Opt Type Pusher SetPoint

Material 1	Material 2	Material 3	Source	Dest Name
Red Oak	2	0.75	Sample1.cs	Sample1
Red Oak	2.125	0.75	Sample1.cs	Sample1
Red Oak	3.0156	0.75	Sample1.cs	Sample1
Red Oak	2.75	0.75	Sample1.cs	Sample1
Red Oak	3	0.75	Sample1	3 Sample1
Red Oak	1.65	0.75	Sample1.cs	Sample1
Red Oak	2.375	0.75	Sample1.cs	Sample1
Cherry	2	0.75	Sample1.cs	Sample1
Cherry	3	0.75	Sample1.cs	2 Sample1
Cherry	3	0.625	Sample1.cs	2 Sample1
Cherry	2	0.625	Sample1.cs	Sample1
Cherry	2.125	0.625	Sample1.cs	Sample1
Cherry	3.0156	0.625	Sample1.cs	Sample1
Cherry	2.75	0.625	Sample1.cs	Sample1
Cherry	1.65	0.625	Sample1.cs	Sample1
Cherry	2.375	0.625	Sample1.cs	Sample1
Cherry	1.65	0.75	Sample1.cs	Sample1
Cherry	2.375	0.75	Sample1.cs	Sample1
Maple	2	0.625	Sample1.cs	Sample1
Maple	3	0.625	Sample1	4 Sample1
Maple	2.125	0.75	Sample1.cs	Sample1

OK Clear Jobs Dest Download

Cancel Open/Add Name Hide



The Job Manager screen is where you select the TigerStop cut list numbers into which you will download your cut lists. Use the standard Windows control keys to select multiple data lines:

- Ctrl to select random lines
- Shift to select a continuous range of lines.

Each line of data represents all the cuts that exactly match the material fields. In the sample above, line 1 contains all the Red Oak Base parts.

1. After selecting your lines of data, click the Dest button and a box opens to let you select a destination cut list number.
2. Once you have assigned all the appropriate data to a cut list, select the right setup for the cut list at the top of the screen:
3. Select either Pusher or SetPoint by clicking on the radial buttons.
4. If optimizing, checkmark the box marked Opt.

Concept  A non-optimized cut list will process the cuts in the order they were entered. An optimized cut list will take the length of material and sort a set of cuts based on your optimizer settings.

TigerLink 3.2 and CabNetWare

Concept → CabNetWare can be easily configured to work with TigerStop. You must first produce a (.B) cut list file.

HowToDoIt → To make CabNetWare create a cut list for TigerStop every time you produce a cut list ...

1. Open your CabNetWare program.
2. Under the HELP menu select About CabNetWare for Windows.
3. This will open a box with a disc icon in the upper corner. Click on the disc icon.
4. Scroll down to the [Cutlist] section and find the LCD= field.
5. Enter B into the field. This produces a (.B) file for each cut list generated.
6. Select Save from the File menu.
7. Select Exit from the File menu.
8. Restart CabNetWare and produce a cut list normally.

CabNetWare should produce a (.B) file in the same directory as your standard cutlist.

||| → TigerLink also needs to know what fields are length and quantity. Below is a sample link. The material fields can be adjusted to fit your needs but the Length and Quantity can not be changed. The data format for the (.B) file is as follows:

CabNetWare descriptors

- Description
- Adjective
- Quantity
- Material
- Room-Cabinet
- Section
- Width
- Length
- Door Style
- #of Lengths
- Banded
- # of Widths
- Banded
- Top Edge Band
- Bottom Edge Band
- Side Edge Band
- Special Operations

Data	Description	Print Order	Header
"Base Cabinet"	Material #3	-	-
"SAMPLE RAISED PANEL DOOR"	-	-	-
1	Quantity	-	-
""	Material #1	-	-
"1-1"	-	-	-
""	-	-	-
""	Material #2	-	-
""	Length	-	-
0	-	-	-
0	-	-	-
""	-	-	-
""	-	-	-
""	-	-	-
""	-	-	-
"06010010"	-	-	-
""	-	-	-
""	-	-	-
""	-	-	-
""	-	-	-
""	-	-	-
""	-	-	-
""	-	-	-

TigerLink 3.2 and Cabinet Vision

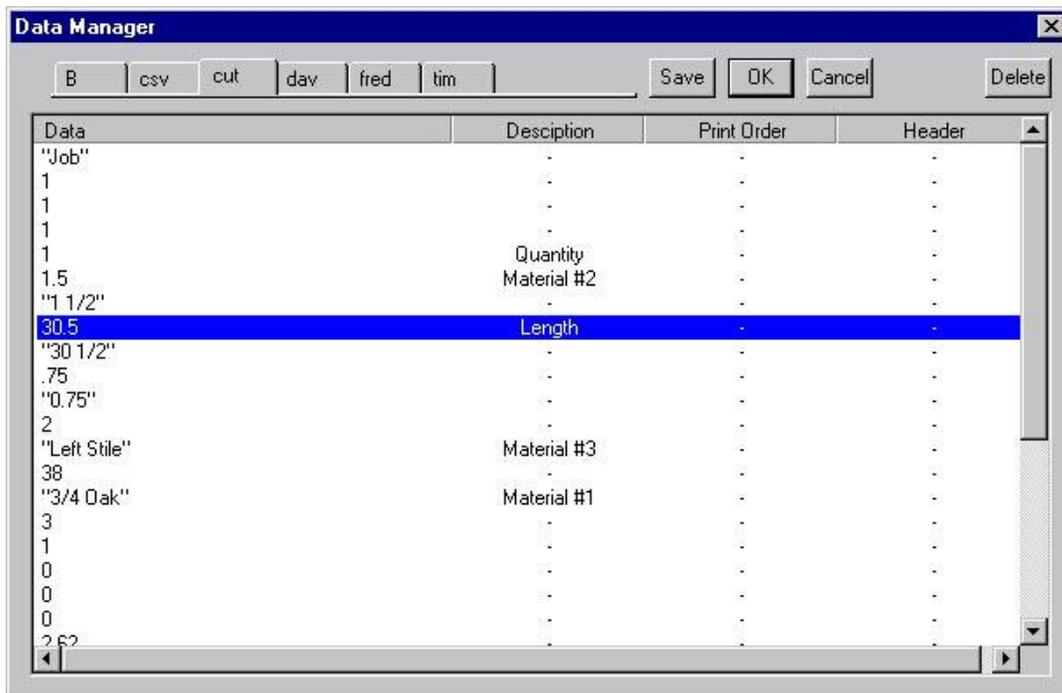
Conversion Utility —.cut file output format

1. To export a .cut file from Solid select the Reports icon from the plan view.
2. Then, from the main menu in reports view select Utilities and the Output Data File option.

This will bring up the Output Data Files dialog box from which you can select the export directory for the .cut file.

You can configure TigerLink as shown below. The length and quantity fields cannot be changed, but the material fields can be adjusted to fit your needs.

- | | | |
|--|--|--|
| 1 Job number - string | 13 Part name - string | 23 Labor in minutes - numerical |
| 2 Wall number - numerical | 14 Material number (form Material:table) - numerical | 24 Material Type (0=panel stock; 1=board stock; 2=Laminate; 3=Banding; 4=Hinges; 5=Drawer Guides; 6=Pulls; 7=Misc) - numerical |
| 3 Room number - numerical | 15 Material name - string | 25 Spare 1 - numerical |
| 4 Cabinet number - numerical | 16 Material list number (1=panel stock; 2=board stock; 3=frame; 4=door; 5=drawers) - numerical | 26 Spare 2 - numerical |
| 5 Quantity of item - numerical | 17 Grain preference (1=yes; 2=no) - numerical | 27 Spare 3 - numerical |
| 6 Width (decimal) - numerical | 18 Optimize (1=yes; 2=no) - numerical | 28 Cabinet name - string |
| 7 Width (fraction) - string | 19 Stock part (1=yes; 2=no) - numerical | 29 Comment - string |
| 8 Length (decimal) - numerical | 20 Weight factor - numerical | 30 CNC Drilling program - string |
| 9 Length (fraction) - string | 21 Cost - numerical | 31 Edge banding code - string |
| 10 Thickness (decimal) - numerical | 22 Cost unit (1=ea; 2=/ft; 3=/sq.ft.) - numerical | 32 Spare A - string |
| 11 Thickness (fraction) - string | | |
| 12 Part number (from Part:table) - numerical | | |



TigerLink 3.2 and Pattern Systems

This deals with the Access database portion of the Pattern Systems file.

You must produce your report creating the cut list for your particular job before trying to link to the information.

1. Select the file that contains the cutting and printing information, and open that file.
2. Under Tools, select the Office links folder.
3. Select Analyze It with MS Excel. This will open your record in Excel.
4. In Excel, under File, select Save As.
5. In the Save As window, select the Save As Type drop-down menu and choose the CSV (comma delimited) option.
6. Select the location that you want to save your file to, and choose Save.

This will create a .CSV file that TigerLink can use to send information to TigerStop.

From this point you can set up your link to this file and determine which fields are relevant for TigerStop. You must set up a new link, of course, as explained in Start a New Link before this data can be used by TigerStop.

Delete a Cut List



Fig. 1

1. To delete (clear) Cut Lists, scroll to the Cut List number you are finished using, and click Delete (Fig. 1).

The Clear Cutlist dialog box (Fig. 2) will open, giving you the option to clear that cut list or all cut lists.

2. Click OK to remove only that cut list from TigerStop memory.

The screen will default to the cut list number that is open in the Main Screen, but you can enter any cut list you want, and TigerLink will delete it from TigerStop memory.

➡ If you want to clear ALL cut lists from TigerStop memory, click Clear All. There is a further confirmation window (Fig. 3) asking ARE YOU SURE? Click Yes only if you ARE sure.

There is no going back after you clear a cut list from TigerStop using this method, so make sure you have selected the correct number before you select OK, or before you click Clear All.



Fig. 2

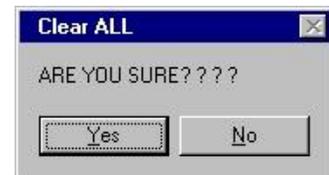


Fig. 3