



# TigerStop<sup>®</sup>



Version 4.3

fast and accurate



This quick reference card is for TigerStop operators. If you're setting up a TigerStop, refer to the TigerStop Manual for complete information.

**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 saws 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. High voltage danger—do not open motor compartment or controller keypad. No user-serviceable parts inside.








Fig. 1.

## Start Up

### Turn TigerStop ON.



The ON/OFF switch is located on the side of the BLUE Motor Box as shown in Fig. 1.



Press [START] for the Home

routine...

```
Initializine
.....
```

```
Clear the deck
Press START
```

**Make sure nothing is in the path of the stop!**



Press [START] again.

The stop will move away from the blue motor box and go through the 5 stages of the setup routine. When it halts, TigerStop is ready for action. The display will change to the Ready Screen.

```
Tiger      H
Posit =current
```

Posit= shows the current position of the stop.

**You can now command TigerStop to move by using one of its many functions!**



This is a quick reference card. Refer to the TigerStop Manual for full information.

# 2

## Move to a Position.

Always start at the Ready Screen.



Pressing **STOP** gets back to the Ready Screen.



Press [STOP] until **Tiger** appears.

When you enter a length that you want to move to, that length appears on the TOP line of the screen.

The BOTTOM line shows the current position.

When you press [START] the stop moves to the length you entered, and the bottom line changes as it moves to the new position.

Example: **Move to 23 7/16"**.

Enter the length either as inches and fractions or as decimal inches.

In the TigerStop Manual 3.0, this function is called the GO function.



Enter [2] [3] [SPACE] [7] [/] [1] [6]

Or...



enter [2] [3] [.] [4] [3] [7] [5] and...



...press [START].

When you press [START] the stop moves to 23 7/16".

The Ready Screen always displays the length in decimal inches, as Posit=23.437.

**Now, try a few more lengths!**

## Inches or Metric

Set Inch Mode



Press [PROGRAM] [SPACE] [6].

Inch mode blinking I N



in the lower right corner of the screen.

Set Metric Mode



Press [PROGRAM] [SPACE] [4].

Metric mode blinking M m



in the lower right corner of the screen.



This is a quick reference card. Refer to the TigerStop Manual for full information.

# Hot Keys = Speed Dial

3




Don't waste time entering common lengths over and over again!




**Make some hot keys!**

In the TigerStop Manual 3.0, this function is called the GO SET function. On the TigerStop display, hot key is called Go Set.








Example:

Make hot keys for three common lengths: 12", 14½", and 17¾".

   Press [PROGRAM] [0] [START] to begin entering hot keys.

   Press [1] [2] to enter the first length and [=] to view it.

 Press [+] to enter the next length.

       Press [1] [4] [SPACE] [1] [/] [2] [=] to enter & view your next hot key.

 Press [+] to enter the third length.

      Press [1] [7] [.] [7] [5] [=] to enter and view your third hot key.




 Press [-] to **go back** and view or correct a previous hot key.

 Press [PROGRAM] to **save** the 3 hot keys you just made.

   **USE hot key #1** – Press [START] [1] [START].

TigerStop moves to 12", the hot key length you selected.

**Hot key lengths don't appear on screen while you're using them.**


   If you want to see what a hot key is before you use it, press [=] after the hot key number. The length displays.

 Press [START] to use it, or...

 press [STOP] to select a different hot key.

When using hot keys, the last hot key number you used will be the default. Just enter the hot key number you want, right over it!

 This is a quick reference card. Refer to the TigerStop Manual for full information.

 **HINT!**  
Keep a list of **hot keys** and what lengths they go to.

# 4

## Increment

Use Increment to push material through a machine to make cuts of equal length.

**Increment is a push feed function and always includes kerf.**

Example:

**Push feed a piece of material into the saw at 6" increments.**



Press [INCREMENT] [6] [START] to enter the increment length and save it.



Move the stop out, load your material, and press [START]. The stop moves 6" + kerf towards the saw.



After you make your cut, press [START] again to push feed the next increment, and keep doing this till the material is used up.

When you are using Increment, the stop can be moved out to load material, or moved in to bypass a defect, without losing the increment. Your increment length is not lost until you press [STOP].

To move the stop while incrementing...



enter a length and press [START]. The stop will move to that length.



The next time you press [START] the stop will begin incrementing again.



Press [STOP] to end incrementing.

## Remember!

**Your Increment Length is lost when you press...**



This is a quick reference card. Refer to the TigerStop Manual for full information.






# Cut List \*






5






Store a cut list in TigerStop by picking a cut list # from 1–99 and entering the lengths and quantities. Use the cut list right away, or save it for later use!

Example: Enter cut list #22, with the following cuts:  
24", 3 pieces; 28", 6 pieces; 32", 2 pieces.

     Press [PROGRAM] [2] [2] [START] [3].


     Enter [2] [4] [START], [3] [START],

     [2] [8] [START], [6] [START],


     [3] [2] [START], [2] [START].

 Press [PROGRAM] to store the cut list.

 If you want to run the cut list now, press [1].

 If you want to save the cut list to use later, press [3].





If you pressed [1] to run the cut list now, the stop moves immediately to the first length and waits for you to make your cut.

 After you make each cut, press [START].






After all the cuts at the first length are made, when you press [START] the stop moves to the next length.

This happens until all the pieces have been cut.






To run a cut list you have stored but never used...

    press [PROGRAM], cut list number, [START] [START].

To run a cut list you have stored and started using...

     press [PROGRAM], cut list number, [START] [START] [1] to reset and start over.

To run a cut list you have stored and started using...

     press [PROGRAM], cut list number, [START] [START] [3] to continue where you left off.

\* This example is for a Manual Set Point Cut List.

For optimized, pattern mode, and push feed cut lists, see the TigerStop Manual.



This is a quick reference card. Refer to the TigerStop Manual for full information.

# ⑥ Making TigerStop Accurate

Calibrate TigerStop to set its distance from zero.  
Calibrate whenever the blade is changed.

Example: **From a position at least 12" out, enter a length of 10".**



Enter [1] [0] [START].




TigerStop moves inbound to 10" from the saw blade.

Cut a piece of stock at this length and carefully measure it.  
It should be right on 10".

**Be sure to use an accurate measuring tool.**

**TigerStop can be only as accurate as you make it!**

If the piece you cut is longer or shorter than 10", the stop must be calibrated. **Let's say it is 10¼" long. Time to calibrate!**

   Press [PROGRAM] [SPACE] [2]  
to get to the calibration screen.



Enter [1] [0] [SPACE] [1] [/] [4] [PROGRAM].

Cut another sample piece using the same procedure. If the sample piece is right on the mark...

**TigerStop is now calibrated!**


---

## Interlock Auto-Detect

TigerStop is set up to operate with no interlock, or with a standard or an advanced interlock, at the factory. To check your TigerStop's interlock status...

...press  and hold down for five seconds at start up.

The screen will display the type of interlock installed.

**IMPORTANT!**  For any system with an IK3 Advanced Interlock, the foot pedal must be held down when the system is starting in order to register the correct values for the Interlock parameters.



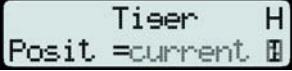
This is a quick reference card. Refer to the TigerStop Manual for full information.

# Min-Max



Min-max your TigerStop to set its minimum and maximum limits.


This is an auto-setup mode and should be run **ONLY** after the stop has run through its Home routine.

At the Ready Screen  press and hold

 and  at the same time, and then quickly release.

The screen displays .

**Make sure nothing is in the path of the stop!**

Press  The stop will move to both ends of the fence extrusion, first to the idle (far) end and then to the motor end of the machine.

The minimum/maximum parameters are now changed and saved.

Now, turn back to **Making TigerStop Accurate**



# Saw Kerf

... is the width of the cut your saw blade makes.



Any time you change saw blades, check the kerf to see if it's the same as the TigerStop kerf setting. If it isn't, then you have to change the kerf setting.



   Press [PROGRAM] [SPACE] [3] to view the current kerf setting. If the setting is correct...

  press [=] [PROGRAM] to accept it.

**If the setting is not correct, enter the correct kerf, and...**

  press [=] [PROGRAM] to save it.

**Saw kerf only matters in push feed applications!**



This is a quick reference card. Refer to the TigerStop Manual for full information.

# 8

## Primary Function Keys

**Program List**

Used to **Program** cut lists, hot keys, & settings.

Also used to run a Cut **List**.

**Incram**

Used to run **Increment**.

**Space Calib**

Used to enter a **Space** in numbers with fractions; to enter negative lengths; and to **Calibrate** the stop, select inches or metric, and set saw kerf.

**Clear**

Used to **Clear** an entry one number at a time.



Used to **Stop** any operation; to return to the Ready Screen; and to exit Increment.



Used to **Start** movement: After entering a length, a hot key, or an increment, **Start** moves the stop to the length entered.

Also used to accept a length or quantity when entering a Cut List.



Used to select a hot key length.

## Numeric Calculator Keys



Used to enter values just like those on any calculator.

Two of the number keys are used to select metric and inches:



Used to select Metric or Inch mode.



Used to insert decimal point in a number.

## Math Function Keys



Used to subtract, enter negative values, and view previous data line.



Used to multiply.



Used to add, and to view the next data line.



Used to divide, and to enter fractions.



Used to complete a calculation or an entry and view the result without moving the stop.



This is a quick reference card. Refer to the TigerStop Manual for full information.