

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.

POWER UP

TigerSaw has a number of safety E-stops that must be reset before it can be powered up.



CALIBRATION

Calibrate TigerSaw whenever the saw blade or your tool setup has changed. Be as accurate as possible.

1. Press [Calib] soft key.

```
%H          Ready
Position =   Current
Next       =
           Calib Show
↑A   ↑B   ↑C   ↑D
```

2. Cut a sample and enter the length.

```
%H  Calib  Ready
Enter distance
from zero= 33.998in
           Done
```

3. Press [Done] soft key.

```
%H  Calib  Ready
Enter distance
from zero=33.935
           Done
↑A   ↑B   ↑C   ↑D
```

SET KERF

Saw Kerf is how much material is destroyed by the saw blade during a cut. Adjust after each blade change.

1. Press [Menu] soft key.

2. Enter your password followed by [=].

```
%H          Ready
Position =   Current
Next       =
Menu Incr List PrSet
↑A   ↑B   ↑C   ↑D
```

3. Press [Setup] soft key.

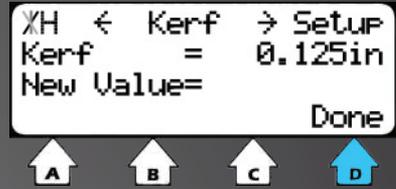
4. Scroll to Kerf using .

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

5. Cut a sample piece. Measure it with a caliper.

6. Cut this piece in half. Put the two pieces together as if they were one piece.

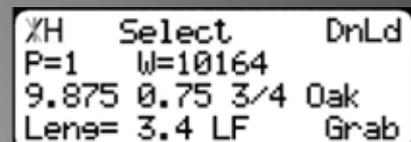
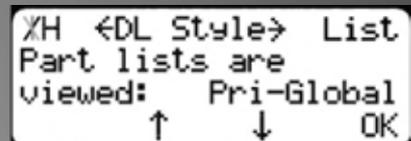
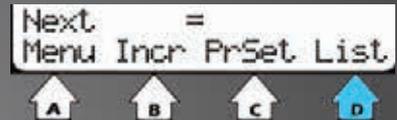
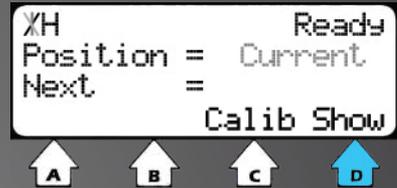
7. Measure with a caliper.
8. The difference between the two measurements is the value of your saw kerf.
9. Enter new Kerf and press the [Done] soft key.



RUN LISTS

Download

1. Press [Show] soft key.
2. Press [List] soft key.
3. Press [Download] soft key.
4. Choose download style and press [OK].
5. Choose a list using .
6. Press [Start].



Manual List Entry

1. Press [Show] soft key.

```
Next      =  
Calib Show
```

↑ A ↑ B ↑ C ↑ D

2. Press [List] soft key.

```
Next      =  
Menu Incr PrSet List
```

↑ A ↑ B ↑ C ↑ D

3. Enter a list number and press the [Edit] soft key.

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

4. Choose your list type.

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

Pusher

A pusher list will push the stock into the saw. TigerSaw will tell you when it needs you to load another piece of stock. Pusher lists can be used with the pack saw function.

Set Point

A set point list will tell TigerStop to act as a stop. Do NOT use this list type with TigerSaw!

Pattern

A pattern list will tell TigerSaw to process one stock length's worth of parts in a push feed fashion. Pattern lists cannot be optimized or used with the pack saw function.

Pull

A pull list works just like a pattern, except it pulls away from the zero point instead of pushing towards it. Do NOT use this list type with TigerSaw!

5. Choose if you want to optimize.

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

Note: Optimizing will make TigerSaw 2000 reorder your part list to cut parts with the least amount of waste.

6. Set Head and Tail cuts.

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

Note: Head and Tail cuts are trim cuts at the beginning (Head) and end (Tail) of your material.

Global

The global option uses the Head and Tail cut values from the part list menu for this list.

Local

Allows you to enter a unique Head and Tail cut for use with this list only.

7. Enter lengths and quantities.

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

Example: 24" 5 cuts

2 4 OK 5 OK

14" 10 cuts

1 4 OK 1 0 OK

8 1/4" 5 cuts

8 1 / 4 OK 5 OK

8. Press the [Done] soft key to run list.

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CRAYON DEFECT MARKING

Once an optimized pusher list is started, Crayon Defect Marking will activate. See the Quick Reference Card for “Run Lists” on page 3.

1. Press [Start]

TigerSaw will send the pusher foot forward to the load offset position.



***Note: Overhead LED lighting may interfere with the UV sensor.**

2. Marking Defects: Use a UV Crayon to mark defects on your piece. Mark with one line at the beginning and one line at the end of the defect. Everything between



***Note: Crayon marks must be drawn a minimum of 36mm (1.41 inches) apart or MORE for defect marking.**

2. (continued)

the two lines is considered a defect and will be removed. The rest of the material will be optimized for the best yield.

3. Load marked material onto the table *behind* the pusher foot.

***Note: TigerSaw pusher foot moves backwards to scan the material and then forwards to push material through the saw.**

4. Press [Start] button to begin the cycle.



***Note: While piece is processing, you can start marking the next piece.**

5. Once the pusher foot has cleared the loading zone you may load another piece of marked material behind the pusher foot and press [Start] to queue it. TigerSaw will automatically start cutting this material when finished with current part.



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GRADE MARKING

Once an optimized pusher list is started, Crayon Defect Marking will activate. See the Quick Reference Card for “Run Lists” on page 3.

1. Press [Start]

TigerSaw will send the pusher foot forward to the load offset position.



***Note: Overhead LED lighting may interfere with the UV sensor.**

2. TigerSaw allows you to process up to 3 different grades of material at the same time. Drawing either 2, 3, or 4 lines with a UV Crayon tells your TigerSaw which grade list to process. With grade marking, your TigerSaw may switch back and forth between various grades. You may also combine Grade Marking with Crayon Defect Marking.

***Note: Grade Marking UV crayon marks must be drawn closely together. The lines must be 35mm (1.37 inches) or LESS.**

3. Load marked material onto the table *behind* the pusher foot.

***Note: TigerSaw pusher foot moves backwards to scan the material and then forwards to push material through the saw.**

4. Press [Start] button to begin the cycle.



***Note: While piece is processing, you can start marking the next piece.**

5. Once the pusher foot has cleared the loading zone you may load another piece of marked material behind the pusher foot and press [Start] to queue it. TigerSaw will automatically start cutting this material when finished with current part.



Grade Marking

Defect
Marking



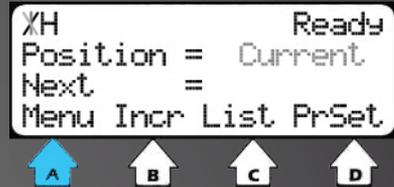
***Note: Draw two lines to tell your TigerSaw to move to Grade Marking List 1, three for Grade Marking List 2, and four for Grade Marking List 3.**

ADJUSTMENT

Saw Stroke Height

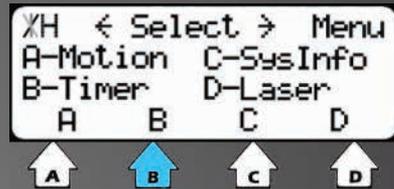
Stroke height is controlled using a timer. This timer must be adjusted if the stroke speed is changed.

1. Press [Menu] soft key.
2. Enter you password followed by [=].



Note: Password is TigerStop serial number.

3. Press .
4. Press [Timer] soft key.



5. Scroll to the 'Cycle-TO' timer using .
6. Enter a new timer value.
7. Press [Done] soft key to save timer.

Note: Timers are set in milliseconds. 1000ms = 1 second.

Pneumatic Adjustments



Adjusts the speed of the saw blade stroke.



Adjusts the pressure of the horizontal and vertical clamps.



Adjusts the speed of the top clamp.



Adjusts the speed of the infeed clamps.