TigerStop®
fast and accurate...every time

TigerTouch

Installation Guide

February 2017 Mk2
Enable Code

If you are adding TigerTouch to a TigerStop product, you will need to update the Enable Code. The Enable Code unlocks TigerStop functionality so you can upgrade in the field.

If you purchased TigerTouch as part of a new TigerStop system, Skip this step.

Enable Code: __________________________

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

2. Press the [Menu] soft key to display the Menu Select screen.

3. TigerStop requires a password to access all menu options. Enter your TigerStop password and press 🔄. Note: By default, the TigerStop password is set to the serial number.

4. At the Menu Select screen, press 🔄.

5. Press the [SysInfo] soft key to access the System Information menu.

6. Press □□□ to view your serial number and enable code.

7. Press [A], [B], [C] and [D] one after the other.

8. Press □□□ to erase the enable code when prompted.

9. Press STOP to return to the Ready Screen.


11. Power up.

12. TigerStop will now ask you to enter your enable code. Enter the code supplied and press 🔄.

TigerStop is now upgraded for TigerTouch.
Safety First!

IMPORTANT SAFETY INFORMATION. READ ALL WARNINGS BEFORE OPERATING THIS PRODUCT.

GENERAL WARNINGS

WARNING: Installation of your TigerStop Product must be done by a person trained in the safe design and installation of automation products, and in the safe operation of power equipment. Ensure that such installation meets all legally required safety requirements and guidelines, and that proper guarding and safety devices are provided on all sides of the equipment to preclude unintended access during operation. Consult with and follow the recommendations of a qualified safety engineer.

WARNING: TigerStop Products are components intended for use in conjunction with potentially dangerous machinery. The use of TigerStop Products does not make other machinery safe. TigerStop Products are not intended to substitute, in any manner, for safe operating practices in general, or for safety features present in other machines designed to make those machines as safe as possible. TIGERSTOP PRODUCTS, IF USED OR INSTALLED IMPROPERLY, MAY CAUSE PERSONAL INJURY OR DEATH AND SHOULD ONLY BE OPERATED BY PERSONS TRAINED IN THEIR SAFE OPERATING PROCEDURES. Illustrations of TigerStop Products in use do not show, and are not intended to show, all safety features and practices necessary for their safe operation.

INSTALLATION WARNINGS

WARNING: TigerStop Products must be installed in accordance with all local, state, and federal regulations. Only personnel properly trained in the safe design and installation of automation machinery and related power equipment should install TigerStop Products onto other equipment, to ensure a safe and proper work station. TigerStop Products should not be operated without proper training, both in the operation of TigerStop Products, and in the operation of related equipment.

IMPORTANT CAUTION:
The motor box (compartment) contains DC voltage with potentially FATAL amperage. NEVER attempt any unauthorized actions inside the motor box.

INTERCONNECTS

WARNING: Using a TigerStop interconnect does not relieve you of the responsibility for making sure that your saw or other tool has all the necessary safety equipment in place. All installations must meet all legally required safety requirements and guidelines. Installation and training should be done following the recommendations of a qualified safety engineer.

OPERATION

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 a saw 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.

DANGER! Don’t get pinched by the push feeder. Keep your hands away when in motion!
IMPORTANT SAFETY INFORMATION. READ ALL WARNINGS BEFORE OPERATING THIS PRODUCT.

Keep the work area clean and well lighted to avoid accidental injury.

Do not use TigerStop machines in a dangerous environment. Using power tools in damp or wet locations or in rain can cause shock or electrocution.

Do not operate near flammable liquids or in gaseous or explosive atmospheres!

Wear proper apparel, no loose clothes, long hair or jewelry which could get pulled into moving machinery or materials. Wear non slip footwear, safety glasses, ear protection and a dust mask.

Use only 3-wire extension cords that have 3-prong grounding type plugs and 3-pole receptacles that accept the tools plug for 120VAC. Use only 5-wire cords and plugs when using 3 phase.

Do not open motor compartment or controller keypad. DC Voltage with potentially FATAL amperage! Disconnect power before servicing. No user-serviceable parts inside.

DO NOT operate this or any machine under the influence of drugs or alcohol!

No one should operate this machine except for fully qualified personnel.

Read the manual!
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Using TigerTouch

Running TigerTouch

TigerTouch will come pre-installed on your TigerStop Tablet Package. Once assembled and powered up, a TigerTouch icon will be on the Windows desktop. Double tap the icon to run TigerTouch.

Note: Ensure that TigerStop is powered up and connected to the tablet as per the TigerStop Tablet Package installation guide.

If you purchased TigerTouch without the tablet package, download TigerTouch at www.tigerstop.com/support.

WARNING! TigerTouch requires full administrator rights to use all features. See your network administrator for details.

1. When TigerTouch opens for the first time, it will attempt to find connected TigerStop products. Tap OK to begin.

2. TigerTouch will display all TigerStop serial numbers that it found. Choose the serial number of the TigerStop you wish to control and tap OK.

3. You will now be taken to the ‘Move Tiger’ screen.

Move Screen

From the Move screen, you can move TigerStop using decimal and fractional lengths. You can also set manual offsets, use Increment mode and configure custom buttons.
The keypad displays TigerStops current position in real time. It also allows you to move TigerStop and enter manual offsets.

**Moving TigerStop**

Enter a length on the keypad and tap the [Start] button. Lengths can be entered in decimal or fraction, but TigerTouch will only display in decimal.

**Moving TigerStop Using Decimal Lengths**

For this example, I want to move TigerStop to 110 1/2 inches.

1. Enter [1] [1] [0] [.][5]
   Note: Any text entry mistakes can be fixed using the [BACK] button.
2. TigerTouch will display this entry in the text entry area.
3. Tap [Start] when you are ready to move TigerStop.
4. TigerStop will now move to the length entered and will display this length in the current TigerStop position.

**Moving TigerStop Using Fractional Lengths**

For this example, I want to move TigerStop to 110 1/2 inches, but I want to enter it as a fraction.

1. Enter [1] [1] [0] [SPACE] [1] [/] [2]
   Note: Use the [SPACE] button to add a space between the whole number and the fractional number.
2. TigerTouch will display this entry in the text entry area.
3. Tap [Start] when you are ready to move TigerStop.
4. TigerStop will now move to the length entered and will display this length, in decimal, in the current TigerStop position.
Custom Buttons

TigerTouch has 60 programmable move screen buttons and 32 fraction buttons. Each of the programmable buttons can be configured to move TigerStop to position, apply a positive offset or apply a negative offset. Each button can be assigned a color, a text label and an image for easy identification.

Note: Custom buttons can only be created and saved by system administrators.

Creating/Editing Buttons
To edit a button, tap and hold the button you wish to edit. Release the button after a few seconds.

Setting Manual Offsets

From the keypad, you can set positive or negative offsets that will offset the position of any entered number.

1. In this example, I want to set a positive offset of .125 inches.

2. Enter \[.\] \[1\] \[2\] \[5\] \[+\]
Note: Use the [-] button to set a negative offset.

3. The keypad will now display this offset in the ‘Applied Offset’ box.

4. If we enter a position of 110.5 and tap [START], TigerStop will move to 110.625.
Note: That is the entered position of 110.5 + .125 offset.

Clearing Manual Offsets
1. Tap the [Clear] button to clear the offset.

Increment Mode

Increment Mode will make TigerStop push into your tool by a set increment value. Pressing the Increment button will show the increment options.

Using Increment Mode

1. Enter an increment value and press [Enter].
Note: Increments can only be positive values.

2. Pressing [Start] without entering a length will cause TigerStop to push into the tool by the entered value.
Note: If you need to move TigerStop back to load material, enter the load length and press [Start], then press [Start] again to continue incrementing.
Set Button Color
Set the button color by tapping a color from the color palette.

Set Button Name
Tap into the ‘Button Name’ text box to bring up the virtual keyboard. Enter a name for the custom button and tap enter on the virtual keyboard when finished.

Set Button Value
Tap into the ‘Button Value’ text box to bring up the keypad. Enter the value for the button and press [Enter].

Set Button Icon
Tap the ‘Browse’ button and browse to an image file you would like to use for the button Icon. Note: TigerTouch can use .bmp, .jpg, .png, .tiff, .gif, ICO and Windows Media Photo images. Images will scale automatically.

Set Button Type
A button can do one of three things:

- **Move To** - This will move TigerStop to the length entered in the ‘Button Value’ text field.
- **Add and Move** - Add and move buttons will take the selected positive or negative value and add it to the current position and move to it. Ex. at 10in, an add and move of 2.5in will add into 10in. and move to 12.5in. At 10in., an add and move of -5in will add into 10in. and move to 5in. This can be combined with manually entered positions. Type 15 into the keypad and select an add and move of 2.5 in will add 2.5 into 15 and move to 17.5in.
- **Apply Offset** - This will apply a positive or negative offset to any length entered into the keypad, but will wait to move until you press [Start].

Saving the Custom Button
Tap [OK] to save the button and return to the ‘Move’ screen.

Using Custom Buttons
To use your custom button, tap on the button you wish to use. TigerTouch will instantly execute the buttons function.
Working with Part Lists

TigerTouch can quickly and easily process part lists, created manually or from TigerLink 6.
Note: For more information about TigerLink 6, please see the TigerLink 6 Installation Guide.

To access the list processing screen, tap the Start menu in the upper left corner of any TigerTouch screen.

TigerTouch has the ability to load up to 3 parts lists and will allow you to swap between them on-the-fly. Each list is loaded into its own list slot. These slots are labeled ‘List 1’, ‘List 2’ and ‘List 3’. Only the list in List 1 will be active.

List Function Buttons

Load
The Load button allows you to load a .Tiger file from TigerLink 6.

1. Tap the [Load] button.

2. Browse to your TigerLink 6 .Tiger file and tap the [Open] button.
Note: By default, TigerLink 6 will export .Tiger files to the TigerLink folder on your desktop.

3. TigerTouch will load the cut list.

Save
The Save button will save the progress of the list. The list will be saved as a .Tiger file.
Note: The save button will only save the progress of the list in its own list slot. For example, the save button on List 1 will not save the list progress of List 3.
Clear
The clear button removes all parts from the List. All unsaved progress will be lost.

+Line
The + Line button allows you to manually enter or remove a part from the list.
Note: Single tap into a cell to edit the cell contents.

The arrow button expands the List so that it extends over the entire screen. This can be useful when processing one list or if you want to view more list information.
Note: Only the list in List 1 can be expanded in this way.

Swap
Lists 2 and 3 each have a swap button. Swap will move the selected list into list List 1, making it the active list.

Once a list is loaded, more options will appear below each Grade.

List Options

Edit List 1 (in)
"1/2"" COPPER TYPE L TUBE"

Edit
The edit button displays information about the part list and will allow you to change the part list type (Push or Setpoint) and toggle Dynamic Optimization.

List
Tapping the List button will bring up statistics about the list.
Once the parts lists are entered, we can now process the list. TigerTouch will process the list in List 1, but a list from List 2 or 3 can be swapped into List 1 at any time.

1. Tap the [Start] button in the upper left corner of the screen.

The statistics available are:

<table>
<thead>
<tr>
<th>Statistic</th>
<th>Result</th>
</tr>
</thead>
<tbody>
<tr>
<td>Longest Piece</td>
<td>212.375</td>
</tr>
<tr>
<td>Shortest Piece</td>
<td>12.000</td>
</tr>
<tr>
<td>Total Pieces</td>
<td>13</td>
</tr>
<tr>
<td>Pieces Remaining</td>
<td>13</td>
</tr>
<tr>
<td>Total Material</td>
<td>105ft</td>
</tr>
<tr>
<td>Material Remaining</td>
<td>105ft</td>
</tr>
<tr>
<td>Waste</td>
<td>0%</td>
</tr>
<tr>
<td>Yield</td>
<td>0%</td>
</tr>
</tbody>
</table>

**Processing a List**

Once the parts lists are entered, we can now process the list. TigerTouch will process the list in List 1, but a list from List 2 or 3 can be swapped into List 1 at any time.

1. Tap the [Start] button in the upper left corner of the screen.
2. The keypad will appear. If you wish to switch to List 2 or 3, press the button.

3. TigerTouch will ask you to enter your stock length. Enter the length of your stock material and tap [Enter].

   Note: If the stock length value you enter is smaller than the smallest part size, you will receive a ‘Stock Too Short’ error.

4. TigerStop will move to the load position to allow you to load your material. TigerTouch will run the Dynamic Optimization algorithm and will display a graphic showing you how TigerTouch plans to process your stock material.

   Note: Red pieces are waste, green pieces are parts from the list and grey is unused stock.

5. Load your material and tap [Start] to move TigerStop to the first position.

6. Cut your part.

7. If you have a TigerStop Interconnect Kit, TigerStop will move to the next position as soon as the cut is complete. If you do not have a TigerStop Interconnect Kit, tap [Start] to move to the next length.

8. Continue until the entire stock is cut.

9. TigerTouch will display the keypad and ask for a new stock length. Repeat until the list has been cut.

**Processing a List Using a TigerStop Saw System**

1. Part list processing changes when using TigerTouch with a TigerStop Defecting Saw System.

2. Load a list into List 1. If you are using the TigerSaw grading system, you will want to load lists in List 2 and List 3 as well.

3. Mark your stock with the UV Crayon as you normally do.

   Note: TigerTouch reads the same defect and grade marks as you normally use with a TigerSaw system if the Grade mark setting is set to “On”. For more information on grade marking, please see the TigerSaw Users Guide.

4. Tap [Start] in the upper left corner

5. TigerSaw will now go to the load position.

6. If you wish to switch to list 2 or 3, press the button. Then load your material and tap [OK].

7. TigerSaw will now scan your material. TigerTouch will display the defect marks and will show the operator how it plans to cut the material. If TigerSaw is in fully automatic mode, it will then cut the stock automatically.

   Note: TigerTouch will automatically process parts from the proper grades as marked on the stock.
Printing Data with TigerTouch

TigerTouch relies on TigerLink 6 to send label printing information to TigerStop. If TigerStop doesn’t have the printing upgrade, TigerTouch will send the printing data to any printer set as the default printer in Windows.

Panel Layup or Pack Sawing with a TigerStop Saw System

If you are using a TigerStop Saw System, TigerTouch can perform the panel layup/pack sawing feature. There are 3 ways to create a Panel/Pack Saw list:
• Load a Panel/Pack Saw list from TigerLink 6 (see TigerLink 6 Installation Guide for details)
• Load a Pusher or Setpoint list from TigerLink 6 and turn it into a Panel/Pack Saw list in TigerTouch
• Create a Panel/Pack Saw list from scratch inside TigerTouch

Loading a Panel/Pack Saw List From TigerLink 6
1. Access the list processing screen.
2. Tap the Load button on any list.
3. Browse to a panel/pack saw list exported from TigerLink 6.
   Note: Panel/pack saw mode will only activate if the list is in the first list slot.

Load a Pusher or Setpoint List and Covert it to a Panel/Pack Saw List
1. Access the list processing screen.
2. Tap the Load button on any list.
3. Browse to a pusher or setpoint list exported from TigerLink 6.
4. Tap Edit in the list options.
5. Check the Pack/Panel option to convert to a panel/pack saw list.
6. Tap [OK].

Create a Panel/Pack Saw List Inside TigerTouch
1. Ensure list 1 is empty.
2. Tap the [+Line] button to add a line to the list.
3. Double click into the length and quantity fields to enter the length and quantity, as you normally do.
4. Tap [Edit] in the list options.
5. Check the Panel Style option and press [OK].
Running a Panel/Pack Saw List

1. Ensure the panel/pack saw list is in list 1.
2. Tap the [Start] button to start list processing.
3. TigerTouch will display a Width keypad. Enter your stock width and tap [Enter].

4. TigerTouch will now display the Stock Length keypad. Enter your stock length and tap [Enter].

5. TigerStop will move to the load position to allow you to load your material. TigerTouch will run the Dynamic Optimization algorithm and will display a graphic showing you how TigerTouch plans to process your stock material.

Note: Red pieces are waste, Green pieces are parts from the list.
6. Load your material and tap [Start] to move TigerStop to the first position.

7. Cut your part.

8. If you have a TigerStop Interconnect Kit, TigerStop will move to the next position as soon as the cut is complete. If you do not have a TigerStop Interconnect Kit, press [Start] to move to the next length.

9. Continue until the entire stock is cut.

10. TigerTouch will display the Width and Stock Length keypad. Repeat steps 3 - 7 until the list is complete.

**Flooring Mode**

Flooring mode is used when making flooring products that need to be shipped in a particular size box. Flooring mode is only available with a TigerStop Defecting Saw System that has the ink jet printing upgrade. TigerSaw will defect and optimize your raw material and will combine one or more cut lengths so that they equal one length of the box size you need.

**Using Flooring Mode**

To access the flooring screen, tap the Flooring menu in the upper left corner of any TigerTouch screen.

The flooring screen is divided into three sections. The left section allows you to enter parameters that tell TigerTouch how long to cut your material. The middle section will display the progress of each length and will help you keep track of how TigerTouch is cutting your material. The right section displays material and yield information.
Flooring Parameters

**Total Piece Length**
Total piece length tells TigerTouch what your box size is. TigerSaw will cut one or more pieces so that they equal this length.
*Note: This is a required field.*

**Minimum Piece Length**
This is the smallest length that TigerSaw will cut when making parts to fit into the Total Piece Length. Pieces smaller than this value will be considered waste by the optimizer.
*Note: This is a required field.*

**Total Linear Feet**
The Total linear feet is the overall linear footage goal that TigerSaw will cut. TigerSaw will stop cutting material when it has met or exceeded this goal.
*Note: This is NOT a required field. If left blank, TigerSaw will cut material until the [Stop] button is pressed.*

**Over Margin**
Over margin sets a length over the total piece length that a piece or group of pieces are allowed to be.

Example: If the Total Piece Length is 8 feet and the Over Margin is set to .25 in, then the total length of the pieces could be any length in between 8 feet and 8 feet 1/4 inches.
*Note: This is an optional setting. If left blank, TigerSaw will cut one or more parts that equal the length of the total piece length setting.*

**Under Margin**
The under margin sets a length under the total piece length that a piece or group of pieces are allowed to be.

Example: If the Total Piece Length is 8 feet and the Under Margin is set to .25 in, then the total length of the pieces could be any length in between 8 feet and 7 feet 3/4 inches.
*Note: This is an optional setting. If left blank, TigerSaw will cut one or more parts that equal the length of the total piece length setting.*
Material Data

Total Material
Displays the amount of material cut by TigerSaw, in linear feet.

Percent Yield
Percent yield is the percentage of good parts cut over total clear length.

Percent Waste
Percent waste is the percentage of waste cut over good parts.

Average Clear Length
Displays the average clear length out of the material cut so far.

Using Flooring Mode
1. Once at the flooring screen, the first step is to set the Total Piece Length parameter.
2. Next, set the minimum piece length parameter.
3. If you have an output goal, enter that amount in the Total Linear Feet parameter.
   Note: Remember, if you don’t enter a Total Linear Feet goal, TigerSaw will continue to cut material until you press the [Stop] button.
4. If you need your material cut to the Total Piece Length plus or minus a certain tolerance, you can enter that tolerance into the Over Margin and Under Margin parameters.
5. Press Start and TigerStop will move to the load position
   Note: Machine will move!
6. Mark your stock with the UV Crayon as you normally do.
   Note: TigerTouch reads the same defect and grade marks as you normally use with a TigerStop Defecting Saw System if the Grade mark setting is set to “On”. For more information on grade marking, please see the TigerSaw Users Guide.
7. Load the material into the TigerSaw and press [Start] to begin the scanning process.
8. TigerSaw will now start to cut your material. Continue to mark stock and load material into TigerSaw until you have reached your required goal length.
Options

Settings Menu

Connect/Disconnect
Tells TigerTouch to connect or disconnect from the TigerStop product it is controlling.

Find Devices
TigerTouch will disconnect from the TigerStop and search for other TigerStop products. Once the search is completed, TigerTouch will display all TigerStop serial numbers that it can connect to. Choose a TigerStop serial number and press [OK] to connect.

To Metric Units / Imperial Units
This option will toggle TigerTouch from imperial units (inches) to metric units (millimeters).

Grade mark On/Off
When used with a TigerSaw defecting system, Grade mark On will allow TigerTouch’s three lists to be used with the material grading feature. When set to Grade mark Off, TigerTouch will treat each list as a separate list.

TigerStop Settings
Tap [TigerStop Settings] to view a complete list of settings from the TigerStop product that TigerTouch is controlling. This list can be copied and pasted to a word processing document if needed. Press ‘OK’ to close the settings window.

Material View
Changes the material image on the parts list processing screen.

Large Grid Text
Toggles the font size of the text inside the list processing grid on the part list processing screen.

Language
Allows you to switch between supported languages.

Exit App
Exits TigerTouch and returns you to the Windows desktop.

Manual Menu
The ‘Manual’ menu contains options to run TigerStop manually. Some of these options require TigerTouch to be used with an Advanced Interconnect Kit or with a TigerStop Saw System.

Home
Tapping [Home] will tell TigerStop to run the home routine.

Calibrate
Allows you to calibrate TigerStop. To calibrate...
1. Cut a piece of material.
2. Carefully measure the cut piece.
3. Tap the Calibrate button in TigerTouch.
Installing TigerTouch 2.03

1. Find the TigerTouch 2.03 setup file and double click it to start installation.

2. A license agreement screen will appear. Click the ‘I agree to the license terms and conditions’ to mark the check box and click ‘Install’.

3. Server installation will begin.

4. After 5-10 seconds, the installer will ask for a file location to extract to.

Installing Software

Terminal
Opens a virtual terminal that TigerStop Customer Service can use to troubleshoot TigerStop issues.

Scan
Tapping [Scan] commands a TigerStop Defecting Saw System to start a defect scanning cycle.

Run Single
If using TigerTouch with a TigerStop Defecting Saw System, Run Single will tell TigerTouch to scan and process just one piece of material.
5. Click ‘Browse’ and select ‘Documents’ and click ‘OK’.

6. Type in ‘\SQLEXPRESS’ on to the end of the file path so that it reads ‘C:\Users\Tigerstop\Documents\SQLEXPRESS’ and click ‘OK’.

7. The installer will begin extracting files, this will take 10-30 seconds usually.

8. The server’s installer will open a window to begin configuration. Select ‘I accept the license terms’ to check the box and click ‘Next’.

9. The server installer will check ‘Global Rules’ and show the ‘Product Updates’ screen. Click ‘Next’.
10. The server installer will check ‘Install Setup Files’, and ‘Install Rules’ on its own. This takes a 5-10 seconds.

11. The server installer will display the ‘Feature Selection’ screen. Ensure that ‘Database Engine Services’ is checked. Click ‘Next’.

12. The server installer will move to the ‘Instance Configuration’ screen. Ensure ‘Named Instance’ is selected and the textbox has ‘SQLEXPRESS’ filled in. Click ‘Next’.

13. The server installer will move to the ‘Server Configuration’ screen. Click ‘Next’.
14. The server installer will move to the ‘Database Engine Configuration’ screen. Ensure ‘Windows authentication mode’ is selected. Click ‘Next’.

15. The server installer will move to the ‘Installation Progress’ screen and begin installing the files. This can take several minutes.

16. Once the server installer is finished it will move to the ‘Complete’ screen. Click ‘Close’.

17. The TigerTouch installer will install the TigerTouch program and show the finished screen. Click ‘Close’ to finish.
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