

**Volume**

**1**

FeneTech, Inc.

FeneVision® Linear Positioner – TigerStop



**Users Manual**

# **FeneVision® Linear Positioner Users Manual for TigerStop**

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## Introduction

Welcome to the FeneVision® Linear Positioner software. The linear positioner software is a member of the FeneVision® family of software products that are pioneering the path of visual manufacturing within the fenestration industry.

The FeneVision® Linear Positioner software provides a plant floor interface to your linear positioner. The FeneVision® products are designed with an open architecture and can easily interface to your existing business systems.

### *System Requirements*

The FeneVision® Linear Positioner software response time is restricted by your system's abilities, so we recommend that your workstation meet the preferred requirements listed below.

Pentium III 500 MHz Processor
128 MB RAM
4.3 GB Hard Drive
17" Monitor
Windows XP
Windows Server Client License
10/100 Mbps Network Interface Card
9-pin serial COM port
9-pin 'straight through', male-female serial cable. (Length depends on distance between the computer and TigerStop controller.)

## *Using Linear Positioner*

The FeneVision® Linear Positioner software has been designed with ease of use in mind. This software is navigated and selections made similar to most Microsoft™ Windows™ based software programs without a mouse.

The table below lists terms used throughout this manual and the actions they define. This table assumes the mouse is disabled. If a mouse is present actions may be accomplished by clicking the specified control

<b>Term</b>	<b>Action</b>
Selecting	Highlighting control using Tab key.
Hot Key	Press and hold the Alt key and press the underlined letter on the control to trigger the controls action.
Point	Move the mouse until the mouse pointer on the screen is on the desired item.
Drag	Hold the left mouse button down while moving the mouse.
Drop	Release the left mouse button after performing the Drag function.

## *Starting and Exiting the Linear Positioner software*

### Starting the Linear Positioner software

1. Turn on the PC.
2. The Linear Positioner software can be started by double clicking on the application icon *Linear Positioner – TigerStop*. This application icon is located in the *FeneVision Linear Positioner – TigerStop* program group. If it is the first time running the Linear Positioner software you will be prompted with a security screen. See Chapter 2 for information on how to unlock the software.

### Exiting the Linear Positioner software

The Linear Positioner interface can be exited one of two ways:

CTRL-X exits the application without shutting down the computer.

SHIFT-F12 exits the application and shuts down the computer.

## Navigation within the Linear Positioner software

### Buttons

Throughout the Linear Positioner application you will find buttons to start an action. The name of the button describes the action. You can trigger the buttons action by selecting it and pressing Enter, or by using the Hot Key combination.



### Scroll Bars

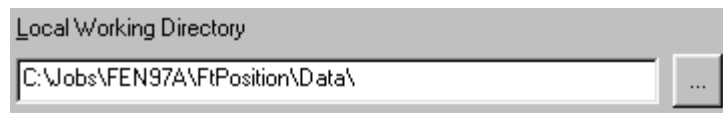
Scroll bars are used when all of the data will not fit on one screen.



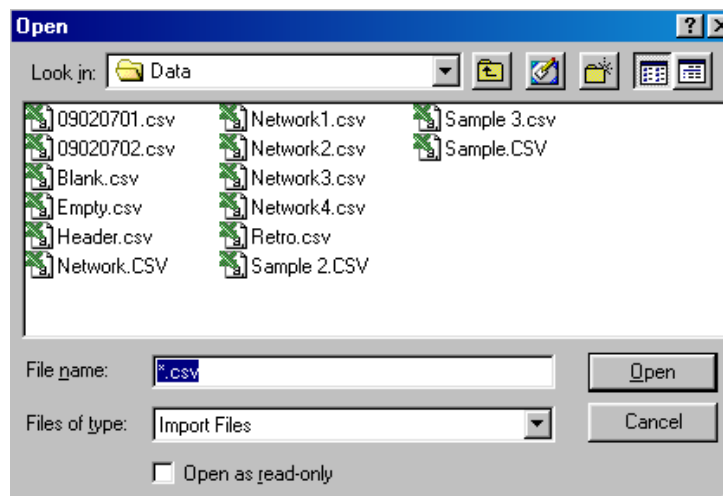
Data is viewed by selecting the associated control and using the arrow keys to scroll either up or down.

### Browse Button

Within the application where directory locations are specified the browse control is used.



Selecting the button on the right hand side and pressing Enter brings up a browse dialog that allows you to specify a file path.



### Toolbars

The main toolbar in the program can be navigated by pressing the associated function key F1 through F10 that appears on the button with the name and icon.



### Radio Buttons

Radio buttons are used in the Linear Positioner to select between two distinct choices. Hot Keys can be used to set them.



# Installation

## *Introduction*

This chapter will identify the steps required to install the Linear Positioner software.

## *Installing the Linear Positioner software*

To install the Linear Positioner application, follow the steps here.

1. First, make sure your system has the ability to run Linear Positioner. See *System Requirements* in Chapter 1 of this manual.
2. Put the FeneVision® Linear Positioner CD into the CDROM drive of your computer.
3. Choose the Run command in the Start menu.
4. Use the Browse button on the Run dialog to select Setup.exe from the CDROM Drive.
5. An installation wizard will be launched that will install the Linear Positioner software on your machine.
6. This installation program will default to the following installation path:

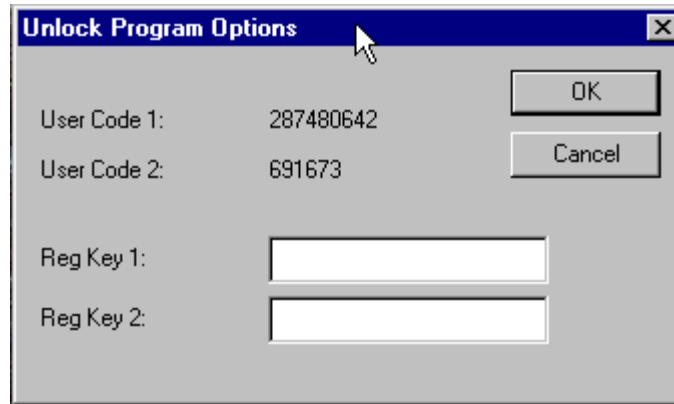
C:\Program Files\Fenotech, Inc\FeneVision Linear Positioner – TigerStop



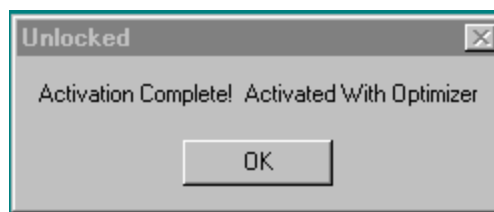
7. The executable file is FtTigerStop.exe

## Security

The FeneVision® Linear Positioner software uses a software protection mechanism to protect end users from receiving an invalid or unauthorized version of the software. The first time you run the Linear Positioner software a security screen will be displayed prompting for a registration key(s). This screen contains information required to unlock the Linear Positioner software.



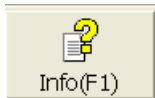
To obtain an unlock code contact Fenetech at (330) 995-2830 or visit [www.fenetech.com](http://www.fenetech.com). These codes are unique to each machine you put the software on so Fenetech will need to be contacted for each new install (*Each Machine that you wish to install this software on requires its own software license*). Tampering with the Linear Positioner software will cause the codes to be voided and a new set will be needed. When you contact Fenetech you will be asked the two User Codes listed in the Unlock dialog. Fenetech will then supply you with Registration Key #'s that you will enter into the fields on the Unlock Program dialog. This code is used to unlock the main program, and an invalid code will cause the program to remain locked. After entering the Registration Key #'s supplied by Fenetech and clicking the OK button a confirmation dialog will appear.



## Running the Software

### *Main Toolbar*

The main toolbar is located at the top of the screen. It is used to execute many of the Linear Positioner application functions. The function of each toolbar icon is described below.

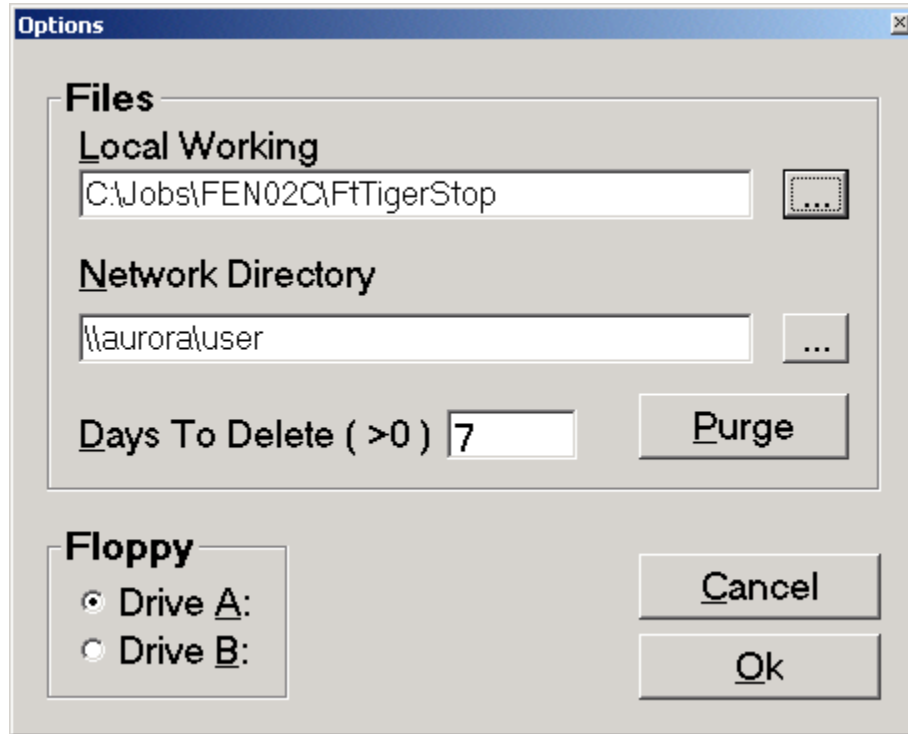


The Info(F1) button is used to display the raw material requirements for the current production file. The Part Requirements dialog displays the number of sticks required for each part number in the file. The number of sticks is derived by the number of optimization changes in the file for the given part number. Press Escape to close this dialog.

Part Requirements	
1	14313BE
13	14314BE
5	14314WH
8	14315BE
3	14315WH
6	14373BE
2	14373WH
1	14313WH



The Setup(F2) button is used to administer some of the common application settings. For more specific information on the Options dialog see the section entitled Options dialog.



The Floppy(F3) button is used to copy files from either the A or B floppy drives. The files are copied to the Local Working Directory specified in the Options dialog. Only files that are older than the number of days specified in the Options dialog will be copied to the directory, and any file in the Local Working Directory older than the number of days specified will be deleted at that time. After the files have been copied the Select Schedule dialog appears.



The Network(F4) button behaves much like the Floppy button except the files that are copied are copied from the Network Directory specified in the Options dialog. Files are also not copied if they are older than the number of days specified in the Options dialog, and files in the Local Working Directory that are older than the number of days are deleted. After the files have been loaded the Select Schedule dialog appears.



The Schedule(F5) button is used to load production schedule files. The Select Schedule dialog lists all files in the Local Working Directory ending with the extension CSV that have not been completed.

File Name	File Size	File Date
Sample 3.csv	819	2/1/00 4:52:13 PM
Blank.csv	0	2/1/00 4:40:31 PM
Header.csv	151	2/1/00 4:40:09 PM
Sample.CSV	921	2/1/00 4:22:45 PM
Empty.csv	287	1/31/00 4:51:18 PM
Network2.csv	293	1/31/00 4:11:15 PM
Network3.csv	1779	1/31/00 4:11:15 PM
Network4.csv	932	1/31/00 4:11:15 PM
Sample 2.CSV	1487	1/31/00 4:11:15 PM
Retro.csv	819	1/31/00 4:11:15 PM
09020701.csv	3400	1/31/00 4:11:14 PM
09020702.csv	293	1/31/00 4:11:14 PM
Network.CSV	932	1/31/00 4:11:14 PM
Network1.csv	1571	1/31/00 4:11:14 PM

To select a schedule for loading, highlight it using the up and down arrow keys on the keyboard and then press the Enter or Return key. Once the selected schedule file has been loaded the first uncut part will be selected. If the local optimizer has been enabled the file will be optimized after loaded. For more information on the optimizer refer to Chapter 4. To exit the Select Schedule dialog without loading a new schedule press the escape key (Esc).



The Home(F6) button is used to move the end stop or feeder to the home position.



The Manual(F7) button is used to manually position the end stop or feeder to a specific length or position.

The image shows a dialog box titled "Manual Movement" with a close button (X) in the top right corner. It contains three input fields and one button. The "Length" field has the value "40" and a blue highlight. The "Part No" field is a dropdown menu showing "1000FRAME-CL". The "Adjust" field has the value "-4.125". An "OK" button is located to the right of the Length field.

After entering the required length pressing the Enter key or selecting OK will move the end stop or feeder to the length specified. If the distance is larger than the max length setting of the positioner the positioner will move to the maximum distance. Repeated manual movements can be done by changing the length and selecting OK. The Part No dropdown menu and Adjust field are populated by the **Adjustment File** (see p. 23 for details). The adjustment value will be subtracted from the length entered.

To exit the Manual Movement dialog press the escape key (Esc). When exiting the end stop or feeder will reposition to the last length prior to entering manual mode.



The Start Pos(F8) button is to mark the starting position within the current production schedule file. By default the starting position is the first uncut item in the file.

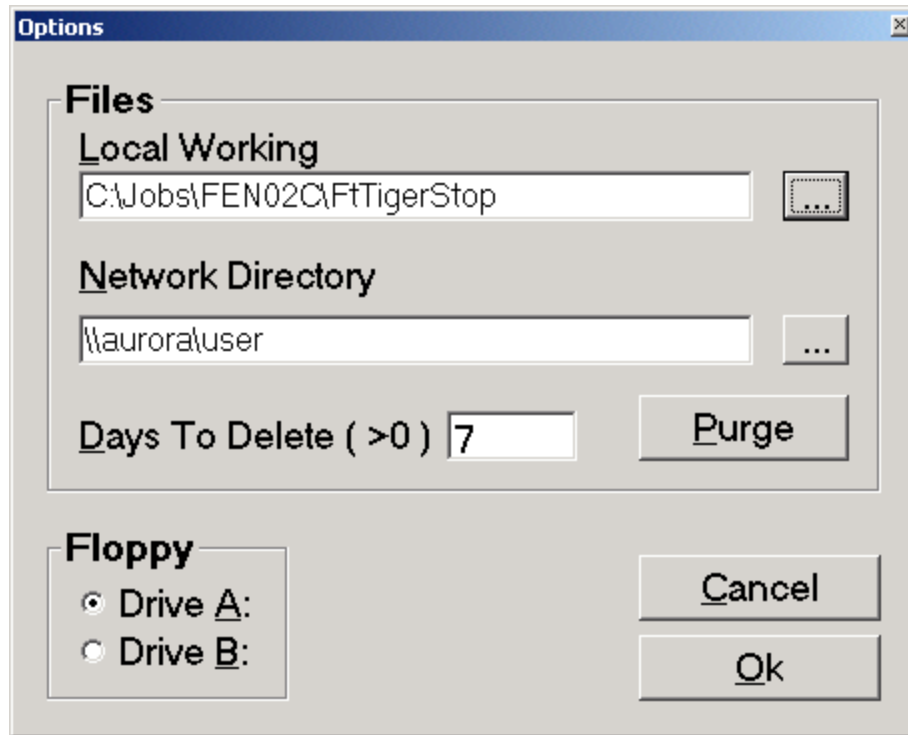
Using the arrow keys identify the starting position within the file. Pressing F8 or selecting the Start Pos(F8) button will reset the starting position in the file and send the required information to the controller.



The Clear(F9) button is used to remove the cut flags from the currently selected production schedule file. The cut flags are the green dots located on the left side of the main screen than appear after a part has been cut. Pressing this button removes all the cut indicators in a file and resets the current part to the first part in the file.

### *Options Dialog*

The Options dialog is used to administer common positioner options. The following describes briefly some of the options and how to use them.



### *The Local Working and Network Directories*

The Local Working directory identifies the location on the computer where files from a floppy or network drive should be copied. The Network Directory identifies the location on the network where new files are copied from. This can be a UNC path (\\computername\directory1\directory2) or a mapped drive (X:\directory1.) To change either of the directories, select the browse button to the right of the directory path. A Browse for Folder select dialog will appear where you can select any directory. Once you have found the directory you wish to use, press OK. To save the settings select the OK button on the main dialog. If you do not wish to save the setting press the Cancel button. You can also change the directory by manually typing a valid directory name in either of the boxes.

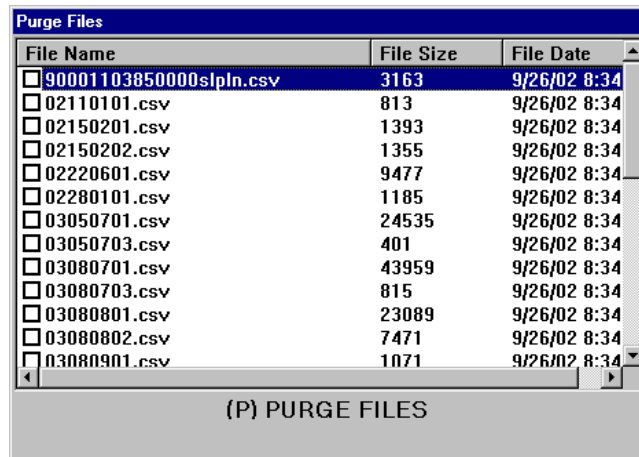
### *Floppy*

The Floppy option identifies the local drive to use when copying new files from a floppy disk.

### *Delete Files Older Than (x) Days*

The number of days used to determine if a file is copied from the floppy or network drive, or if it is to be removed. Files older than the number of days will not be copied and files currently in the local directory will be removed.

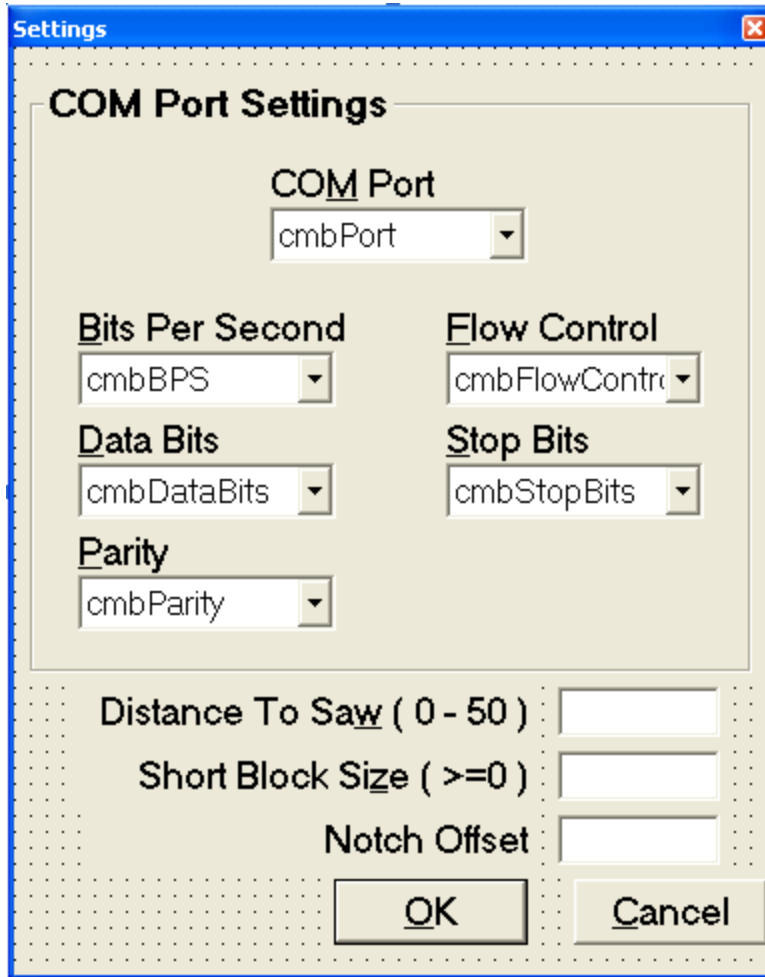
## Purge Files



The purge function is used to delete files from the local working directory. Use the arrow keys to navigate the list and press the space bar to select the files to delete. Pressing the 'P' key will delete the selected files.

## Hidden Options Dialog

The hidden options dialog contains setting that the end-user does not typically have to use. For the TigerStop Linear Positioner, the COM Port and Saw settings are located on this dialog. To reveal the Hidden Options Dialog, press the key combination provided to you by Fenetech.



### *COM Port Settings*

The COM Port settings are used to configure the communication between the Linear Positioner software and the TigerStop positioner. The software communicates to the hardware through a serial port connection, which can be configured with this dialog. Select the appropriate COM port, followed by the additional settings. In most cases, these values can be left alone. **Always consult the TigerStop hardware documentation for more details and exact settings.**

**Note:** By default, newer TigerStop controllers ship set to 115200 baud. Older controllers ship set to 9600 baud.

**Note:** The serial cable between the computer and controller should be straight through.

## Saw Settings

The Saw settings should only be changed by an experienced person who is familiar with the Linear Positioner software.

**Distance To Saw** The distance between the saw blade and the edge of the sled when the sled is at its closest position. Valid values range from 0 to 50.

**Short Block Size** The size of the short block to be used for cutting pieces less than the distance between the saw and the sled at its closest point. If no block is to be used this setting should be zero. Valid values are greater than 0.

**Notch Offset** The distance between the home position and the notching mechanism. Can be between positive and negative 50. A negative value would indicate that the notching mechanism is to the left of the home position, a positive value indicates the notching mechanism is to the right of the home position.

## The Main Screen

The screenshot displays the FTigerStop v1.0.26 software interface. The main window shows a table with columns for Action, Schedule ID, Batch ID, Unit ID, Part Number, Order Number, Length, Quantity, Notes, Stock, Material Change, and Material Notes. The table contains multiple rows of data, including actions like CUT and PUNCH for various parts and schedules. Below the table, a details panel shows the current selection: BATCH 1, BIN 18, and UNIT 7. The status bar at the bottom indicates 'Command Sent. Waiting for Stop to respond.'

Action	Schedule ID	Batch ID	Unit ID	Part Number	Order Number	Length	Quantity	Notes	Stock...	Material Change	Material Notes
CUT	500	1	7	716-BG	110092-5	3	1	(W)	244	1	Throw (0.13)
CUT	500	1	3	716-BG	110092-5	22	1	(W)	0	0	
CUT	500	1	4	716-BG	110092-5	44.1	1	(W)	0	0	
PUNCH	500	1	4	716-BG	110092-5	17.44	1	(W)	0	0	
PUNCH	500	1	4	716-BG	110092-5	28.9	1	(W)	0	0	
CUT	500	1	4	716-BG	110092-5	78.45	1	(W)	0	0	
CUT	500	1	5	716-BG	110092-5	88.32	1	(W)	0	0	
PUNCH	500	1	5	716-BG	110092-5	2.312	1	(W)	180	1	Throw (0.1)
PUNCH	500	1	5	716-BG	110092-5	4.44	1	(W)	0	0	
CUT	500	1	5	716-BG	110092-5	12	1	(W)	0	0	
CUT	500	1	3	716-BG	110092-5	63	1	(W)	0	0	
CUT	500	1	5	716-BG	110092-5	99.4	1	(W)	0	0	
CUT	500	1	2	716-BG	110092-5	42.3	1	(W)	180	1	Throw (0.1)
CUT	500	1	3	716-BG	110092-5	55	1	(W)	0	0	
CUT	500	1	3	716-BG	110092-5	77.1	1	(W)	0	0	
CUT	500	1	1	716-BG	110092-5	11.5	1	(W)	180	1	Throw (0.75)
CUT	500	1	41	716-BG	110093-5	20.5	1	(H)	0	0	
CUT	500	1	41	716-BG	110093-5	20.5	1	(H)	0	0	
PUNCH	500	1	37	716-BG	110093-4	5	1	(W)	0	0	
PUNCH	500	1	37	716-BG	110093-4	8	1	(W)	0	0	
CUT	500	1	37	716-BG	110093-4	27.5	1	(W)	0	0	
CUT	500	1	16	716-BG	110092-4	27.5	1	(W)	0	0	
CUT	500	1	2	716-BG	110092-5	28.75	1	(W)	0	0	
CUT	500	1	1	716-BG	110092-5	32.5	1	(W)	0	0	
CUT	500	1	6	716-BG	110092-5	8	1	(W)	180	1	Throw (6.5)
PUNCH	500	1	1	716-BG	110092-5	3	1	(W)	0	0	
PUNCH	500	1	1	716-BG	110092-5	4	1	(W)	0	0	
CUT	500	1	1	716-BG	110092-5	15	1	(W)	0	0	

Details  
 BATCH **1** BIN **18** UNIT **7**

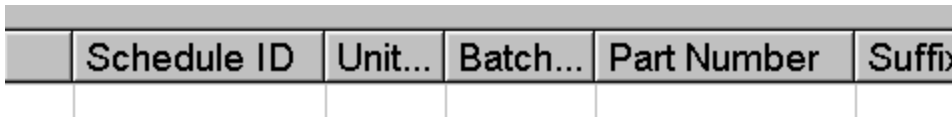
Command Sent. Waiting for Stop to respond.

### *Resizing and Hiding Columns*

The main screens columns can be resized or hidden so that only needed information is displayed. The columns are numbered as follows:

- |                    |            |             |                     |                  |
|--------------------|------------|-------------|---------------------|------------------|
| 1. Schedule ID     | 2. Unit ID | 3. Batch ID | 4. Part Number      | 5. Part Suffix   |
| 6. Order #         | 7. Length  | 8. Quantity | 9. Description      | 10. Notes        |
| 11. Container      | 12. Bin    | 13. Cut     | 15. Material Change | 16. Stock Length |
| 17. Material Notes | 18. Action |             |                     |                  |

You can use a mouse to rearrange and resize the columns. Do this by clicking on the end of the column and dragging the mouse left or right. To make a column larger with the keyboard, press and hold the ALT key and then press the number key of the column you wish to enlarge. If you wish to make a column smaller with the keyboard, use the CTL key in combination with a number key instead of the ALT key.



Schedule ID	Unit...	Batch...	Part Number	Suffix
-------------	---------	----------	-------------	--------

To completely hide a column press and hold the Shift key and then press the number key of a column you wish to hide. If you hide a column you can enlarge it again using the above method anytime.

### *Reordering Columns*

The column order may be changed by dragging a column header to the desired location on the heading line. Point the mouse on the column header name to be moved, drag the column header to the desired location, and drop the column header in its new position. The new column order is saved for the next runtime. To move the column header to its original position, use the drag drop feature.

### *Loading a Schedule*

To load a schedule file press the F5 key or select the Schedule(F5) button from the toolbar. Once the file has been loaded the first uncut part in the file will be highlighted and the end stop or feeder will reposition as required.

Parts will be shown on the screen in different colors depending on their status. Blue highlighted parts are used to signify raw material changes. Red parts with red dots next to them are used to show that the part length designated was larger than the stock length. These will only appear if you are using the optimizer. Parts that have been marked as cut have a green dot to the left of them.

	Z / Z / W	U
	2727W	100
	2727W	100
●	2727W	0
●	2727W	0

### *Cutting / Punching / Unmarking Parts*

You can cut/punch a part by pressing the spacebar once causing a green cut flag to appear. The green flag marks the part as having been cut or punched. The Linear Positioner automatically moves to the next uncut /non punched part on the schedule. If you wish to move to another part before or after the currently selected part you can use the arrow keys to scroll up or down. As parts are cut/punched, a message will appear warning you of events like stock changes and raw material changes. A message will also be displayed indicating when end of file is reached. These message boxes can be exited by pressing the Enter key. Note: Punches will need to be reprocessed on file re-open for any non-cut items, even if a punch or two was made prior to closing.



To remove all the cut/punch flags (the green dots) select the Clear(F9) button on the toolbar or press F9. There is no way to unmark a single part.

### *Saving Files*

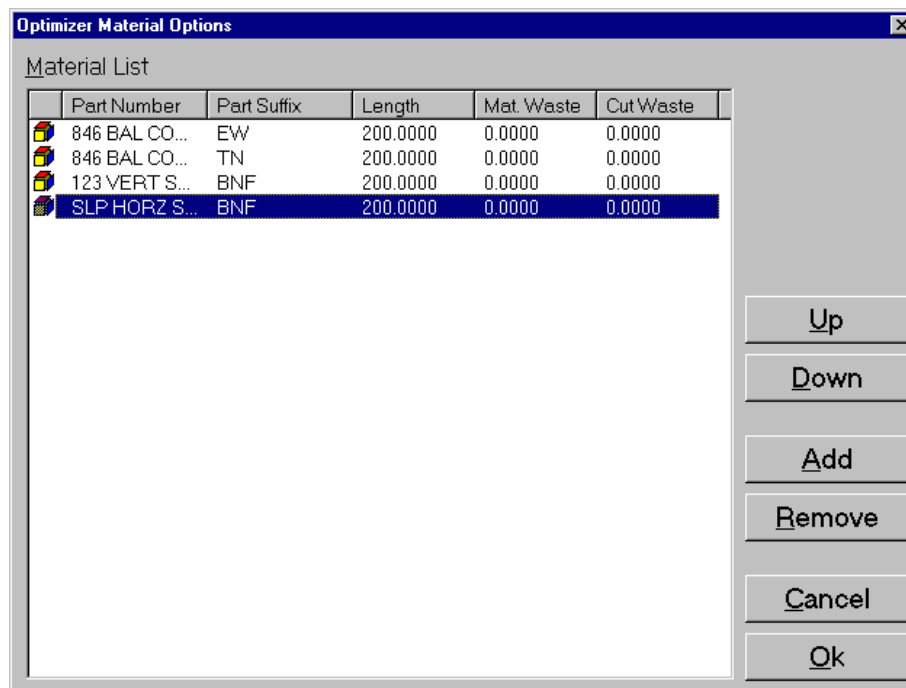
Saving files is done automatically by the Linear Positioner Software upon exit of the program or the loading of a new file. Files are also saved whenever the cut flags are removed from them.

## The Optimizer

### *Setup*

If you did not purchase the optimizer option with the Linear Positioner software all of the features in this chapter will be disabled. If at any time you wish to purchase the optimizer, contact Fenetech at (330) 995-2830 and you will be instructed on how to unlock the optimizer. If you have purchased the optimizer option you will see an optimizer button in the Options dialog. Selecting this button brings up the Optimizer Material Options dialog where all the settings for the optimizer are.

### *Optimizer Material Options*



## Material List

This is the large list of parts that take up most of the dialog. It is used to display Part Number, Part Suffix, Length, Material Waste, and Cut Waste. Parts are optimized in the order they appear in this list based on the given information. Parts are compared based on Part Number and Part Suffix. For more on this see the section titled Part Comparison in Appendix A of this manual.

## Changing The Optimization Sequence

To move a part up or down on the parts list press and hold the Shift key and then press an arrow key depending on which way you want to move the part. You can also move it by selecting the arrow keys to the right of the list.

## Adding and Removing Parts

To add a part to the parts list select the Add button. A dialog box will appear asking you for the required part information. To remove a part select it in the list view and choose the Remove button.

## Editing Parts

To edit an existing part highlight the part in the parts list using the arrow keys and press the Enter key. After editing the part information select OK to save changes.

## Cut and Material Waste

Material Waste is the amount of waste that is initially cut off of either end due to splitting or defaults. Valid values range from 0 to 10. Cut Waste is the amount of material that is lost with each cycle of the saw because of the blade or mitering. Values can range from 0 to 10. Both of these values are taken into account before and during optimization and if not set correctly will cause poor optimization.

## When Optimization Occurs

Optimization occurs each time a file is loaded onto the main screen when the optimizer option is enabled. If a file contains one or more parts that have been marked as cut optimization does not occur and the file is loaded as is. If you wish to re-optimize a schedule you can open the optimization settings, make the desired changes and then reload the file. You can also re-optimize a schedule file that has been cut by removing the cut flags and then reloading it.

## *Missing Parts*

If you are loading a schedule and the optimizer detects that some parts are not in the optimization parts list it will bring up the Optimizer Material Options dialog with the missing parts already added to the parts list. The missing parts will have a stock length of -1. You must specify a valid stock length before the optimizer can continue.

## File Format

### *Overview*

This section identifies the file format utilized by the FeneVision® Linear Positioner software. Sample files are included during install and can be viewed with NotePad or any other basic text editor. The following sections explain briefly what each part of the file is.

### *The Schedule File*

The schedule file is a file of values separated by commas. The first line of the file is the header and contains all the column headings and designate what each value in the file is. It looks like this

Schedule ID, Unit ID, Batch ID, Part Number, Part Suffix, Order Number, Length, Quantity, Description, Notes, Container ID, Bin, Cut, Material Change, Material Length, Material Notes, Punches

This is all one line and is ended by a carriage return. The following lines in the file are the actual part records. Each one is on its own line with the values that correspond to the header values being separated by commas with the first value being the Schedule ID, the second the Unit ID and so on. For specifics on valid value see the Valid Part Field Values section at the end of this appendix. Each part in the file must be ended by a carriage return, even the last one. Only the Schedule ID, Part Number, Part Suffix, Length and Quantity are required for the file to be valid. If values are to be left out they must be represented by consecutive commas like this

Schedule ID,,,Part Number,Part Suffix,,Length,Quantity,,,,,

Any invalid value found in the file will cause the file to be interpreted as invalid and it may be corrupted on load. To load multiple parts with the same characteristics set the Quantity field to the number of parts you wish to have. When the file is loaded the software sets the Quantity to 1, but loads the part the number of times specified. Putting 10 in the Quantity field would cause the software to put 10 parts of that type on the screen each with a quantity of 1.

## *Parts Comparison*

Parts are compared during the optimization phase of the file load. It is very important to understand how the Linear Positioner compares and interprets part numbers and part suffixes. The following set of rules is to help you understand the differences in parts while you are running the software or designing schedules.

### Comparison

The part number and part suffix are put together to form a comparison string. The following table shows what the comparison string would be for different parts.

<b>Part Number Field</b>	<b>Part Suffix Field</b>	<b>Comparison String</b>
2727W-W	0000	2727W-W
2727	W-W	2727W-W
2727W-W	1234	2727W-W1234
2727W-W	0	2727W-W0

The part suffix 0000 is the default and is considered null and will not show up on message boxes and other prompts and is not considered in the comparison. Comparison is not case sensitive so part 2727w is the same as 2727W. Comparison is not number sensitive so a part with a 0001 suffix is different from a part with a 0010 suffix and a part with a 1 suffix.

## *Part Field Values*

<b>Schedule ID</b>	<b>(REQUIRED)</b> The Schedule ID is of type long and can be any numeric value from 1 to 2 million.
<b>Unit ID</b>	The Unit ID is of type integer and can range from 0 to 32,000.
<b>Batch ID</b>	The Batch ID is of type integer and can range from 0 to 32,000.
<b>Part Numbers</b>	<b>(REQUIRED)</b> Part Numbers can be represented by any character string of length 1 to 16 such as 309W-W, 222XX, X400 or QW290.
<b>Part Suffixes</b>	<b>(REQUIRED)</b> Part Suffixes can be represented by any character string up to 4 characters long such as 0000 ,0010, W-W or CCX.
<b>Order Number</b>	Order Numbers can be represented by a character string of length 0 to 20.

<b>Length</b>	<b>(REQUIRED)</b> Length is a decimal (floating point) number between 0 and 2 million. It can have up to 5 decimal places.
<b>Quantity</b>	<b>(REQUIRED)</b> Quantity is an integer value and can range from 1 to 32,000. If you set this number greater than zero the software will automatically add that many parts to the schedule upon load.
<b>Description</b>	Description can be any character string of length 0 to 50 characters.
<b>Notes</b>	Notes is a character string between 0 and 255 characters in length
<b>Container ID</b>	Container ID is a character string of length 0 to 16
<b>Bin</b>	Bin is a character string of length 0 to 5
<b>Cut</b>	Cut is an integer value normally 0 or 1. Putting a one in this field will cause the part to be marked as cut, 0 will cause it to be not cut
<b>Material Change</b>	Material Change is an integer value normally 0 or 1. If you are doing your own optimization putting a one in this field will cause the software to see the part as a raw material change. It will also display the part in blue on the screen.
<b>Material Length</b>	Material length is a numeric value indicating the stock length of the stick being cut. If you are doing your own optimization putting a value in this field will let the operator know which stock length to pull. If the application is performing the optimization this value is ignored and replaced with the value from the optimization results.
<b>Material Notes</b>	Material Notes is a character string. If you are performing your own optimization place notes about the optimization here such as Reminder (35"). Value is ignored if application is performing the optimization.
<b>Punches</b>	Semi-colon delimited list of punch locations. When displayed on the screen each punch location will have it's own record to move the positioner.

## Adjustment File

The Adjustment File is used to automatically adjust the end stop or feeder movement by part number. If a part number appears in the file the corresponding adjustment value is subtracted from the cut length of the part before the position command is sent to the controller. If the part number is not in the file then no adjustment is made to the cut length of the part. The adjustment file is automatically created by the application if one does not exist. This file is located in the application install directory. The format of the file is indicated below:

### *Adjustmentfile.txt*

Input: PartNumber/PartNumberSuffix/Adjustment below separated by commas

103W,0000,0.5  
104W,0000,-0.5

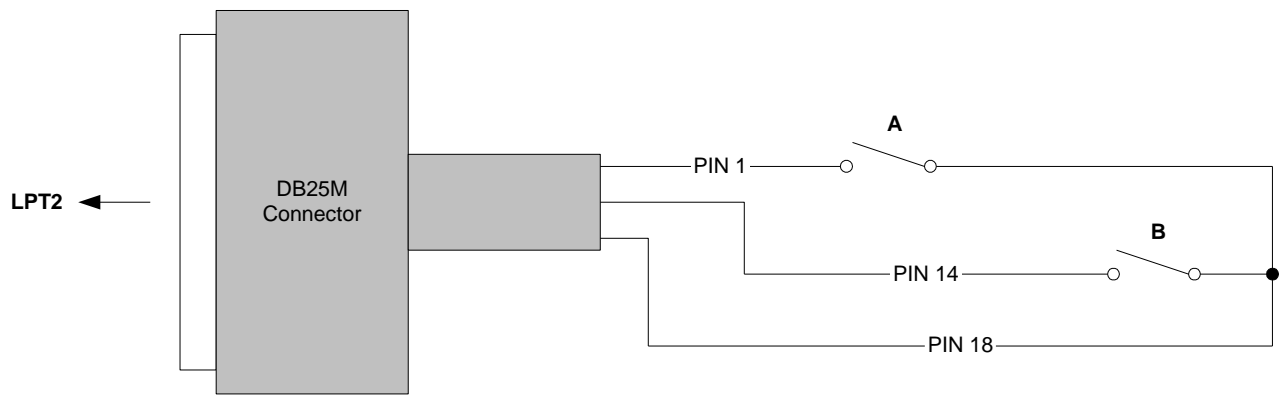
...  
...  
...

## **SAW SETUP**

### *Saw Settings*

Pressing and holding the CTRL, ALT and SHIFT keys at the same time and the pressing the F1 key accesses saw specific settings. The linear positioner may or may not have any of these specific settings. These settings should only be changed by an experienced person who is familiar with the Linear Positioner software.

# **PUSH BUTTON WIRING DIAGRAM**



**A - NORMALLY CLOSED PB USED TO ADVANCE CUTS**  
**B - NORMALLY CLOSED PB USED TO ADVANCE 2ND BINNING MONITOR**

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