CYCLONE SAW AUTOLIST

MAIN SCREEN

To enter Autolist mode from the main screen, select AUTOLIST SCREEN

AUTOLIST SCREEN

Note: Any button on the screen that has a red dot next to it indicates the red button on the left hand control may be used to perform same function.

AUTOLIST SCREEN

Once in the AUTOLIST screen a cutlist may be uploaded. To browse for a cutlist press OPEN FILE then select desired file from the menu

OPEN FILE
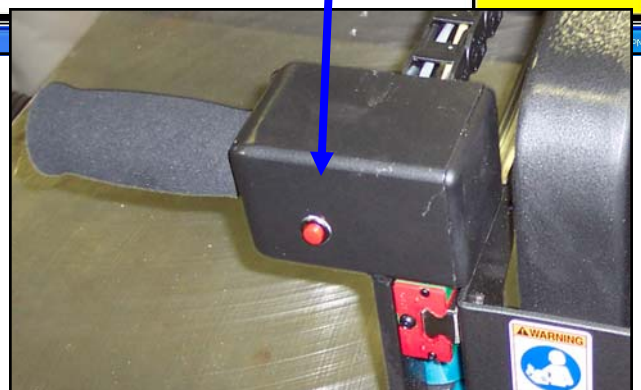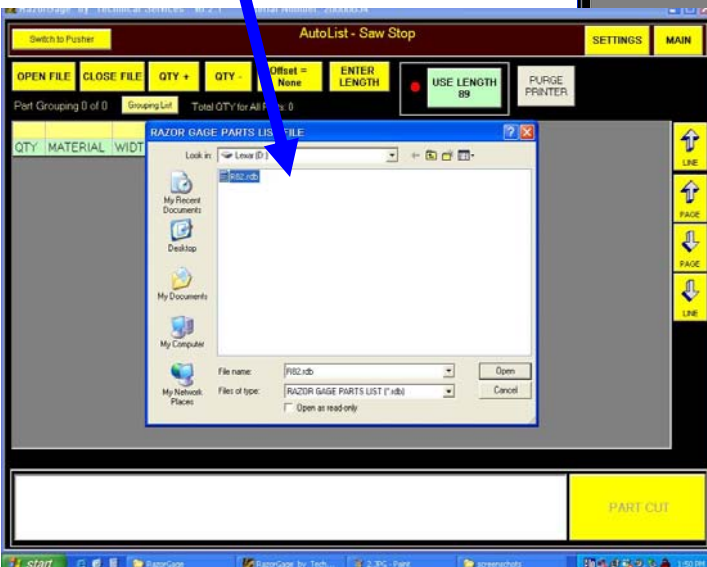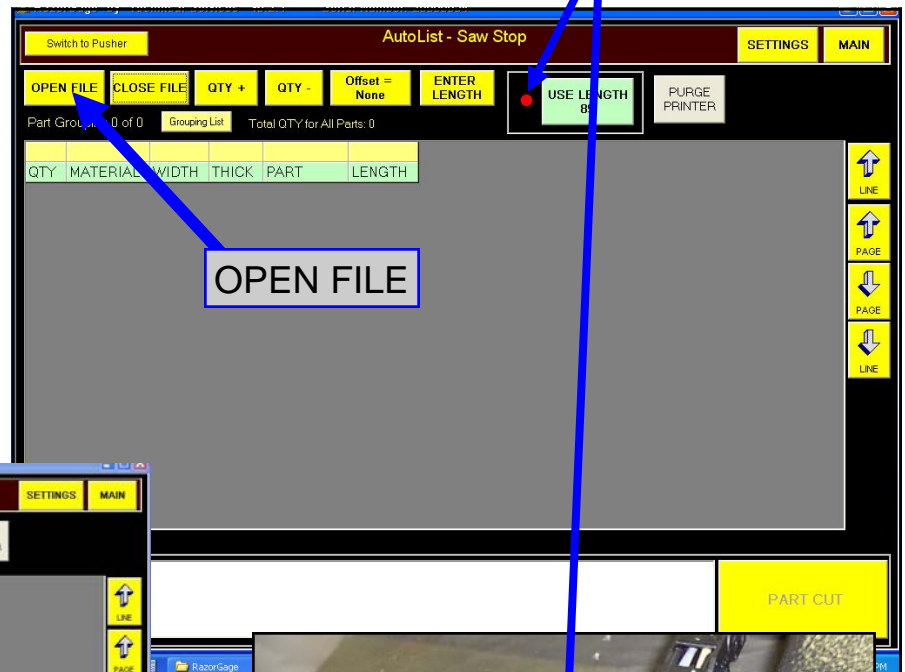
The Autolist option has two main modes: Saw Stop and Pusher mode. To change mode press button in the top left corner of the screen.

Saw Stop mode

In SAW STOP mode a specific part can be selected from the cutlist; the saw stop will automatically move to the appropriate length for that part. Position the material against the stop, cycle the saw & remove the part. Press PART CUT to reduce the quantity by 1.

SWITCH TO PUSHER /
SWITCH TO SAW STOP

Use the quantity buttons to increase or decrease the quantity of each part.

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Switch to Pusher   AutoList - Saw Stop   SETTINGS   MAIN

OPEN FILE   CLOSE FILE   QTY +   QTY -   Offset = None   ENTER LENGTH   ●   USE LENGTH 116   PURGE PRINTER

Part Grouping 1 of 3   Grouping List   Total QTY for All Parts: 143

95	3/4 Hickory				2,049.8
QTY	MATERIAL	WIDTH	THICK	PART	LENGTH
1	3/4 Hickory	3	0.75	Top Rail	40.25
1	3/4 Hickory	2	0.75	Bottom Rail	40.25
3	3/4 Hickory	2	0.75	Bottom Rail	35
0	3/4 Hickory	3	0.75	Top Rail	35
	3/4 Hickory	2	0.75	Right Stile	30.5
	3/4 Hickory	2	0.75	Left Stile	30.5
	3/4 Hickory	2	0.75	Right Stile	30.5
3	3/4 Hickory	2	0.75	Left Stile	30.5
2	3/4 Hickory	2	0.75	Left Stile	30.5
					30.5
					30.5
					30
					30
					30
					30
					26
					26
1	3/4 Hickory	2	0.75	Mid Rail	26

Cutlist

(Note: The part is struck through when the quantity reaches "0")

PART CUT

D:\R82.rdb

R82.rdb Top Rail 3/4 Hickory
3 40.25

PART CUT

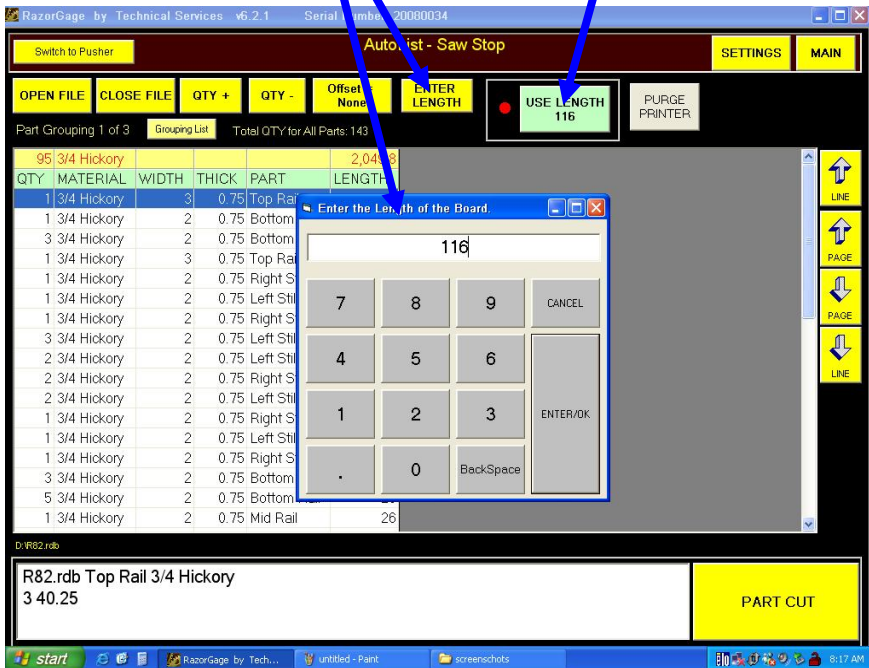start   RazorGage by Tech...   untitled - Paint   screenschots   8:16 AM
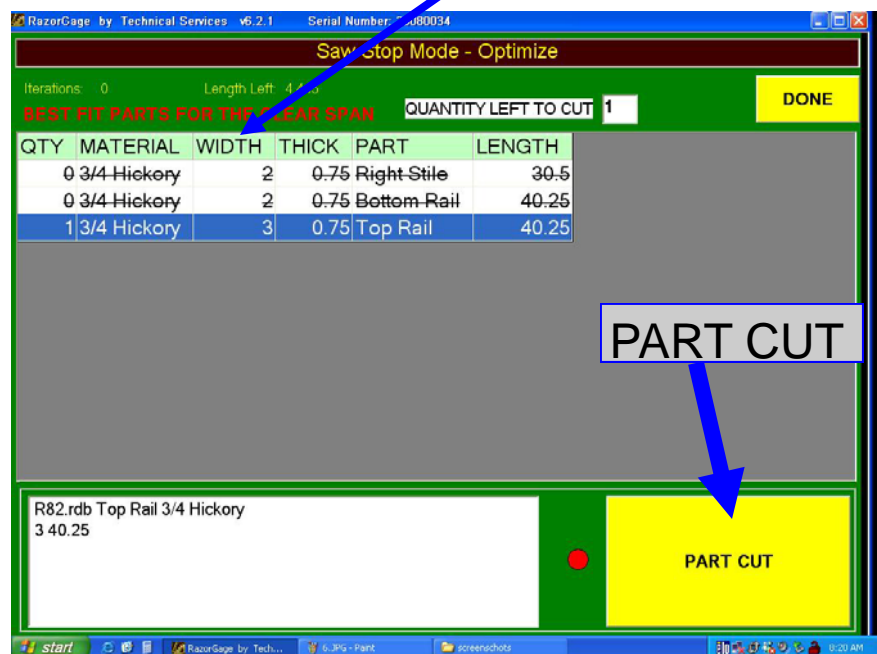
Saw Stop mode

ENTER

USE LENGTH

Saw Stop mode also offers an optimizing option. To start simply enter the length of the material. Next press the USE LENGTH button; the program will automatically select the appropriate parts from the cutlist that will optimize the material.

Best fit parts for specified length

Once the list appears, cycle the saw to make the first cut. Next press the PART CUT button to cross the part off and cue up next part as shown at right.

The original cutlist will automatically update after exiting the optimize screen.

PART CUT

To use the same length of material again press the USE LENGTH button and another list will be formed from the remaining parts on the cutlist.

Pusher mode

In PUSHER mode a specific length of material can be entered the same as in SAW STOP mode. The program will then chose all parts from the cutlist that can be cut from the material.


After entering the length press USE LENGTH. The parts selected by the program will be listed as shown.

SELECTED PARTS

MOVE TO FIRST POSITION

Once the material is loaded onto the table, press MOVE TO FIRST POSITION or press the NEXT BUTTON.

Once in the correct position, cycle the saw. Repeat this step to complete all cuts.

Notice the bottom of the screen displays the current position at all times. Each yellow dot signals the cut is not complete. Each red dot signals the cut is complete.

Done

Positions Displayed

When finished press done to return to the Autolist screen
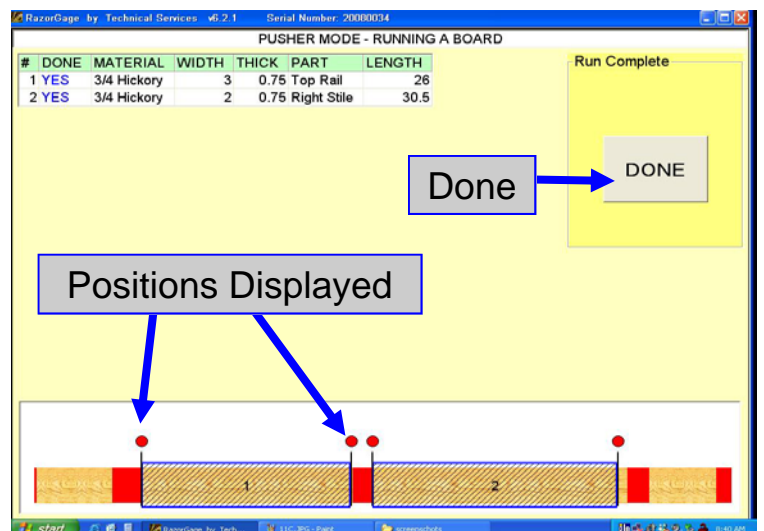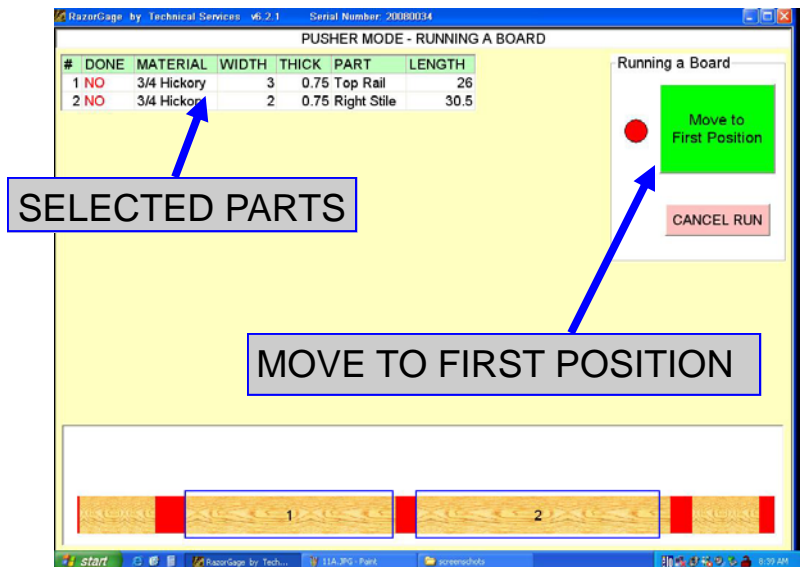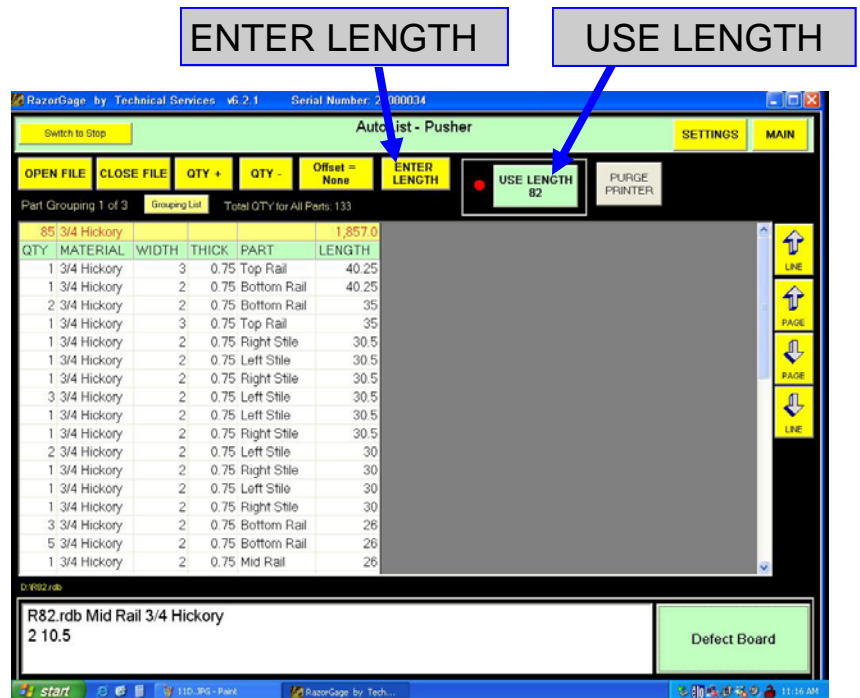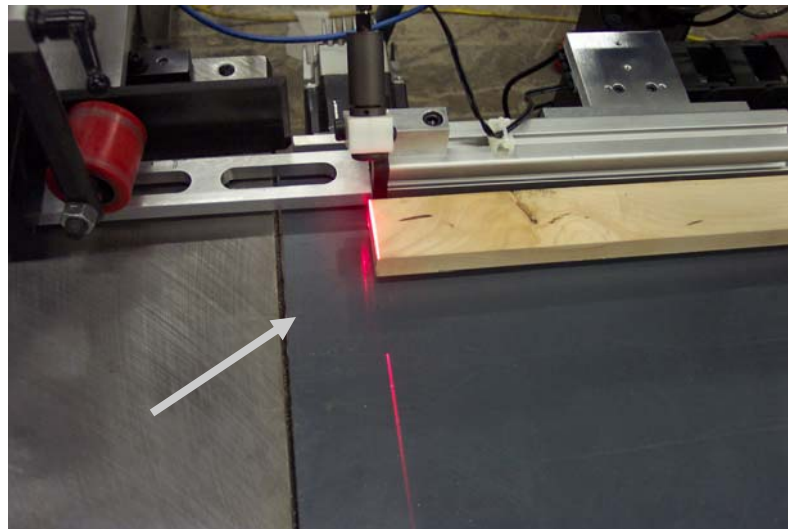
Pusher mode

Defect Board

In PUSHER mode there is a defecting option available also.   To begin press the DEFECT BOARD button in the lower right corner of the Autolist screen.

Once in the DEFECTING screen select MOVE TO DEFECT START.
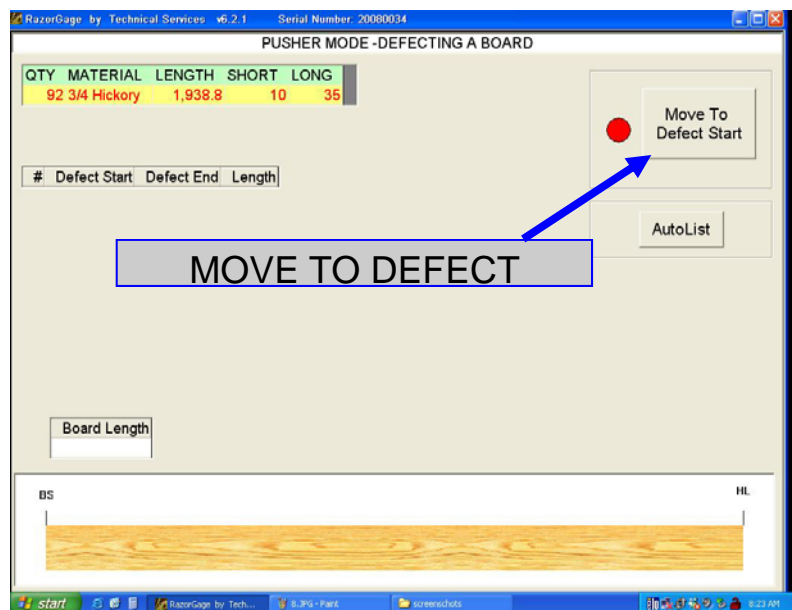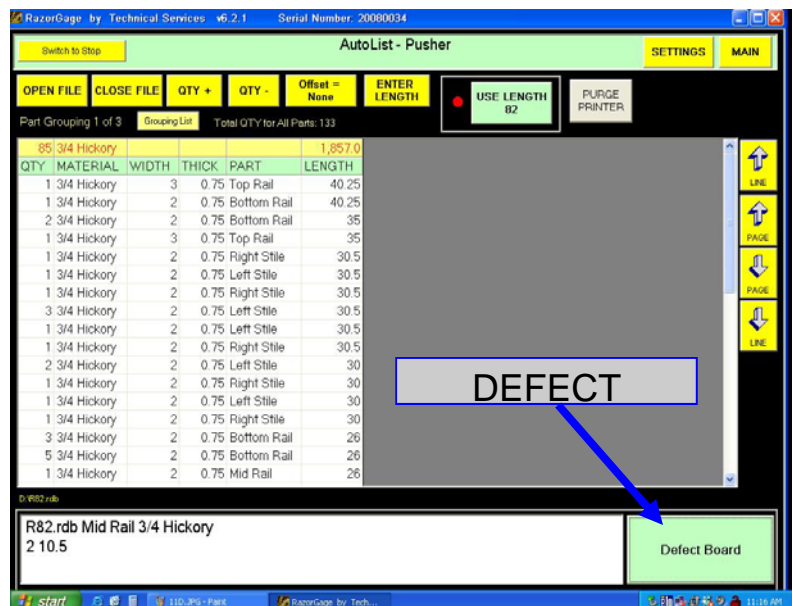
Next align the end of the material up with the line laser mounted on the saw stop as shown to the right.

Next use the joystick on the right hand control to feed the laser past the material.
Note: if the joystick is pushed immediately to it's maximum position the saw stop will not move.
Slowly advance the pusher w/laser down the length of board. When the laser line approaches a defect push in & hold the red button. When the laser line reaches the end of the defect, release the red button. Repeat this process for the full length of the board, stopping with the laser line at the end of the board.
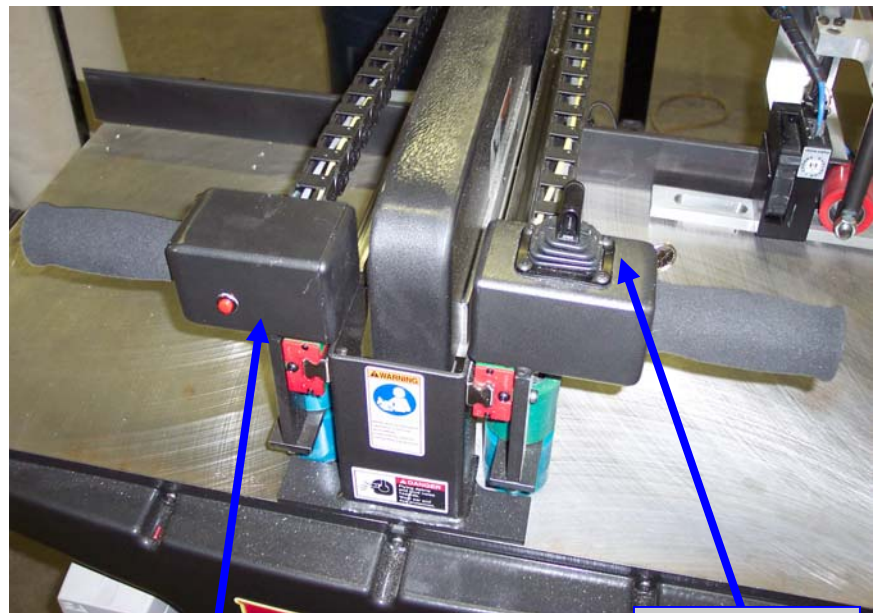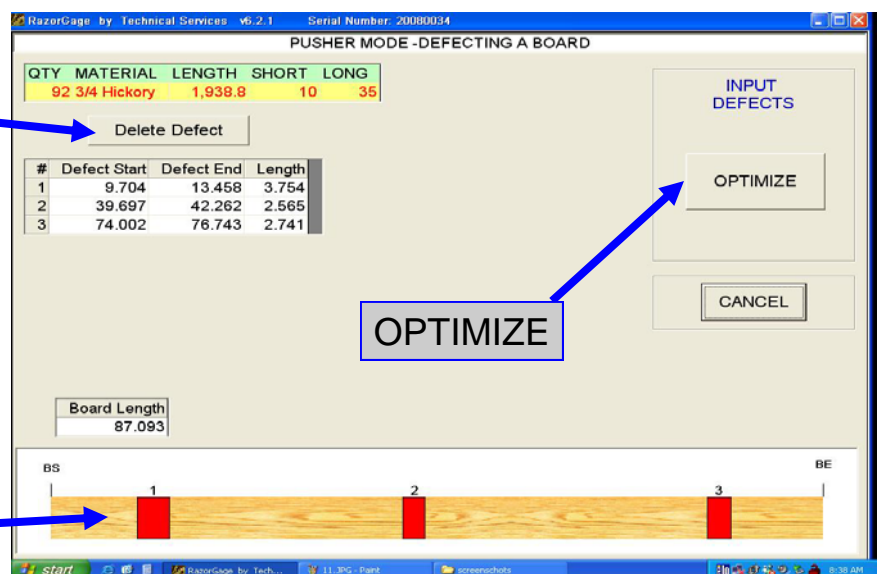
Press either END OF BOARD WAIT or END OF BOARD OPTIMIZE.

END OF BOARD WAIT will show the selection of defects highlighted in red and give an option to delete a defect or optimize.

END OF BOARD OPTIMIZE will automatically optimize according to the defects highlighted.

RED BUTTON

JOYSTICK

DELETE DEFECT

OPTIMIZE

DEFECTS HIGHLIGHTED

SETTINGS PAGE

From the main Autolist screen the SETTINGS menu can be accessed.

Settings

The trim at start/ end parameters set the default length that the saw will cut off of the ends of a board to ensure the finished parts are square at each end.

LOAD-OUT OFFSET
Load position equals Part length + Offset. This allows extra room for easy loading of the material.