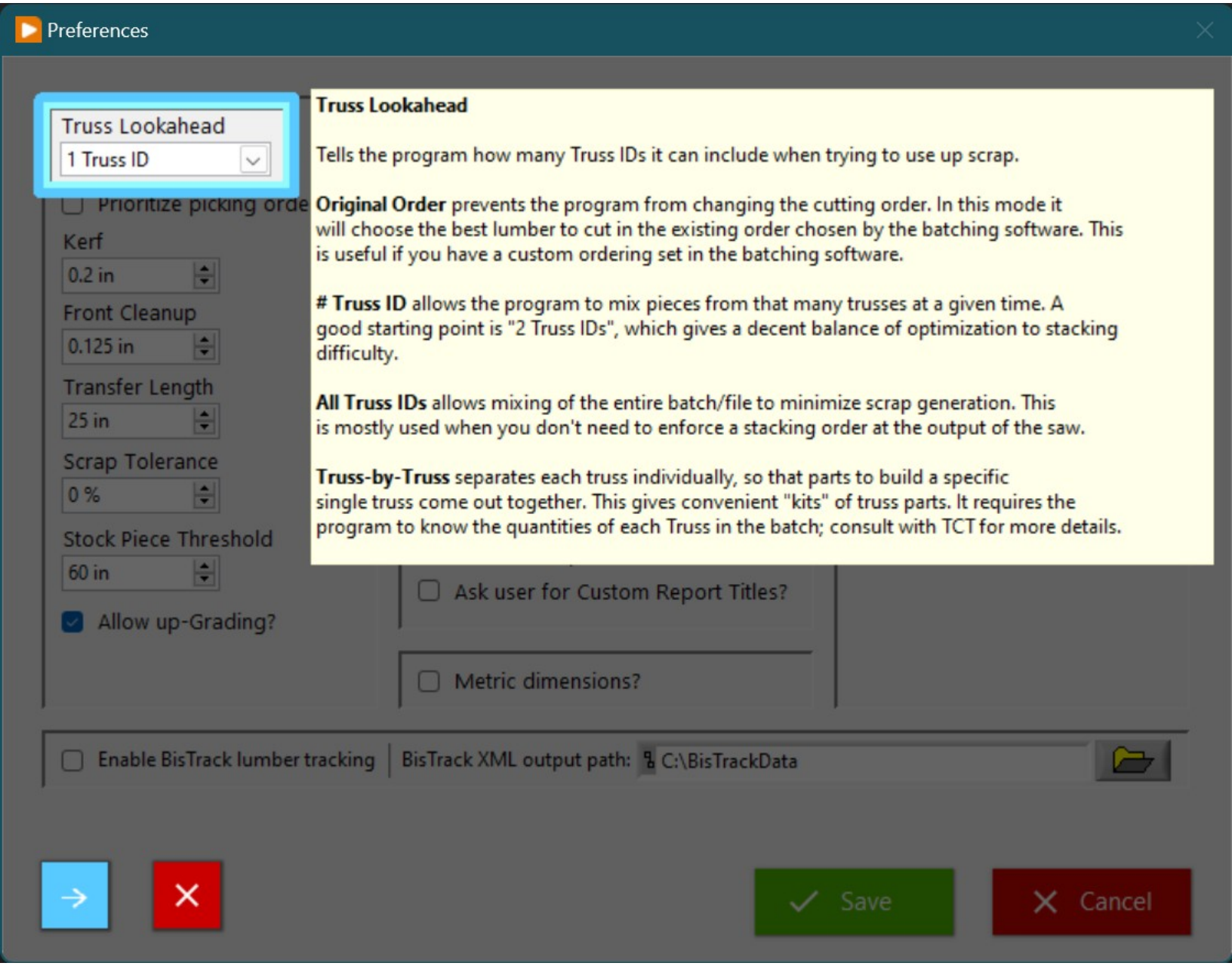
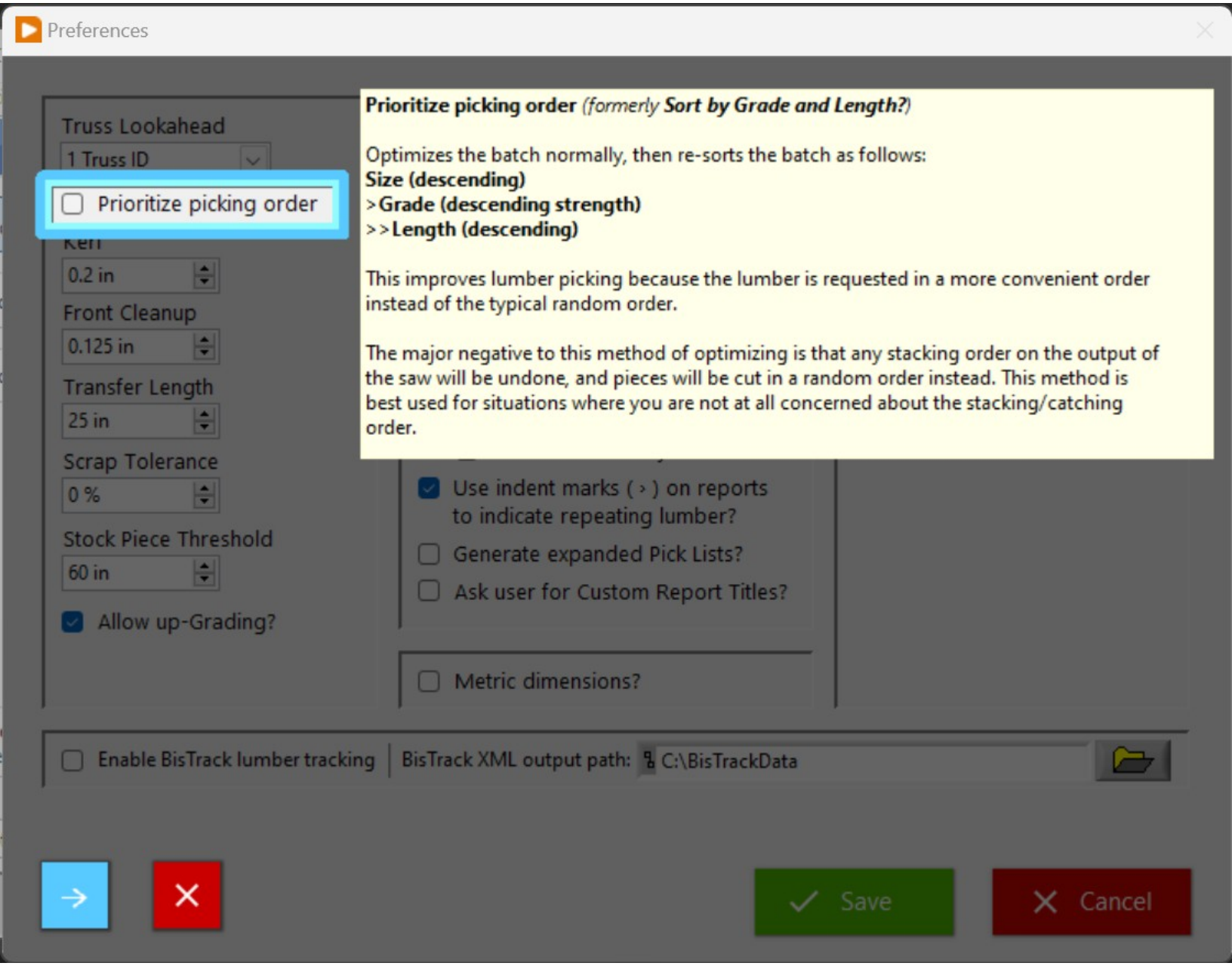
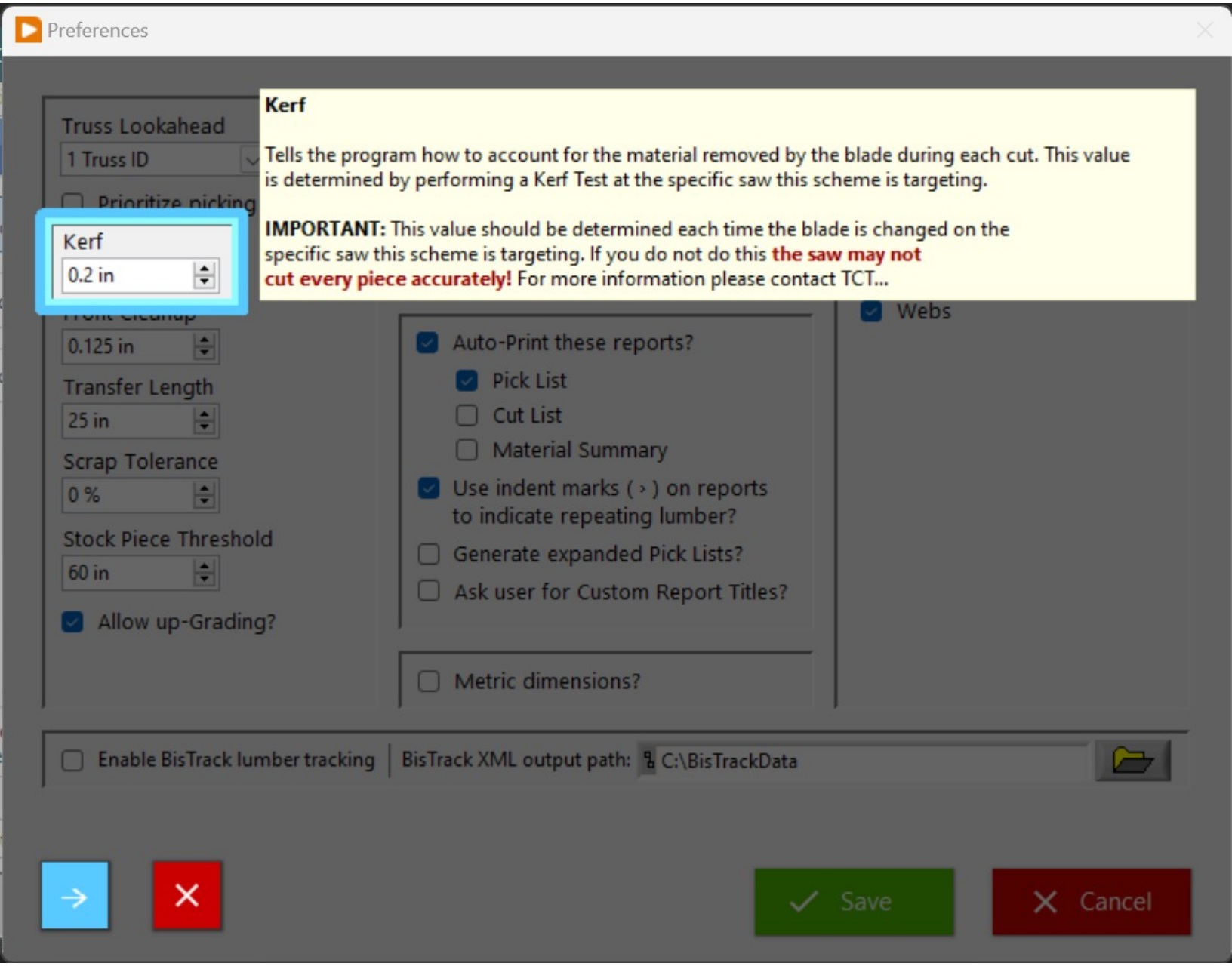
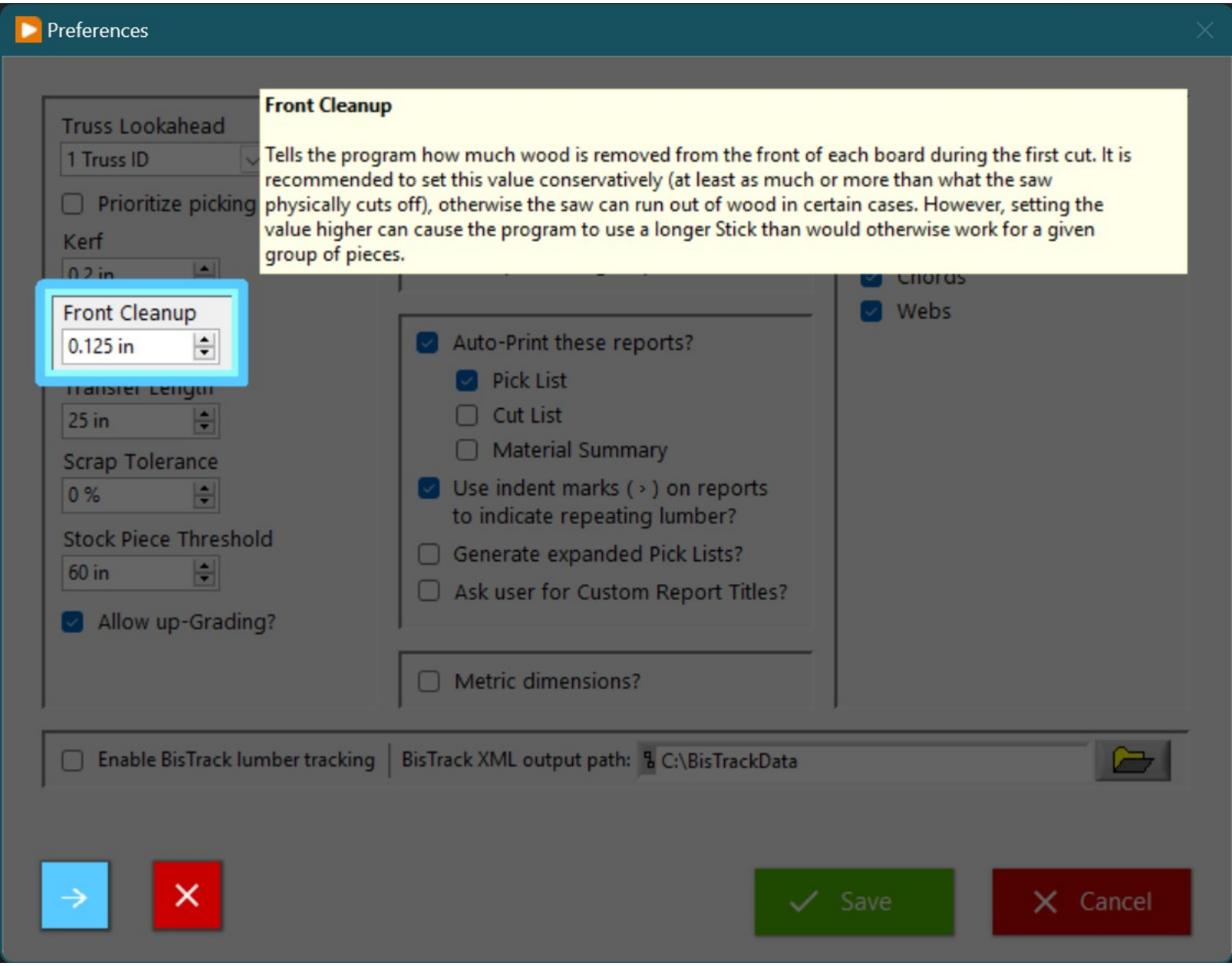
TCT XLOpt Training

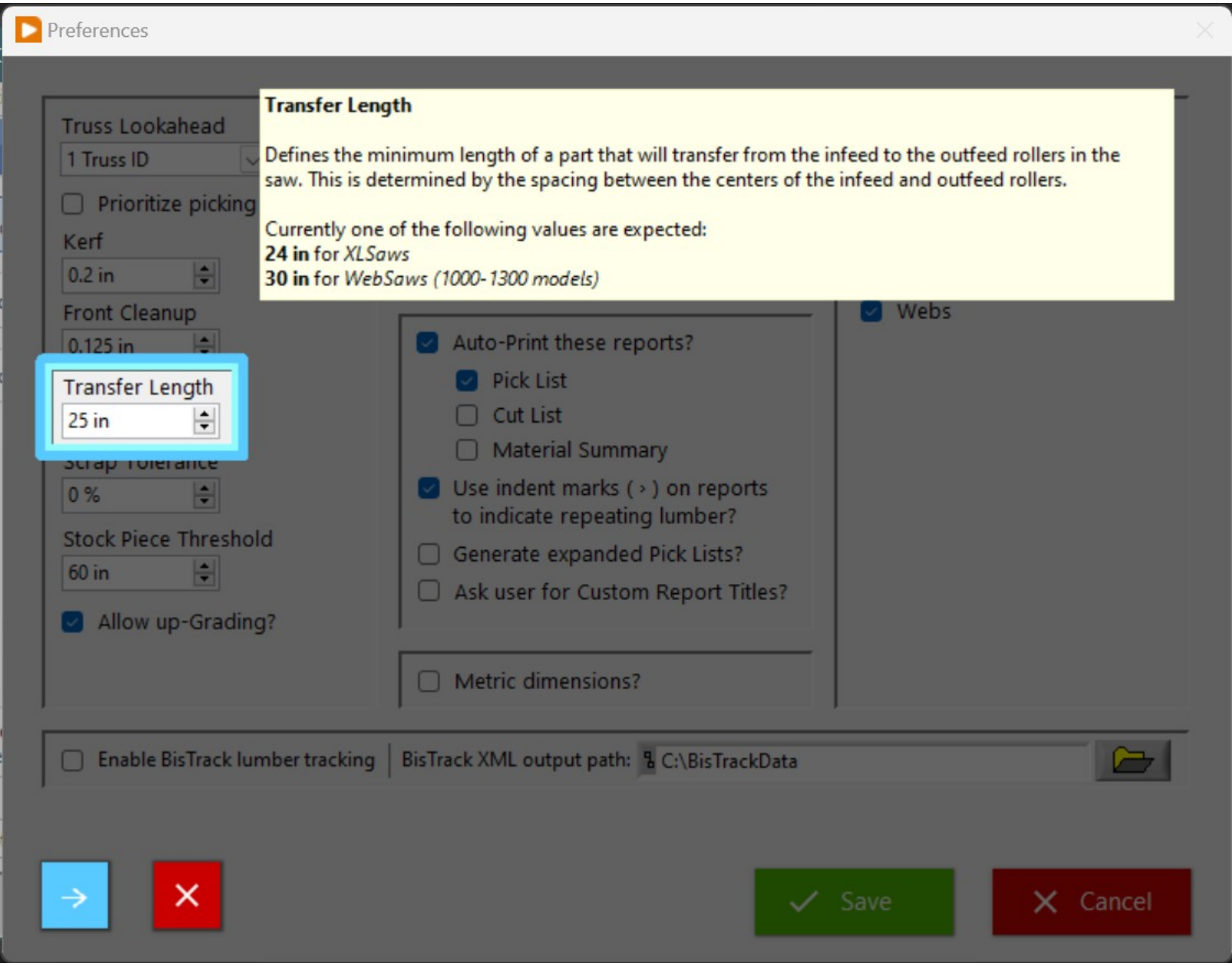
Preferences Screen (v6.20.1)

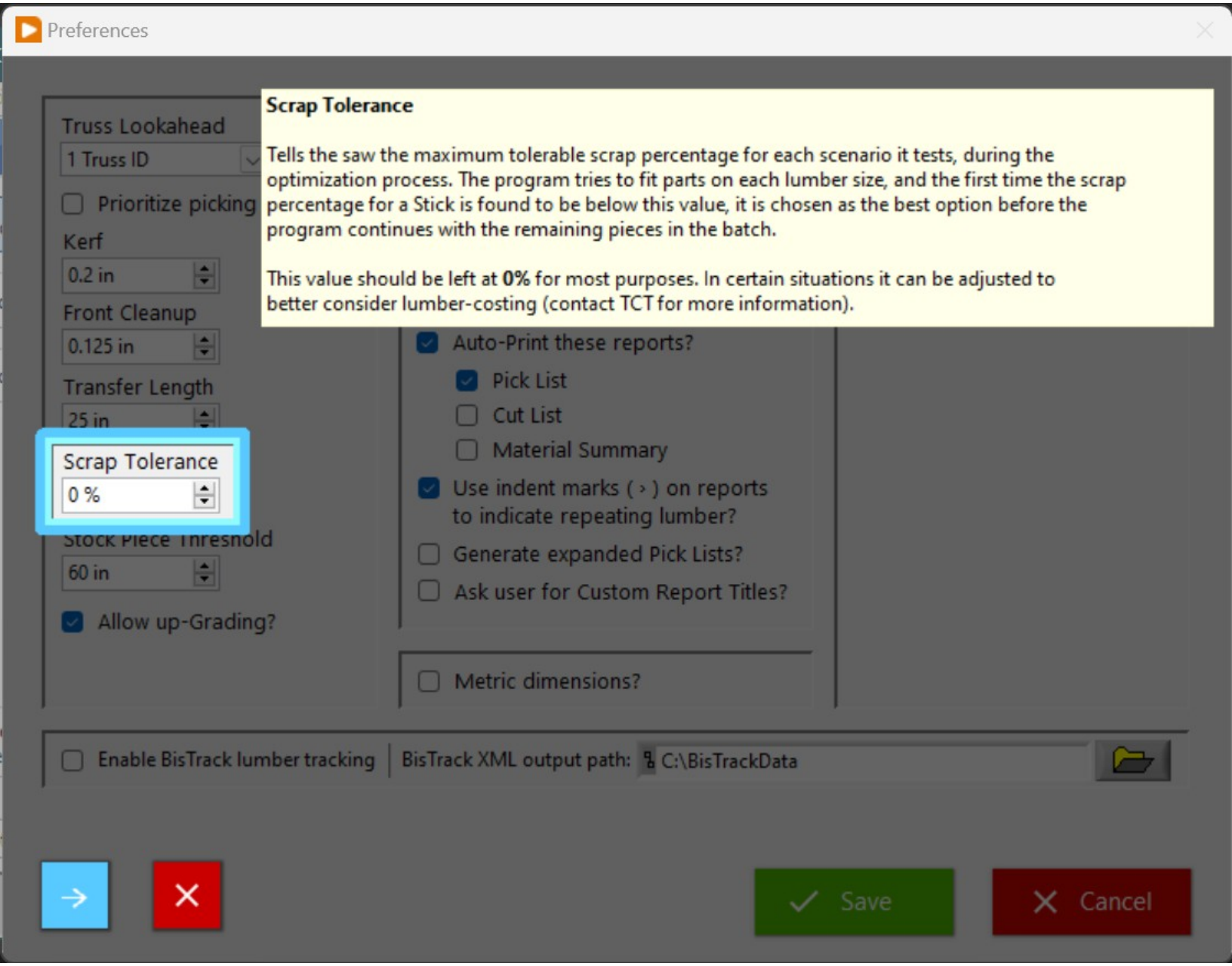

Preferences
Truss Lookahead
1 Truss ID
Prioritize picking orde
Kerf
0.2 in
Front Cleanup
0.125 in
Transfer Length
25 in
Scrap Tolerance
0 %
Stock Piece Threshold
60 in
Allow up-Grading?
Truss Lookahead
Tells the program how many Truss IDs it can include when trying to use up scrap.
Original Order prevents the program from changing the cutting order. In this mode it will choose the best lumber to cut in the existing order chosen by the batching software. This is useful if you have a custom ordering set in the batching software.
Truss ID allows the program to mix pieces from that many trusses at a given time. A good starting point is "2 Truss IDs", which gives a decent balance of optimization to stacking difficulty.
All Truss IDs allows mixing of the entire batch/file to minimize scrap generation. This is mostly used when you don't need to enforce a stacking order at the output of the saw.
Truss-by-Truss separates each truss individually, so that parts to build a specific single truss come out together. This gives convenient "kits" of truss parts. It requires the program to know the quantities of each Truss in the batch; consult with TCT for more details.
Ask user for Custom Report Titles?
Metric dimensions?
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel

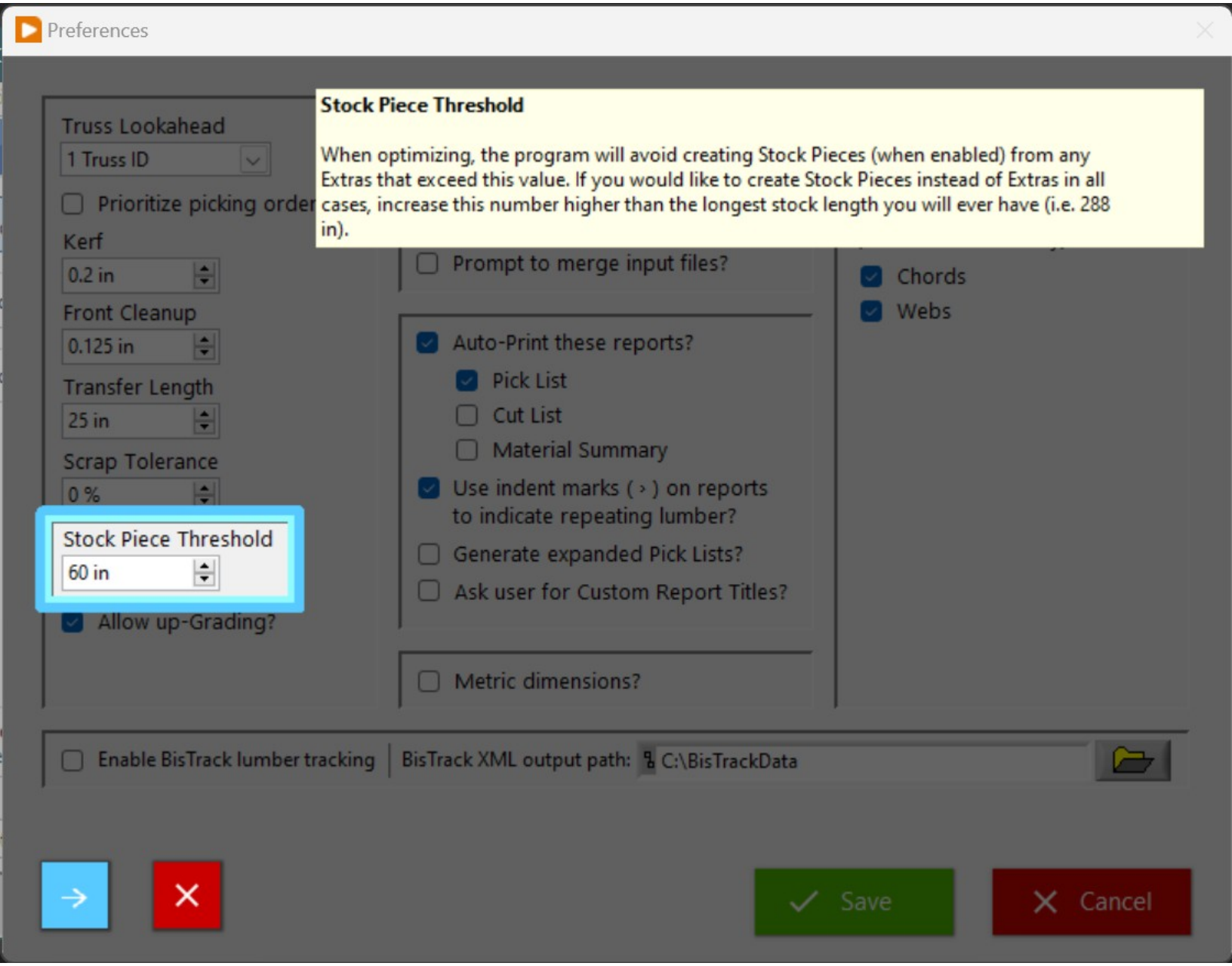

Preferences
Truss Lookahead
1 Truss ID
Prioritize picking order
0.2 in
Front Cleanup
0.125 in
Transfer Length
25 in
Scrap Tolerance
0 %
Stock Piece Threshold
60 in
Allow up-Grading?
Prioritize picking order (formerly Sort by Grade and Length?)
Optimizes the batch normally, then re-sorts the batch as follows:
Size (descending)
>Grade (descending strength)
>>Length (descending)
This improves lumber picking because the lumber is requested in a more convenient order instead of the typical random order.
The major negative to this method of optimizing is that any stacking order on the output of the saw will be undone, and pieces will be cut in a random order instead. This method is best used for situations where you are not at all concerned about the stacking/catching order.
Use indent marks (›) on reports to indicate repeating lumber?
Generate expanded Pick Lists?
Ask user for Custom Report Titles?
Metric dimensions?
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel

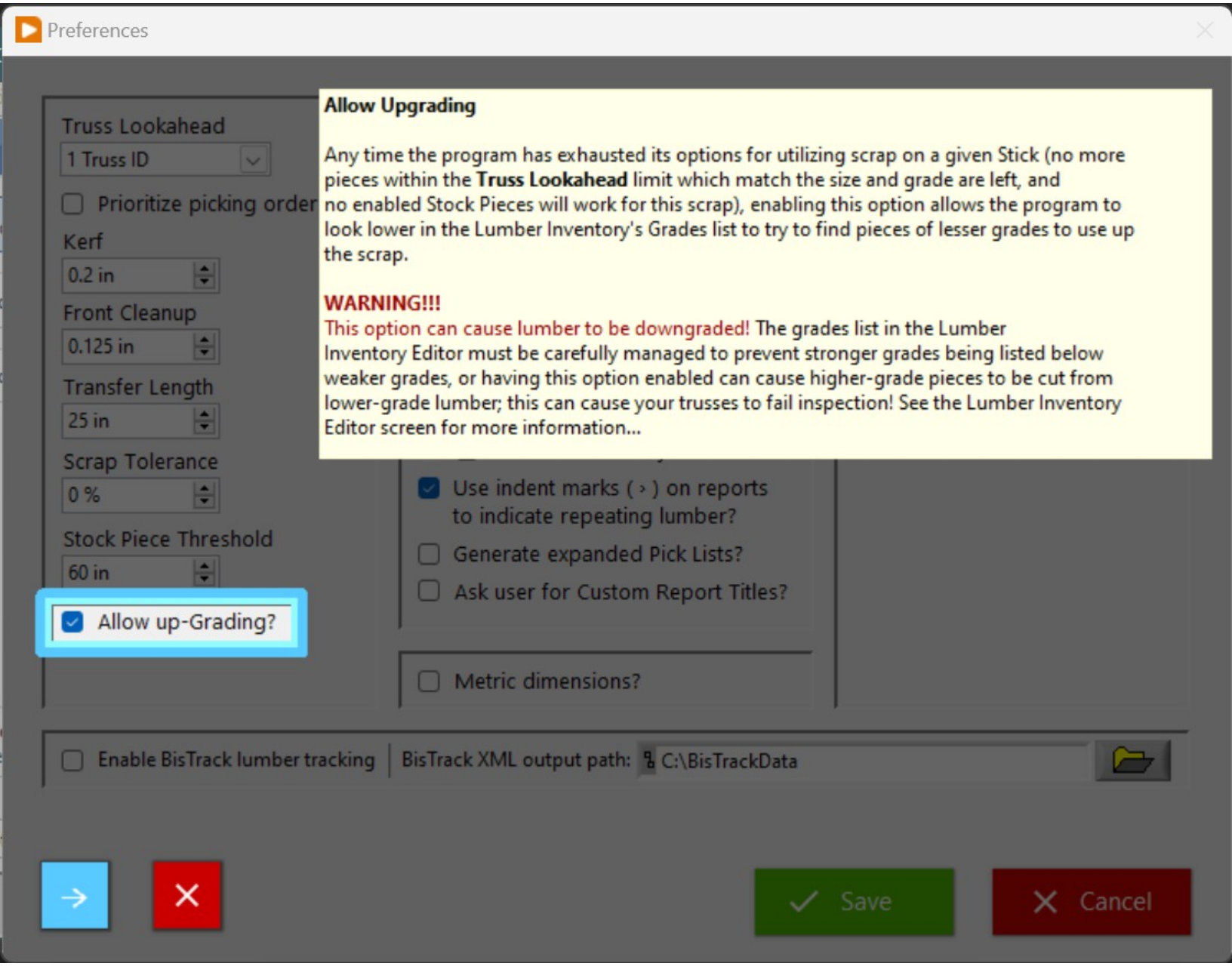

Preferences
Kerf
Tells the program how to account for the material removed by the blade during each cut. This value is determined by performing a Kerf Test at the specific saw this scheme is targeting.
IMPORTANT: This value should be determined each time the blade is changed on the specific saw this scheme is targeting. If you do not do this the saw may not cut every piece accurately! For more information please contact TCT...
Truss Lookahead
1 Truss ID
Kerf
0.2 in
0.125 in
Transfer Length
25 in
Scrap Tolerance
0 %
Stock Piece Threshold
60 in
Allow up-Grading?
Auto-Print these reports?
Pick List
Cut List
Material Summary
Use indent marks (›) on reports to indicate repeating lumber?
Generate expanded Pick Lists?
Ask user for Custom Report Titles?
Metric dimensions?
Webs
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel

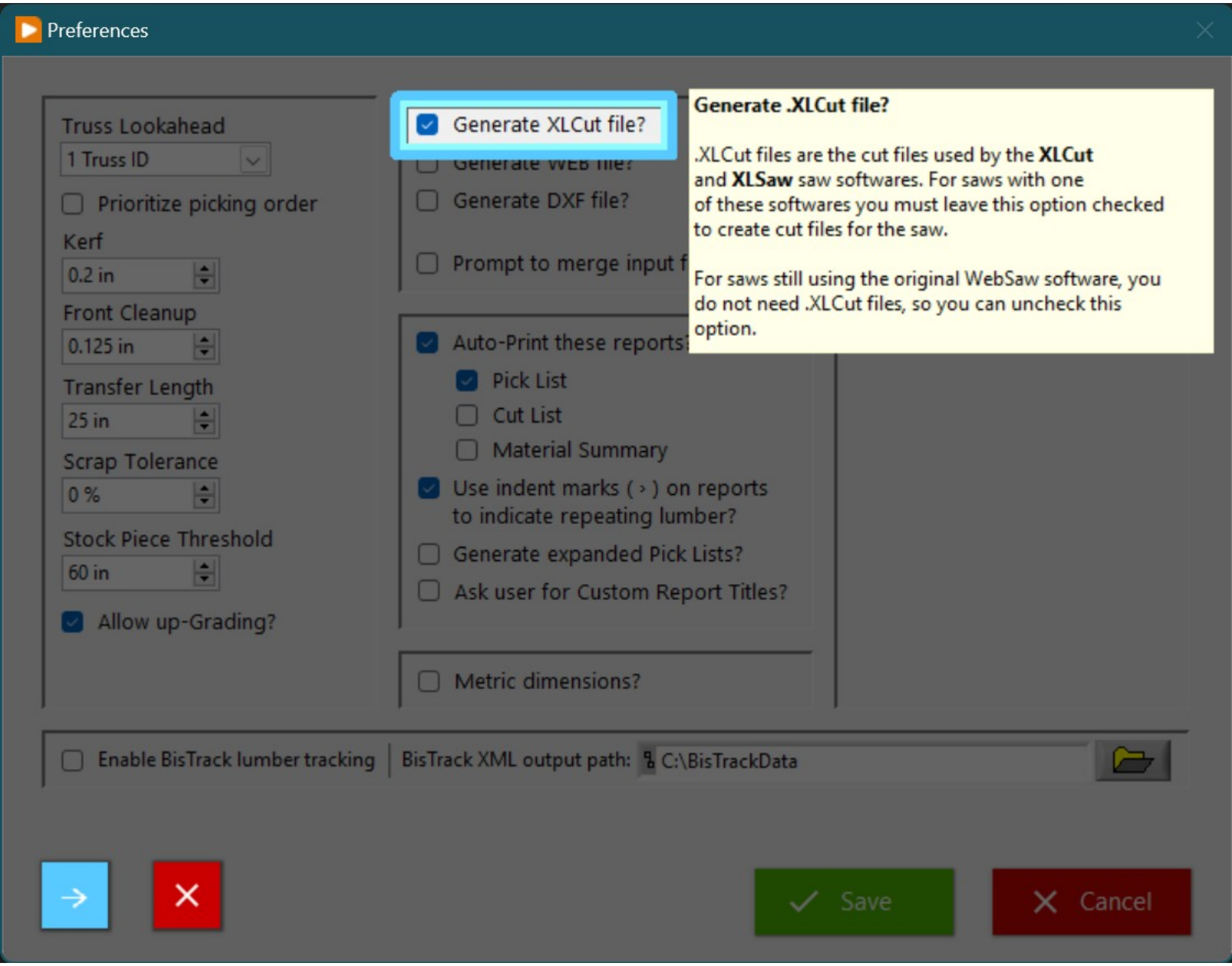

Preferences
Front Cleanup
Tells the program how much wood is removed from the front of each board during the first cut. It is recommended to set this value conservatively (at least as much or more than what the saw physically cuts off), otherwise the saw can run out of wood in certain cases. However, setting the value higher can cause the program to use a longer Stick than would otherwise work for a given group of pieces.
Truss Lookahead
1 Truss ID
Prioritize picking
Kerf
Front Cleanup
0.125 in
25 in
Scrap Tolerance
0 %
Stock Piece Threshold
60 in
Allow up-Grading?
Auto-Print these reports?
Pick List
Cut List
Material Summary
Use indent marks (›) on reports to indicate repeating lumber?
Generate expanded Pick Lists?
Ask user for Custom Report Titles?
Metric dimensions?
Webs
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel


Preferences
Transfer Length
Defines the minimum length of a part that will transfer from the infeed to the outfeed rollers in the saw. This is determined by the spacing between the centers of the infeed and outfeed rollers.
Currently one of the following values are expected:
24 in for XLSaws
30 in for WebSaws (1000-1300 models)
Truss Lookahead
1 Truss ID
Prioritize picking
Kerf
0.2 in
Front Cleanup
0.125 in
Transfer Length
25 in
0 %
Stock Piece Threshold
60 in
Allow up-Grading?
Auto-Print these reports?
Pick List
Cut List
Material Summary
Use indent marks (›) on reports to indicate repeating lumber?
Generate expanded Pick Lists?
Ask user for Custom Report Titles?
Metric dimensions?
Webs
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel


Preferences
Scrap Tolerance
Tells the saw the maximum tolerable scrap percentage for each scenario it tests, during the optimization process. The program tries to fit parts on each lumber size, and the first time the scrap percentage for a Stick is found to be below this value, it is chosen as the best option before the program continues with the remaining pieces in the batch.
This value should be left at 0% for most purposes. In certain situations it can be adjusted to better consider lumber-costing (contact TCT for more information).
Truss Lookahead
1 Truss ID
Prioritize picking
Kerf
0.2 in
Front Cleanup
0.125 in
Transfer Length
25 in
Scrap Tolerance
0 %
Stock Piece Threshold
60 in
Allow up-Grading?
Auto-Print these reports?
Pick List
Cut List
Material Summary
Use indent marks (›) on reports to indicate repeating lumber?
Generate expanded Pick Lists?
Ask user for Custom Report Titles?
Metric dimensions?
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel


Preferences
Stock Piece Threshold
When optimizing, the program will avoid creating Stock Pieces (when enabled) from any Extras that exceed this value. If you would like to create Stock Pieces instead of Extras in all cases, increase this number higher than the longest stock length you will ever have (i.e. 288 in).
Truss Lookahead
1 Truss ID
Prioritize picking order
Kerf
0.2 in
Front Cleanup
0.125 in
Transfer Length
25 in
Scrap Tolerance
0 %
Stock Piece Threshold
60 in
Allow up-Grading?
Prompt to merge input files?
Auto-Print these reports?
Pick List
Cut List
Material Summary
Use indent marks (›) on reports to indicate repeating lumber?
Generate expanded Pick Lists?
Ask user for Custom Report Titles?
Metric dimensions?
Chords
Webs
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel


Preferences
Truss Lookahead
1 Truss ID
Prioritize picking order
Kerf
0.2 in
Front Cleanup
0.125 in
Transfer Length
25 in
Scrap Tolerance
0 %
Stock Piece Threshold
60 in
Allow up-Grading?
Allow Upgrading
Any time the program has exhausted its options for utilizing scrap on a given Stick (no more pieces within the Truss Lookahead limit which match the size and grade are left, and no enabled Stock Pieces will work for this scrap), enabling this option allows the program to look lower in the Lumber Inventory's Grades list to try to find pieces of lesser grades to use up the scrap.
WARNING!!!
This option can cause lumber to be downgraded! The grades list in the Lumber Inventory Editor must be carefully managed to prevent stronger grades being listed below weaker grades, or having this option enabled can cause higher-grade pieces to be cut from lower-grade lumber; this can cause your trusses to fail inspection! See the Lumber Inventory Editor screen for more information...
Use indent marks (›) on reports to indicate repeating lumber?
Generate expanded Pick Lists?
Ask user for Custom Report Titles?
Metric dimensions?
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel


Preferences
Truss Lookahead
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Prioritize picking order
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Transfer Length
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Scrap Tolerance
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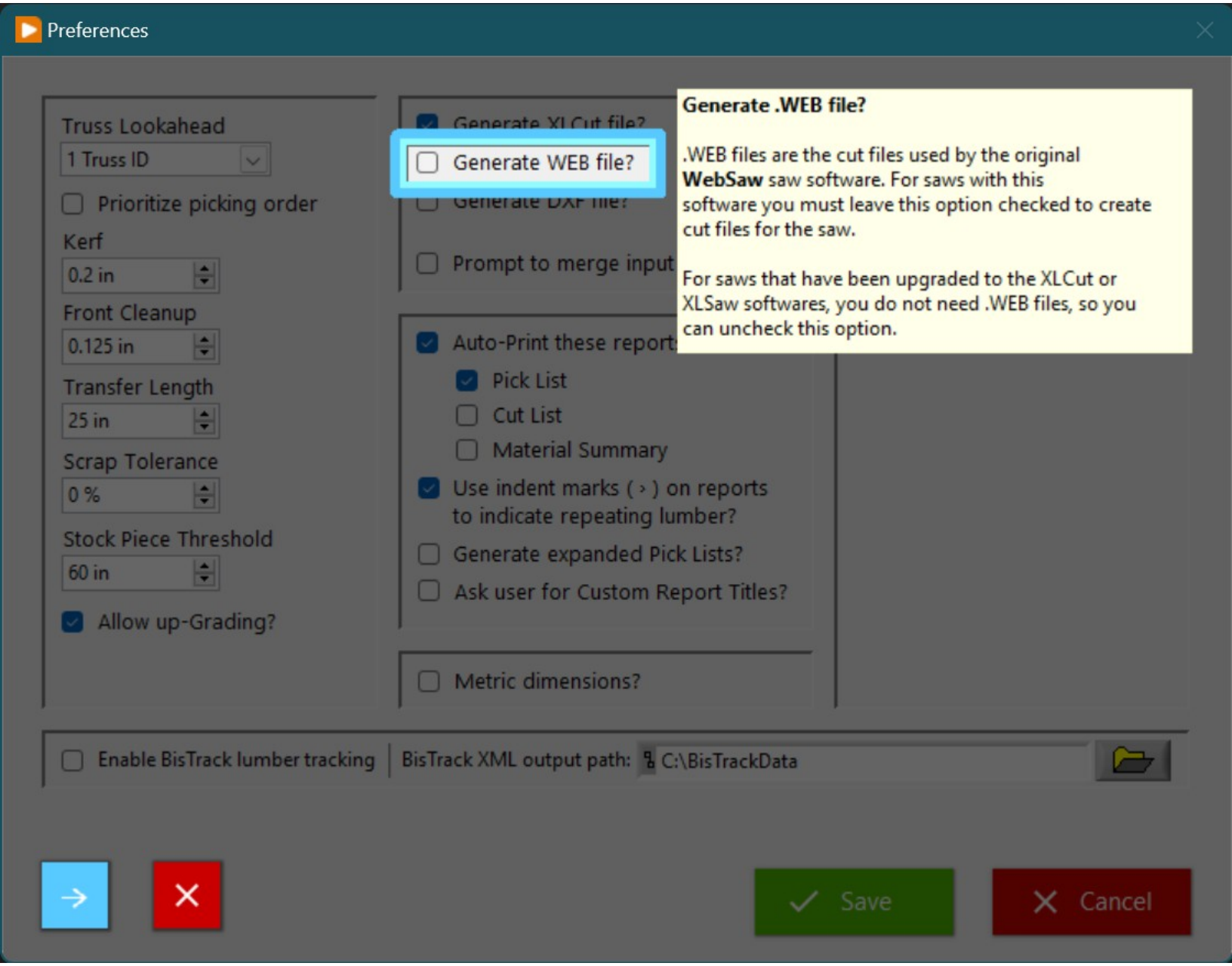
Stock Piece Threshold
60 in
Allow up-Grading?
Generate XLCut file?
Generate DXF file?
Prompt to merge input f
Auto-Print these reports?
Pick List
Cut List
Material Summary
Use indent marks (›) on reports to indicate repeating lumber?
Generate expanded Pick Lists?
Ask user for Custom Report Titles?
Metric dimensions?
Generate .XLCut file?
.XLCut files are the cut files used by the XLCut and XLSaw saw softwares. For saws with one of these softwares you must leave this option checked to create cut files for the saw.
For saws still using the original WebSaw software, you do not need .XLCut files, so you can uncheck this option.
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel


Preferences
Truss Lookahead
1 Truss ID
Prioritize picking order
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Transfer Length
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Scrap Tolerance
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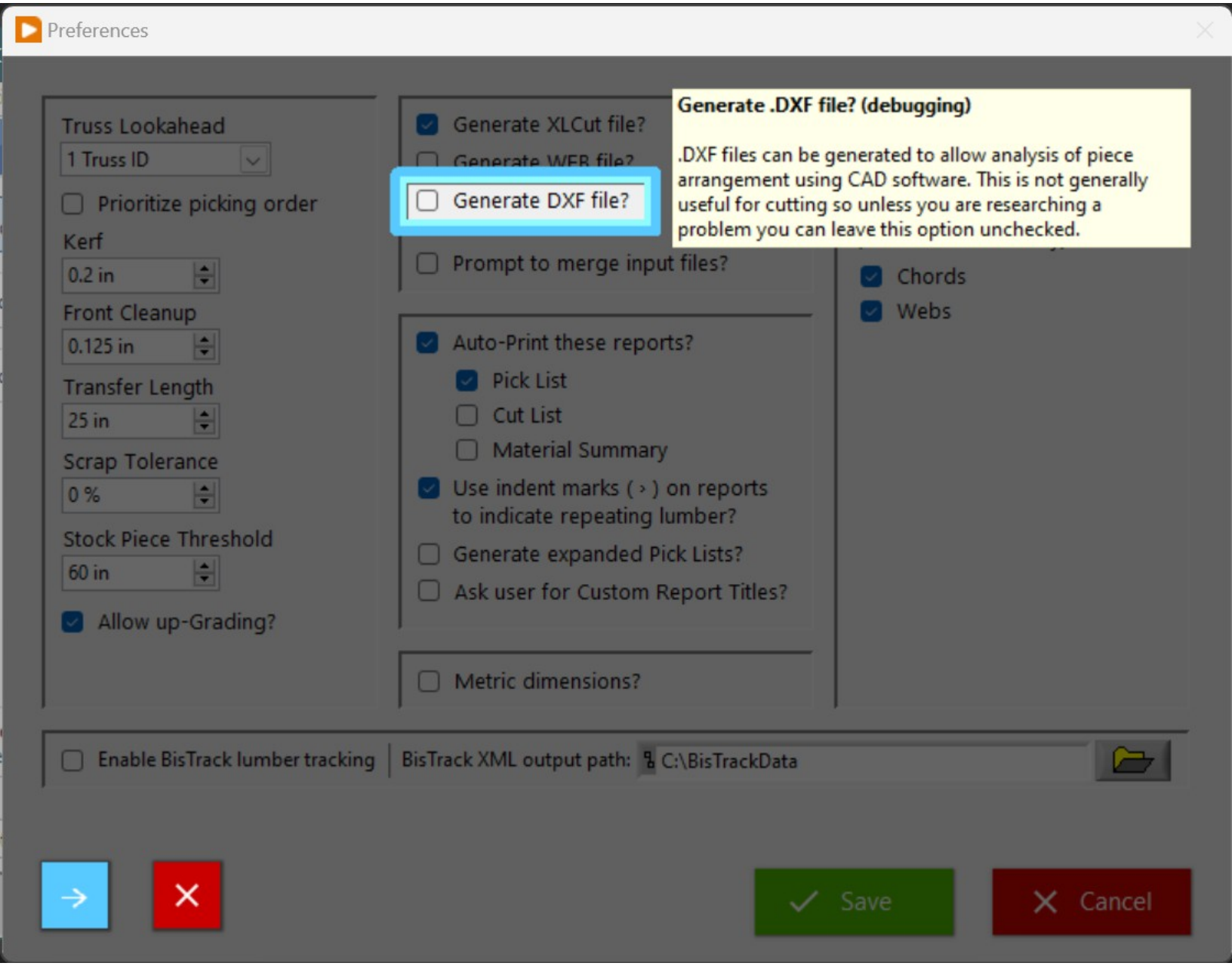
Allow up-Grading?
Generate XLCut file?
Generate WEB file?
Generate DXF file?
Prompt to merge input
Auto-Print these reports
Pick List
Cut List
Material Summary
Use indent marks (›) on reports to indicate repeating lumber?
Generate expanded Pick Lists?
Ask user for Custom Report Titles?
Metric dimensions?
Generate .WEB file?
.WEB files are the cut files used by the original WebSaw saw software. For saws with this software you must leave this option checked to create cut files for the saw.
For saws that have been upgraded to the XLCut or XLSaw softwares, you do not need .WEB files, so you can uncheck this option.
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel


Preferences
Truss Lookahead
1 Truss ID
Prioritize picking order
Kerf
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Front Cleanup
0.125 in
Transfer Length
25 in
Scrap Tolerance
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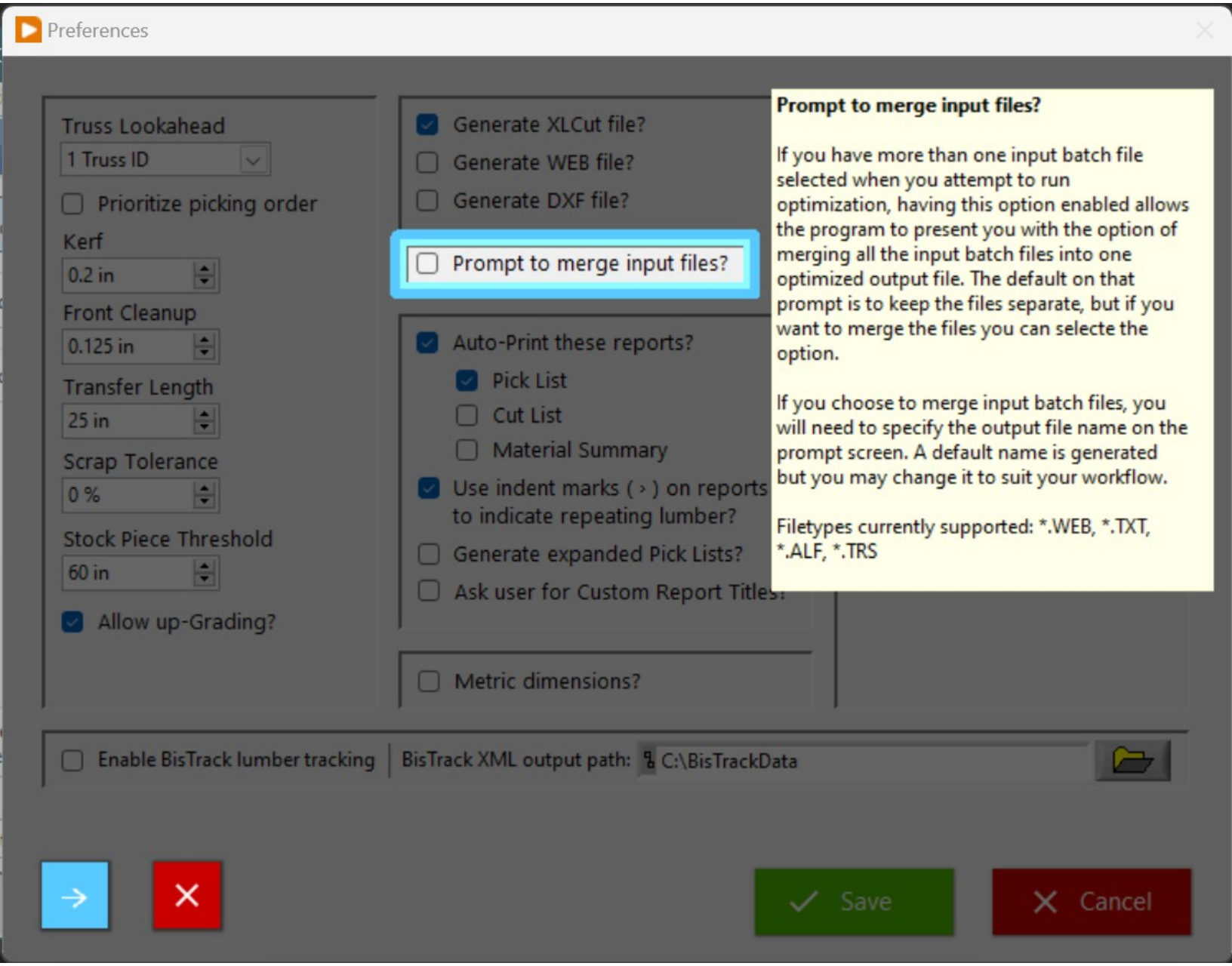
Stock Piece Threshold
60 in
Allow up-Grading?
Generate XLCut file?
Generate DXF file?
Prompt to merge input files?
Auto-Print these reports?
Pick List
Cut List
Material Summary
Use indent marks (›) on reports to indicate repeating lumber?
Generate expanded Pick Lists?
Ask user for Custom Report Titles?
Metric dimensions?
Generate .DXF file? (debugging)
.DXF files can be generated to allow analysis of piece arrangement using CAD software. This is not generally useful for cutting so unless you are researching a problem you can leave this option unchecked.
Chords
Webs
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel


Preferences
Truss Lookahead
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Prioritize picking order
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Front Cleanup
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Transfer Length
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Scrap Tolerance
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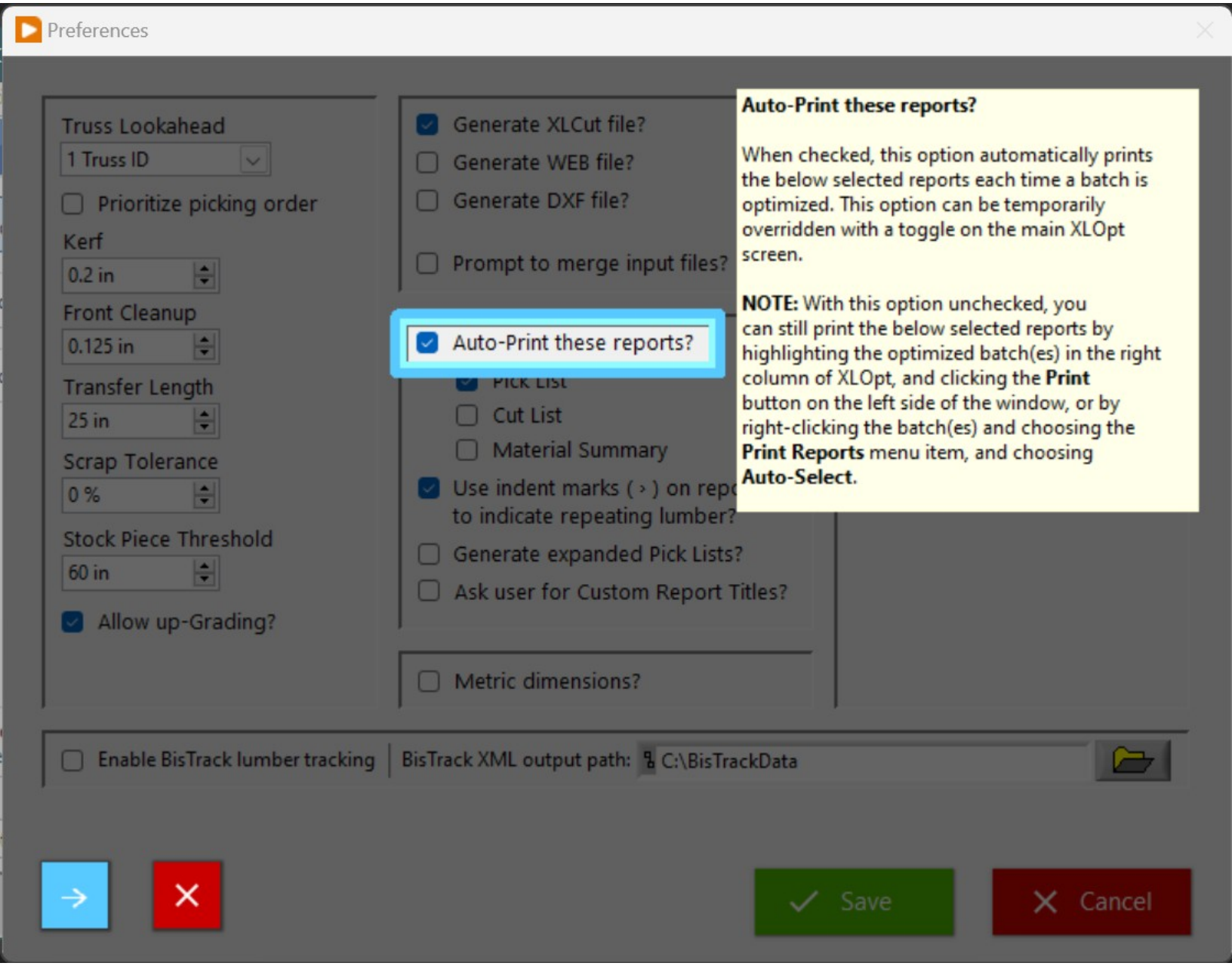
Stock Piece Threshold
60 in
Allow up-Grading?
Generate XLCut file?
Generate WEB file?
Generate DXF file?
Prompt to merge input files?
Auto-Print these reports?
Pick List
Cut List
Material Summary
Use indent marks (›) on reports to indicate repeating lumber?
Generate expanded Pick Lists?
Ask user for Custom Report Titles?
Metric dimensions?
Prompt to merge input files?
If you have more than one input batch file selected when you attempt to run optimization, having this option enabled allows the program to present you with the option of merging all the input batch files into one optimized output file. The default on that prompt is to keep the files separate, but if you want to merge the files you can selecte the option.
If you choose to merge input batch files, you will need to specify the output file name on the prompt screen. A default name is generated but you may change it to suit your workflow.
Filetypes currently supported: *.WEB, *.TXT, *.ALF, *.TRS
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel


Preferences
Truss Lookahead
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Scrap Tolerance
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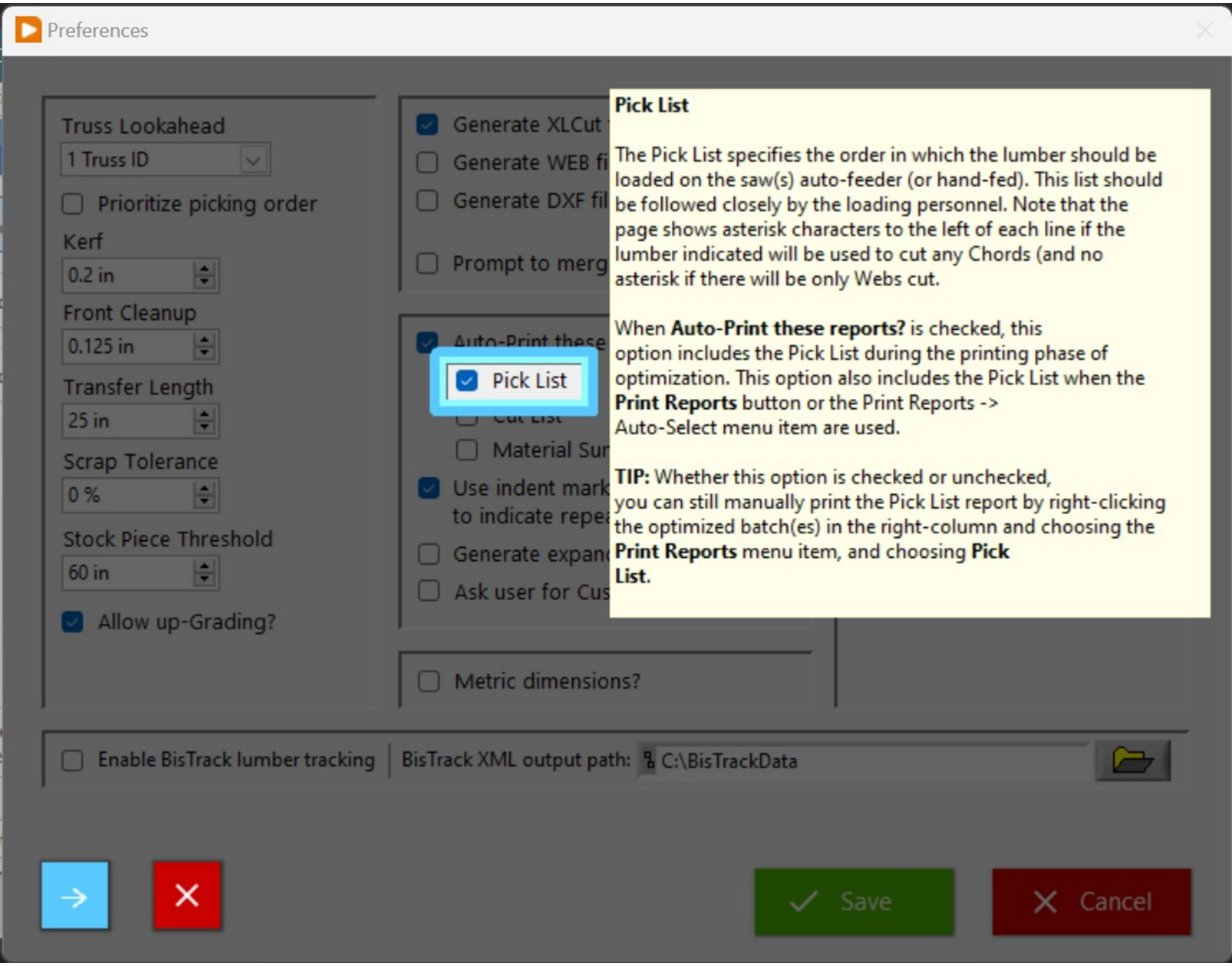
Stock Piece Threshold
60 in
Allow up-Grading?
Generate XLCut file?
Generate WEB file?
Generate DXF file?
Prompt to merge input files?
Auto-Print these reports?
Pick List
Cut List
Material Summary
Use indent marks (›) on repo
to indicate repeating lumber?
Generate expanded Pick Lists?
Ask user for Custom Report Titles?
Metric dimensions?
Auto-Print these reports?
When checked, this option automatically prints the below selected reports each time a batch is optimized. This option can be temporarily overridden with a toggle on the main XLOpt screen.
NOTE: With this option unchecked, you can still print the below selected reports by highlighting the optimized batch(es) in the right column of XLOpt, and clicking the Print button on the left side of the window, or by right-clicking the batch(es) and choosing the Print Reports menu item, and choosing Auto-Select.
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel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Stock Piece Threshold
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Allow up-Grading?
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Generate WEB fi
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Pick List
Material Sur
Use indent mark
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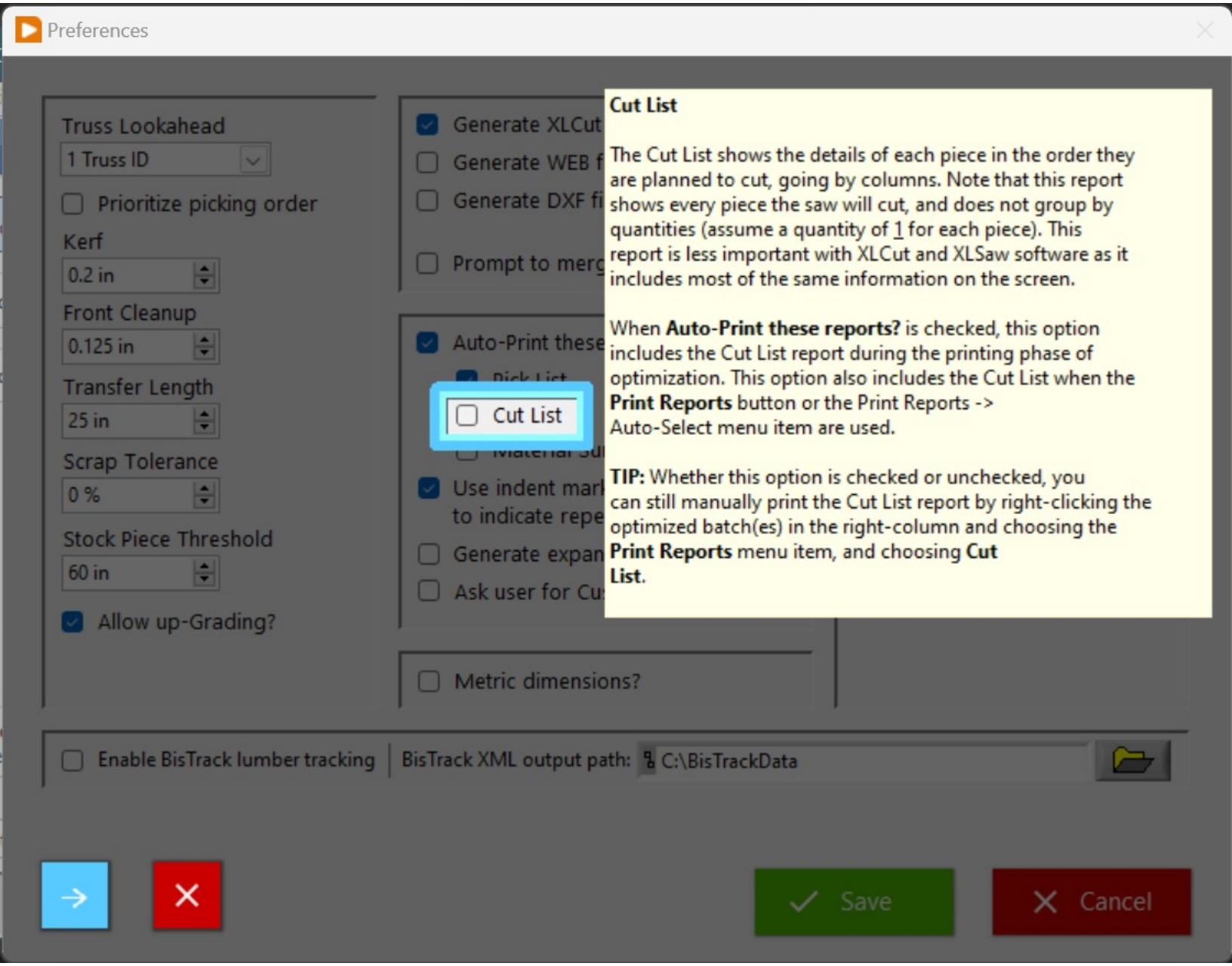
Ask user for Cus
Metric dimensions?
Pick List
The Pick List specifies the order in which the lumber should be loaded on the saw(s) auto-feeder (or hand-fed). This list should be followed closely by the loading personnel. Note that the page shows asterisk characters to the left of each line if the lumber indicated will be used to cut any Chords (and no asterisk if there will be only Webs cut.
When Auto-Print these reports? is checked, this option includes the Pick List during the printing phase of optimization. This option also includes the Pick List when the Print Reports button or the Print Reports -> Auto-Select menu item are used.
TIP: Whether this option is checked or unchecked, you can still manually print the Pick List report by right-clicking the optimized batch(es) in the right-column and choosing the Print Reports menu item, and choosing Pick List.
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel


Preferences
Truss Lookahead
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Prioritize picking order
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Generate XLCut
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Auto-Print these
Cut List
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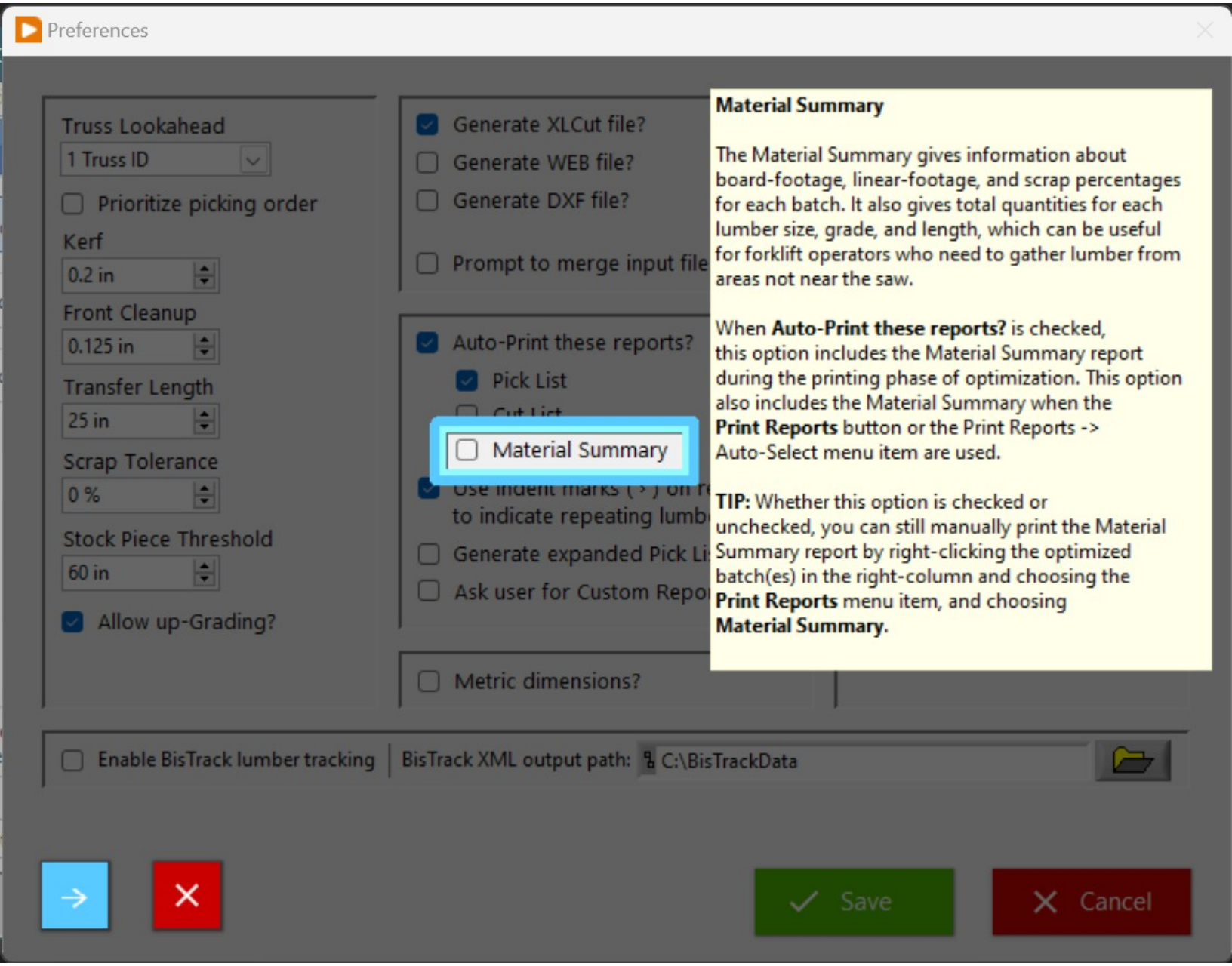
Generate expan
Ask user for Cu
Metric dimensions?
Cut List
The Cut List shows the details of each piece in the order they are planned to cut, going by columns. Note that this report shows every piece the saw will cut, and does not group by quantities (assume a quantity of 1 for each piece). This report is less important with XLCut and XLSaw software as it includes most of the same information on the screen.
When Auto-Print these reports? is checked, this option includes the Cut List report during the printing phase of optimization. This option also includes the Cut List when the Print Reports button or the Print Reports -> Auto-Select menu item are used.
TIP: Whether this option is checked or unchecked, you can still manually print the Cut List report by right-clicking the optimized batch(es) in the right-column and choosing the Print Reports menu item, and choosing Cut List.
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel


Preferences
Truss Lookahead
1 Truss ID
Prioritize picking order
Kerf
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Front Cleanup
0.125 in
Transfer Length
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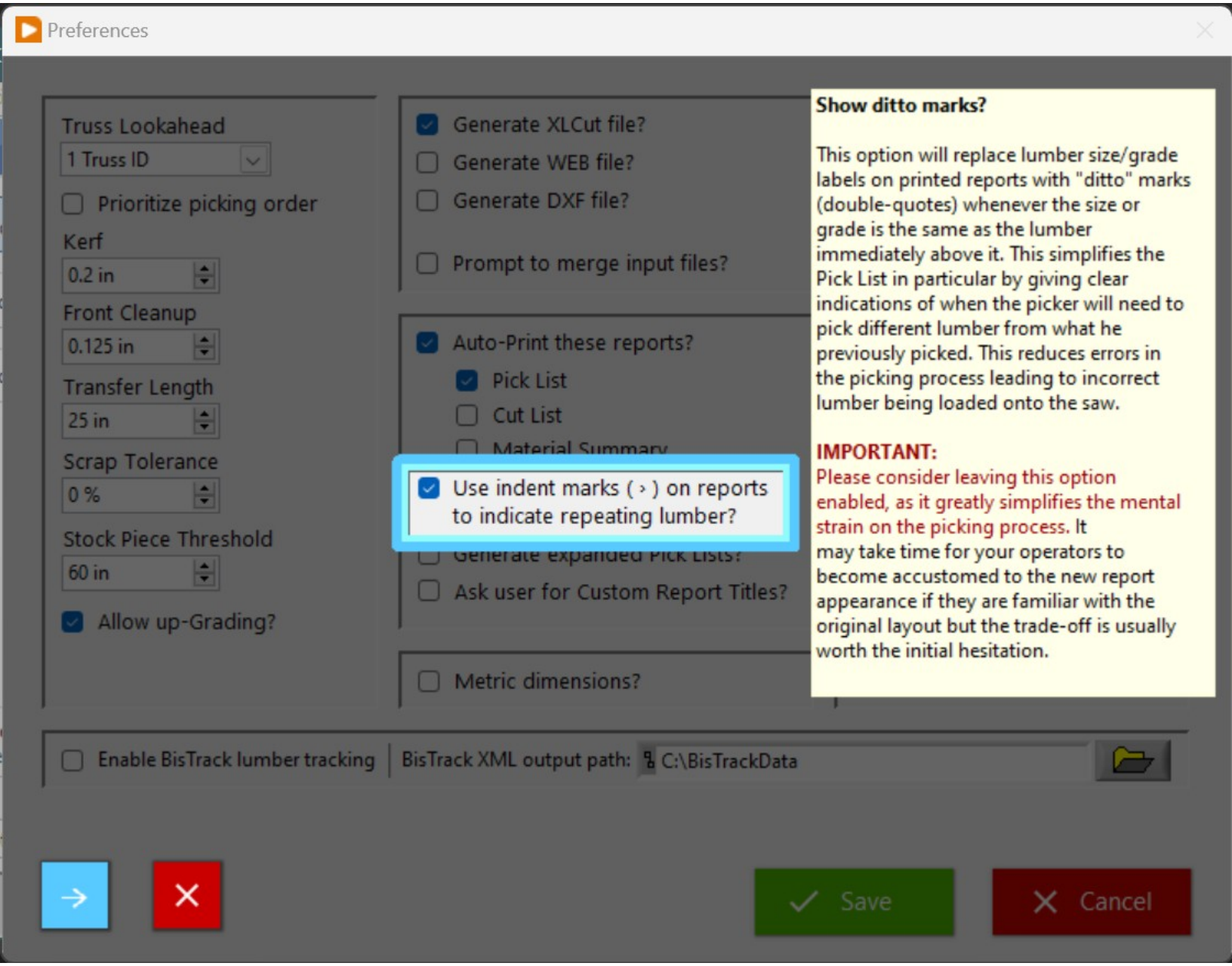
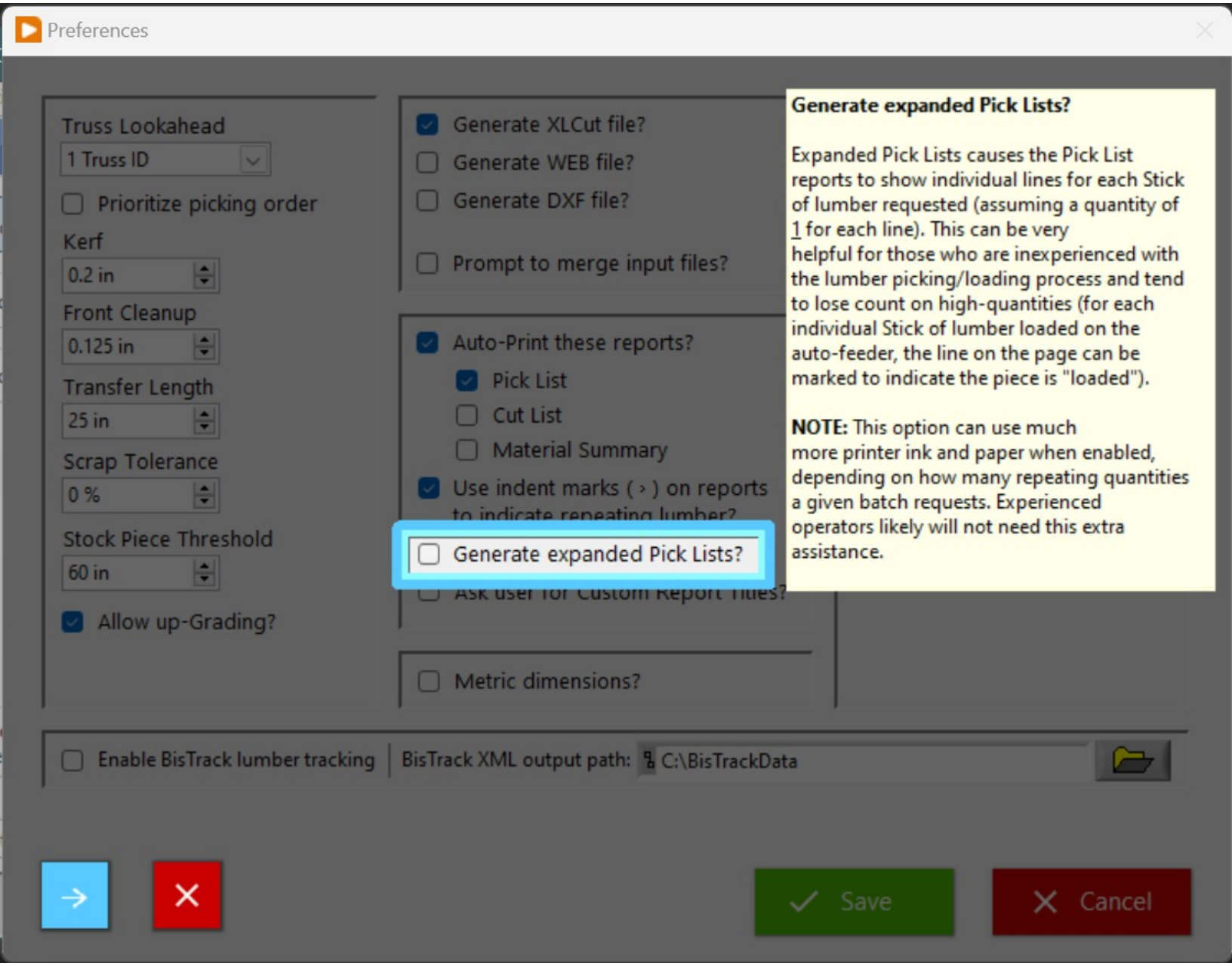
Scrap Tolerance
0 %
Stock Piece Threshold
60 in
Allow up-Grading?
Generate XLCut file?
Generate WEB file?
Generate DXF file?
Prompt to merge input file
Auto-Print these reports?
Pick List
Material Summary
Generate expanded Pick Li
Ask user for Custom Repo
Metric dimensions?
Material Summary
The Material Summary gives information about board-footage, linear-footage, and scrap percentages for each batch. It also gives total quantities for each lumber size, grade, and length, which can be useful for forklift operators who need to gather lumber from areas not near the saw.
When Auto-Print these reports? is checked, this option includes the Material Summary report during the printing phase of optimization. This option also includes the Material Summary when the Print Reports button or the Print Reports -> Auto-Select menu item are used.
TIP: Whether this option is checked or unchecked, you can still manually print the Material Summary report by right-clicking the optimized batch(es) in the right-column and choosing the Print Reports menu item, and choosing Material Summary.
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel


Preferences
Truss Lookahead
1 Truss ID
Prioritize picking order
Kerf
0.2 in
Front Cleanup
0.125 in
Transfer Length
25 in
Scrap Tolerance
0 %
Stock Piece Threshold
60 in
Allow up-Grading?
Generate XLCut file?
Generate WEB file?
Generate DXF file?
Prompt to merge input files?
Auto-Print these reports?
Pick List
Cut List
Use indent marks (») on reports to indicate repeating lumber?
Ask user for Custom Report Titles?
Metric dimensions?
Show ditto marks?
This option will replace lumber size/grade labels on printed reports with "ditto" marks (double-quotes) whenever the size or grade is the same as the lumber immediately above it. This simplifies the Pick List in particular by giving clear indications of when the picker will need to pick different lumber from what he previously picked. This reduces errors in the picking process leading to incorrect lumber being loaded onto the saw.
IMPORTANT:
Please consider leaving this option enabled, as it greatly simplifies the mental strain on the picking process. It may take time for your operators to become accustomed to the new report appearance if they are familiar with the original layout but the trade-off is usually worth the initial hesitation.
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel


Preferences
Truss Lookahead
1 Truss ID
Prioritize picking order
Kerf
0.2 in
Front Cleanup
0.125 in
Transfer Length
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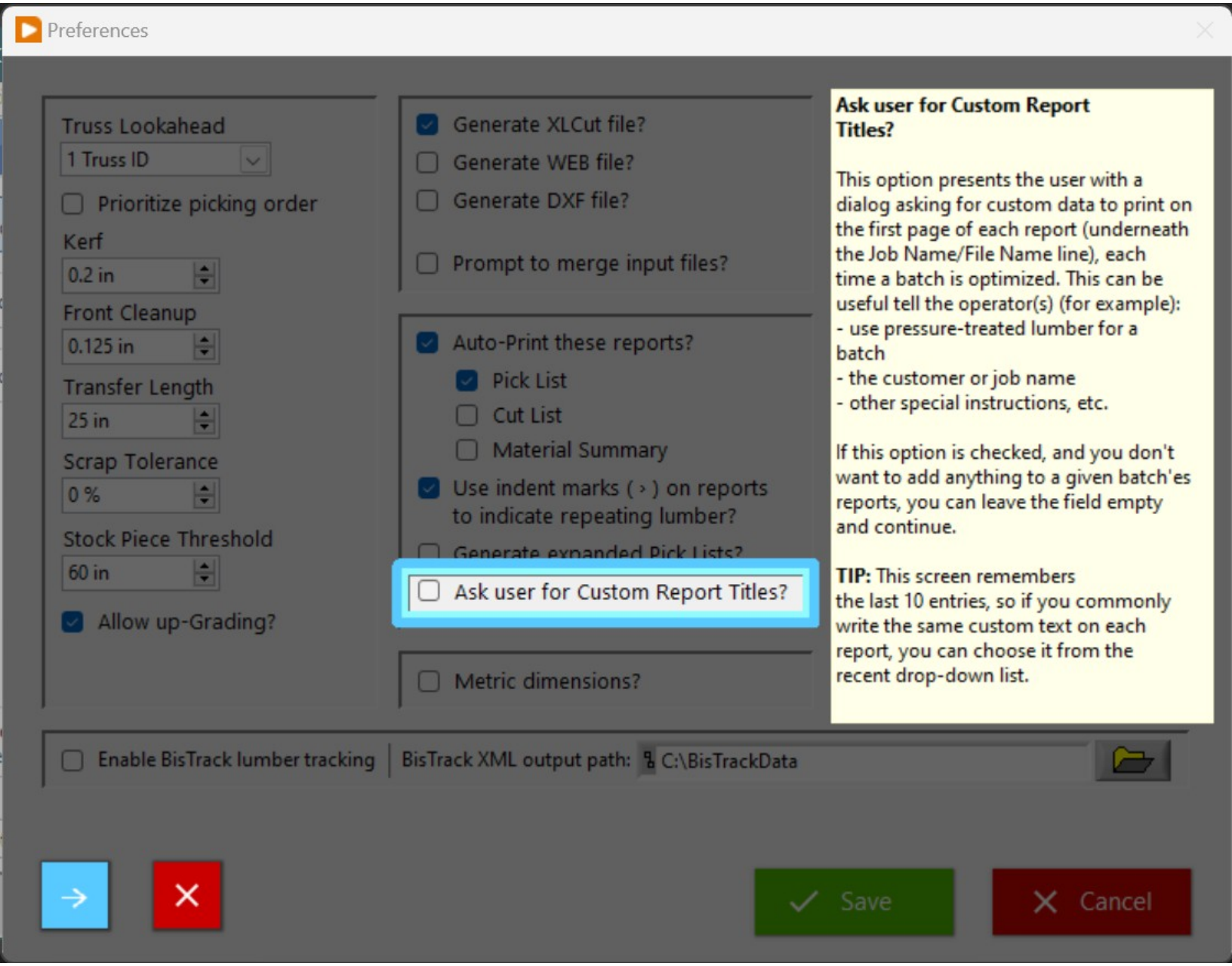
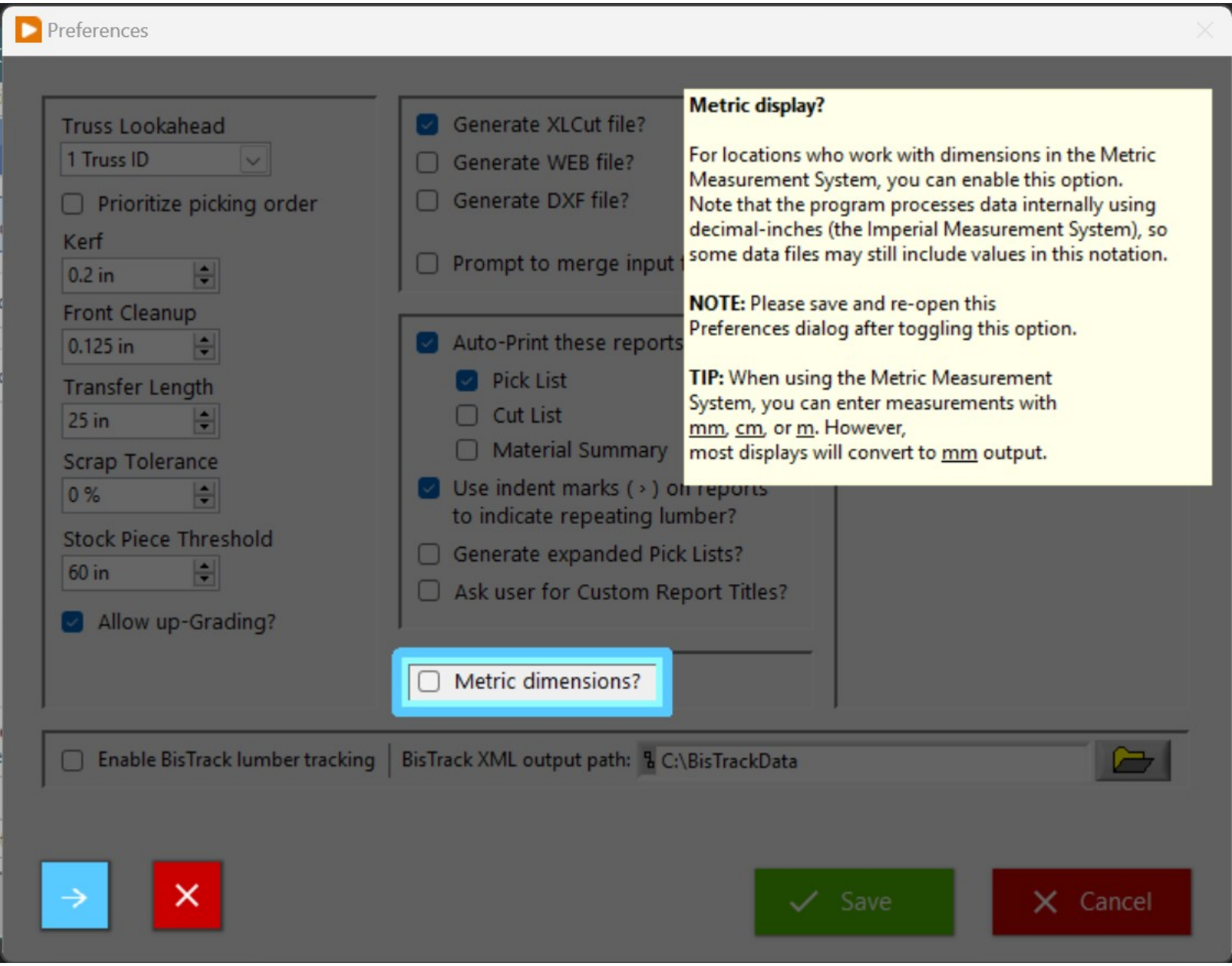
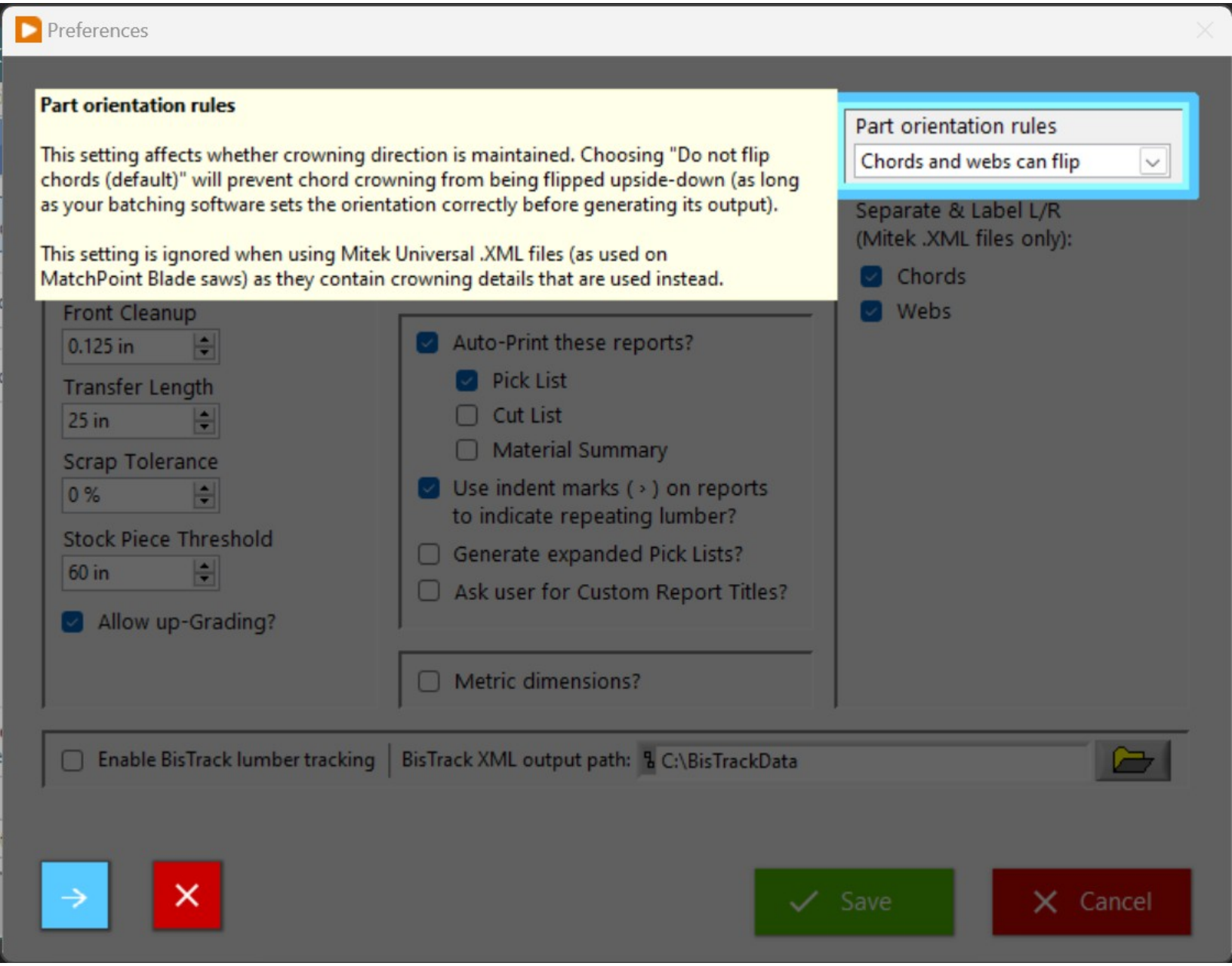
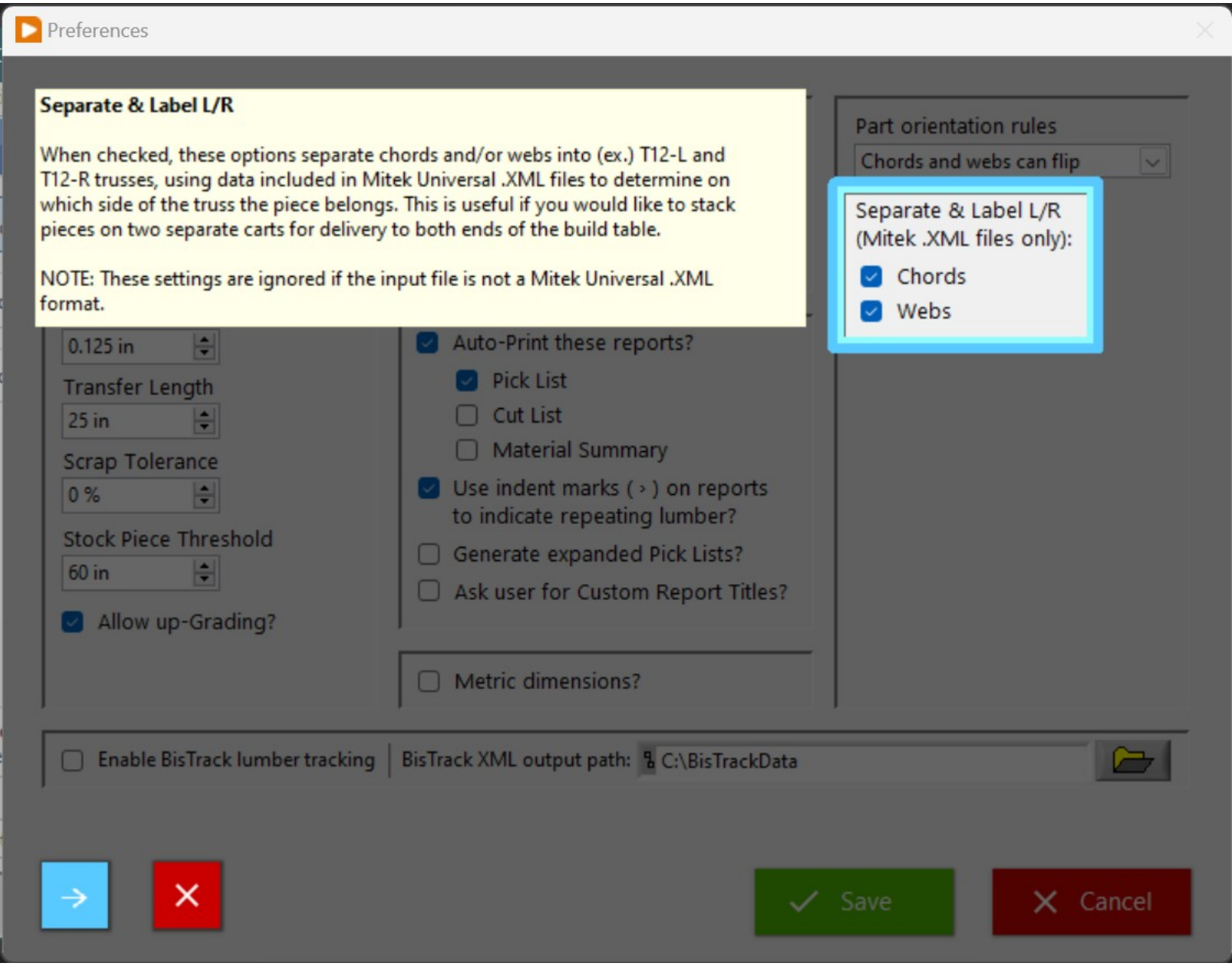
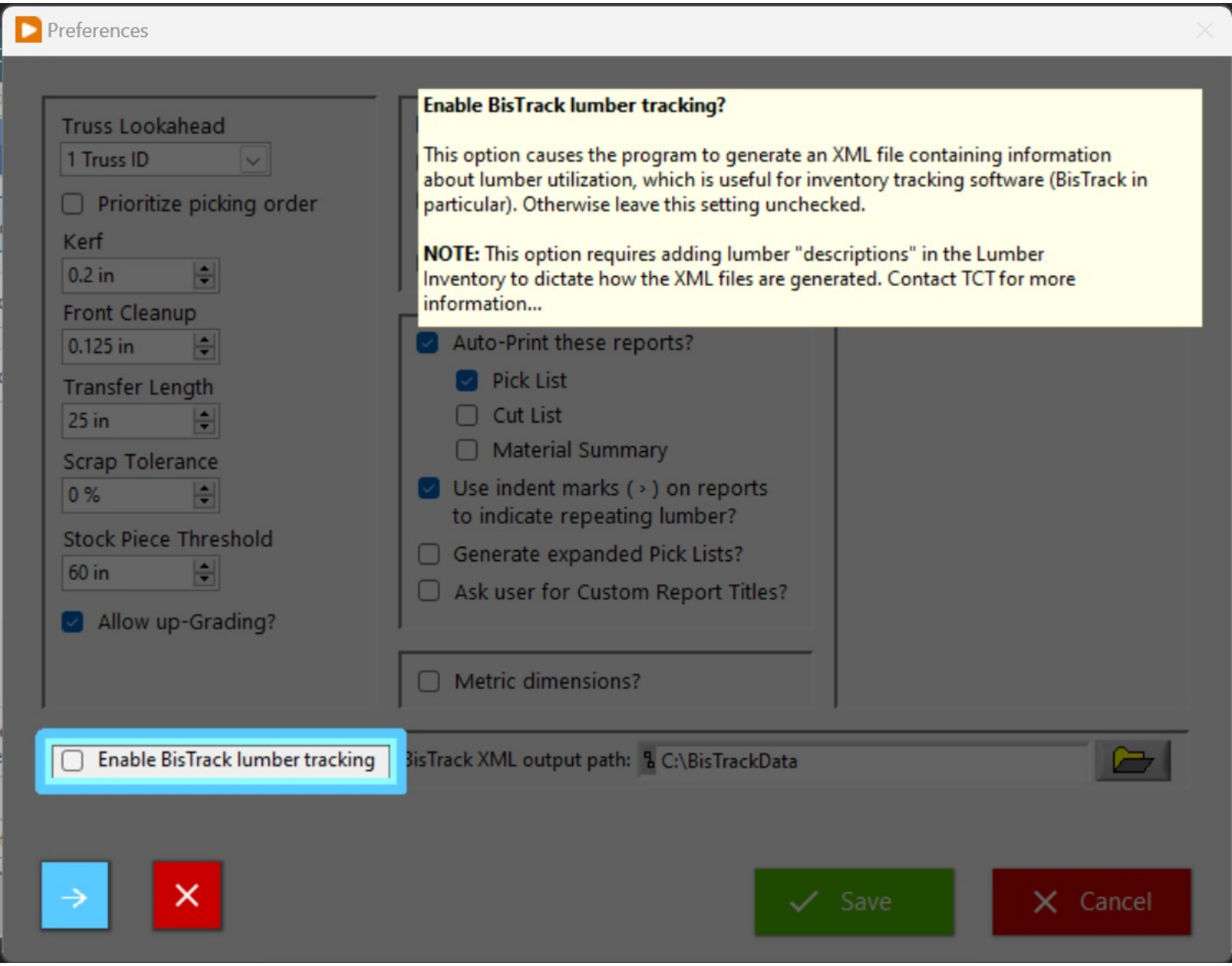
Scrap Tolerance
0 %
Stock Piece Threshold
60 in
Allow up-Grading?
Generate XLCut file?
Generate WEB file?
Generate DXF file?
Prompt to merge input files?
Auto-Print these reports?
Pick List
Cut List
Material Summary
Use indent marks (›) on reports
Generate expanded Pick Lists?
Metric dimensions?
Generate expanded Pick Lists?
Expanded Pick Lists causes the Pick List reports to show individual lines for each Stick of lumber requested (assuming a quantity of 1 for each line). This can be very helpful for those who are inexperienced with the lumber picking/loading process and tend to lose count on high-quantities (for each individual Stick of lumber loaded on the auto-feeder, the line on the page can be marked to indicate the piece is "loaded").
NOTE: This option can use much more printer ink and paper when enabled, depending on how many repeating quantities a given batch requests. Experienced operators likely will not need this extra assistance.
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel

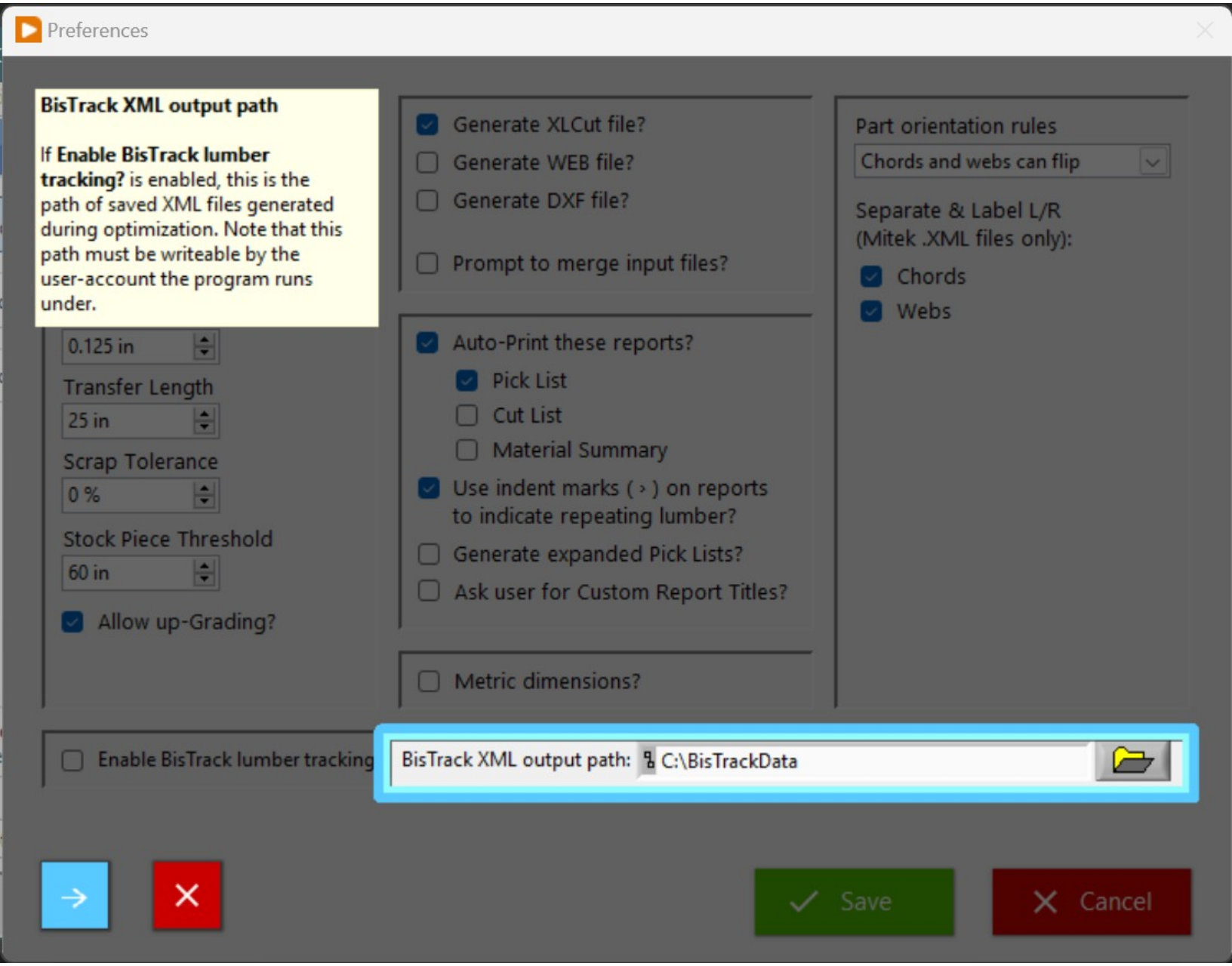

Preferences
Truss Lookahead
1 Truss ID
Prioritize picking order
Kerf
0.2 in
Front Cleanup
0.125 in
Transfer Length
25 in
Scrap Tolerance
0 %
Stock Piece Threshold
60 in
Allow up-Grading?
Generate XLCut file?
Generate WEB file?
Generate DXF file?
Prompt to merge input files?
Auto-Print these reports?
Pick List
Cut List
Material Summary
Use indent marks (›) on reports to indicate repeating lumber?
Ask user for Custom Report Titles?
Metric dimensions?
Ask user for Custom Report Titles?
This option presents the user with a dialog asking for custom data to print on the first page of each report (underneath the Job Name/File Name line), each time a batch is optimized. This can be useful tell the operator(s) (for example):
- use pressure-treated lumber for a batch
- the customer or job name
- other special instructions, etc.
If this option is checked, and you don't want to add anything to a given batch'es reports, you can leave the field empty and continue.
TIP: This screen remembers the last 10 entries, so if you commonly write the same custom text on each report, you can choose it from the recent drop-down list.
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel


Preferences
Truss Lookahead
1 Truss ID
Prioritize picking order
Kerf
0.2 in
Front Cleanup
0.125 in
Transfer Length
25 in
Scrap Tolerance
0 %
Stock Piece Threshold
60 in
Allow up-Grading?
Generate XLCut file?
Generate WEB file?
Generate DXF file?
Prompt to merge input
Auto-Print these reports
Pick List
Cut List
Material Summary
Use indent marks (›) on reports to indicate repeating lumber?
Generate expanded Pick Lists?
Ask user for Custom Report Titles?
Metric dimensions?
Metric display?
For locations who work with dimensions in the Metric Measurement System, you can enable this option. Note that the program processes data internally using decimal-inches (the Imperial Measurement System), so some data files may still include values in this notation.
NOTE: Please save and re-open this Preferences dialog after toggling this option.
TIP: When using the Metric Measurement System, you can enter measurements with mm, cm, or m. However, most displays will convert to mm output.
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel


Preferences
Part orientation rules
This setting affects whether crowning direction is maintained. Choosing "Do not flip chords (default)" will prevent chord crowning from being flipped upside-down (as long as your batching software sets the orientation correctly before generating its output).
This setting is ignored when using Mitek Universal .XML files (as used on MatchPoint Blade saws) as they contain crowning details that are used instead.
Part orientation rules
Chords and webs can flip
Separate & Label L/R (Mitek .XML files only):
Chords
Webs
Front Cleanup
0.125 in
Transfer Length
25 in
Scrap Tolerance
0 %
Stock Piece Threshold
60 in
Allow up-Grading?
Auto-Print these reports?
Pick List
Cut List
Material Summary
Use indent marks (›) on reports to indicate repeating lumber?
Generate expanded Pick Lists?
Ask user for Custom Report Titles?
Metric dimensions?
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel


Preferences
Separate & Label L/R
When checked, these options separate chords and/or webs into (ex.) T12-L and T12-R trusses, using data included in Mitek Universal .XML files to determine on which side of the truss the piece belongs. This is useful if you would like to stack pieces on two separate carts for delivery to both ends of the build table.
NOTE: These settings are ignored if the input file is not a Mitek Universal .XML format.
Part orientation rules
Chords and webs can flip
Separate & Label L/R (Mitek .XML files only):
Chords
Webs
0.125 in
Transfer Length
25 in
Scrap Tolerance
0 %
Stock Piece Threshold
60 in
Allow up-Grading?
Auto-Print these reports?
Pick List
Cut List
Material Summary
Use indent marks (›) on reports to indicate repeating lumber?
Generate expanded Pick Lists?
Ask user for Custom Report Titles?
Metric dimensions?
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel


Preferences
Truss Lookahead
1 Truss ID
Prioritize picking order
Kerf
0.2 in
Front Cleanup
0.125 in
Transfer Length
25 in
Scrap Tolerance
0 %
Stock Piece Threshold
60 in
Allow up-Grading?
Enable BisTrack lumber tracking?
This option causes the program to generate an XML file containing information about lumber utilization, which is useful for inventory tracking software (BisTrack in particular). Otherwise leave this setting unchecked.
NOTE: This option requires adding lumber "descriptions" in the Lumber Inventory to dictate how the XML files are generated. Contact TCT for more information...
Auto-Print these reports?
Pick List
Cut List
Material Summary
Use indent marks (›) on reports to indicate repeating lumber?
Generate expanded Pick Lists?
Ask user for Custom Report Titles?
Metric dimensions?
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel


Preferences
BisTrack XML output path
If Enable BisTrack lumber tracking? is enabled, this is the path of saved XML files generated during optimization. Note that this path must be writeable by the user-account the program runs under.
0.125 in
Transfer Length
25 in
Scrap Tolerance
0 %
Stock Piece Threshold
60 in
Allow up-Grading?
Generate XLCut file?
Generate WEB file?
Generate DXF file?
Prompt to merge input files?
Auto-Print these reports?
Pick List
Cut List
Material Summary
Use indent marks (›) on reports to indicate repeating lumber?
Generate expanded Pick Lists?
Ask user for Custom Report Titles?
Metric dimensions?
Part orientation rules
Chords and webs can flip
Separate & Label L/R (Mitek .XML files only):
Chords
Webs
Enable BisTrack lumber tracking
BisTrack XML output path:
C:\BisTrackData
Save
Cancel