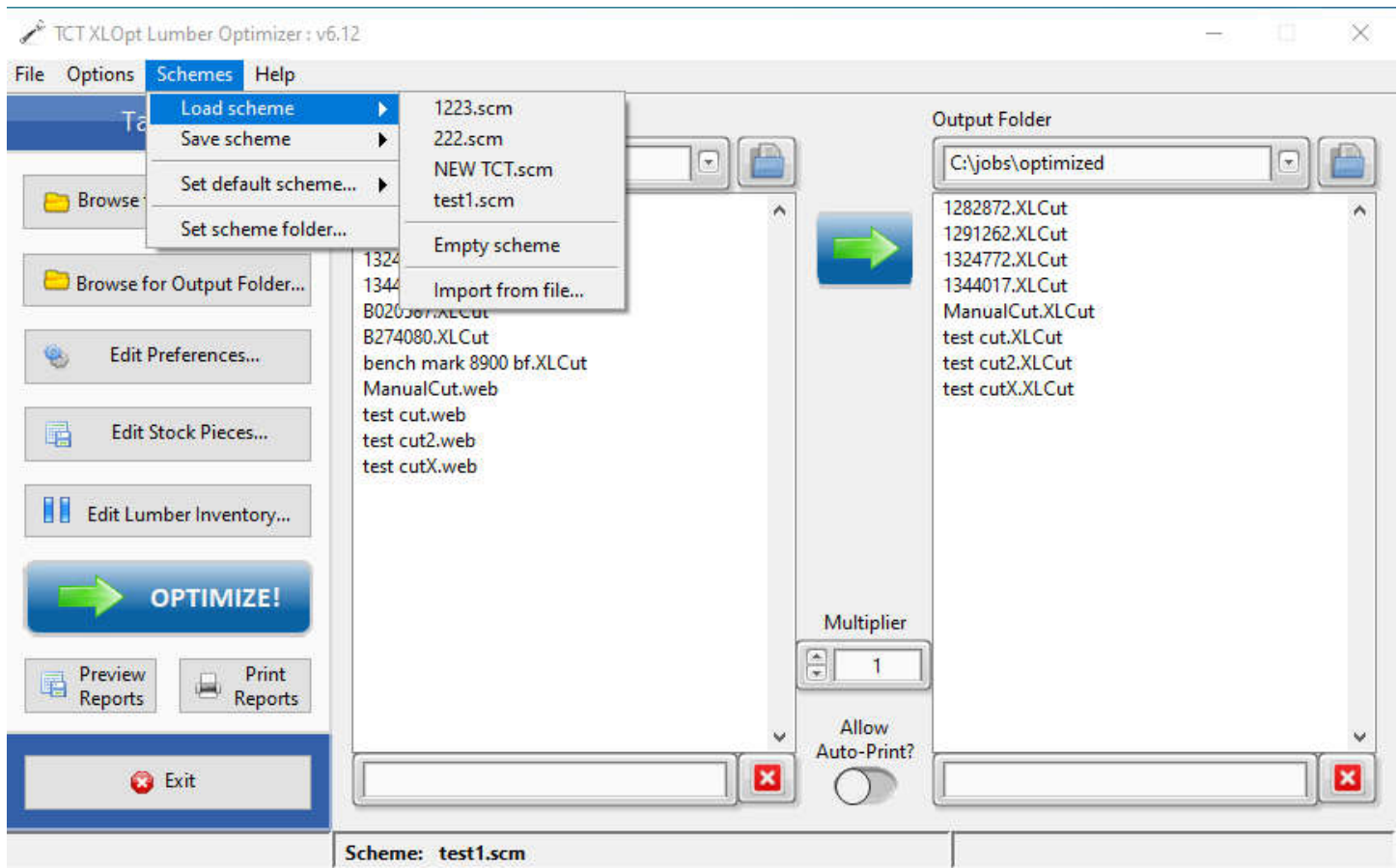


# XL-OPT OPTIMIZER GUIDE

When starting a fresh copy of XL-Opt, begin by saving an initial copy of your scheme file. Select “Schemes” from the upper menu bar. Select “Save Scheme”.

Save a copy in a safe place, you can select the “Schemes > Set Scheme Folder”. In the event you need to reload your settings, you can upload this same .SCM file using “Schemes > Load Scheme | Select which Scheme. Alternately, you can use a previous “.XLCUT” batch with the known correct settings. Use “Schemes > Load Scheme > Import from file” and select your .XLCUT file.

Please note that any time a permanent change is made to input and output folders, that you must re-save your scheme. Auto save is not available for folder selections.



## Customizing your XL-Opt

Begin by selecting the “Edit Preferences” tab on the left menu.

Preferences.vi

Truss Lookahead  
2 Truss IDs  
 Sort by Grade and Length?  
Kerf  
0.19 in  
Front Cleanup  
0.1875 in  
Transfer Length  
24 in  
Scrap Tolerance  
0 %  
Stock Piece Threshold  
60 in  
 Allow up-Grading?

Generate XLCut file?  
 Generate WEB file?  
 Generate DXF file?

Auto-Print reports?  
 Pick List  
 Cut List  
 Material Summary  
 Generate expanded Pick Lists?  
 Ask user for Custom Report Titles?

Part orientation rules  
Flipping allowed (default)

Enable BisTrack lumber tracking    BisTrack XML output path: C:\BisTrackData

Import    OK    Cancel

### Truss Lookahead

The more trusses you look ahead and allow the software to pick from truss pieces, the better your lumber will be optimized and the less scrap you will have. (Note: Having more stock lumber length varieties will also decrease scrap) The further you look ahead, the more sorting is required. Selecting “2 Truss IDs” is a default halfway point to test what works best for your plant.

**Kerf:** Set optimizer Kerf measurement to match Kerf setting on the saw. This setting must be confirmed each time the saws blade is changed. A kerf test must be ran after each blade change, and update the kerf settings as necessary.

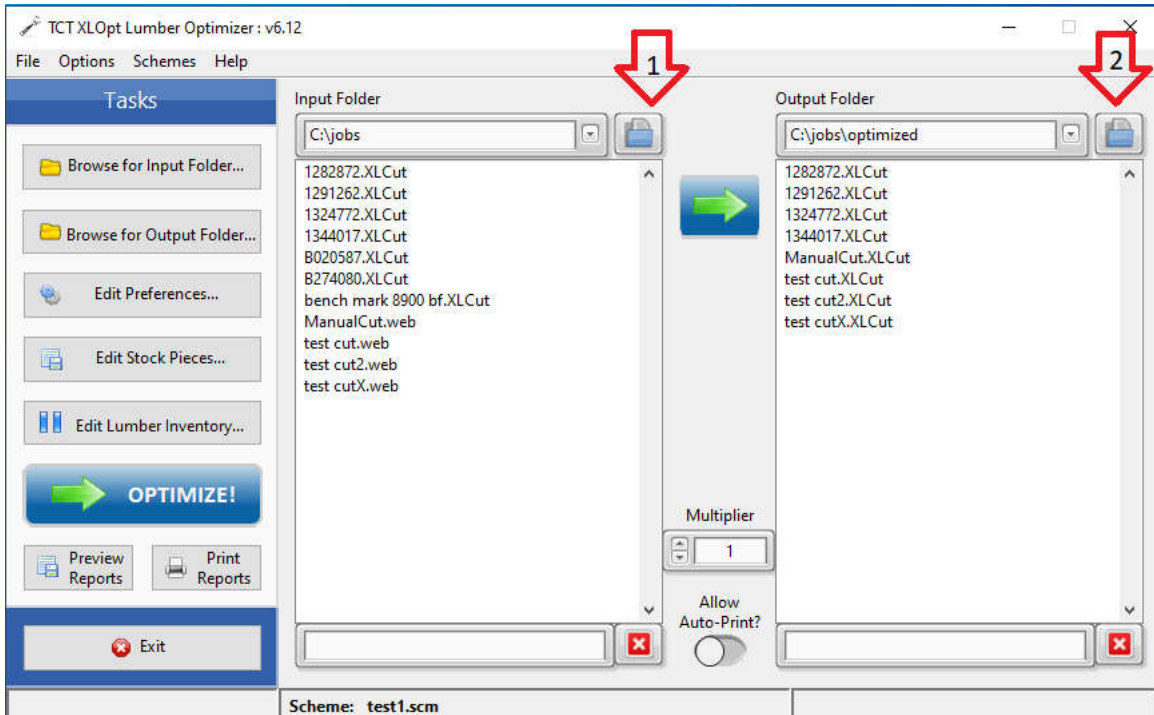
**Transfer Length:** Set to 24” for XL-Saws and 30” for Websaws

**Allow Upgrading:** Check this if you would like to allow the software to upgrade lumber types to decrease scrap. Uncheck box if you want to use less higher-grade material (will increase scrap).

**Quick Start:** Front cleanup, Scrap Tolerance, Stock Piece Threshold and all other settings leave at default.

**1) Select “Input Folder”.** Click the blue file button (or the “Browse for Input Folder” on the left menu) and navigate to the folder with your .TRS or .WEB files.

**2) Select “Output Folder”.** Click the blue file button (or the “Browse for Output Folder” on the left menu) and navigate to the folder for .XLCut files. Either access the saws hard drive directly over your network, or output your file to a thumb drive. In either scenario, files must be directly on your saws hard drive before they are ran by the saw.



Highlight your .TRS or .WEB file in the Input Folder window, and hit the OPTIMIZE! Button.

Initially, the optimizer will ask for lumber types. When prompted, select “Add to Lumber Inventory”. Confirm you add all available lumber types before continuing to maximize use of all lumber available. Once all the lumber types have been added, select “Edit Lumber Inventory” in the left hand menu. Sort grades for each width from strongest at the top to weakest at the bottom using the blue arrows then click OK.

