

Pipe-tunes 2.0 – User guide

26 October 2026 · version 2.0.0

Introduction

Pipe-tunes 2.0 works out how to cut the required parts from bars (profiles, tubes) so that as few new bars as possible are used and as little waste as possible is produced. The result is shown in a table and graphically as a cutting plan, and it can be printed or exported to Excel for production.

Compared with version 1.3.4, the main additions are:

- **offcut stock** – offcuts from previous jobs are used before a new bar is started,
- **shared stock** – stocks can be kept in a shared folder on a server and used by all computers in the company,
- **licence without a USB dongle** – activation with a licence key over the internet or without internet, 30-day free trial,
- **MAX optimization** – tries several approaches and picks the best result,
- **graphical cutting plan** on screen, in print and in Excel,
- **bar start trim** and correct calculation of the waste after the last cut,
- **pasting lengths from the clipboard**, recently opened jobs and opening a job by double-click,
- protection against invalid values and loss of unsaved changes,
- 7 languages: Slovak, Czech, English, German, Dutch, Hungarian, Polish.

Jobs (.opt files) from version 1.3.4 can also be opened in the new version.

1. Installation

Download the installer **PipeTunes-2.0.0-setup.exe** from pipe-tunes.com/en/downloads/.

1. Run the downloaded file and allow it to make changes to your computer (the installation needs administrator rights).
2. Your browser or Windows may warn that the file is not commonly downloaded – the program is not yet signed with a certificate. In the browser choose **Keep**, in the Windows SmartScreen window **More info → Run anyway**.
3. Choose the setup language and the folder (default C:\Program Files\Pipe-tunes 2). If you like, tick the desktop icon. The program is also added to the Start menu.
4. When the installation has finished, start the program.

Version 1.3.4 with the USB dongle stays installed and keeps working. Both versions can be on the computer at the same time.

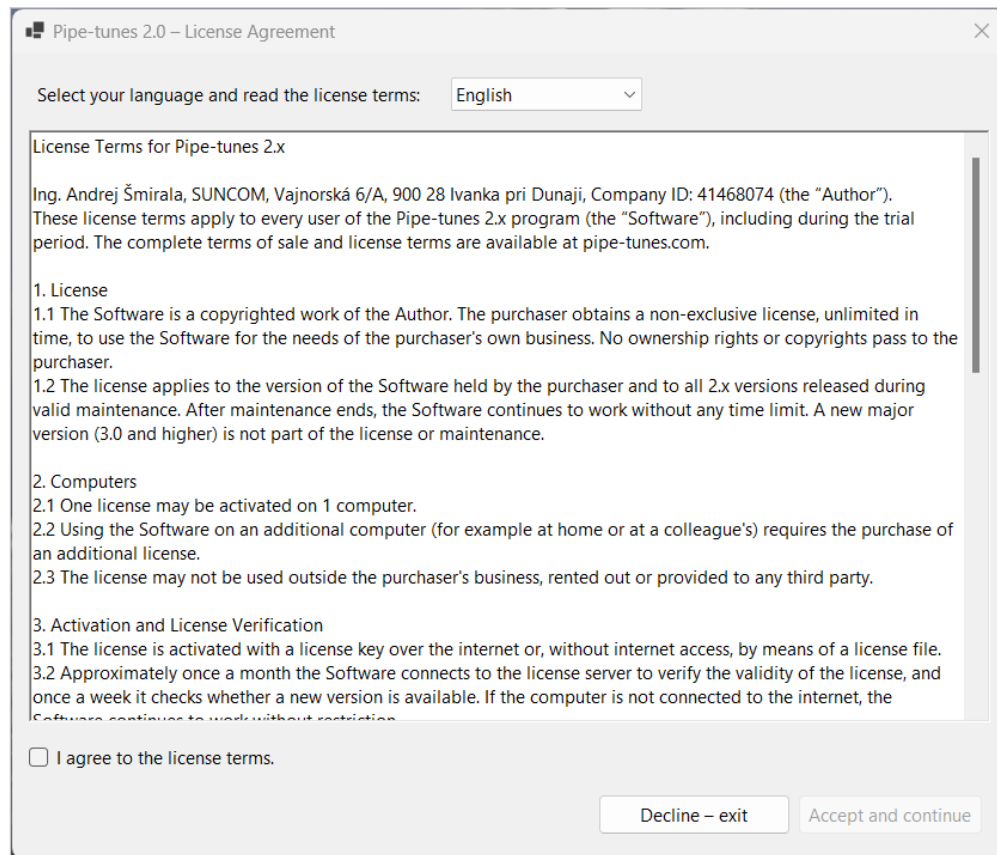
A new version is installed the same way over the existing installation. The licence, stocks and settings are kept.

Uninstalling: Windows Settings → Apps → Pipe-tunes → Uninstall. The licence, stocks and settings are not deleted, so after reinstalling, the program carries on where it left off.

The program runs on 64-bit Windows 10 (version 1607 or later) and Windows 11.

2. First start

On the first start the licence agreement is shown. Choose your language at the top of the window, read the agreement, tick your consent and confirm. Without confirmation the program does not start; on later starts the agreement is no longer shown.



License agreement window on the first start – choose the language at the top.

The program language can be changed at any time in the menu **Settings → Language** (chapter 12).

After you confirm the agreement, the program starts as a **30-day trial version** with full functionality. The remaining days are shown at the top right of the menu bar. You can enter a licence key at any time, during the trial period or after it (chapter 13).

3. Main window

The main window has a menu and a toolbar at the top, three panels for input and evaluation below them, and the result table and status bar at the bottom.

pipe-tunes : 2026-118.opt

File Settings Optimization Help

New Open Save | Excel Print | Optimization BestFit optimization MAX optimization Show | **STOCK Accept** Parameters STOCK: aluminium - RAL 9016

Evaluation

Total number of new bars	81
Total waste (mm)	8736
Waste pieces (pcs)	76
Total utilization (%)	97,80
Calculated options	2 655 644
Theoretical minimum (pcs)	80

Job

Job: 2026-118

Name: Aluminium profile 40x40

Color: RAL 9016

Add part: Length (mm) pcs

Required dimensions

length (mm)	pcs
606	32
1106	90
1506	90
1506	2
1806	2
1436	12

Stock length: 6000 mm
Cut width: 6 mm

Optimization result

number of bars	bar (mm)	source	waste (mm)	number of pieces	dimension 1	dimension 2	dimension 3	dimension 4	dimension 5	dimension 6
2	3250	STOCK	-2	2	1806	1436				
3	2470	STOCK	10	5	606	456	456	456	456	
4	1960	STOCK	0	3	756	596	596			
5	1540	STOCK	4	3	606	456	456			
6	1180	STOCK	68	1	1106					
4	820	STOCK	58	1	756					
8	640	STOCK	28	1	606					
2	6000	NEW	0	13	456	456	456	456	456	456
10	6000	NEW	-2	7	1436	1306	1106	606	596	456
13	6000	NEW	-2	7	1506	1106	1106	596	596	596
5	6000	NEW	-2	7	1306	1306	1106	596	596	596
1	6000	NEW	-4	6	1506	1506	1306	596	596	456
6	6000	NEW	1	7	1506	1306	1031	606	596	456

Done - algorithm used: MAX optimization 00:02 100 %

Main window after MAX optimization with stock – blue rows are offcuts from stock.

Menu

Menu	Items
File	New, Open, Save, Save as, Recent orders, Export to Excel, Print, Exit
Settings	Parameters, Stock, Language, Open .opt files by double-click
Optimization	Optimization, BestFit optimization, MAX optimization, Show cutting plan, Accept
Help	License..., Check for updates, About

Toolbar (from left to right)

Group	Buttons
File	New, Open, Save
Output	Excel, Print
Calculation	Optimization, BestFit optimization, MAX optimization, Show
Stock	STOCK, Accept

Group	Buttons
Settings	Parameters

On the right of the toolbar is the stock status: "OPTIMIZATION WITHOUT STOCK" or "STOCK: stock name".

On the right of the menu bar is the **licence status**: "Licensed to: ...", the number of trial days left, or "DEMO mode – activate license". Click it to open the License window.

Panels

- **Evaluation** – summary of the last calculation (chapter 7).
- **Job** – job details and adding parts (chapter 5).
- **Required dimensions** – table of all parts of the job with the buttons Delete, Up, Down and Paste; below them the current stock length and cut width.
- **Optimization result** – table of cutting patterns (chapter 7).

The **status bar** shows what is happening (Ready, Modified, Saved...), the time and progress of the calculation, and the **Cancel** button, which stops a running optimization.

4. Parameters

First set the parameters: the **Parameters** button on the toolbar or the menu **Settings → Parameters**. The values are saved and also apply the next time you start the program.

Parameters

Dimension settings

Max. waste to discard (mm)

200

Shorter waste is proposed for disposal, longer goes to stock.

Cut width

6

Stock length

6000

Bar start trim (mm)

0

Optimization method

☐ Start with smallest waste

☒ Start with largest dimensions

☒ Sort output by least waste

☐ Material is billed per metre (show started metres)

OK

Cancel

Parameters window.

Parameter	Default	Meaning
Max. waste to discard (mm)	200	Waste up to this length is proposed for discarding, longer pieces go to stock.
Cut width (mm)	6	Kerf of your saw, 0 to 100 mm.
Stock length (mm)	6000	Length of the new bars that are cut.
Bar start trim (mm)	0	How many mm are cut off at the start of a new bar to square it; 0 = no trim.

Bar start trim. With a value greater than 0, the given trim piece plus one cut is lost at the start of every new bar. Example: bar 6000 mm, trim 5 mm, cut 6 mm → 5989 mm remain for parts. Offcuts from stock are not trimmed because they already have a straight end from the cut. In the outputs the bar stays 6000 mm and the trim is stated in bold at the end.

Optimization method applies to the **Optimization** calculation (chapter 6):

- **Start with largest dimensions** – usually the better option, the longest parts are placed first.
- **Start with smallest waste** – sometimes better because of the remaining offcuts.

Sort output by least waste – the cutting patterns in the result are sorted from the least waste.

Material is billed per metre (show started metres) – useful for material sold by the metre. The material used is then also shown in started metres: every started metre is counted for each bar, e.g. “522.19 m (540 m)”. The material used appears on a tile in the Cutting plan window, in print and in Excel.

Checks. Only digits can be typed into the fields. If you enter a stock length greater than 20,000 mm, the program asks whether it is correct (e.g. 60000 instead of 6000); the default answer is No. The values are saved only after all fields have been checked.

5. Entering a job

In the **Job** panel fill in the fields **Job**, **Name** and **Color**. They appear in print and in Excel.

Adding a part. Enter the length of the part in the **Length (mm)** field, the number of pieces in **pcs** and click **Add**. The part appears on the right in the **Required dimensions** table. Enter all parts of the job this way.

Fast entry with the Enter key. Type the length and press Enter – the cursor moves to the pcs field. Type the number of pieces and press Enter – the part is added and the cursor returns to the Length field for the next part. If the number of pieces is already filled in, Enter in the Length field adds the part straight away.

Editing the table.

- You can overwrite a length or number of pieces directly in the table.
- **Delete** (or the Delete key) removes the selected row.
- **Up** and **Down** change the order of the rows.

Pasting from the clipboard. Lengths copied from Excel, an e-mail or a text file are pasted with the **Paste** button, with **Ctrl+V** in the table, or with the right mouse button → **Paste from clipboard**. Each line should contain a length and a number of pieces, for example:

Text in the clipboard	Result
1506 [Tab] 92 (two columns from Excel)	1506 mm, 92 pcs
1106;90 or 2406 x 12	1106 mm, 90 pcs / 2406 mm, 12 pcs
756 (single number)	756 mm, 1 pc
1 [Tab] 456 [Tab] 100 (no., length, pcs)	456 mm, 100 pcs

Lines without numbers (headers) are skipped. Invalid lines – a decimal number, a length longer than the bar, 0 pieces – are left out and listed with the reason.

Checks. Only digits can be typed into the length and pcs fields. A length must be shorter than the usable bar length (after trimming), the number of pieces 1 to 99,999 per line and at most 200,000 pieces per job.

6. Optimization

Start the calculation with one of the three buttons on the toolbar or from the **Optimization** menu. For everyday work we recommend **MAX optimization**.

Method	How it works	When to use
MAX optimization	Tries several ways of filling the stock and new bars and picks the result with the fewest new bars; if equal, the one with more use of stock and less waste. For smaller jobs it also uses an exact search.	Always, best result; usually takes 1–3 seconds.
Optimization	Fills bars with whole combinations of parts according to the selected optimization method (chapter 4).	Quick comparison.
BestFit optimization	Places parts from the longest into the bar where the least space remains.	Very large jobs, fastest.

If a stock is selected, all three methods first use the offcuts from stock and only then new bars (chapter 8).

Progress. During the calculation the status bar shows the elapsed time and progress. Press **Cancel** to stop the calculation; a partial result is not shown.

Calculation rules. The parts together with the cuts between them always fit into the bar. A length equal to or longer than the bar is left out and the program warns you about it.

7. Result and evaluation

The result is shown in the **Optimization result** table. Each row is one cutting pattern: how many bars are cut the same way and which parts they produce. The table is for viewing only and cannot be edited.

Column	Meaning
number of bars	How many bars are cut according to this pattern.
bar (mm)	Bar length: a new bar or an offcut from stock.
source	NEW = new bar, STOCK = offcut from stock (the row is blue).
waste (mm)	The remainder of the bar after the last cut.
number of pieces	Number of parts from one bar.
dimension 1, 2, ...	Lengths of the parts in the order in which they are cut.

How the waste is calculated. The waste is the actual piece left after the last cut, i.e. already without the width of the last cut.

- Waste 0 – the bar comes out exactly, or the remainder is used up by the last cut.

- **Negative waste**, e.g. -4 – less than the cut width remains at the end; 4 mm must be ground off the last part. It is not included in the total waste.

Evaluation in the main window:

Item	Meaning
Total bars (pcs)	Number of new bars for the job. When a stock is used it is called "Total number of new bars"; offcuts from stock are not counted.
Total waste (mm)	Sum of all waste pieces.
Waste pieces (pcs)	Number of bars that leave a piece of waste.
Total utilization (%)	What percentage of the material is made up of the required parts.
Calculated options	Number of combinations checked.
Theoretical minimum (pcs)	Fewer new bars are physically impossible: the sum of parts and cuts divided by the usable bar length.

If the result equals the theoretical minimum or is 1 bar above it, it is a very good result. The minimum is often not reached because the parts do not fit into the bars without a remainder.

8. Offcut stock

The stock keeps track of offcuts from previous jobs so that they are used before new bars. You can have several stocks, for example by material and colour.

The **Stock window** is opened with the **STOCK** button on the toolbar or via **Settings → Stock**.

H:\Pipe-tunes 2 sklady\aluminium_RAL 9016.stock

Stocks

- aluminium – anodised
- aluminium – RAL 9016**
- stainless – brushed
- steel – galvanised

New stock

Edit stock

Stock folder... H:\Pipe-tunes 2 sklady

Stock items

Material type **aluminium** Color **RAL 9016** Note **profile 40x40**

Length (mm)	Quantity	Note
3250	2	Order 2026-104
2470	3	Order 2026-104
1960	4	Order 2026-097
1540	5	Order 2026-097
1180	6	Order 2026-091
820	4	Order 2026-091
640	8	Order 2026-088

Add offcut Edit Delete

Use this stock Close stock

Stock window – stocks on the left, offcuts of the selected stock on the right, stock folder at the bottom.

- On the left is the list of stocks: **New stock**, **Edit stock**, **Delete stock**. A stock has a material type, colour and note.
- On the right are the offcuts of the selected stock (length, quantity, note): **Add offcut**, **Edit**, **Delete**.
- Use this stock** switches the stock on for optimization; “STOCK: name” appears on the right of the toolbar. **Close stock** closes the window and the optimization runs without stock.

Working with the stock

- Click **STOCK**, select a stock and choose **Use this stock**.
- Run the optimization. The program first fills the offcuts from stock and only then distributes the remaining parts to new bars. Rows from stock are blue in the table.
- When you use the result in production, click **Accept**. The button is active only after an optimization with stock.
- In the **Accept optimization** window you see what will be taken from stock and the list of new offcuts – each piece separately. Tick the offcuts that should go to stock; you can edit the length and the note.
- After confirmation the used offcuts are removed from stock and the ticked new ones are added. **Cancel** changes nothing.

Accept optimization

Remove from stock: aluminium – RAL 9016
 2× 3250 mm, 3× 2470 mm, 4× 1960 mm, 5× 1540 mm, 6× 1180 mm, 4× 820 mm, 8× 640 mm

New offcuts – tick those to be stored

To stock	Offcut length	From bar	Cut parts	Note
☒	1176	6000 mm – NEW	2406 + 2406	Job: 2026-118
☒	1176	6000 mm – NEW	2406 + 2406	Job: 2026-118
☒	964	6000 mm – NEW	2406 + 1306 + 1306	Job: 2026-118
☒	352	6000 mm – NEW	1506 + 1506 + 1306 + 1306	Job: 2026-118
☐	152	6000 mm – NEW	1506 + 1506 + 1506 + 1306	Job: 2026-118
☐	152	6000 mm – NEW	1506 + 1506 + 1506 + 1306	Job: 2026-118
☐	152	6000 mm – NEW	1506 + 1506 + 1506 + 1306	Job: 2026-118
☐	152	6000 mm – NEW	1506 + 1506 + 1506 + 1306	Job: 2026-118
☐	152	6000 mm – NEW	1506 + 1506 + 1506 + 1306	Job: 2026-118
☐	152	6000 mm – NEW	1506 + 1506 + 1506 + 1306	Job: 2026-118
☐	152	6000 mm – NEW	1506 + 1506 + 1506 + 1306	Job: 2026-118
☐	152	6000 mm – NEW	1506 + 1506 + 1506 + 1306	Job: 2026-118

Select all Clear selection To be stored: 4 / 76 pcs

Accept Cancel

Accept optimization window – offcuts taken from stock at the top, new offcuts below.

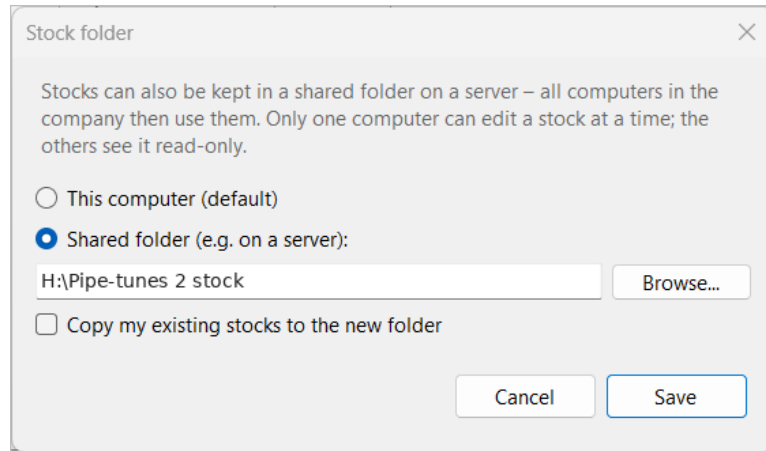
Default ticks. Offcuts longer than **Max. waste to discard** (default 200 mm) are proposed for stock, shorter ones for discarding. The note is pre-filled with the job number. An offcut with the same length and note as one already in stock only increases the quantity.

Stock protection. When accepting, the stock is read again. If the used offcuts are missing from it in the meantime, the program warns you and writes nothing; run the optimization again. The same result cannot be accepted twice.

Shared stock for several computers

By default the stocks are stored on this computer. If you want all computers in the company to work with the stock, store it in a shared folder on a server or network drive:

1. In the Stock window click **Stock folder...** at the bottom left.
2. Choose **Shared folder (e.g. on a server)** and select the folder with the **Browse...** button. The option **This computer (default)** moves the stocks back to the computer.
3. If you want to move your existing stocks, leave **Copy my existing stocks to the new folder** ticked and confirm.
4. Set the same folder on the other computers.



Stock folder window.

Only **one computer can edit** a stock at a time. The others see who is editing it and since when, and can open it **read-only** and use it for optimization. As soon as the first computer closes it, the window on the others switches to editing by itself.

If the shared folder is not available (network failure, server switched off), the toolbar shows “STOCK UNAVAILABLE – optimization without stock”. The stocks appear again when the folder is available. If another computer has taken over the stock in the meantime, for example after a long period of inactivity, the change is not saved and the program tells you so.

9. Cutting plan

After the optimization click **Show** (or **Optimization → Show cutting plan**). A window opens in which every bar is drawn to scale with parts, cuts and waste.



Cutting plan window – every bar to scale; ticked rows are done.

- **Tiles at the top:** new bars, offcuts from stock, waste, utilization, number of cutting patterns and theoretical minimum.
- **Colour legend:** every length has its own colour, so you recognise identical parts on all bars.
- **Pattern row:** number, number of bars, bar length, NEW or STOCK label and the bar to scale. A black line is a cut, a hatched section is waste, a dark section at the start is the trim.
- **On the right** is the waste in mm; with negative waste a red warning “grind X mm”.
- **Hovering the mouse** over a part shows its length and position in the bar.
- **Clicking the square** on the right marks the row as done (only while the window is open).

Print prints the same coloured graphics in landscape, with the job header, summary and legend, over several pages for many patterns. The squares are empty so they can be ticked with a pen in production. On a black-and-white printer the colours are printed in shades of grey. Close the window with **Close** or the Esc key.

10. Printing and export to Excel

Print the result with the **Print** button and export it with the **Excel** button (or via the **File** menu). Both outputs are intended for production and have the same content.

Print. First the printer is chosen, then the paper and margins, and finally the print preview is shown.

Excel has two sheets:

- **Optimization result** – tables and summary (see below).
- **Cutting plan** – every bar drawn to scale from cells, with the waste and a “done” column for ticking off; set up for landscape printing.

pipe-tunes 2.0																			
2026-118																			
Aluminium profile 40x40																			
RAL 9016																			
no. number	count bars	bar (mm)	source	waste	count pcs	dimension 1	dimension 2	dimension 3	dimension 4	dimension 5	dimension 6	dimension 7	dimension 8	dimension 9	dimension 10	dimension 11	dimension 12	dimension 13	
1	2	3250	STOCK	-2	2	1806	1436												
2	3	2470	STOCK	10	5	606	456	456	456	456									
3	4	1960	STOCK	0	3	756	596	596											
4	5	1540	STOCK	4	3	606	456	456											
5	6	1180	STOCK	68	1	1106													
6	4	820	STOCK	58	1	756													
7	8	640	STOCK	28	1	606													
8	2	6000	NEW	0	13	456	456	456	456	456	456	456	456	456	456	456	456	456	456
9	10	6000	NEW	-2	7	1436	1306	1106	606	596	456	456							
10	13	6000	NEW	-2	7	1506	1106	1106	596	596	596	456							
11	5	6000	NEW	-2	7	1306	1306	1106	596	596	596	456							
12	1	6000	NEW	-4	6	1506	1506	1306	596	596	456								
13	6	6000	NEW	1	7	1506	1306	1031	606	596	456	456							
14	1	6000	NEW	2	4	2406	1506	1031	1031										
15	1	6000	NEW	40	5	1506	1106	1106	1106	1106									
16	12	6000	NEW	40	5	1306	1306	1106	1106	1106									
17	3	6000	NEW	64	3	2406	2406	1106											
18	1	6000	NEW	90	5	1506	1306	1306	1306	456									
19	22	6000	NEW	152	4	1506	1506	1506	1306										
20	1	6000	NEW	352	4	1506	1506	1306	1306										
21	1	6000	NEW	964	3	2406	1306	1306											
22	2	6000	NEW	1176	2	2406	2406												
Summary																			
Total number of new bars				81 pcs															
Total waste				8 736 mm															
Total waste pieces				76 pcs															
Total utilization				97,800 %															
Calculated options				2 655 644 x															

Export to Excel – Optimization result sheet.

Content of the output (from top to bottom)

Part	What it contains
Header	Job, name, colour, parameters.
Result	Table of cutting patterns: no., number of bars, bar (mm), source, waste, number of pieces, lengths.
Summary	Total number of (new) bars, waste, waste pieces, utilization, calculated options, stock length, cut width.
Required dimensions	Lengths of the job and numbers of pieces.
Take from stock	Only when a stock is used: which offcuts and how many the foreman should take from stock.
Offcuts to stock	After acceptance the approved offcuts, otherwise a proposal (longer than max. waste to discard).
Waste to discard	The other waste pieces.
Final lines	Total waste, explanation of negative waste, theoretical minimum and, in bold, the bar start trim (if switched on).

When printing from the main window, the cutting plan follows on a separate page.

11. Job files

A job (details and required dimensions) is saved to a file with the extension **.opt**. The optimization result is not saved; calculate it again after opening the job.

Function	How
New job	New on the toolbar or in the File menu.
Open	Open ; jobs from version 1.3.4 can also be opened.
Save	Save , for a new job you are asked for a file name; Save as saves under a new name.
Recently opened	File → Recent orders : the last 8 jobs, newest at the top; Clear list empties it. A missing file is reported and removed from the list.
Opening by double-click	Choose Settings → Open .opt files by double-click once. After that a job opens by double-clicking it in File Explorer. If Windows asks for an app, choose pipe-tunes and “Always”.

Protection of unsaved changes. If you change a job and click New, Open or close the program, the program asks: “The order has been changed. Do you want to save the changes?” – **Yes** saves, **No** continues without saving, **Cancel** takes you back to the job.

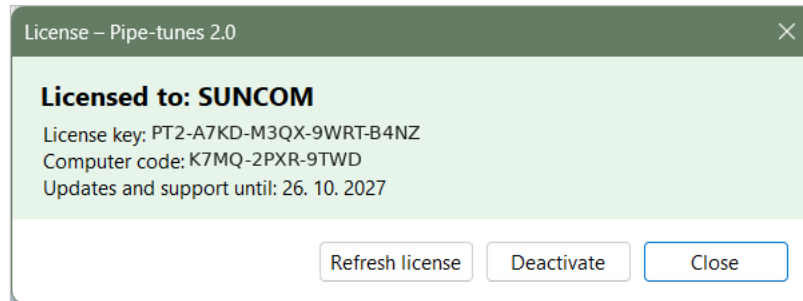
12. Languages

The program is available in 7 languages: Slovak, Czech, English, German, Dutch, Hungarian and Polish. Change the language in the menu **Settings → Language**; it takes effect immediately, also on a result that has already been calculated. Printouts, Excel and the cutting plan are also in the selected language.

13. Licence and activation

The licence is perpetual and valid for **1 computer**. You can buy it at pipe-tunes.com/en/pricing/; you receive the licence key (format PT2-XXXX-XXXX-XXXX-XXXX) by e-mail. Open the License window via **Help → License...** or by clicking the licence status on the right of the menu bar.

Status	What it means
Trial version	30 days from the first start, the program works without restrictions.
Licensed	The program is activated with a licence key; the customer name is shown at the top right.
DEMO mode	After the trial period or without a valid licence. The program works, but the optimization uses a randomly changed stock length, so the result cannot be used in production.



License window with an activated licence.

Activation over the internet

1. Open the License window.
2. Paste the key from the e-mail into the **License key** field and click **Activate**.
3. After the message "The license has been activated successfully" the program runs as the full version.

Activation without internet (computer in the workshop without a connection)

1. In the License window, in the **Activation without internet** section, you will find the **code of this computer**; copy it with the **Copy** button.
2. On another device with internet (e.g. a mobile phone) open pipe-tunes.com/en/activation/, enter the licence key and the computer code and download the licence file.
3. Transfer the file to the computer and load it with the **Load license file...** button in the License window.

Transfer to another computer. In the License window click **Deactivate** – this computer switches to demo mode and you can activate the licence on another computer. Without internet you receive a **deactivation code**, which you enter on the website before activating on the new computer. Two transfers per year are free; further transfers are handled on request by e-mail.

One licence = one computer at a time. If you start the program with the same licence on a second computer, it runs there in demo mode until you close it on the first computer. The full version then returns by itself within a few minutes; if the program crashed on the first computer, the licence is released after 10 minutes at the latest.

Updates and maintenance. Every licence includes 12 months of updates and support; you can see the date in the License window ("Updates and support until"). Once a week the program checks whether a new version is available and offers to download it; manually via **Help → Check for updates**. After the maintenance ends, the program keeps working in the version you are entitled to. You get a newer version by renewing the maintenance – the program tells you, and the **Renew maintenance** button opens an order with your key.

The **Refresh license** button loads the current licence details from the server, for example after renewing the maintenance.

14. Notes and contact

Where the data is stored (for backup when moving to another computer):

Data	Location
Jobs	.opt files, wherever you save them.
Offcut stocks	%LOCALAPPDATA%\SUNCOM\PipeTunes2\Stocks (.stock files), or the folder chosen in the Stock window → Stock folder
Settings and recently opened jobs	Windows registry: HKEY_CURRENT_USER\ Software\SUNCOM\pipe-tunes\nastavenia

If a nonsensical value ends up in the registry (e.g. a stock length of 60000 from an old version), the program replaces it with the default on start and starts normally.

The price list, terms and licence conditions and the installer are available at **pipe-tunes.com**. When moving to another computer, remember to deactivate the licence on the old computer (chapter 13).

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If you have any problems or questions, please contact me by e-mail at info@pipe-tunes.com.