



Training Documentation

Prinect Signa Station 2021 - What's New

Revision 1.2



Prinect

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What you should already know

We assume that you are familiar with the Windows® and Mac OS X® operating systems that are supported by this application.

A basic Signa Station Training is required to understand this documentation!

Additional Documentation

You can find this document and additional information in:

- **Educate Center:** http://educate-center.heidelberg.com/ilias/login.php?target=crs_1517&soap_pw=&ext_uid=&cookies=nocookies&client_id=HEI-e-Learning&lang=en
- **Easy Sales Portal:** <https://hdmnet.sharepoint.com/sites/EasySales/Pages/Search.aspx#k=ProductArea%3APrinect#l=1033>
- **Online Help:** http://onlinehelp.prinect-lounge.com/Prinect_Signa_Station/Version2020/en/#t=Prinect%2FTitle_RoboHelp%2FTitle_RoboHelp.htm

Important Information

Important information in the text is marked by symbols that are used as follows:



Warning: Contains information that must be taken into consideration to protect the user from injury.



Attention: Contains information that must be taken into consideration to prevent damage to hardware or software.



Note: Contains important general or supplementary information about a specific topic.



Note: This feature was implemented in Signa Station 2020.10.

Before you start...

1 General

2020.10 **Note:** This features were implemented in Signa Station 2020.10.

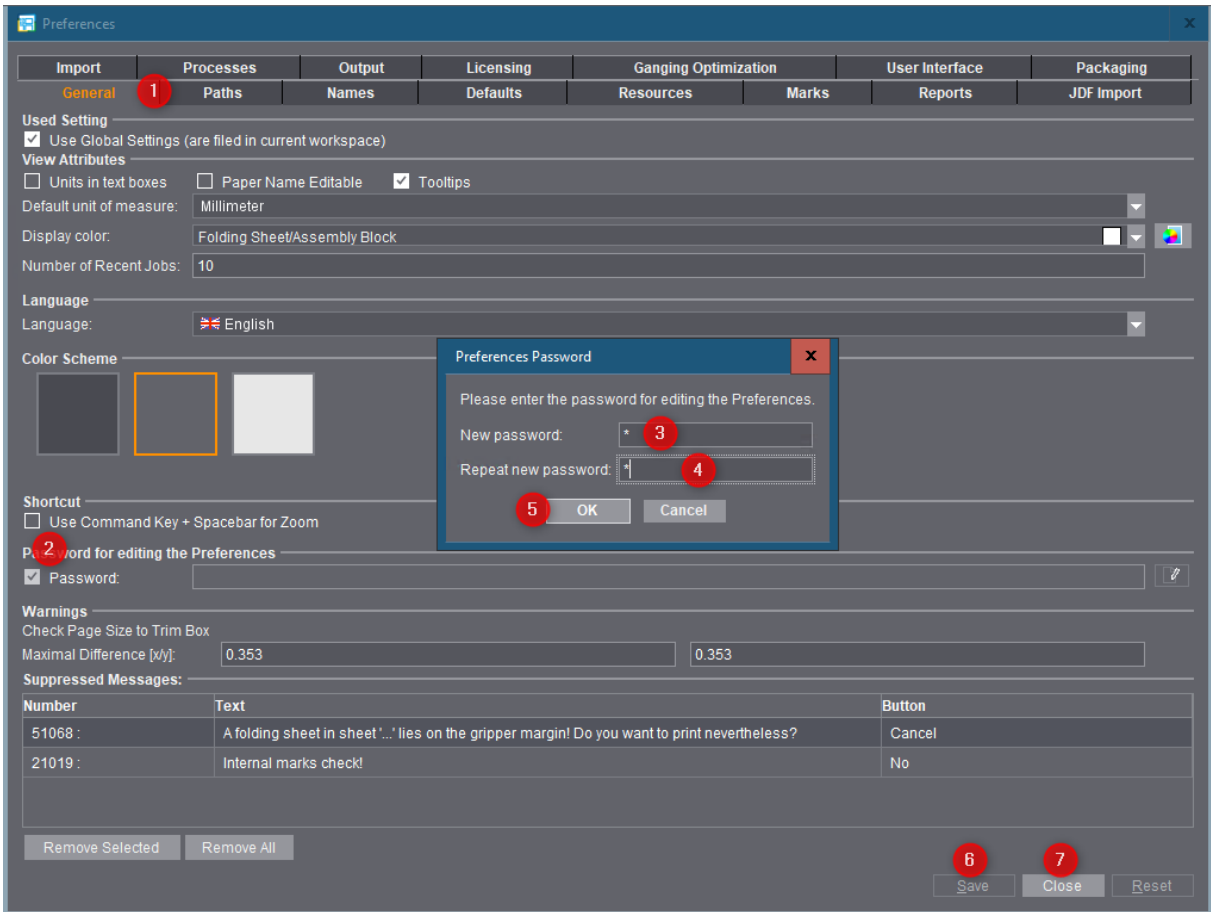
1.1 Password Protection for Preferences

Motivation

Changing the Signa Station preferences can disable automated workflows with Signa Server or Signa Gang Server. For this reason we should protect the preferences.

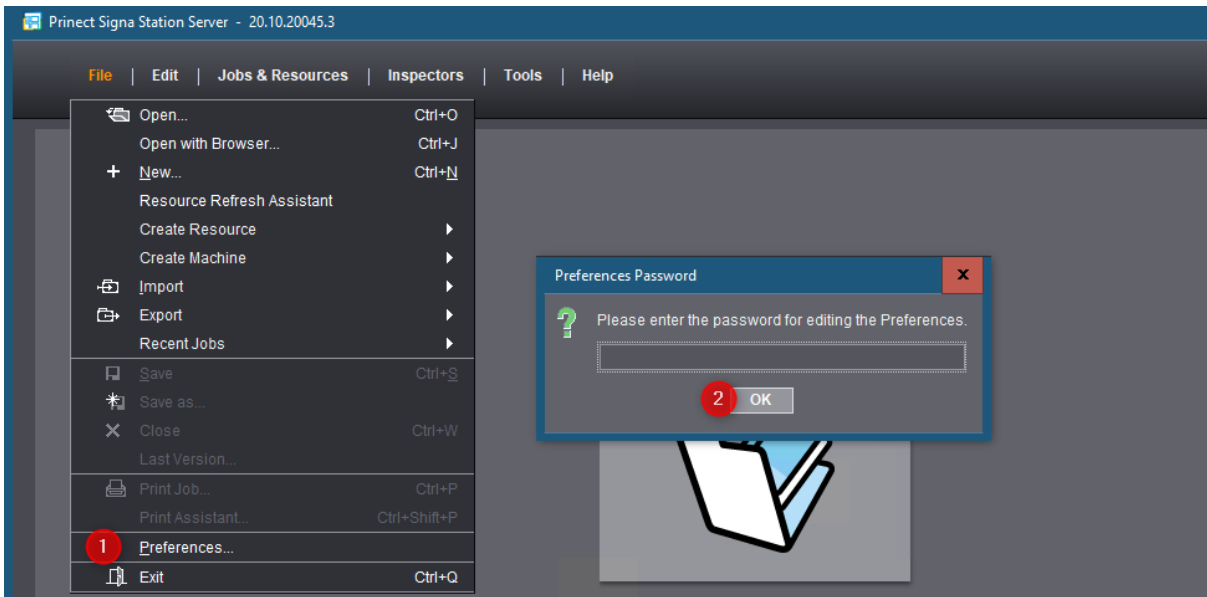
Description

In 'File > Preferences > General' we can now enable a password protection.

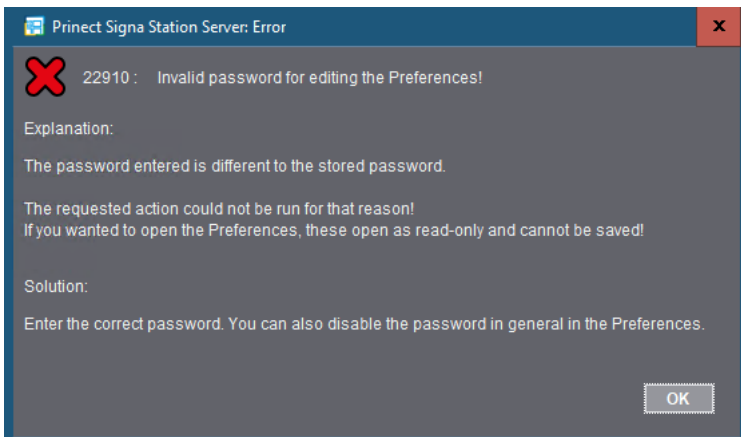


1 General

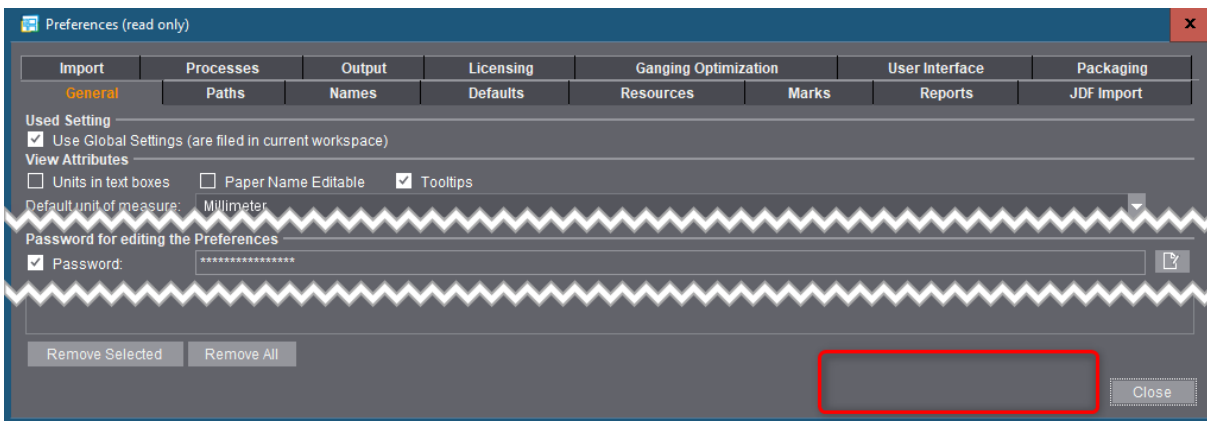
An enabled protection requires the password to open and to edit the preferences.



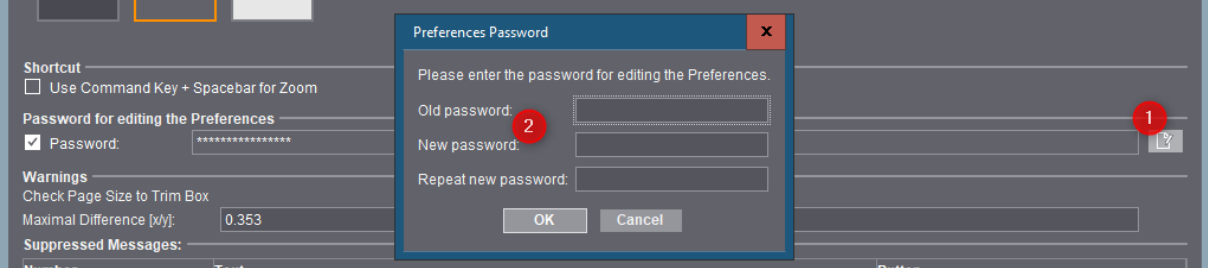
Visiting the preferences with the wrong password displays this warning dialog.



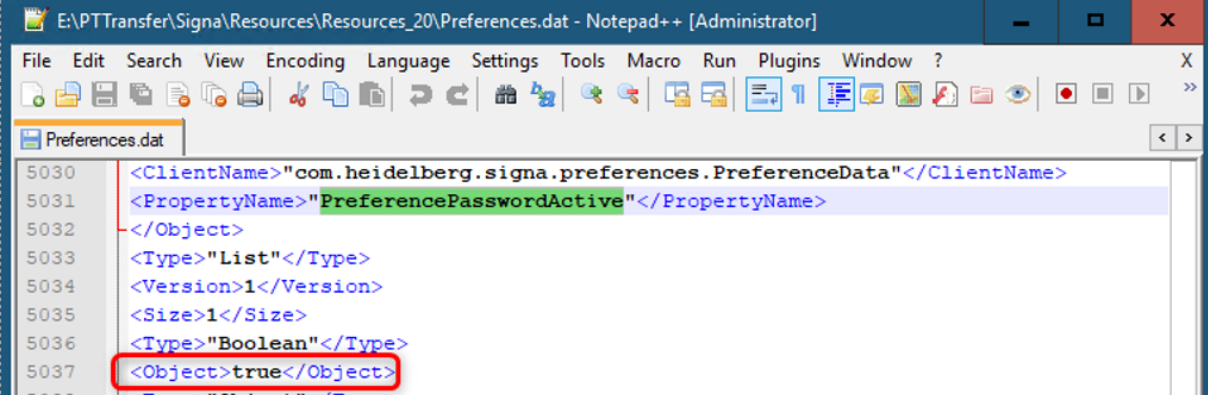
After this warning the preference dialog is opened, but we cannot save any changes in this condition.



Only with the correct password we can change the password.



Note: We can disable a activated password protection in the Preferences.dat file:
 Activated = true, deactivated = false



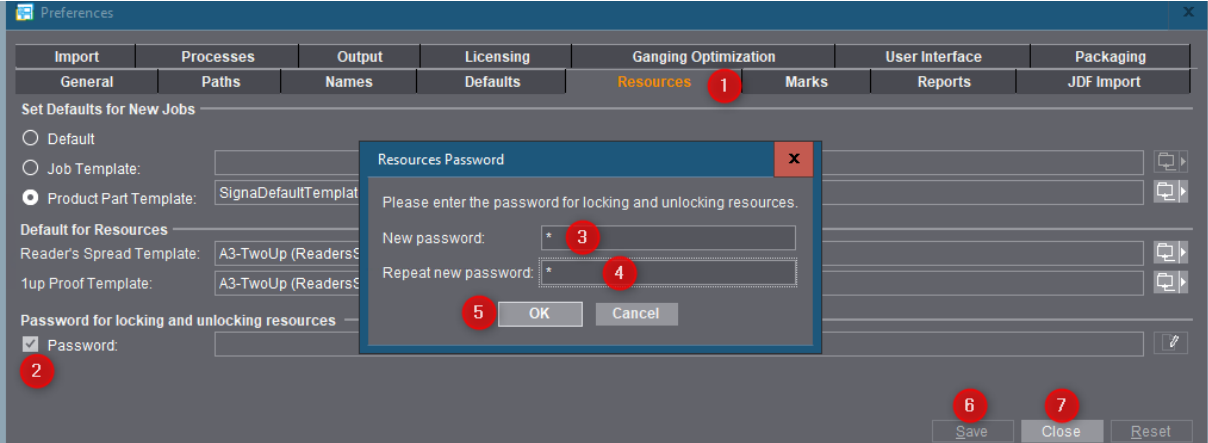
1.2 Password for Locking and Unlocking Resources

Motivation

Locked Signa Station resources should not be able to unlock by any user.

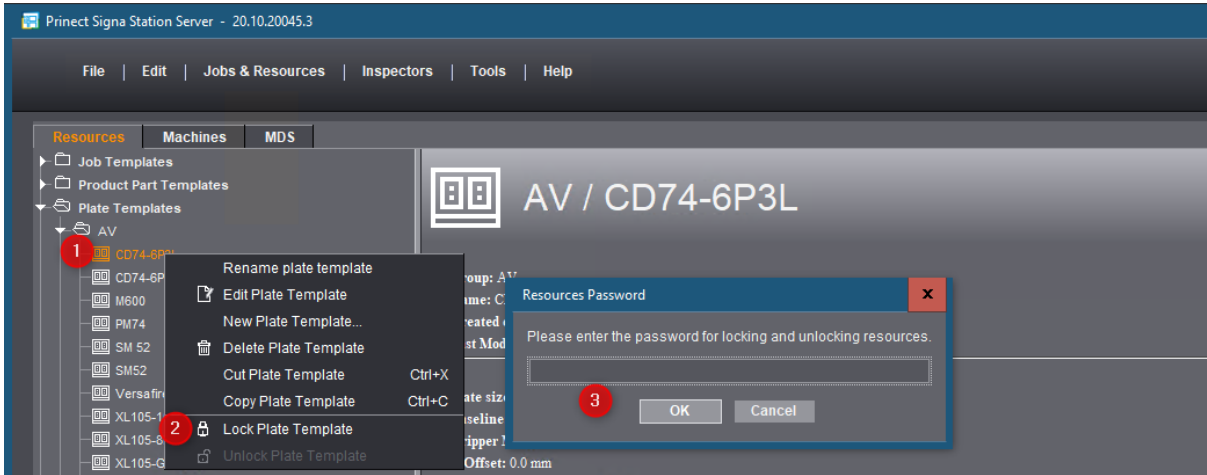
Description

In 'File > Preferences > Resources' we can now enable a password protection.

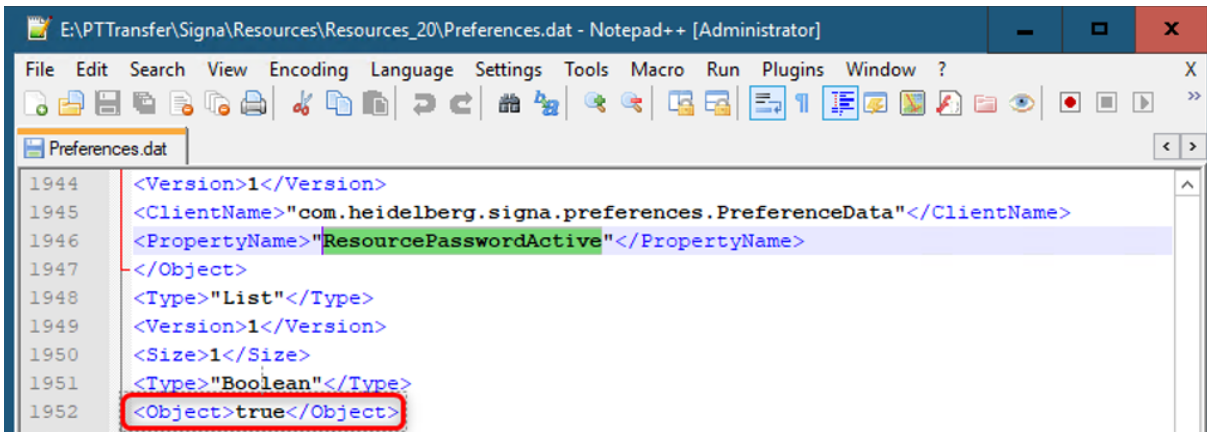


1 General

We need a password for locking and unlocking when this feature is enabled.



Note: We can disable an activated password protection in the Preferences.dat file:
Activated = true, deactivated = false



1.3 Magnetic Placement of Folding Schemes

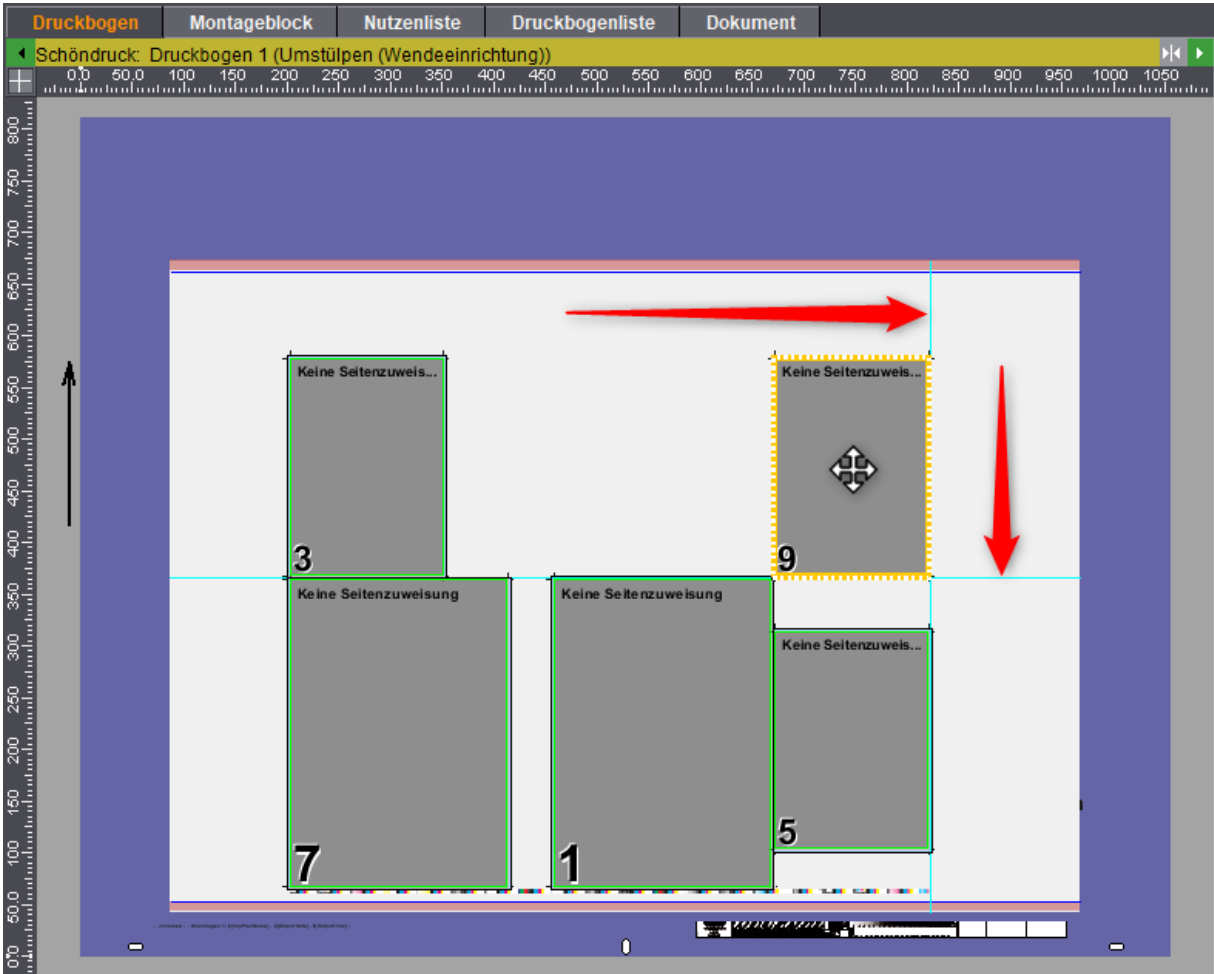
2020.10 **Note:** This feature was implemented in Signa Station 2020.10.

Motivation

We have changed the behavior to move folding schemes in the Graphic View to customer needs.

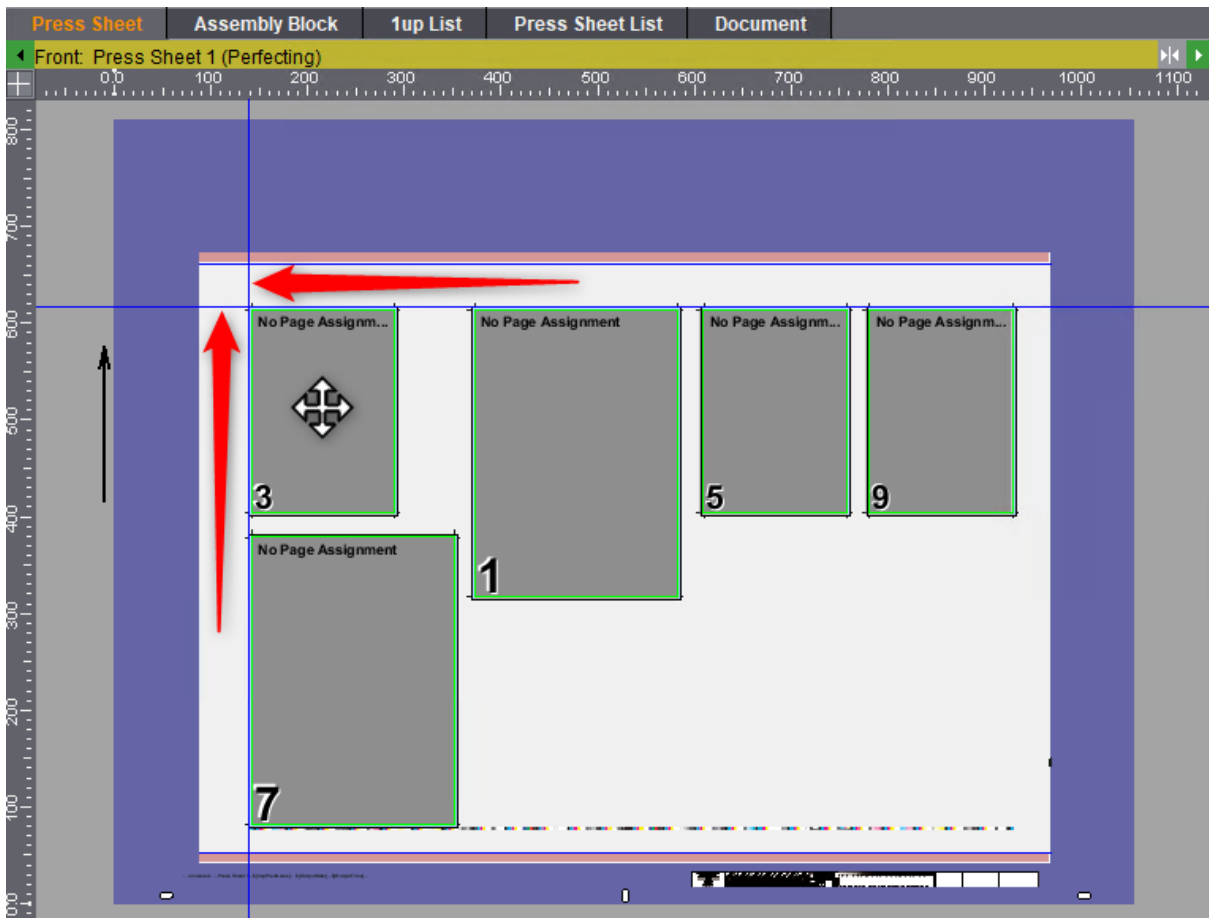
Description

We can move folding schemes and assembly blocks to automatically displayed magnetic help lines - cyan colored lines.



1 General

We can move folding schemes and assembly blocks to manually created magnetic help lines - blue colored lines.



2 Marks & Text Replacer

2.1 Multiple Character Formatter for Text Replacer

2020.10

Note: This feature was implemented in Signa Station 2020.10.

Motivation

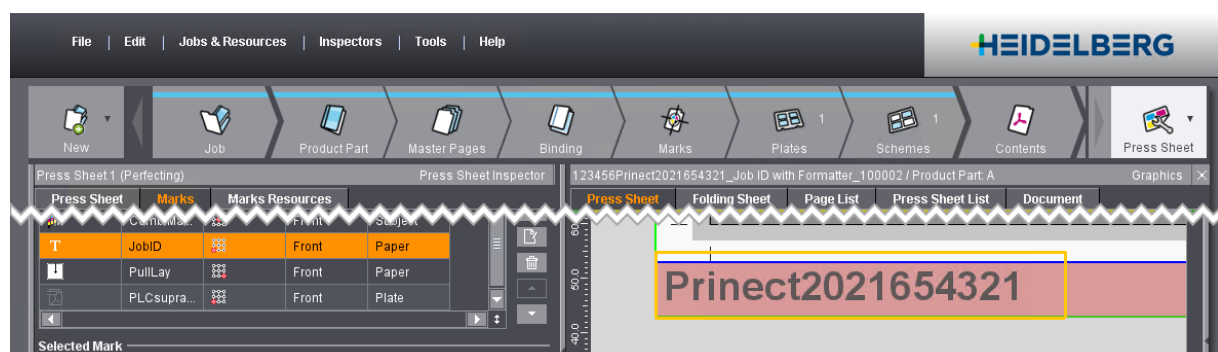
Until now the formatter for cutting text replacer only allows us to use a one-digit number (0 to 9). Especially for text replacer that replace too long text, this restriction leads to the fact that the text cannot be cropped as desired.

Description

With Prinect version 2020.10 onwards, it is now possible to enter any numbers and text in formatters.

Format	Visible result	In words
<code>[\$jobid]</code>	123456Prinect2021654321	No formatting.
<code>[\$jobid:13]</code>	123456Prinect	Displays the first 13 characters.
<code>[\$jobid:-13]</code>	ect2021654321	Displays the last 13 characters.
<code>[\$jobid:(6,0)]</code>	Prinect2021654321	Removes the first 6 and the last 0 characters.
<code>[\$jobid:(1,8)]</code>	23456Prinect20	Removes the first 1 and the last 8 characters.
<code>[\$jobid:(Prinect,0)]</code>	2021654321	Remove all first characters including 'Prinect'
<code>[\$jobid:(5,Prinect)]</code>	6	Removes the first 5 and the last characters including 'Prinect'.
<code>[\$jobid:(Prin,0)]</code>	ect2021654321	Removes the first characters including 'Prin' and the last 0 characters.

Using the text replacer "`[$jobid]`" with the formatter "(6,0)" looks as follows:



2 Marks & Text Replacer

2.2 New Text Replacer "\$[SegmentName]"

2020.10

Note: This feature was implemented in Signa Station 2020.10.

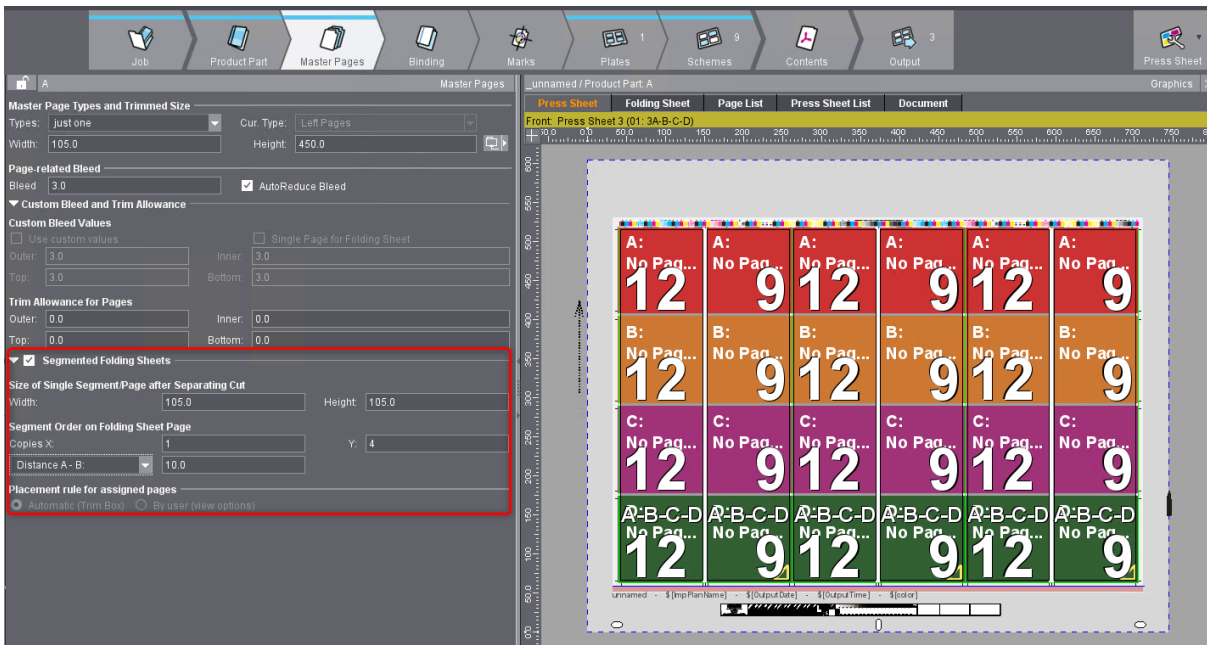
Motivation

Until Prinect version 2020, the placeholder "\$[SegmentName]" was only used at a "segmented folding sheets" (pixi books).

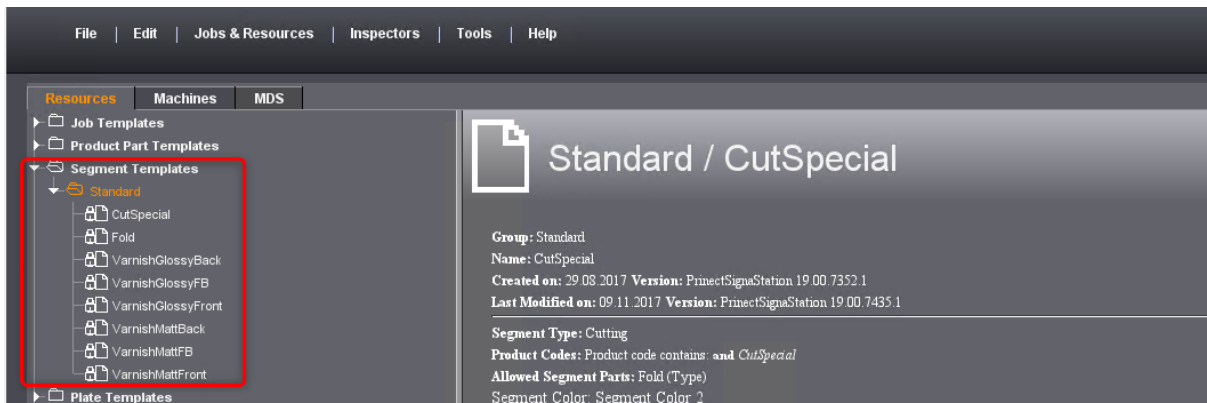
We want to use the same placeholder to output the name of "segment templates" (Chapter 8 - Gang-ing with Segments).

Description

The placeholder "\$[SegmentName]" has always replaced the name of "segmented folding sheets".



AND can now also replace the name of used "segment templates".



Note: This both features are absolutely different!

The mark can be placed on:

- a segment signature
- a segment folding sheet/montage block
- on a single page
- If the mark is placed on the paper, subject or printed sheet, all segments on it are replaced with the placeholder separated by commas.

2.3 New Text Replacer "\$[SheetregionOutputIndexInGroup]"

2020.10 **Note:** This feature was implemented in Signa Station 2020.10.

Motivation

For folding sheet identification at the feeder, the sheet index within the group must be known. Therefore, the text replacer "\$[SheetregionIndexInGroup]" already exists.

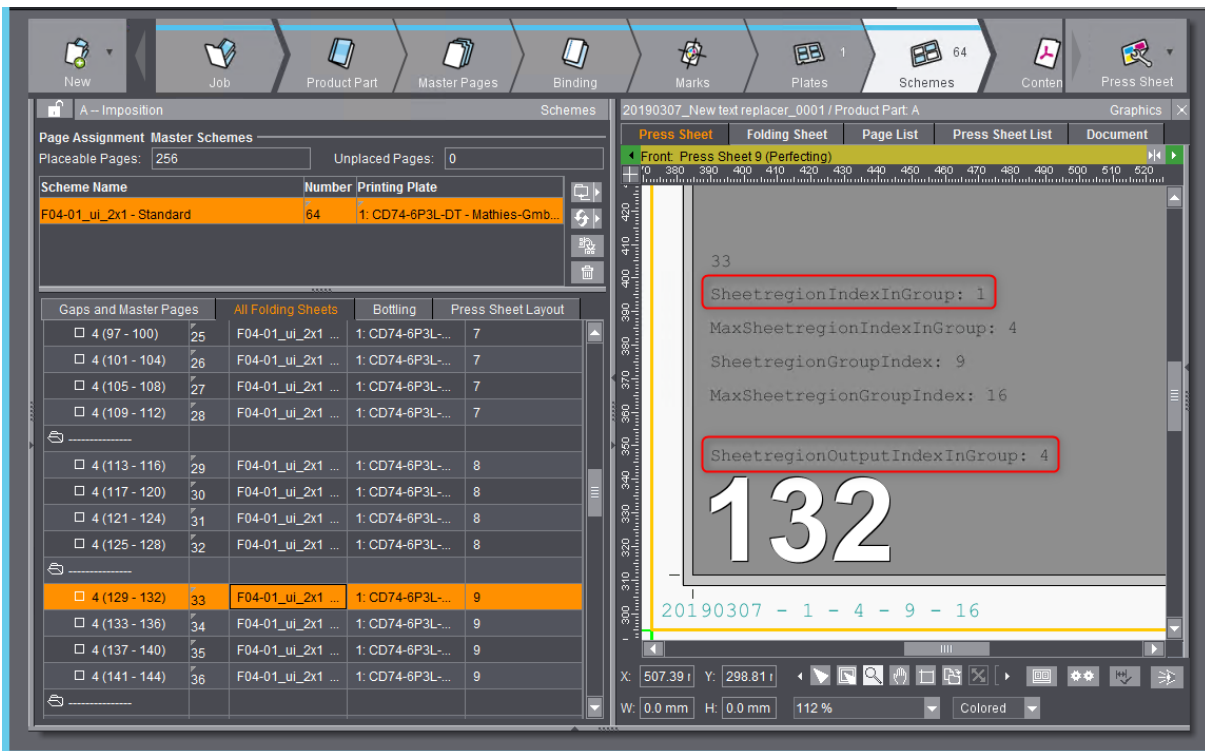
For using 'Reverse Folding Sheet Order within Groups' we need a placeholder to recognize the output order.

Description

For this purpose we have a new text formatter: "\$[SheetregionOutputIndexInGroup]".

Using the function 'Reverse Folding Sheet Order within Groups' in the TOV Scheme, we need this text replacer – instead of "\$[SheetregionIndexInGroup]" – to output the actual order of the folding schemes withing the group.

Example: The output order for 'Reverse Folding Sheet Order within Groups' is "4".



2.4 Collating Mark - "Offset orthogonal"

2020.10

Note: This feature was implemented in Signa Station 2020.10.

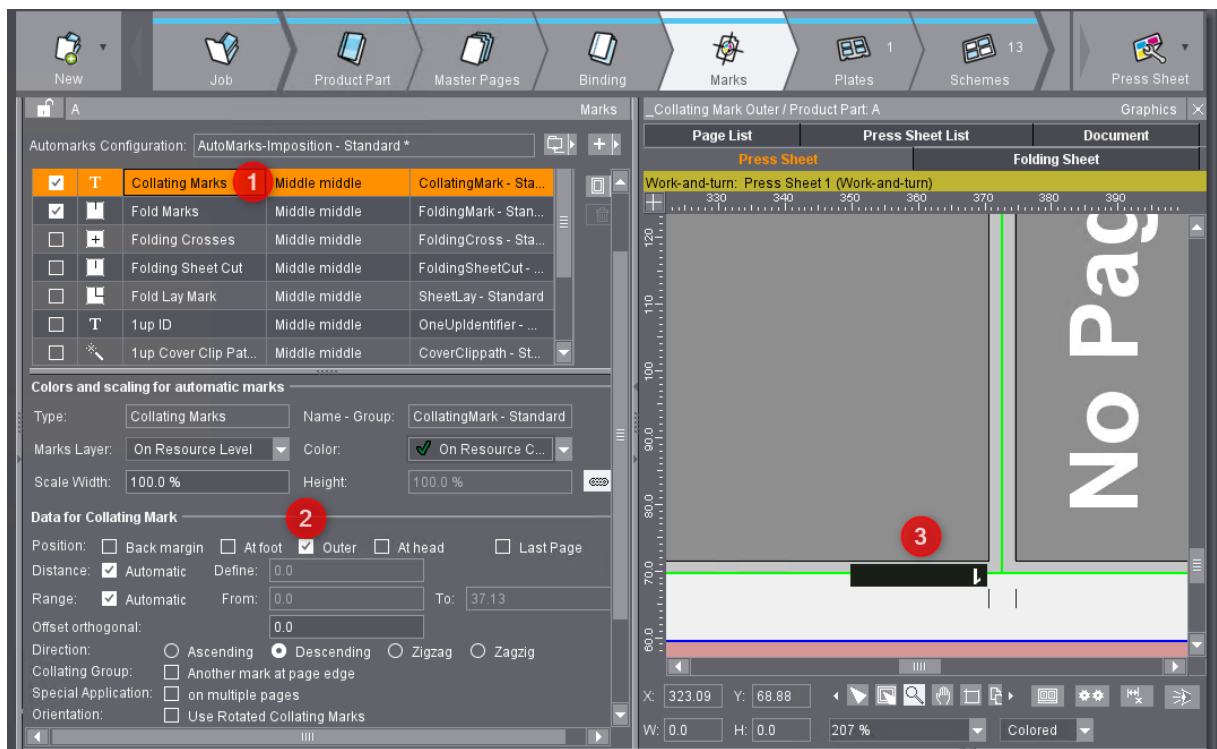
Motivation

Basically, collating marks are set automatically for Perfect Binding and should not be edited by the user afterwards. The "Collating Mark" is always placed centered at the cutting box (green line).

We have a customer who wants to define the "Collating Mark":

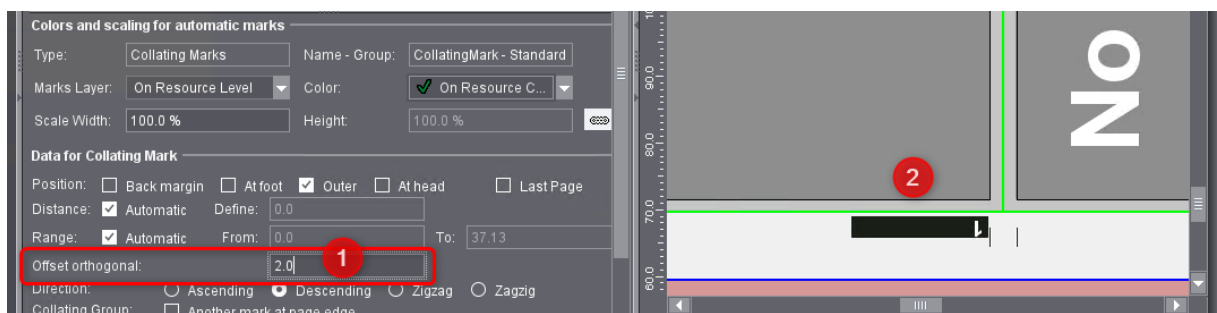
- For saddle stitched brochures with only F04 schemes too at an outer position!
- He also ignores the cutting box and cuts manually!

In this special case the "Collation Mark" would be placed into the page bleed - he wants to move it.



Description

We can now move the "Collating Mark" outwards (positive values) or inwards (negative values)



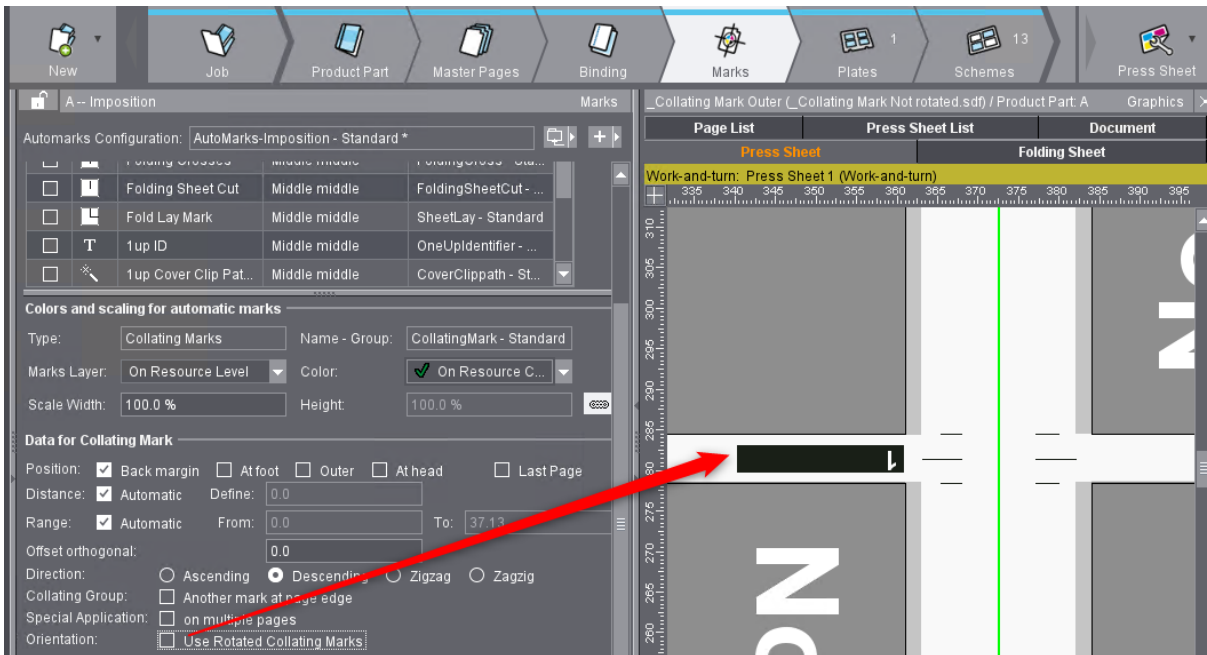
2.5 Collating Mark - "Use Rotated Collating Marks"

Motivation

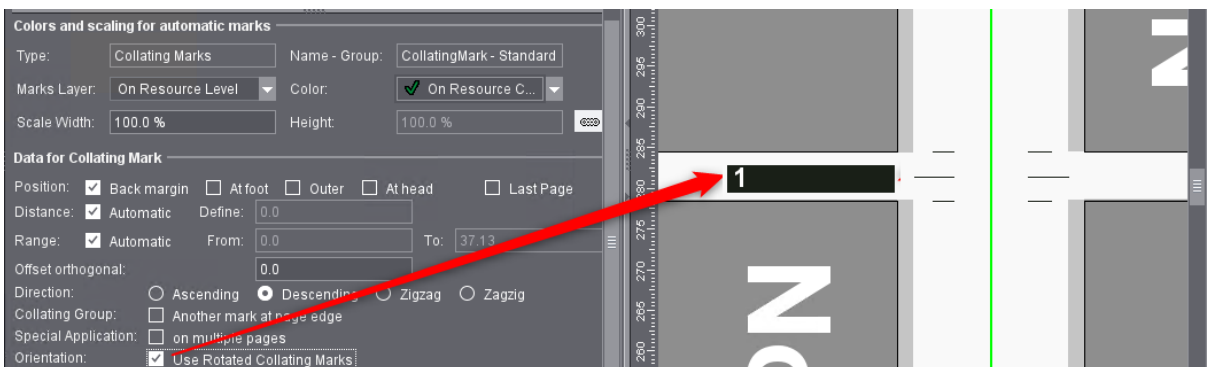
With the implementation of the "Auto Marks Configuration" (next chapter) as a resource, we have to move some marks "Preferences" into the job.

Description

The attribute "Use Rotated Collating Marks" has been removed from the preferences settings and is located in the Marks tab now.



The rotated "Collating Mark":



2.6 Checking Mark Positioning During Output

2020.10

Note: This feature was implemented in Signa Station 2020.10.

Motivation

During outputting Signa Station is checking automatically if marks are

- in the gripper margin
- outside of the paper

If this is the case, a warning dialog is displayed before output process will start.

Customers wants to disable warnings for some marks.

Description

Special mark types are excluded from this warning

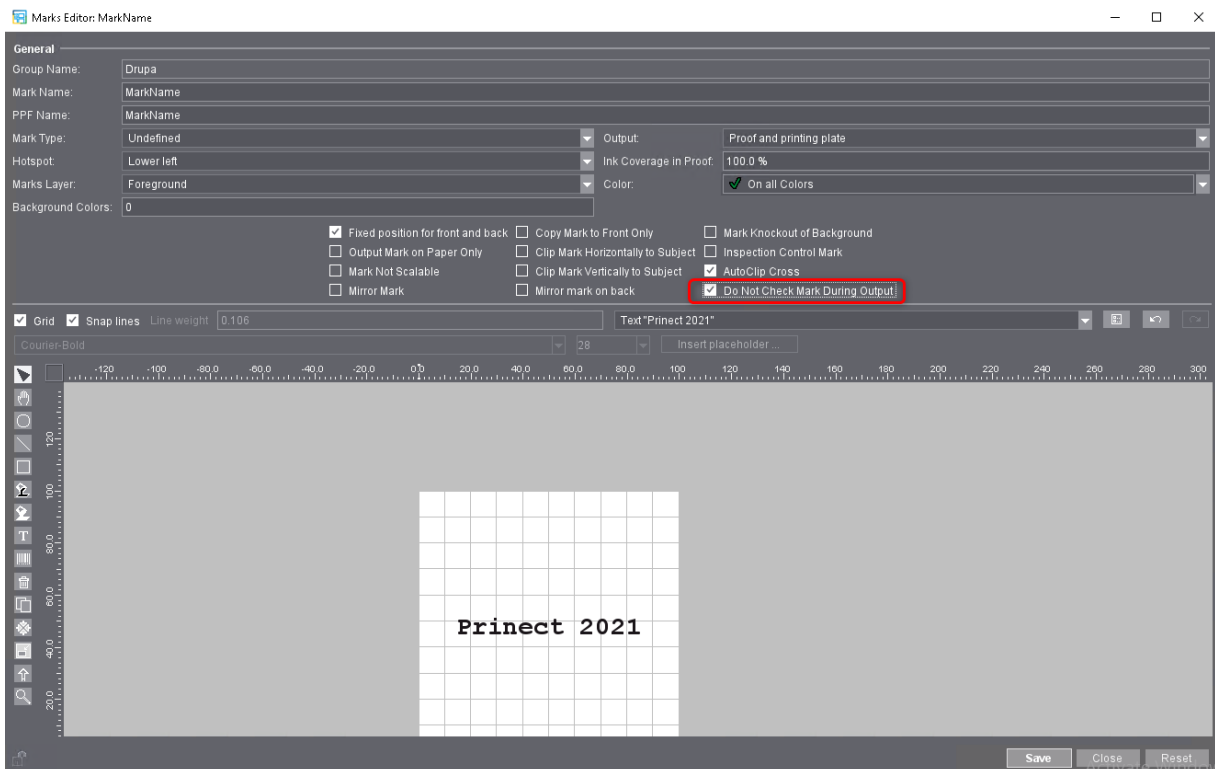
- Plate control marks
- Default 'RegisterLine' mark
- Scavenger Mark
- Print quality strip
- Pull lay

The following marks are also excluded from check due to compatibility reasons:

- Marks with the name 'PullLay', 'RegisterLine' and the mark 'Text' in the 'Standard' group.

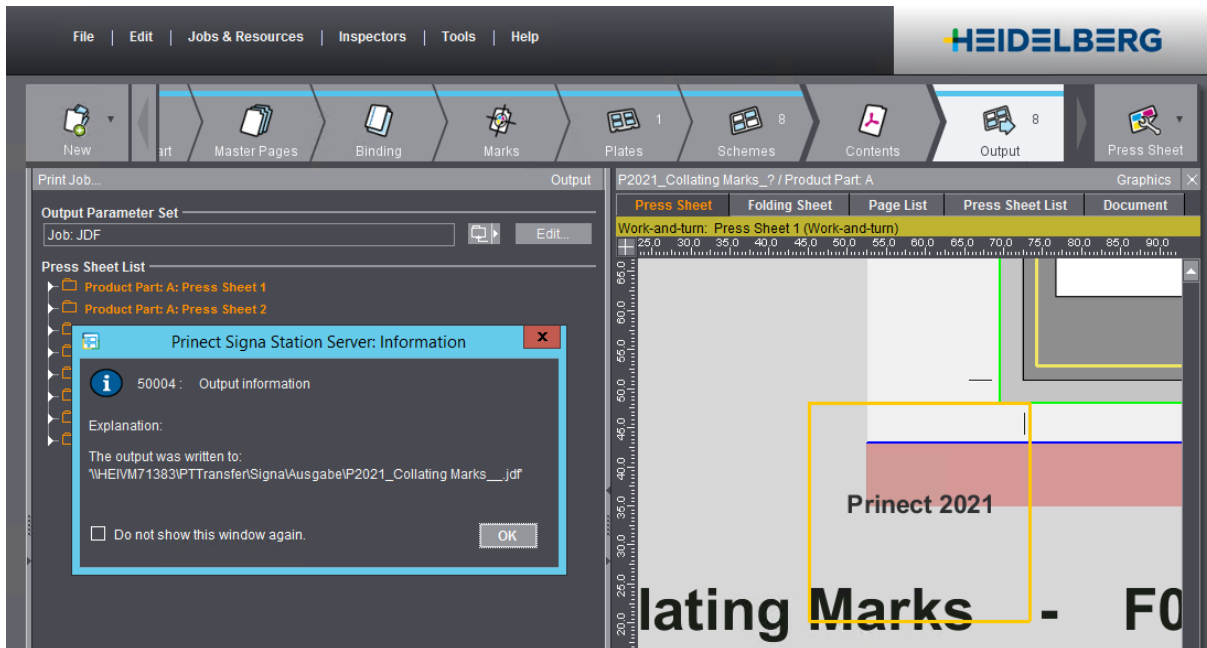
We can now disable the marks check in the marks editor.

In the Marks Editor the check box 'Do Not Check Mark During Output' is now available.



2 Marks & Text Replacer

Mark with enabled attribute 'Do Not Check Mark During Output' will not cause a warning.



3 Automarks

Motivation

Especially customers with MIS connectivity wants to have a Signa Server layout with "Folding sheet marks" for finishing on special places.

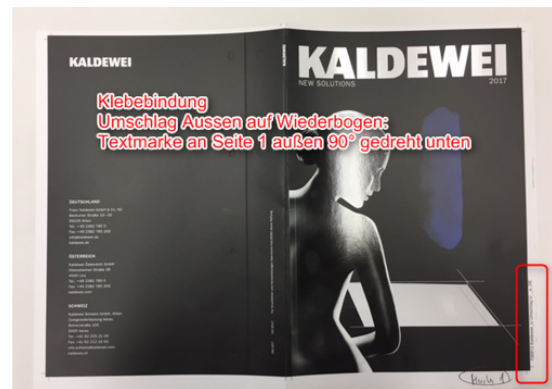
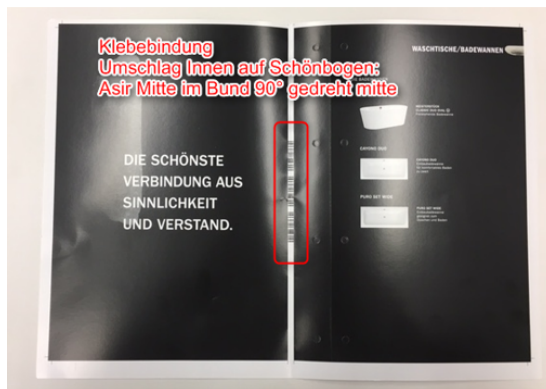
Example: Barcodes for "Kolbus" binder or "Mueller Martini" stitcher.

We need mark sets and rules to place marks for different binding intents on different places for cover and body.

Example Perfect Binding:

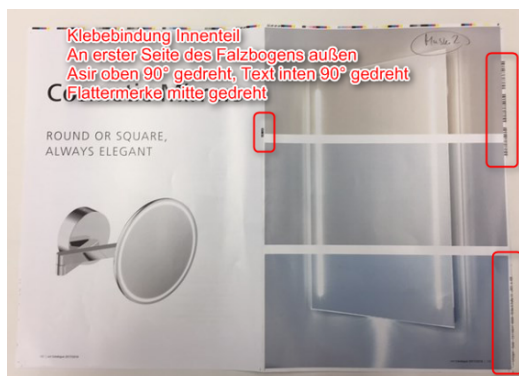
The job should have at the "Cover" a:

- "Folding Sheet Mark" in "Asir Code" on the "back side" in the middle of the "Routing Margin"...
- "Folding Sheet Mark" as "Text Mark" on the "front side" at the bottom right position



For the "Body" folding sheets we need a:

- "Collating Mark" at the front side in the "Routing Margin" centered middle
- "Folding Sheet Mark" in "Asir Code" at the front upper right position
- "Folding Sheet Mark" as "Text Mark" at the front bottom right position



At the moment we have to do this manually and we want to achieve this result by loading mark sets or automatically.

3 Automarks

3.1 Automarks as a Resource

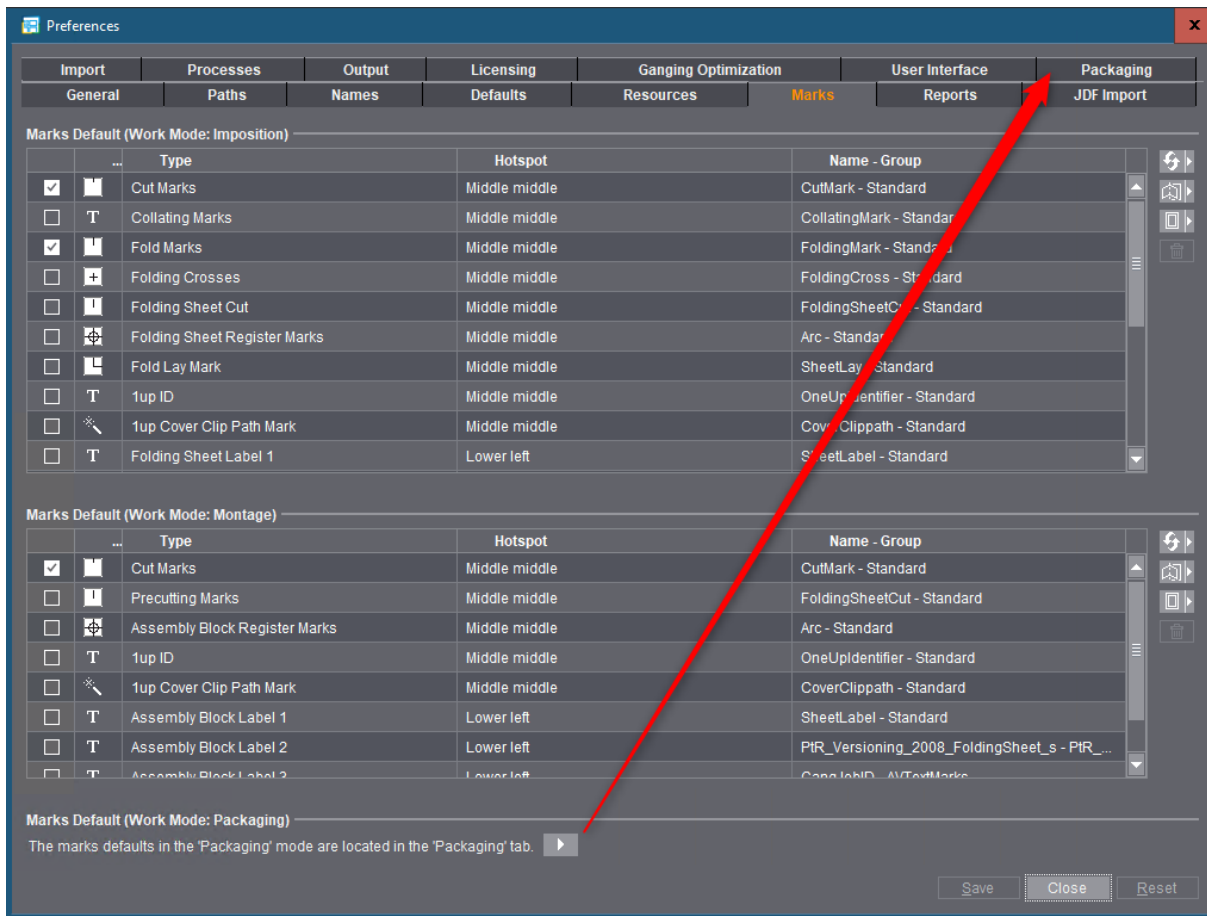
Motivation

Some customers want to define the marks handling individually for different work modes, different binding intents and different formats.

It is only possible to specify marks globally for new jobs in the "Preferences" for the modes:

- Imposition
- Montage
- Packaging

Signa Station 2020.10 Preferences



Description

We have two different cases:

1. New Signa Station installation

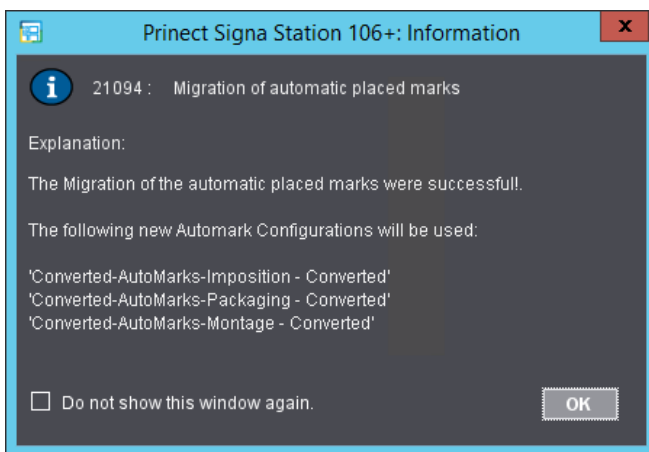
No dialog informs about "Migration of automatic placed marks".

2. Starting up Signa Station after a upgrade

Automarks are converted automatically from the old Preferences > Marks settings.

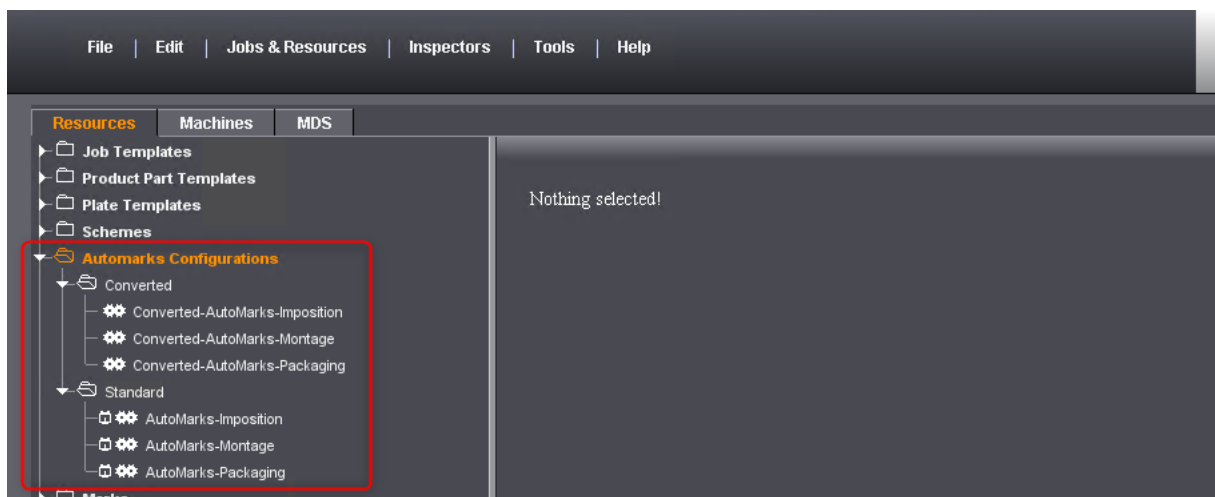
- Converted-AutoMarks-Impositioning
- Converted-AutoMarks-Packaging
- Converted-AutoMarks-Montage

Information dialog after a successful migration of automatic placed marks.



Note: This dialog does not come up, when the old defaults are identical to the Heidelberg factory defaults.

The mark sets are stored in the "Resources > Automarks Configuration" in the group "Converted". A new Signa Station installation or an upgrade with factory defaults has only the folder "Standard".



3 Automarks

3.2 Marks Preferences in Signa Station

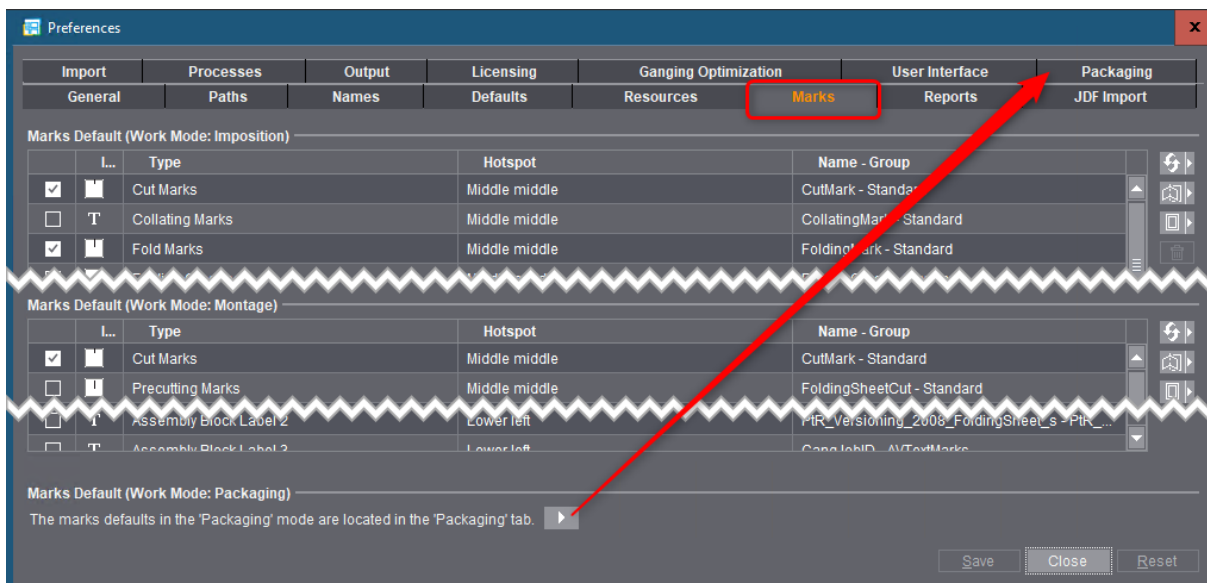
Motivation

Because we have now "Automarks" as a resource, we do not need the marks tab in the preferences.

Description

Signa Preferences Prinect 2020.10

In previous Signa Station versions we had an own marks tab to define defaults for 3 work modes.

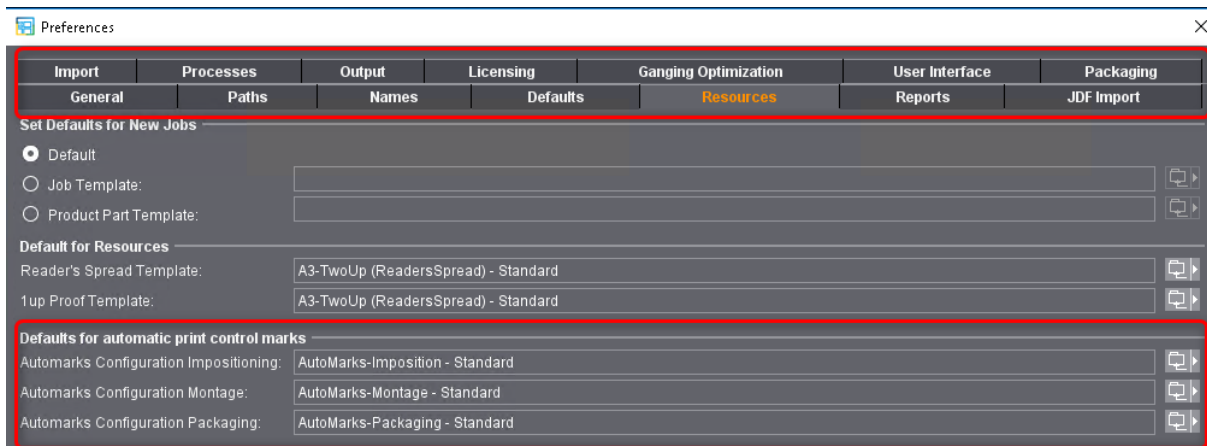


Signa Preferences Prinect 2021

In Signa Station 2021 we do not have a marks tab in the preferences anymore!

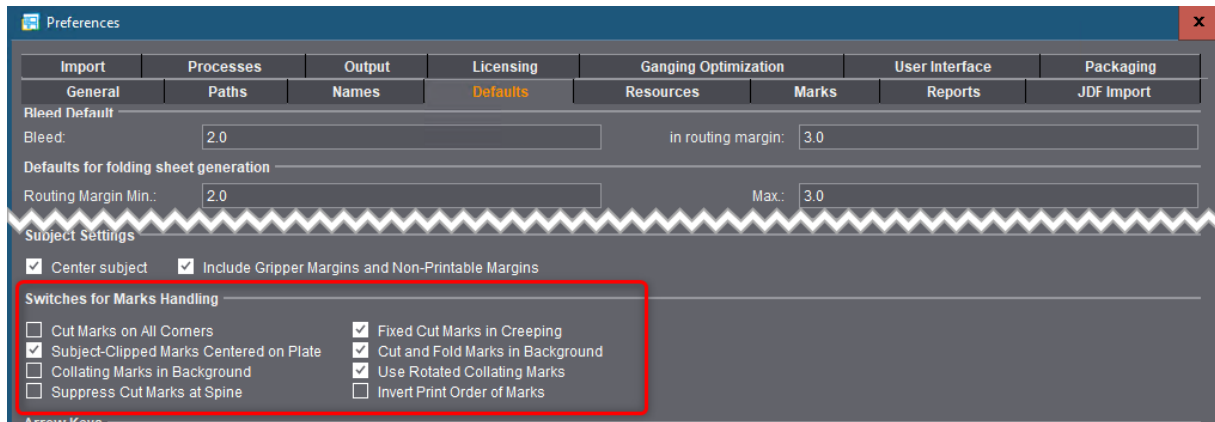
We will find "Defaults for automatic print control marks" in the tab "Resources":

- A new installation has defaults from the folder "Standard"
- A Signa Station upgrade with converted Automarks takes the defaults from folder "Converted"
- The Signa Server takes this "Automarks Configuration" to create new layouts



Signa Preferences Prinect 2020

In previous Signa Station versions we had many options in "Defaults > Switches for Marks Handling".



Signa Preferences Prinect 2021

A lot of these options are now to be found in the Automarks Configuration and in the job.

In the preferences we now have only two global options in the dialog:



- **Subject Clipped Marks Centered on Plate:**
Color control marks with enabled "AutoClip" are automatically centered on the plate.
- **Invert Print Order of Marks:**
By default, the marks are printed in the following order:
 1. Page-related marks
 2. Folding sheet-related marks
 3. Subject-related marks
 4. Paper-related marks
 5. Plate-related marks

This means that the plate-related marks are printed over the other marks.

When this option is enabled, the marks are printed in exactly the reverse order, in other words, the page-related marks are printed over all the other marks.

3 Automarks

3.3 "Automarks Configuration"

We can create or modify "Automarks" defaults for job creation at two places:

- In "Resources" => without visible result
- From a job => visible result

3.3.1 Create / Modify a Automarks Configuration in Resources

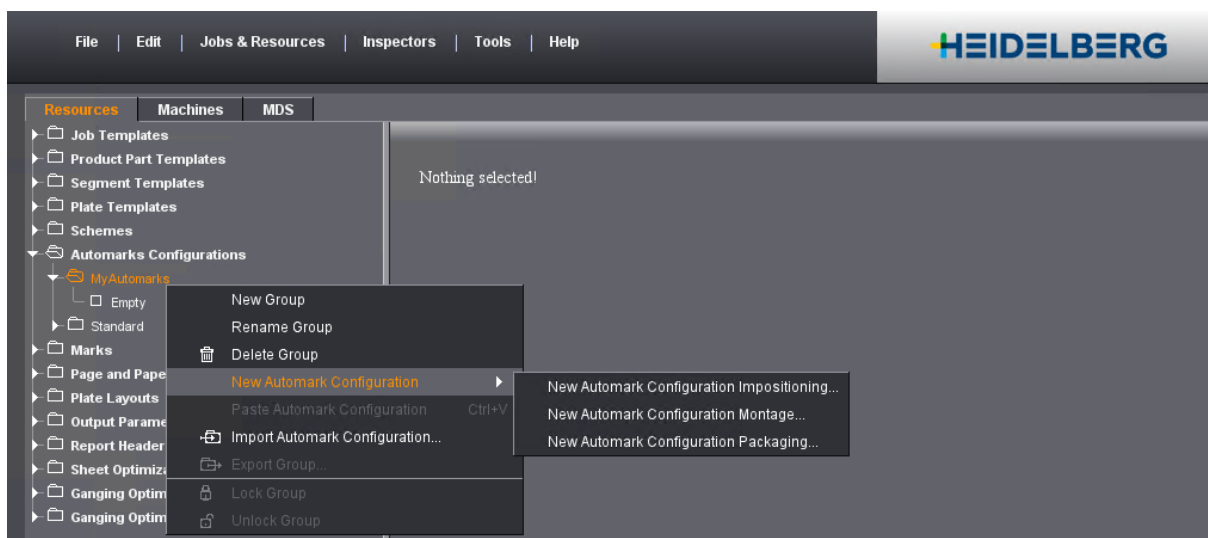
Motivation

For basic "Automarks" defaults we have to create them in "Resources" like we have done it in previous versions in the "Preferences".

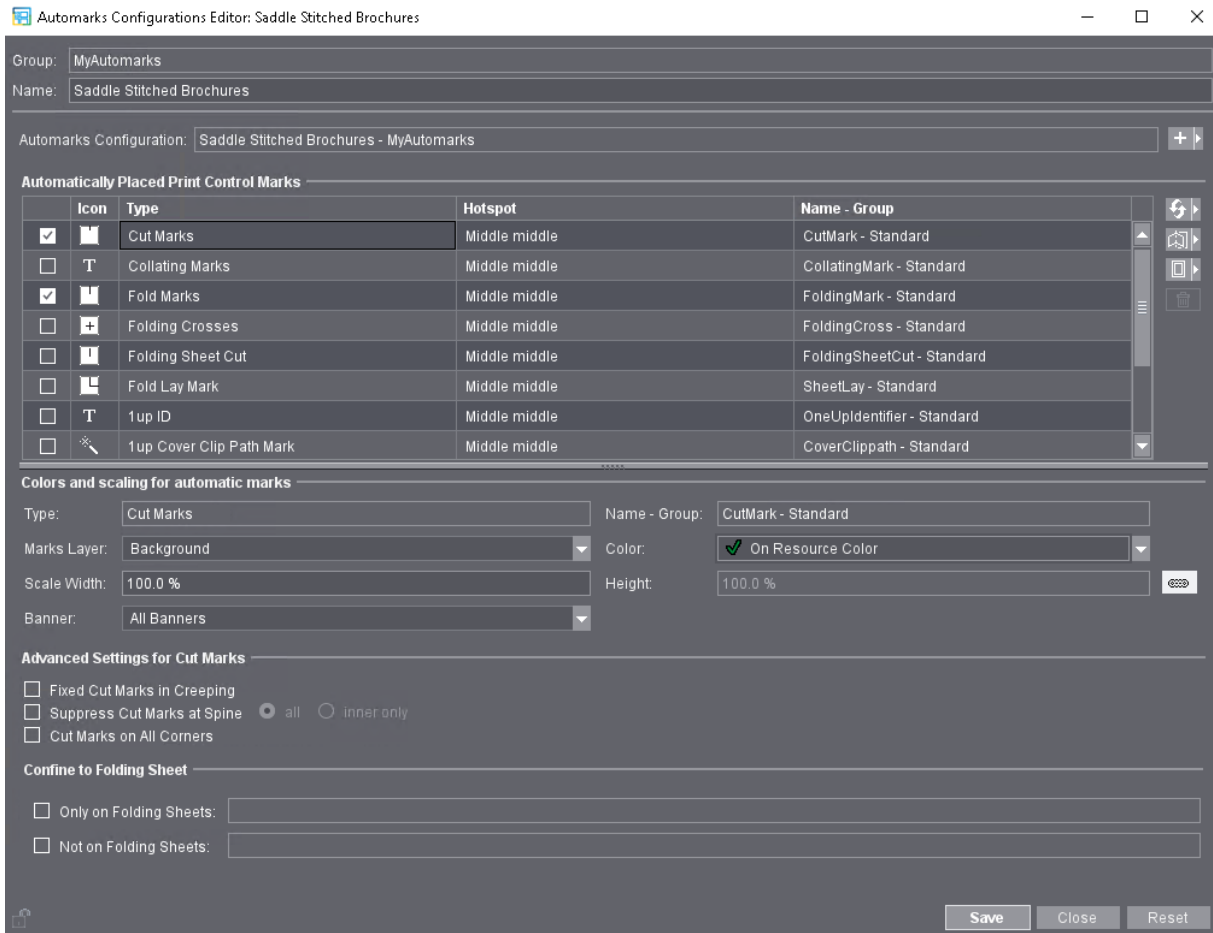
Description

There are three different work modes available for creating "Automarks":

- Automarks Configuration for Imposition
- Automarks Configuration for Packaging
- Automarks Configuration for Montage



A new created "Automarks Configuration" is identical to the previous "Preference > Marks" defaults.



We can modify the existing "Automarks" in the folder "Converted", the "Automarks Configuration" in the folder "Standard" are write protected.



Note: Do not forget to define new created defaults in the "Preferences > Defaults" tab.

3 Automarks

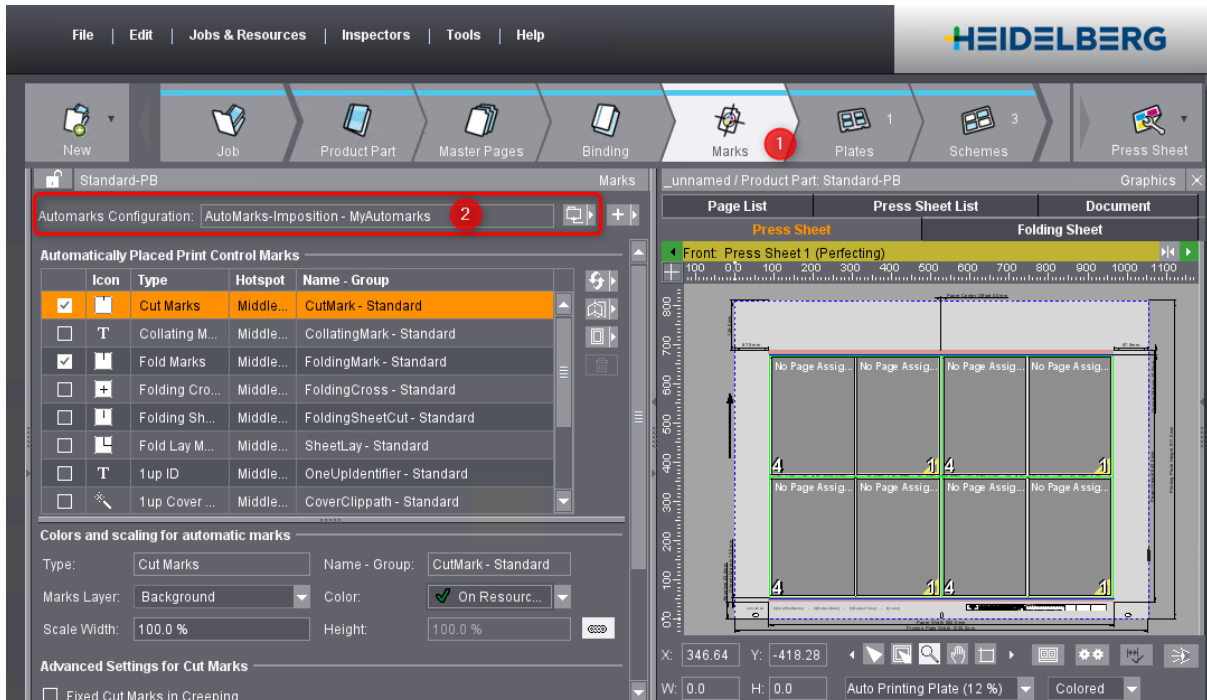
3.3.2 Create a new "Automarks Configuration" from Job

Motivation

For complex "Automarks Configurations" it is much better to save it from a job, because the result is displayed in the User Interface.

Description

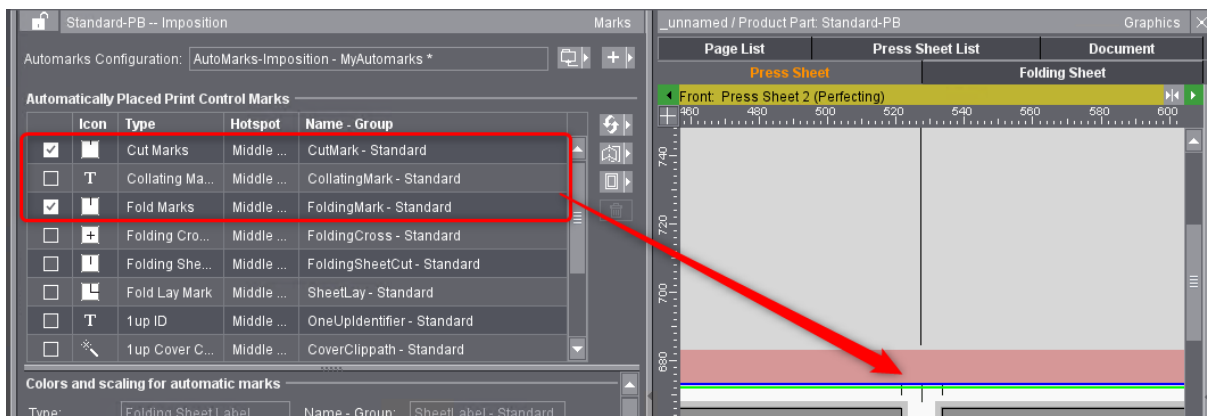
The used "Automarks", configured in "Preferences > Defaults", are displayed in the job marks tab.



Example: We want to create an "Automarks Configuration" for a "Perfect Binding" job with:

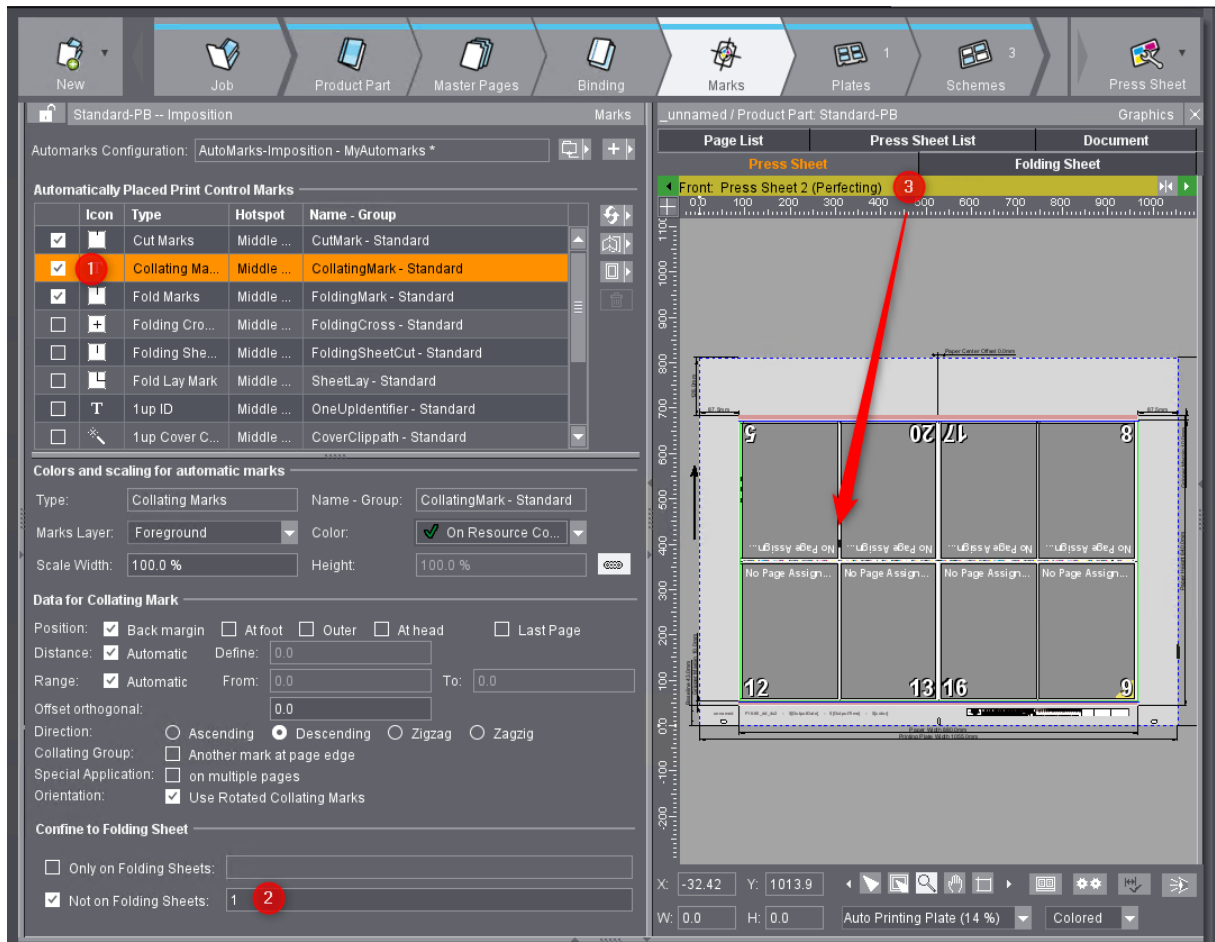
- "Cut" & "Folding" marks
- "Collating Marks"
- Different "Folding Sheet Marks" positions for different folding sheets

Cut & Folding marks are defined by default.



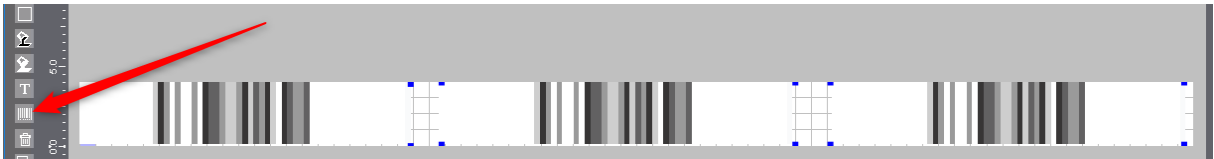
"Collating Mark" should be ignored for Folding sheet 1 (Cover).

Result: The Collating Mark is visible at the second sheet on position 2.

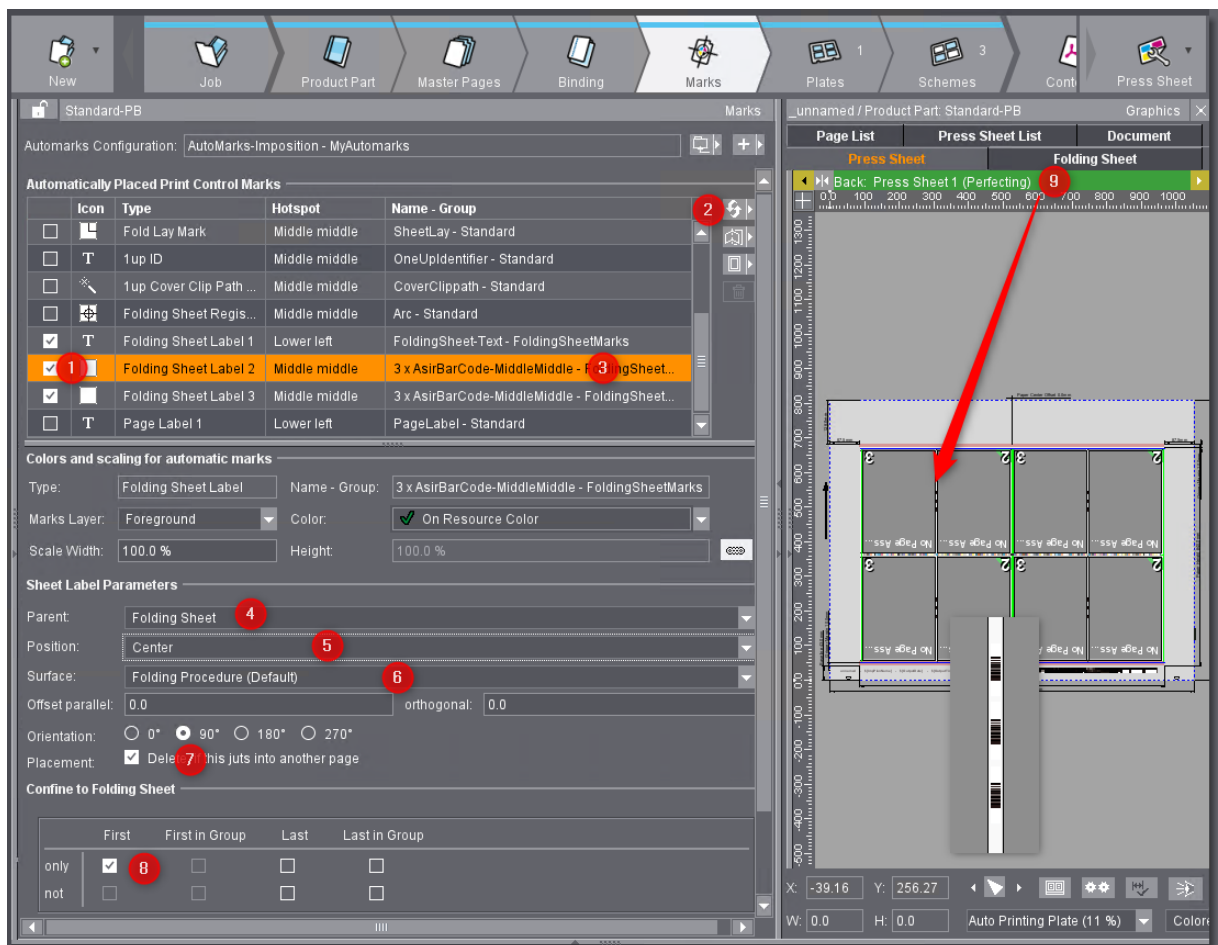


2. A "Asir" bar code mark for the first folding sheet only.

We can create Bar codes in Signa Station "Marks Editor" - the "Hotspot" should be "Middle middle!"



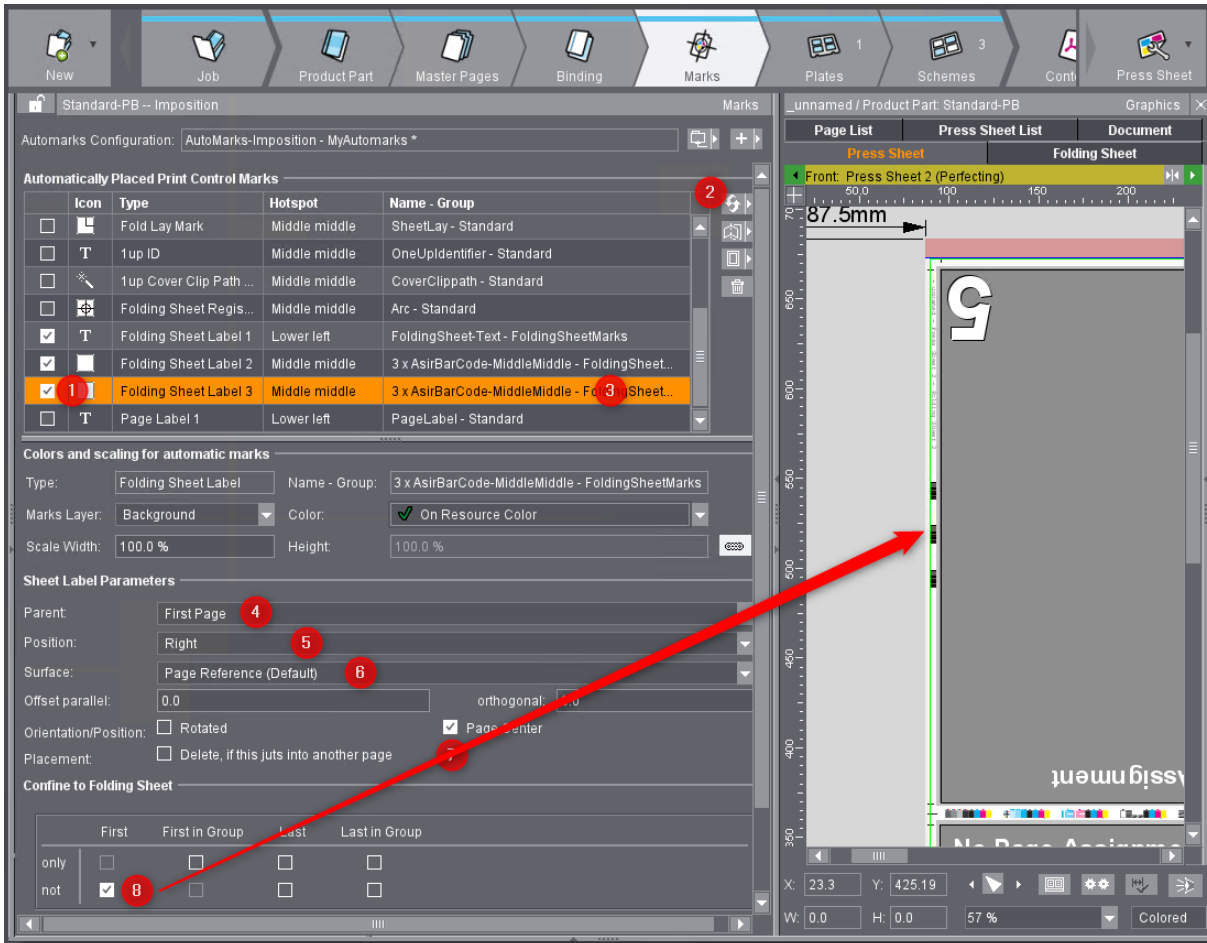
Result: Only on the first folding sheet we want to have a ASIR bar code inside the routing margin of the inner pages (back sheet).



3 Automarks

3. A "Asir" bar code mark for all inner folding sheets.

Result: A "Asir" bar code mark for inner folding sheets only, on the right side of the first page (front).

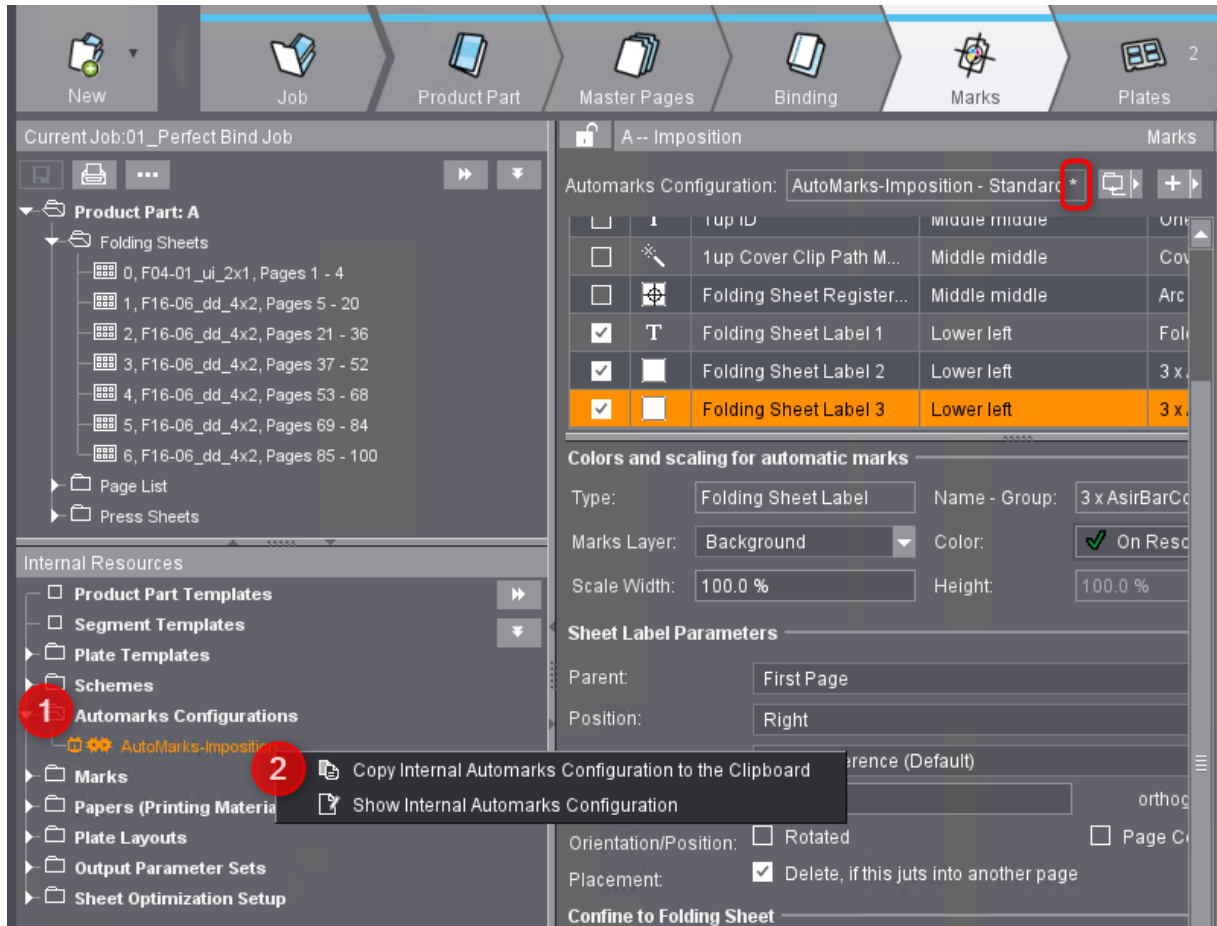


Now we want to save this complex "Automarks Configuration".

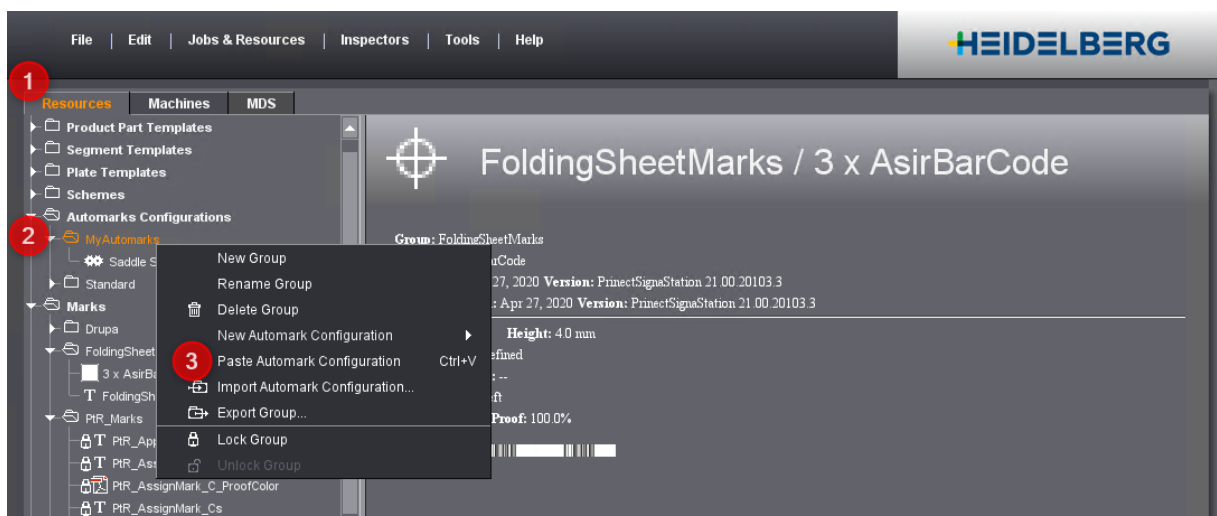


Note: A changed "Automarks Configuration" is displayed with a "*".

We copy the actual "Automarks Configuration" from the "Internal Resources" of the job...

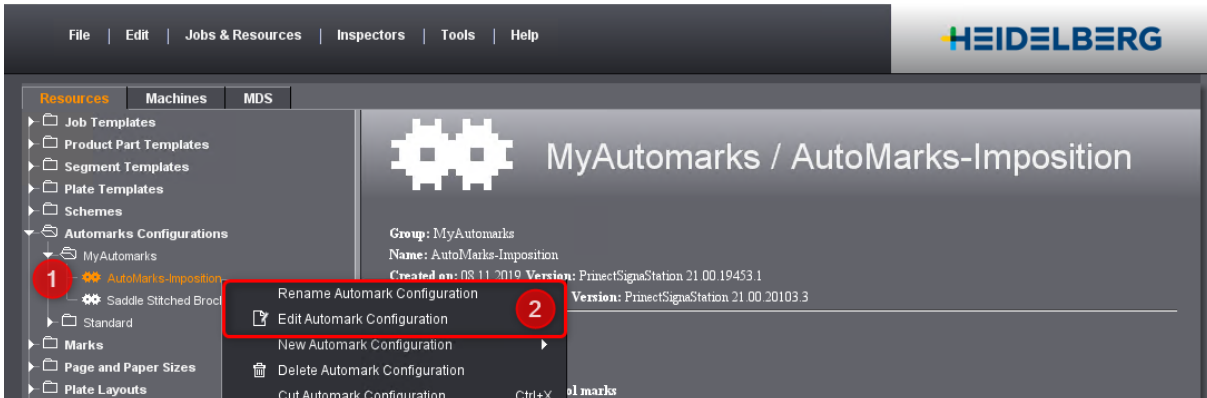


... and paste it into a folder of the "Resources > Automarks Configurations".



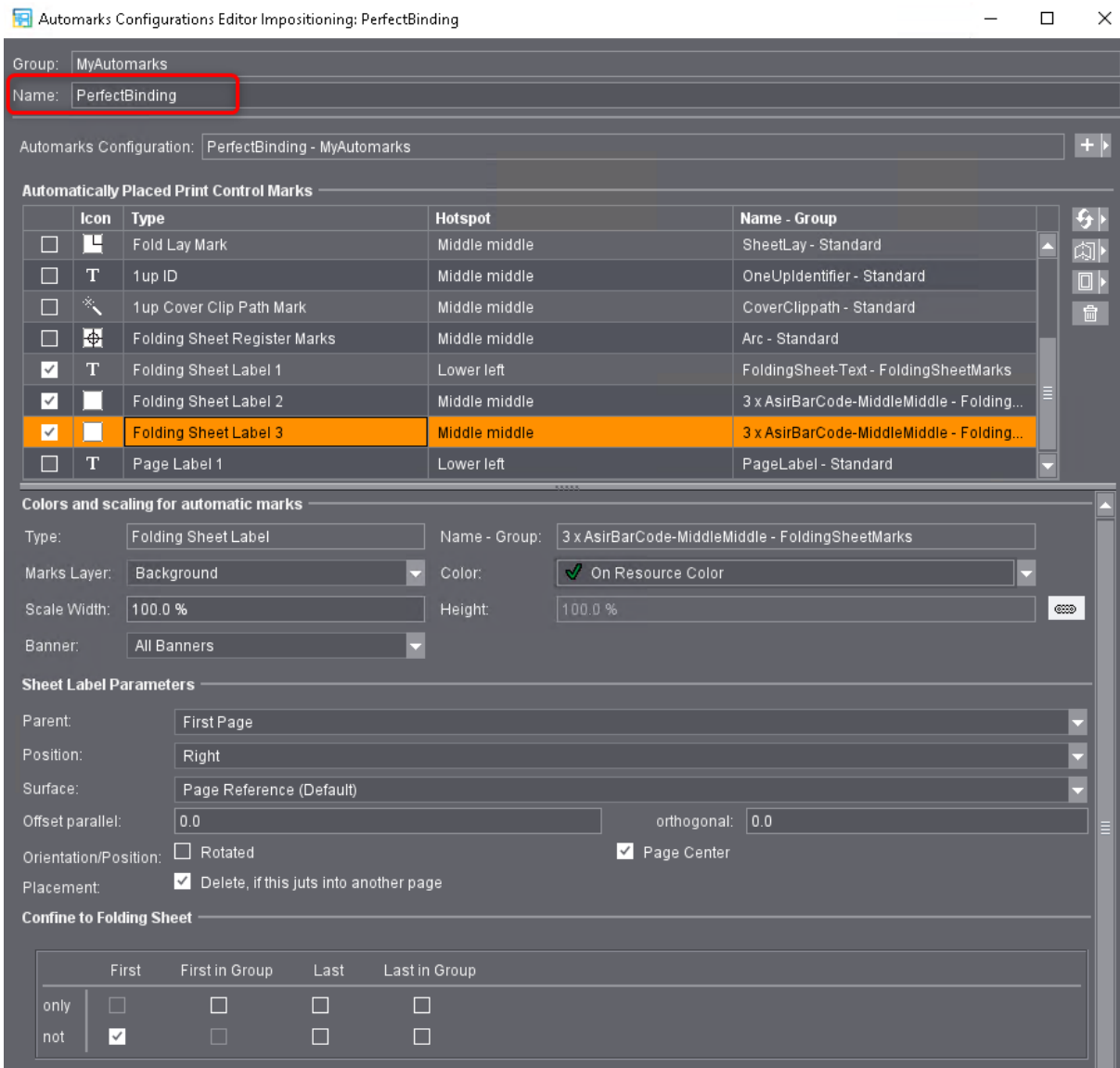
3 Automarks

We can rename the configuration in the context menu or...



... inside the "Automarks Configuration".

Result: All our job dependent settings are saved in this configuration.



3.3.3 Load an "Automarks Configuration" into a Job

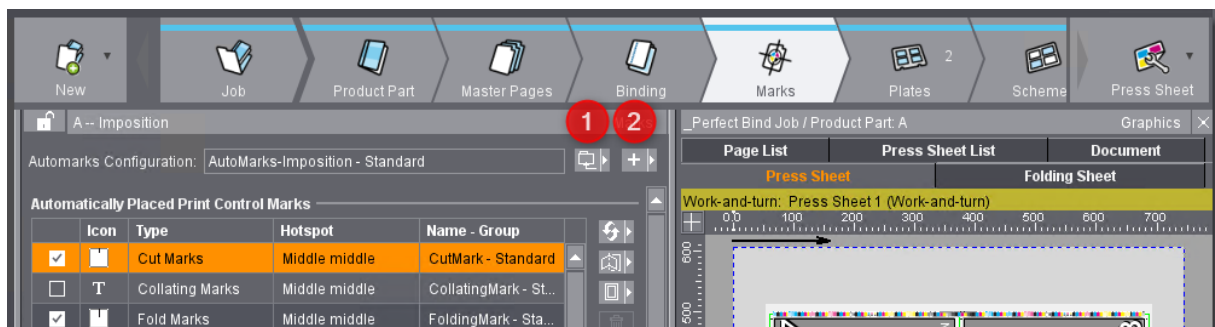
Motivation

It should be possible to load a saved mark set.

Description

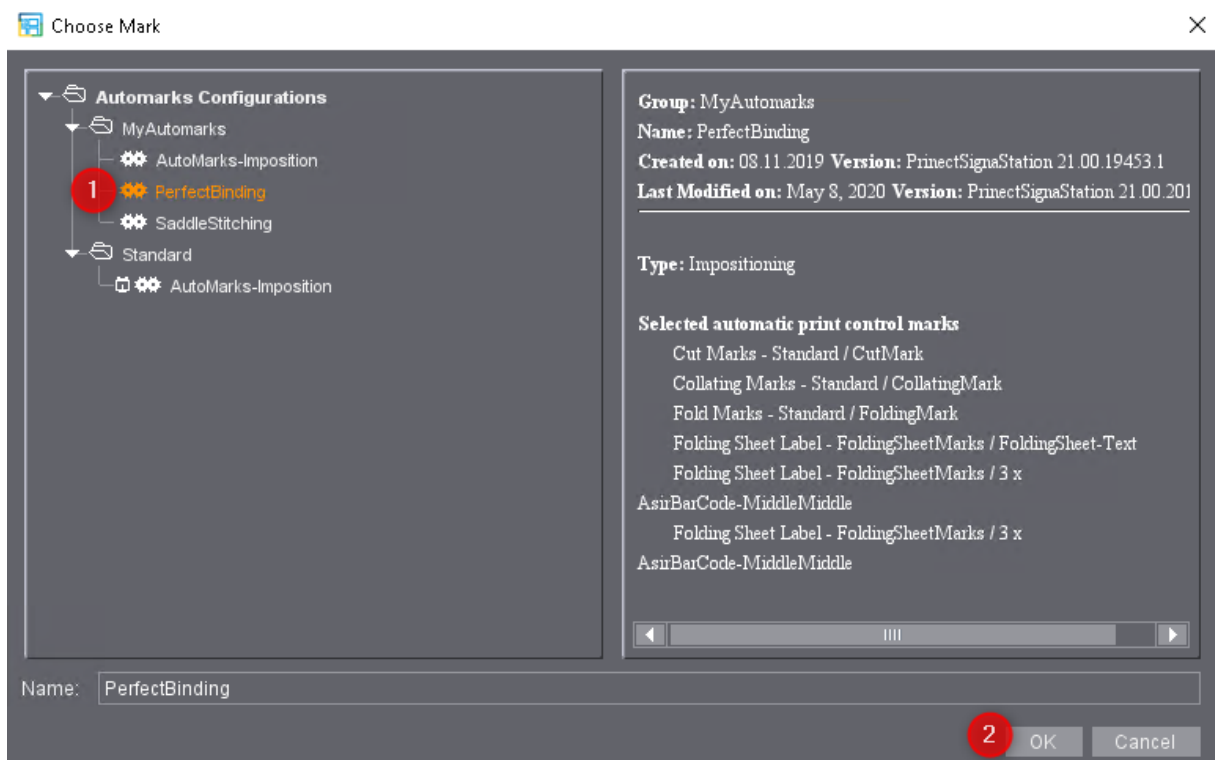
We have two options to load an "Automarks Configuration":

1. Load an "Automarks Configuration"
2. Add different "Automarks Configurations" with different "Rules" - **next chapter**



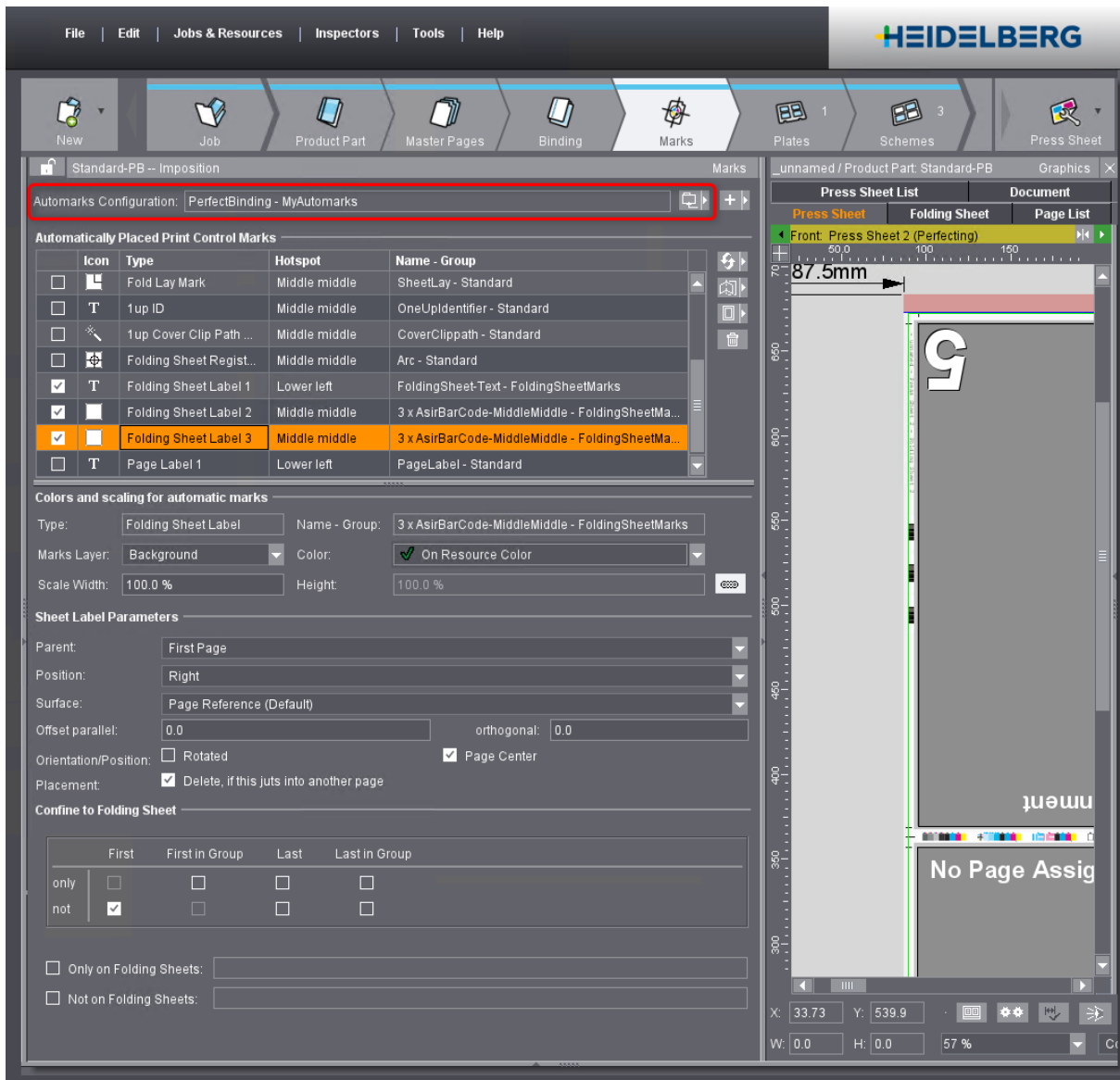
Load an "Automarks Configuration" (1) opens the resources of "Automarks Configuration".

Here we can load ONE "Automarks Configuration" for the whole layout.



3 Automarks

After loading the "Automarks Configuration" we have automatically the same result as described in chapter 3.3.2.



3.4 "Rules" for "Automarks Configurations"

Motivation

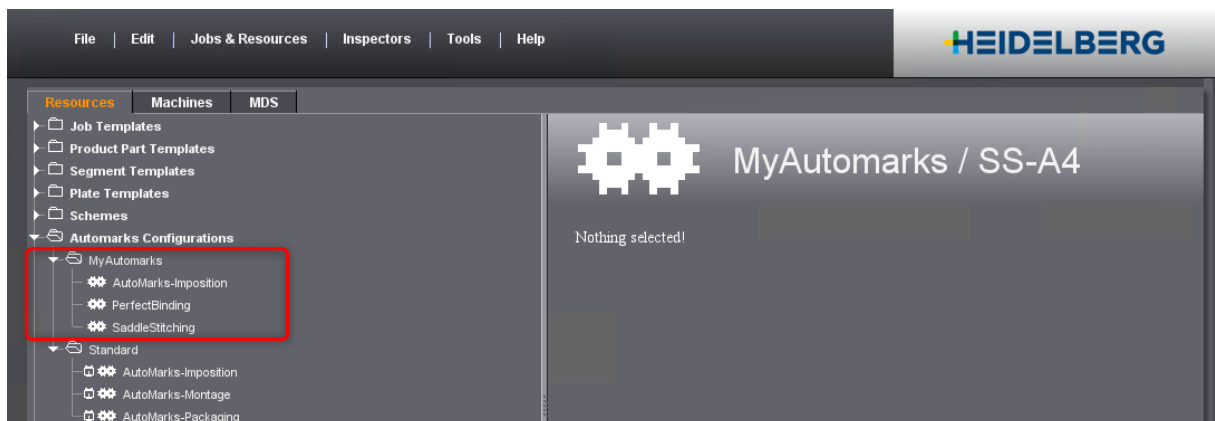
We want to configure a set of different marks configurations for the "Preferences". The Signa Server should automatically take the right mark set for the current product.

3.4.1 Create a "Automarks Configuration with Rules" in "Resources"

Description

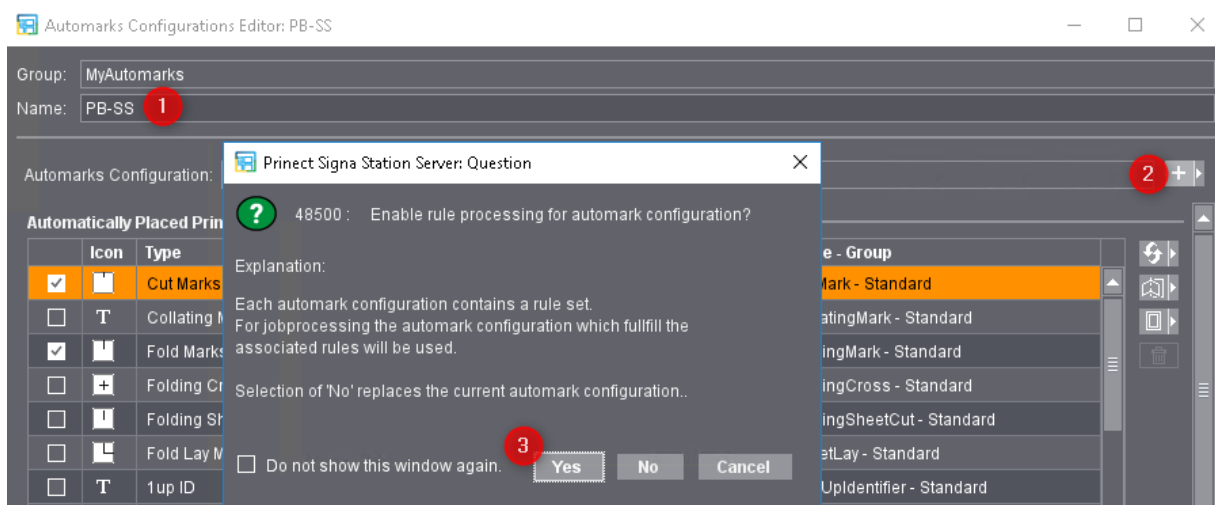
In this example we have 3 Automarks Configurations without rules:

1. Automarks-Imposition - a copy from the "Standard" folder for cut and fold marks only
2. PerfectBinding - the configured mark set of the last chapter
3. SaddleStitching - a complex Automarks Configuration for saddle stitched brochures



We will now combine these 3 mark sets to an Automarks Configuration with rules.

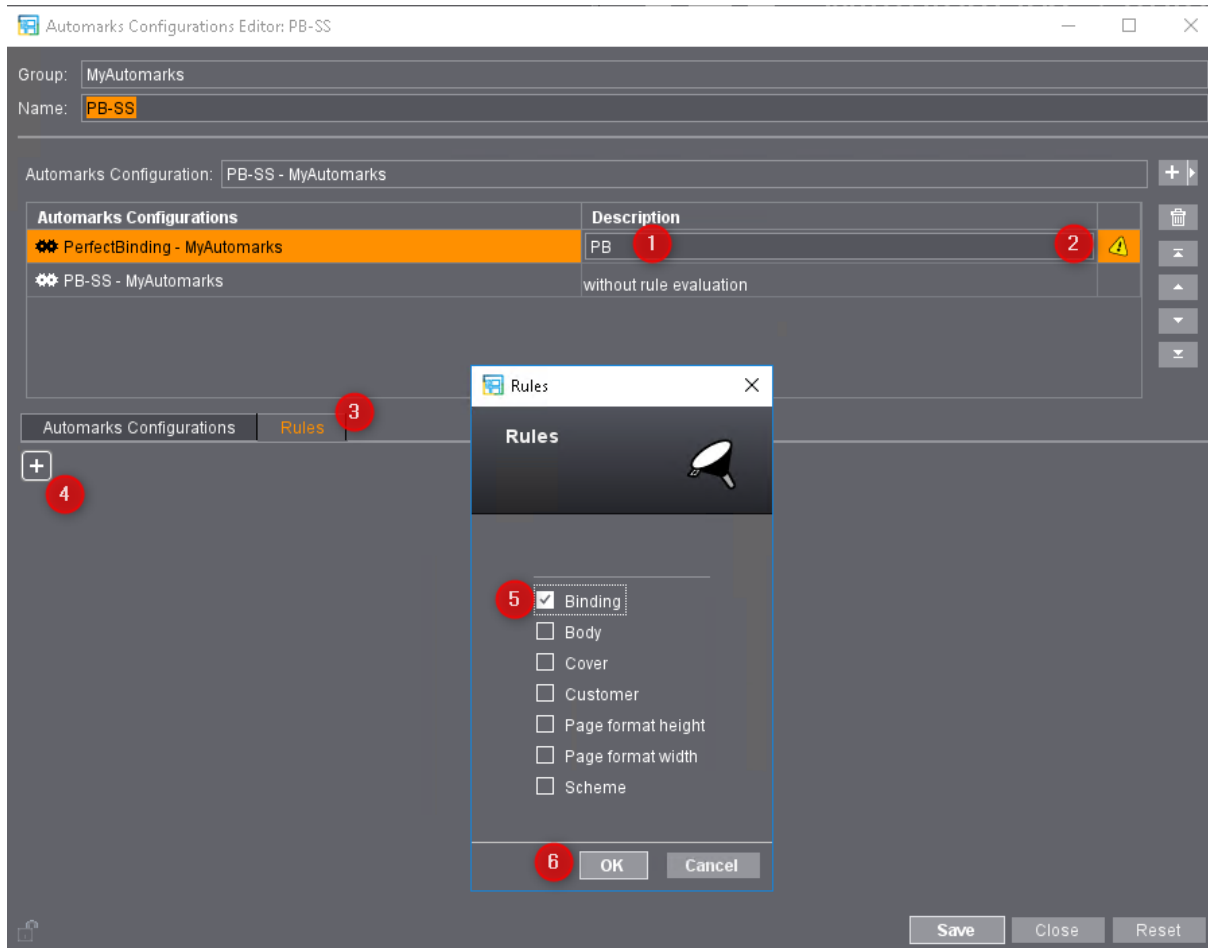
We open the default mark set "Automarks-Imposition", define a new name and add a mark set from the resources.



3 Automarks

We have to define a rule now:

1. We can define a "Description"
2. The warning displays that no rule is configured
3. We change to the rule tab
4. Add a rule
5. Select the rule "Binding"



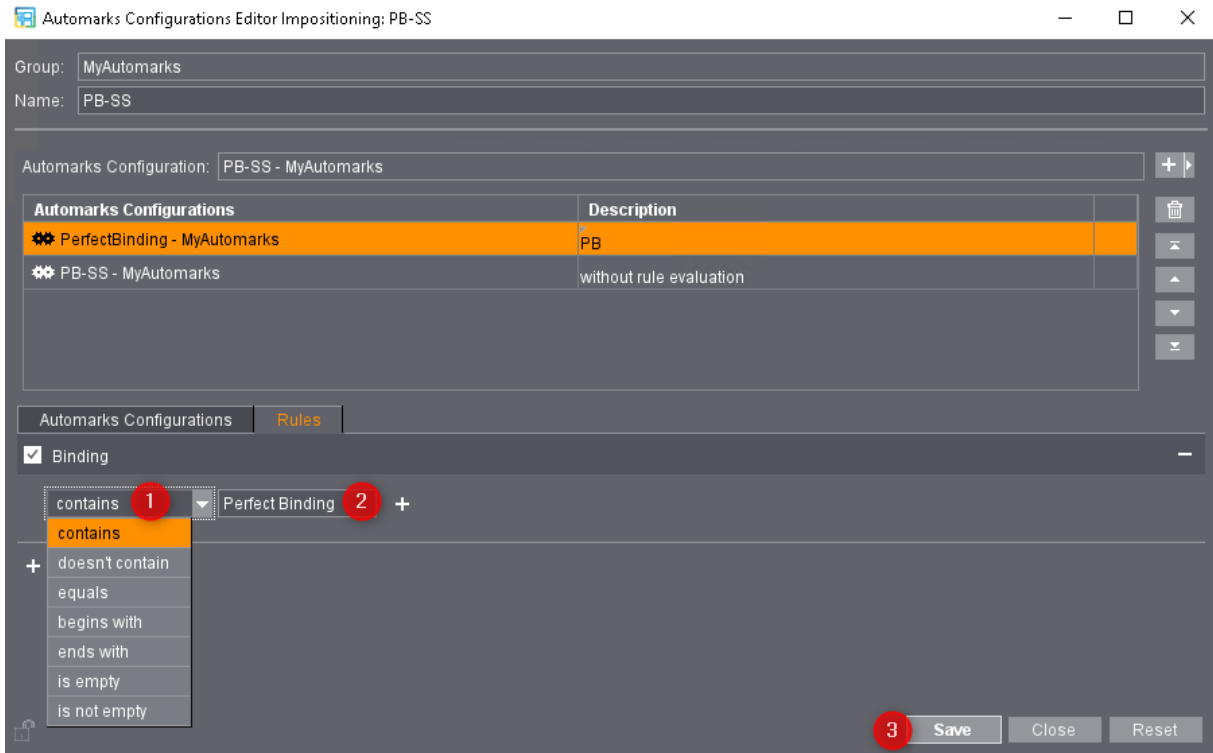
Signa Station Rule Parameters

- **Binding** - the "Binding Method" that we get displayed in the job workflow step "Binding"
- **Body & Cover** - in use when we enable "First Folding Sheet is Cover" in "Binding"
- **Customer** - we can configure different mark sets for different customers (finishing supplier)
- **Page format height & width** - we should always try to place marks independent of format
- **Scheme** - for special schemes like "PushToStop Stahlfolder" marks

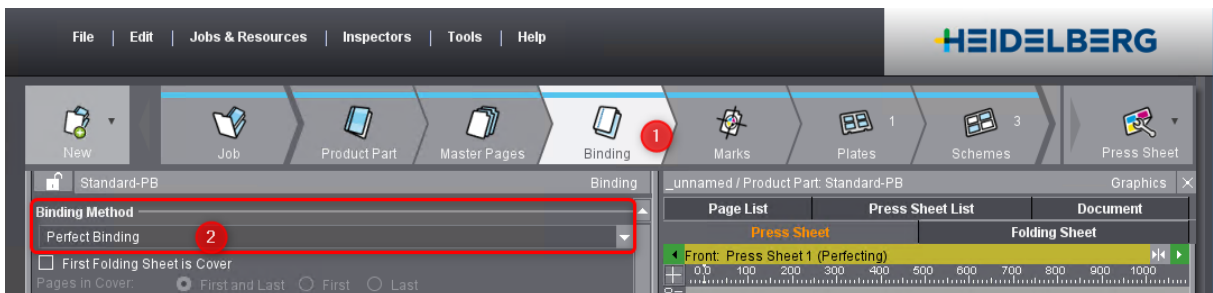


Note: We will get more rules like "Product Part", "Product Code"...

We add a rule for "Binding".

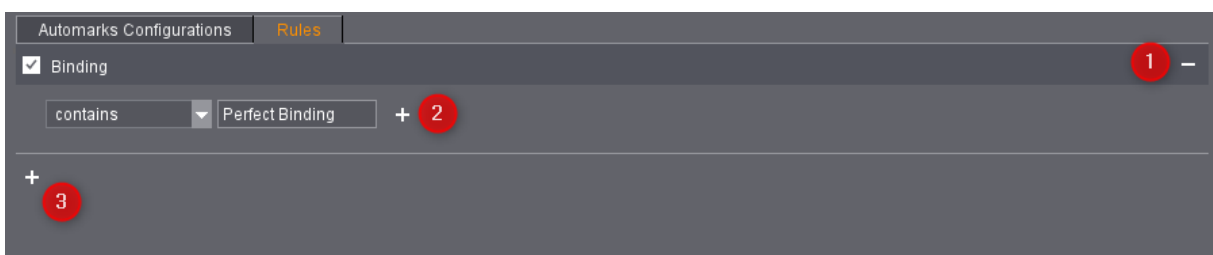


Note: The "Binding Method" has to be the same as displayed in Signa Station:



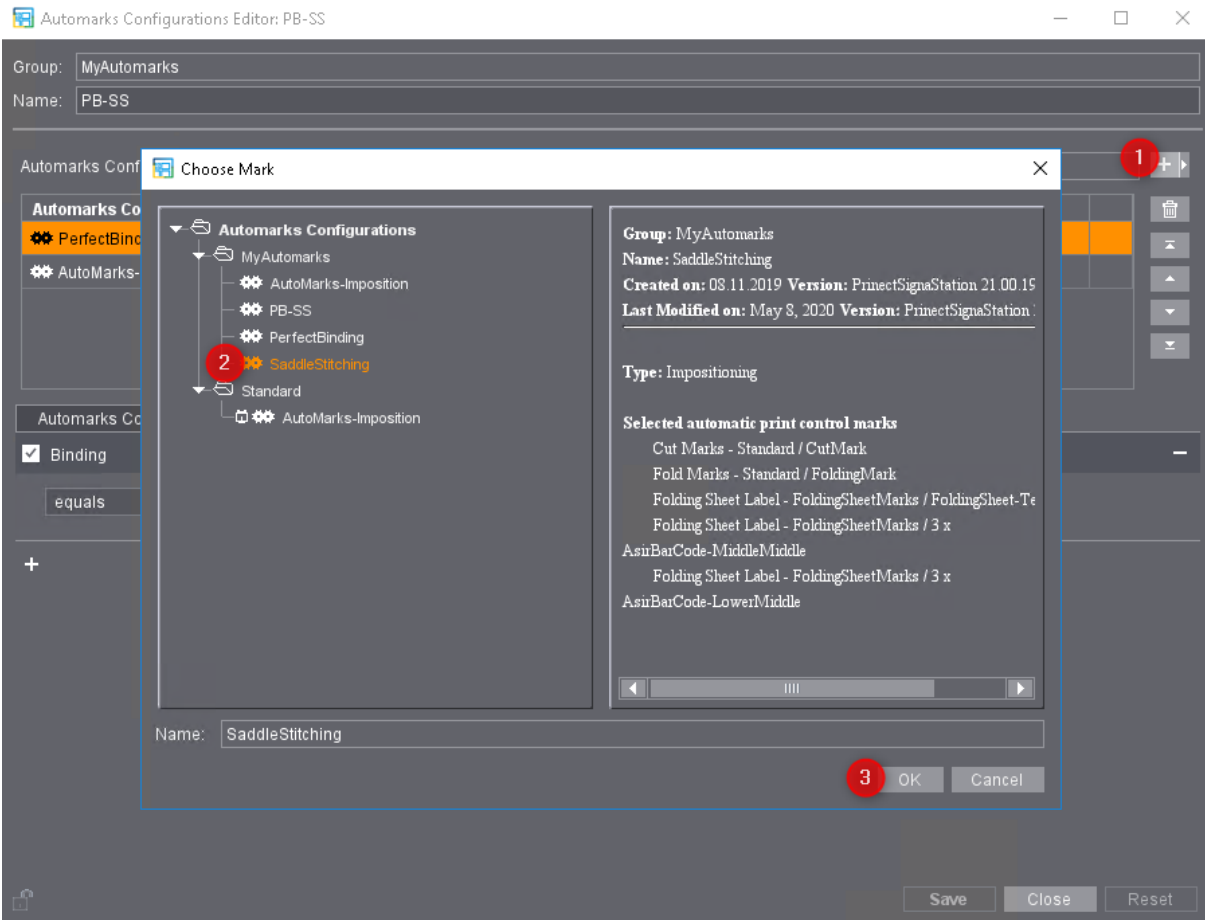
In the "Rules" dialog we can:

1. Delete the displayed rule
2. Create an "OR" relationship - Example: OR "Binding Method" "Sewn"
3. Add another rule

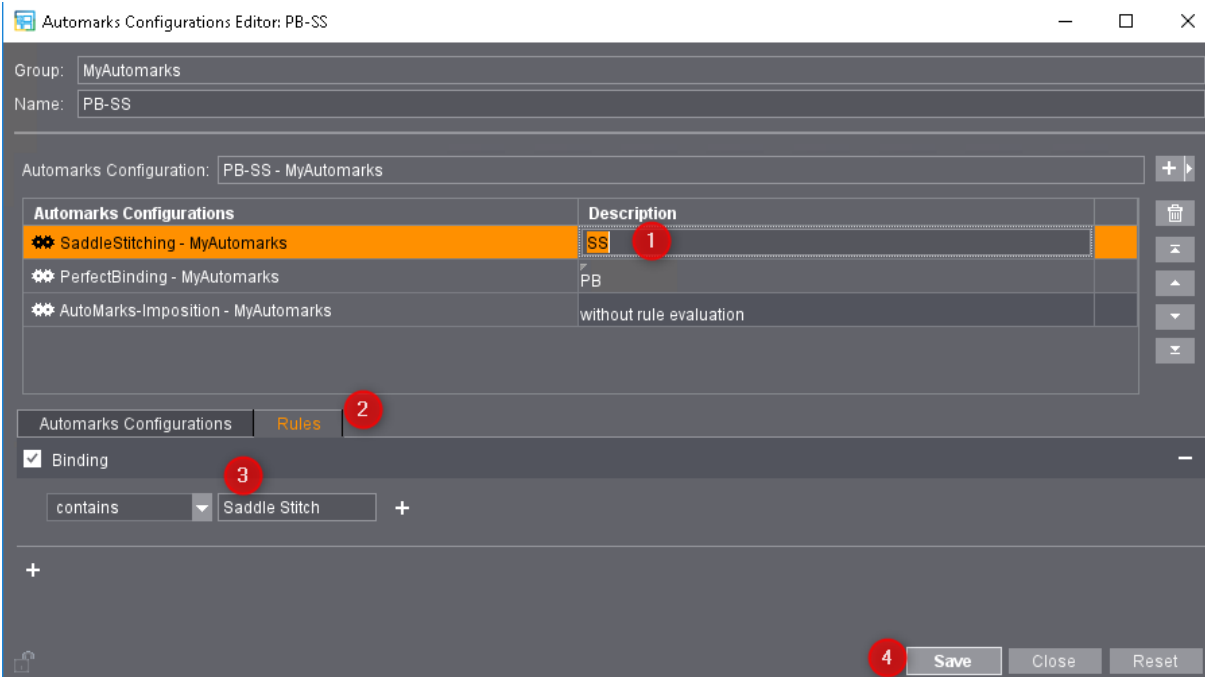


3 Automarks

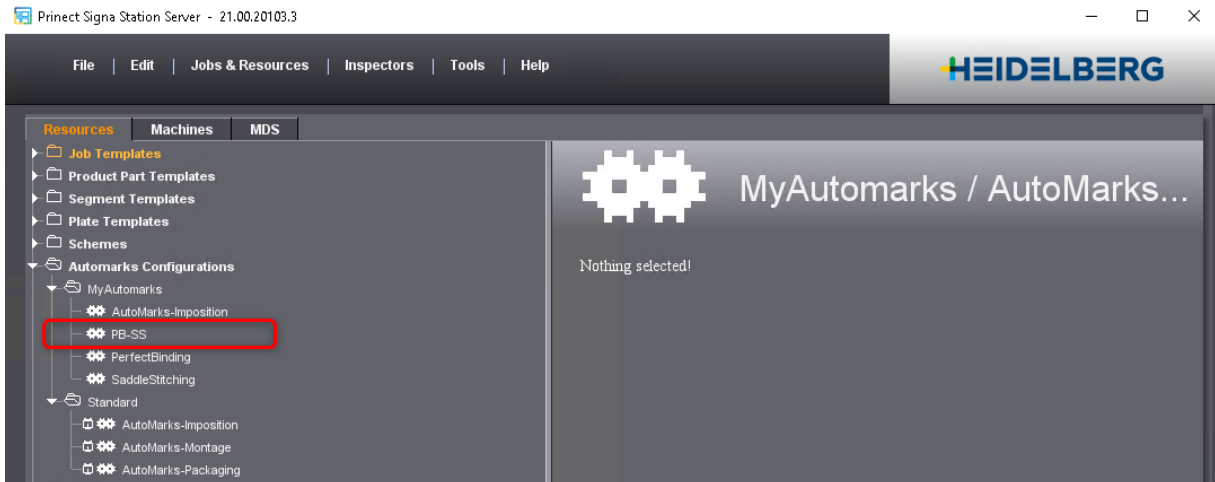
Now we add a second "Marks Configuration" set for saddle stitched brochure.



We define the "Marks Configuration" description and add a rule for binding "Saddle Stitch".



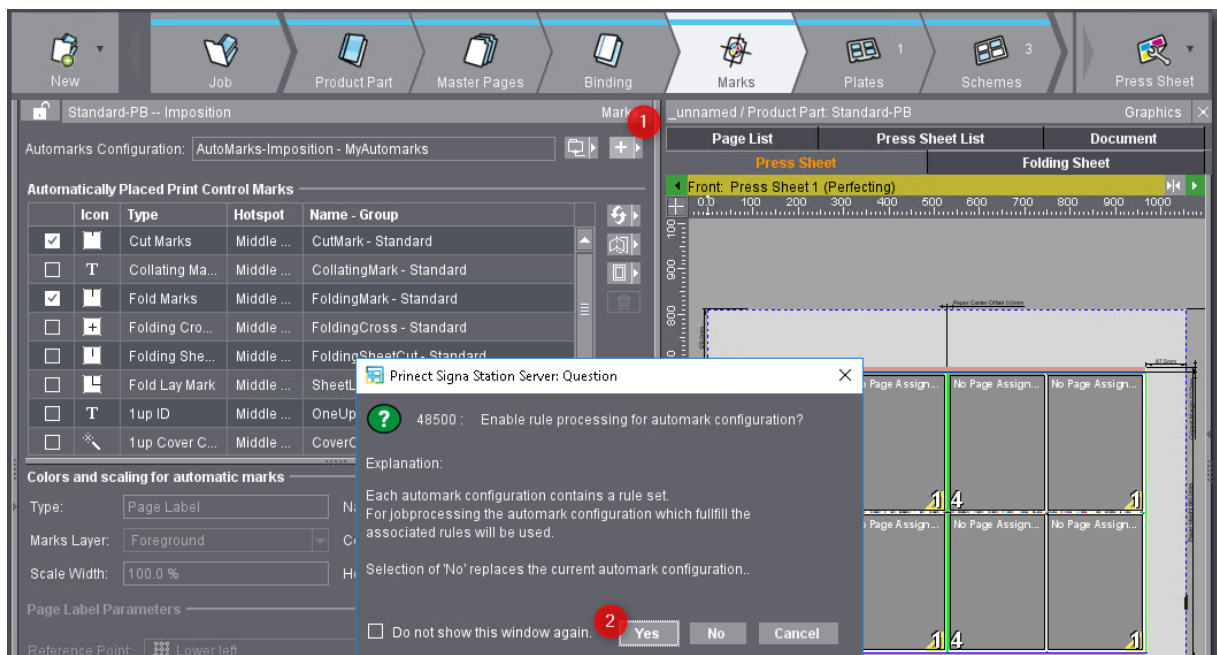
Result: We now have a combined "Automarks Configuration with Rules".



3.4.2 Create an "Automarks Configuration with Rules" in a Job

We can also create an "Automarks Configuration with Rules" from a Job, when we load a second mark set into a job.

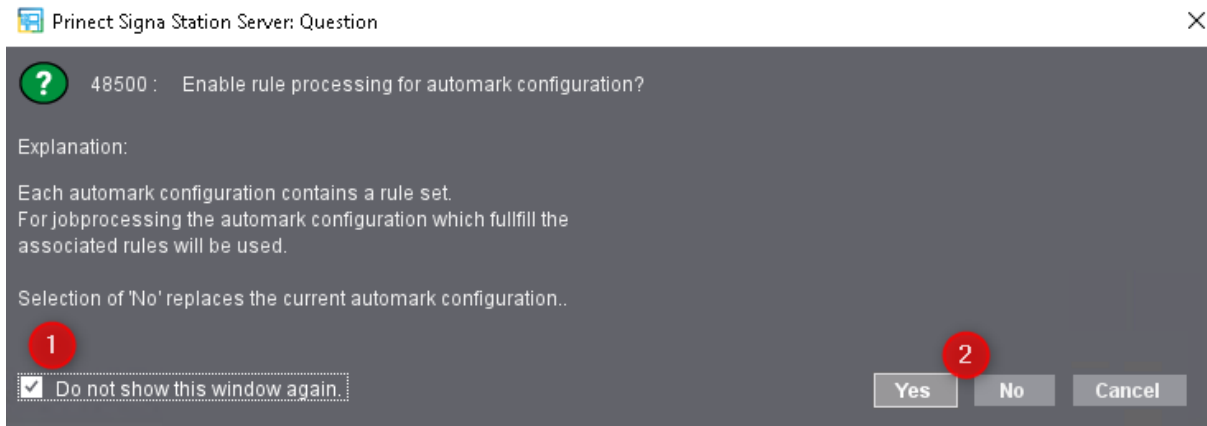
The same dialog pop's up, when we add a second mark set.



3 Automarks

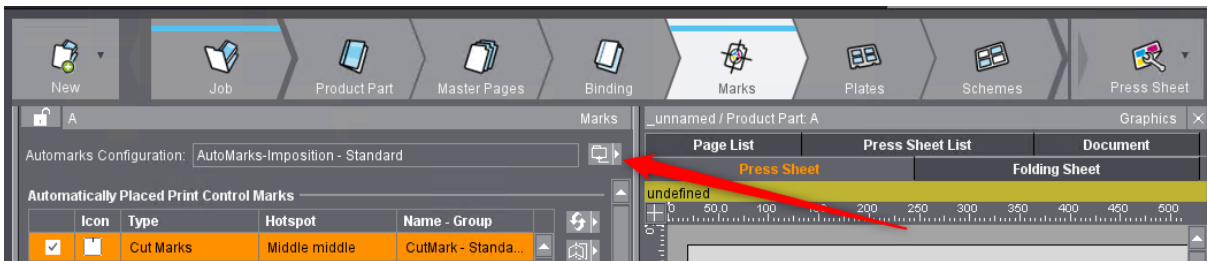


Attention: When we enable "Do not show this window again"...



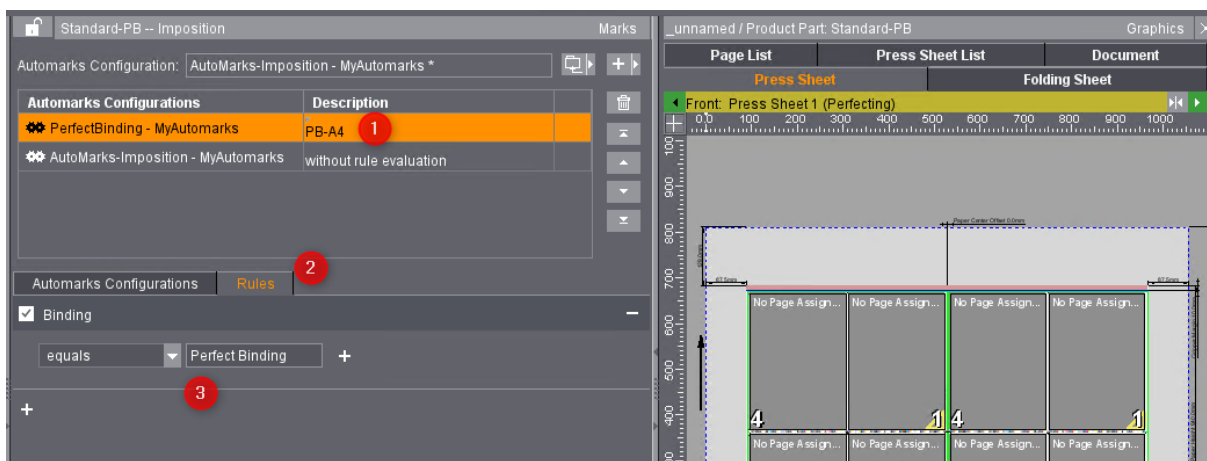
... the Signa Station will hide the "+" button for the next new signature.

This feature was implemented to hide this "+" button, because customers could be confused about this new feature.



Note: We can enable the "+" button display again in Signa Station "Preferences > General > Suppressed Messages".

In chapter **"3.3.2 Create a new "Automarks Configuration" from Job"** we can read how to save a job mark resource (Copy & paste of the internal job marks resources into the Signa Station Resources and rename it).



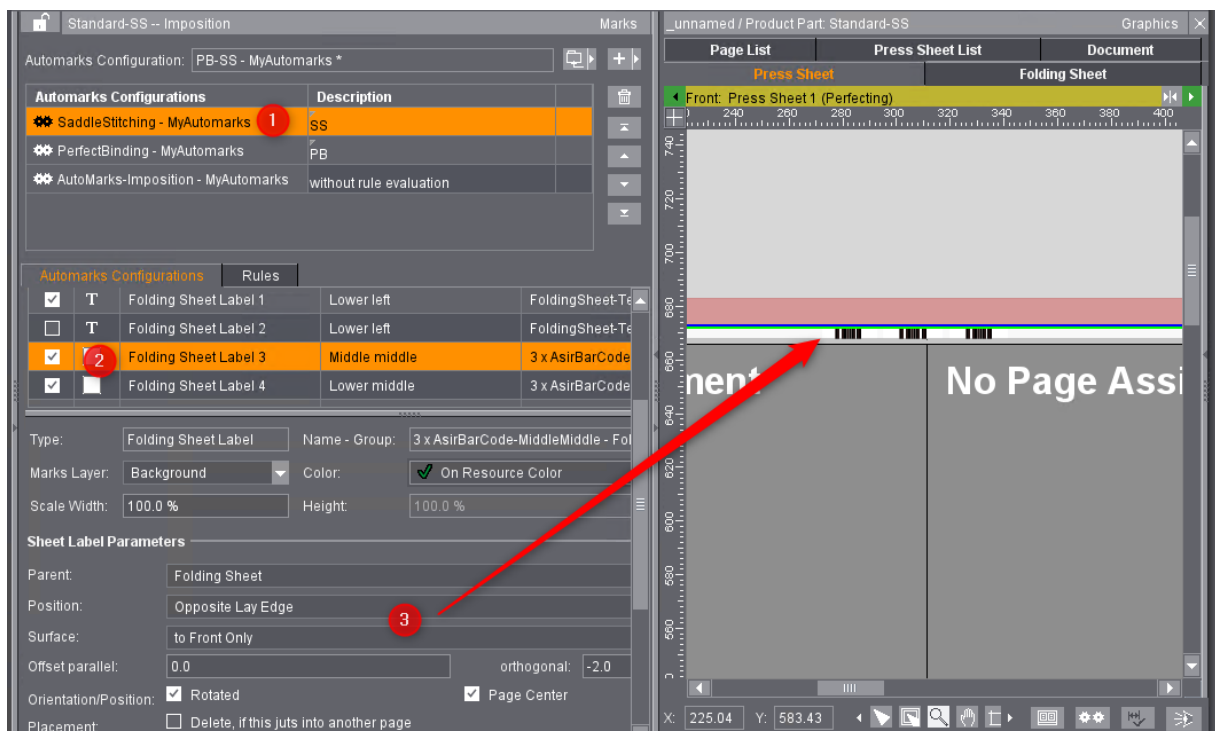
3.4.3 Load an "Automarks Configuration with Rules" manually into a Job

Now we create a saddle stitched brochure in Signa Station and load a "Automarks Configuration" with different rules. After loading such a marks configuration...



... all combined "Automarks Configurations" are displayed in the job.

In this example only the first mark set AND the third mark set is in use, because the rule "Perfect Binding" is not in use.



In a gang job it can happen that different mark sets for different jobs are in use.

3 Automarks

3.4.4 Load an "Automarks Configuration with Rules" automatically into a Job

Motivation

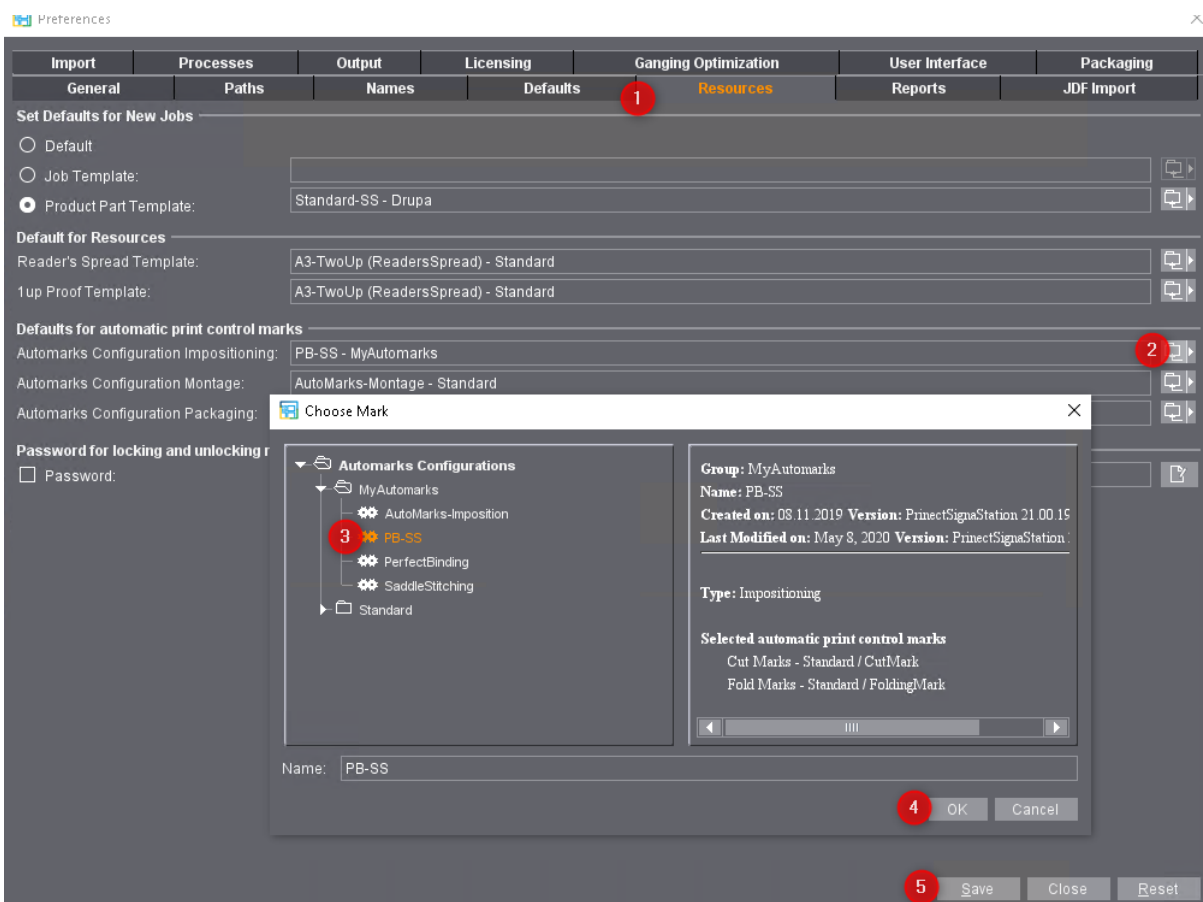
We want to use an "Automarks Configuration with Rules" automatically in the workflow.

Description

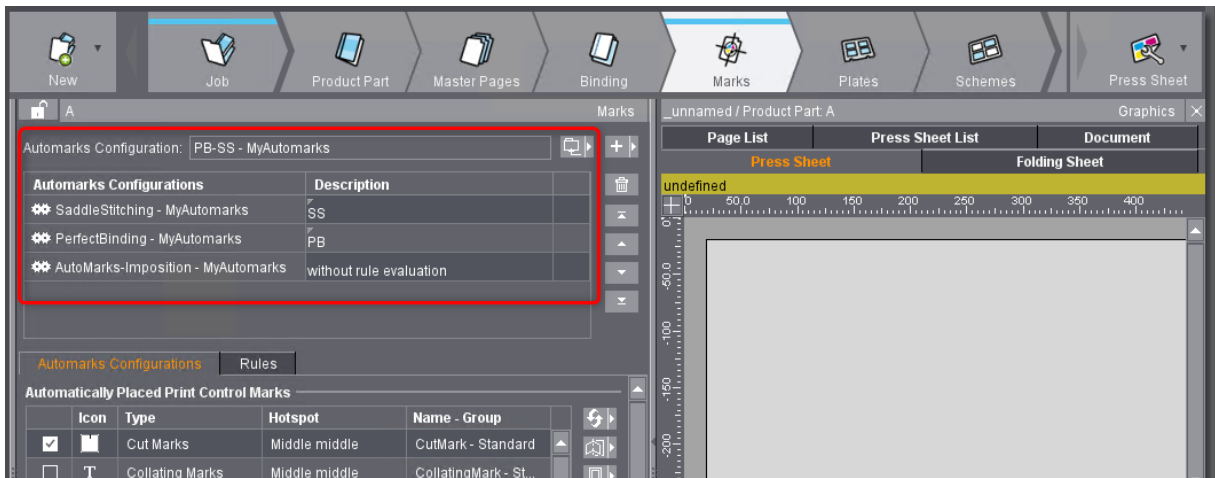
We can define the "Automarks Configuration with Rules" in the "Preferences" to use it for a:

1. New layout generation in Signa Station
2. Automatically generated layouts from Signa Server for job import via W2p, CSV, JDF, XJDF or JASON.

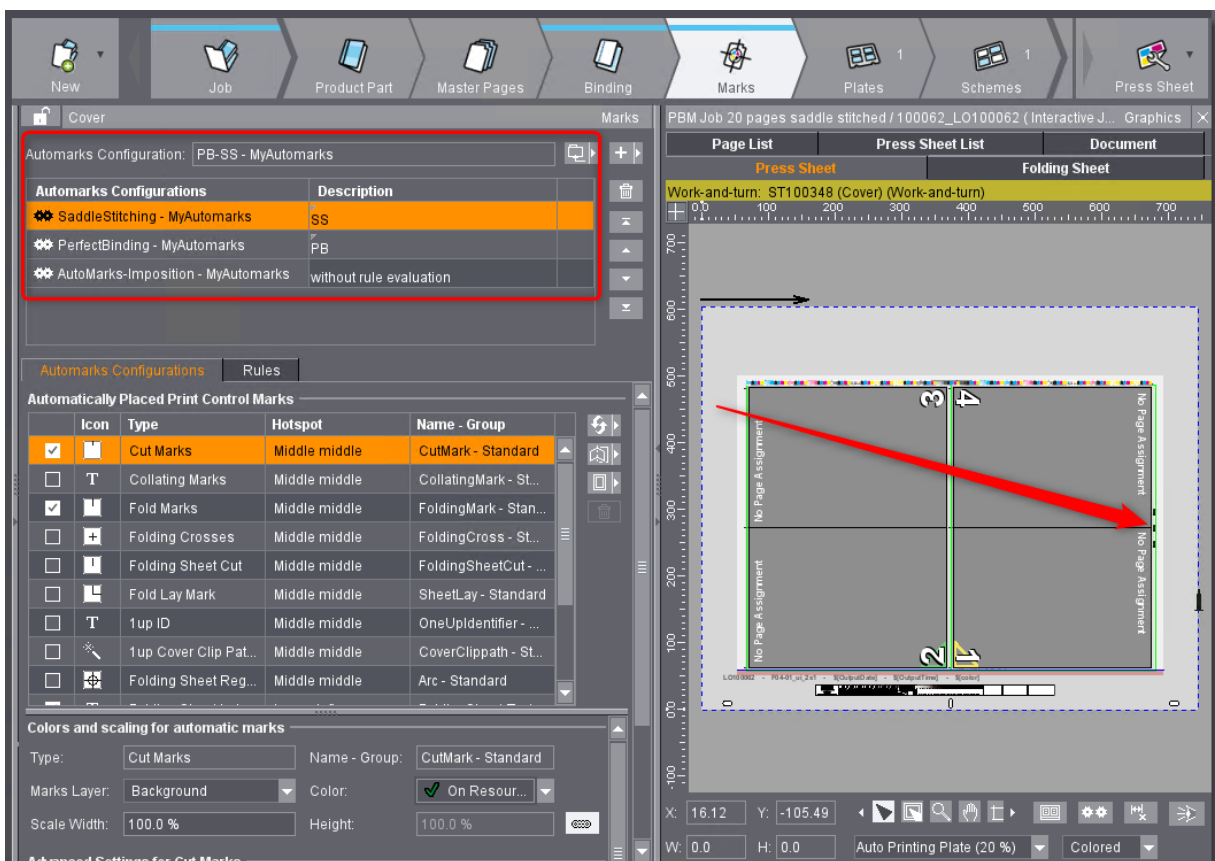
At first we have to define an "Automarks Configuration with Rules" in the Signa Station Preferences.



1. When we create a new layout in Signa Station manually we automatically have the defined Automarks Configuration preassigned for this job.



2. The same would happen, when the Signa Server would create a layout from a MIS-JDF.



3 Automarks

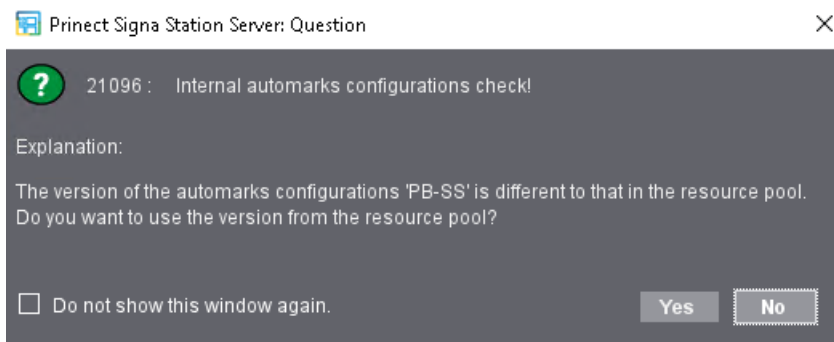
3.5 Alignment of Job Internal Resources

Motivation

We have to compare job internal marks resources with the actual marks resources.

Description

When opening a job, the internally used "Automarks Configuration" will be compared with the actual marks resources. If a difference is detected, the user has the option to keep the job resources or to use the actual Signa Station resources.



In Princt 2021.10 we plan to implement much more Marks Configuration features:

- Save button - for Marks Configuration in the job tab "Marks"
- Show Automarks - display of marks of a Marks Configuration in the Graphic view
- Further filter criteria:
 - MIS Product Parts
 - Product Code
- Further positions
 - Spine - inner and outer
 - Gripper fold rear - inner and outer
 - Gripper fold front - inner and outer
- Press sheet label
- ...

4 Imposition Automation

4.1 New Attribute "Automatic Gap Computation"

Motivation

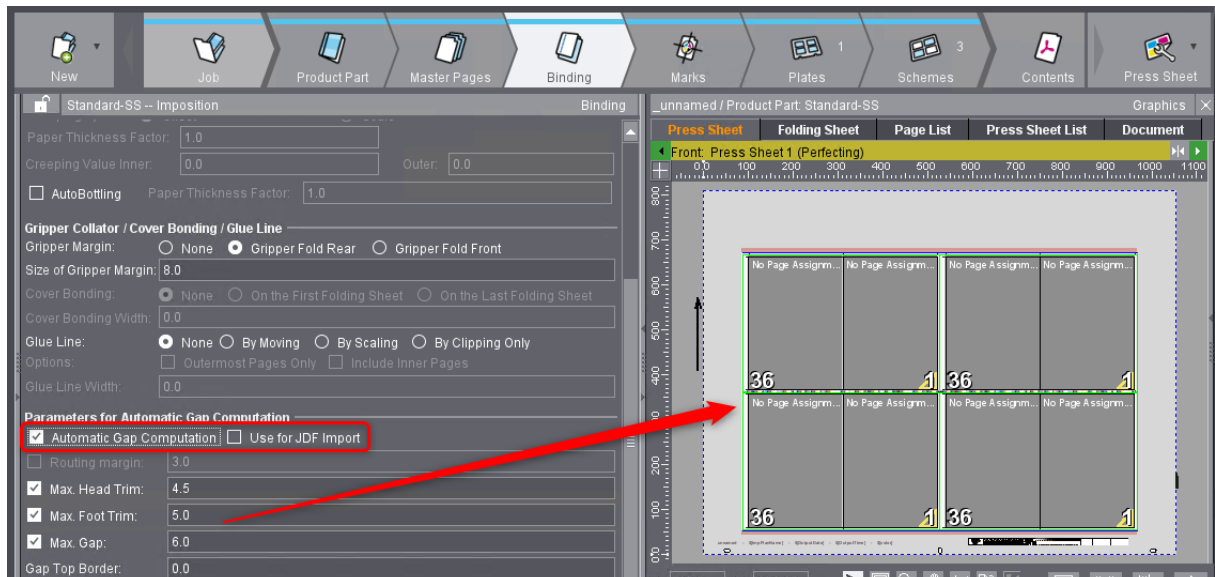
In the work mode "Imposition" and "Automatic Imposition", gaps can be created in the workflow step "Scheme" by clicking on the button "Automatic gaps".

It would be nice to activate this action automatically for jobs and product part templates.

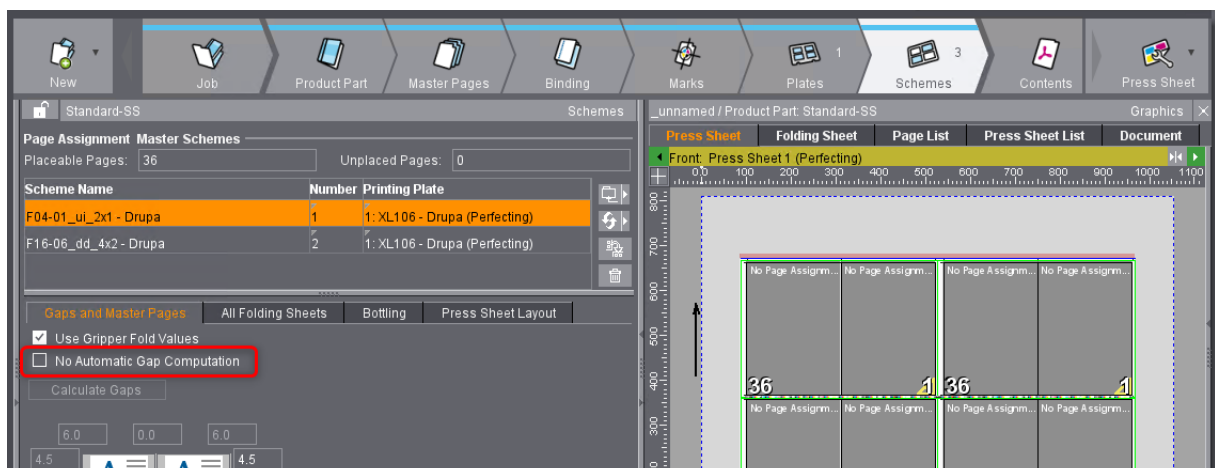
Description

In the workflow step "Binding", there is now a new check box "Automatic Gap Computation".

Signa Station calculates automatically all gaps for every sheet. "Use for JDF Import" can be enabled for "Signa Product Part Templates" referenced by "MIS Product Codes".



We can ignore or apply this individually for special folding schemes in the workflow step "Schemes".



4 Imposition Automation

4.2 "Max. Foot Trim" for "Automatic Gap Computation"

2020.10

Note: This feature was implemented in Signa Station 2020.10.

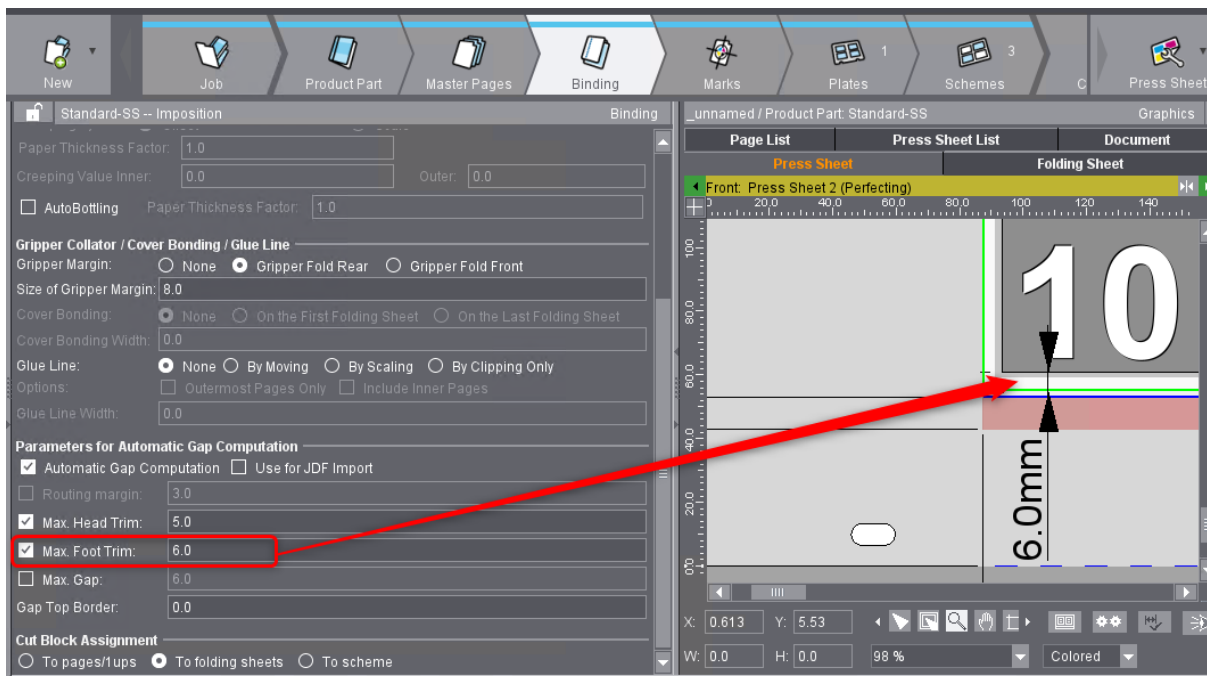
Motivation

We do not have a foot trim definition, but this is necessary when customers wants

- to place folding sheet labels at the foot
- run multiple 1ups in postpress so close as possible defined by head and foot trim

Description

We can now define a "Max. Foot Trim" in the tab "Binding" and in "Preferences > Defaults".



4.3 JDFs without Cover Information

2020.10

Note: This feature was implemented in Signa Station 2020.10.

Motivation

We can reference "Signa Product Part Templates" by "Product Codes". When a MIS job with the same product code comes into the Prinect system the Signa Server will use this product part template to create the layout.



Note: The Signa product part template must use the same folding schemes as the incoming MIS-JDF.

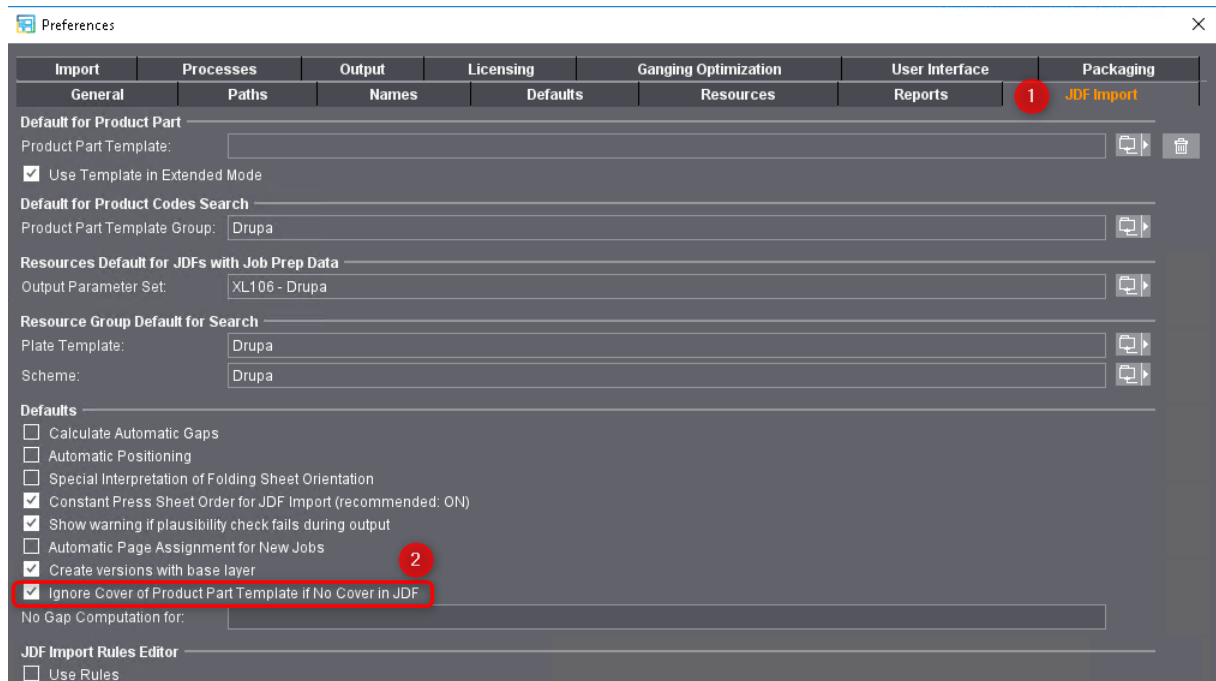
Until Prinect version 2020.10 we needed two different product part templates, because MIS Brochures do not always have a cover with 4 pages at the first sheet:

1. Product part template with cover (enabled function 'First Folding Sheet is Cover')
2. Product part template without cover

Description

In the "Preferences > JDF Import" we can now "Ignore cover from Product Part Template when no cover is specified in JDF".

With this setting we need only one product part template for both cases - the first one.



Note: This setting only affects product part templates when the setting "Match Folding Sheet Count to Page Total" is activated.

4 Imposition Automation

5 Ganging in General

5.1 Gang Filter and Gang Tasks as Resources

2020.10

Note: This feature was implemented in Signa Station 2020.10.

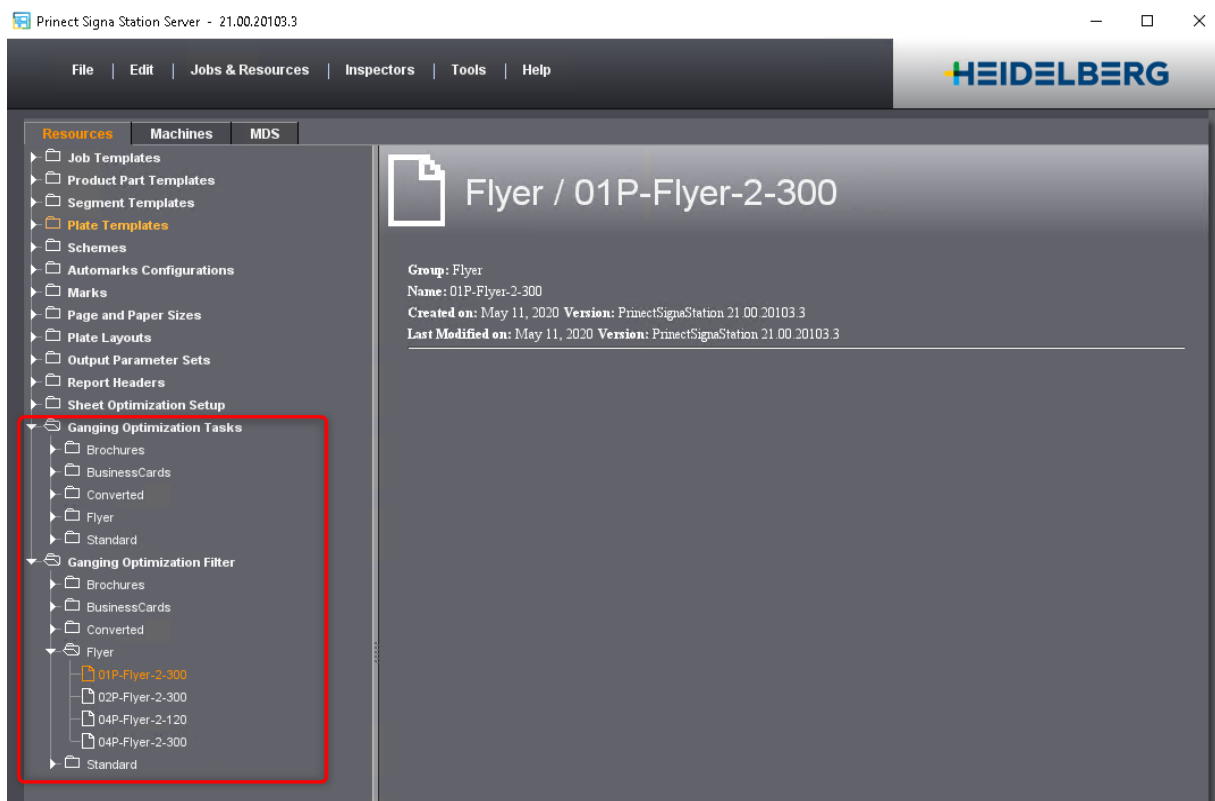
Motivation

Customers with a lot of "Gang Filters" and "Gang Tasks" wants to have a structured view to manage them.

Description

With Prinect 2021 "Gang Filters" and "Gang Tasks" are displayed in the "Resources":

- Ganging Optimization Tasks
- Ganging Optimization Filter



Note: After upgrading Signa Station existing Gang Filter and Gang Tasks of previous Signa Station versions are automatically in the folder "Converted".

5 Ganging in General

5.1.1 "Gang Optimization Filter" as Resources

Motivation

Because customers have a lot of different filters, they want to manage them centralized.

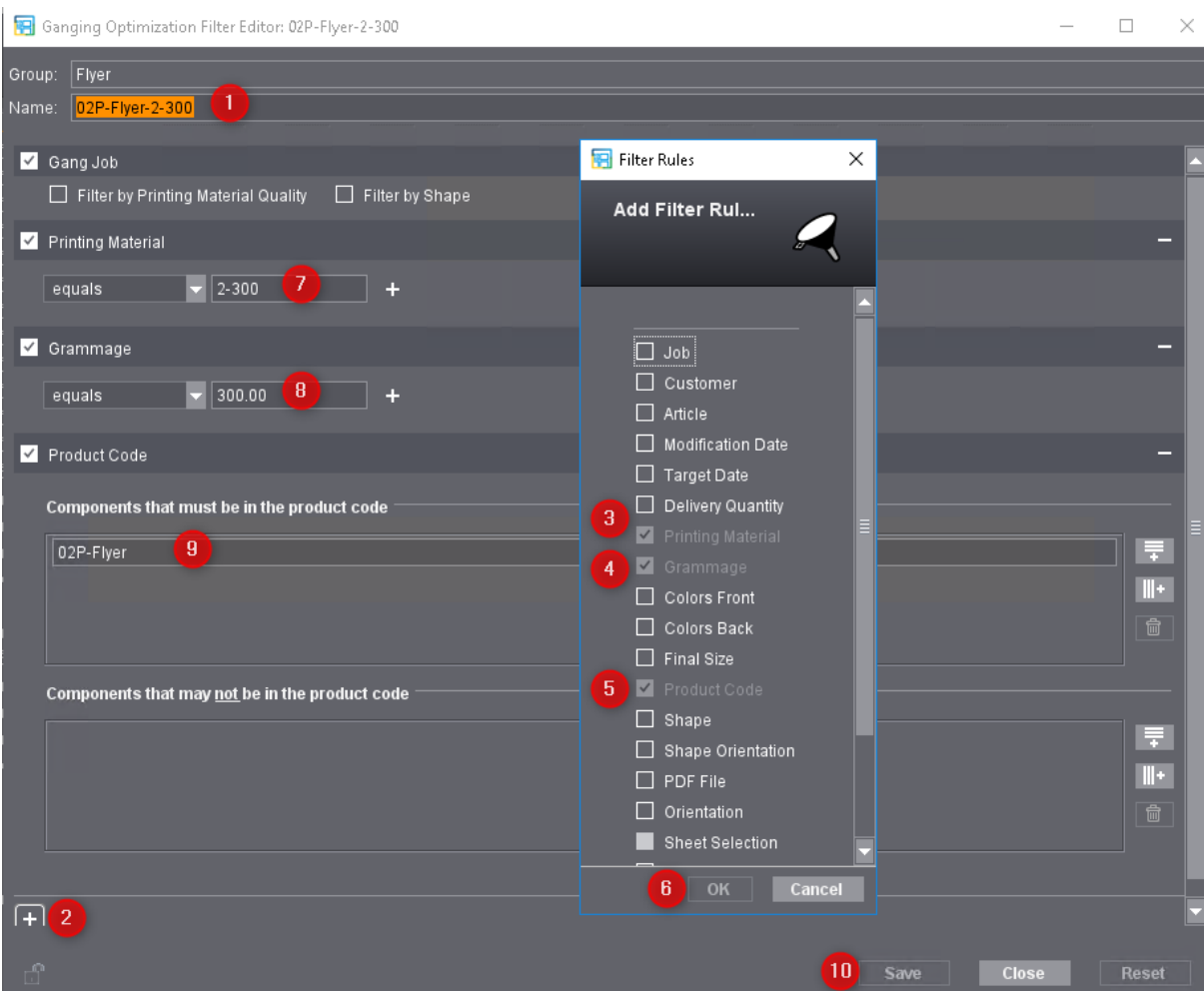
Description

Filters are to manage in the resource group "Ganging Optimization Filter".

We can create, sort in groups, copy & paste, rename, edit and lock the filter.



The filter dialog allows to create "Gang Filter" with different filter conditions like in previous versions.

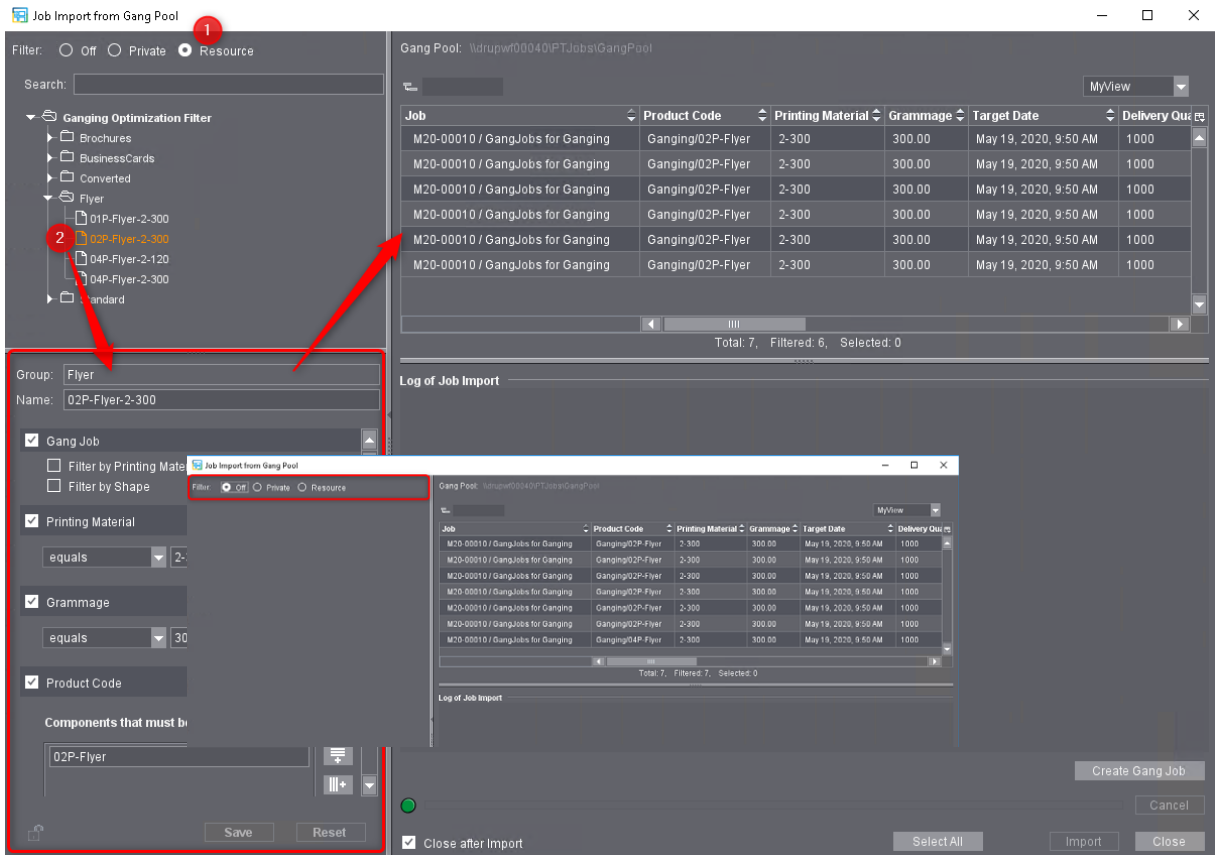


The Gang Filter can be used for:

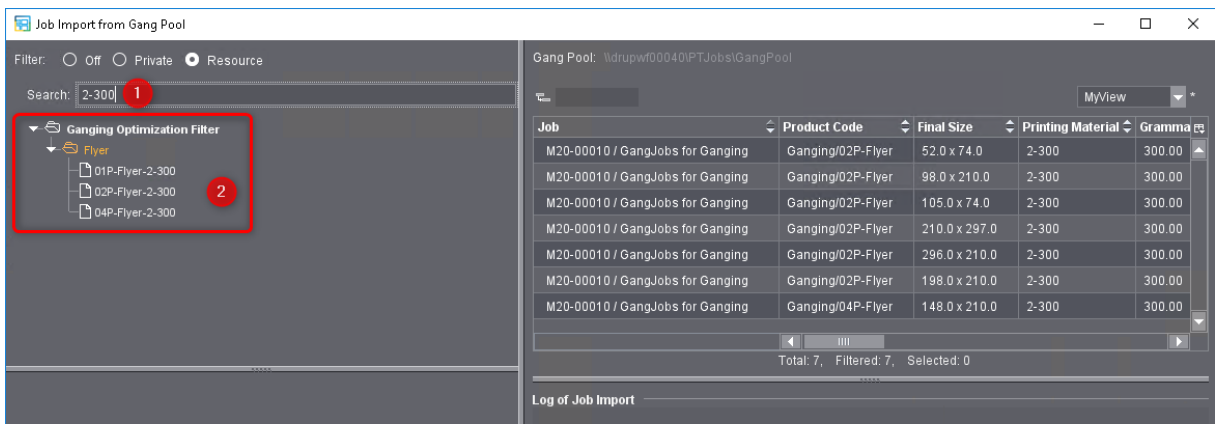
1. Automated Gang Tasks - next chapter
2. Manual "Job Import from Gang Pool"

2. Manual "Job Import from Gang Pool"

We can load the saved filter from the "Resource" pool and filter all jobs with the same criteria.



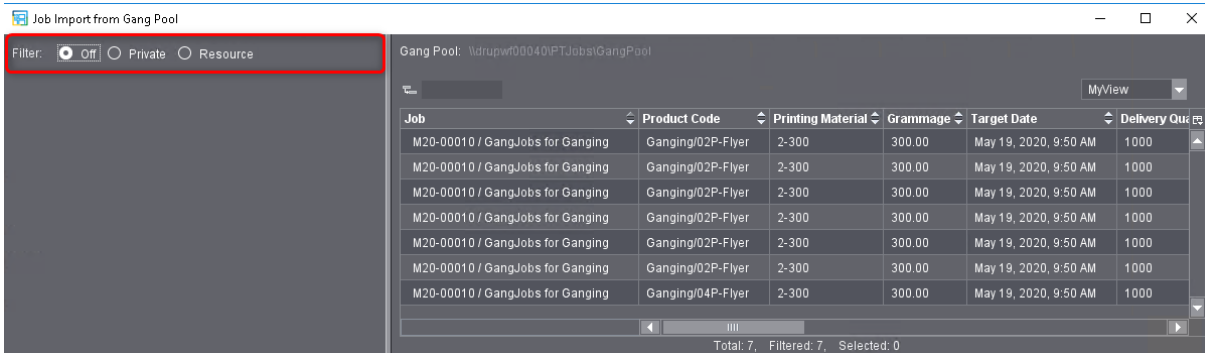
The "Search" dialog allows to find a special filter much easier.



5 Ganging in General

In the "Job Import from Gang Pool" dialog, we can switch between three options:

1. Filter "Off" - no filtering
2. Filter "Private" - the last configured filter is available on the local Signa Station computer
3. Filter "Resources" - the filter is available for all Signa Station computers, when they are using the "Global Preferences"



5.1.2 "Gang Optimization Task" as Resources

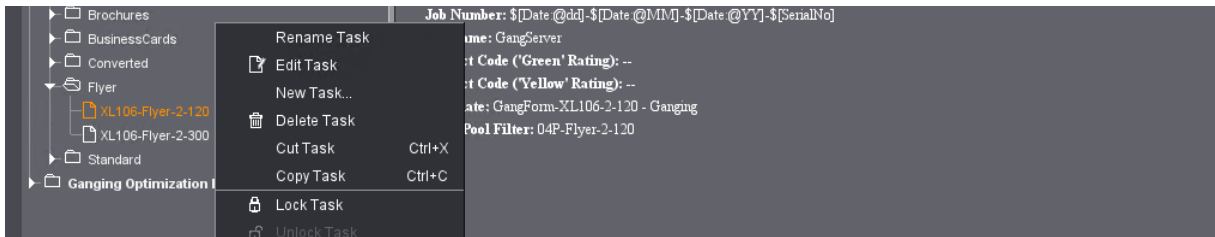
Motivation

Because customers have a lot of different tasks, they want to manage them centralized.

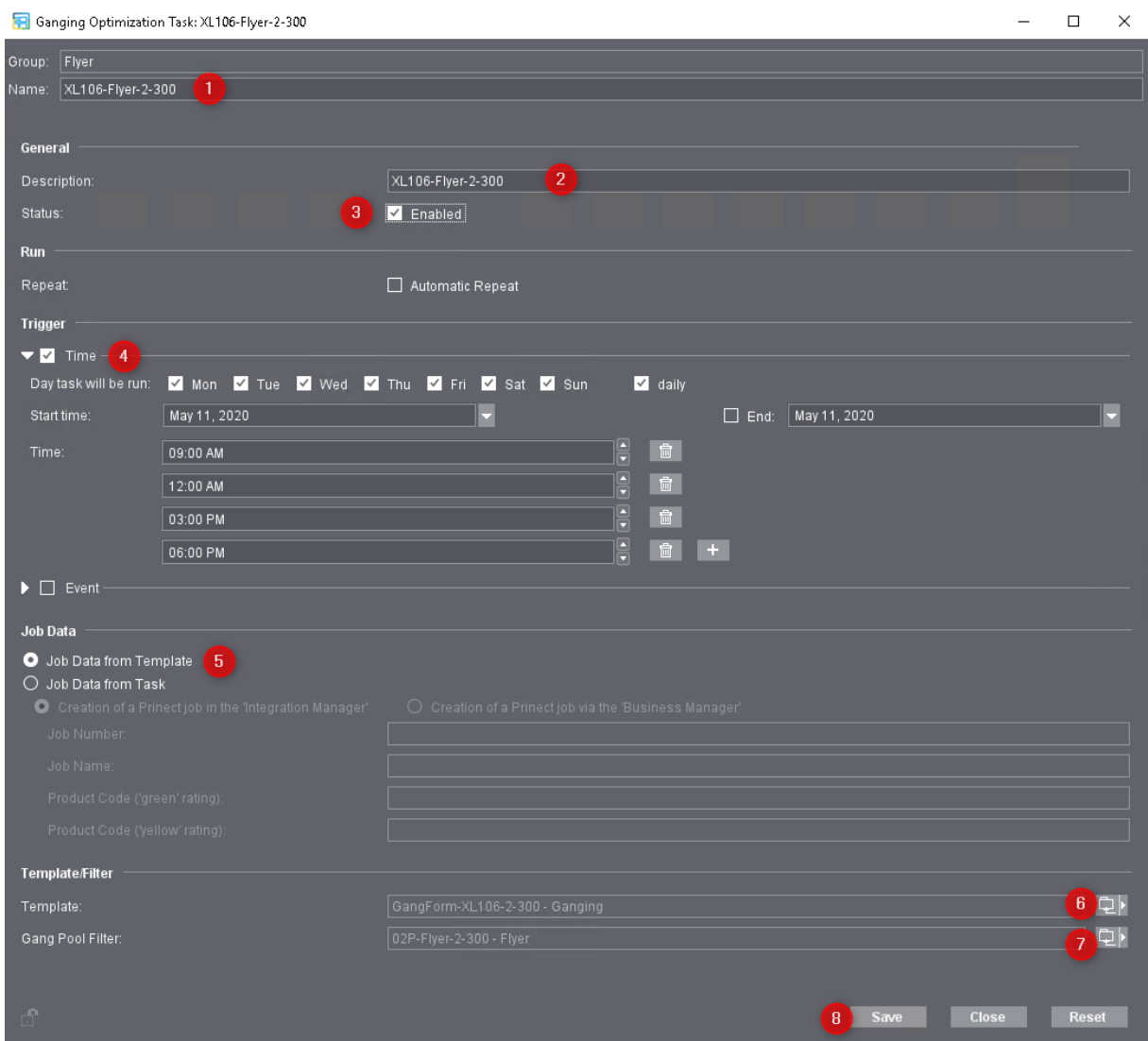
Description

"Planned Gang Tasks" are to manage in the resource group "Ganging Optimization Tasks".

We can create, sort in groups, copy & paste, rename, edit and lock filters.



For a "Ganging Optimization Task" we need a "Product Part Template" (6) and a "Gang Pool Filter" (7).



5 Ganging in General

5.2 Activated "Planned Gang Tasks"



Note: After upgrading Signa Station existing Gang Filter and Gang Tasks of previous Signa Station versions are automatically in the folder "Converted".

Motivation

We need to define a resource path to activate "Ganging Optimization Tasks".

Description

In the "Planned Gang Jobs" we have to define a path for "Active Task Group" (2-3).

Only tasks inside this group can be active (we can disable a task) for scheduling gang tasks.

Princt Signa Station Server - 21.00.20109.3

File | Edit | Jobs & Resources | Inspectors | Tools | Help

Resources | Machines | MDS

Background Processes...
Show Output Status...
JDF Jobs Status...
JDF Import Rules Editor...
Planned Gang Jobs... (1)
Job Import from Gang Pool...

BusinessCards / XL106-BC-2-300

Planned Gang Jobs

Active Task Group: MyGangTasks (2) (3)

Group	Name	State	Re
MyGangTasks/BusinessC...	XL106-BC-2-300	Disabled	
MyGangTasks/Flyer	XL106-Flyer-2-120	Disabled	
MyGangTasks/Flyer	XL106-Flyer-2-300	Disabled	

Properties

Property	Value
Task Name	XL106-Flyer-2-120
Description	XL106-Flyer-2-300
(Dedicated) Server	
Next Run	Disabled
Predecessor	
Job Number	\$(Date:@dd)-\$(Date:@MM)-\$(Date:@YY)-\$(Ser...
Job Name	GangServer
Template	GangForm-XL106-2-120 - Ganging
Gang Pool Filter	04P-Flyer-2-120
Product Code ('green' rating)	
Product Code ('yellow' rating)	

Start | Duration | Started by User

Save Cancel Close (3)



Attention: A group hierarchy like here cannot be defined in "Planned Gang Tasks"!

Sheet Optimization Setup

Ganging Optimization Tasks

- Brochures
- BusinessCards
- Converted
- Flyer
 - XL106-Flyer-2-120
 - XL106-Flyer-2-300
- Standard

Ganging Optimization Filter

Time(s): 09:00 AM, 12:00 AM, 03:00 PM, 06:00 PM

Predecessor: --

Job Number: \$(Date:@dd)-\$(Date:@MM)-\$(Date:@YY)-\$(SerialNo)

Job Name: GangServer

Product Code ('Green' Rating): --

Product Code ('Yellow' Rating): --

Template: GangForm-XL106-2-120 - Ganging

Gang Pool Filter: 04P-Flyer-2-120

5.3 "Create Prinect Job" for Ganging

2020.10

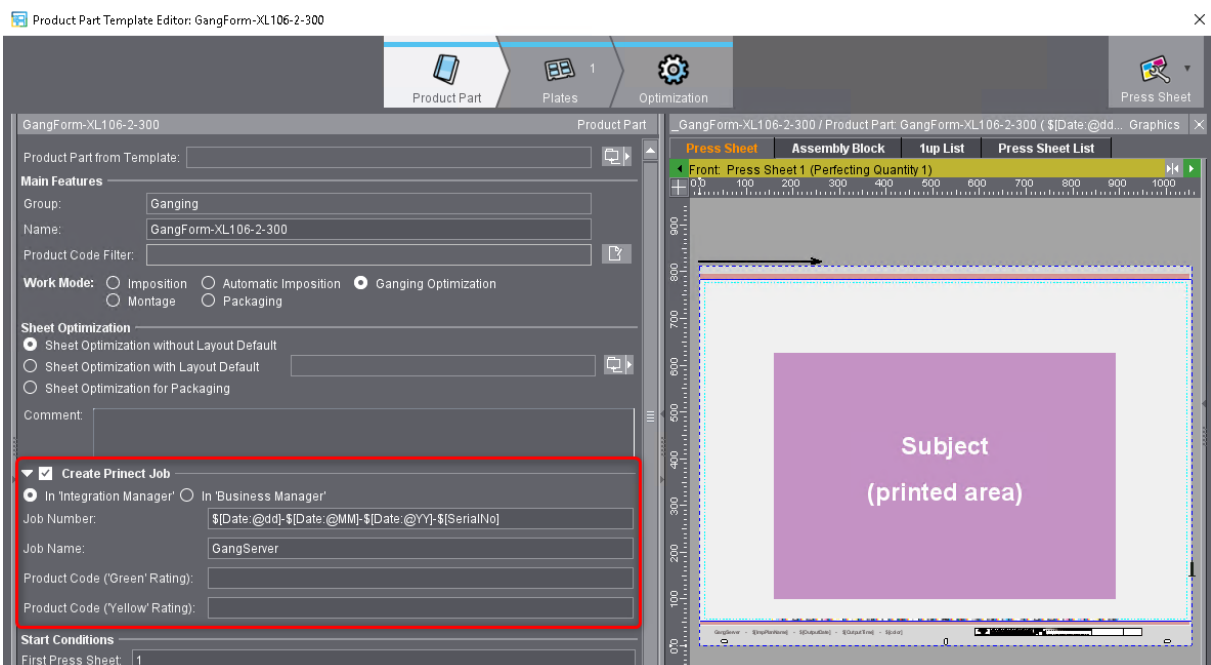
Note: The main part of the feature was implemented in Signa Station 2020.10.

Motivation

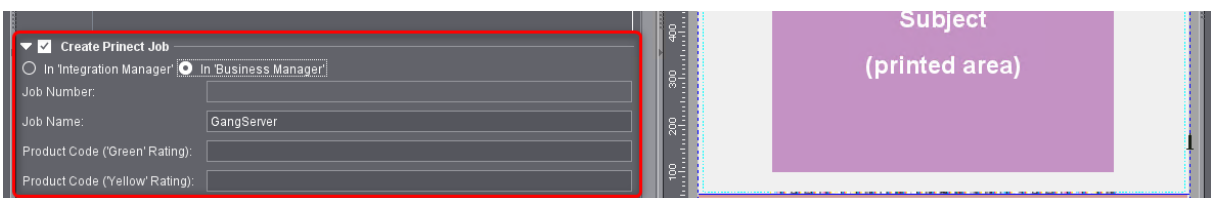
We want to define in a "Product Part Template" **AND** in the "Ganging Optimization Task" that the "Gang Server" can create a Job in the "Cockpit" **OR** in the "Prinect Business Manager".

Description

- We can define in the "Product Part Template" that this template can be used to create a job in the Cockpit or in the Business Manager.
 - Integration Manager (Cockpit) - job number and job name required



- Prinect Business Manager - only job name for PBM - the PBM creates the job number



Note: The used "Plate Template" in the "Product Part Template" has to define the right "Output Parameter" for Cockpit or PBM output!

5 Ganging in General

2. It is also possible to define "Job Data" in the "Ganging Optimization Task".

The screenshot shows a configuration window for a "Ganging Optimization Task: XL106-Flyer-2-120". The window is divided into several sections:

- General:** Group: MyGangTasks/Flyer, Name: XL106-Flyer-2-120, Description: XL106-Flyer-2-300, Status: Enabled.
- Run:** Repeat: Automatic Repeat.
- Trigger:** Time, Event. Day task will be run: Mon, Tue, Wed, Thu, Fri, Sat, Sun, daily. Start time: May 11, 2020, End: May 11, 2020. Time slots: 09:00 AM, 12:00 AM, 03:00 PM, 06:00 PM.
- Job Data:** Job Data from Template, Job Data from Task. Under "Job Data from Task", there are two radio buttons: "Creation of a Prinect job in the 'Integration Manager'" (selected) and "Creation of a Prinect job via the 'Business Manager'". Fields include: Job Number: , Job Name: , Product Code ('green' rating): , Product Code ('yellow' rating): .
- Template Filter:** Template: , Gang Pool Filter: .

Buttons at the bottom: Save, Close, Reset.



Note: When "Job Data from Template" is enabled and we browse for a "Product Part Template", Signa Station does only display templates with defined "Job Data".

5.4 "User-defined XML Tags" for Ganging Attributes

2020.10

Note: This feature was implemented in Signa Station 2020.10.

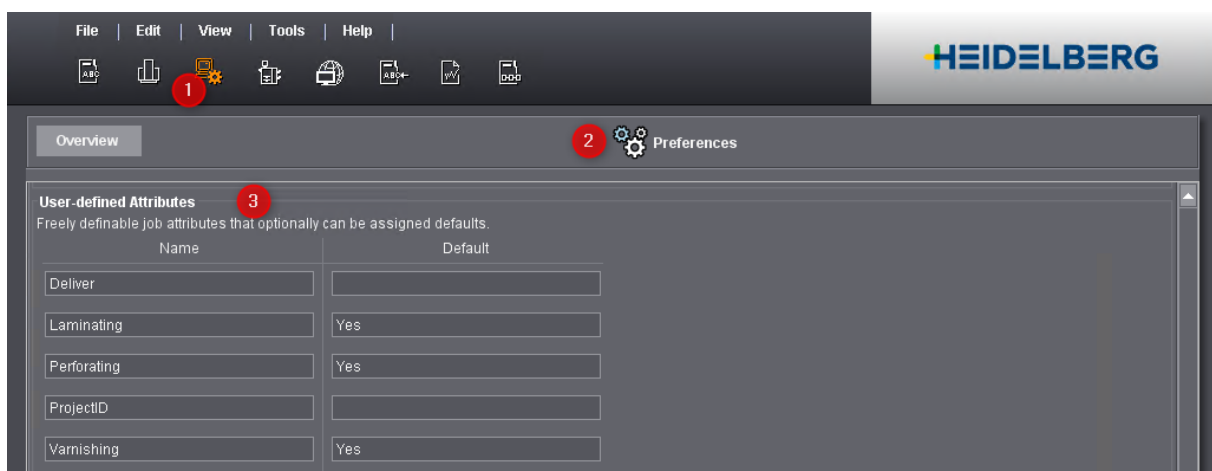
Motivation

We can write user-defined attributes into a gang XML-file. These attributes can describe a special finishing work step or a special behavior for production.

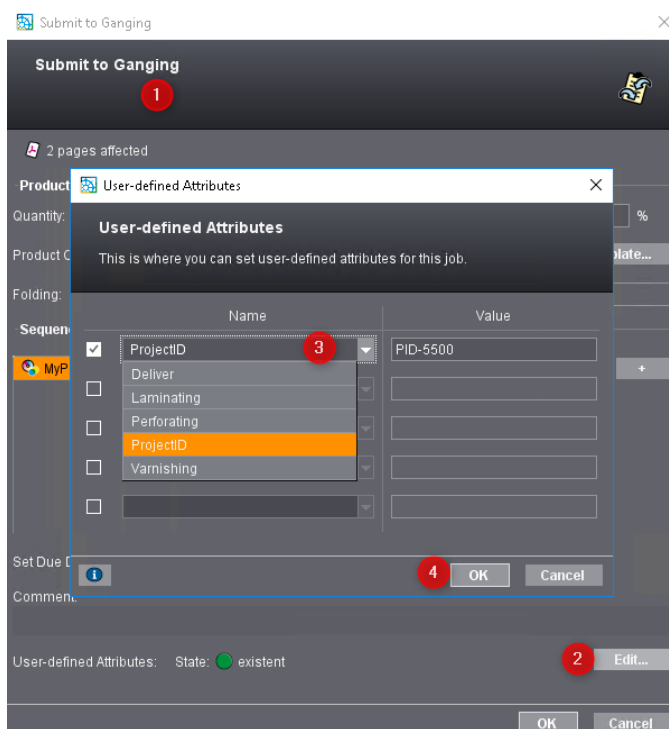
Customer wants to use this attributes as a mark on the placed ganged job.

Description

In the Cockpit we can define up to 5 different user-defined attributes, Signa can handle up to 9.

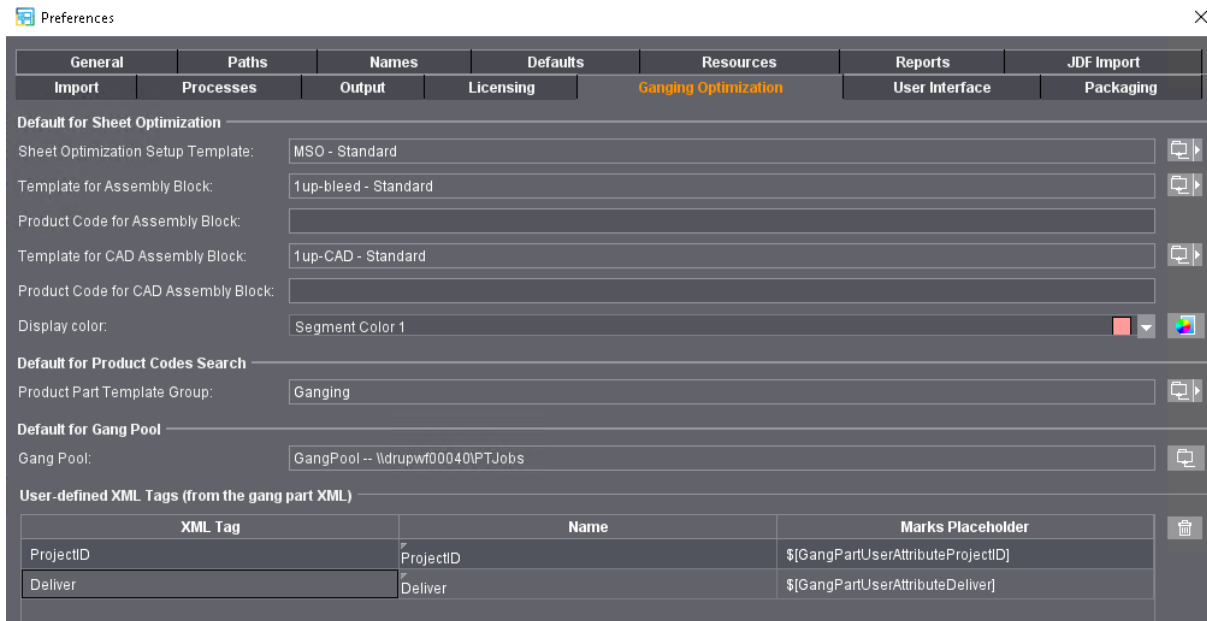


This attributes are available for submitting pages or folding schemes into the gang pool.

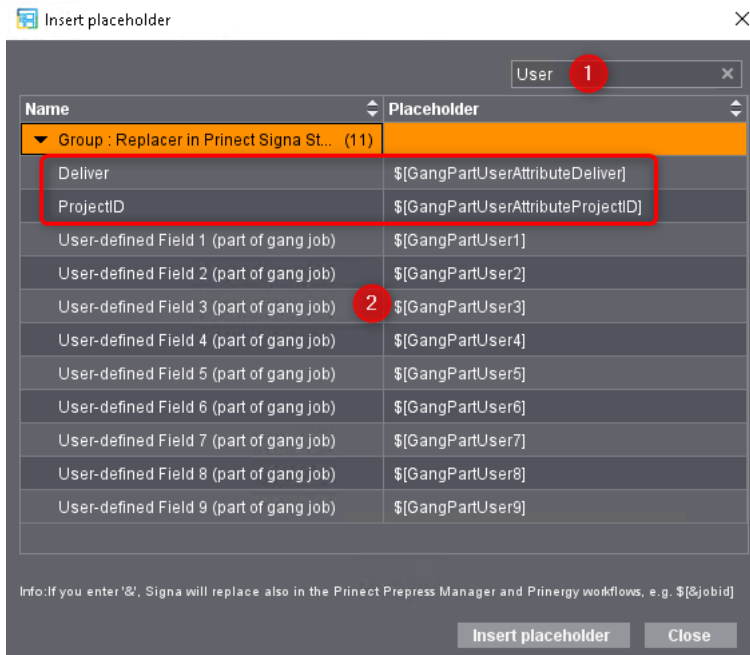


5 Ganging in General

After optimization of these jobs in a gang job, Signa Station reads out all user-defined XML-entries, displayed in the "Preferences".



Signa Station generates automatically "Marks Replacer" for user-defined gang attributes!



These "Marks Replacer" are to add to a "Text Mark" and can be placed in the "Product Part Template" (e. g. as a "Page Label Mark", outside of the page), visualized in the gang form.

When only one attribute is available for the job => only one is displayed at the job, even when 5 Marks Replacer are defined in the mark.



Note: We can use the existing "Marks Replacer" "[GangPartUser1]" - "[GangPartUser9]" too.

The existing "Marks Replacer" `$(GangPartUser1) - $(GangPartUser9)` are always mapped to the first 9 entries in the "Preferences" list. We can change the order of mapping of "User-defined XML Tags" in this dialog.

The screenshot shows the 'Preferences' dialog box with the 'Ganging Optimization' tab selected. The 'User-defined XML Tags (from the gang part XML)' section contains a table with the following data:

XML Tag	Name	Marks Placeholder
Deliver	Deliver	\$(GangPartUserAttributeDeliver)
ProjectID	ProjectID	\$(GangPartUserAttributeProjectID)

A red circle with the number '1' is positioned next to the 'ProjectID' name in the table. A red box with the number '2' highlights the arrow controls (up, down, and a trash icon) on the right side of the table, used for reordering the XML tags.

5 Ganging in General



Note: We can use the user-defined attributes for filtering jobs.

Job Import from Gang Pool

Filter: Off Private Resource

Gang Job

Filter by Printing Material Quality

Filter by Shape

Printing Material

contains 2-300

Final Size

Width/Height equals

ProjectID

is not empty

Deliver

is not empty

Job	Product Code	Printing Material	Grammage	Target Date	ProjectID	Deliver
M20-00010 / GangJobs for Ganging	Ganging/02P-Flyer	2-300	300.00	May 19, 2020, 9:50 AM		Hermes
M20-00010 / GangJobs for Ganging	Ganging/02P-Flyer	2-300	300.00	May 19, 2020, 9:50 AM		
M20-00010 / GangJobs for Ganging	Ganging/02P-Flyer	2-300	300.00	May 19, 2020, 9:50 AM		
M20-00010 / GangJobs for Ganging	Ganging/02P-Flyer	2-300	300.00	May 19, 2020, 9:50 AM		
M20-00010 / GangJobs for Ganging	Ganging/02P-Flyer	2-300	300.00	May 19, 2020, 9:50 AM	PID-5500	
M20-00010 / GangJobs for Ganging	Ganging/02P-Flyer	2-300	300.00	May 19, 2020, 9:50 AM		
M20-00010 / GangJobs for Ganging	Ganging/02P-Flyer	2-300	300.00	May 19, 2020, 9:50 AM		

Total: 10, Filtered: 10, Selected: 0

Log of Job Import



Note: We can use the user-defined attributes for viewing and printing the "Gang Report".

GangForm-XL106-2-120 -- Sheet Optimization without Layout Default

Input List for Sheet Optimization

Process Order	State	Job	Article
2	✓	M20-00010 / GangJobs for ...	
3	✓	M20-00010 / GangJobs for ...	
5	✓	M20-00010 / GangJobs for ...	
6	✓	M20-00010 / GangJobs for ...	
7	✓	M20-00010 / GangJobs for ...	
8	✓	M20-00010 / GangJobs for ...	
10	✓	M20-00010 / GangJobs for ...	

Ganging... Import PDF... Single Jobs: 7 / 10

Deadline: No deadline

11-05-20-1_GangServer / Product Part: GangForm-XL106-2-120

Press Sheet List

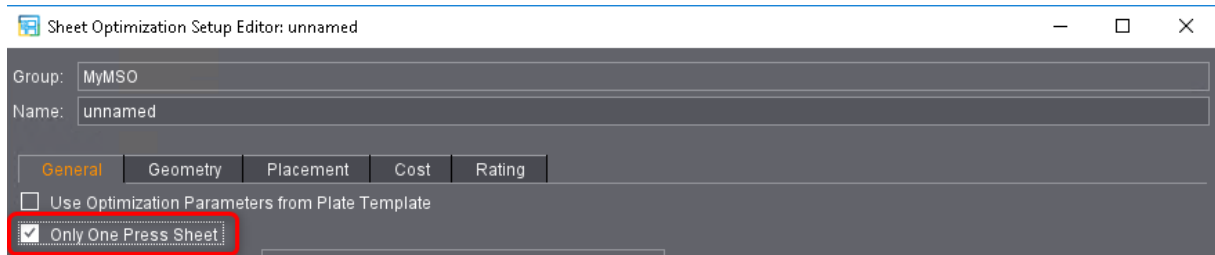
No.	Assembly Block Name	Format	Product Part	1ups	Deliver	ProjectID
2	1, F02-01_ui_1x1, Pages M20-00010-P1 - M20-00...	1 X 1	GangForm-XL106-2-120	M20-00010-P1 - M20-00010-P2		
3	1, F02-01_ui_1x1, Pages M20-00010-P1 - M20-00...	1 X 1	GangForm-XL106-2-120	M20-00010-P1 - M20-00010-P2	Hermes	
4	1, F02-01_ui_1x1, Pages M20-00010-P1 - M20-00...	1 X 1	GangForm-XL106-2-120	M20-00010-P1 - M20-00010-P2		
5	1, F02-01_ui_1x1, Pages M20-00010-P1 - M20-00...	1 X 1	GangForm-XL106-2-120	M20-00010-P1 - M20-00010-P2		
6	1, F02-01_ui_1x1, Pages M20-00010-P1 - M20-00...	1 X 1	GangForm-XL106-2-120	M20-00010-P1 - M20-00010-P2		
7	1, F02-01_ui_1x1, Pages M20-00010-P1 - M20-00...	1 X 1	GangForm-XL106-2-120	M20-00010-P1 - M20-00010-P2		PID-5500

6 Ganging Based on "Cost" or "Rating"

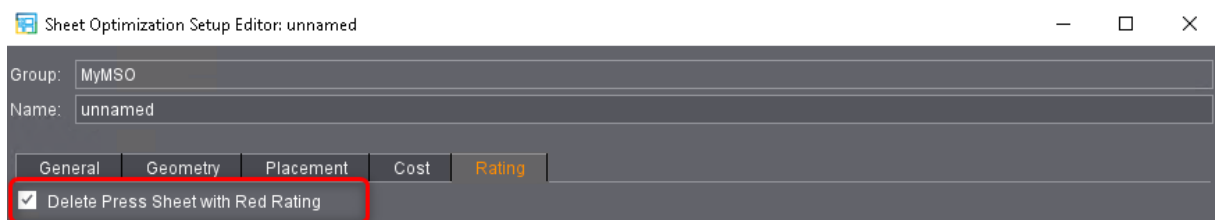
In Signa Station 2019 we have introduced "Rating" as a new criteria for ganging.

Two settings are responsible for the decision, if Signa Station calculates **cost based** or **rating based**:

"Only One Press Sheet"



"Delete Press Sheet with Red State"



Calculation Case 1: Cost based

"Only One Press Sheet": **Off**, "Delete Press Sheet with Red State": **Off**

- Optimization is running on the Cost basis.
- All gang parts are placed.
- Defined Rating criteria results are shown in the Report, but they have only a lower priority for optimization.

Calculation Case 2: Rating based

"Only One Press Sheet": **On**, "Delete Press Sheet with Red State": **On**

- Only one press sheet is generated.
- Gang parts are placed with the best possible overall rating.
- Unused Gang parts are returned to the gang pool.

Calculation Case 3: Cost and Rating based

"Only One Press Sheet": **Off**, "Delete Press Sheet with Red State": **On**

- Based on the quality criteria and taking the cost into account, several press sheets may be generated because you try to process all the imported gang parts if possible.
- If a sheet has a red rating in the overall rating or in a criterion defined as "Veto", the sheet is rejected automatically, the unused Gang parts are returned to the gang pool.

6 Ganging Based on Cost or Rating

6.1 Cost Based Optimization

Cost based ganging compares the relationship between 'Make Ready' costs and 'Good Production' costs. The unit for the cost is not relevant, it can be Euro, US-Dollar or British Pounds – the balance must be correct.

1. Print Preparation (global)

- Make Ready time + Make Ready sheets:
400 € : 60 min x 8 min \approx 54 € + 6 € for 60 Sheets = **60 €**

2. Per separation

- Imaging of Plates + Plate material:
30 € per separation

3. Cost [1000 sheets]

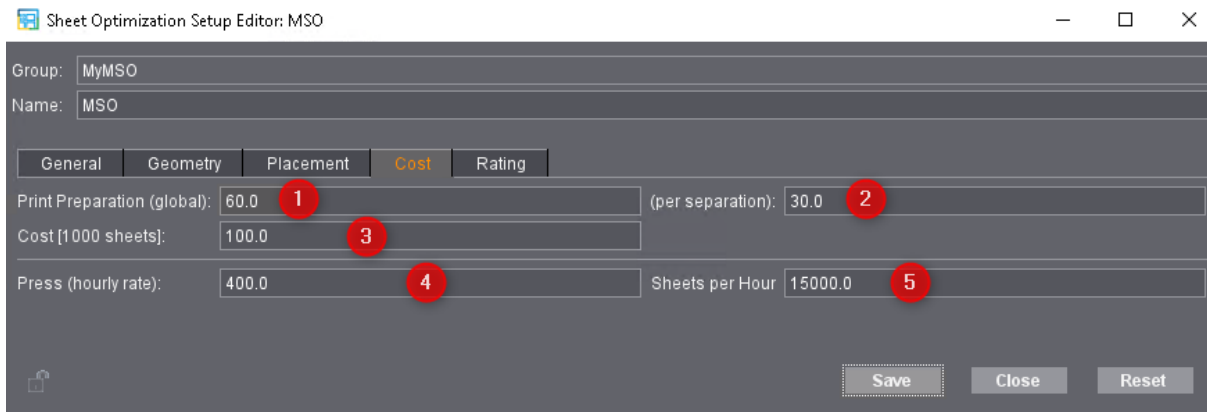
- Print material price per 1000 sheets:
100 € for 1000 sheets glossy coated paper 135 g/m²

4. Press (hourly rate) – Sheets per Hour

- Cost Center Press: Hourly machine rate + hourly Employee:
400 € per hour

5. 5. Sheets per Hour

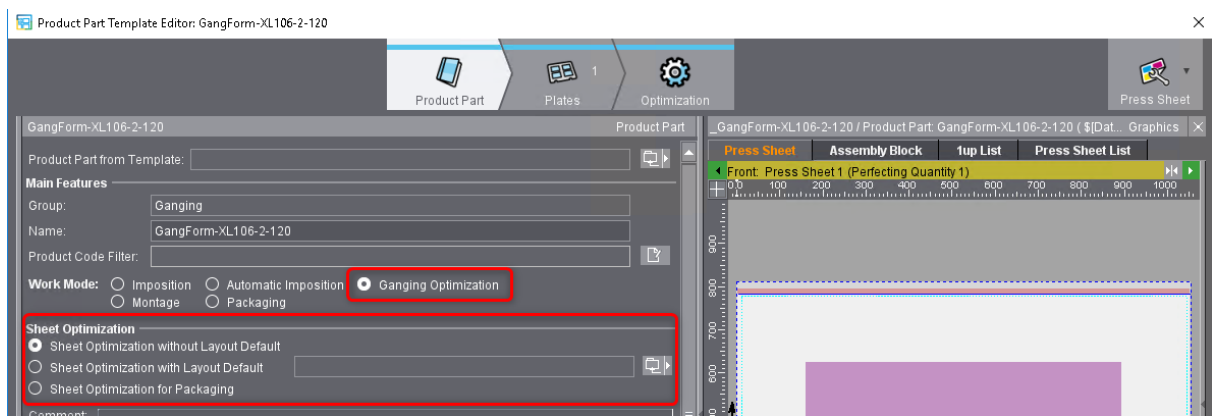
- The default speed of an XL:
15 000 Sheets per hour



6.2 Rating Based Optimization

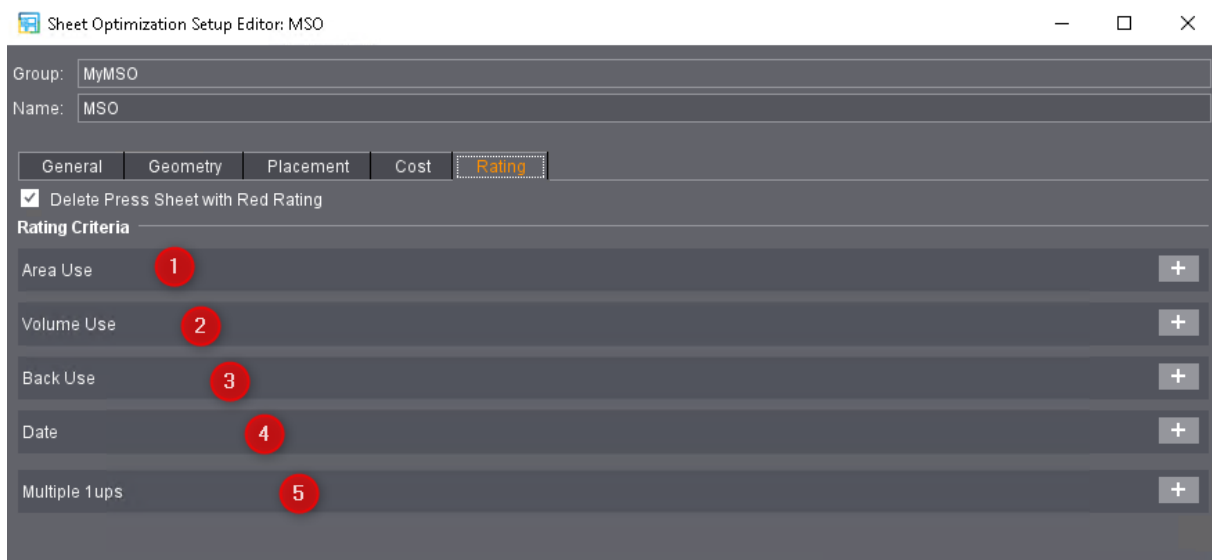
General

- Customers are often combining different criteria for one "Sheet Optimization Setup"
- When different critical criteria are in use, we need a lot of jobs in the gang pool, otherwise the "Gang Task" cannot create good gang sheets
- Tolerant gang tasks are necessary to clean up the gang pool at the end of the day
- We can use "Product Part Templates" in 3 different ways:



We have 5 different rating criteria

1. Area Use – looks for one sheet of a Gang job
2. Volume Use – looks for the whole stack of a Gang job
3. Back Use – respects the Back side too
4. Date Spreading – looks for the target date
5. Multiple 1ups – tries to avoid multiple 1 up sheets

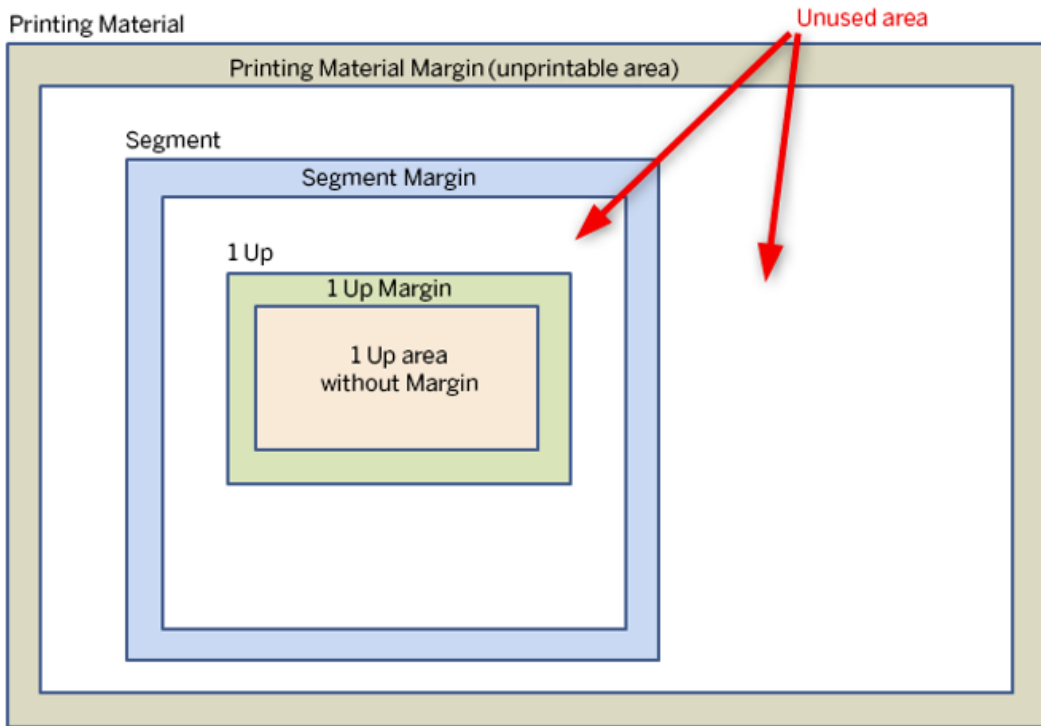


6 Ganging Based on Cost or Rating

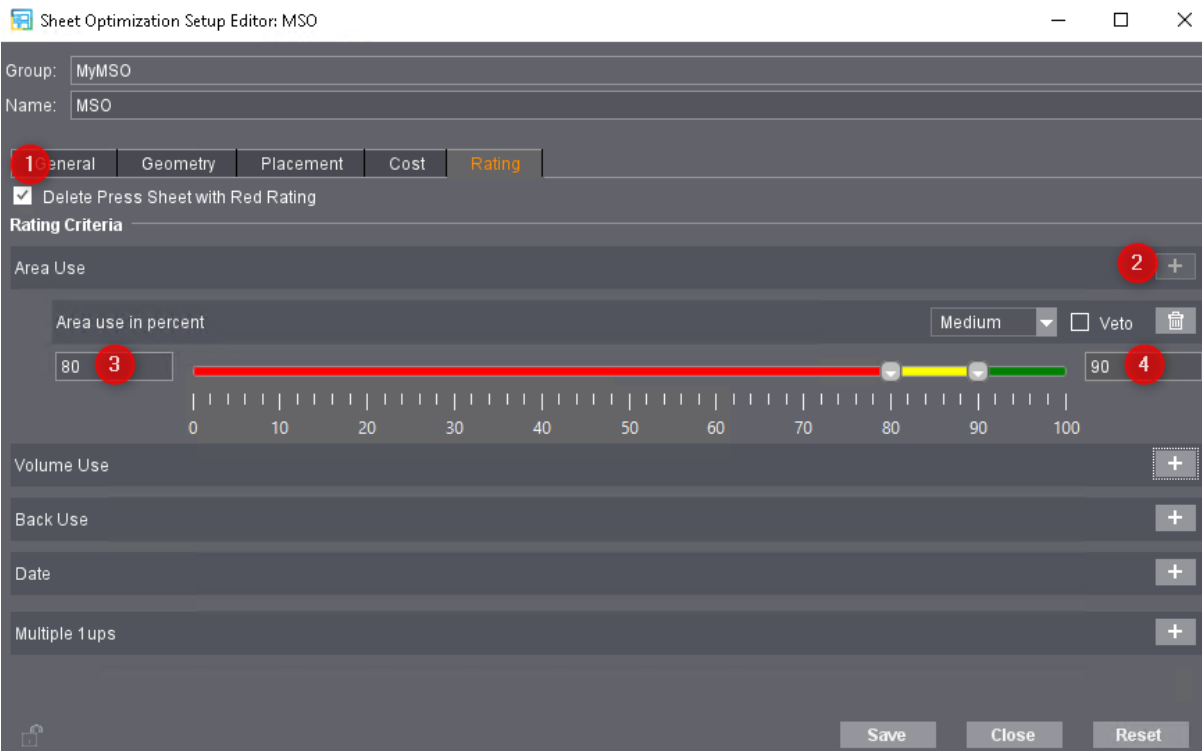
6.2.1 "Area Use" - looks for one sheet of a gang job

Usage of printed area versus unprinted area in percent.

Unprintable areas are not included (gripper, sheet brakes or margins).



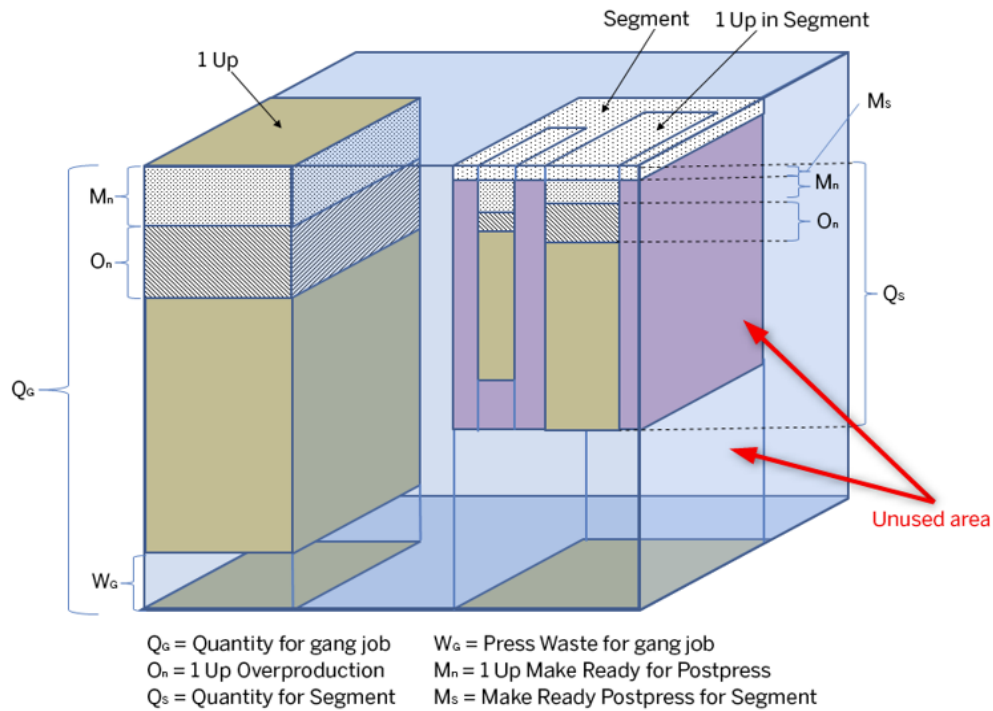
Gang sheets with an area usage higher than 80% will be created.



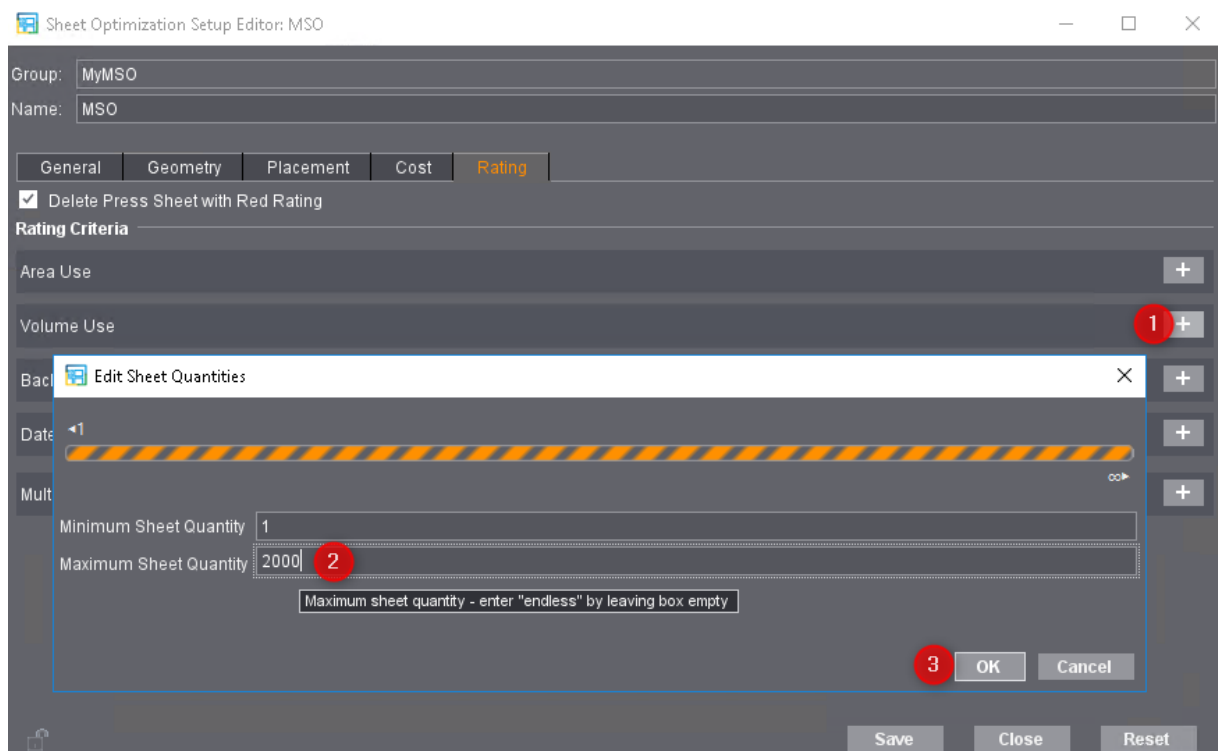
6.2.2 "Volume Use" - looks for the whole stack of a gang job

The rating for volume is only in use in the defined volume range.

The volume usage compares **profitably used paper** versus **printed waste and unused areas**. **Profitably used paper**: Quantity, make ready sheets for post press, overproduction, margins.



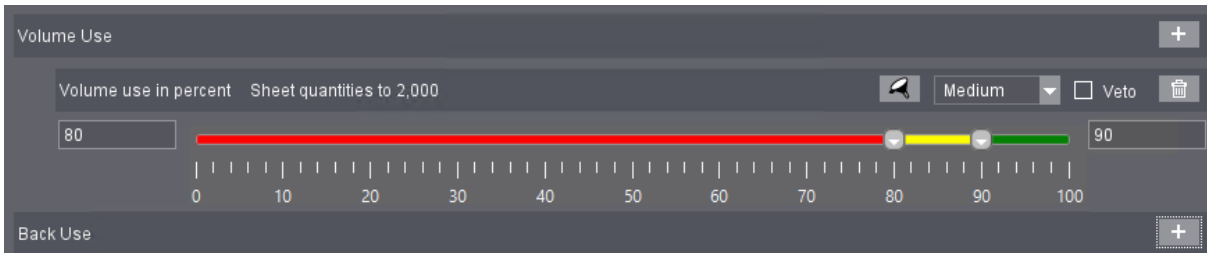
For "Volume Use" we can define a range of sheets.



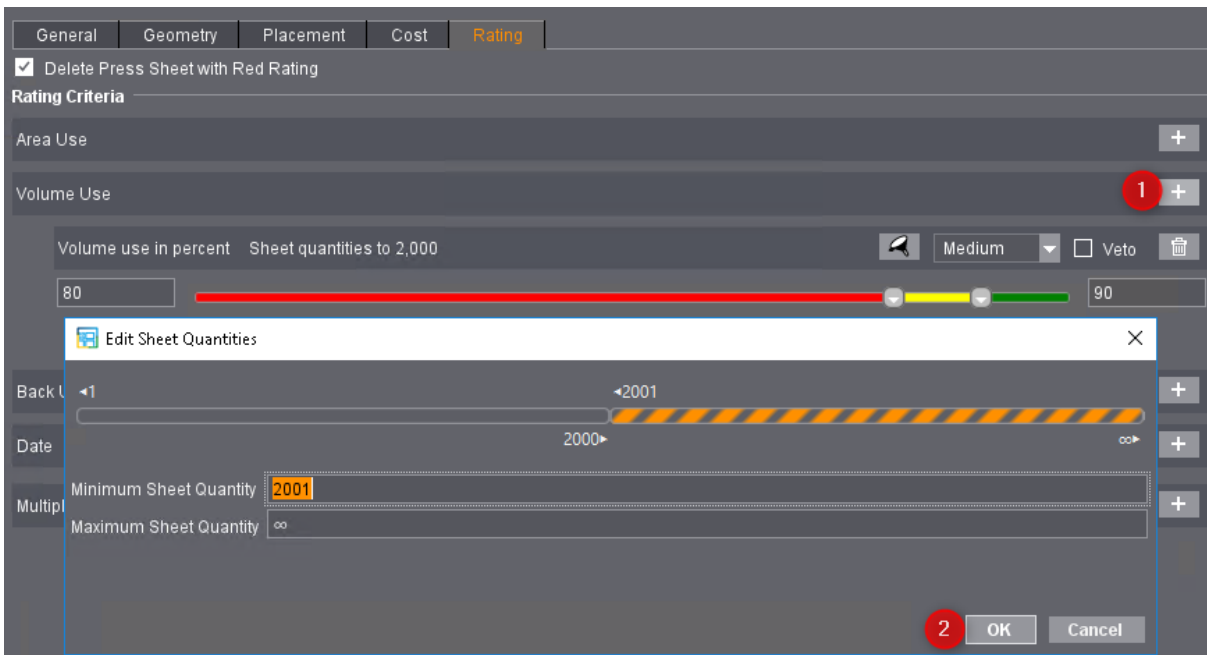
6 Ganging Based on Cost or Rating

Example

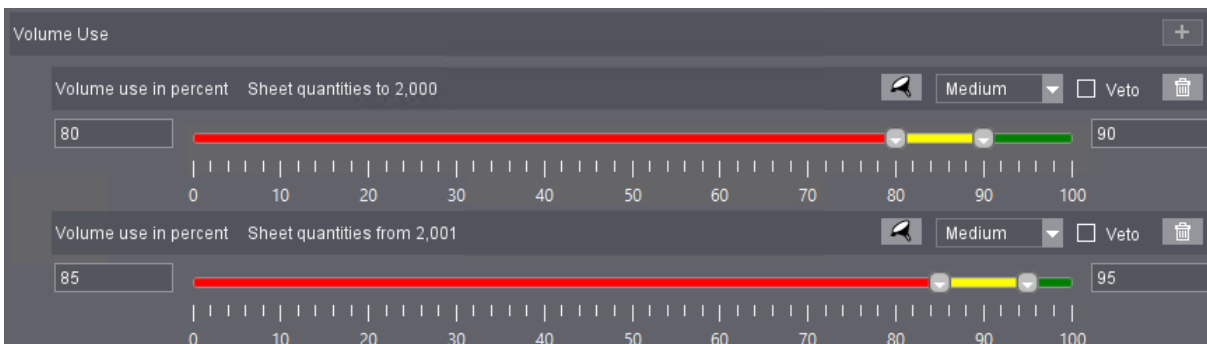
- Gang sheets up to a quantity of 2000 sheets and with a Volume usage higher than 80% will be created with the volume criteria in the report.
- When we would have only one volume range, we would generate higher quantities too, but they would not respect the volume criteria in the report.



It is possible to define different sheet ranges.



When the sheet quantity is higher => the waste volume is larger!



6.2.3 "Back Use" - respects the back side

The "Area Use" looks only for the front sheet. Additionally, we can respect the back sheet too:

- When a sheet has only jobs on front (back is empty) the back use is also 100%
- The function tries to create 4/0 and 4/4 sheets
- The slider definition defines the rating report result

80% of the front side and 50% of the back side must be filled.



Note: The "Ganging Optimization Filter" allows to avoid empty back side jobs too!

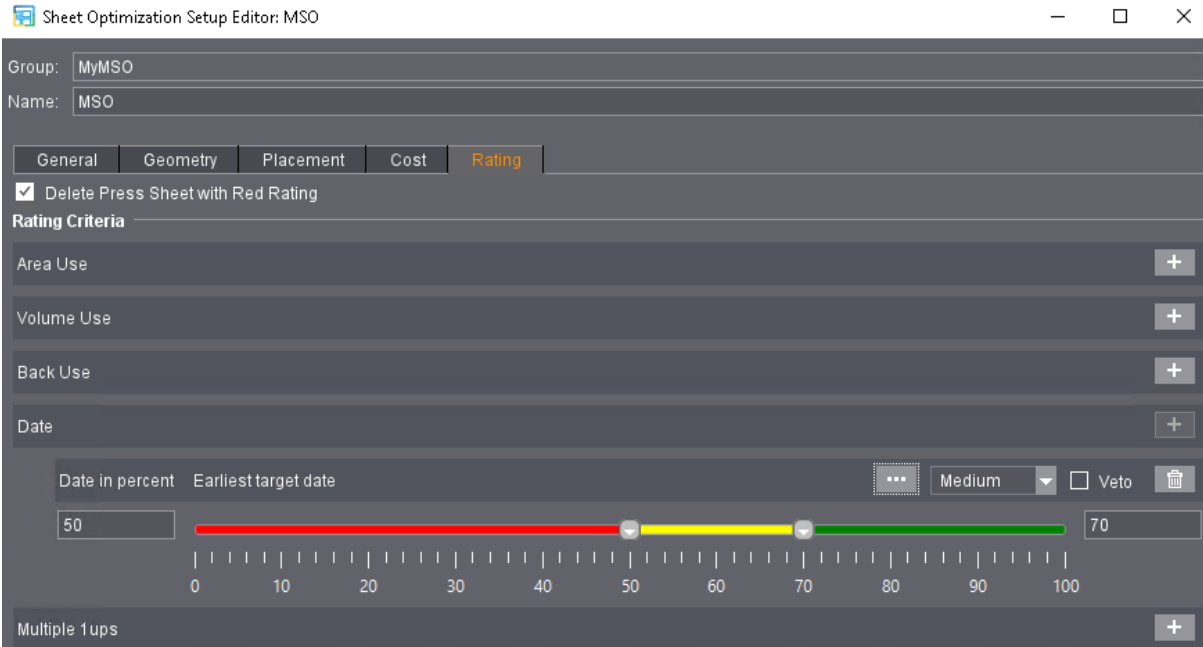


6 Ganging Based on Cost or Rating

6.2.4 "Date" – looks for the target date

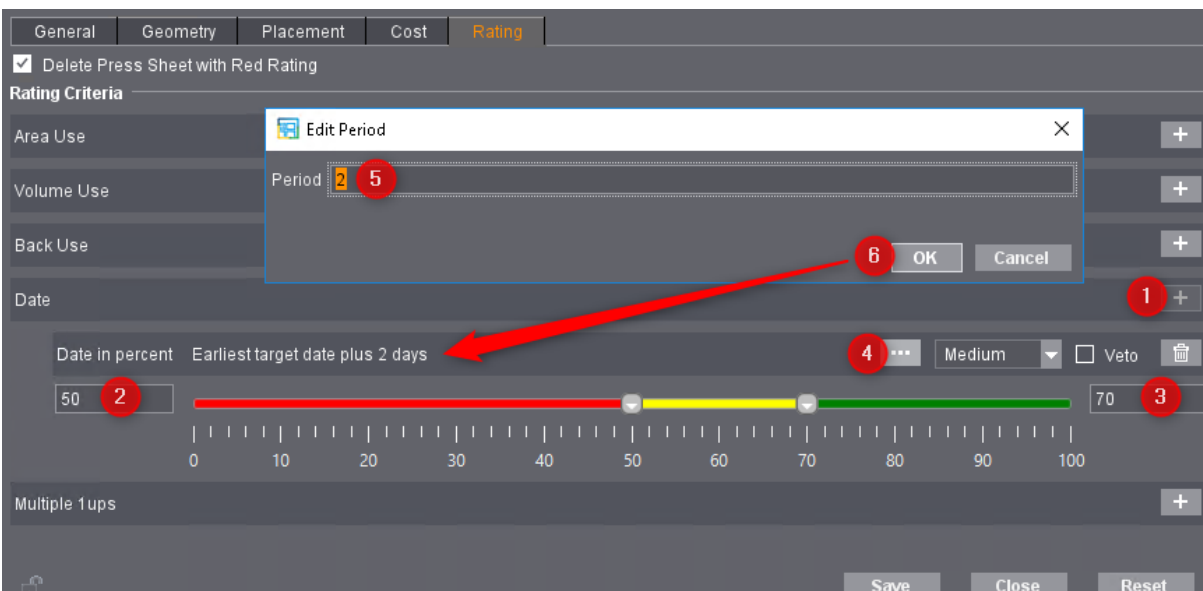
Instead of "Date spreading" (Princt 2020.0) we have now the criteria "Date".

We can define the "Date" criteria without a "Period" - earliest target dates are ganged first.



With "Period": Looks primary to the defined next days (due date or print date is the target date).

The "Gang Server" generates gang sheets with the oldest target dates first, the last gang sheets are generated up to the next 2 days of the target date.

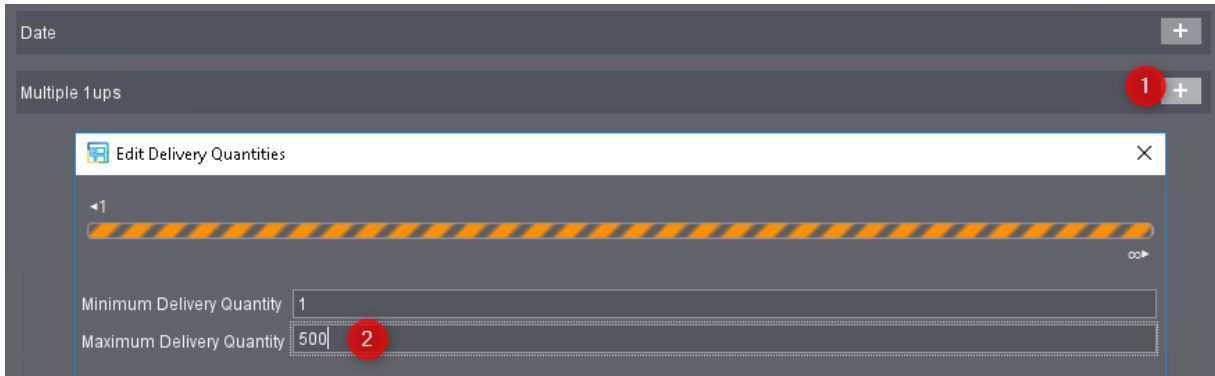


Note: This criterion can only exist once.

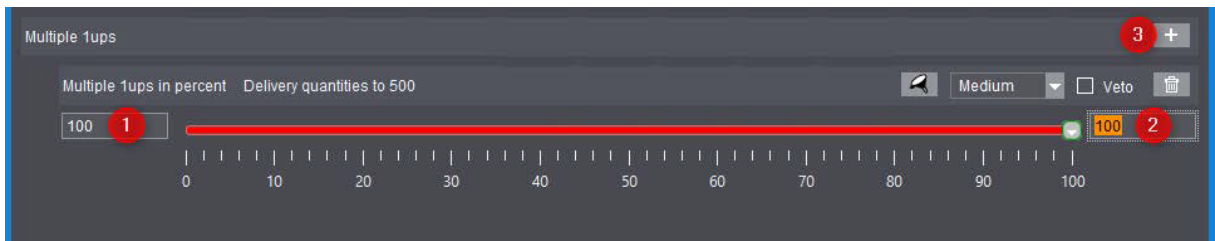
6.2.5 "Multiple 1ups" – tries to avoid multiple 1 up sheets

Many different jobs on one sheet => higher print quantities => less manual sorting.

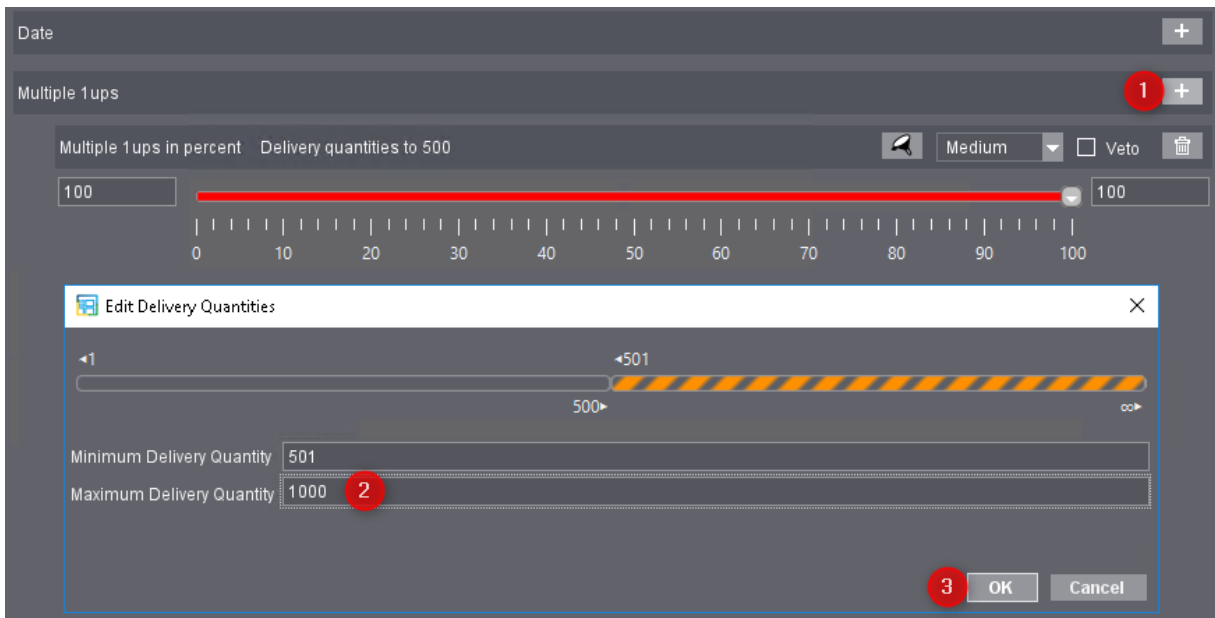
We can define different ranges for the delivery quantity to gang sheets with single one Ups only.



Jobs with a delivery quantity up to 500 must be ganged as single one Ups:

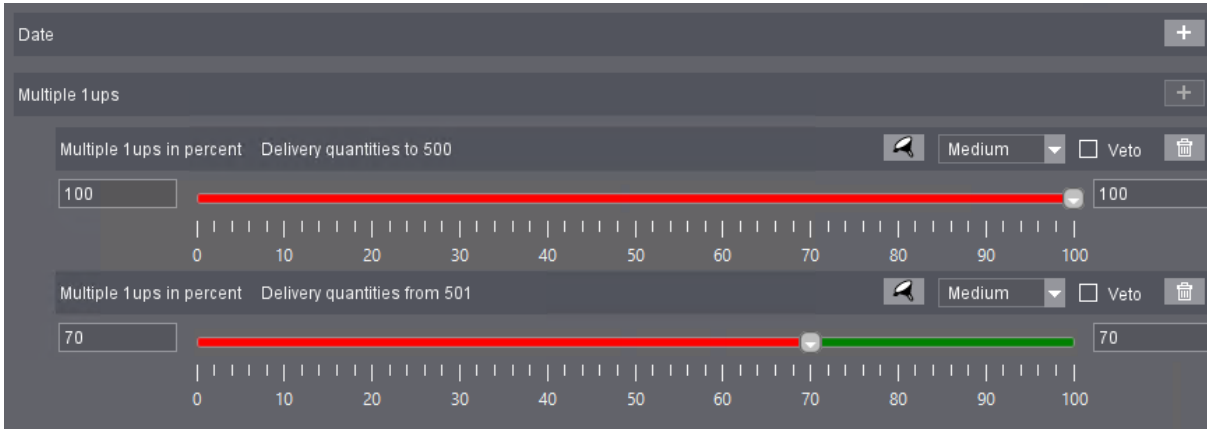


Between a delivery quantity 501 and higher we allow to generate multiple one Ups...



6 Ganging Based on Cost or Rating

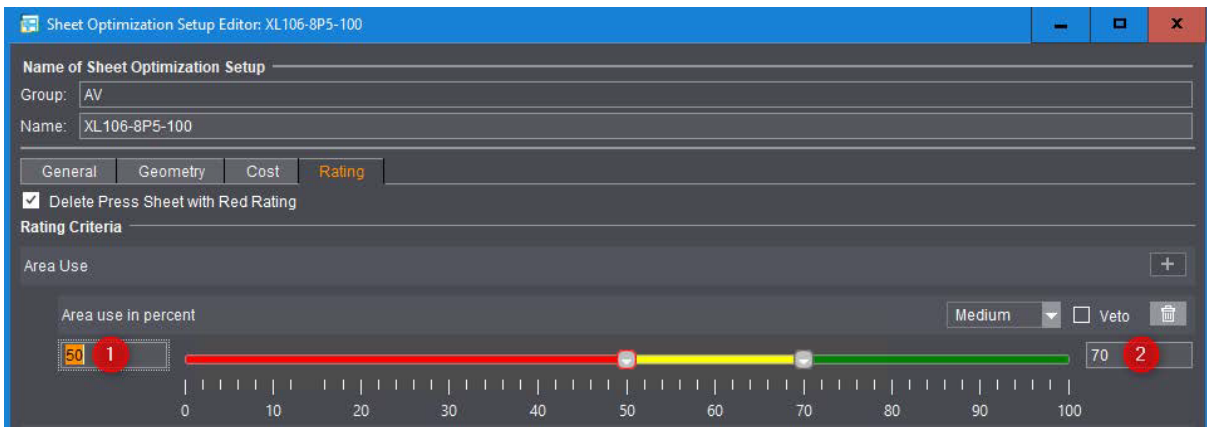
... up to 30%. How many multiple of one job depends on job size, job amount, sheet size.



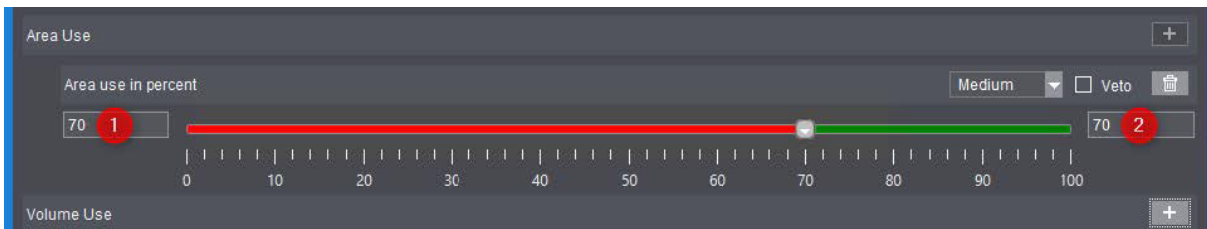
6.3 "Ratings" in the "Gang Report"

The rating criteria slider define the status icon in the report.

We can define 3 different status: Red – Yellow – Green...



... or we can define only Red and Green:

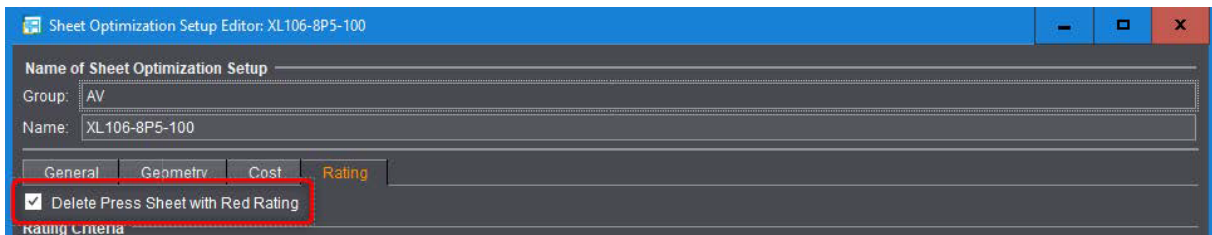


6 Ganging Based on Cost or Rating

The "Gang Report" displays the rating status:

Sheets	Rating	Quantity	Allowance	Area Use	Volume Use	Multiple 1ups Delivery quantities to 50,000
1	✓ 90.45 %	12000	0	⚠ 86.49 %	⚠ 84.87 %	✓ 100.0 %
2	✓ 85.88 %	12000	0	✓ 91.82 %	✓ 90.21 %	⚠ 75.62 %
3	⚠ 74.98 %	17000	0	⚠ 80.32 %	✗ 65.48 %	⚠ 79.16 %
4	✓ 86.8 %	50000	0	⚠ 89.85 %	✗ 70.55 %	✓ 100.0 %

A red rating would not create a gang job with the Gang Server when the option is enabled!



A full gang report with 4 gang sheets and different ratings

- 3 ratings were active for the MSO parameter
- The column "Rating" is a weighted average for all rating criteria

Job Number: AutoOptimizeGangpool 05.12.19 15:04

Total Values:
 Total Real Costs: 13100.00
 Total Sheet Count: 91000
 Efficiency Factor: 74.08 %
 Number of Press Sheets: 4
 Number of Placed Single Jobs: 21
 Splits: 0
 Deadline: ---
 Total Target Quantity: 859800
 Total Allowance: 0
 Total Paid Overproduction: 4200
 Blank Waste (Sheets): 11023
 Printed Waste (Sheets): 12562
 Printed Waste (Items): 80000
 Plate Template: XL106 - Standard
 Paper Size: 3004.72 pt x 2125.98 pt
 Name of Optimization Algorithm: 0_MSOCruncherSubAmount_Clustering

Sheets	Rating	Quantity	Allowance	Area Use	Volume Use	Multiple 1ups Delivery quantities to 50,000
1	✓ 90.45 %	12000	0	⚠ 86.49 %	⚠ 84.87 %	✓ 100.0 %
2	✓ 85.88 %	12000	0	✓ 91.82 %	✓ 90.21 %	⚠ 75.62 %
3	⚠ 74.98 %	17000	0	⚠ 80.32 %	✗ 65.48 %	⚠ 79.16 %
4	✓ 86.8 %	50000	0	⚠ 89.85 %	✗ 70.55 %	✓ 100.0 %

No.	State	Job	Target Date	Delivery Quantity	Allowance	Overproduction	Waste	Sheets			
								1	2	3	4
1	✓	12-019777 / CutMarksTest	Dec 30, 2011 12:00 AM	50000	0	0	0				1
2	✓	12-01876547 / Test-Nutzenkennungen	Dec 30, 2011 12:00 AM	50000	0	1000	0				3
3	✓	12-01876547 / Test-Nutzenkennungen	Dec 30, 2011 12:00 AM	50000	0	1000	0				3
4	✓	12-01876547 / Test-Nutzenkennungen	Dec 30, 2011 12:00 AM	50000	0	0	0				1
5	✓	12-01876547 / Test-Nutzenkennungen	Dec 30, 2011 12:00 AM	50000	0	0	0				1
6	✓	12-01876547 / Test-Nutzenkennungen	Dec 30, 2011 12:00 AM	50000	0	0	0				1

6 Ganging Based on Cost or Rating

6.4 "Priority"

If you have more than one setting active you can set up here the order for the most important setting:

- Very high
- High
- Medium
- Low
- Very low

All active ratings are combined to a weighted average!

It might happen that a sheet is rated OK, even if your parameter with the highest priority is red.

Example 1

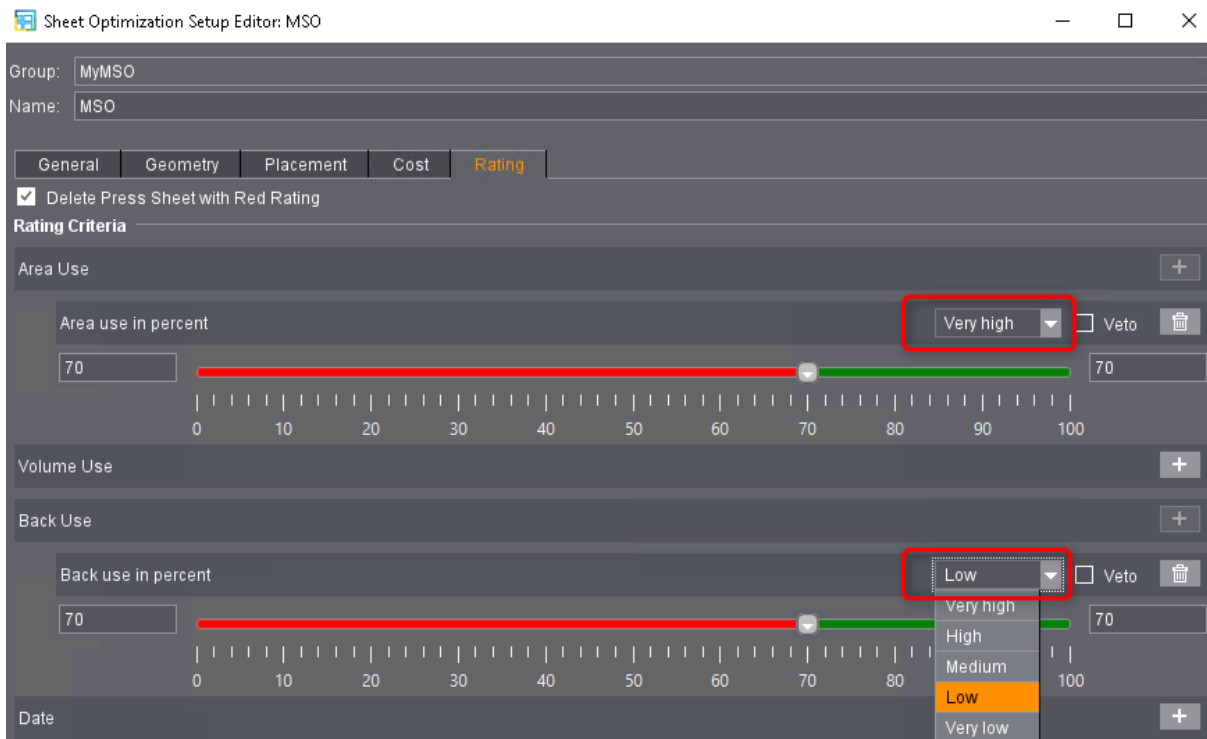
- Very high: Sheet with 90% for Area Use => green
- Low: 60% for Back Use => red

=> The final report will display green!

Example 2

- Very high: Sheet with 71% for Area Use => green
- Low: 10% for Back Use => red

=> The final report will display red!



6.5 "Veto"

A "Veto" can overrule all other rating criteria

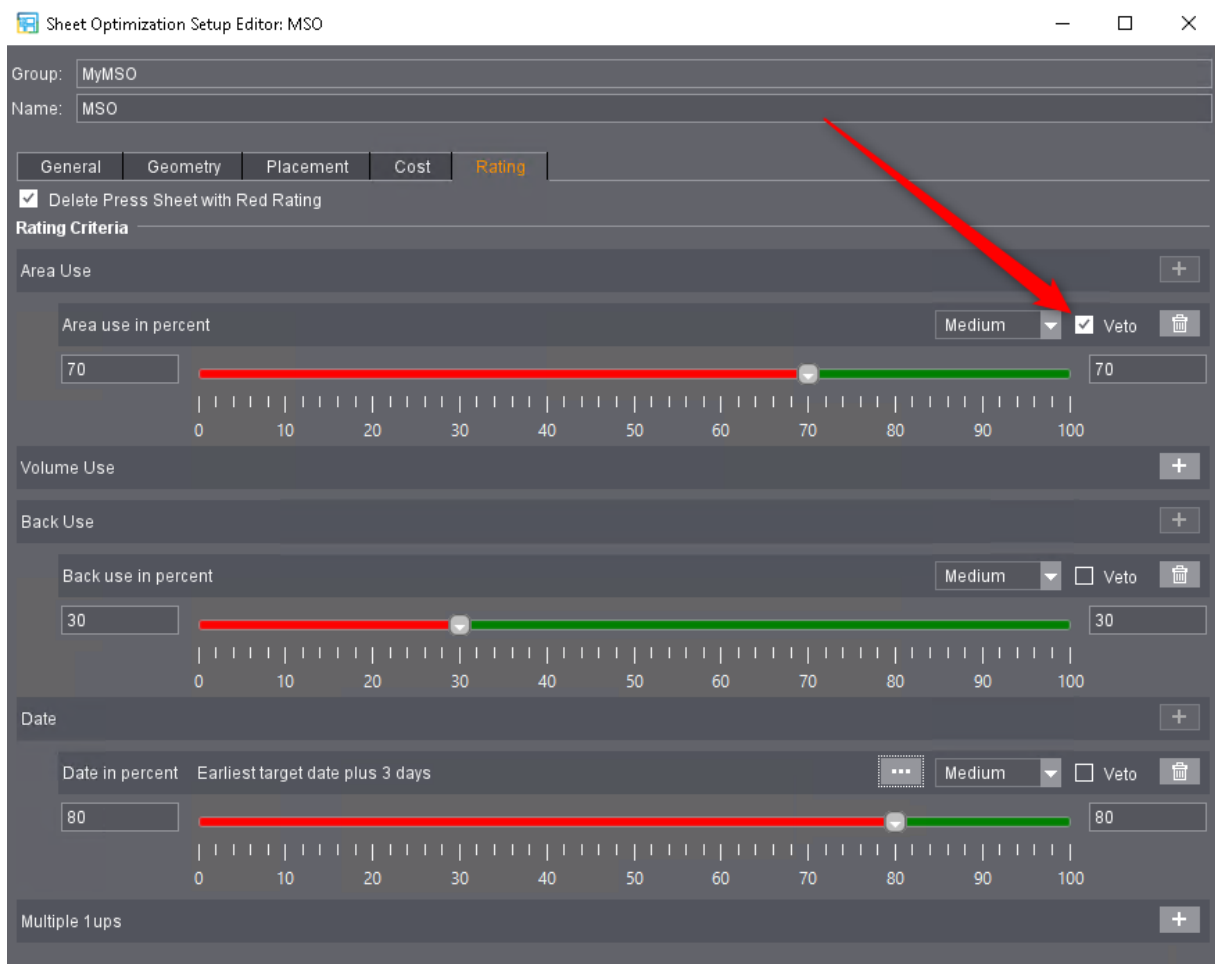
- The "Veto" flag will be respected as a last step after rating calculation.
- it can make the rating result worse
- but it cannot make a rating result better

Examples 1

- The weighted average about all ratings would generate a 'green' rating, but the "Area Use" in "Veto" has only 69% => the press sheet would be deleted

Examples 2

- The weighted average about all ratings would generate a 'red' rating, but the "Area Use" in "Veto" has only 71% => the press sheet would be deleted



6 Ganging Based on Cost or Rating

7 Ganging Optimization

7.1 MSO Parameter – "Placement"

2020.10

Note: This feature was implemented in Signa Station 2020.10.

Motivation

Customers wants to define the placement direction to get better cutting results.

Description

The "Placement" parameters has been added for:

- Sheet Optimization without Layout Default
- Sheet Optimization with Segments

"Primary placement direction" (has moved from the "General" tab into the "Placement" tab)

- Generally: - the gang jobs can be placed horizontal or vertical, the best result will be used
- Horizontal - the gang jobs will be placed horizontal
- Vertical - the gang jobs will be placed vertically

"Placement starts horizontally"

- Left
- Right

"Placement starts vertically"

- Bottom
- Top

"Placement" in "MSO Parameter: Sheet Optimization Setup".



7 Ganging Optimization

7.2 MSO Parameter – "Sheet Brake" and "Horizontal Lanes"

2020.10 **Note:** This feature was implemented in Signa Station 2020.10.

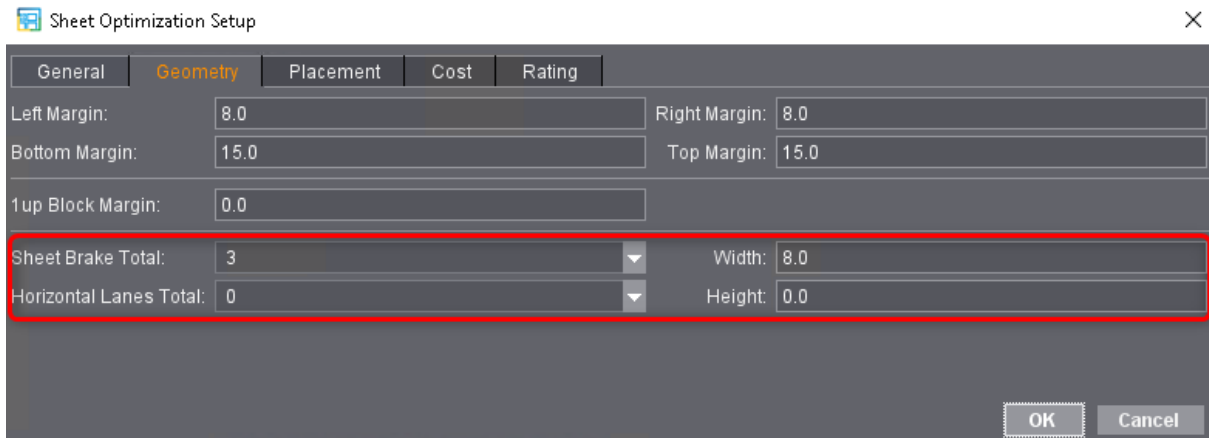
Motivation

Customers want to define the sheet brake width to define unprinted paper areas.

Description

The optimization parameters are extended by:

- Width of the sheet brakes - vertical clearance areas
- Number and width of the horizontal lanes - for "Ganging with Segments" only



The sheet break width is excluded for ganging.



7.3 MSO Parameter – Sorting of Press Sheets

2020.10

Note: This feature was implemented in Signa Station 2020.10.

Motivation

After the "Multi Sheet Optimization" the generated print sheets should be sorted in a controlled order.

Description

The following sort criteria run one after the other:

- Keep identical layouts together - "Sheet Optimization for Packaging" and "Ganging with Layout"
- Sort by due date - the oldest date per sheet first
- Sort by run length - long run sheets first

7.4 MSO Parameter – Alignment of Job Internal Resources

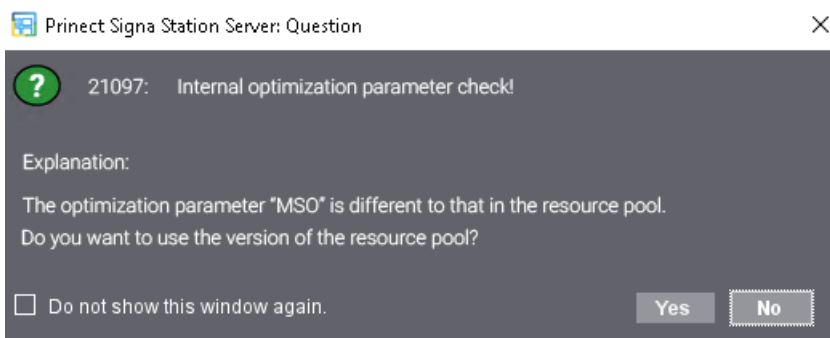
Motivation

The alignment of job internal resources has been extended by the resource type "Sheet Optimization Parameter".

Description

When loading a saved job, the internal resource "Sheet Optimization Parameter" is now compared with those in the resource area in addition to the plate template because it can be edited within a job.

When a change is detected, we are asked whether the version from the resource pool should be used.



7 Ganging Optimization

7.5 Editing of Incoming Gang Jobs

2020.10

Note: This feature was implemented in Signa Station 2020.10.

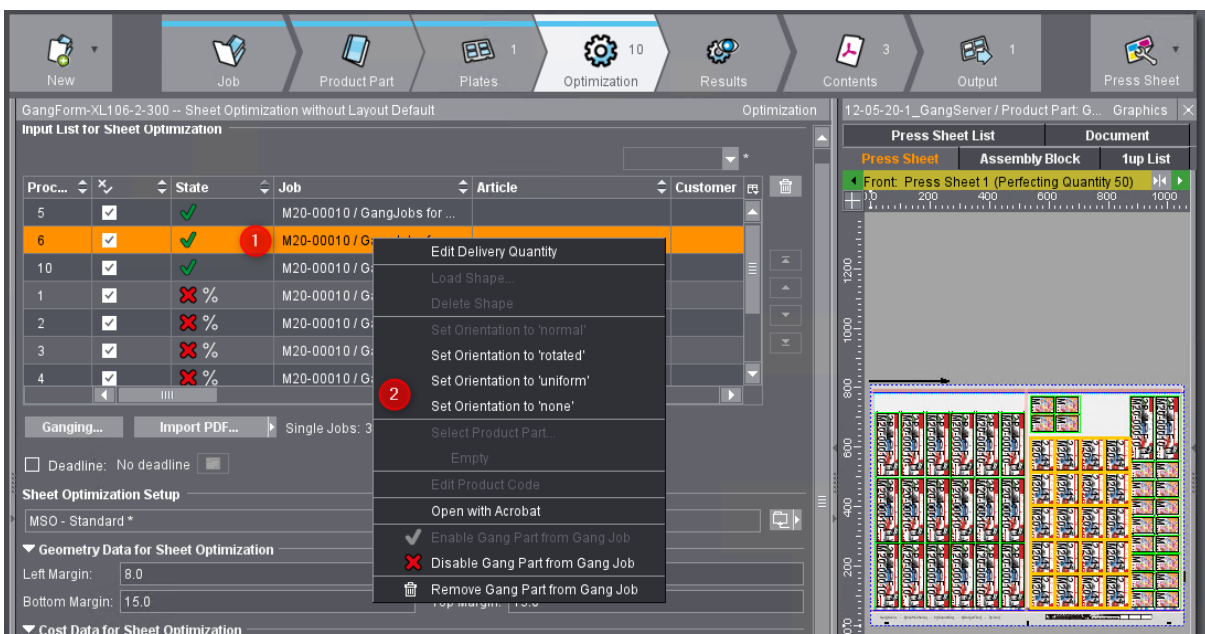
Motivation

The editing of individual orders in the input list for sheet optimization should be easier.

Description

Single jobs in the input list for sheet optimization can be edited using the context menu:

- Until Prinect 2020: Only the entries 'Enable Gang Part from Gang Job', 'Disable Gang Part from Gang Job' and 'Remove Gang Part from Gang Job' was visible in the context menu. For all other entries the cursor had to be in the corresponding column of the table.
- Now: All entries available for this mode are displayed in the context menu – regardless of the column in which the quote is displayed.



8 Ganging with Segments for Finishing

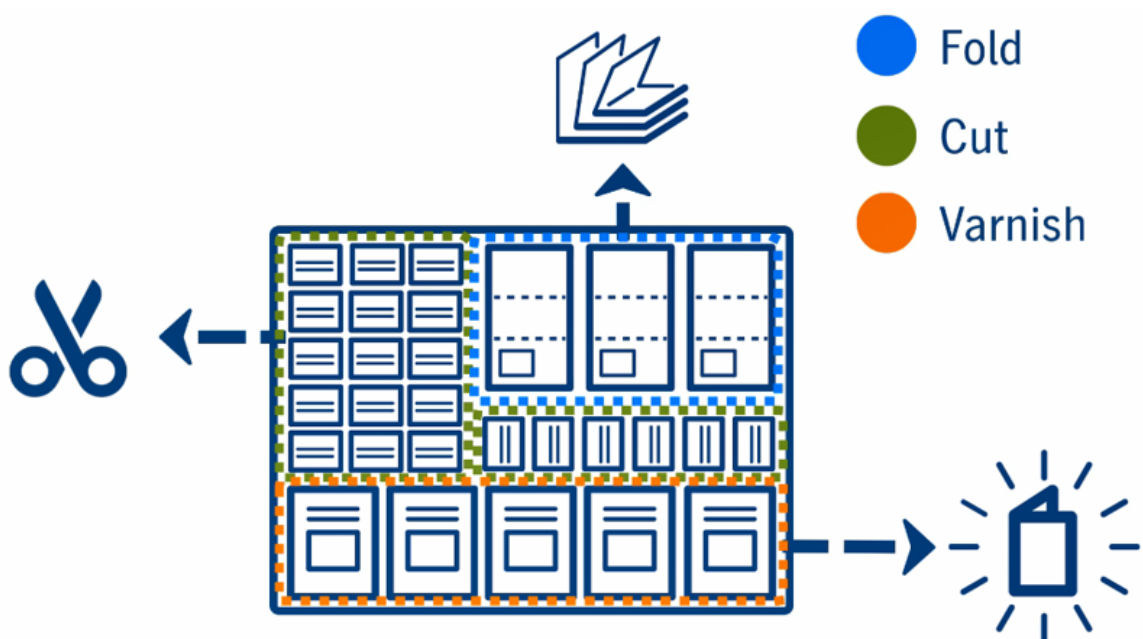


Note: We only enable this feature for customers, when a chargeable project has been started. You can contact the Prinect Product Management for further informations.

Motivation

For a printer with a Web2Print shop we have developed "Ganging with Segments for Finishing":

- Keep jobs with the same finishing procedure together in segments on the press sheet
- Create from a large format press (XL162, XL145) small cut blocks for finishing devices

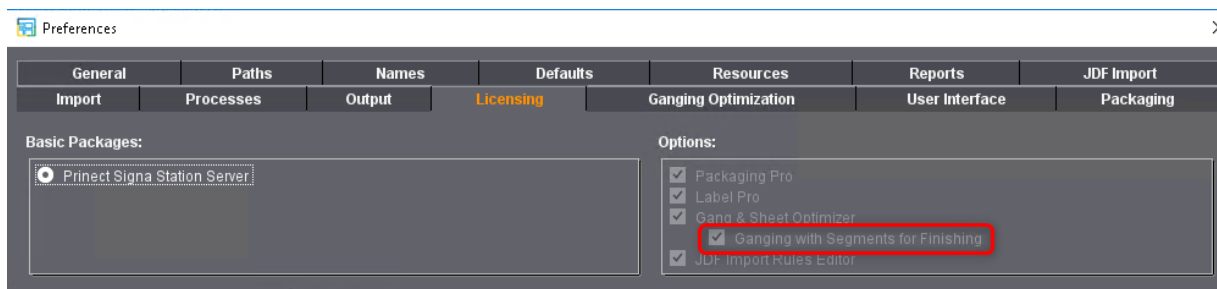


Description

The segment workflow is based on "Product Codes", defined from a web shop:

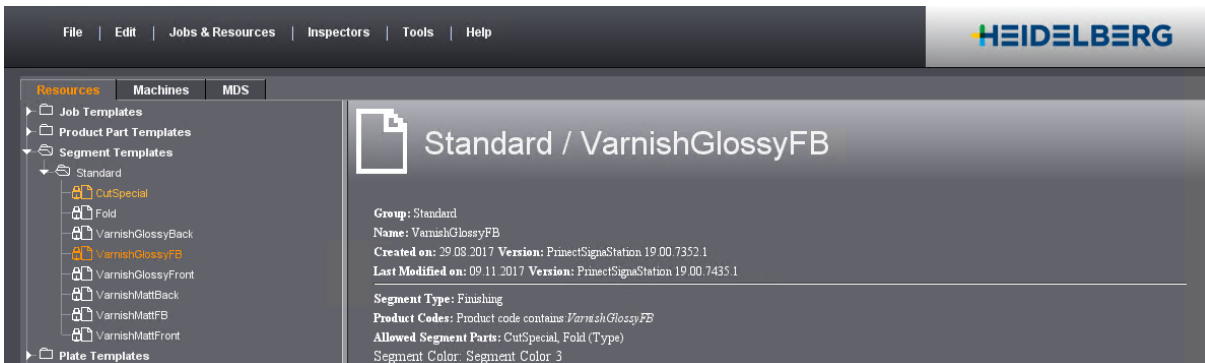
- **Example of a Product Code:** F-F4-1_VAR_S-A4_C4x4_135Glossy
- **Translation of the Example:** FoldingScheme_Varnishing_Format_Color_PapierQuality

When this license is enabled...



8 Ganging with Segments

... the "Segment Templates" are displayed in Signa Station Resources.



9 Java AdoptOpenJDK 11

Motivation

Oracle Java 11 is not longer free of charge.

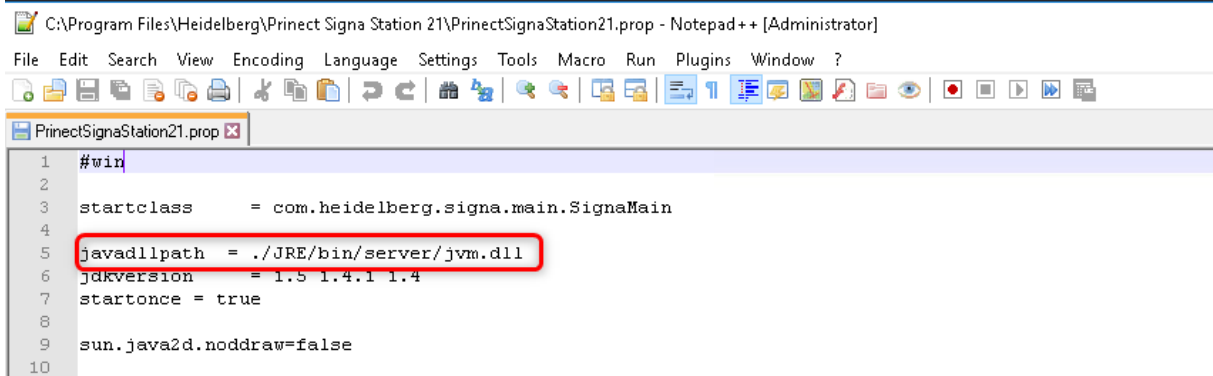
We should change to Java AdoptOpenJDK 11 to avoid higher prices for Heidelberg and our customers.

Description

In Prinect 2021 we have implemented Java AdoptOpenJDK 11 for:

- Signa Station
- Cockpit
- DataTerminal

In the application property file we can see the Java path and that Oracle Java (sun) is deactivated.



```
C:\Program Files\Heidelberg\Princt Signa Station 21\PrinctSignaStation21.prop - Notepad++ [Administrator]
File Edit Search View Encoding Language Settings Tools Macro Run Plugins Window ?
PrinctSignaStation21.prop
1 #win
2
3 startclass = com.heidelberg.signa.main.SignaMain
4
5 javadllpath = ./JRE/bin/server/jvm.dll
6 jdkversion = 1.5 1.4.1 1.4
7 startonce = true
8
9 sun.java2d.noddraw=false
10
```


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Revision 1.0

Version 2021

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