



Training Documentation

Smart Print Shop - Push to Stop

Revision 1.1



Prinect

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About this Documentation

This documentation is based on Prinect 2020 and PressCenter 19A, but the most settings and features are also working in previous versions too.



Note: This document should give an overview about Prinect and PressCenter with Intellistart 2. Basic Prinect trainings and Basic Press trainings are required to use and understand this document!

Smart Print Shop: All machines and processes work more and more automated in a conclusive Workflow. The goal is the autonomous production.

Push to Stop: Jobs at the PressCenter, which are to print in Push to Stop mode - loading jobs automatically out of the queue. The queueing should be possible with minimum interactions.

Goal of the document

When a Prinect job from the Storage has

- all job columns filled with information
- and all Printing Material parameters are available

we have the base to work in Push to Stop mode.

In this document we want to explain how to realize such a filled job queue.

The screenshot displays the Heidelberg Intelligade software interface. At the top, there are tabs for 'Job', 'Production', 'Machine', and 'myWallscreen'. The main area shows a 3D model of a printing press with various color units. Below the model is a table with job details. The table has columns for Start, Number, Name, Operation, Printing m..., Length, Width, Gram..., Colors, and Color Order. The first row is highlighted in orange.

Start	Number	Name	Operation	Printing m...	Length	Width	Gram...	Colors	Color Order
10.02.2019 22:00	M18-000169	ReusePlates with Preview	ST118709_Umschlag 01...	100253-Glossy ...	630	880	150.0	4/4	
10.02.2019 23:10	M18-000169	ReusePlates with Preview	ST118709_Umschlag 02...	100253-Glossy ...	630	880	150.0	4/4	
10.02.2019 23:48	M18-000169	ReusePlates with Preview	ST118709_Umschlag 03...	100253-Glossy ...	630	880	150.0	4/4	
11.02.2019 00:26	M18-000169	ReusePlates with Preview	ST118710_4-stg. B0 1 0...	100253-Glossy ...	630	880	150.0	4/4	
11.02.2019 01:36	M18-000169	ReusePlates with Preview	ST118710_4-stg. B0 1 0...	100253-Glossy ...	630	880	150.0	4/4	
11.02.2019 02:14	M18-000169	ReusePlates with Preview	ST118710_4-stg. B0 1 0...	100253-Glossy ...	630	880	150.0	4/4	
11.02.2019 02:52	M18-000169	ReusePlates with Preview	ST118711_8-stg. B0 2 0...	100253-Glossy ...	630	880	150.0	4/4	
11.02.2019 03:30	M18-000169	ReusePlates with Preview	ST118711_8-stg. B0 2 0...	100253-Glossy ...	630	880	150.0	4/4	
11.02.2019 04:40	M18-000169	ReusePlates with Preview	ST118711_8-stg. B0 2 0...	100253-Glossy ...	630	880	150.0	4/4	
11.02.2019 05:18	M18-000169	ReusePlates with Preview	ST118711_8-stg. B0 2 0...	100253-Glossy ...	630	880	150.0	4/4	
11.02.2019 05:56	M18-000169	ReusePlates with Preview	ST118711_8-stg. B0 2 0...	100253-Glossy ...	630	880	150.0	4/4	
11.02.2019 06:34	M18-000169	ReusePlates with Preview	ST118711_8-stg. B0 2 0...	100253-Glossy ...	630	880	150.0	4/4	
11.02.2019 07:12	M18-000169	ReusePlates with Preview	ST118711_8-stg. B0 2 0...	100253-Glossy ...	630	880	150.0	4/4	

At the bottom of the interface, there are buttons for 'Intellistart 2', 'Load job part', 'Print', and 'Release job'. The status bar shows '21/66'.

Before you start...

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.

Suitable knowledge of network configuration, time server, Prinect Maintenance Center, Prinect License Server and Prinect Cockpit is recommended to work with a Prinect Workflow System.

There are separate training documents about Prinect 2020

- Prinect Production Manager
 - Prinect Prepress Manager
 - Prinect Pressroom Manager (Analyze Point, Prinect API)
 - Prinect Postpress Manager
- Prinect Portal - Files and Approvals
- Prinect Portal - Plate Pilot
- PDF Toolbox
- Prinect Scheduler
- Prinect Signa Station

Additional Documentation

You can find this document and additional information in:

- **Educate Center:**
http://educate-center.heidelberg.com/ilias/login.php?target=&soap_pw=&ext_uid=&cookies=nocookies&client_id=HEI-e-Learning&lang=en
- **Easy Sales Portal:**
<http://net.heidelberg.com/portals/EasySales/SitePages/EasySalesResultPage.aspx?FilterField1=HDM%5Fx0020%5FES%5Fx0020%5FProduct&FilterValue1=Prinect>
- **Confluence:**
<https://confluence.prinect-lounge.com/display/PP2020/Prinect+2020+Neue+Funktionen>

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.



2018: This feature was implemented in Prinect 2018.



2019: This feature was implemented in Prinect 2019.



2020: This feature was implemented in Prinect 2020.

Before you start...

1 System Configuration

Motivation

To get jobs at the PressCenter from a Prinect Production Manager we have to configure both systems. PressCenter and Prinect Production Manager have to be reachable in the same network.

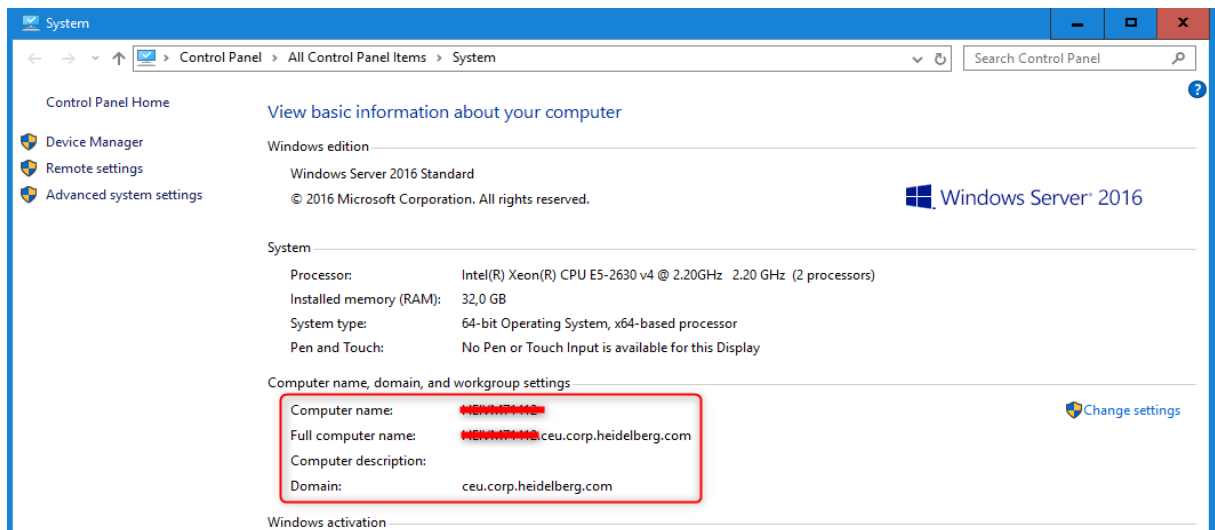
1.1 Prinect Configuration

1.1.1 Network

The Prinect Production Manager Server can be in a **Domain** or **Windows Workgroup**.

We strongly recommend to have a **DNS Server** to prevent TCP/IP - naming conflicts.

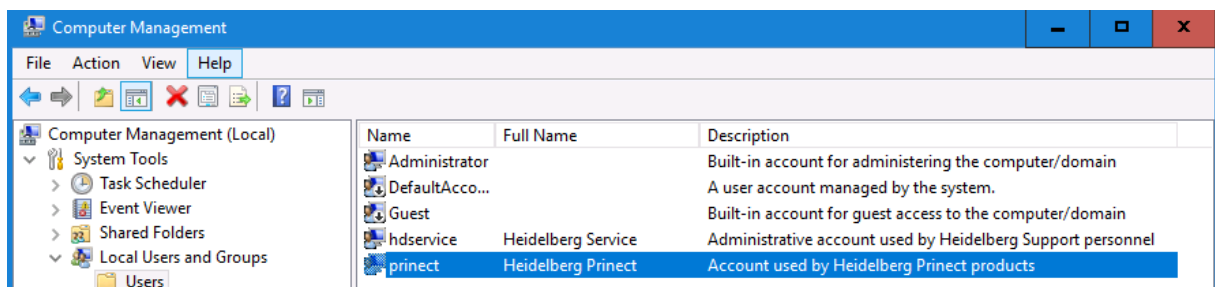
In case you have a Domain Controller the DNS and the Time Server is automatically included.



1.1.2 Prinect Network User

To get access to thumbnails and measurement files we need a network user. "PTConfig" and "PTJobs" at the Prinect Server have to be reachable for the PressCenter.

We recommend to use the default user "prinect". The password for this user is to get by the Heidelberg technician or by customer-IT.



1 System Configuration

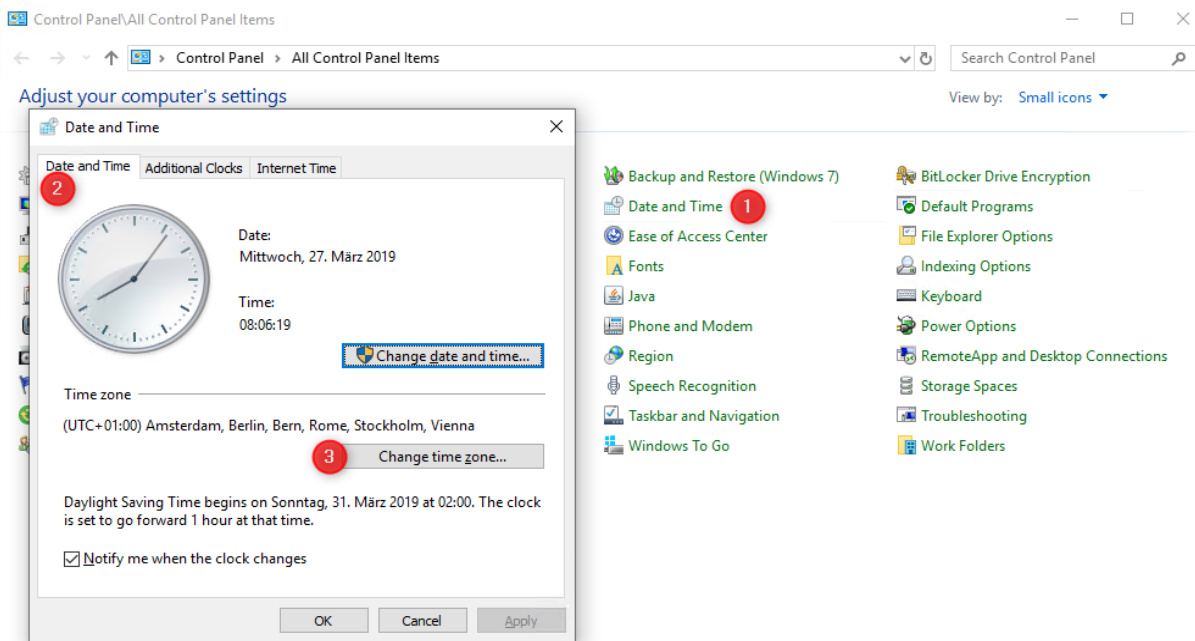
1.1.3 Time Synchronization

We need a Time Server to synchronize the time between all Prinect components:

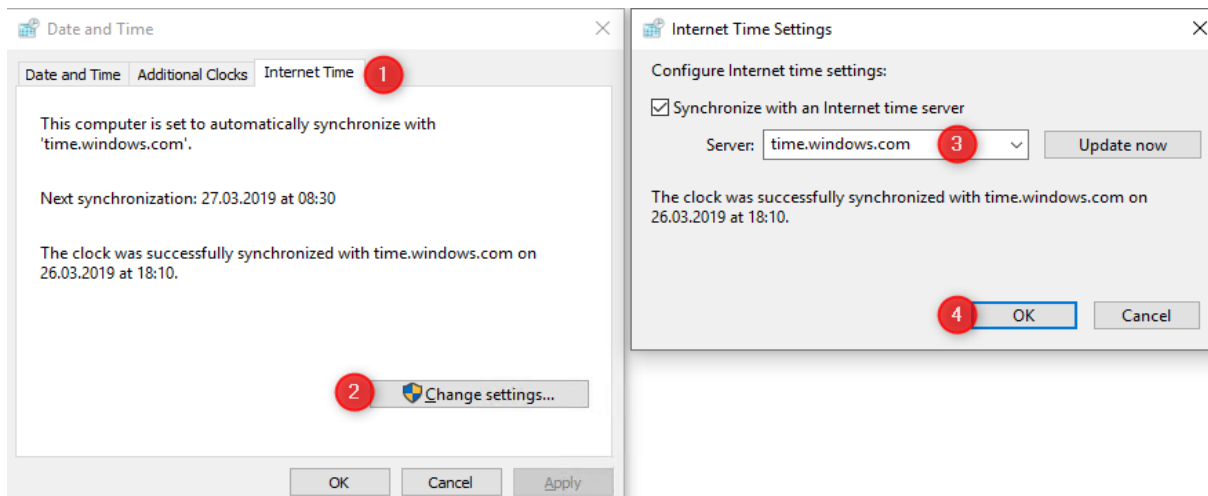
- Prinect Server/Clients (Server, Prinect Portal, Prinect Data Center, Renderer, Shooter)
- Prinect Business Manager Server/Clients
- PressCenter/Data Terminal

Time Zone

We have to define the right time zone.



Time Server - this can be a URL or a IP number of a internal or external NTP-Server.



Note: When the computer is in a Domain (Active Directory) the tab "Internet Time" is not visible, because the computer is automatically time synchronized by the Domain Controller.

1.1.4 Employee

The MDS (Master Data Store) is an MS SQL Database where we store all workflow relevant resources. Some resources are to define for the system configuration:

MDS - System Configuration

- Employees
- Press Devices
- Cost Center

MDS - Workflow resources

- Calibration & Ink Presetting Curve
- Central Color Data Base
- Printing Material
- ...

The Press Operator is an employee and has to Login at the PressCenter or Data Terminal for time sheets, analyzes and job costing. **The ID has to be identically to an existing MIS!**



Note: When a Prinect Business Manager (MIS) is integrated to the system, we have to create Employees in the **Prinect Portal** => Employees are synchronized in Prinect MDS (Master Data Store) and in the Business Manager MS SQL Data Base! This has to be done by an expert!

When we have no Prinect Business Manager integrated, we can create all employees in the Prinect Cockpit.

By default we can Login at the Prinect Cockpit with the User "Administrator" without Password:

Prinect Cockpit: Login 19.10.72.0

User Name: Administrator

Password:

Store Password

Domain:

Servername: Prinect Servername

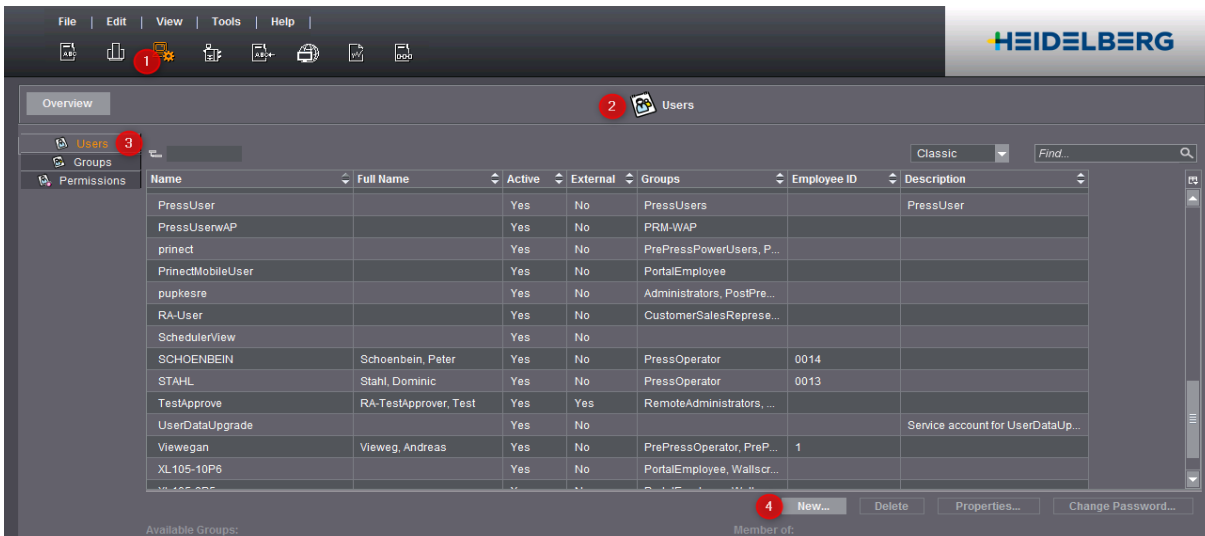
OK Cancel



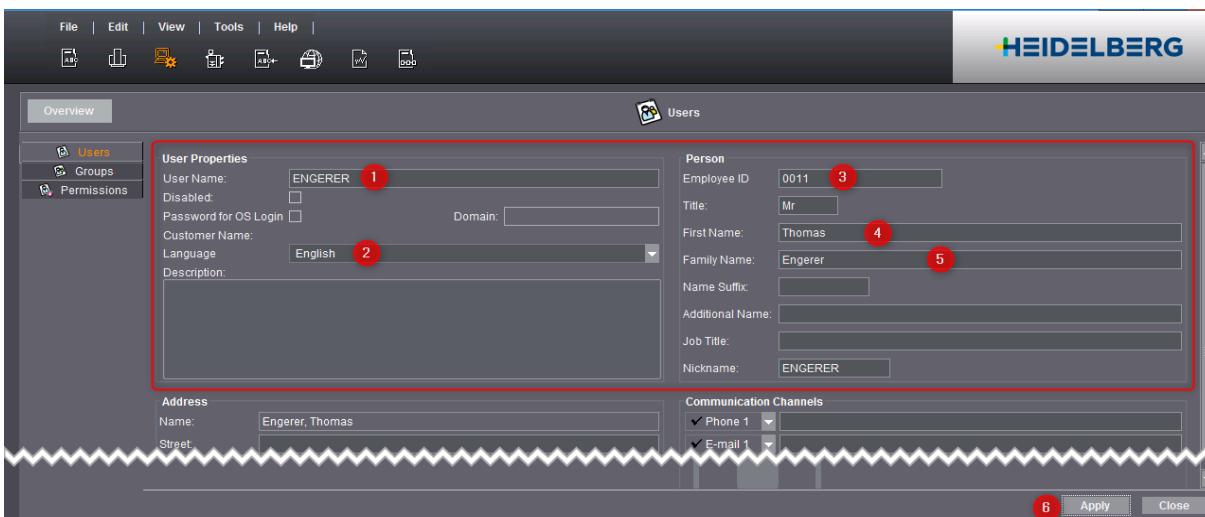
Note: Users and passwords can be different because security reasons! In this case you have to ask the Print Shop Administrator for actual users and passwords.

1 System Configuration

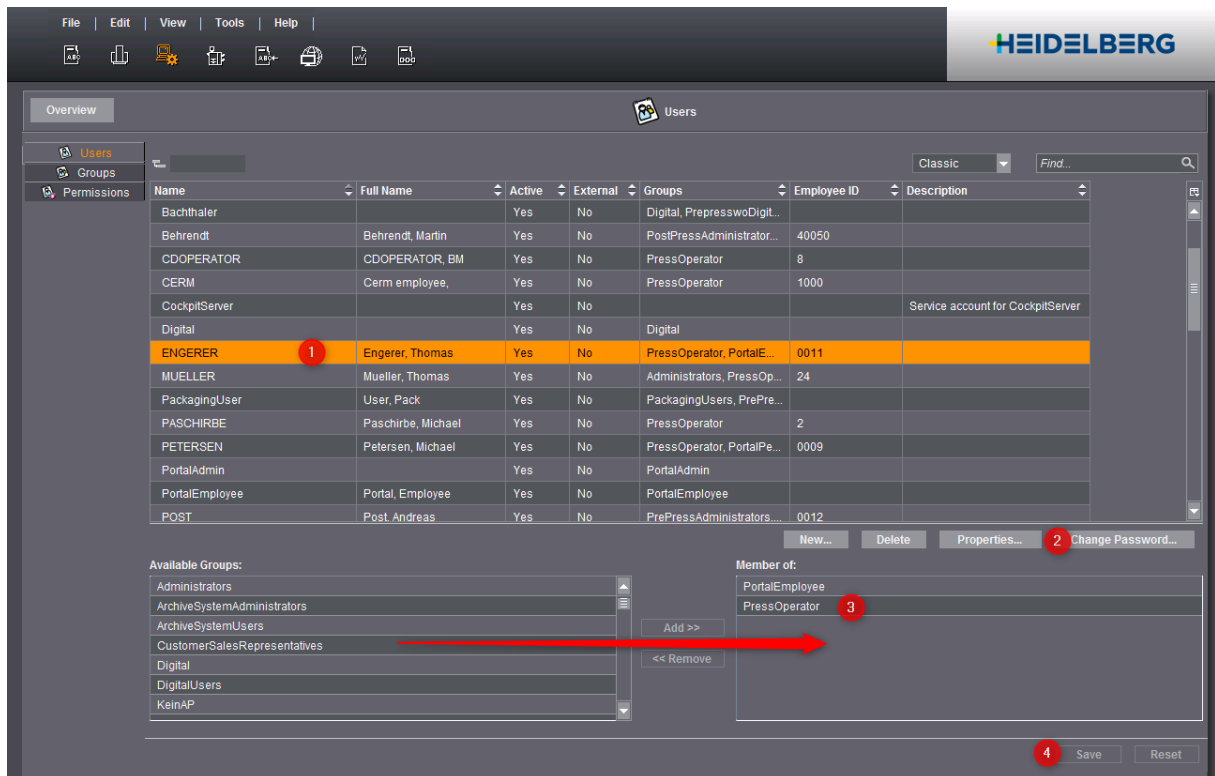
User and employee management in the Cockpit:



This are the minimum required informations for an employee.



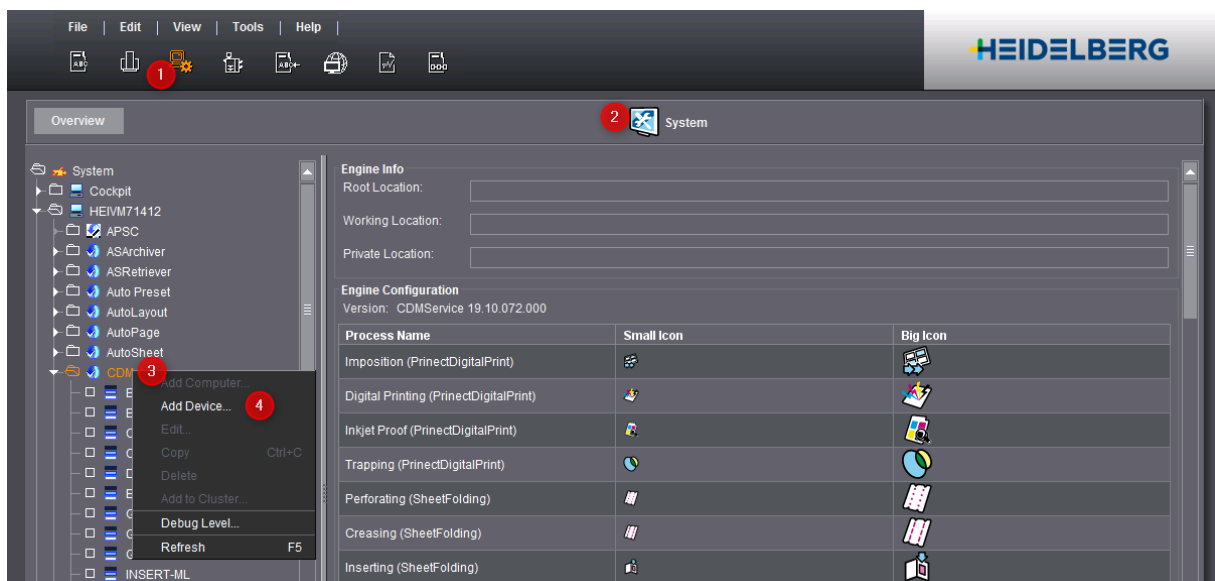
Finally we have to define a password and to assign the user rights "PressOperator".



Note: All employees which are assigned to the User Group "PressOperators" can Login at the PressCenter. A second User Group for PressCenter Login is named "PressAssistants".

1.1.5 Press Device

In the Prinect Cockpit we have to create Press Devices to send Print Presettings to the PressCenter. This is to do in the CDM (Central Device Manager):



1 System Configuration

General

1. Device Name (no blanks, no special funny characters)
2. Device ID (4 numbers)
3. Device Class: Sheetfed Press (PressCenter = Direct connection of the machine)
4. Login for Press Assistants (another employee role)
5. Performance Parameters of the Press (for manual waste sheet and time calculation)
6. Next...

The screenshot shows the 'Device assistant' software interface. The title bar reads 'Device assistant'. The main window is titled 'General'. The configuration fields are as follows:

- Device name *: XL105-8P5
- Device ID *: 4202
- Device class: Sheet-fed press
- Connection: Direct connection of the machine
- Contents of operations list: Show only workable operations
- Time Recording Modes: (empty)
- Book Unscheduled Only to Jobs:
- External:
- Assigning functions:
 - Assistant
 - Operator
 - Multiple operator
- Performance Parameters:
 - Fixed basic time for setup per operation: 6 Minutes
 - Average Production Speed: 13,000 units/h
 - Maximum Production Speed: 18,000 units/h
 - Fixed waste per operation: 50 Copies
 - Variable waste per operation: 1.0 % of the target quantity

At the bottom right, there are buttons for 'Cancel', 'Back', 'Next', and 'Finish'.



Note: When a MIS (Management Information System) is available in the Workflow, we have to synchronize all settings to the MIS!

Machine

1. Press Selection: Press model
2. Press Serial number: To define manually, automatically synchronized with >=P2019.1 and PC19A
3. Language: Shop Floor Data Collection buttons at the PressCenter
4. Version: PressCenter version - different features are related to the PressCenter version
5. Workplace ID: Keep it easy - WPI ID should be consistent to the Device ID
6. Axis Control / Inpress control: Path for the measurement files from Inpress Control. This path is automatically selected - please let it in this location!
7. Next...



Note: The Serial number of the press is to find at the PressCenter here. With Prinect 2019.1 we synchronize the PressCenter serial number automatically when the PressCenter is booting.

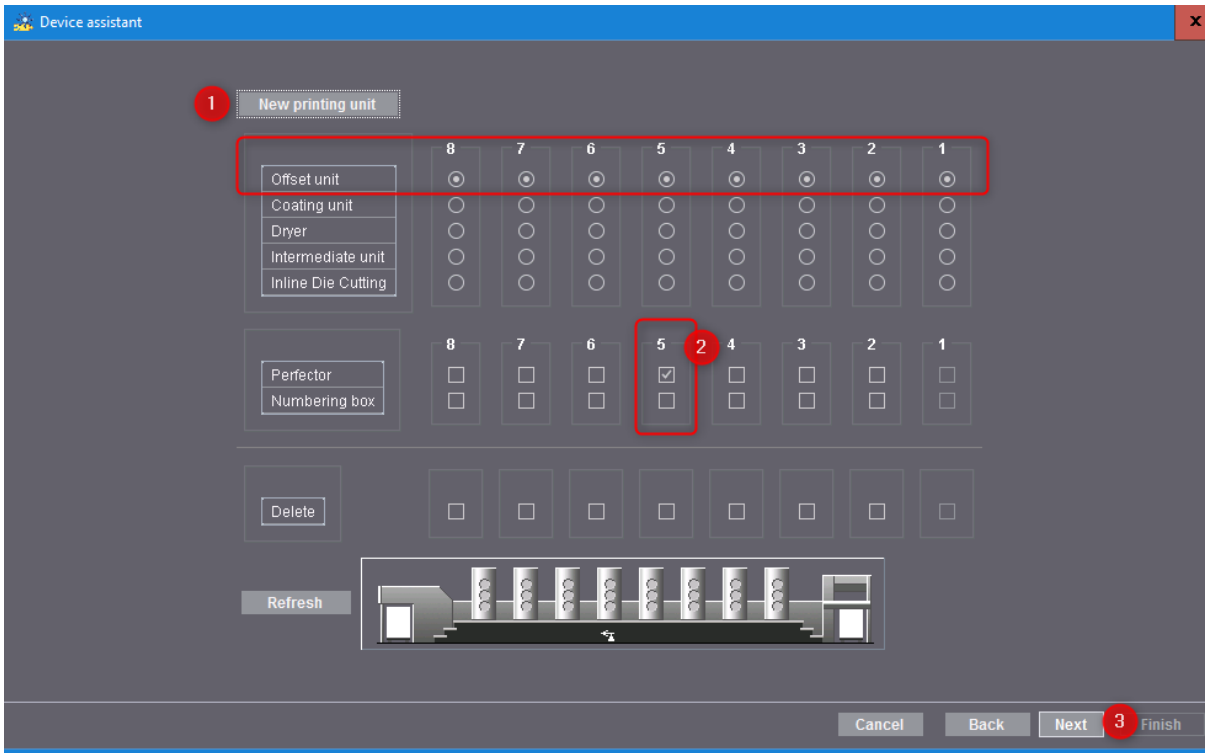
1 System Configuration

Press Configuration

Before this dialog a small dialog pops up and is asking for the number of print units. We can increase or delete units in this dialog too: New printing unit - Delete (a selected unit).

Coating units and Perfector is to define in this dialog too.

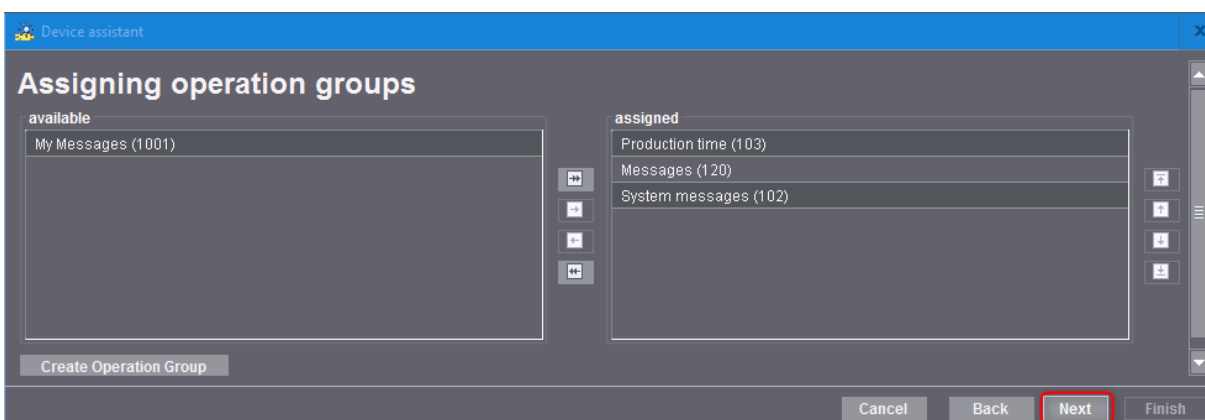
This configuration of the press has influence to Cockpit warning about impossible press runs.



Operation Groups

The default Operations should be assigned - Shop Floor Data Collection buttons at the PressCenter:

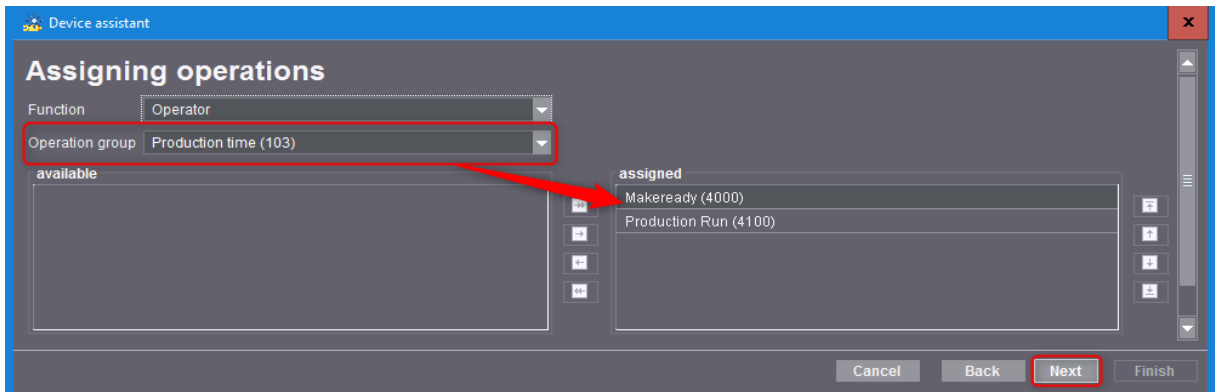
- Production Time, Messages, System messages



Note: The customization of Shop Floor Data Collection buttons has to be done by an Prinect expert and it's not included as a standard service!

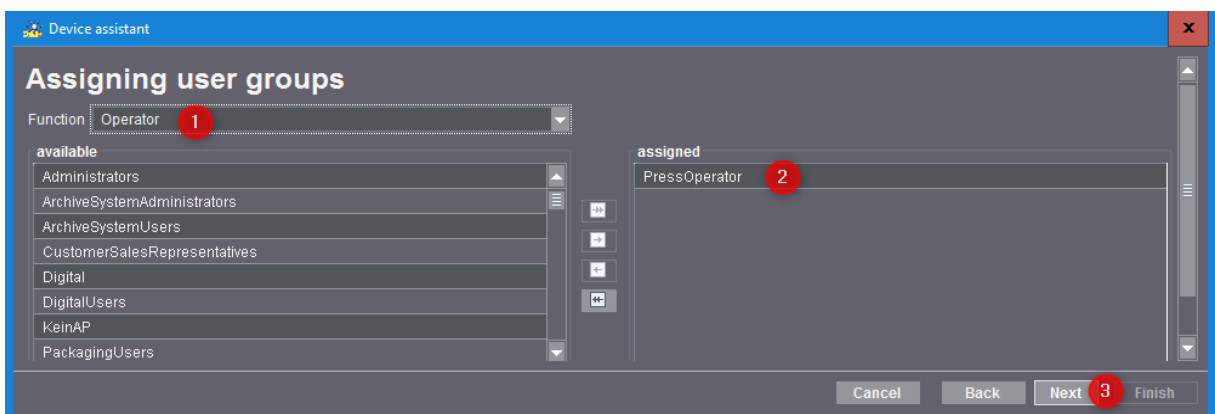
Assigned Operations

In the last tab we have assigned Operation Groups - here we can see the assigned Operations.

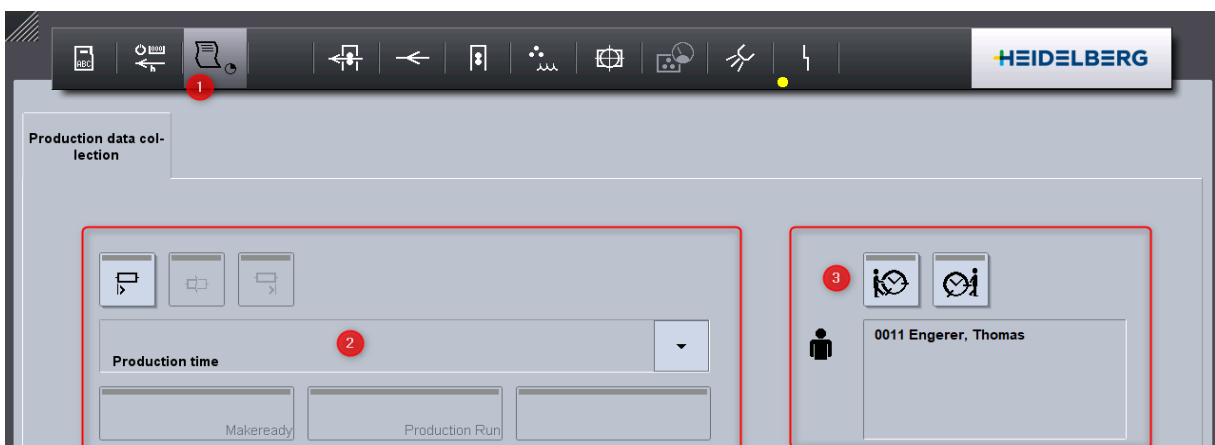


Assigned User Groups (Employees)

In the chapter **1.1.4 Prinect Employee** we have created employee "Thomas Engerer" and we have assigned him to the User Group "PressOperators". All employees which are assigned to this group are after this chapter available at the PressCenter to Login.



i **Production Data Collection:** Operation Groups, Operations and a logged in Press Operator at PressCenter.



1 System Configuration

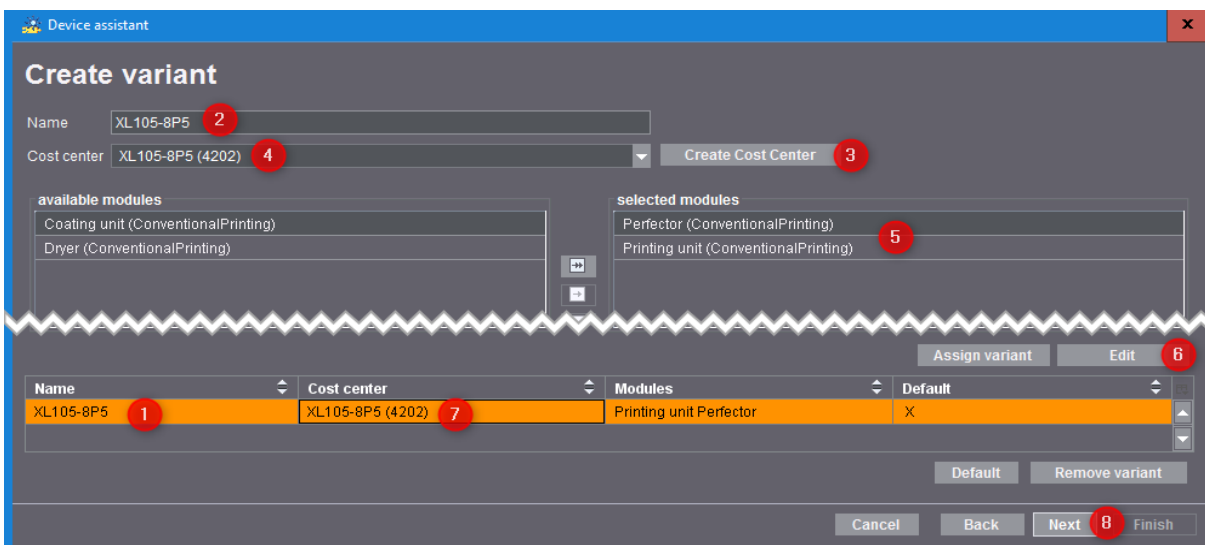
1.1.6 Cost Center

In the device wizard we can define a cost center for PressCenter log in and Job costing to the MIS.

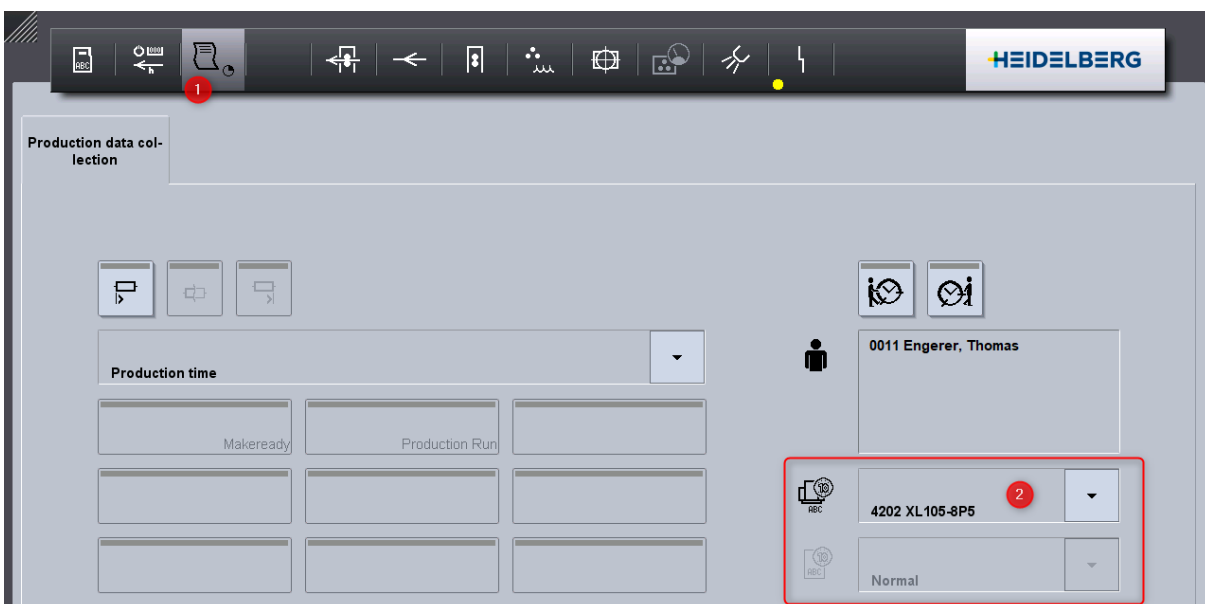
Create Variant

1. We have to select the variant
2. Copy the Name...
3. ...and create a Cost Center with the same Name and Device ID (in a sub-dialog).
4. Assign the existing modules of the machine...
5. ... and modify the variant.

Result: A variant with a identical Cost Center and correct modules.

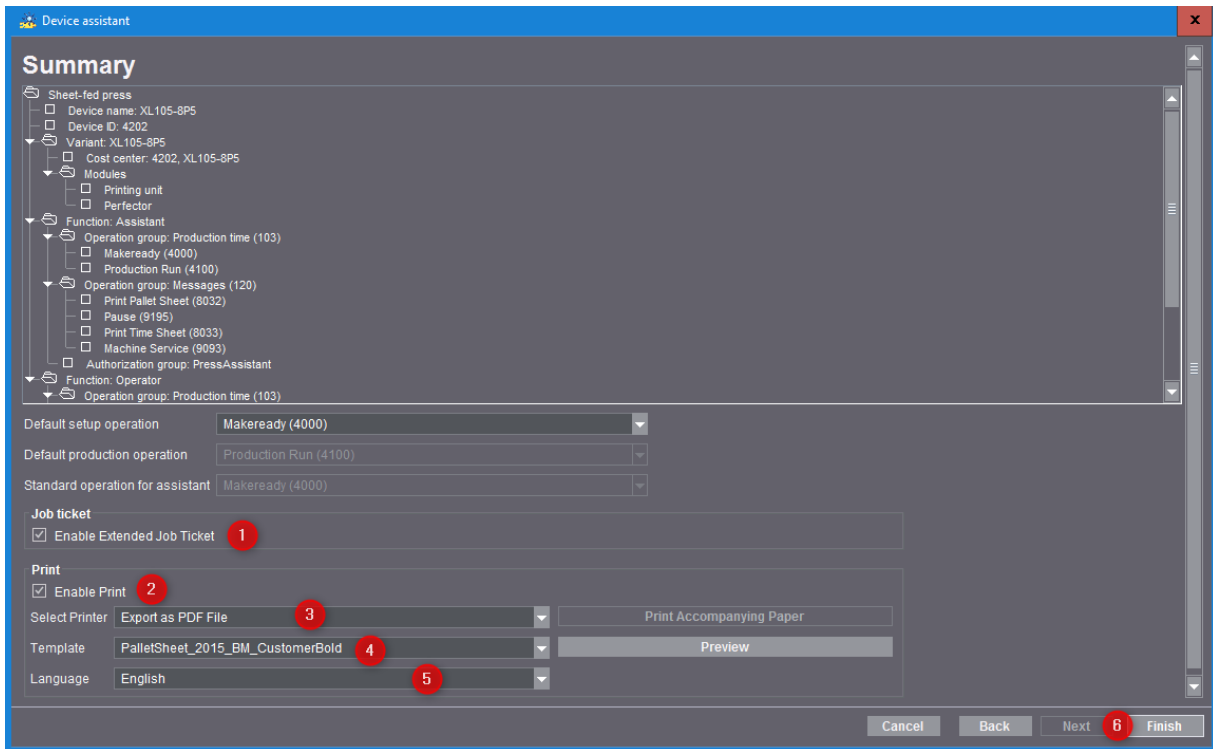


Note: The Cost Center selection at the PressCenter.

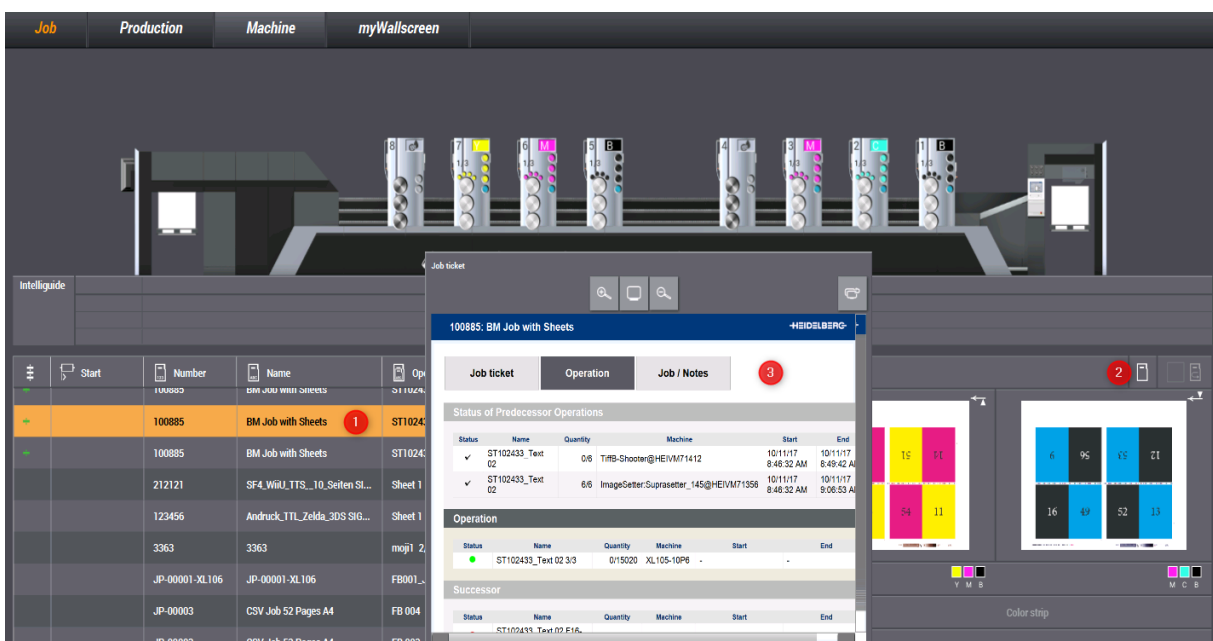


Summary

1. Job Ticket - Create Extended Job Ticket: Displayed at the Press Center.
2. Print - Enable Print: Pallet sheets and time sheets can be activated here.



Note: The extended Job Ticket is displayed at the PressCenter in 3 tabs: Job Ticket - Operations - Job Notes.
A Job Ticket is only available when a MIS is connected to the Heidelberg system.



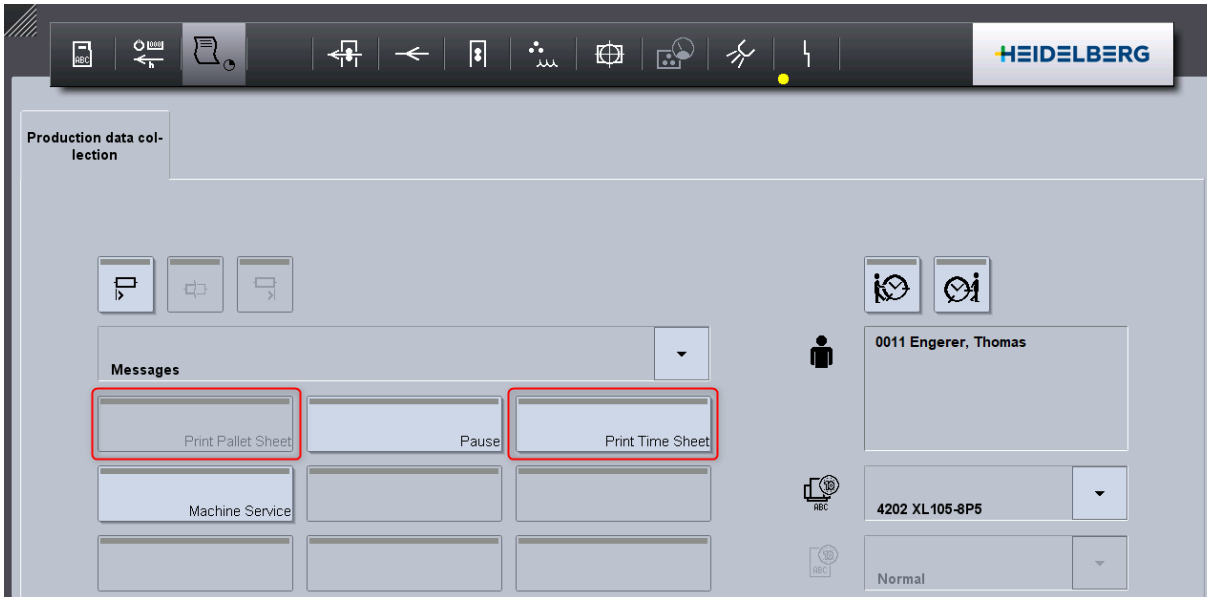
1 System Configuration



Note: The PDF File is to find after printing in a Folder at the Prinect Server:
[\\Prinect-SERVERNAME\PTJobs\AD-PDF\"DeviceID\".](#)

A real printer is only to configure by a Heidelberg Prinect expert.

Pallet sheets and Time Sheets are to print out in the PressCenter or at the Wallscreen Widget.



The Pallet Sheet can look like this and is to print after every job change.

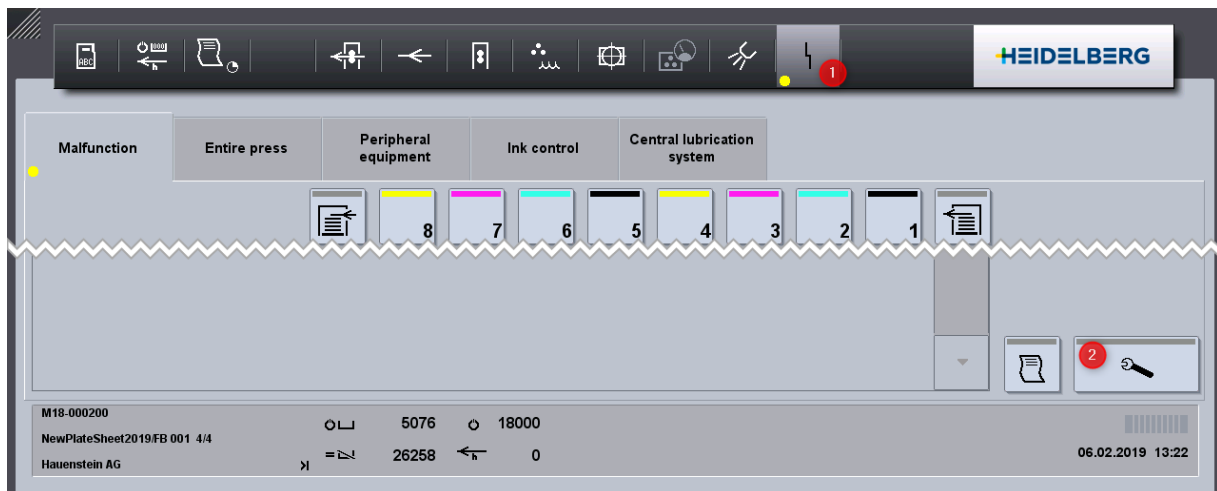


1.2 PressCenter Configuration

The PressCenter can be not in a Domain, because we have to ensure that the local user rights at a PressCenter are not controlled by the Domain!

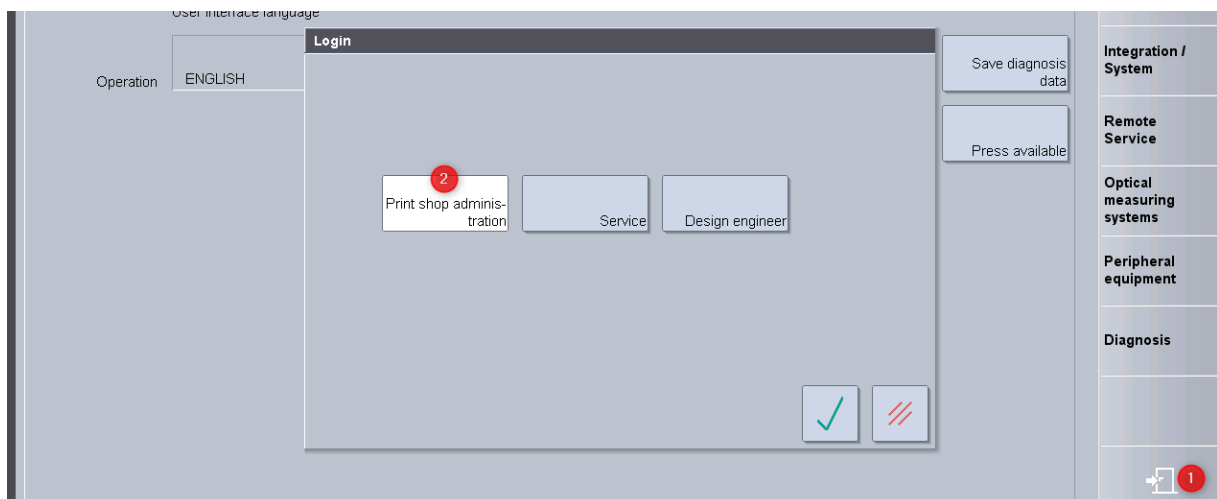
1.2.1 Login as a Print Shop Administrator

To make changes at the PressCenter it is necessary to login in a Service Mode.



The Password for the Print shop administrator is: 000

This user rights are high enough to do all settings for a successful Prinect connection.



The Login as "Service" or "Design Engineer" is only possible for a Heidelberg Technician with a key-file on a USB stick:

<https://www.primectonlineportal.heidelberg.com/prinectUser/userarea/main.xhtml?dswid=7362>

1 System Configuration

1.2.2 Network & Time Synchronization

The network settings at the PressCenter have to be done by the Heidelberg technician together with customer IT!

We strongly recommend to have a DNS and a DHCP Server with a reserved IP for the Press-Center!

Example:

The screenshot shows the Heidelberg PressCenter configuration interface. The top navigation bar includes icons for home, back, forward, search, and other functions, along with the HEIDELBERG logo. The main menu has tabs for 'Prinect Konfiguration', 'Netzwerk-einstellungen' (marked with a red '4'), 'Remote Service', 'Regional', and 'Benutzer'. The 'Netzwerk-einstellungen' tab is active, displaying a table of network parameters. A red '1' is visible in the top right corner of the interface. On the right side, there is a vertical sidebar with various configuration categories, including 'Integration / System' (marked with a red '3') and 'Diagnose' (marked with a red '2').

Art	Parameter	Wert
TCP/IP	Computer-Name	HFS070000002114
TCP/IP	State	on
TCP/IP	Mode	dhcp
TCP/IP	Address	10.54.16.187
TCP/IP	Mask	255.255.255.0
TCP/IP	Gateway	10.54.16.1
DNS	DNSServer	10.55.161.199
DNS	DNSDomain	ceu.corp.heidelberg.com
DNS	DNSSuffix	ceu.corp.heidelberg.com
WINS	WINSServer	
WINS		
NTP	NTPServer	10.50.198.62
Domänen und Arbeitsgruppen	Liste der Domänen und Arbeitsgruppen	
HTTP-Proxy Konfiguration	Adresse Proxyserver	proxy 8080
HEIRES Tunnelserver	IP-Adresse Tunnelserver	
HEIRES Daten-Server	IP-Adresse Datenserver	
RemoteShutDown	RemoteShutDown	

Ändern

NTP Server

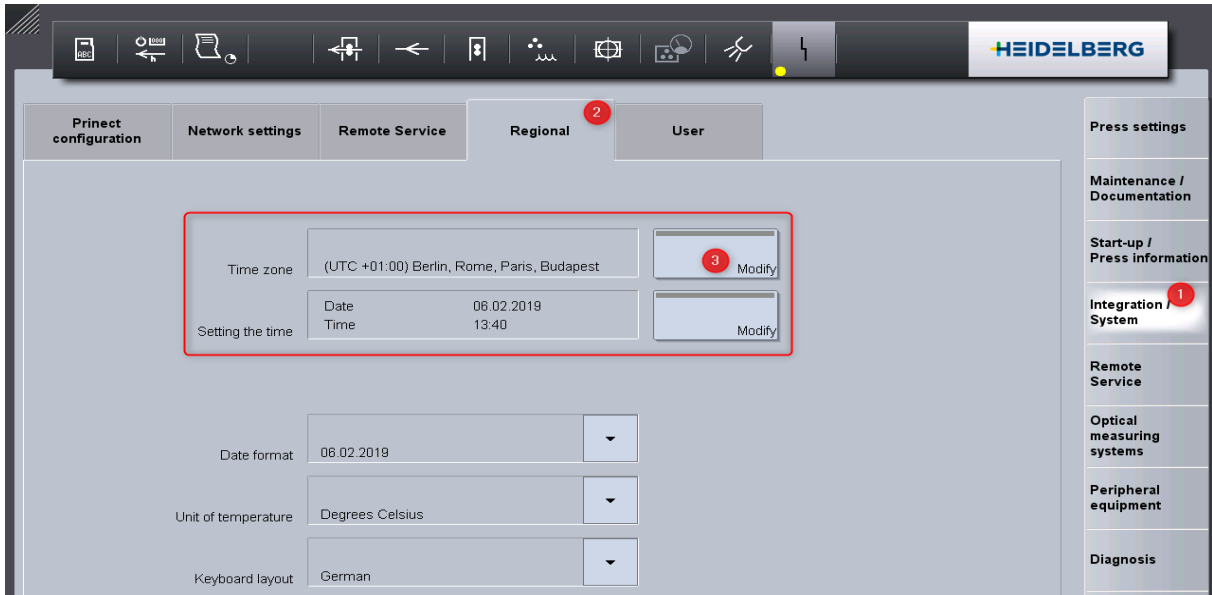
- NTP: The NTP-Server has to be identical to the NTP-Server of the Prinect Server
- NTP: We recommend to use a internal NTP-Server
- NTP: An external NTP-URL (pool.ntp.org) is only working when a DNS Server is configured

HEIRES - Remote Service

- HEIRES: For remote access the PressCenter is automatically asking for "ping heires-device.heidelberg.com". **Only when no DNS is available** we have to define the actual IP numbers
 - HEIRES Tunnel: 194.31.235.38 (17.07.2019)
 - HEIRES Data: 194.31.235.36 (17.07.2019)

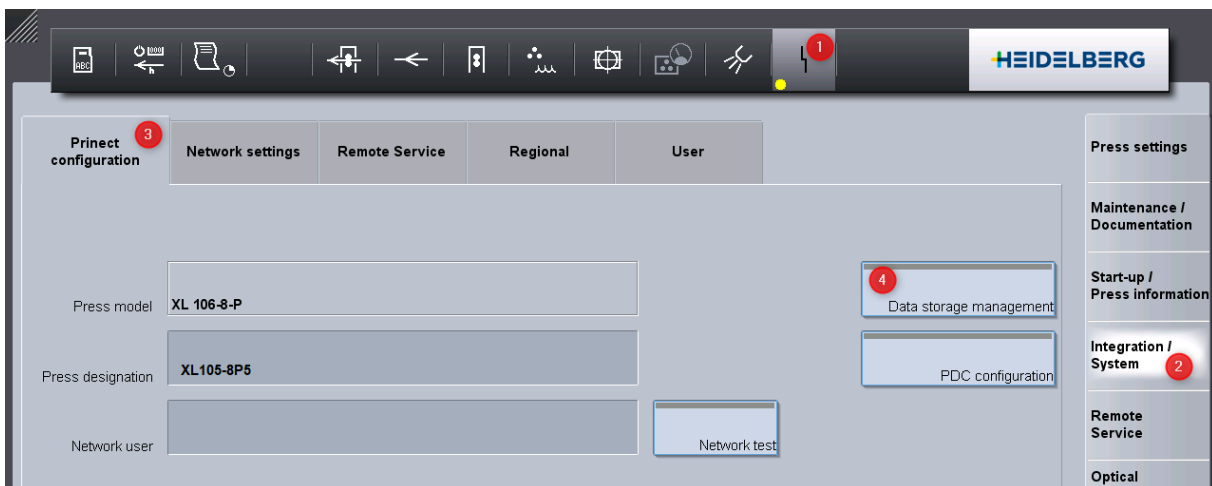
Time Zone

The time zone is additionally to define to a NTP-Server (network time server) to guarantee the time synchronization. As an example: In Brazil they have 4 different time zones!



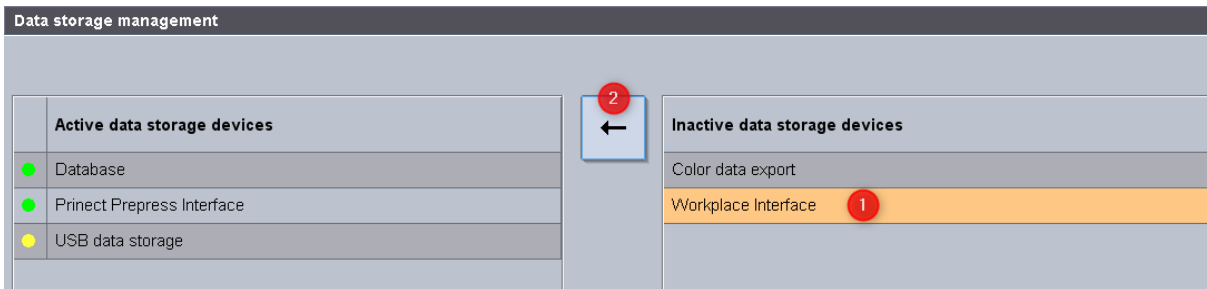
1.2.3 Storage Manager - Press Device

In the Storage management we can configure network connections:

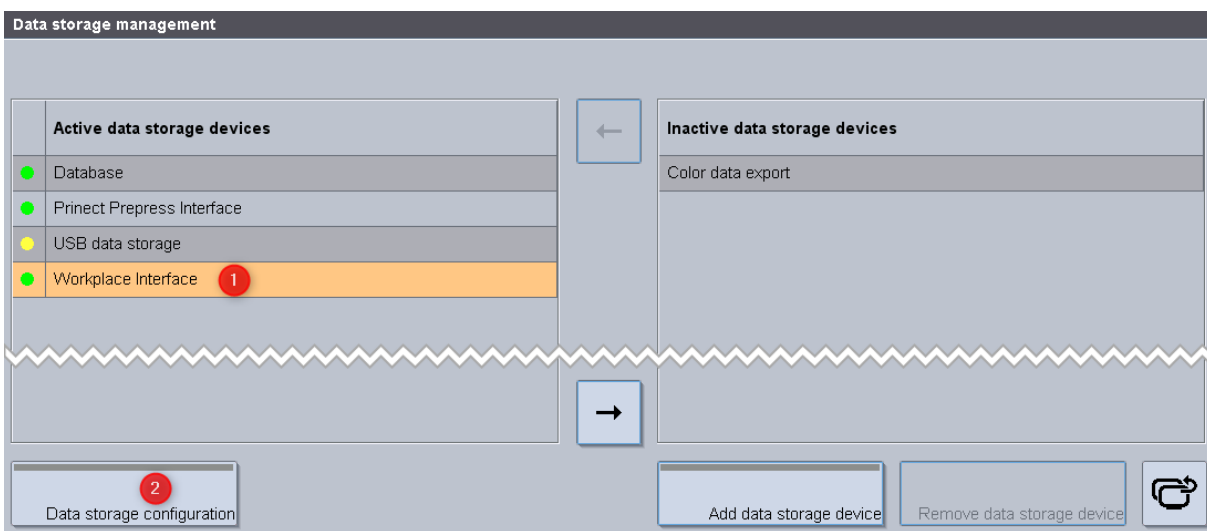


1 System Configuration

We have to activate "Workplace Interface" (default name) - the name could be different!




In the Data storage configuration...



We have to define:

1. Name of the storage device (if there is no value defined it is named "Workplace Interface")
2. The WPI ID of the CDM Device
3. Prinect Server Name

Designation	Value
Name	Prinect 1
Workplaceld	4202 2
Server	10.10.1.112 3
Port	508
CodePage	1252
JobNameElement1	PRODNAME
JobNameElement2	PRODNO
JobNameElement3	ORDERNAME
JobNameSeparator	''
RepeatDataSelection	<input checked="" type="checkbox"/>



1 System Configuration

1.2.4 Storage Manager - Color Data Export

We can get a Quality Report from Heidelberg Measurement Systems

- Easy Control
- Axis Control
- Inpress Control

A Quality Report is displayed in the Cockpit:

The screenshot displays the Heidelberg Cockpit software interface. The top menu bar includes File, Edit, View, Tools, and Help. The main window is divided into several sections:

- Navigation:** Machines, Jobs (2), Employee, Statistics, Performance Report.
- Job Information:** Job number, Job Name: quality, Customer name: Default.
- Operation List:** A table showing operations. The selected row is: FB 001 4/4 (3), Quality Report PT2, Printing, XL105-8P5, Finished.
- Operation Evaluation:** A section with tabs for Operation evaluation, Operation protocol, Operation progression, and Quality (4).
- Qualifiers:** Report Selection, Summary, OK sheet (Front: 43 / 98 (#5), Back: 68 / 123 (#6)), Print standard (ISO 12647-2_2007 FograWB-AV).
- Quality Report (5):** A detailed report titled "Operation Quality - Summary" with an "Analyze" button. It includes job details and two tables for color measurements.

Table 1: Measurement Number: 5 (OK)

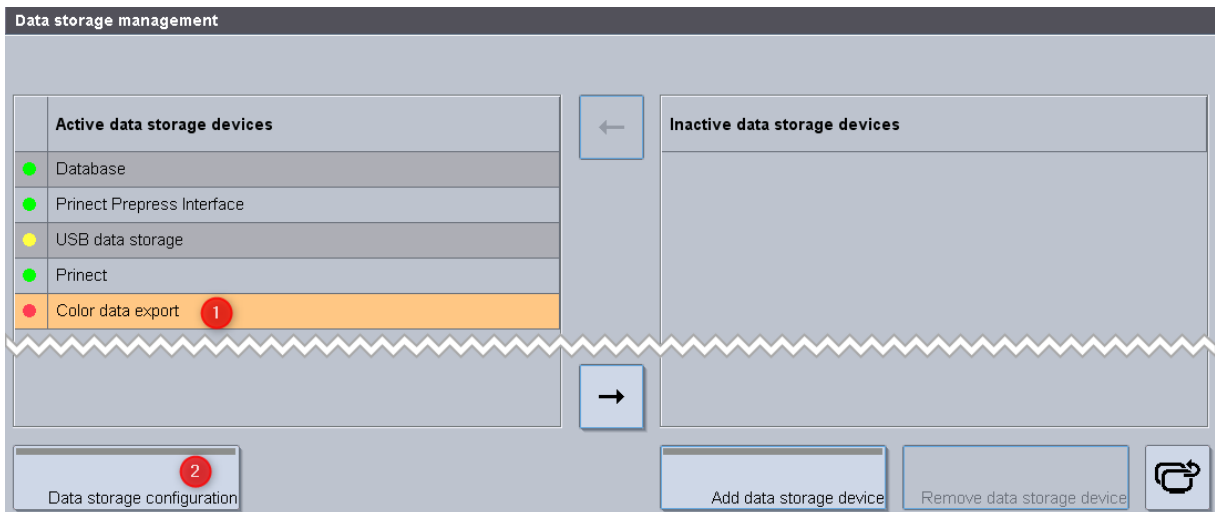
	Black		Cyan		Magenta		Yellow								
	1	2	1	2	1	2	1	2							
ΔE	D	2%	D	20%	ΔE	D	20%	80%							
2.50	1.80	16.0	14.0	2.48	1.32	11.0	10.0	3.72	1.21	11.0	11.0	4.13	1.44	14.0	13.0

Table 2: Measurement Number: 6 (Error)

	Black		Cyan		Magenta		Yellow								
	1	2	1	2	1	2	1	2							
ΔE	D	2%	D	20%	ΔE	D	20%	80%							
2.50	1.79	15.6	13.0	2.47	1.31	11.0	8.0	3.71	1.22	11.0	11.0	4.13	1.44	14.0	14.0

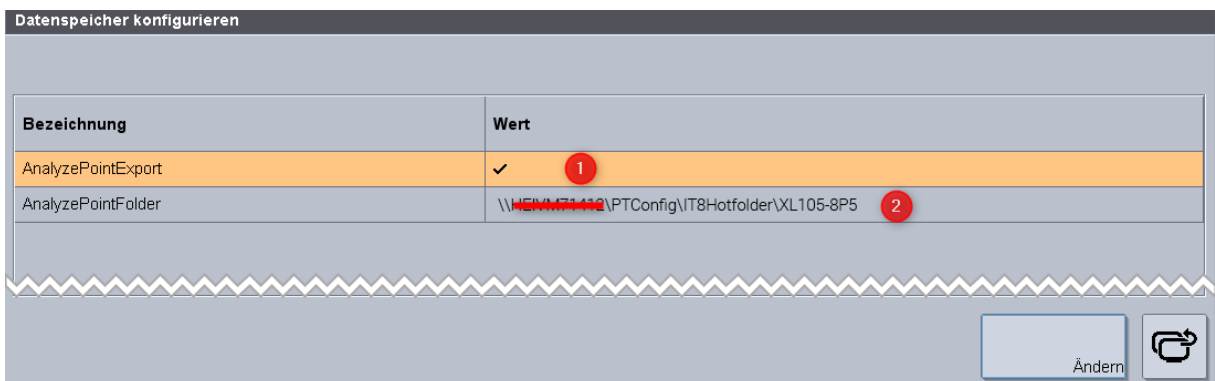
Page 1 of 3
Updated: 08.02.19 09:37

We have to activate the storage device "Color data export".

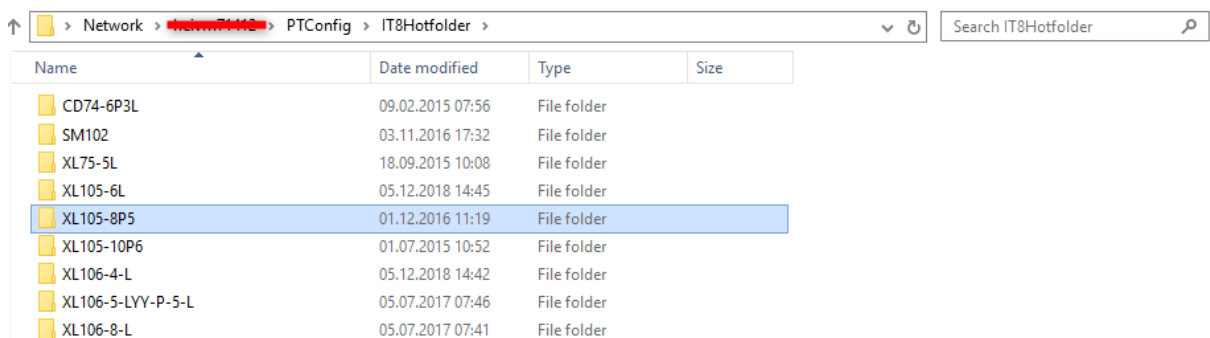


We have to

1. activate Analyze Point Export
2. select the Press-Device folder at the Prinect Server (created in chapter 1.1.5)



Note: In the IT8Hotfolder we can find all Presses with measuring devices:



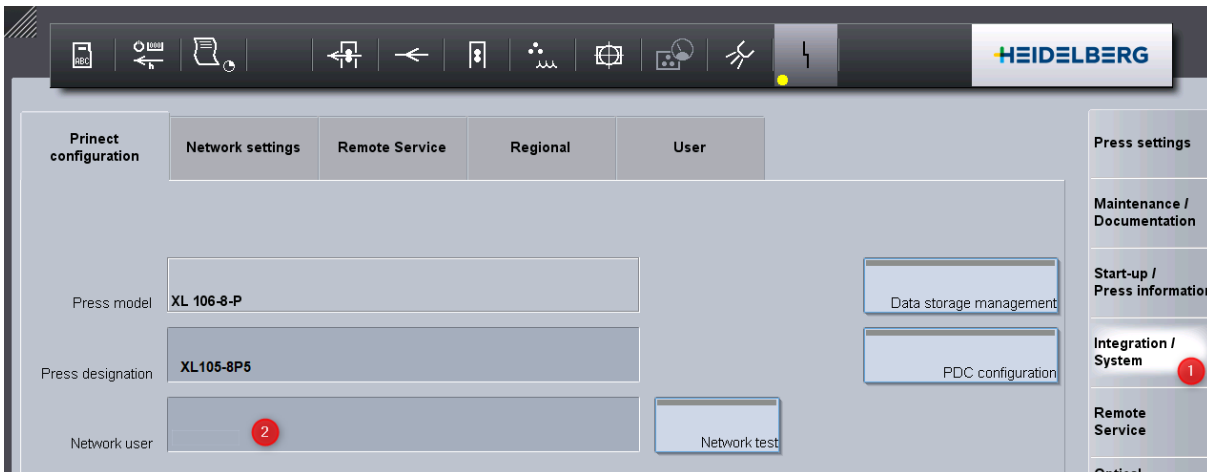
Note: A reboot of the PressCenter is required after this setup.

1 System Configuration

1.2.5 Prinect Network User

To get access to thumbnails and measurement files we need a network user. We recommend to use the default user "prinect".

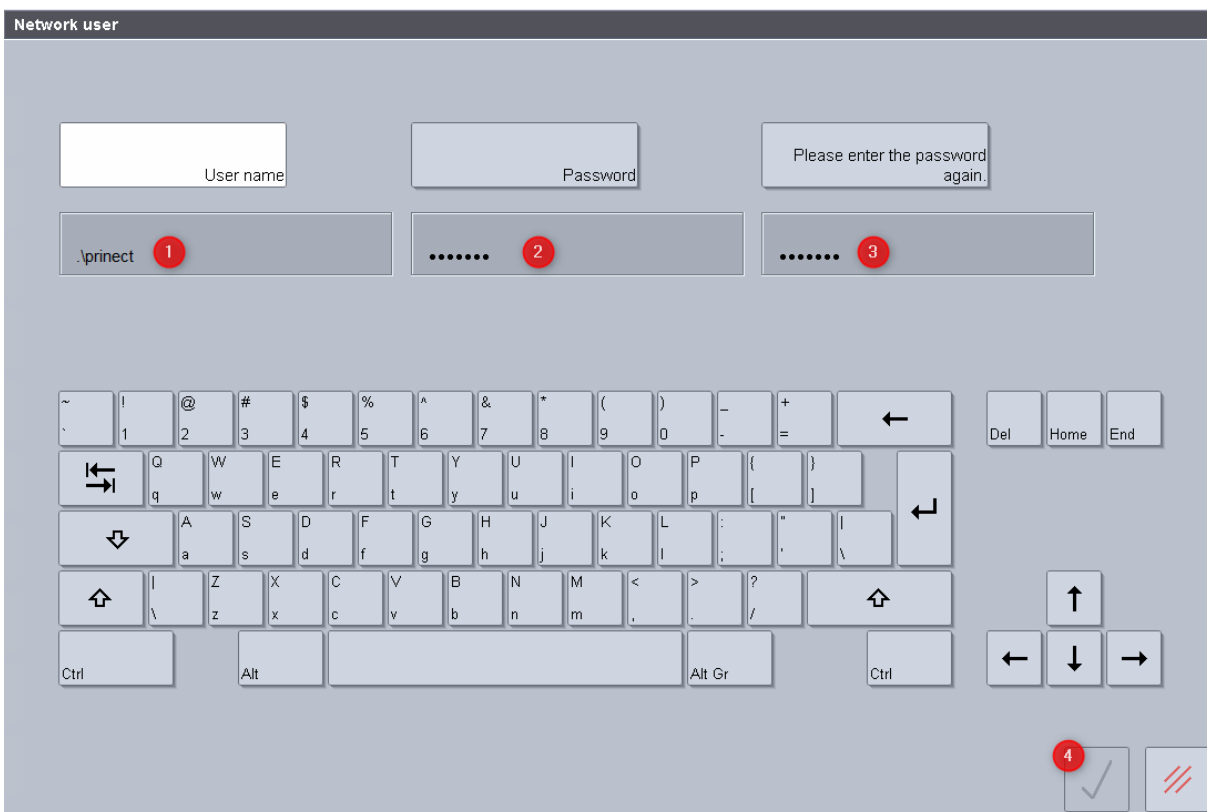
The password for this user is to get by the Heidelberg technician or by customer-IT.



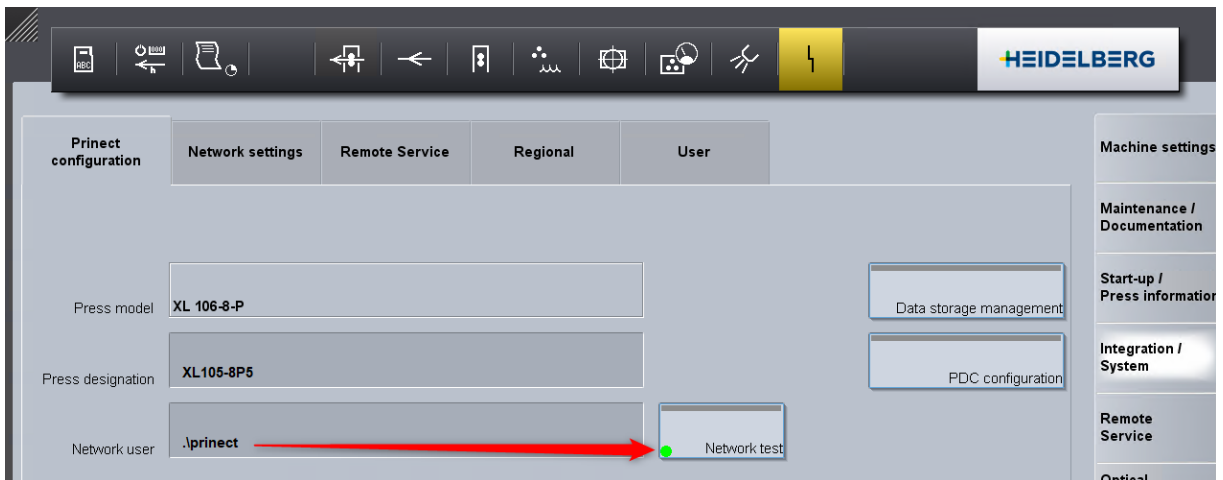
Examples for a Prinect network user

Local User: **.\ User name** or for

Domain User: **Domain name \ User name**

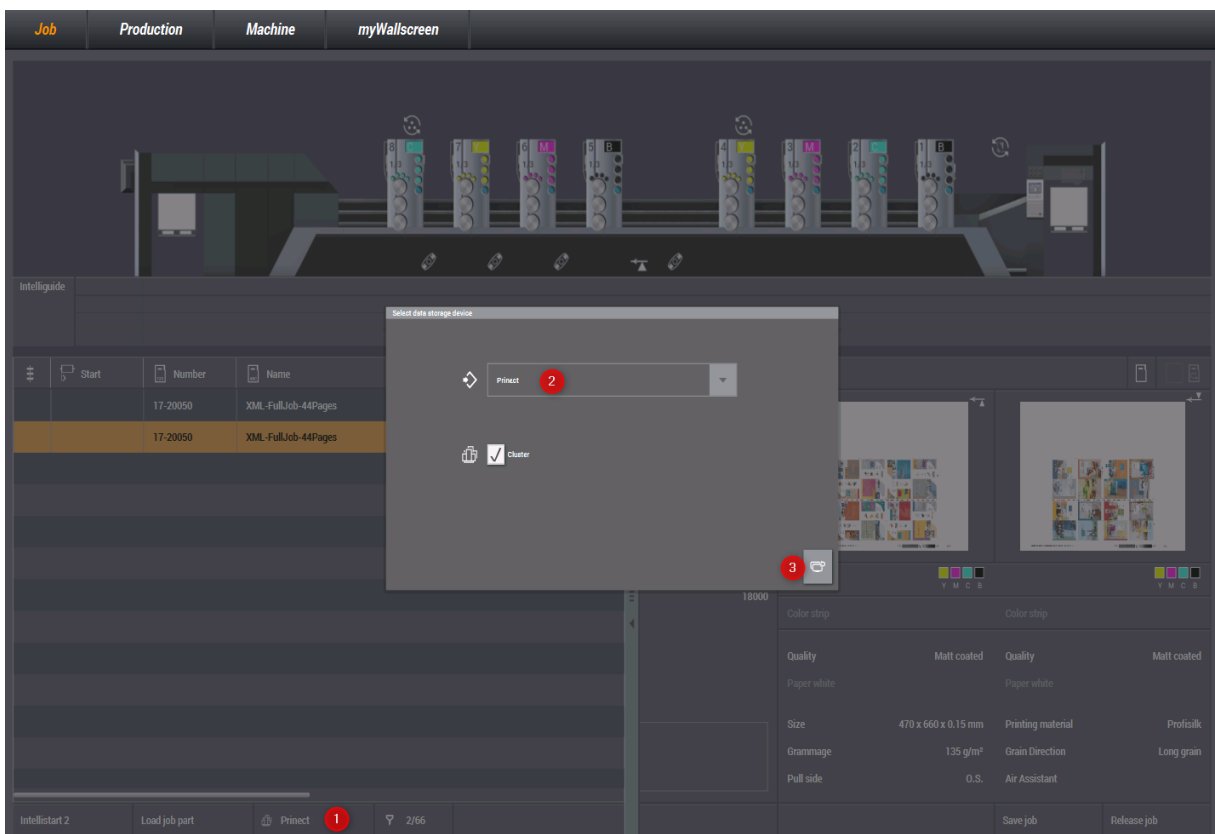


Result when the user has network access to the Pressroom Manager.



1.2.6 Test of the Storage Configuration

When the "Princt Storage is reachable without any error messages the PressCenter is connected to the Princt System.



Now we can load Princt jobs from the Storage after we have created Jobs in the Cockpit

1 System Configuration

2 Workflow Resources

Motivation

The MDS (Master Data Store) is an MS SQL Database where all workflow relevant resources are stored.

Some resources we have configured for the system configuration, some we have to define for the job workflow.

MDS - System Configuration

- Employees
- Devices
- Cost Center

MDS - Workflow Resources

- Calibration & Ink Presetting Curve
- Central Color Data Base
- Printing Material
- ...

2.1 Calibration & Ink Presetting Curve

This chapter is only relevant for the full integrated workflow with Prinect Prepress (chapter 3).

Motivation

Calibrations are to create for different screening systems to standardize the dot gain.

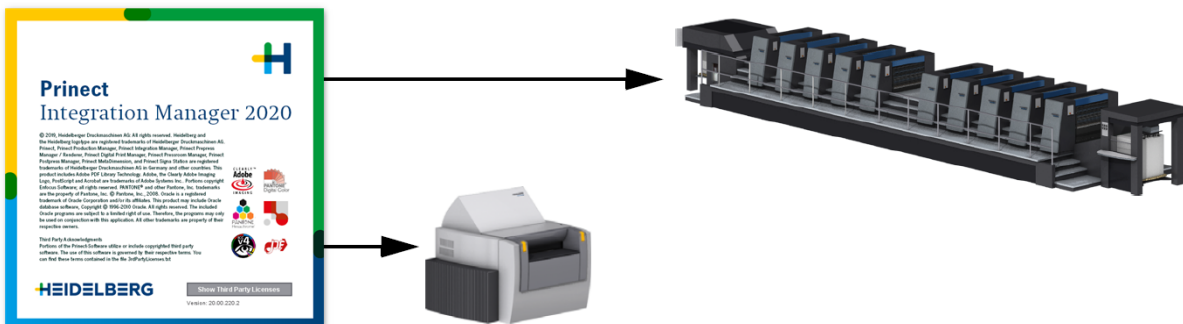
In prepress we can define ink series in the calibration. These ink series are automatically selected as ink presetting curves at the PressCenter job and are calculating the ink zone specific settings at the ink units.

Description

The synchronization has to be configured in "Calibration Manager", "Cockpit" and "PressCenter".

Example in this document:

1. Calibration Manager - Ink serial "STAR"
2. Calibration Manager - Process Calibration
3. Cockpit - ImpositionOutput with calibration "STAR"
4. PressCenter - Ink serial "STAR"
5. PressCenter - Load a job => STAR is automatically preselected



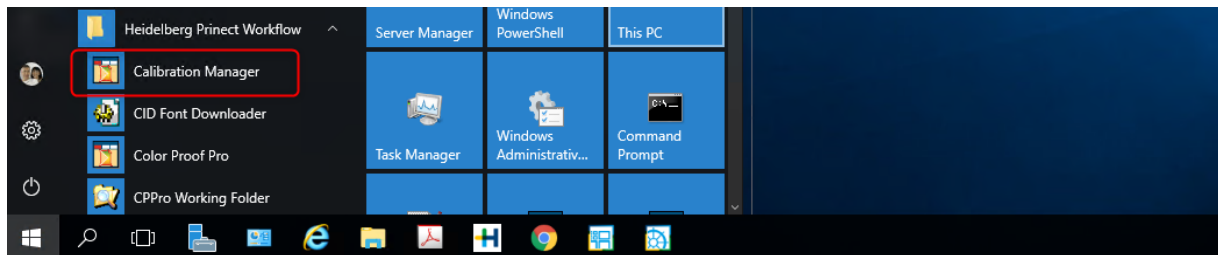
2.1.1 Calibration Manager & Ink Serial "STAR"

Motivation

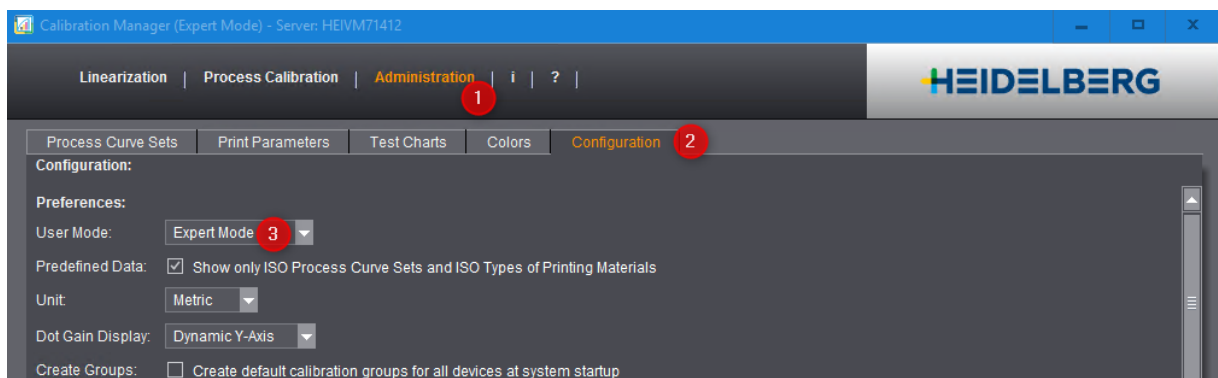
In the Calibration Manager we can define Ink serials and reference them in an calibration.

Description

At the Prinect Server we can start the Calibration Manager.

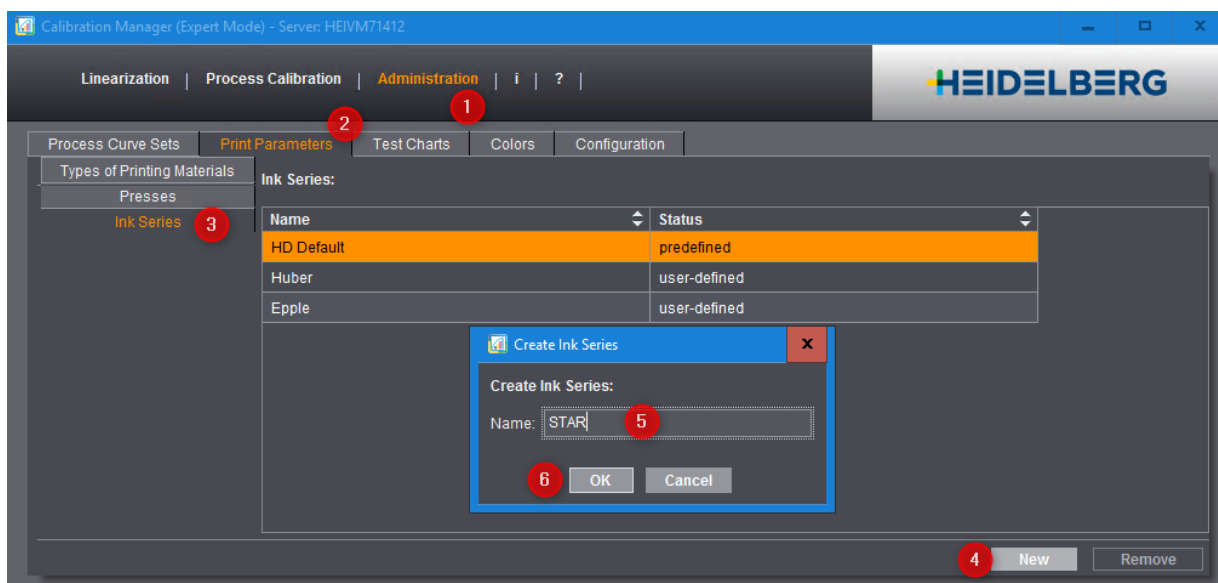


At first we should define the "Expert Mode".



In Administration > Print Parameters > Ink Series we can create a new ink serial.

The name is case sensitive and will be synchronized to PressCenter Ink serials.



2 Workflow Resources

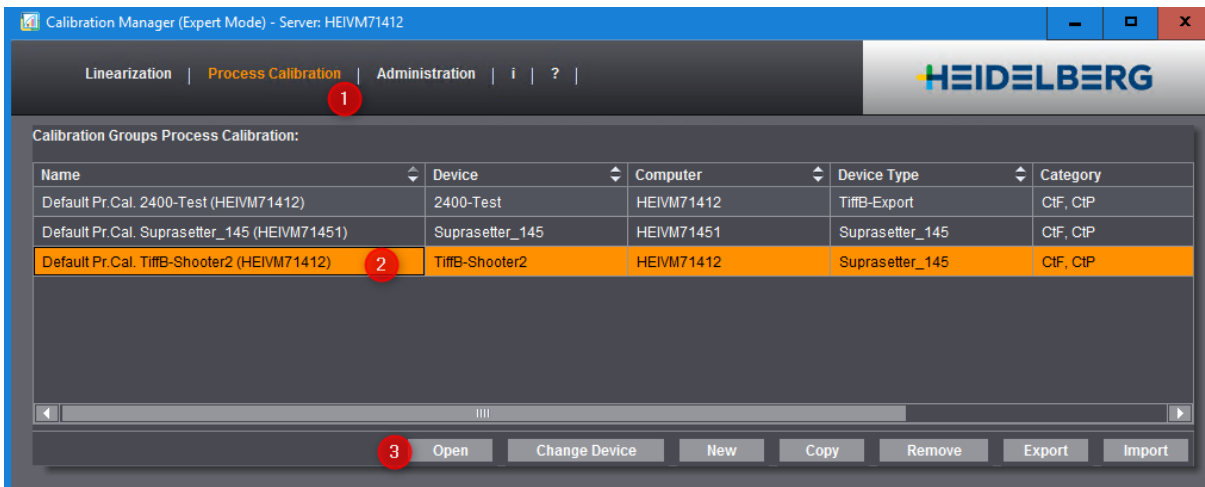
2.1.2 Calibration Manager - Process Calibration



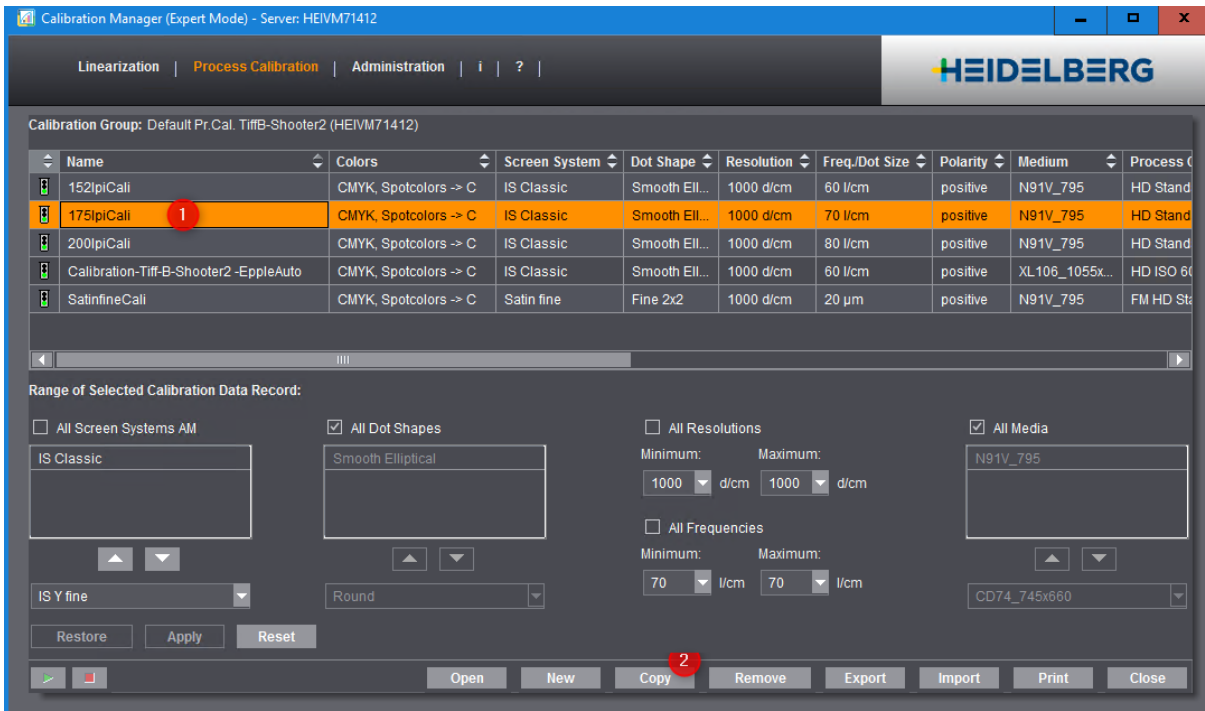
Note: Before we change calibration settings we should make a Backup via Export!

We have to open the calibration group of the device, which we are using later in the "ImpositionOutput" sequence for plate output:

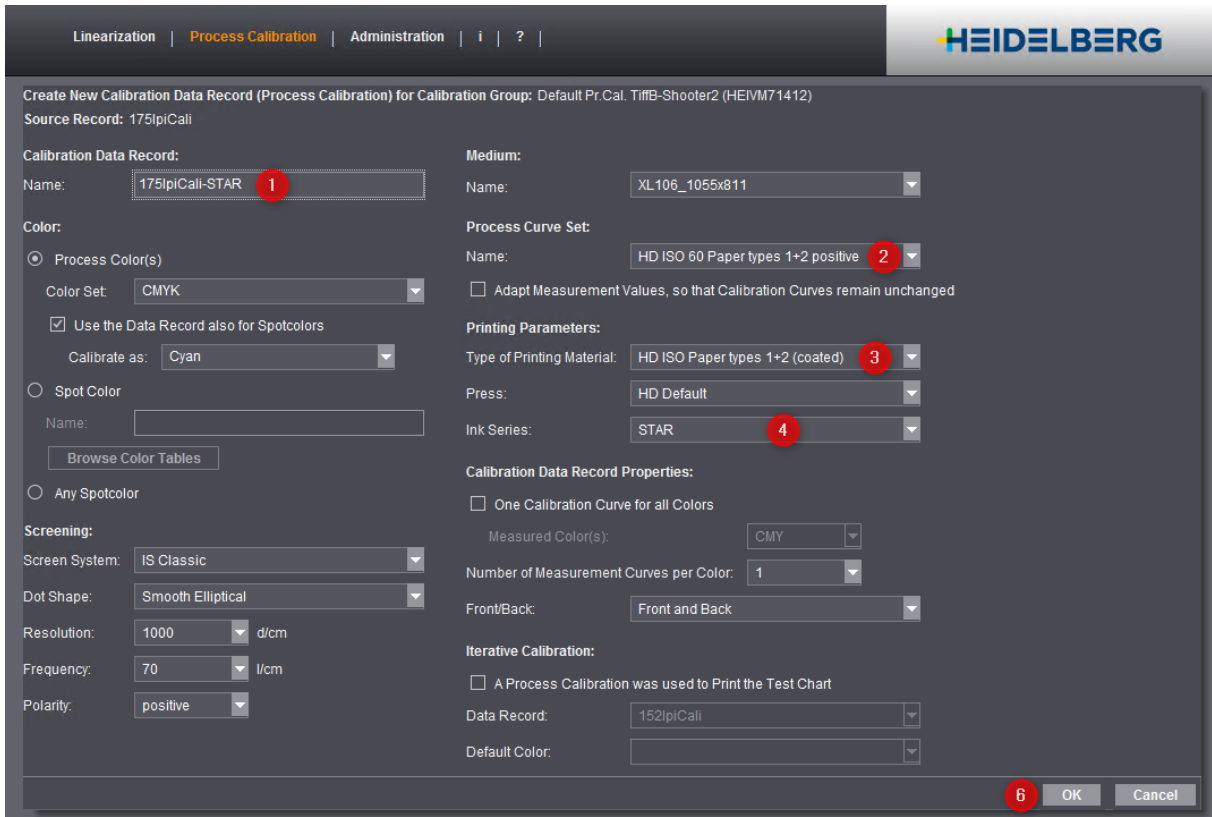
- Tiff-B / Suprasetter device for the Shooter
- Suprasetter for a direct connection



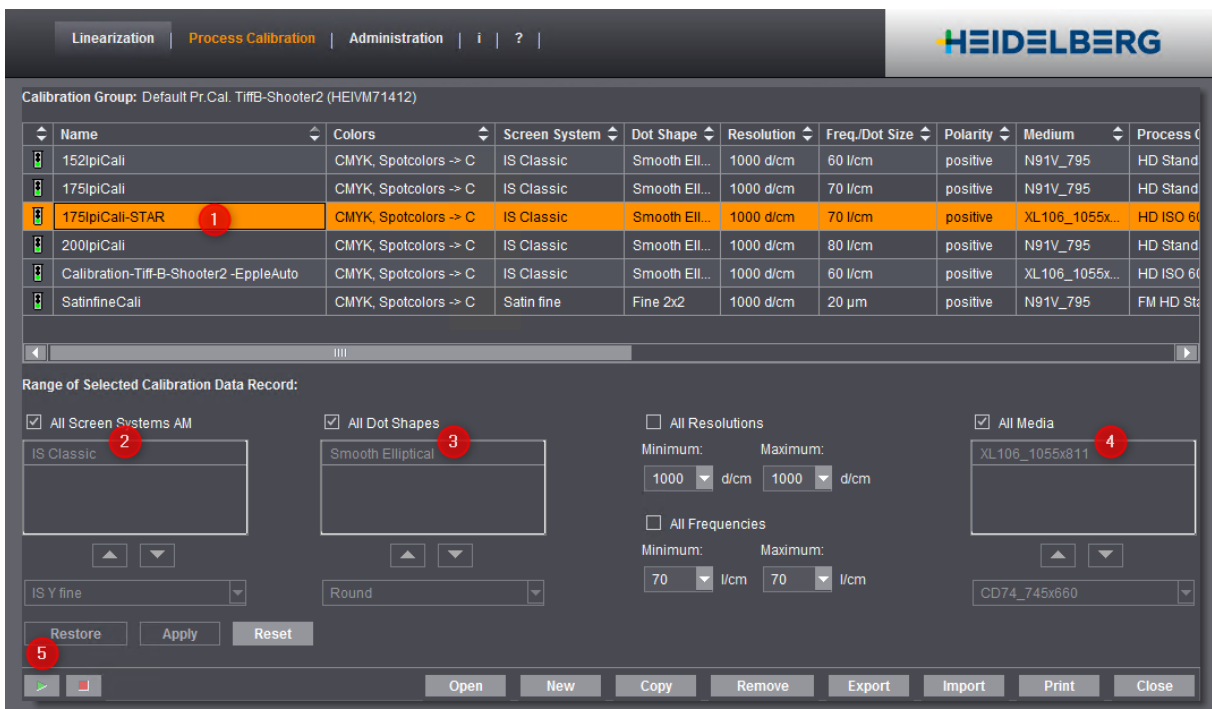
For testing the Ink Series transfer we can copy an existing calibration...



... and reference the ink series.



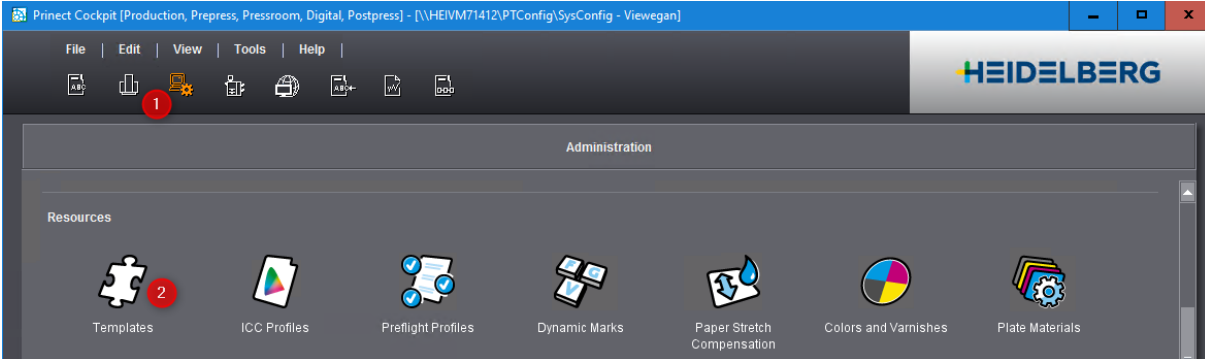
After saving the calibration we have to define the tolerances for using it and finally the calibration has to be active - green light.



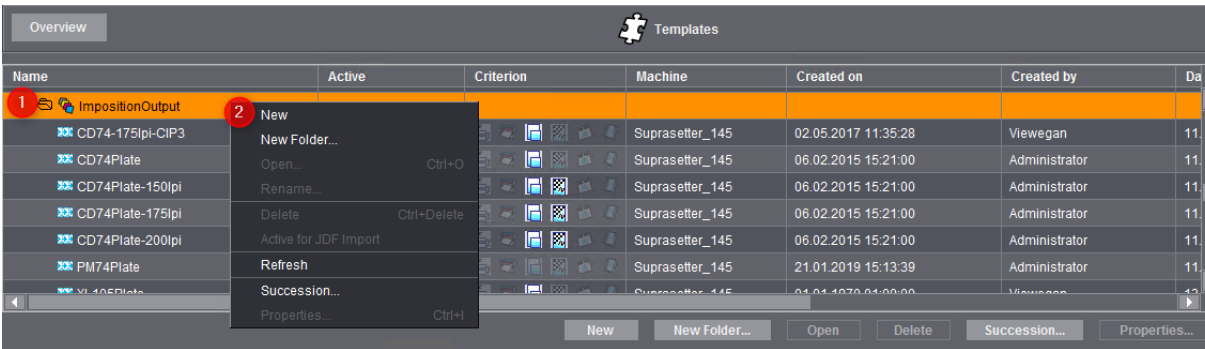
2 Workflow Resources

2.1.3 Cockpit - ImpositionOutput with Calibration "STAR"

In the Cockpit we can generate...



... a ImpositionOutput sequence for plate output when we have a Prepress Manager activated.



At first we have to select the Tiff-B device and the output device.

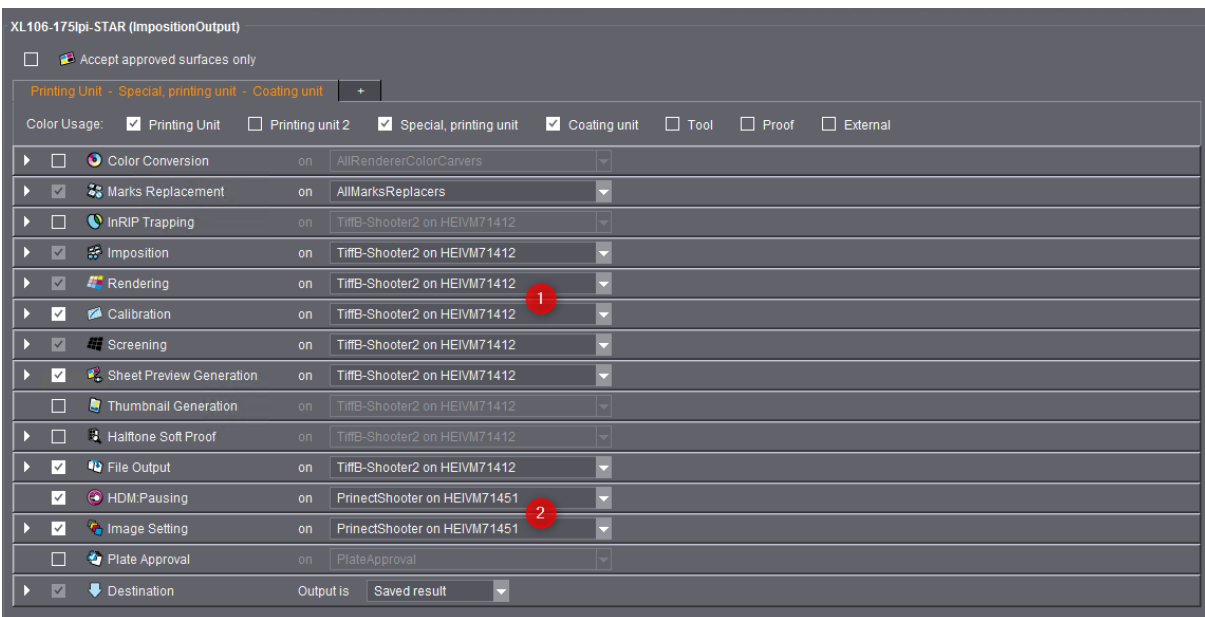
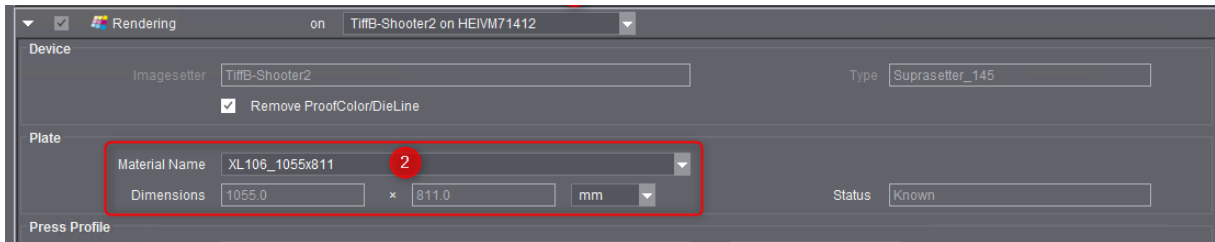
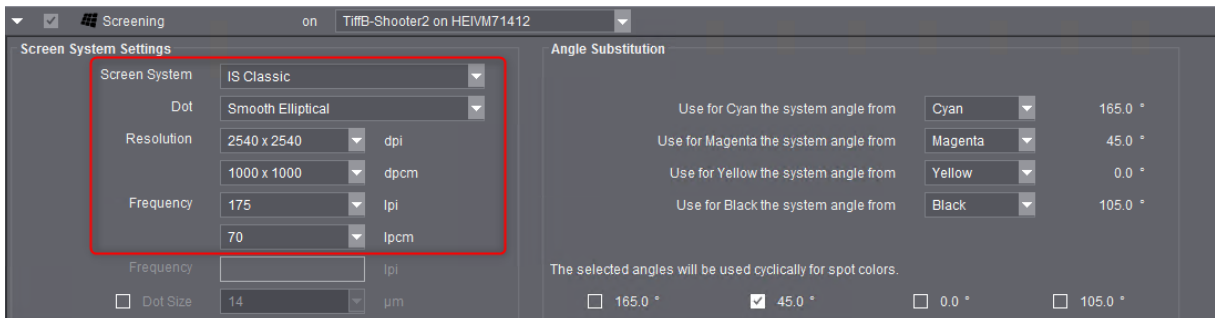


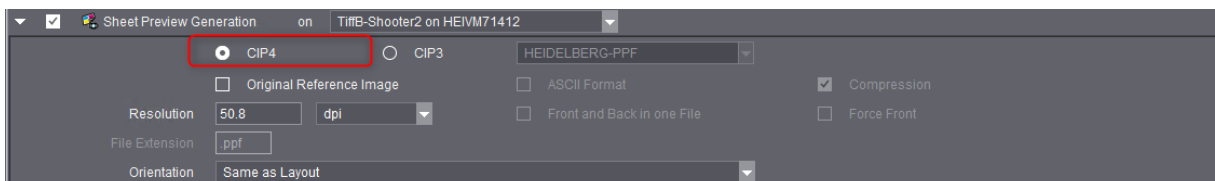
Plate size and...



... screening system are to define.

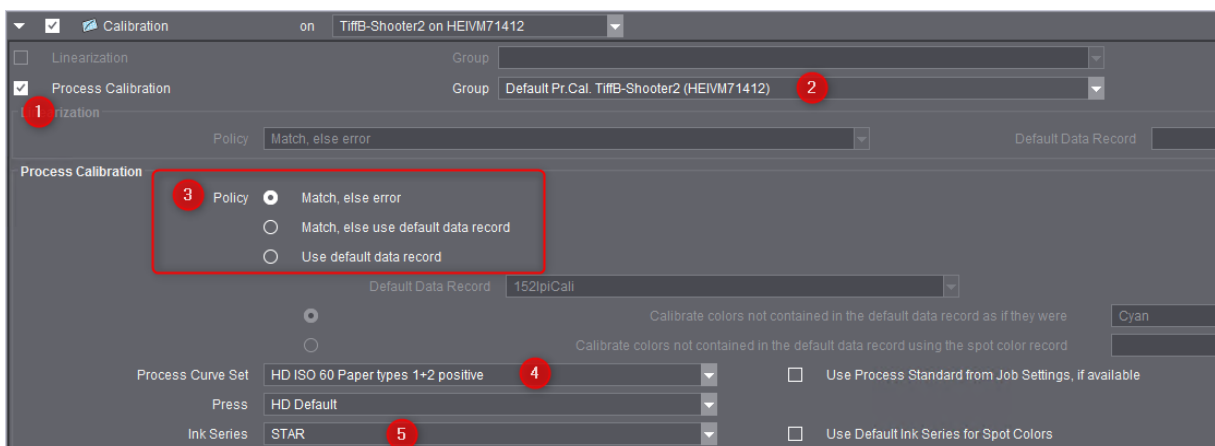


In "Sheet Preview Generation" we have to select CIP4 as an output format.



It is possible to use the Calibration Manager in 2 modes:

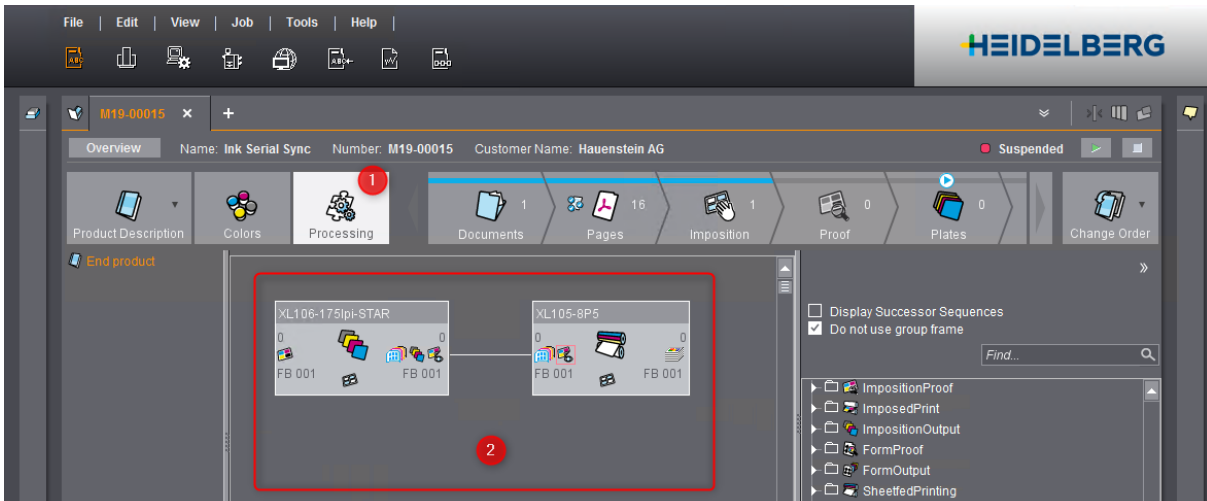
- Automatic - for experts
- By selection - easy



Note: The automatic mode can reduce the amount on sequences dramatically.

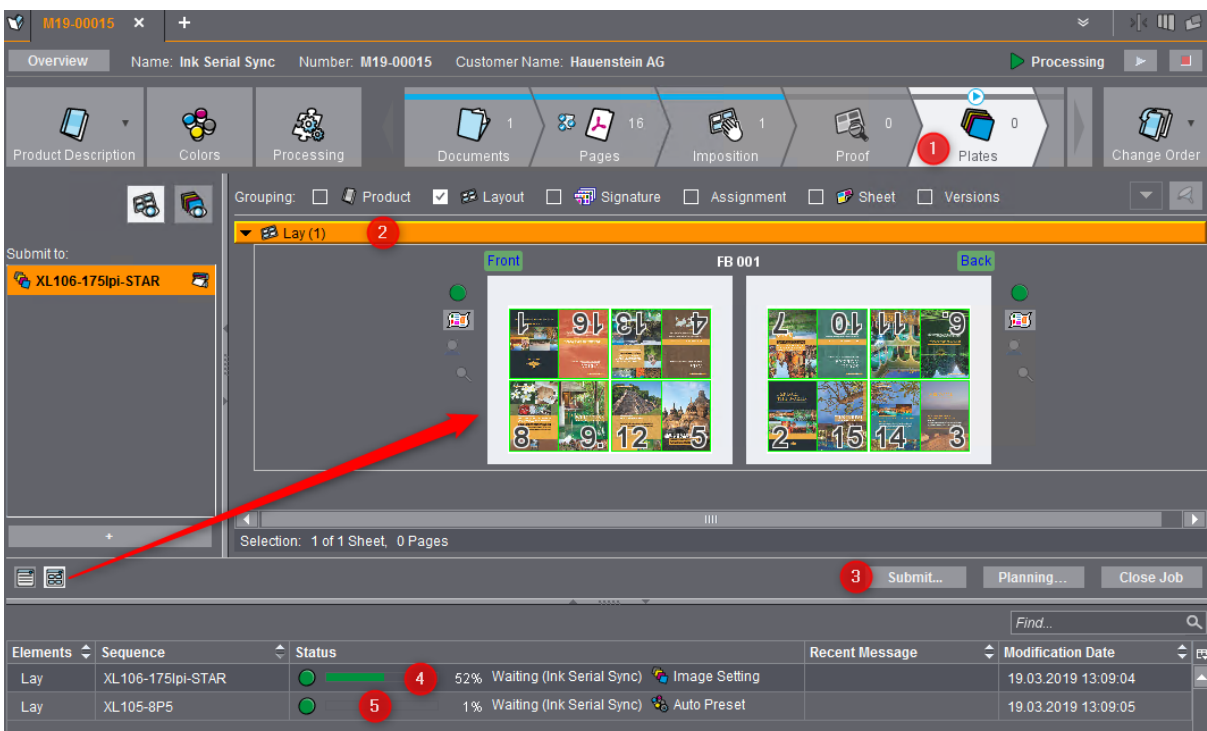
2 Workflow Resources

We have to create a job with "ImpositionOutput" + "SheetfedPrinting" sequences for the press. Further details we will explain in chapter 3 "Prinect Job".



After submitting the layout to the ImpositionOutput sequence we will get plates at the

- 4. "Image Setter" (platesetter)
- 5. "Ink Presettings" at the press

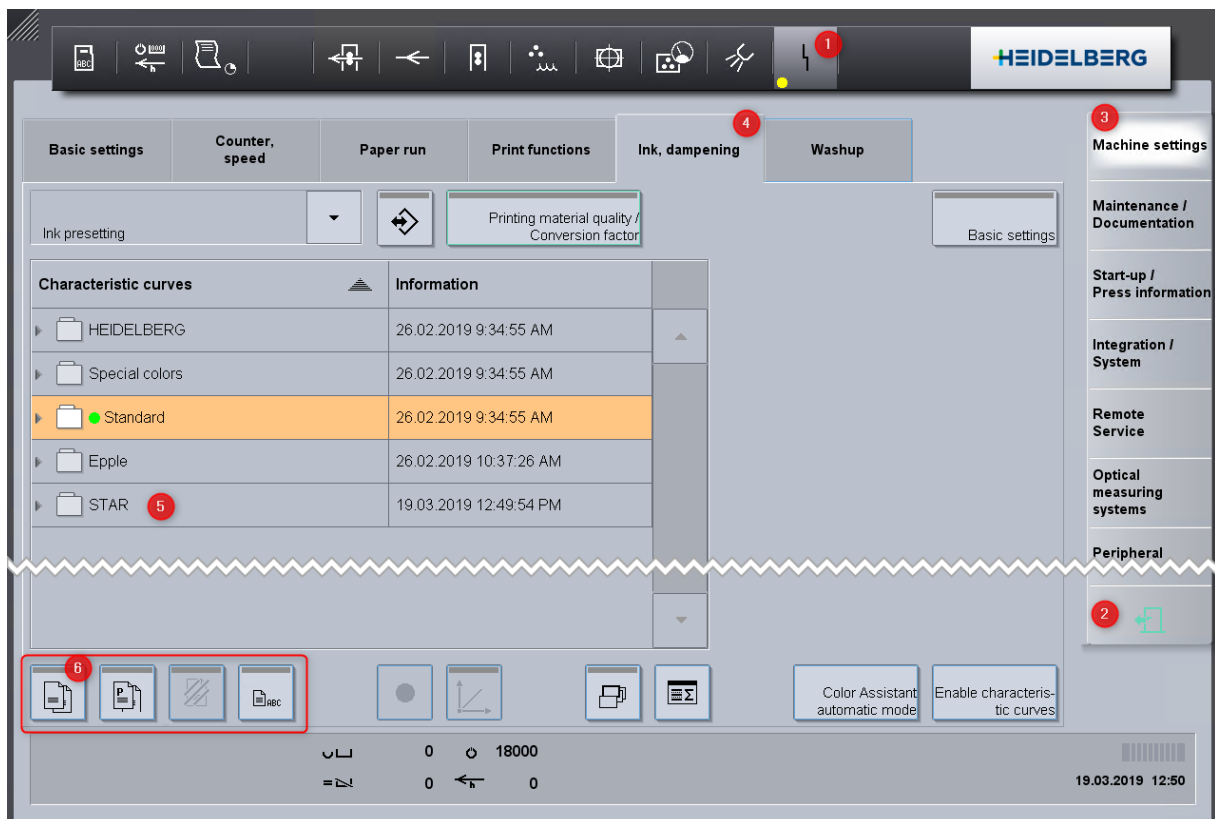


In this condition the operation is visible at the PressCenter.

2.1.4 PressCenter - Ink Series "STAR"

At the PressCenter we have to generate "Ink Presetting Curves" with the name "STAR".

- 2. To manage "Ink Presetting Curves" it is necessary to log in as "Service" or "Print Shop Administrator" (Password: 000)
- 5. - 7. For testing we can duplicate the "Standard" curves and rename the copy to "STAR".



2 Workflow Resources

- For a Perfector machine we should generate Ink presetting curves for Perfecting.

The screenshot shows the Heidelberg software interface with a dialog box titled "Generate set of characteristic curves for perfecting". The dialog contains a question mark icon and the text "STAR P: Do you want to generate the set of characteristic curves for perfecting?". Below the text are two buttons: "Yes" (with a red circle containing the number 3) and "No". In the background, the "Characteristic curves" list shows "STAR" selected (with a red circle containing the number 1), and the bottom toolbar shows "STAR.P" selected (with a red circle containing the number 2).

- This ink presetting curve is automatically preselected for Perfecting when using a color series "STAR"

Characteristic curves	Information
HEIDELBERG	26.02.2019 9:34:55 AM
Special colors	26.02.2019 9:34:55 AM
Standard	26.02.2019 9:34:55 AM
STAR	19.03.2019 12:49:54 PM
STAR.P	03.04.2019 11:52:59 AM

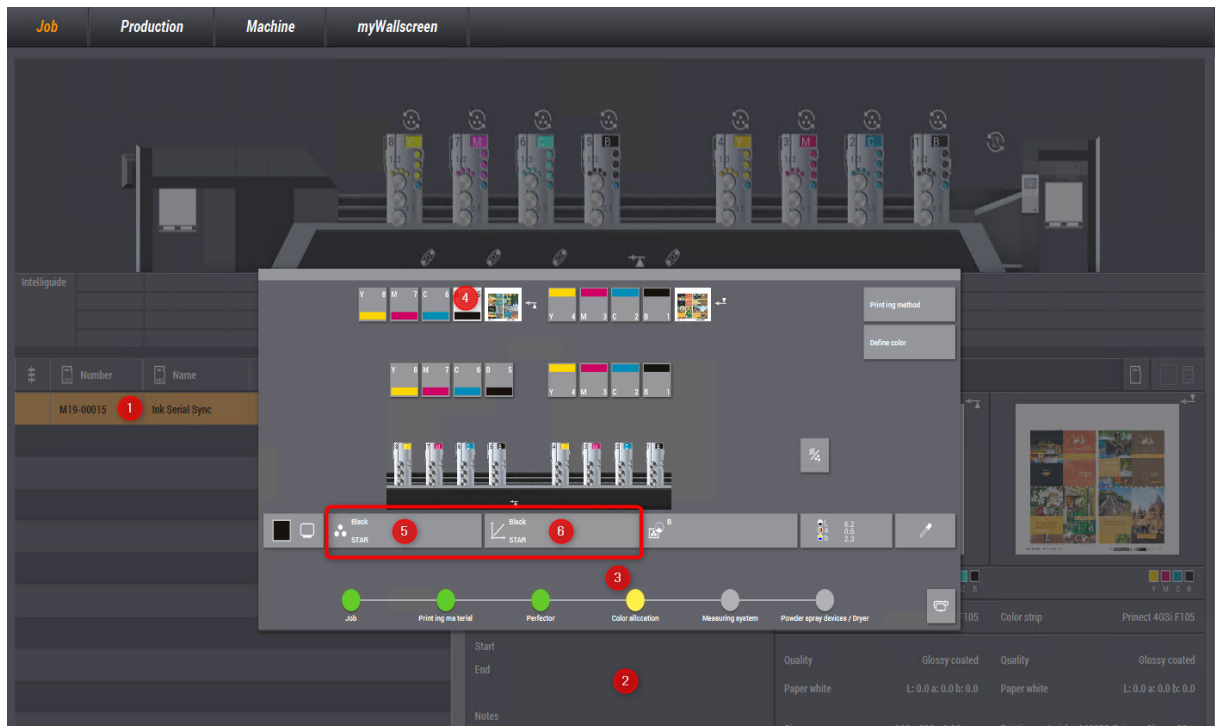


Note: In chapter 4.7 we will explain how to generate such a "Ink Presetting Curve"

2.1.5 PressCenter - Job with automatic Ink Serial Reference

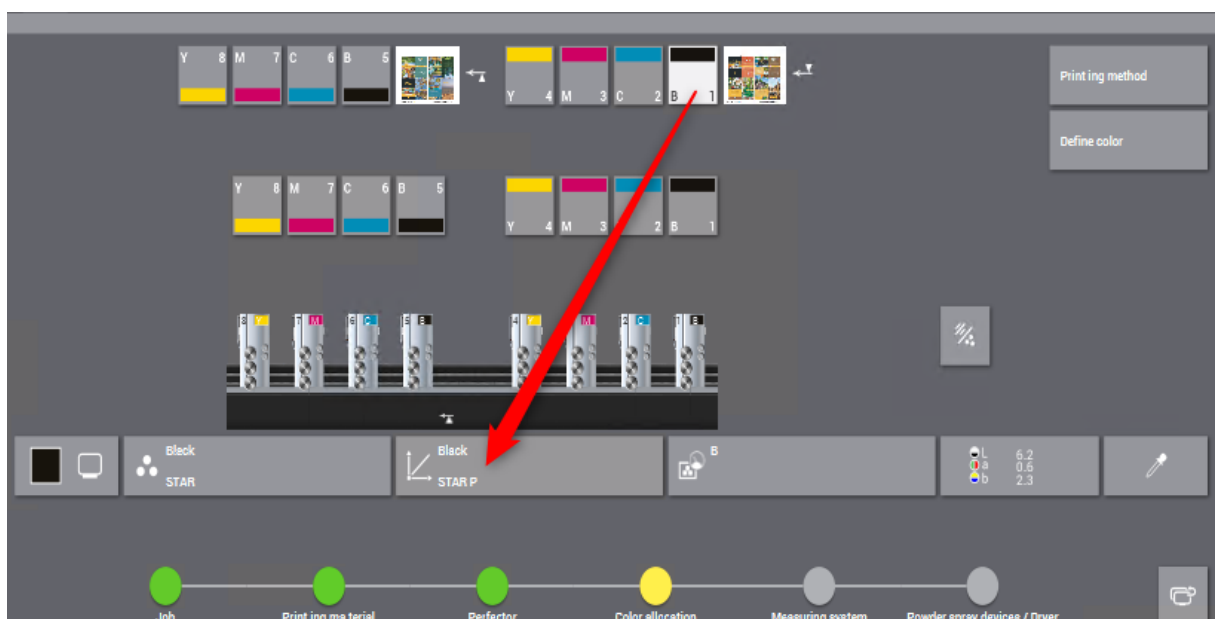
After loading this job we will see that the

- 5. Ink serial "STAR" was detected from the system and
- 6. The ink presetting curve is automatically assigned to the job



Note:

The "P-ink presetting curve" is always taken for the printing before the active Perfector.

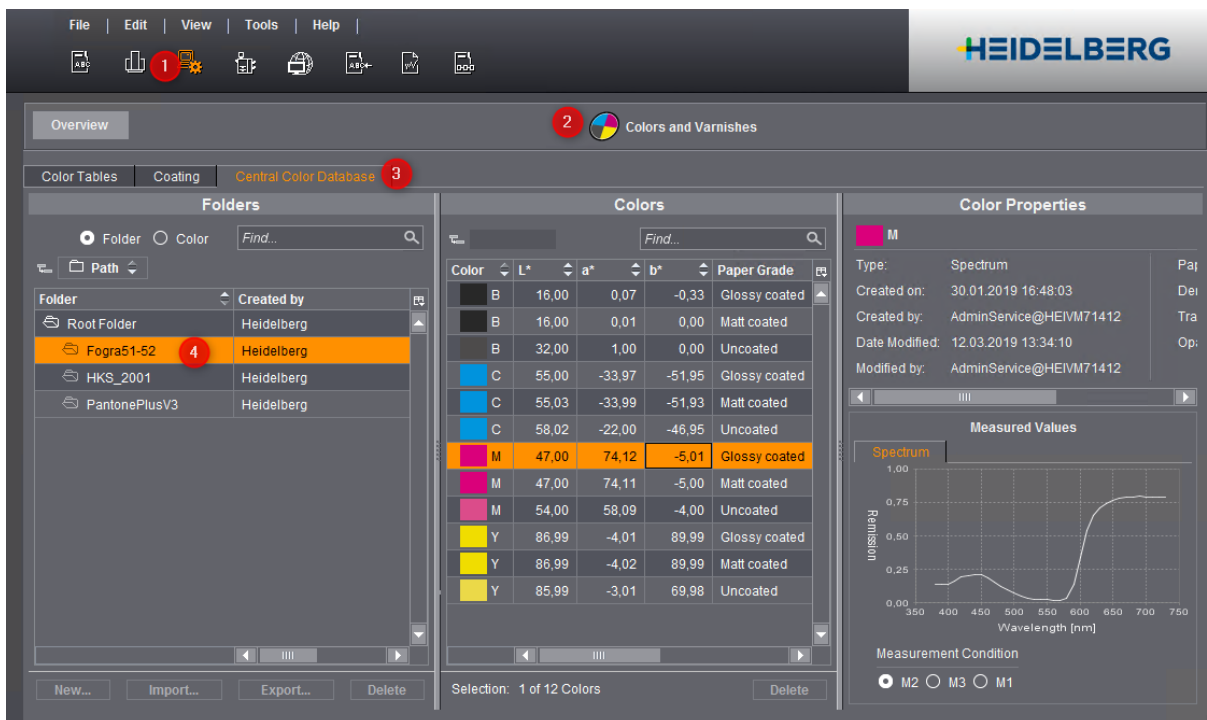


2 Workflow Resources

2.2 Central Color Data Base

In a new installation Prinect 2020 we have only 3 write protected default groups with all Paper Grades and all measurement filter:

- Fogra51-52
- HKS_2001
- PantonePlusV3



In chapter 4.8 we explain how to generate for the measurement system:

- "Color reference values" for process colors
- "Color reference values" for Spot Colors

Central Color Data Base in PressCenter

- In PressCenter 19A a Variant key is required for using the Central Color Data Base
- In PressCenter 20A the Central Color Data Base is enabled by standard

We can manage all colors in the PressCenter too, when they are not write protected.

The screenshot displays the Heidelberg PressCenter software interface. The main window shows the 'Color archive' section with a table of color data. The table has the following columns: Folderlink, L, a, b, D, Filter, and Date. The 'Fogra51-52' folder is highlighted in orange. The table contains the following data:

Folderlink	L	a	b	D	Filter	Date
Color archive						
Epple						
Fogra51-52						
B	6.2	0.6	2.3	2.06	(B)	12.03.2019
C	52.6	-37.3	-50.1	1.52	(C)	12.03.2019
M	44.0	74.6	-6.9	1.51	(M)	12.03.2019
Y	86.4	-6.2	92.5	1.26	(Y)	12.03.2019
HKS_2001						
MyColors						
MySpotColors						
PantonePlusV3						

The interface also shows a sidebar on the right with navigation options: Machine settings, Maintenance / Documentation, Start-up / Press information, Integration / System, Remote Service, Optical measuring systems, Peripheral equipment, and Diagnosis. The status bar at the bottom shows '19.03.2019 13:40'.



Note: In chapter 4.7.2 "PressCenter Job" we explain the spot color measurement in detail.

2 Workflow Resources

2.3 Printing Material & Substrates

2.3.1 CIP3/PPF workflow - 3rd Party Prepress

CIP3/PPF paper data from a 3rd Party workflow should include:

- Grammage
- Thickness
- Paper Extent (dimensions)

In the most CIP3 files we miss:

- Paper Grade
- Grain Direction

```
%!PS-Adobe-3.0
%%CIP3-File Version 2.1
%-Cip3-PPF-(RD20-2018-10-12)

%Mirror:1 Rotation:0
%PPFOnly-Mode

%-----
%   Sheet
%-----
CIP3BeginSheet
/CIP3AdmCustomer (Heidelberger Druckmaschinen AG) def
/CIP3AdmJobCode (101173) def
/CIP3AdmJobName (PBM Job with 3 Sheets XL106) def
/CIP3AdmSheetName (ST103298) def
%No TypeOfScreen
/CIP3AdmCreationTime (Mon Mar 18 14:33:33 2019) def
/CIP3AdmSheetLay /Left def
/CIP3AdmPaperGrammage 120.0 def
/CIP3AdmPaperThickness 0.145 mm def
%No /CIP3AdmPaperColor <-InData
/CIP3TransferFilmCurveData [0.0 0.0 1.0 1.0] def
/CIP3TransferPlateCurveData [0.0 0.0 1.0 1.0] def
/CIP3AdmPSExtent [2990.55118 2298.89764] def
/CIP3AdmPaperExtent [ 2494.48818898  1814.17322835 ] def
/CIP3AdmPaperTrf [ 1 0 0 1 -248.03149606 -121.88976378 ] def

%-----
%   Surface Front
%-----
CIP3BeginFront
/CIP3AdmSeparationNames [(Black)(Cyan)(Magenta)(Yellow)] def
/CIP3AdmInkColors [[ 16.0 0.0 0.0 ][ 54.0 -36.0 -49.0 ][ 46.0 72.0 -5.0 ][ 88.0 -6.0 90.0 ]] def

CIP3BeginPreviewImage

%-----
%   Separation 1
%   PlateColor: Black
%-----

CIP3BeginSeparation
/CIP3PreviewImageWidth 2110 def
/CIP3PreviewImageHeight 1622 def
/CIP3PreviewImageBitsPerComp 8 def
/CIP3PreviewImageComponents 1 def
/CIP3PreviewImageMatrix [2110 0 0 -1622 0 1622 ] def
/CIP3PreviewImageResolution [ 50.79999924  50.79999924 ] def
/CIP3PreviewImageEncoding /Binary def
/CIP3PreviewImageCompression /RunLengthDecode def
/CIP3PreviewImageDataSize 594391 def
```



Note: We can take missing informations from filename (tokening), when necessary.

2.3.2 Printing Materials

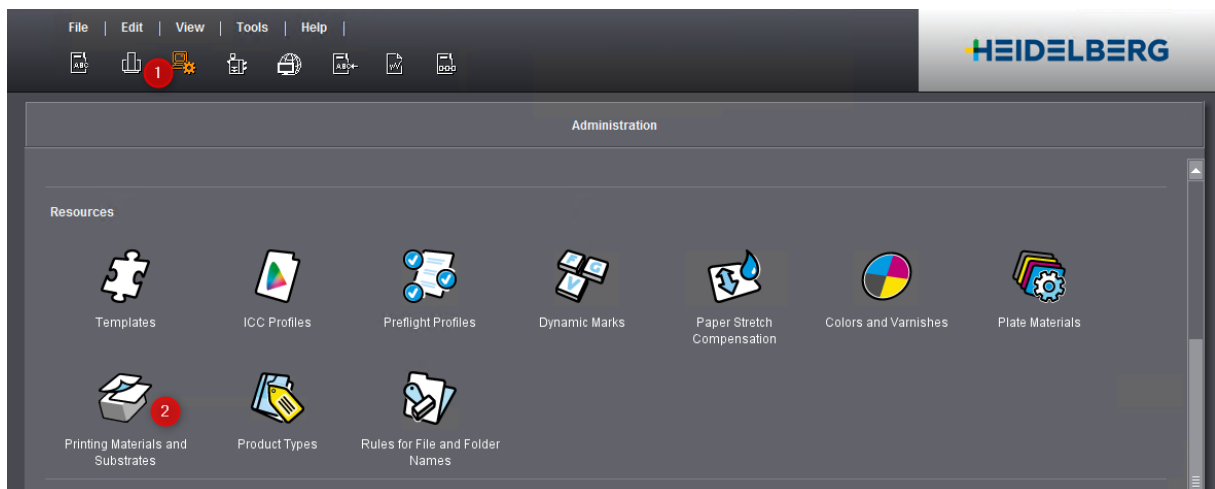
In a integrated Prinect workflow we generate the layout with Signa Station (description in chapter 3).

Signa Station can load the paper informations from JDF or MDS

- With MIS connection the paper is defined in the JDF
- Without MIS we should define the "Printing Material" in the MDS

Printing Material

We can create "Printing Materials" in Cockpit > Administration > Printing Materials and Substrates.



These "Printing Materials" are to use in Signa Station.

Overview Printing Materials and Substrates

Printing Materials Substrates

Paper Grade (ISO) Width/Height Unit mm Entries 777 Paper Grade * 880

Brand	Article Number	Paper Grade (ISO)	Width	Height	Thickness [...]	Grammage [g/m ²]	Grain Direction	F
▼ Paper Grade (ISO) : 1 (glossy coated) (11)								
PlanoJet 157.286 hochweiss FSC	88008526	1 (glossy coated)	1000,000	700,000	0,364	280,000	Short grain	
100254-Glossy Coated-880x640	124514	1 (glossy coated)	880,000	640,000	0,100	150,000	Long grain	
100252-Glossy Coated-880x630	100252	1 (glossy coated)	880,000	630,000	0,100	150,000	Long grain	
100253-Glossy Coated-880x630	100253	1 (glossy coated)	880,000	630,000	0,100	150,000	Short grain	
100255-PrimagoGlossy-880x640	100255	1 (glossy coated)	880,000	640,000	0,120	135,000	Short grain	
Luxo magic glänzend gestrichen	(88066030)	1 (glossy coated)	720,000	520,000	0,136	170,000	Short grain	
LuxoSatin 88002504 hochweiss ungerfest F...	88060595	1 (glossy coated)	700,000	500,000	0,300	250,000	Long grain	
LuxoSatin 91351 hochweiss ungeriest FSC	88066126	1 (glossy coated)	640,000	460,000	0,160	200,000	Long grain	
Arctic Volume White naturweiss FSC unger...	88041150	1 (glossy coated)	640,000	460,000	0,136	170,000	Long grain	
LuxoArt Samt 345.201 hochweiss	88000374	1 (glossy coated)	640,000	460,000	0,160	200,000	Long grain	
Digit-Print N (Color 695.660 hochweiss FSC	(888025845)	1 (glossy coated)	500,000	900,000	0,080	100,000	Short grain	
▶ Paper Grade (ISO) : 2 (matt coated) (6)								

Create Printing Material... Substrate from Printing Material... Properties... Duplicate Delete



Note: Even in the PPF workflow we can use the MDS materials to send it to the PressCenter (chapter 2.2.1.2).

2 Workflow Resources

Substrates

For digital presses like "Primefire" and "Labelfire" we are using "Substrates" in the "Color Center" for calibration, drying, ICC-profiling...

A "Substrate" defines the characteristics of a "Printing Material" and is size independent:

- Lab - Front & Back
- Spectral values - Front & Back
- Drying characteristics
- Reflectivity
- ...

In further Prinect versions (\geq Prinect 2021) we will use "Substrate" informations on top of "Printing Materials" for conventional presses too.

3 Prinect Job

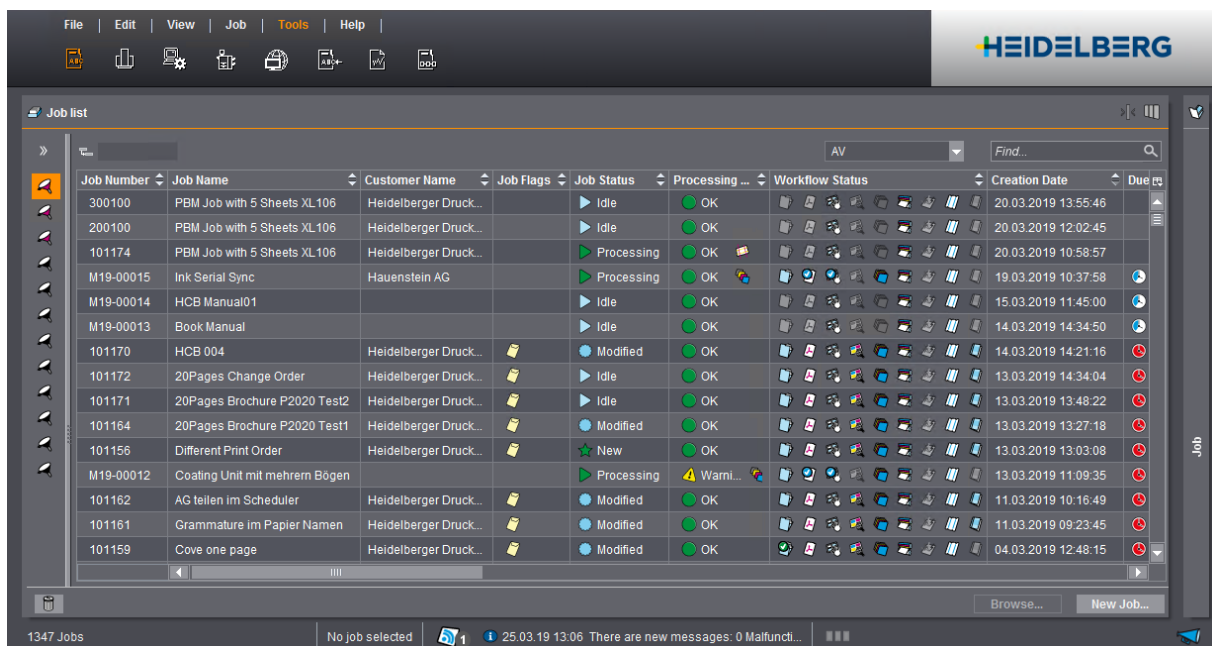
3.1 Introduction

Push to Stop

How to get jobs at the PressCenter, which are to print in Push to Stop mode with minimum interactions of the press operator.

General

- A Prinect job is to manage in the Cockpit.
- A Prinect job can be created in different ways (chapter 3.2 Prinect Workflows).
- A Prinect job includes all sheets of a product or of a gang job.
- Press operations of a sheet are displayed as jobs at the PressCenter.
- A Prinect job can define a lot of informations which are necessary to realize Push to Stop
 - Due Date / Delivery Date
 - Good sheet quantity / waste sheet quantity
 - Material details: Paper, dimension, paper grade, grammage, thickness
 - Color definition (Lab values and spectral values automatic allocation in the press)
 -



3 Prinect Job

3.2 Prinect Workflows

Motivation

In this chapter we describe how Prinect can send jobs to the PressCenter and how we can edit missing data in the Cockpit to realize Push to Stop.

We describe 2 of the most common workflows in detail:

- 1. CIP3/PPF Workflow (Detailed Description)**
2. Imposed PDF Workflow
- 3. Manual Workflow (Detailed Description)**
4. JDF-PPF Merge Workflow
5. Fully integrated Workflow

3.2.1 CIP3/PPF Workflow (Detailed Description)

Approximately 50% of our customers have such a workflow.

Customer Equipment

- 3rd Party Prepress (Esko, Kodak, Agfa, Fuji, Screen) with CIP3/PPF output
- 3rd Party Platesetter
- Prinect Production Manager
- PressCenter / Data Terminal

In this workflow we get PPF only

1. PPF hotfolder input - job automatically at the PressCenter
2. Quantity - to define in Planning Assistant
3. Printing Material and Grain Direction - to define in sheet properties

3.2.1.1 PPF hotfolder input - job automatically at the PressCenter

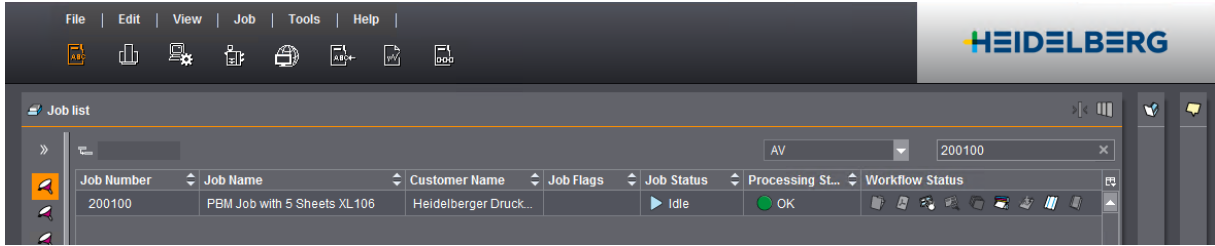
In chapter 1.1.5 we have created a press device. This configuration has automatically created a hotfolder for CIP3/PPF import. The hotfolders for all configured press devices is to find at the Prinect Server in PTConfig\PPFIn.

We can copy 5 PPF files (sheets) of the job 200100 into the hotfolder "XL105-8P5".

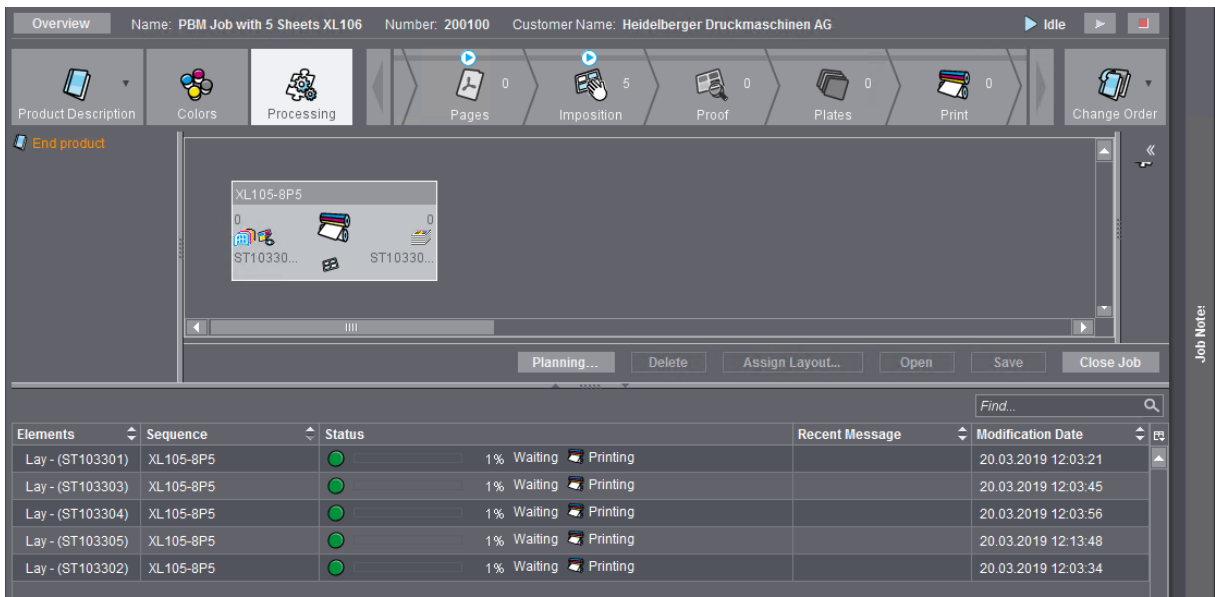
PPF files are to find here: <\\heiapp00322\PrinectTraining\Prinect2020\Push2Stop\NormalPPF>

Name	Date modified	Type	Size
CD74-6P3L	20.03.2019 10:07	File folder	
SM52-5P2-ANI	20.03.2019 10:07	File folder	
XL105-6L	20.03.2019 10:07	File folder	
XL105-8P5	20.03.2019 10:07	File folder	
XL105-10P6	20.03.2019 10:07	File folder	
XL105-10P6-IC	20.03.2019 10:07	File folder	
XL106-4-L	20.03.2019 10:07	File folder	

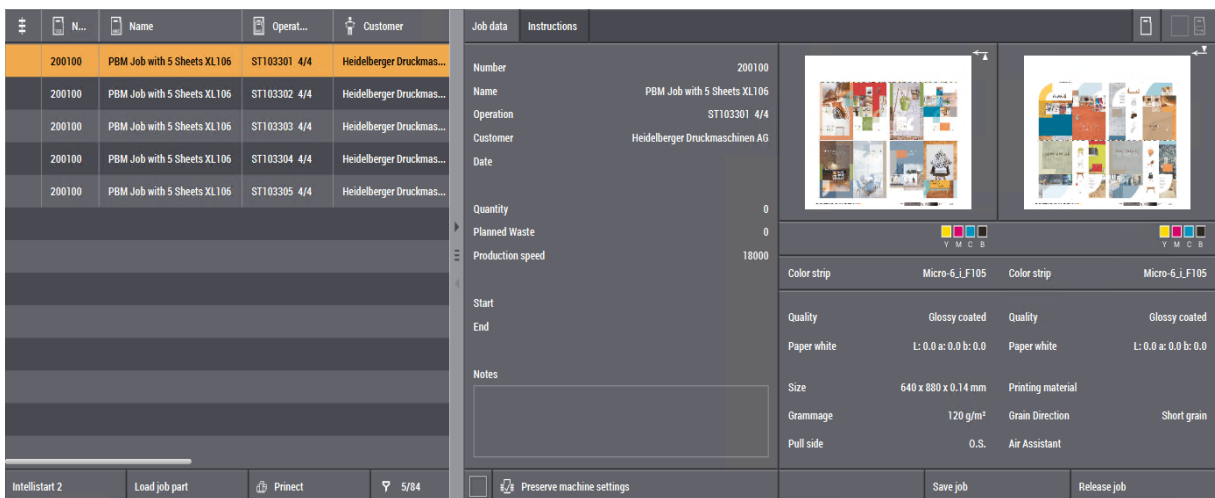
After approx. 1 minute we can see the job in the Cockpit.



After approx. 3 minutes all ink presettings are calculated for 5 sheets...



Sheet operations (jobs) are available at the PressCenter.



3 Prinect Job

3.2.1.2 Job Combiner

In the PPF workflow customers are using very often the Job Combiner to view PressCenter jobs, because the jobs are displays like in "Prepress Interface" (former Heidelberg workflow software).

The job combiner allows to manipulate PressCenter jobs

- create new jobs
- delete jobs
- change ink order
- combine separate jobs to one Perfector job
- change Perfector job to two separate jobs
- change front & back

The screenshot displays the Heidelberg PPF Job Combiner interface. At the top, there is a menu bar with 'File', 'Edit', 'View', 'Tools', and 'Help'. Below the menu is a toolbar with various icons. The main interface is divided into several sections:

- PPF Input List:** A table showing job details for Job Number 200100. The table has columns for Sheet designation, Job designation, Processes, and Number of color sets. The first row is highlighted in orange.
- Job list:** A table showing a list of jobs for Job Number 200100, with columns for Sheet designation, Customer Name, and Work Style.
- Detail View:** A detailed view of a job with four panels: 'Front side' (top-left), 'Perfecting' (top-right), 'Front side' (bottom-left), and 'Perfecting' (bottom-right). Each panel shows a preview of the job and a list of ink colors (B: Black, C: Cyan, M: Magenta, Y: Yellow). A red 'X' is drawn over the Perfecting panels, and a red arrow labeled 'drag & drop' points from the top-right Perfecting panel to the bottom-right Perfecting panel.
- Designation Panel:** A panel on the right showing job details such as Job Number, Job designation, Sheet designation, Customer name, and Creation date.
- Buttons:** At the bottom right, there are 'Save' and 'Delete' buttons.

3.2.1.3 How to edit missing data in the Cockpit?

In the PPF Workflow we are missing very often some parameters which we need for Push to Stop:



- **Quantity** - can be defined manually in Cockpit "Planning Assistant" (chapter 2.2.1.2)
- **Printing Material** since Prinect 2019.10 it is possible to define missing Paper Informations in the Planning Assistant too! (Paper Type: Glossy, matte, uncoated) In further Prinect versions it was necessary to define it manually in Cockpit "Sheet Properties" (chapter 2.2.1.3)
- **Grain direction** - can be defined manually in Cockpit "Sheet Properties" (chapter 2.2.1.3)
- **Start Date** - can only be defined with "Scheduler" or "Machine Widget" (chapter 5)
- **Pull Side** - can only be defined with "Signa Station" (chapter 2.2.5)

Data from Prinect

Start	N...	Name	Operation	Length	Width	Gra...		Printing material
	200100	PBM Job with 5 Sheets XL106	ST103305 4/4	640	880	120.0		
	200100	PBM Job with 5 Sheets XL106	ST103304 4/4	640	880	120.0		
	200100	PBM Job with 5 Sheets XL106	ST103303 4/4	640	880	120.0		
	200100	PBM Job with 5 Sheets XL106	ST103302 4/4	640	880	120.0		
	200100	PBM Job with 5 Sheets XL106	ST103301 4/4	640	880	120.0		

Machine data

The blue marked data can be manipulated by PressCenter presets (chapter 4.1)

Job data	Instructions		
Number	200100		
Name	PBM Job with 5 Sheets XL106		
Operation	ST103305 4/4		
Customer	Heidelberger Druckmaschinen AG		
Date			
Quantity	0		
Planned Waste	0		
Production speed	18000		
Start			
End			
Notes			
		Color strip	Micro-6_i_F105
		Quality	Glossy coated
		Paper white	L: 0.0 a: 0.0 b: 0.0
		Size	640 x 880 x 0.14 mm
		Grammage	120 g/m²
		Pull side	O.S.
		Printing material	
		Grain Direction	Short grain
		Air Assistant	

3 Prinect Job



Note: In the PPF workflow we have always missing informations.
The most of our customers do not edit data in the Cockpit!
In the next chapters we explain how to edit data in the Cockpit.

3.2.1.4 Quantity & Printing Material - to define in Planning Assistant

In the PPF workflow we will never have a quantity in Cockpit...

Operation	Colors	Work Style	Machine	Setup time	Production time	Duration	Planned Amount	Planned Waste
01. ST103301 4/4	CMYK / CMYK	Perfecting	XL105-8P5 (4202)	00:00:00	00:00:00	00:00:00	0	0
01. ST103302 4/4	CMYK / CMYK	Perfecting	XL105-8P5 (4202)	00:00:00	00:00:00	00:00:00	0	0
01. ST103303 4/4	CMYK / CMYK	Perfecting	XL105-8P5 (4202)	00:00:00	00:00:00	00:00:00	0	0
01. ST103304 4/4	CMYK / CMYK	Perfecting	XL105-8P5 (4202)	00:00:00	00:00:00	00:00:00	0	0
01. ST103305 4/4	CMYK / CMYK	Perfecting	XL105-8P5 (4202)	00:00:00	00:00:00	00:00:00	0	0

Elements	Sequence	Status	Recent Message	Modification Date
Lay - (ST103305)	XL105-8P5	1% Waiting	Printing	25.03.2019 13:31:50
Lay - (ST103303)	XL105-8P5	1% Waiting	Printing	25.03.2019 13:31:27
Lay - (ST103302)	XL105-8P5	1% Waiting	Printing	25.03.2019 13:31:15
Lay - (ST103304)	XL105-8P5	1% Waiting	Printing	25.03.2019 13:31:39
Lay - (ST103301)	XL105-8P5	1% Waiting	Printing	25.03.2019 13:31:03

... and PressCenter.

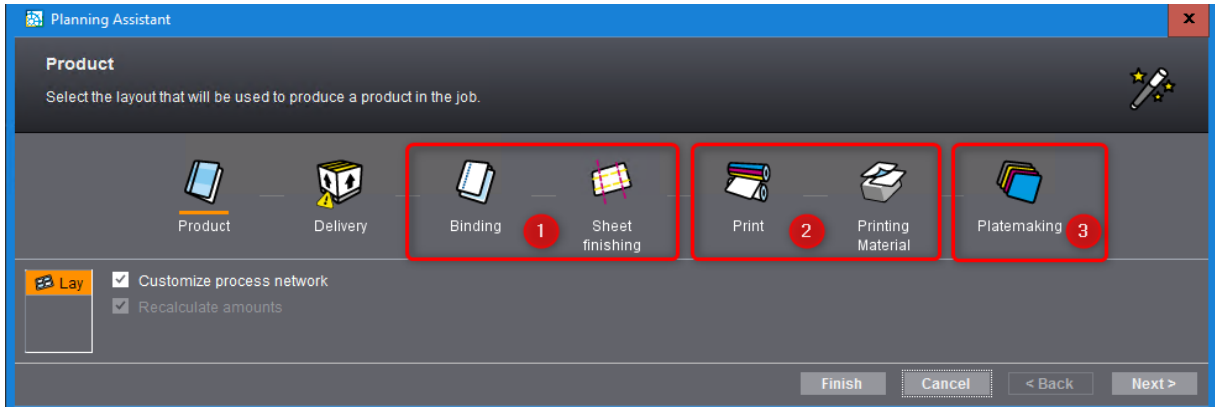
Number	200100
Name	PBM Job with 5 Sheets XL106
Operation	ST103301 4/4
Customer	Heidelberger Druckmaschinen AG
Date	
Quantity	0
Planned Waste	0
Production speed	18000



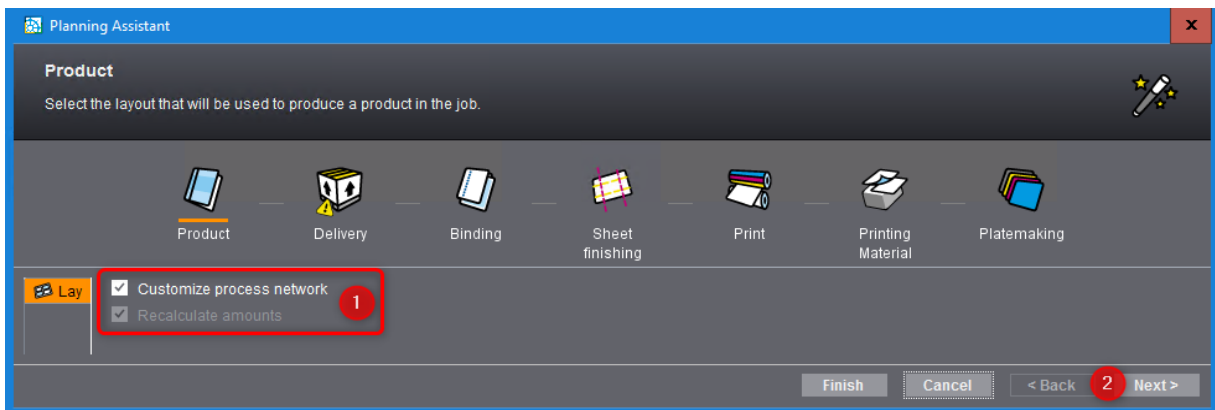
Note: With the "Planning Assistant" we can define for all operations (cutting, folding, printing, binding...) times and quantities (performance parameters chapter 1.1.5).
Additionally we can define missing printing material since Prinect 2019.10.

The Planning Assistant displays 3 different production areas only when the feature is enabled by license:

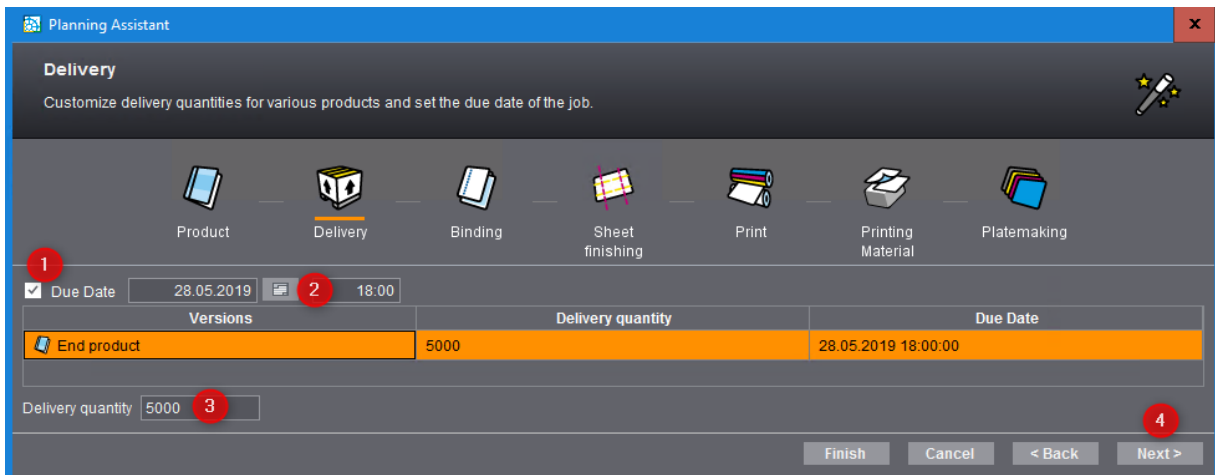
1. Postpress
2. Press
3. Prepress



In the first tab we define to customize the process network and to recalculate amounts.



We need a "Due Date" for Scheduler and a "quantity" for PressCenter.

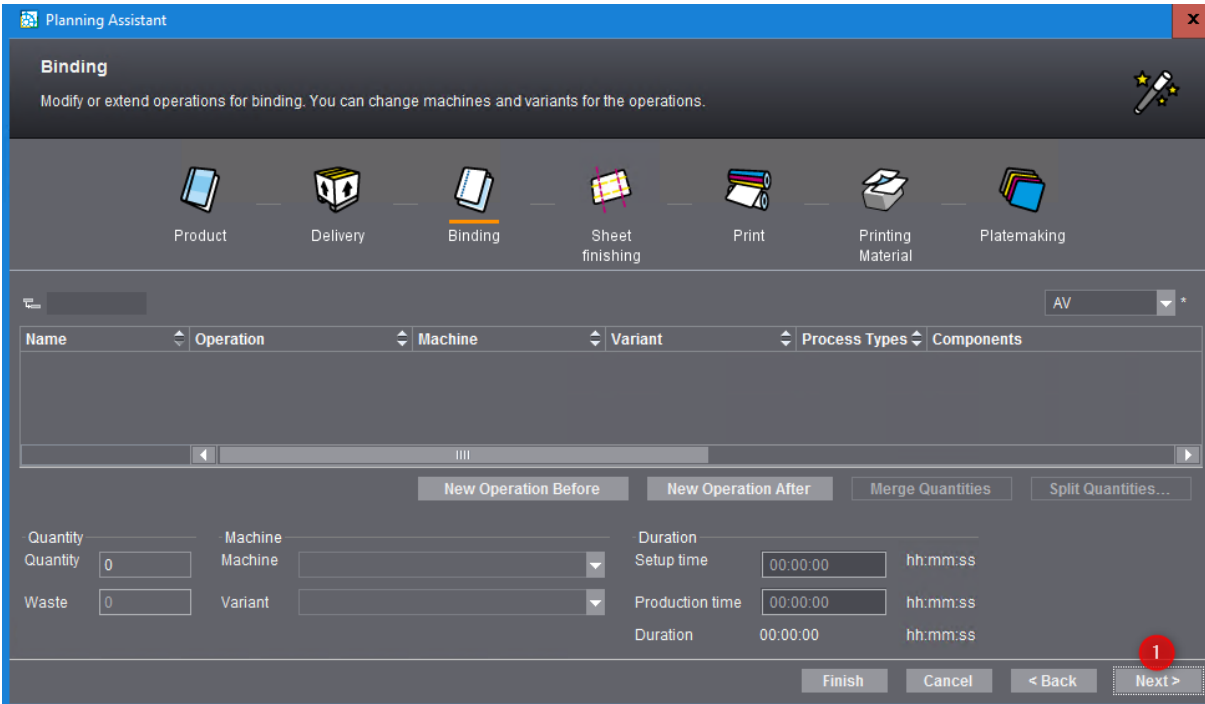


3 Prinect Job

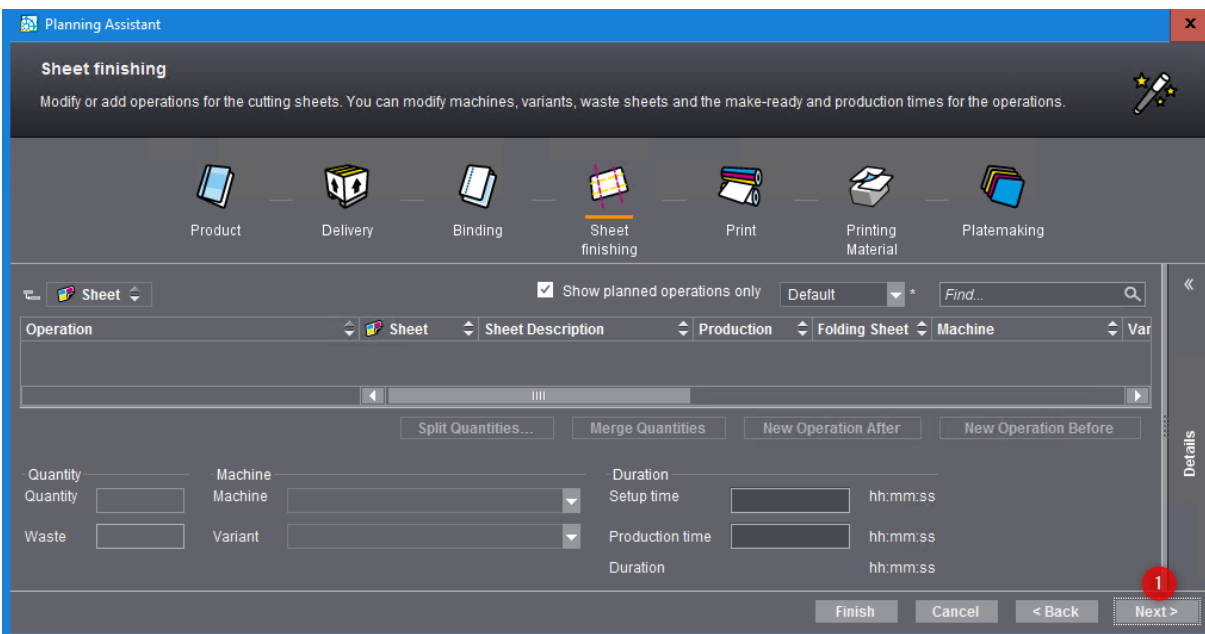


Note: In the "Manual Workflow (chapter 2.2.3), in the PPF-JDF Merge Workflow (chapter 2.2.4) and in the fully integrated workflow (chapter 2.2.5) we can get operations for Post-press too!

In the PPF workflow we do not have "Binding" and...



..."Sheet finishing" because we have no Signa Station layout.

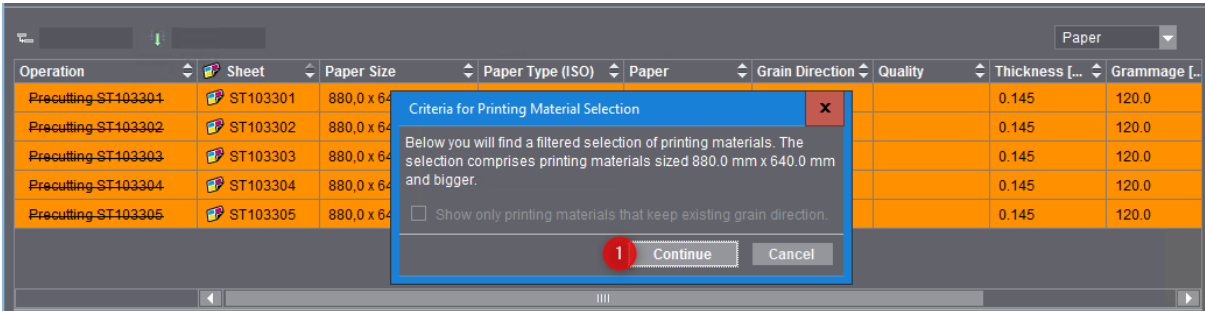


The quantities and duration times are now defined by "Planning Assistant".

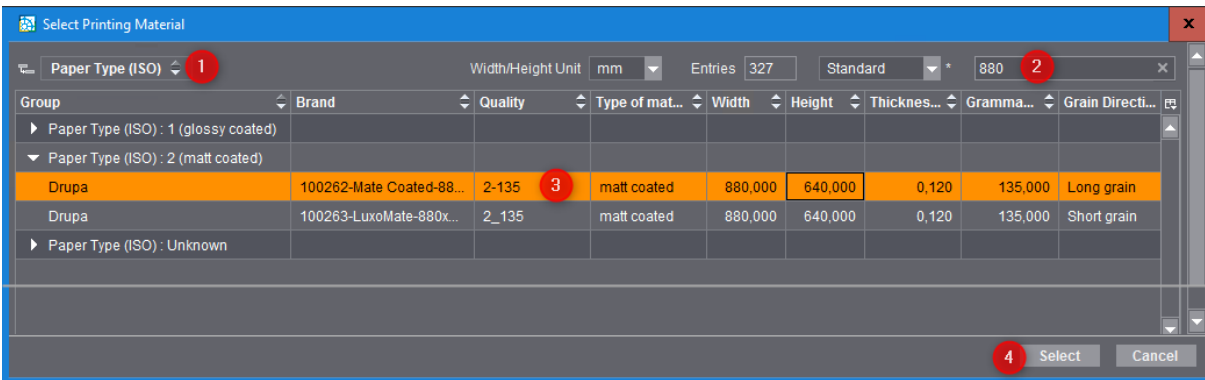
Note: Since Prinect 2019.10 we can define missing printing material parameters in the Planning Assistant too!

3 Prinect Job

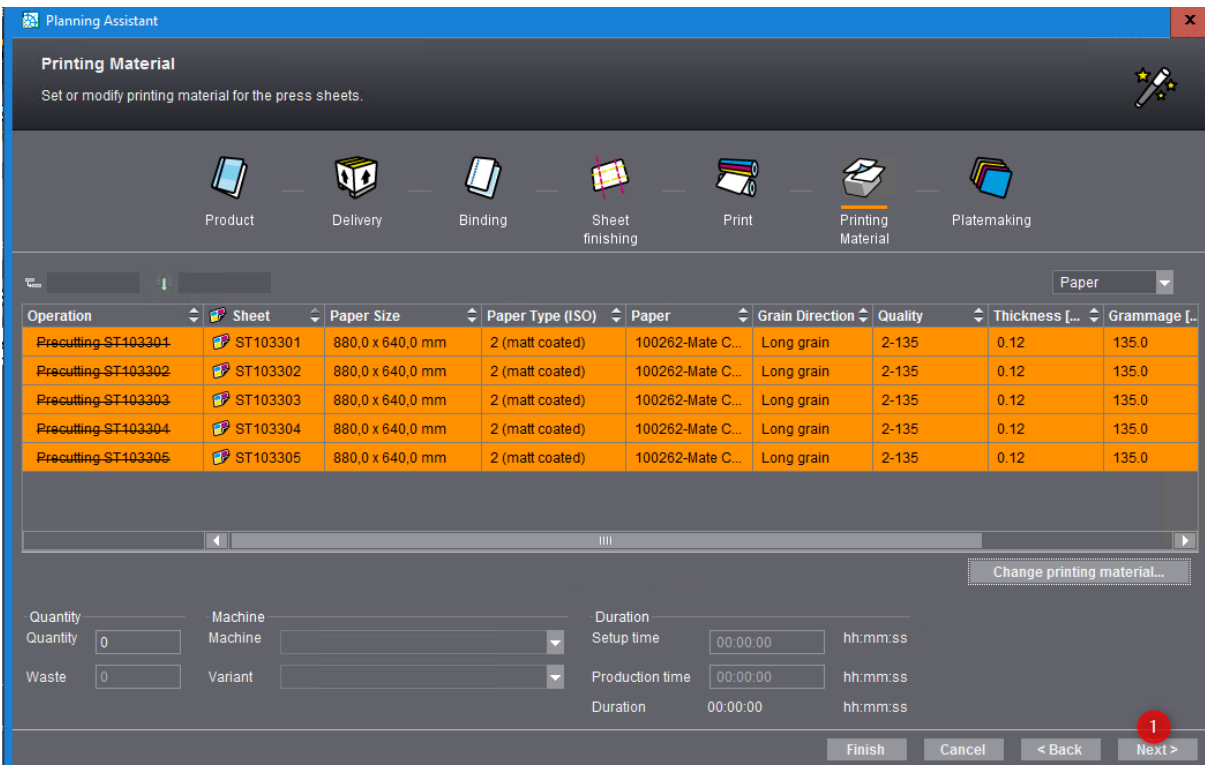
We will get a warning that only larger papers, as defined in the ppf, are displayed in the next window.



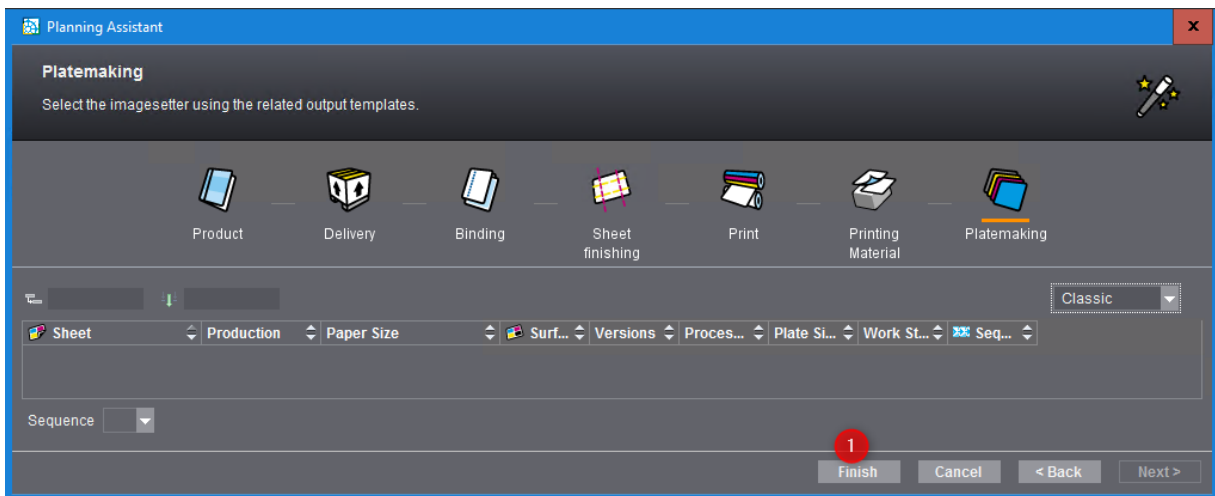
We have to search for a paper in the MDS with the same size, otherwise we would generate a Pre-cutting Operation. We have defined Printing Materials in chapter 2.3.2.



In this condition we have defined all relevant parameters for the PressCenter.

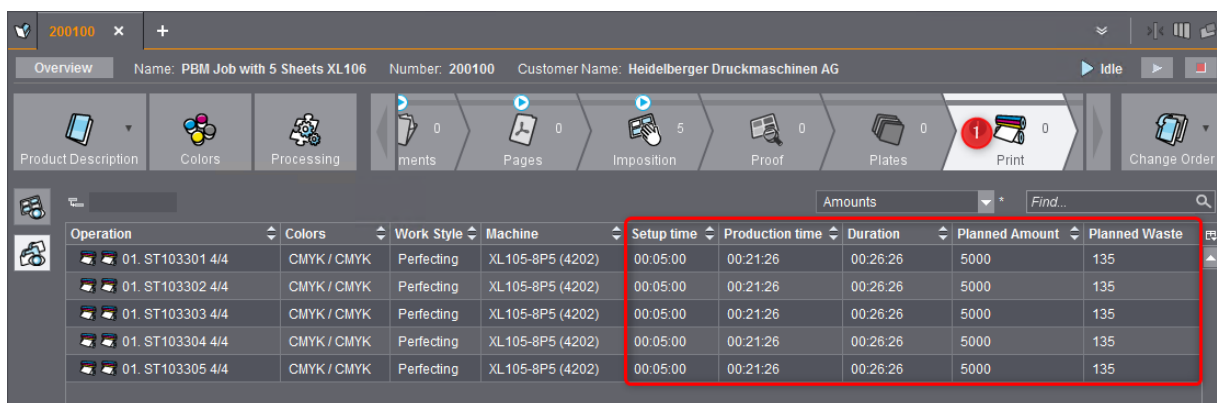


We do not have to produce plates in the PPF workflow, because the plates are done by a 3rd Party workflow. We have to finish the Planning Assistant to apply the settings.

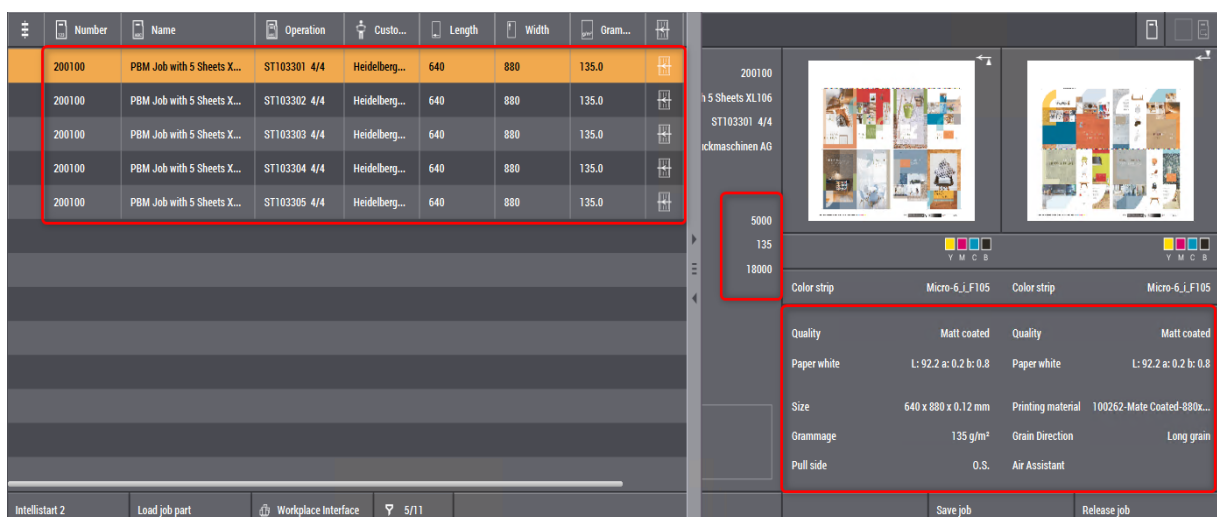


Result

Quantities and duration times are displayed in the Cockpit job...



... and after 1 minute (PressCenter default refresh time) we have all informations at the PressCenter.



3 Prinect Job

3.2.1.5 Printing Material and Grain Direction - to define in sheet properties



Note: When we do not define the Printing Material in the Planning Assistant we will miss detailed paper informations at the PressCenter, because in the PPF workflow we miss very often the Paper Type and the Grain direction.

In this example we see only the actual machine settings and not the correct paper parameters (chapter 4.1.1 and 4.1.2).

Quantity	5000		
Planned Waste	135		
Production speed	18000		
Start			
End			
Notes			
Color strip	Micro-6_i_F105	Color strip	Micro-6_i_F105
Quality	Glossy coated	Quality	Glossy coated
Paper white	L: 0.0 a: 0.0 b: 0.0	Paper white	L: 0.0 a: 0.0 b: 0.0
Size	640 x 880 x 0.14 mm	Printing material	
Grammage	120 g/m ²	Grain Direction	Short grain
Pull side	O.S.	Air Assistant	

Buttons: Preserve machine settings, Save job, Release job

Before Prinect 2019.10 it was necessary to define the right material in the Sheet properties - since Prinect 2019.10 this can be done in the Planning Assistant (last chapter).

Overview | Name: PBM Job with 5 Sheets XL106 | Number: 200100 | Customer Name: Heidelberger Druckmaschinen AG | Idle

Product Description | Colors | Processing | Impositions | Pages | Imposition | Proof | Plates | Print | Change Order

Operation	Colors	Work Style	Machine
01. ST103301 4/4	CMYK / CMYK	Perfecting	XL105-8P5 (4202)
01. ST103302 4/4	CMYK / CMYK	Perfecting	XL105-8P5 (4202)
01. ST103303 4/4	CMYK / CMYK	Perfecting	XL105-8P5 (4202)
01. ST103304 4/4	CMYK / CMYK	Perfecting	XL105-8P5 (4202)
01. ST103305 4/4	CMYK / CMYK	Perfecting	XL105-8P5 (4202)

Selection: 5 of 5 operations

Printing Material

Width/Height Unit: mm

Description:

Brand:

Article Number:

Type of Printing Material for Calibration:

Paper Grade (ISO):

Quality:

Type of material:

Width [mm]: 880,0

Height [mm]: 640,0

Thickness [mm]: 0,145

Grammage [g/m²]: 120,0

Grain Direction: Unknown

Feed Direction: Unknown

Ink Consumption Factor [%]: 0,0

L*:

a*:

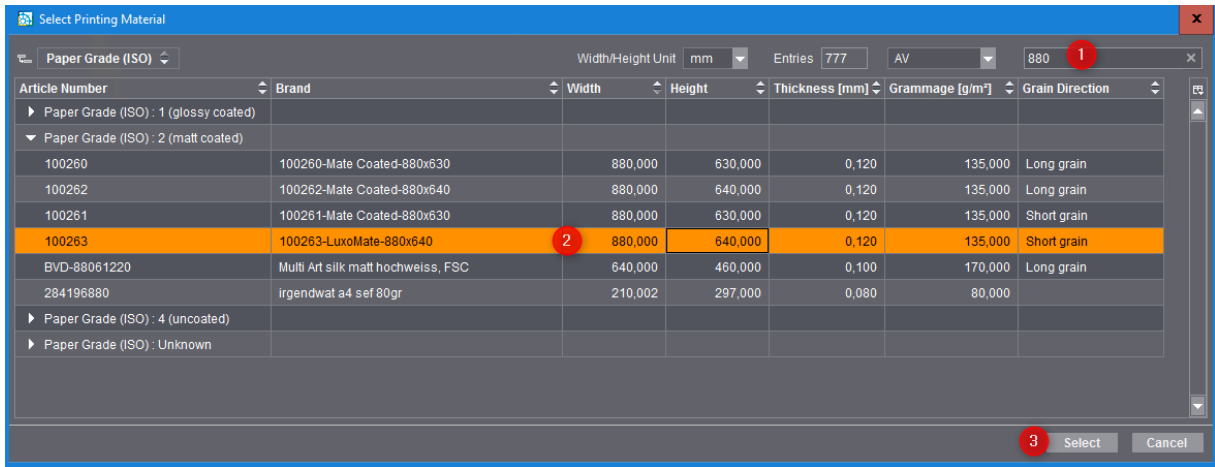
b*:

Availability:

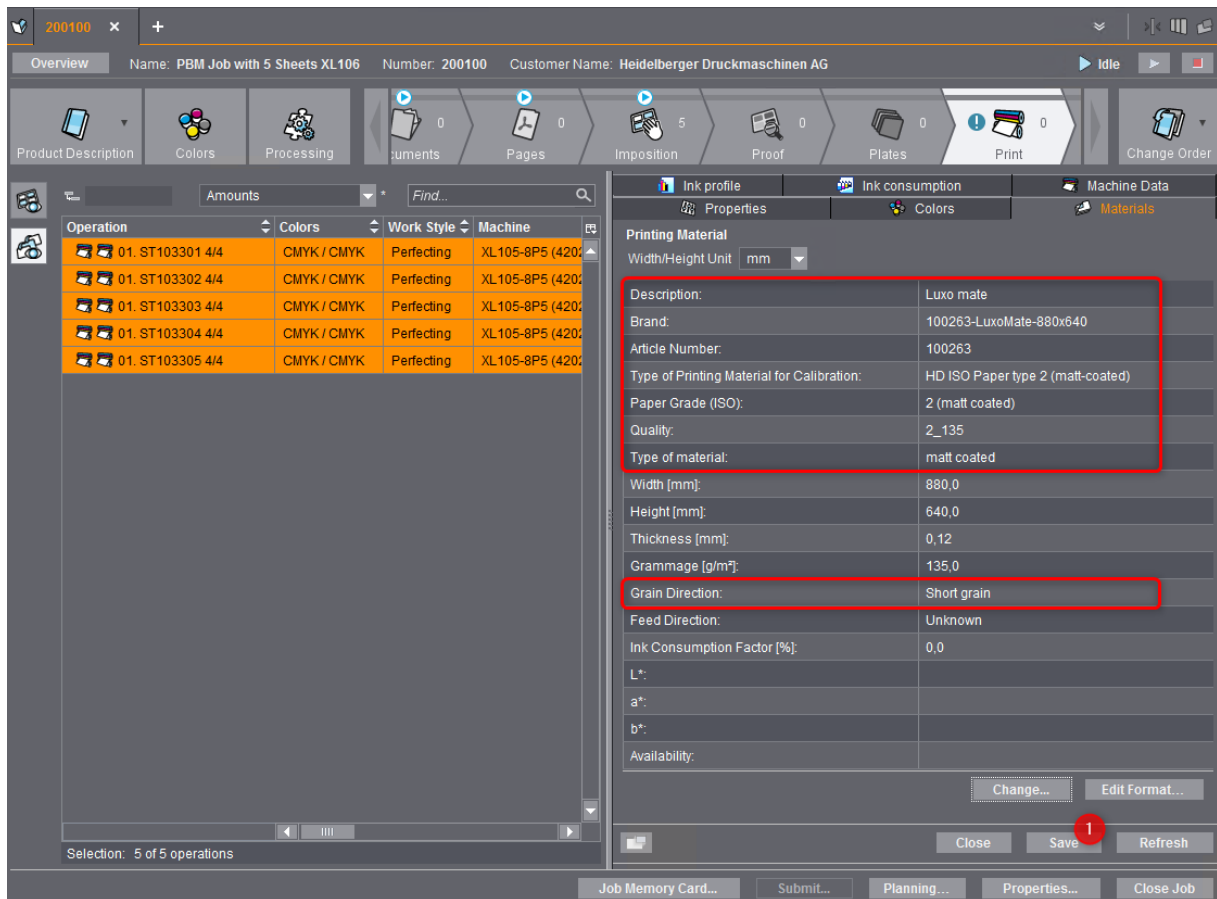
Buttons: Change..., Edit Format..., Close, Save, Refresh

Buttons: Job Memory Card..., Submit..., Planning..., Properties..., Close Job

Paper definition from the MDS to get better informations...







... at the PressCenter.



3 Prinect Job

After 1 minute refresh time we have the right informations of the printing material at the PressCenter.

Job data	Instructions	
Number	200100	
Name	PBM Job with 5 Sheets XL106	
Operation	ST103301 4/4	
Customer	Heidelberger Druckmaschinen AG	
Date		
Quantity	5000	
Planned Waste	135	
Production speed	18000	
Start		
End		
Notes		
		
		
	Color strip	Color strip
	Micro-6_i_F105	Micro-6_i_F105
	Quality	Quality
	Matt coated	Matt coated
	Paper white	Paper white
	L: 0.0 a: 0.0 b: 0.0	L: 0.0 a: 0.0 b: 0.0
	Size	Printing material
	640 x 880 x 0.12 mm	100263-LuxoMate-880x640
	Grammage	Grain Direction
	135 g/m ²	Short grain
	Pull side	Air Assistant
	O.S.	
<input type="checkbox"/>	<input checked="" type="checkbox"/> Preserve machine settings	
	Save job	Release job



Note: It is not possible to define Lab values for the Printing Material in the Cockpit at the moment. This has to be done in the PressCenter (chapter 4.3.2).

3.2.2 Imposed PDF Workflow

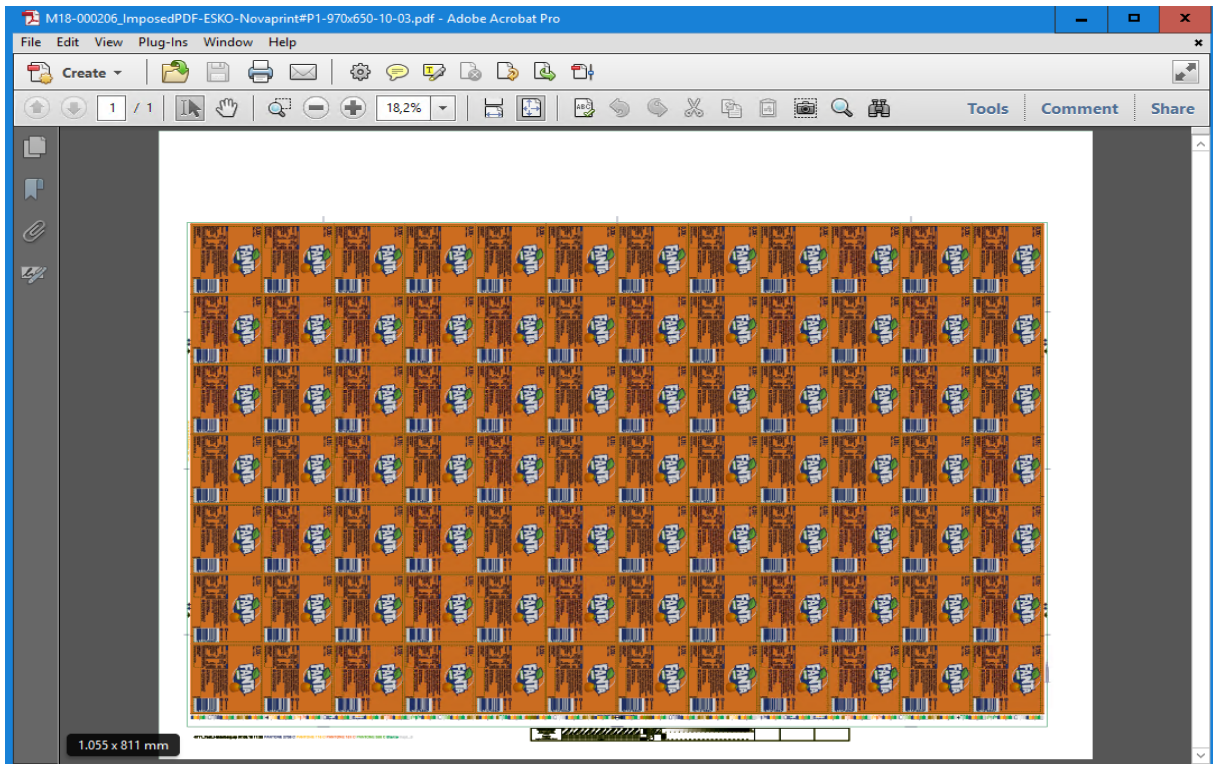
Approximately 5% of our customers have such a workflow.

Customer Equipment

- 3rd Party Prepress (Esko, Kodak, Agfa, Fuji, Screen) with Imposed PDF output
- Production Manager
- Heidelberg Platesetter (Suprasetter)
- PressCenter / Data Terminal

In this workflow we get only a "Imposed PDF", created in a 3rd Party workflow

1. The PDF page size should have the same dimension as the plate



2. We can use a hotfolder with a "Group Template" or a "Smart Template" to create these jobs.



3 Prinect Job

3. We can use 4 dynamic layouts in "AutoSheet" to impose the PDF page and the workstyle.
Special layout in: [\PTConfig\SysConfig\Resources\ImpositionEditorLayoutTemplates](#)
 - F1-1 1x1-ImposedPDF.jdf - Media box = Plate size / Trim box = Paper size (New in P2020)
 - F1-1 1x1-PageSize.jdf - for "Single Sided" and "Work & Turn" jobs
 - F2-1 1x1 C-PageSize.jdf - for "Perfactor" jobs
 - F2-1 1x1-PageSize.jdf - for "Sheetwise" jobs
4. We do not have information about times and quantities - possible to do manually with the "Planning Assistant" (chapter 2.2.1.1) or automatically by PDF file name and "Smart Templates".
5. We do not have any information about the "Printing Material" - only possible to add manually (chapter 2.2.1.2).

3.2.3 Manual Prinect Workflow (Detailed Description)

Approximately 25% of our customers have such a workflow.

Customer Equipment

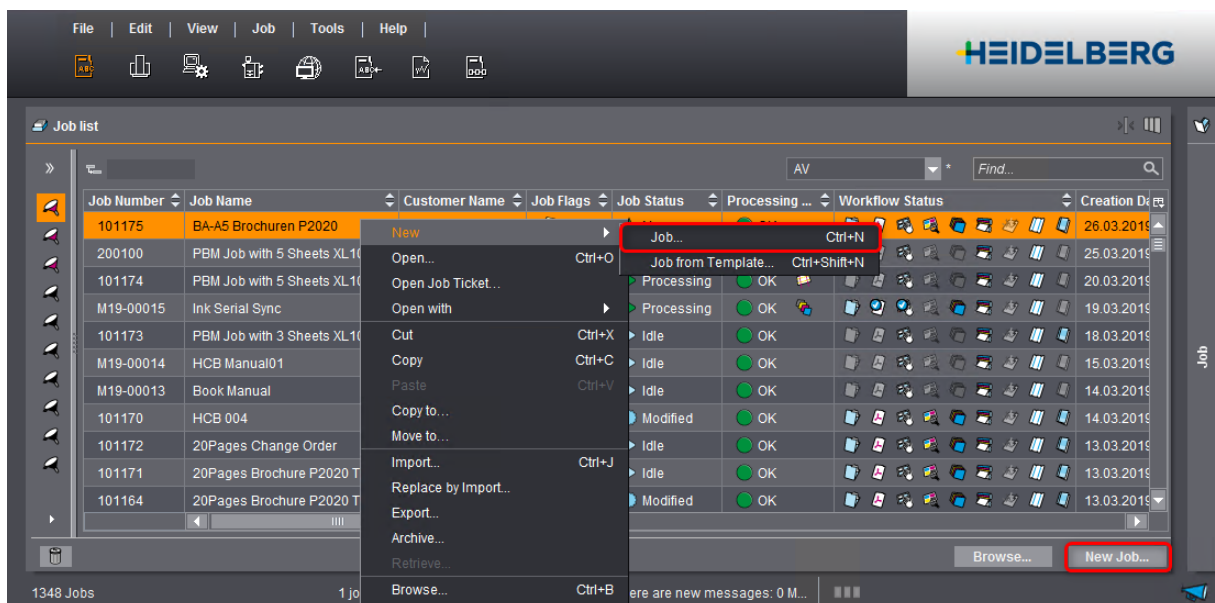
- No MIS connection
- Production Manager
- Heidelberg Platesetter (Suprasetter)
- PressCenter / Data Terminal

In this workflow we get PDF pages only

1. Manual job creation in Cockpit
2. Add PDF documents to the job => Qualify + Prepare files
3. Create a Signa Station layout with assigned pages
4. Planning Assistant - to create operations with quantities and duration times
5. Submit sheets to plate making and sheetfed printing

3.2.3.1 Manual Job Creation in Cockpit

We can create a new job in the job list when we have the right user rights.

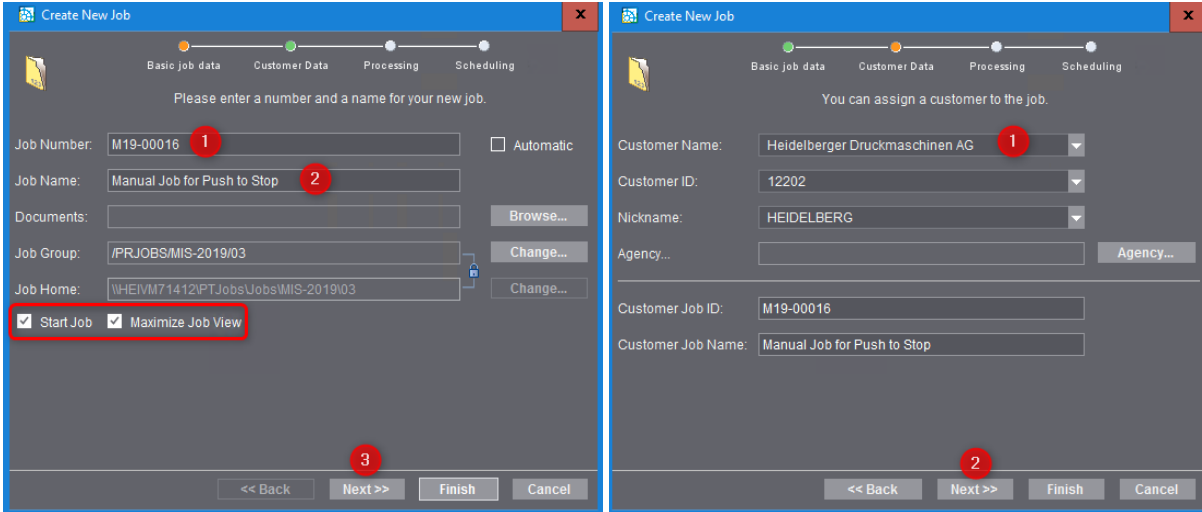


3 Prinect Job

Cockpit settings are user specific - the user interface remembers the last used user settings.

Job number and name are mandatory

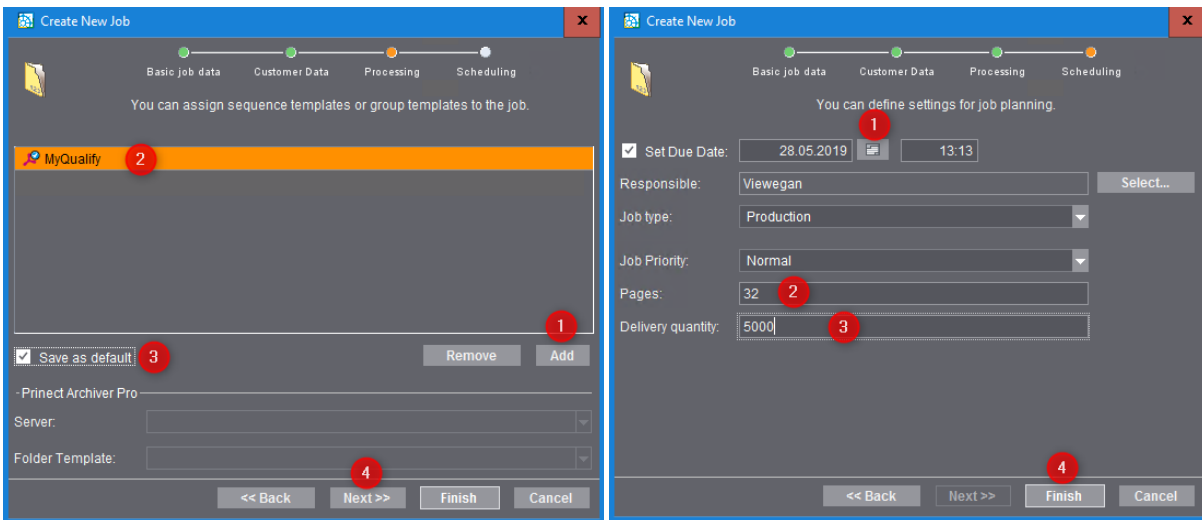
We can define a existing customer



Note: New customers are to create in Cockpit > Administration > Customer.

Qualify is necessary to add PDF files

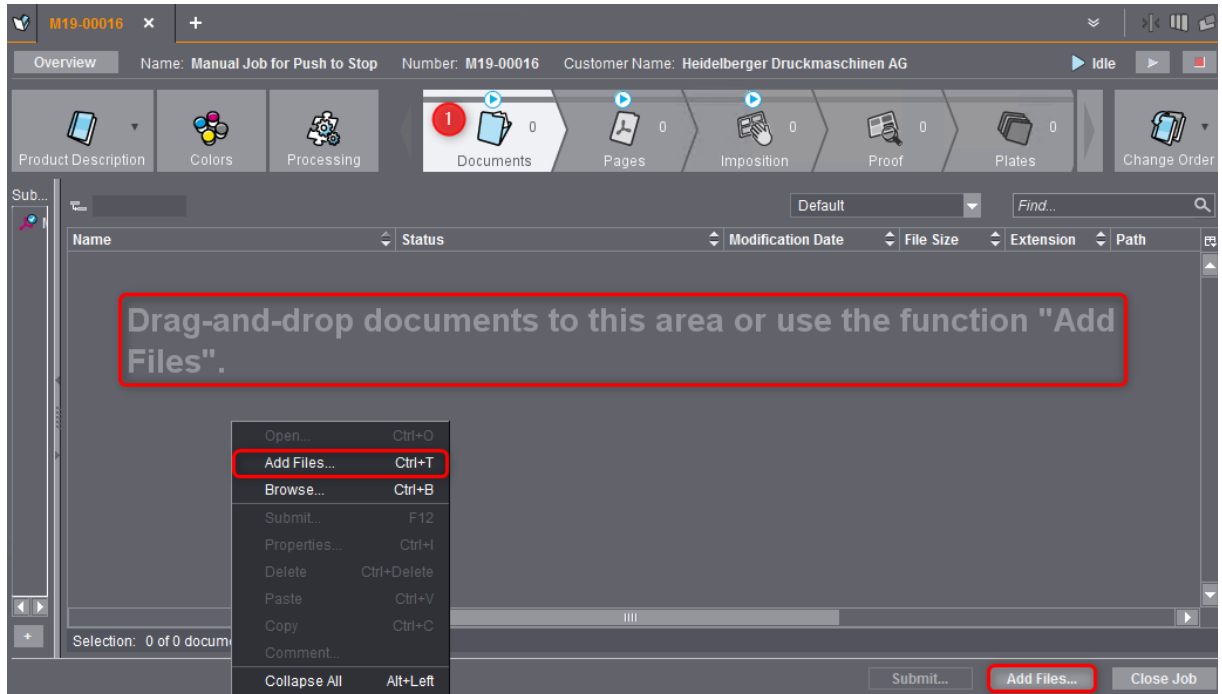
We can define due date, pages and quantity



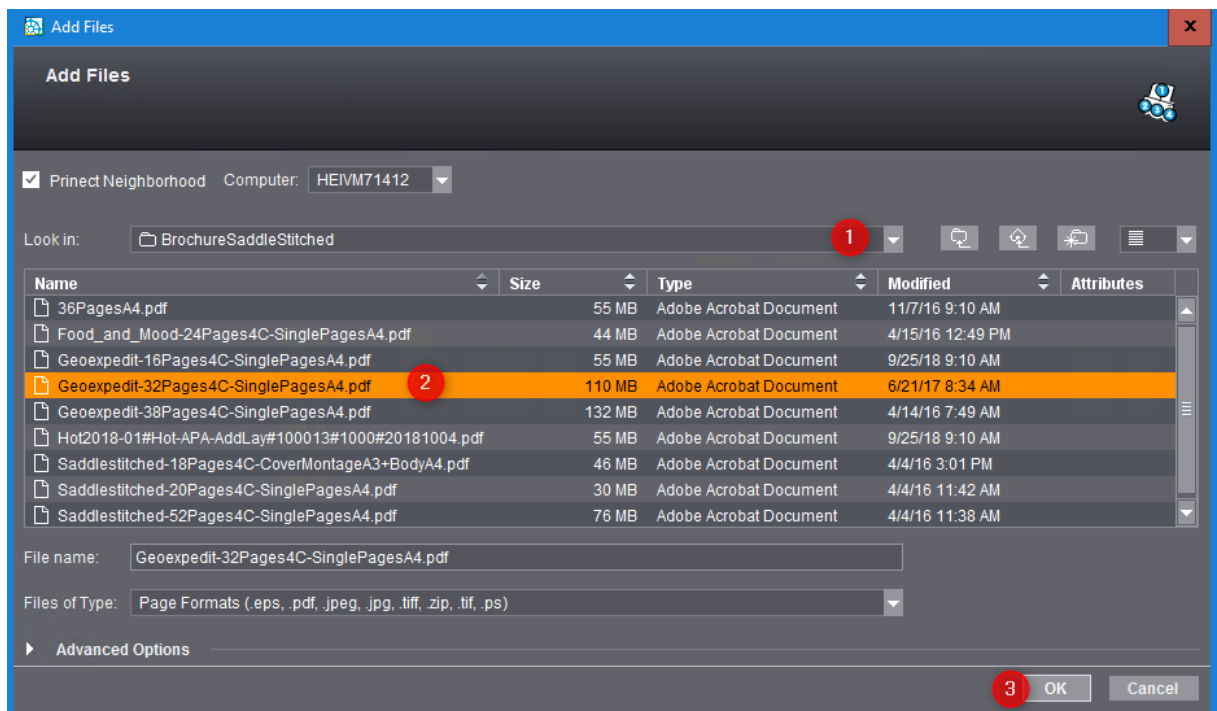
Note: We can define customer, due date, pages and quantity later in the job too, but it is easier to do it by job creation.

3.2.3.2 Add PDF documents to the job => Qualify + Prepare files

The Job is automatically opened and displays the workflow step "Documents", where we have to add PDF files.

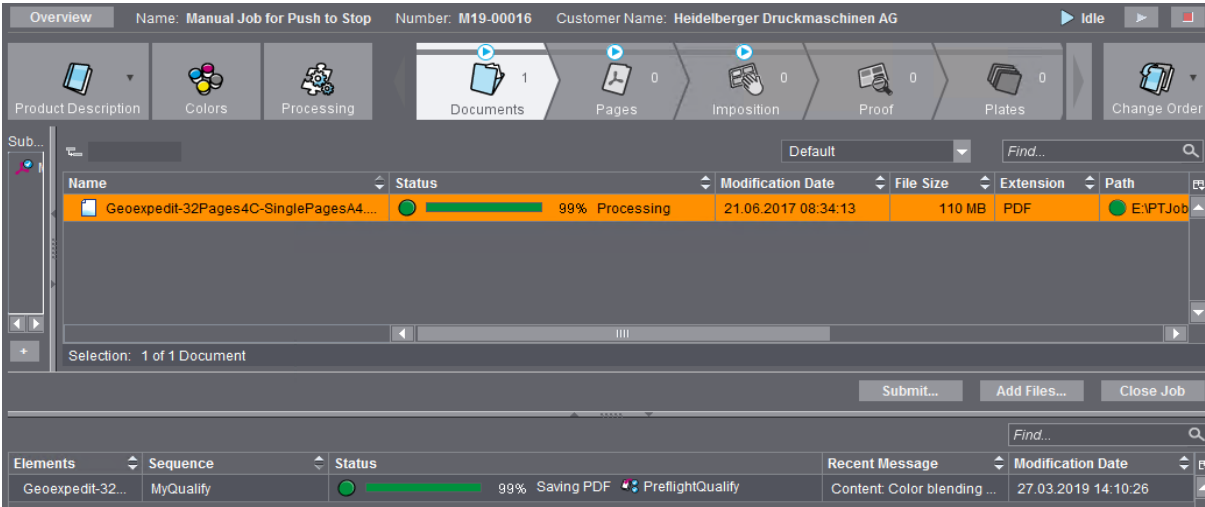


After files are added to the job...

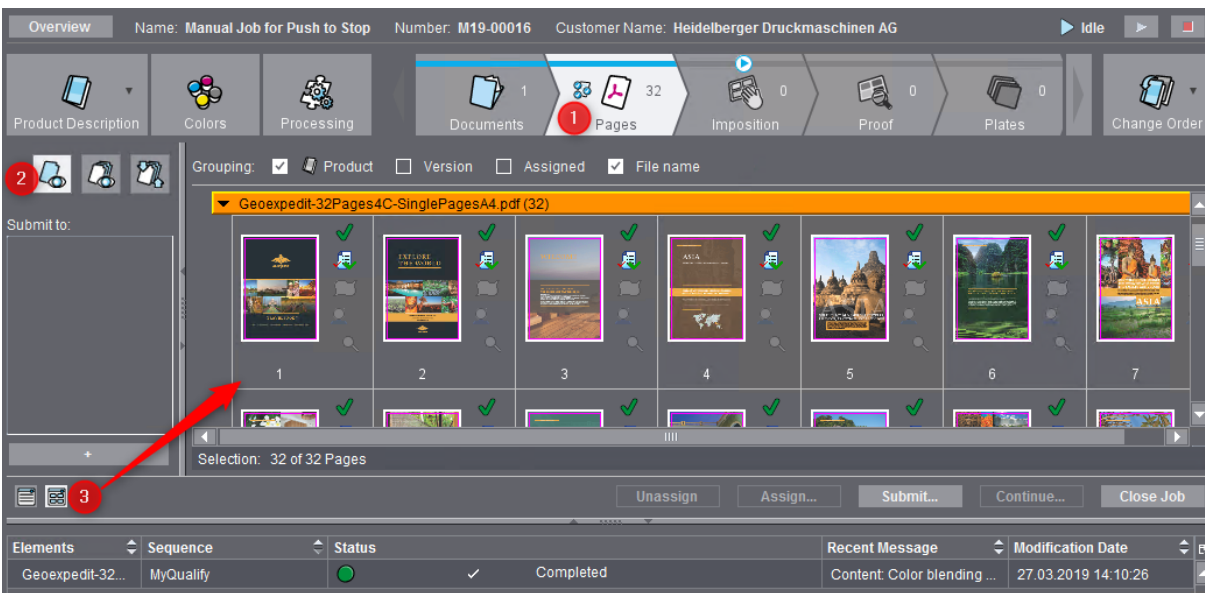


3 Prinect Job

... they will run automatically through the "Qualify" sequence - Qualify is checking the PDF quality.

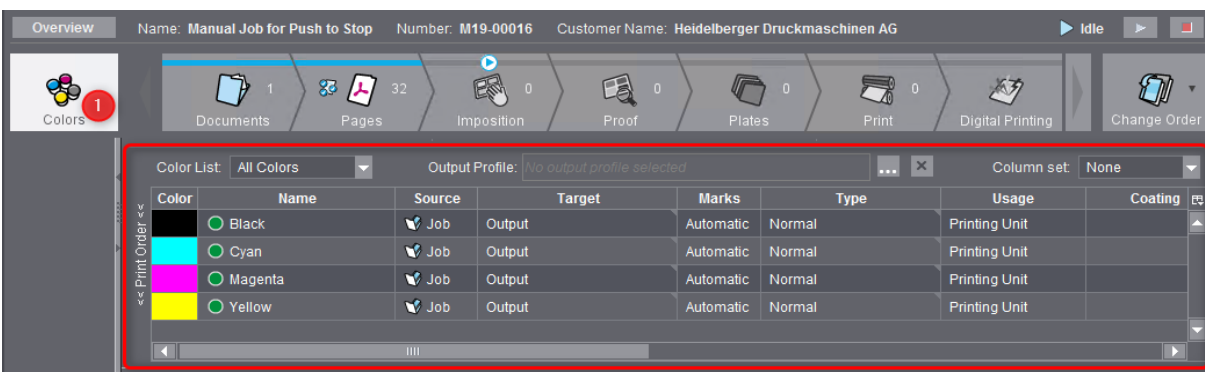


After Qualify we can see the pages with thumbnails.

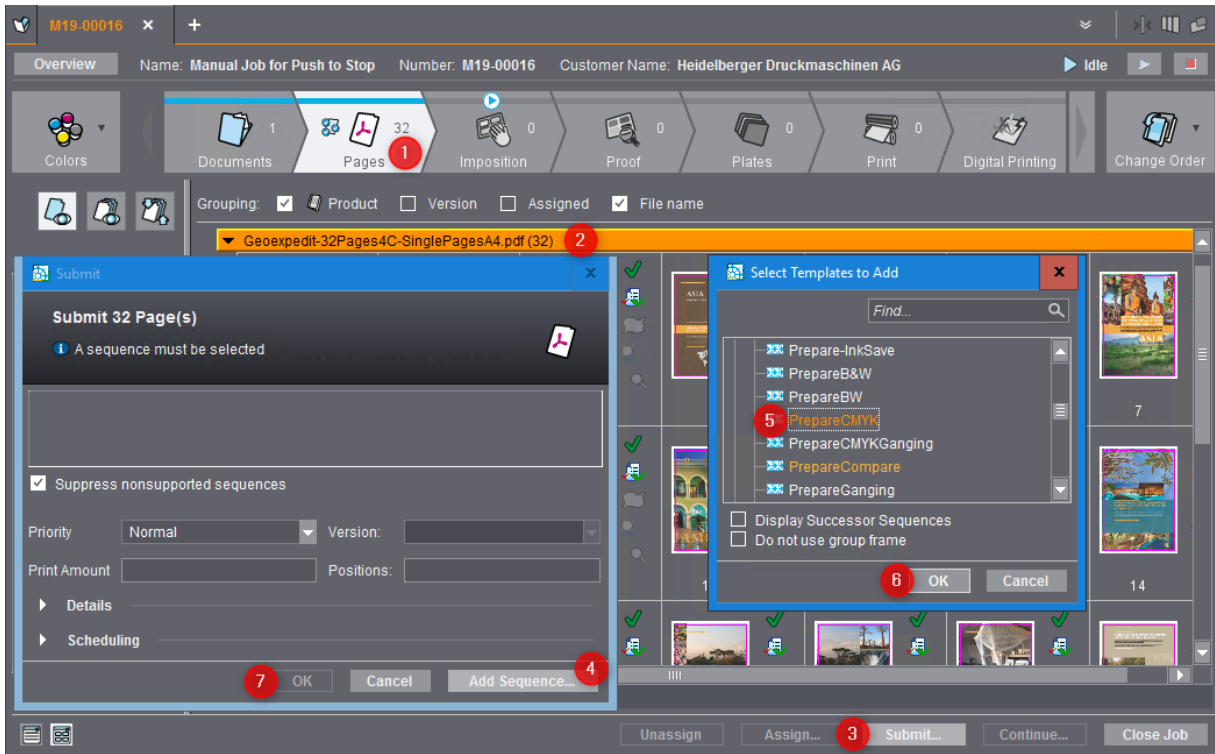


After Qualify we know about the quality of the PDF.

We should have a look for the PDF Colors before we submit the pages to a "Prepare" sequence.

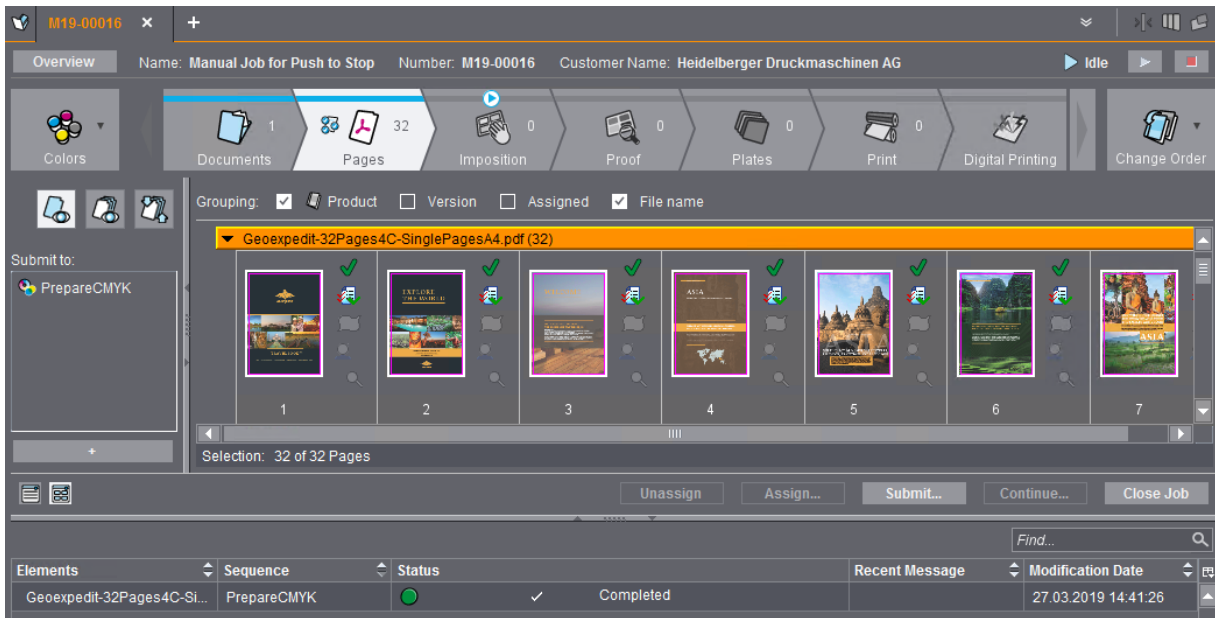


All pages have to run through a "Prepare" sequence for "Color Management" and "Trapping".



In this condition we can generate page proofs or digital prints.

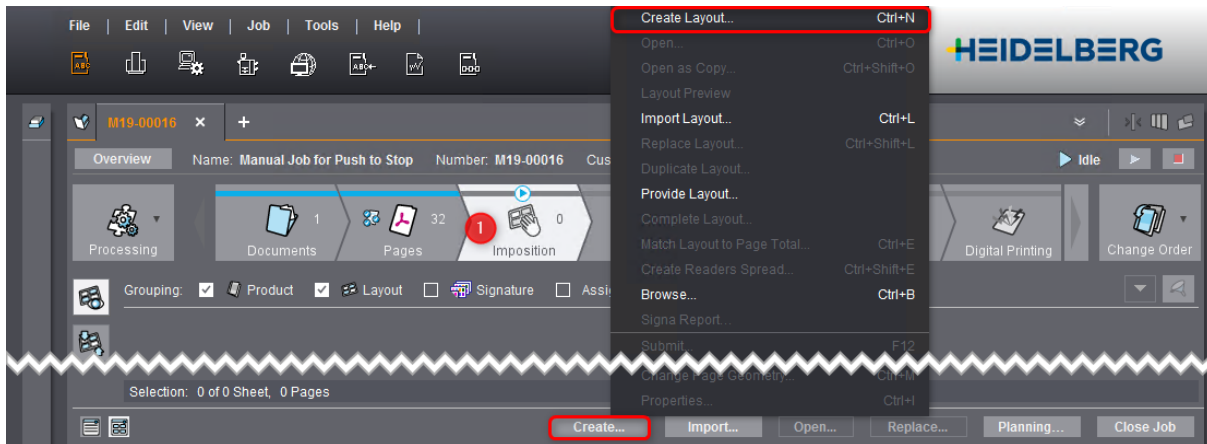
For plate output and press operations with ink-presettings we need a Signa Station layout.



3 Prinect Job

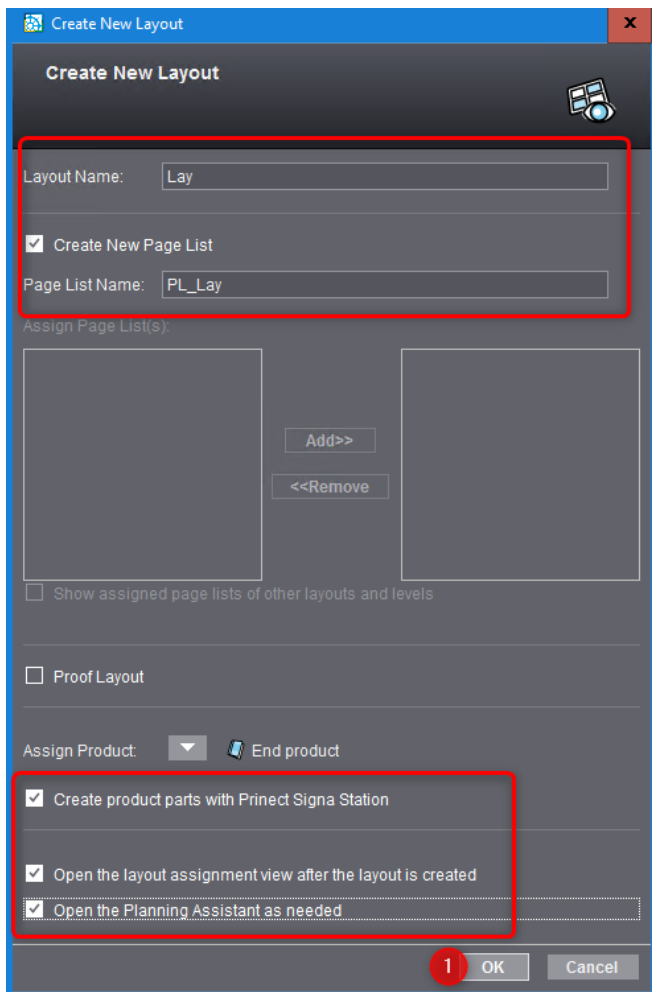
3.2.3.3 Create a Signa Station layout with assigned pages

When Signa Station is installed at the same computer we can use "Create Layout" in the Cockpit.



After we have created the layout in Signa Station we want to

- assign pages to page list - assignment and order of pages in the layout
- start the Planning Assistant to generate a process net to get operations with quantities and times

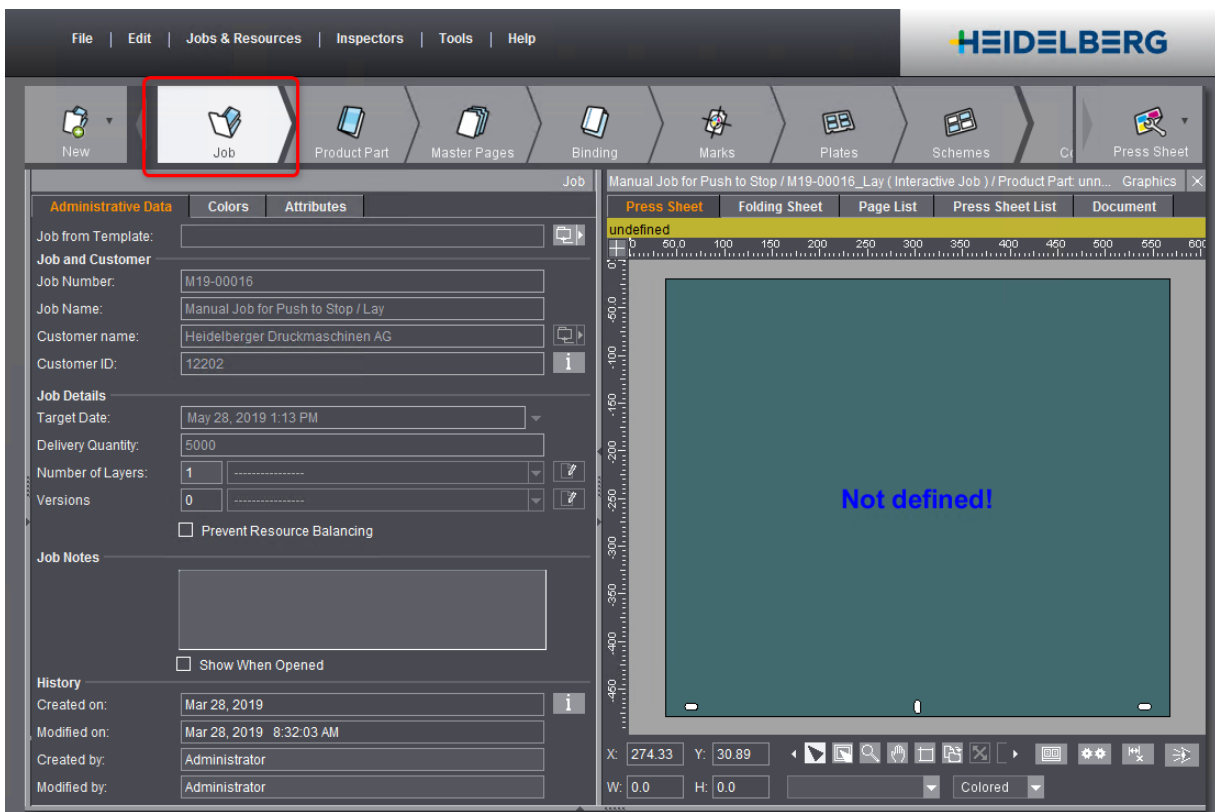


The Signa Station is starting now at the computer...



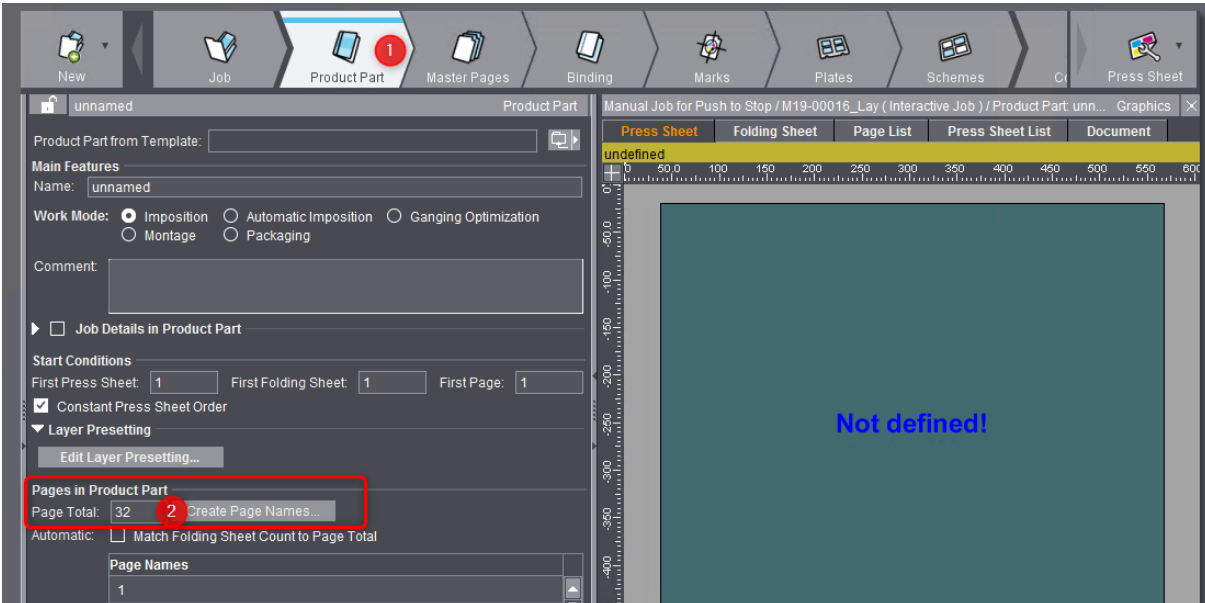
... and opens an empty layout.

The Job header is predefined by the Cockpit.

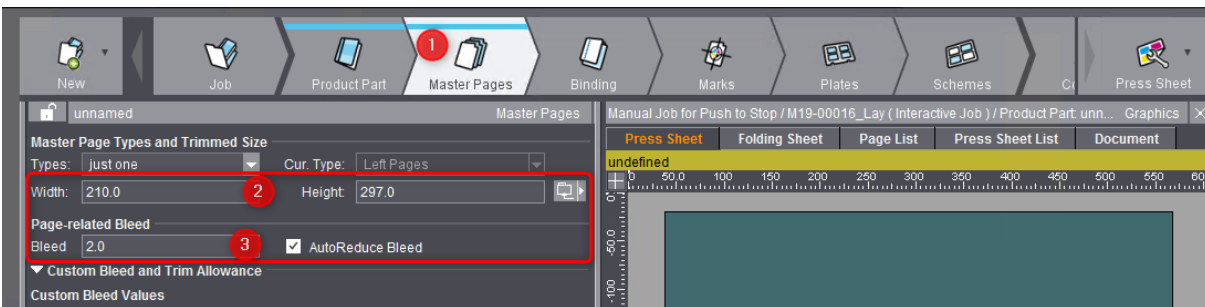


3 Prinect Job

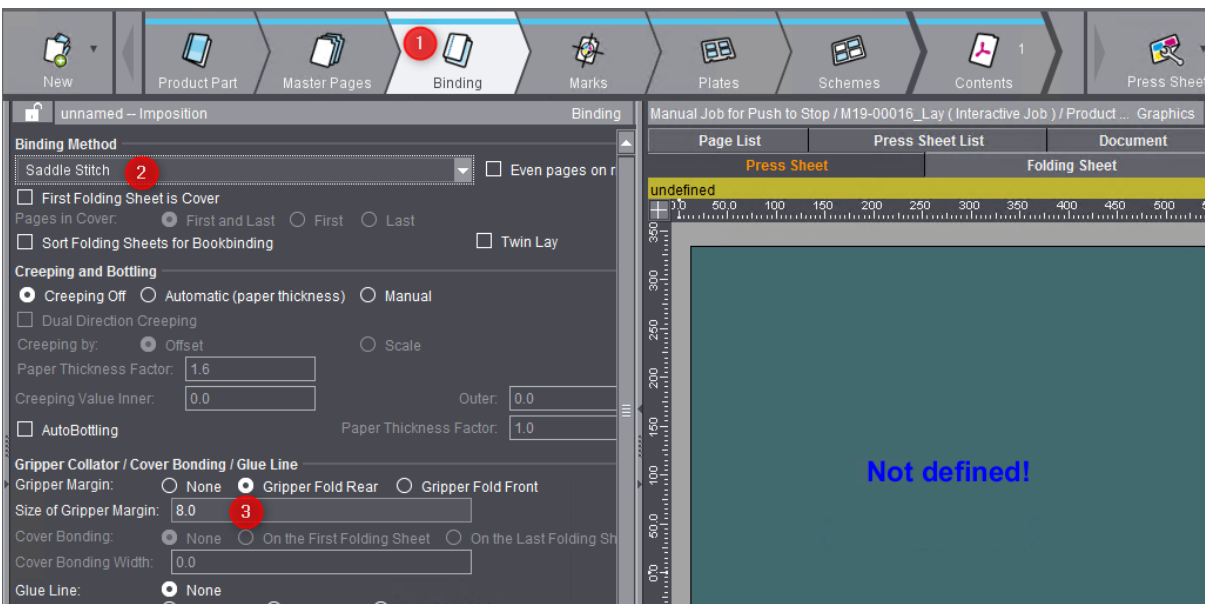
The page amount is predefined by Cockpit, when necessary we can overwrite the amount.



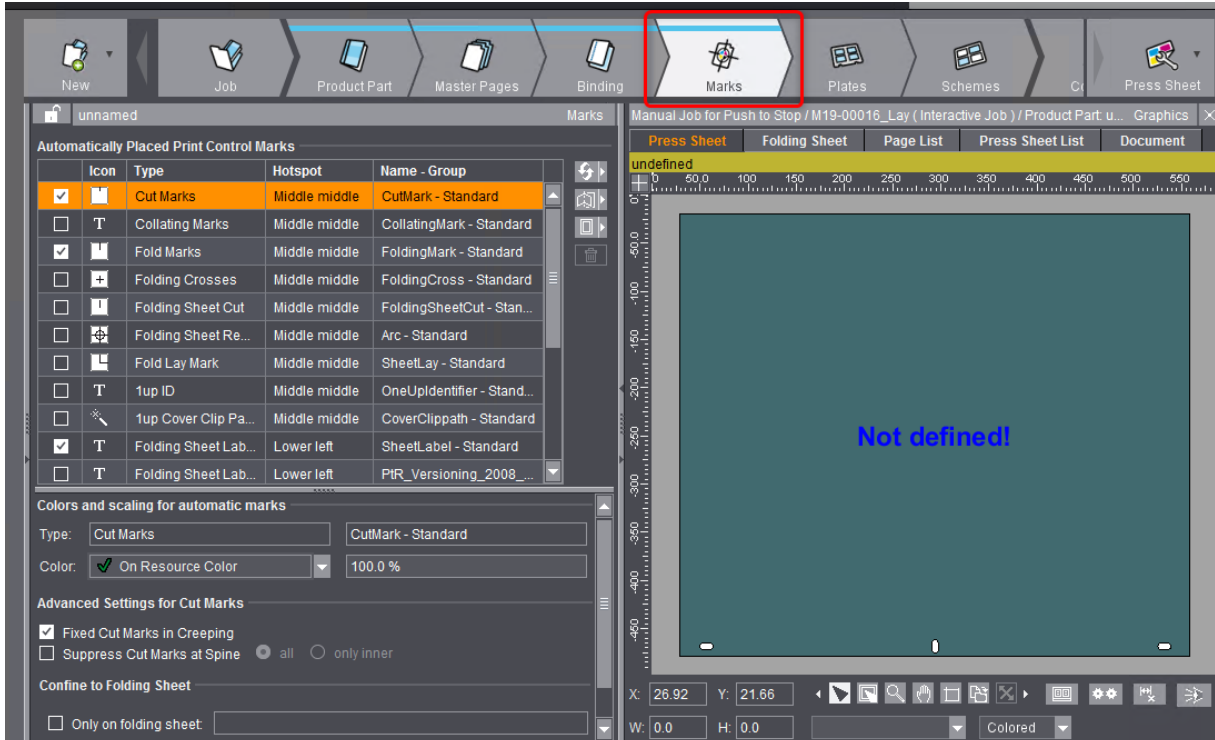
The Signa Station default page size is A4, the bleed is normally 2 or 3 millimeters.



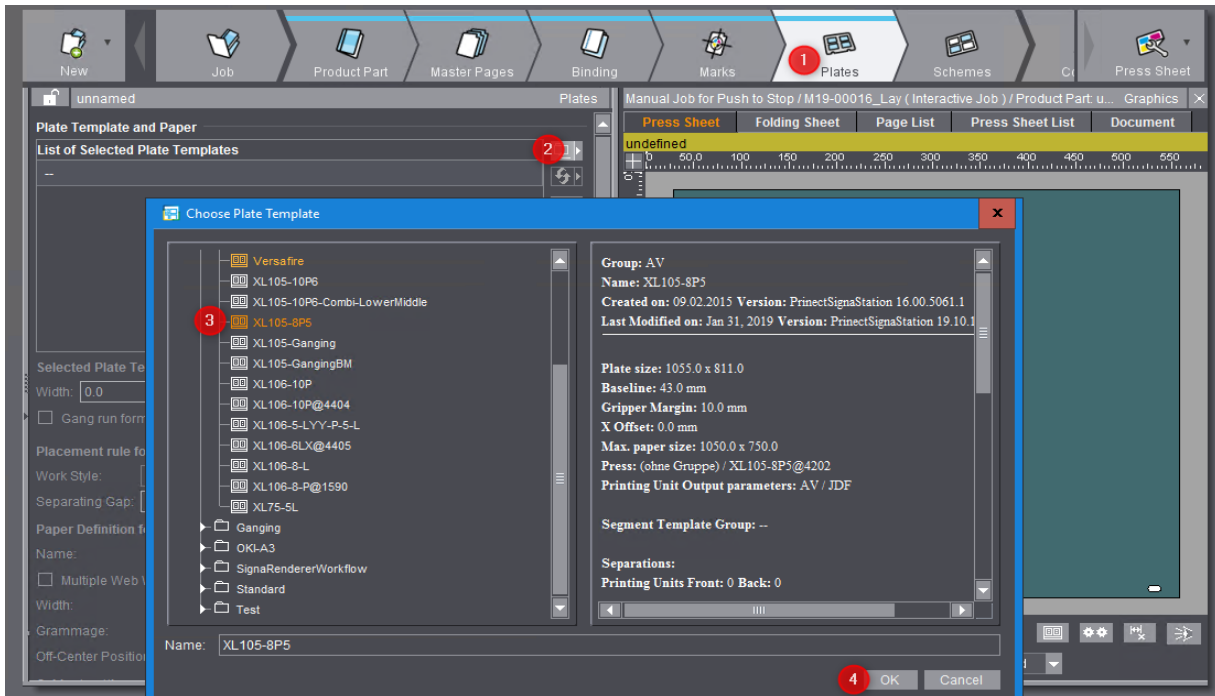
For a saddle stitched brochure we need a gripper.



By default the Cut-, Fold- and Folding Sheet Label-mark are enabled.



We have to select the plate template of the press on which we want to print.

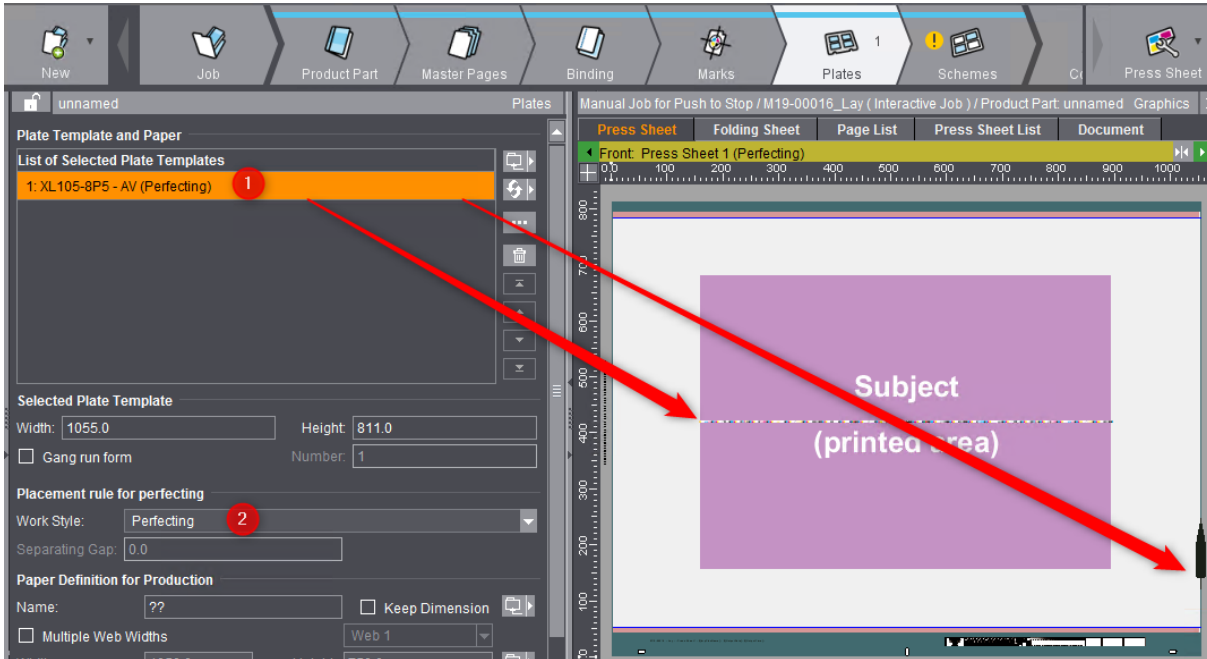


3 Prinect Job

The plate template should have a placed a

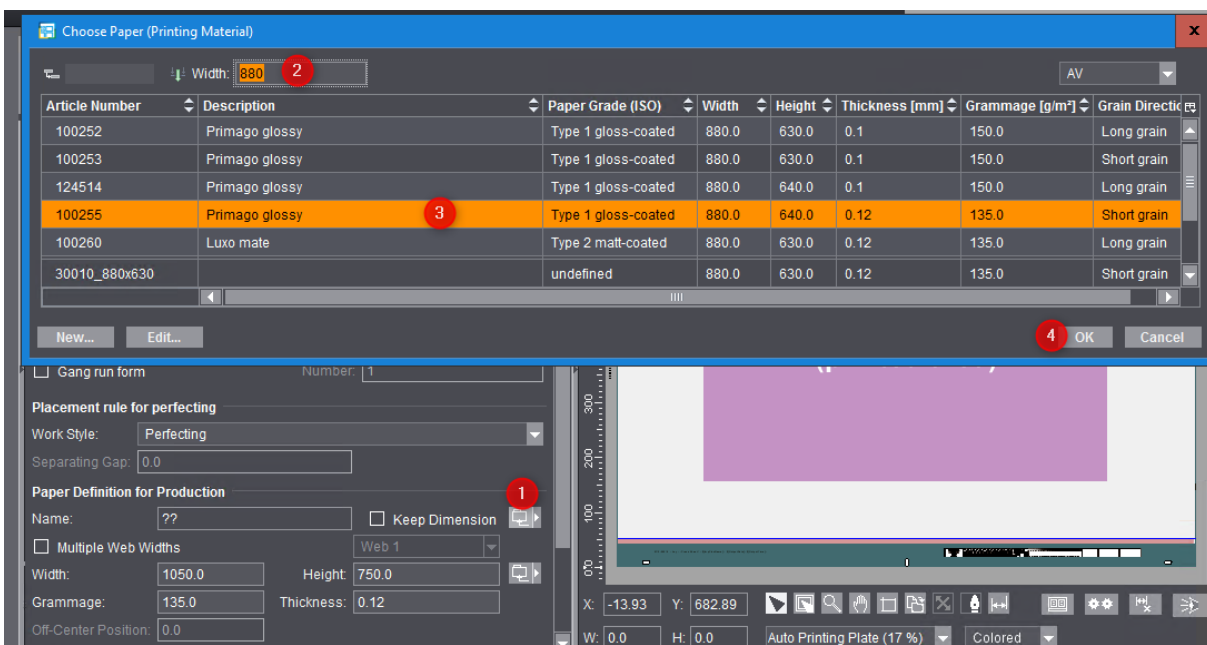
- "Color Bar" on the right position for the Heidelberg measuring system
- "Pull Lay" to display the Pull side at the PressCenter

The "Work Style" is very important for the right positioning and for the press operation.

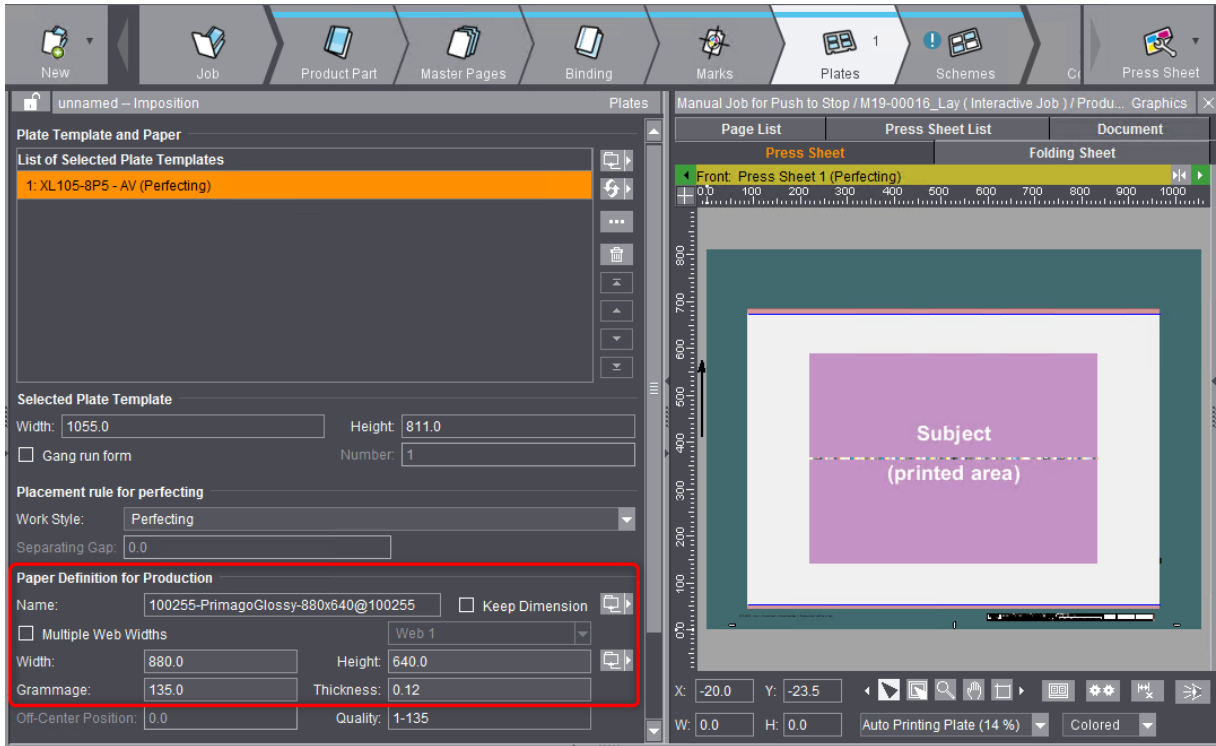


Note: The Pull side will be only transferred when in CDM Properties in Cockpit Administration/System "Transfer sheet Lay to Press" is enabled.

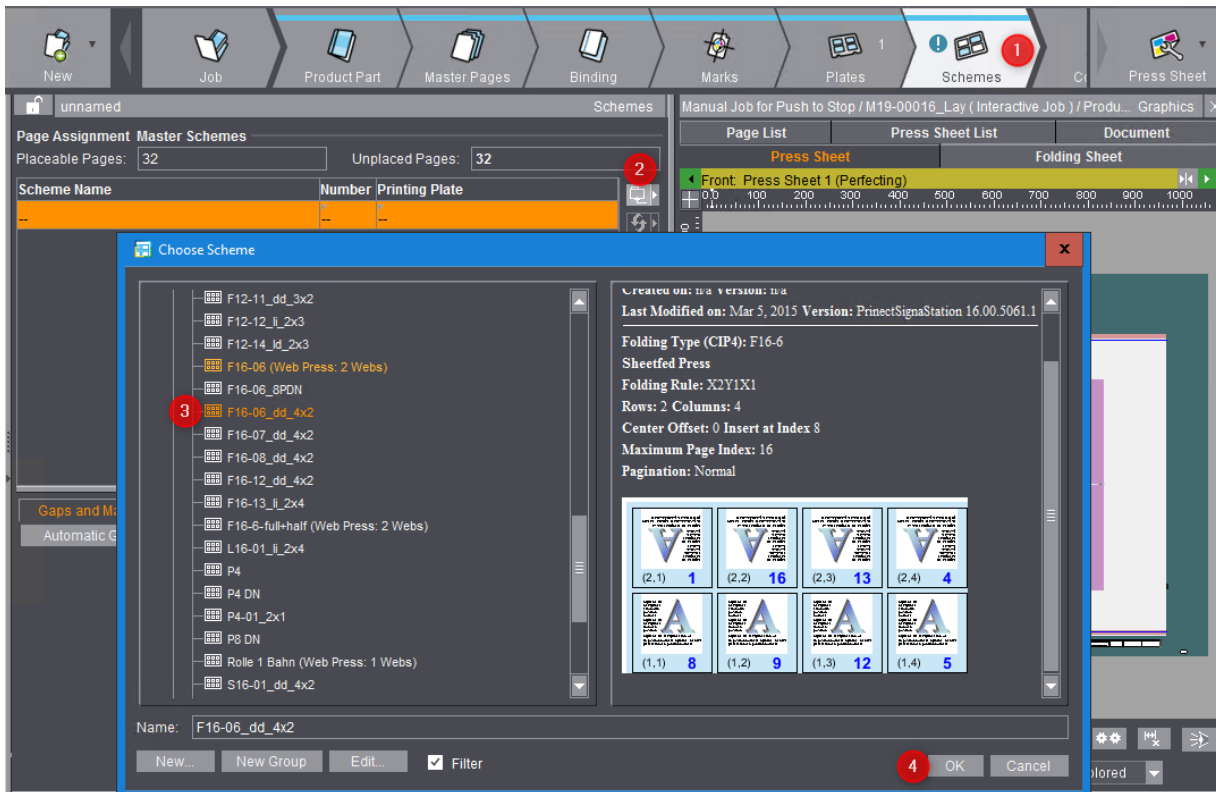
We have to select the right paper with all informations from MDS (chapter 2).



Now we have all paper informations for the PressCenter defined.



After we have defined the right folding sheet...

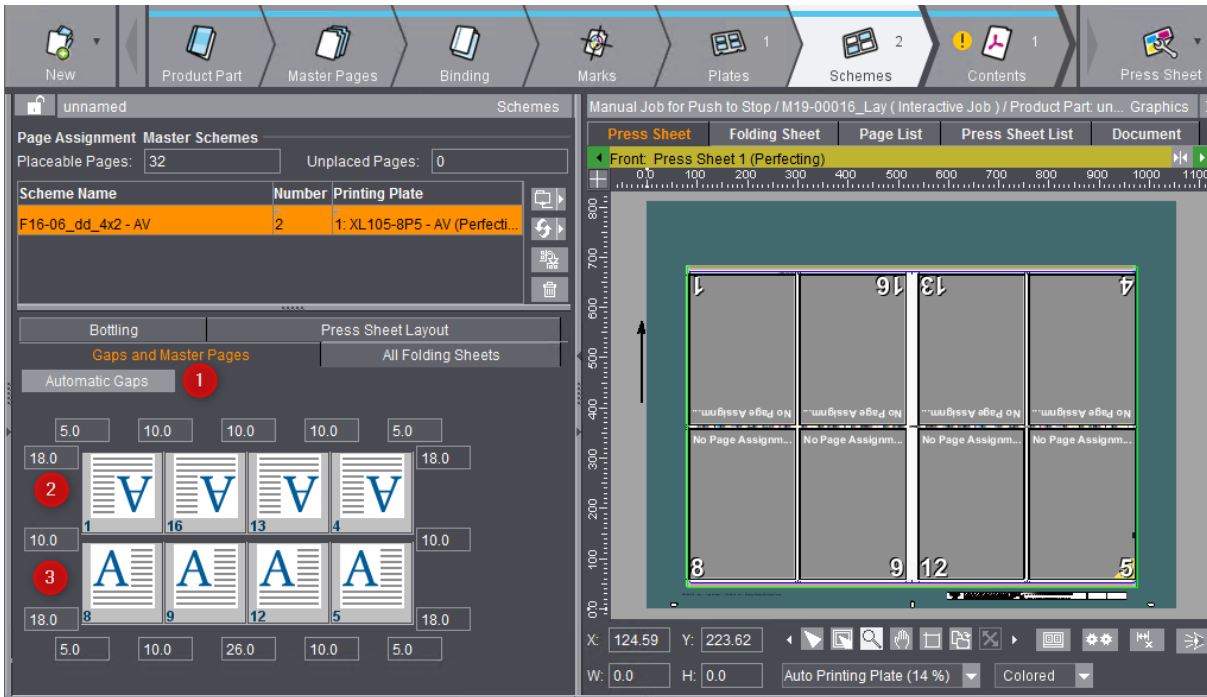


3 Prinect Job

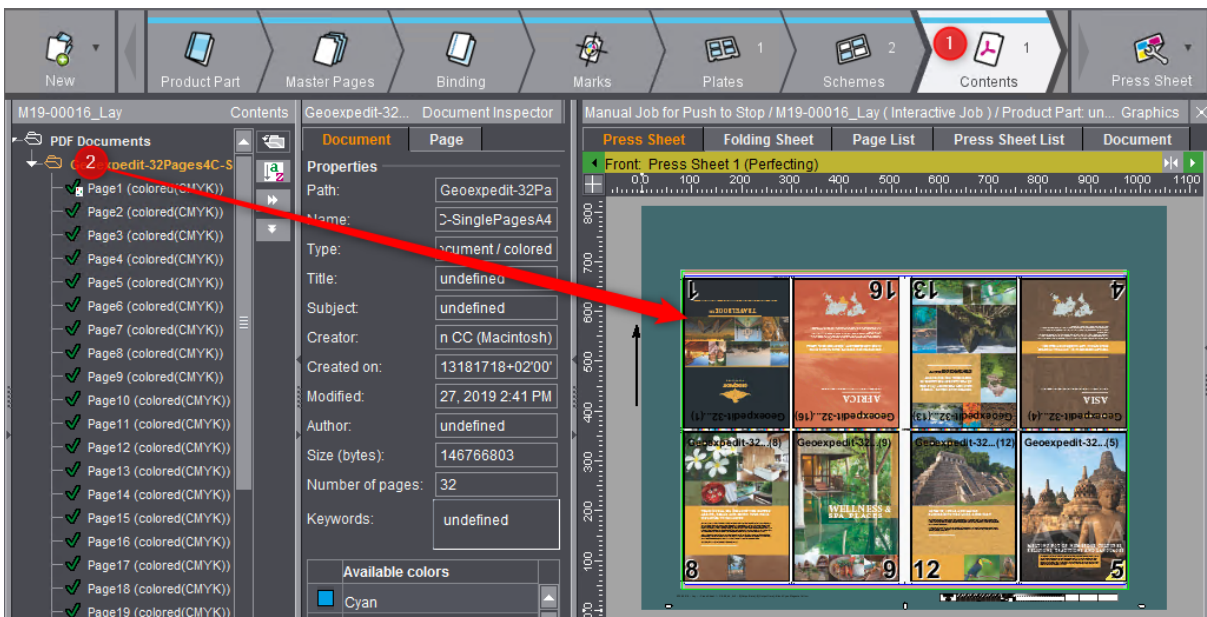
... we have to define the intermediates.



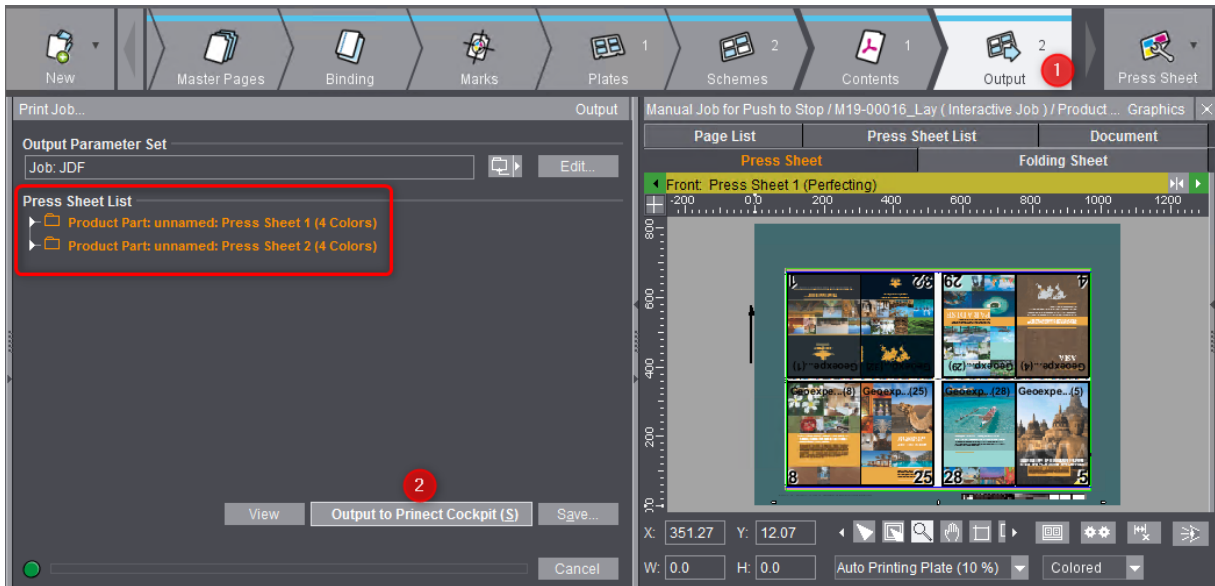
Note: We do not generate a cutting file for Polar Mohr, when the "green line" is exactly at the edge of the plate template.



It is possible to assign the pages now in Signa Station to the positions or we can do this in the Cockpit after layout import.



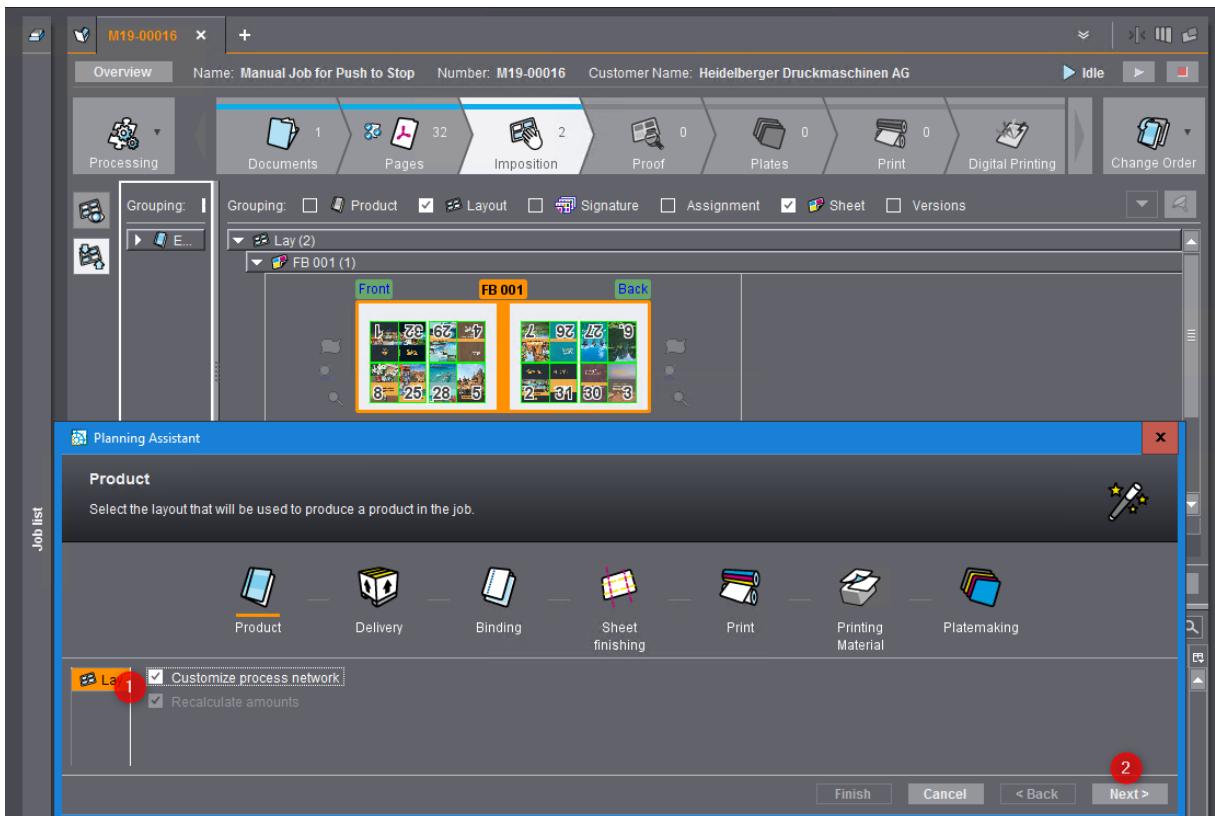
Finally we have to output the layout into the Cockpit.



3.2.3.4 Planning Assistant - to create operations with quantities and duration times

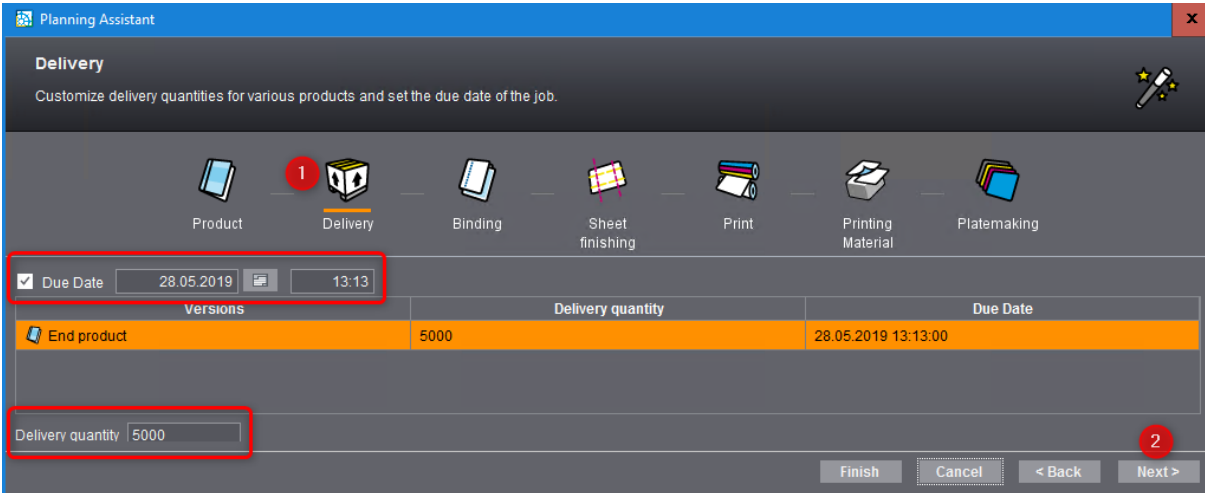
We are now again in the Cockpit.

When we have selected "Open Planning Assistant when needed" in the layout creation dialog the Planning Assistant starts now automatically. We want to generate a process network with amounts.



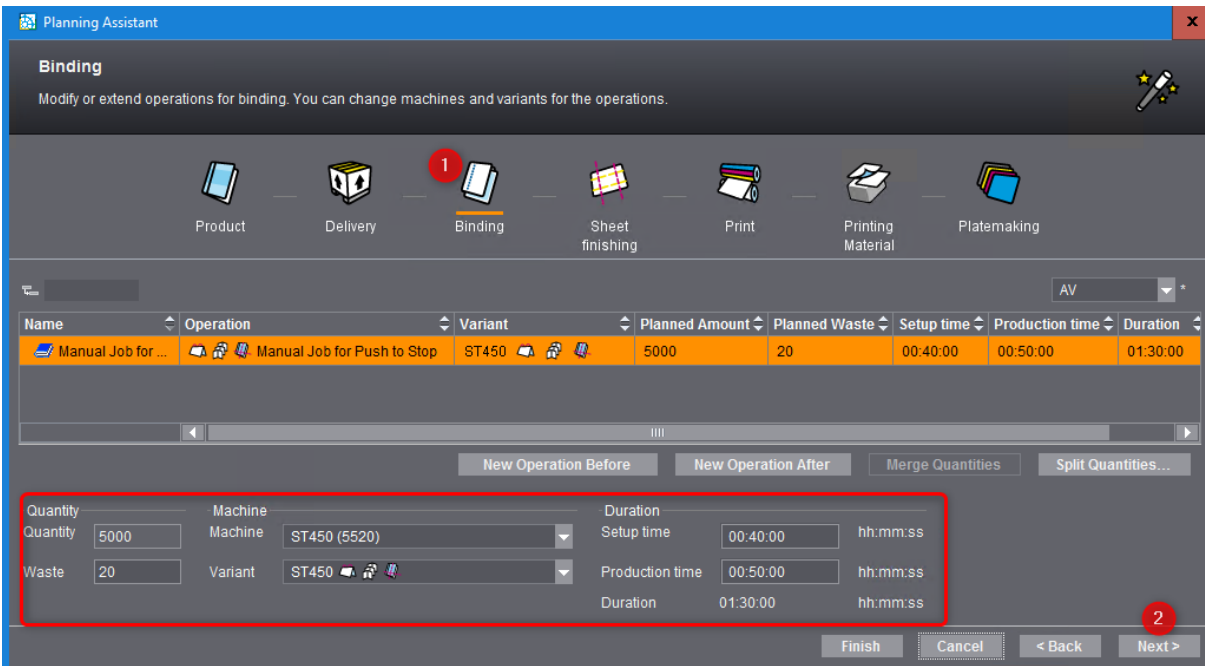
3 Prinect Job

We have predefined due date and quantity by job creation.



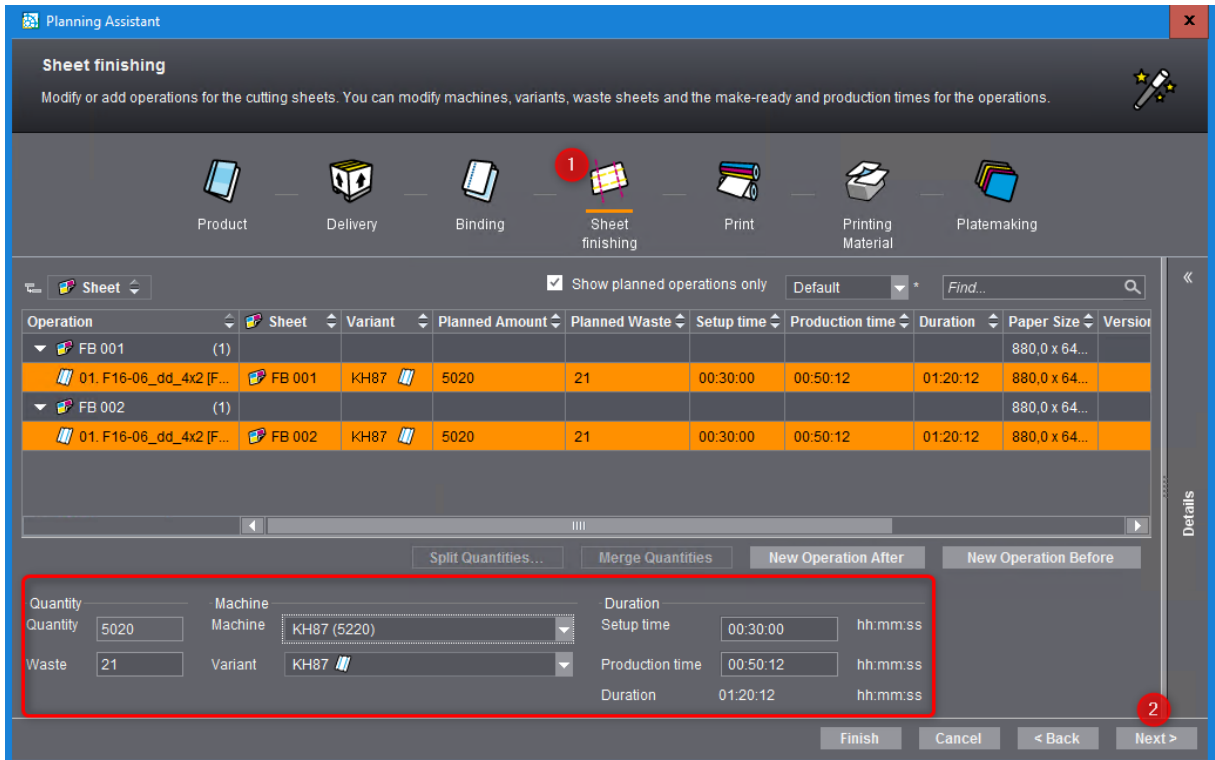
Saddle stitching was defined by Signa Station as the "binding type".

- This dialog is only available if we have the "Postpress Manager" license.
- A postpress device with such a device class has to be created in the CDM.

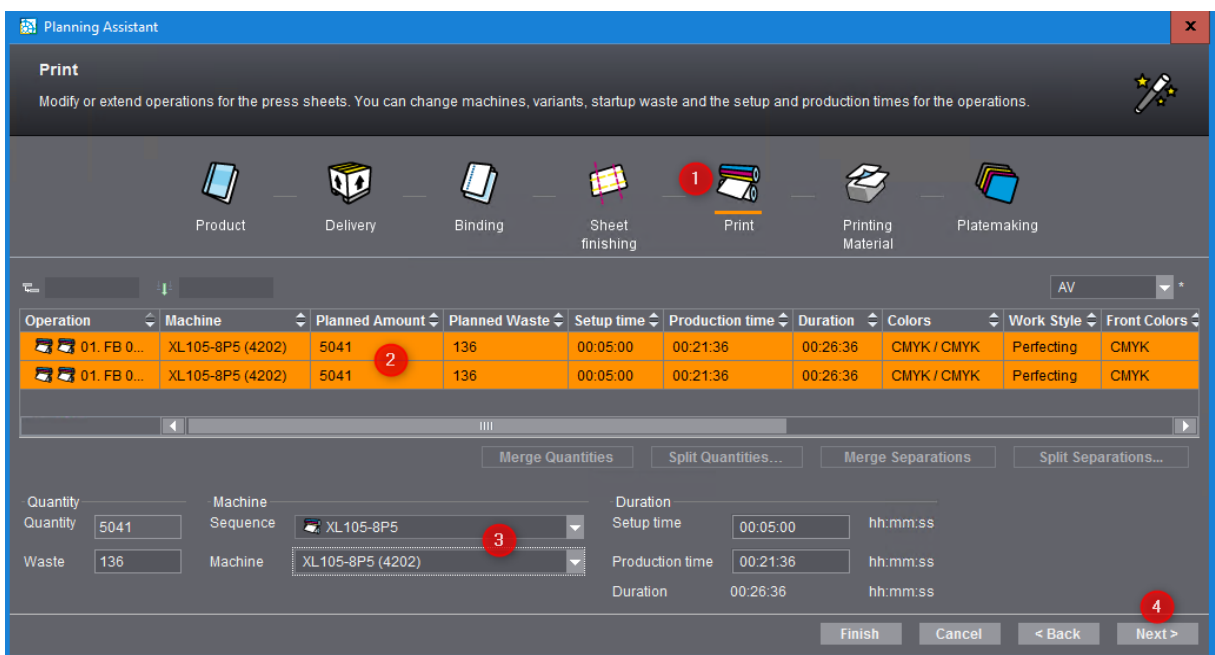


Folding operations are generated by the Signa Station layout (Postpress license required).

- This dialog is only available if we have the "Postpress Manager" license
- A postpress device with such a device class has to be created in the CDM
- When we have Signa cutting informations in the layout we would get cutting operations too

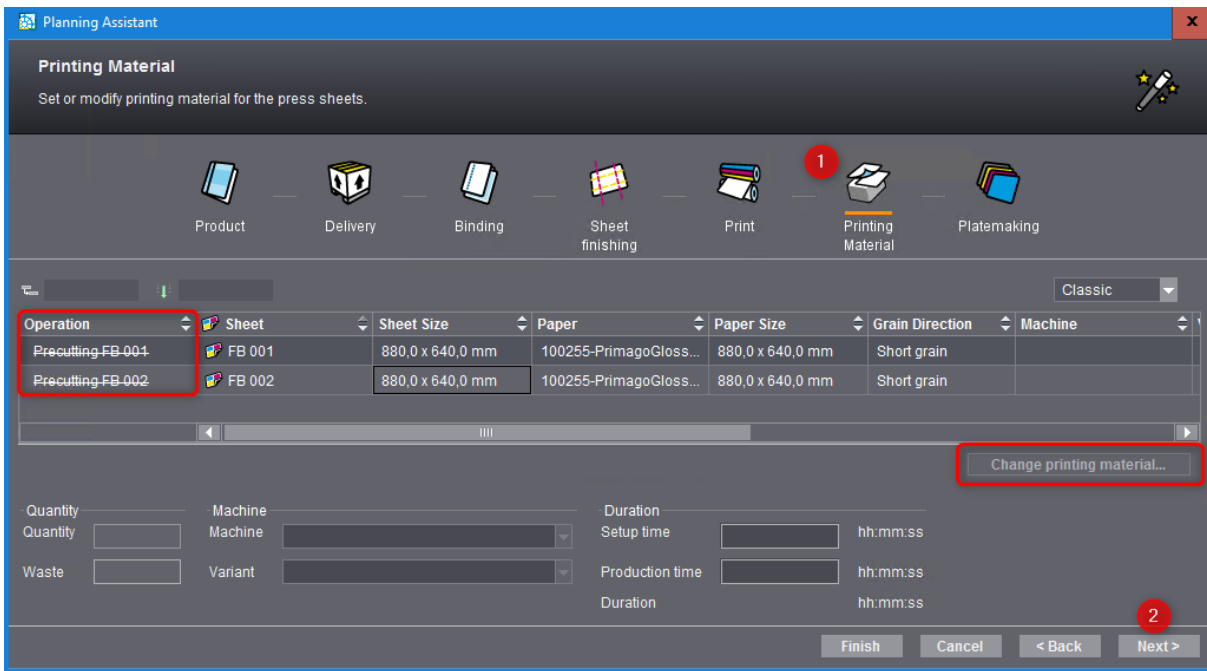


In the "Print" dialog we can select all presses with the same plate size.



3 Prinect Job

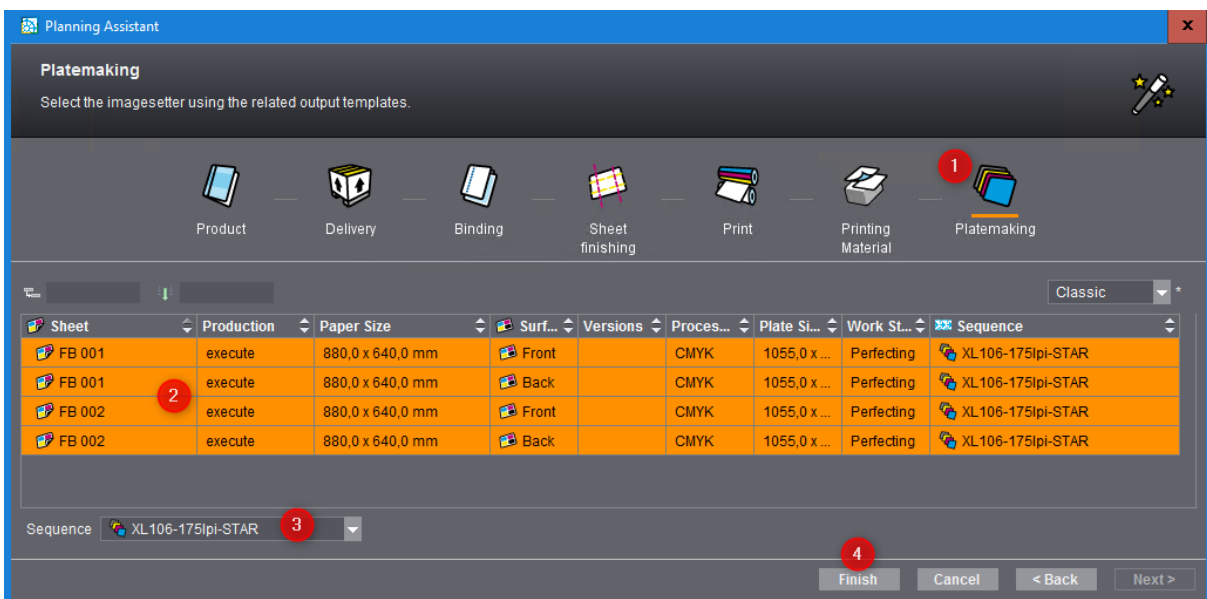
In the tab "Printing Material" we do not have to do "Precutting". This can be forced when we would now select a larger paper from MDS as defined in Signa Station.



For plate output we have to select a "Imposition Output" sequence with the correct

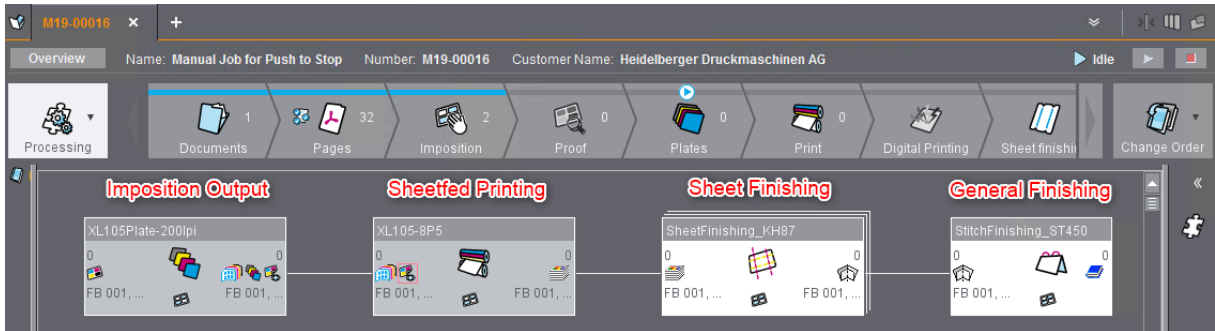
- screen
- process calibration
- ink series

These parameters are explained in chapter 2.1.1, 2.1.2, 2.1.3.

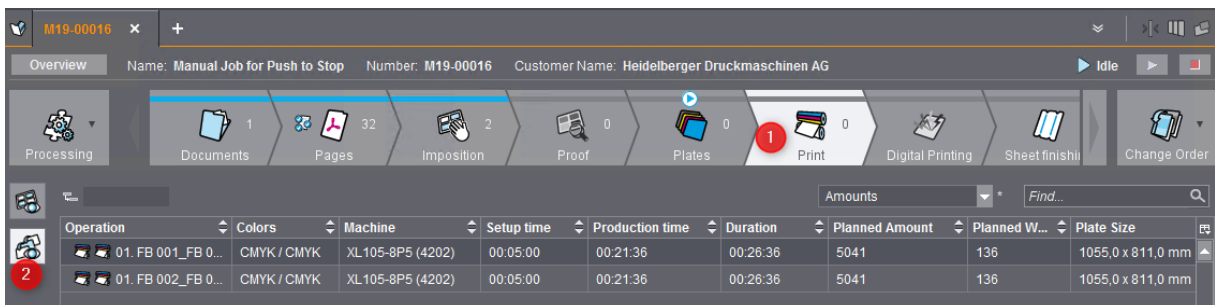


Result

The process net defines operations for press and postpress.



Operations, quantities and times are displayed in detail in the press and postpress tabs.

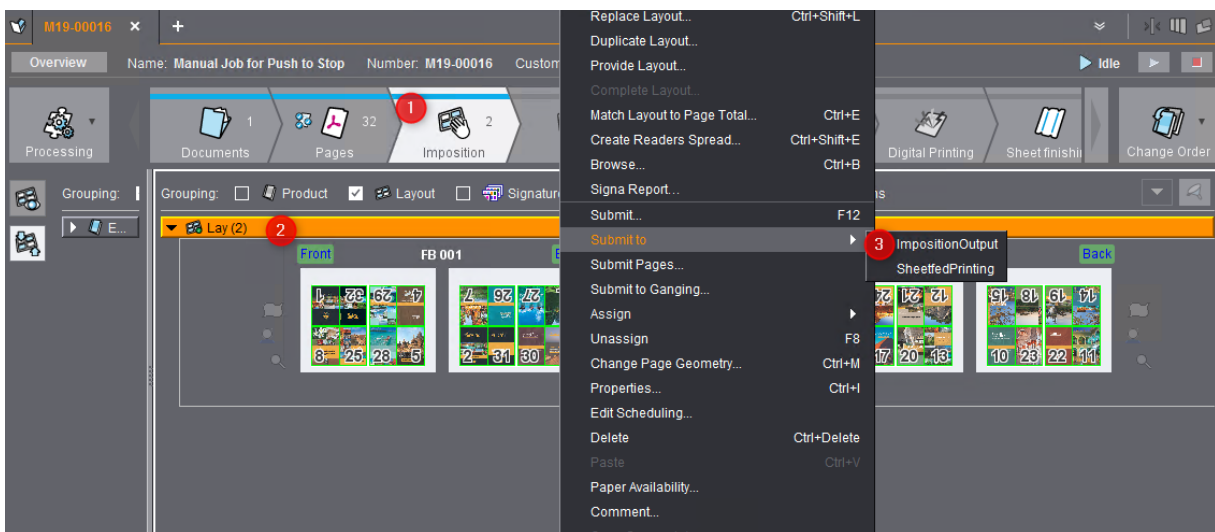


3.2.3.5 Submit sheets to plate making and sheetfed printing

We have to submit the sheets to "Imposition Output" and the "Sheetfed Printing" to generate

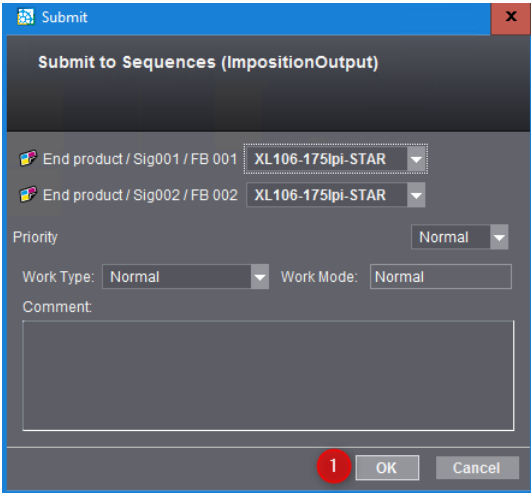
- plates
- Ink presets for the press

Now we submit all sheets to the right sequence which we have configured by Planning Assistant.

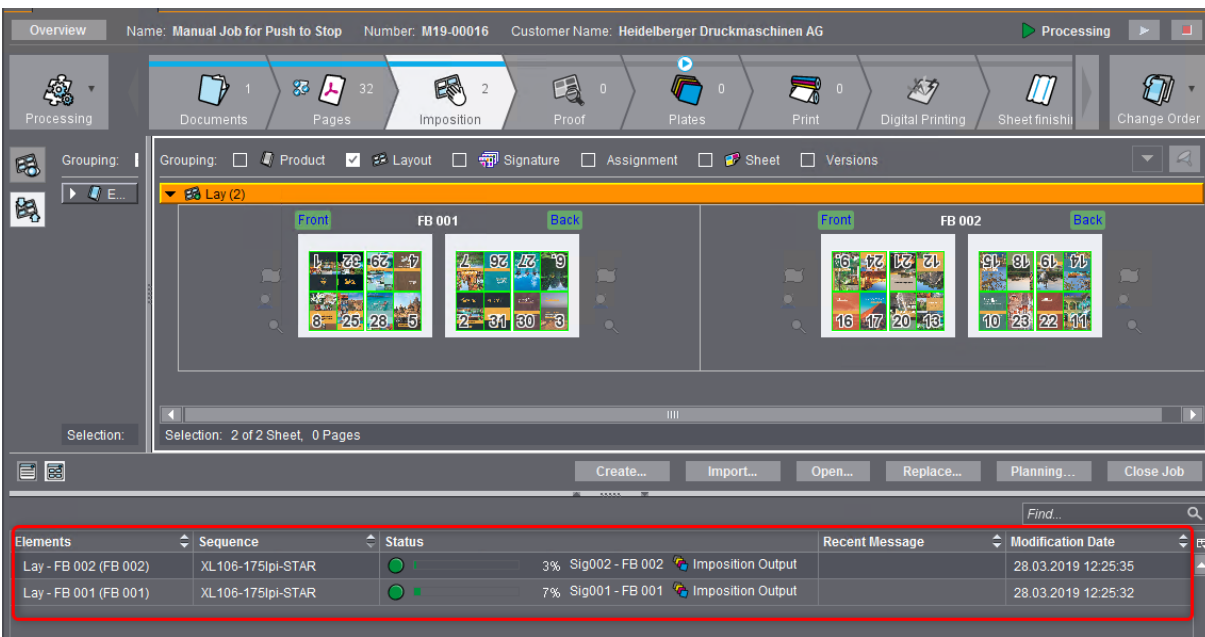


3 Prinect Job

At first we...

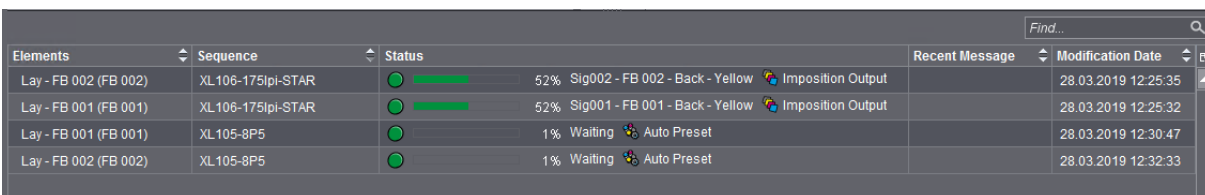


... generate plates, thumbnails and CIP 4 files. After this is done...



.... automatically we generate operations with ink presettings for the press.

In this condition the Tiff-B files for plates are waiting at the Shooter and the job is available...



... at the PressCenter.

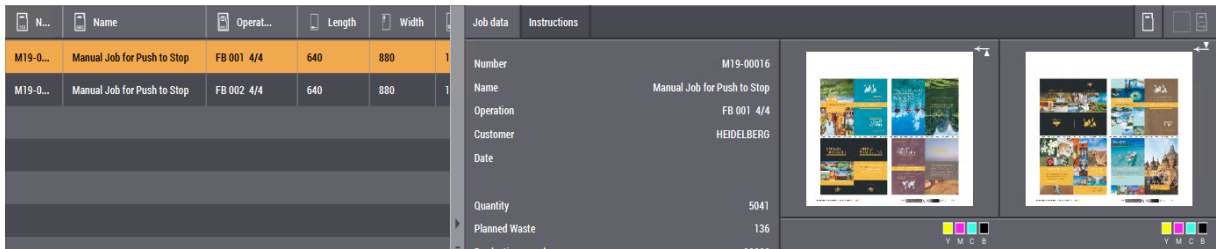
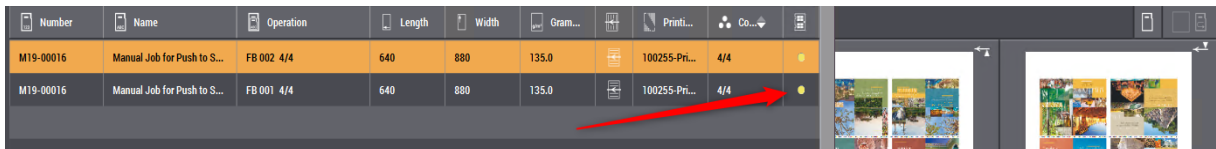
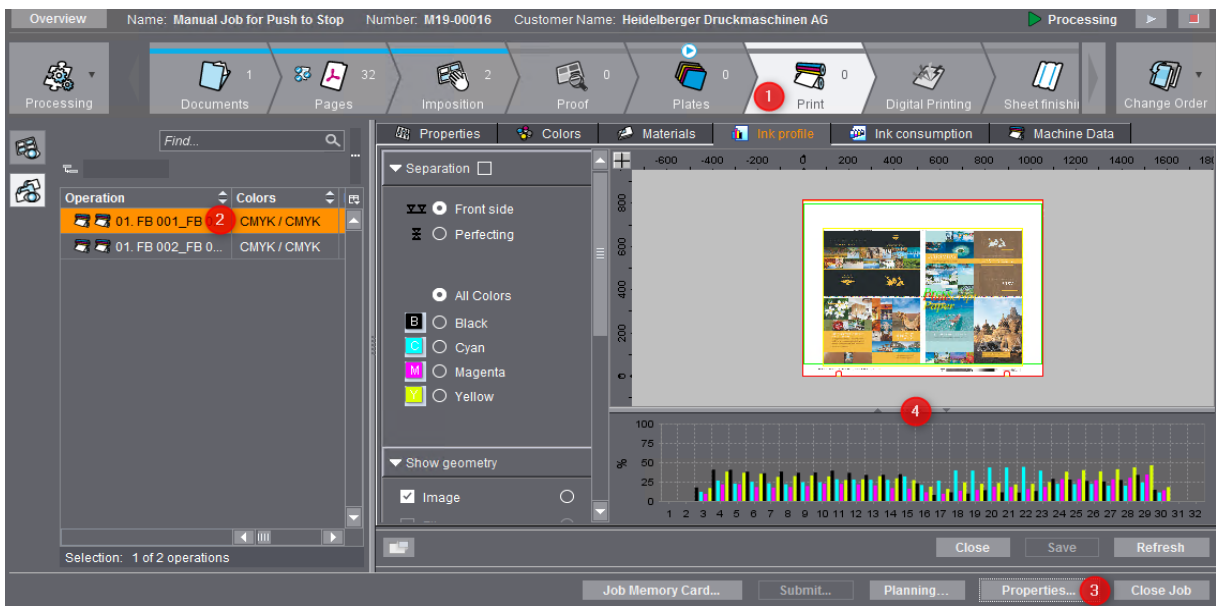


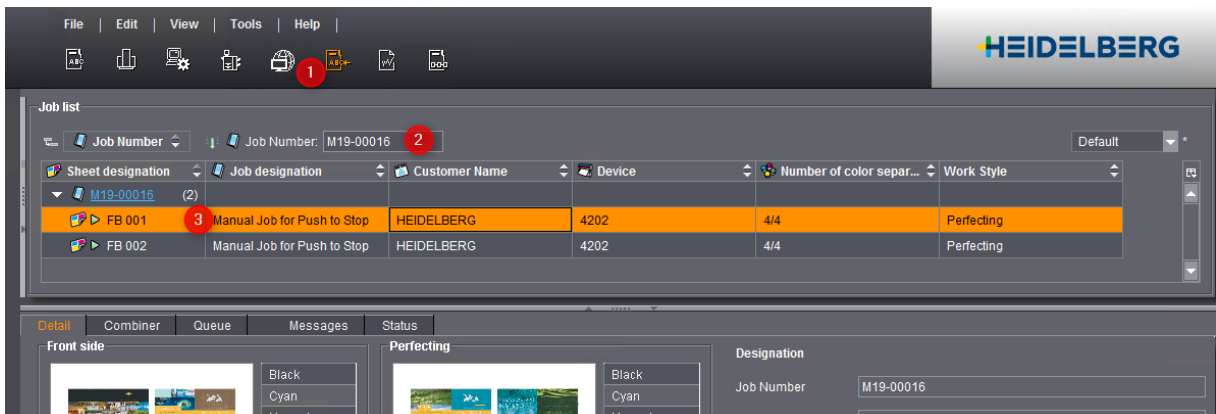
Plate available status in yellow displays that the plate is waiting at the Shooter (platesetter).



The coverage values are displayed in the Cockpit Job.



The jobs are visible in the Job Combiner too



3 Prinect Job

3.2.4 JDF - PPF Merge Workflow

Approximately 5% of our customers have such a workflow.

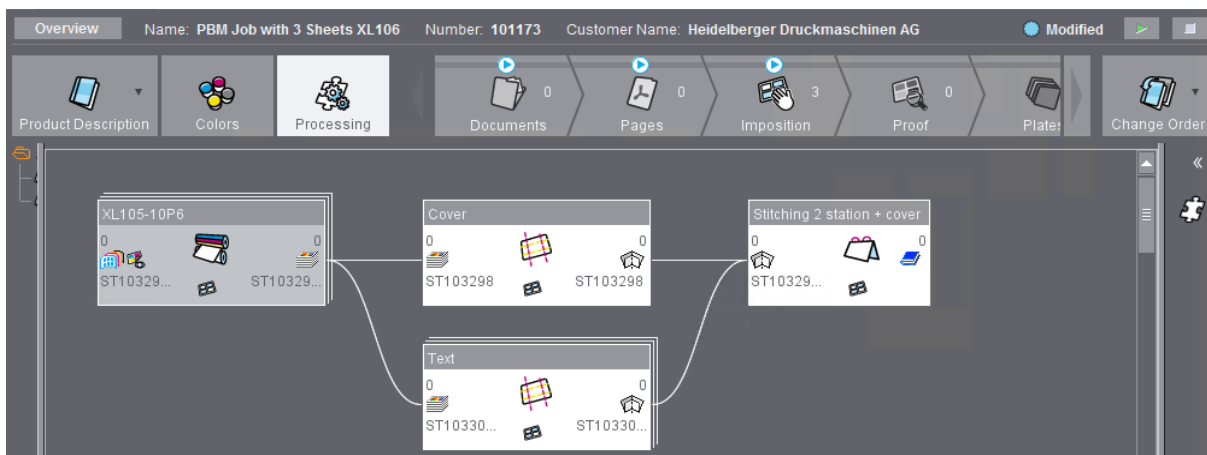
Customer Equipment

- 3rd Party MIS or Prinect Business Manager
- 3rd Party Prepress
- 3rd Party Platesetter
- Production Manager
- PressCenter / Data Terminal

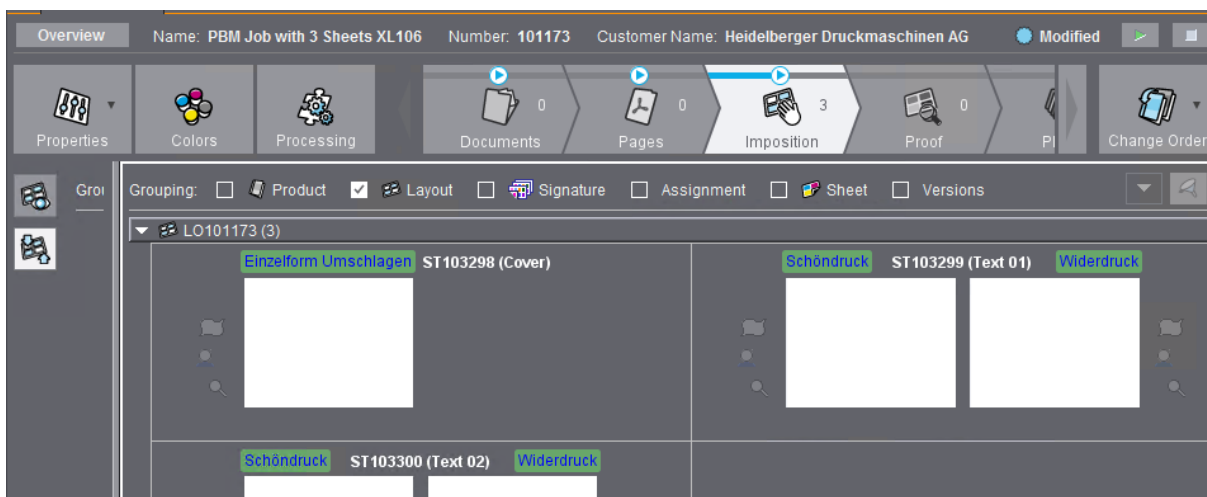
In this workflow we get a MIS-JDF and PPF from 3rd Party prepress

Example files are to find: [\\heiapp00322\PrinectTraining\Prinect2020\Push2Stop\JDF-PPF Merge](#)

1. A MIS-JDF creates a job in Cockpit
 - We will get a process network for press and postpress



- All sheets are defined by MIS, but there is no layout from Signa Station available



- Quantities and duration times are defined by MIS

Operation	Colors	Work Style	Machine	Setup time	Production time	Duration	Planned Amount	Planned Waste
01. Cover_ST...	CMYK / -	Work-and...	XL105-10P6 (4205)	00:15:00	00:18:00	00:33:00	1880	45
01. Text 01_S...	CMYK / CMYK	Perfecting	XL105-10P6 (4205)	00:11:00	00:35:00	00:46:00	7520	45
01. Text 02_S...	CMYK / CMYK	Perfecting	XL105-10P6 (4205)	00:08:00	00:35:00	00:43:00	7520	45

2. PPF files from 3rd Party prepress are written automatically in a hotfolder after plate output

- PPF will be merged to the MIS defined sheets
- Press operations are available at the PressCenter with presets, quantities and duration times

Elements	Sequence	Status	Recent Message	Modification Date
Text - LO10117...	XL105-10P6	1% Waiting	Printing	27.03.2019 09:15:01
Text - LO10117...	XL105-10P6	1% Waiting	Printing	27.03.2019 09:15:14
Cover - LO1011...	XL105-10P6	1% Waiting	Printing	27.03.2019 09:14:43



Note: This workflow is only working when JDF and PPF are matching and the right informations are in JDF and PPF. A change order is not possible after the PPF was sent.

The configuration is a Prinect Project which has to be configured by professional Prinect Engineers only.

3 Prinect Job

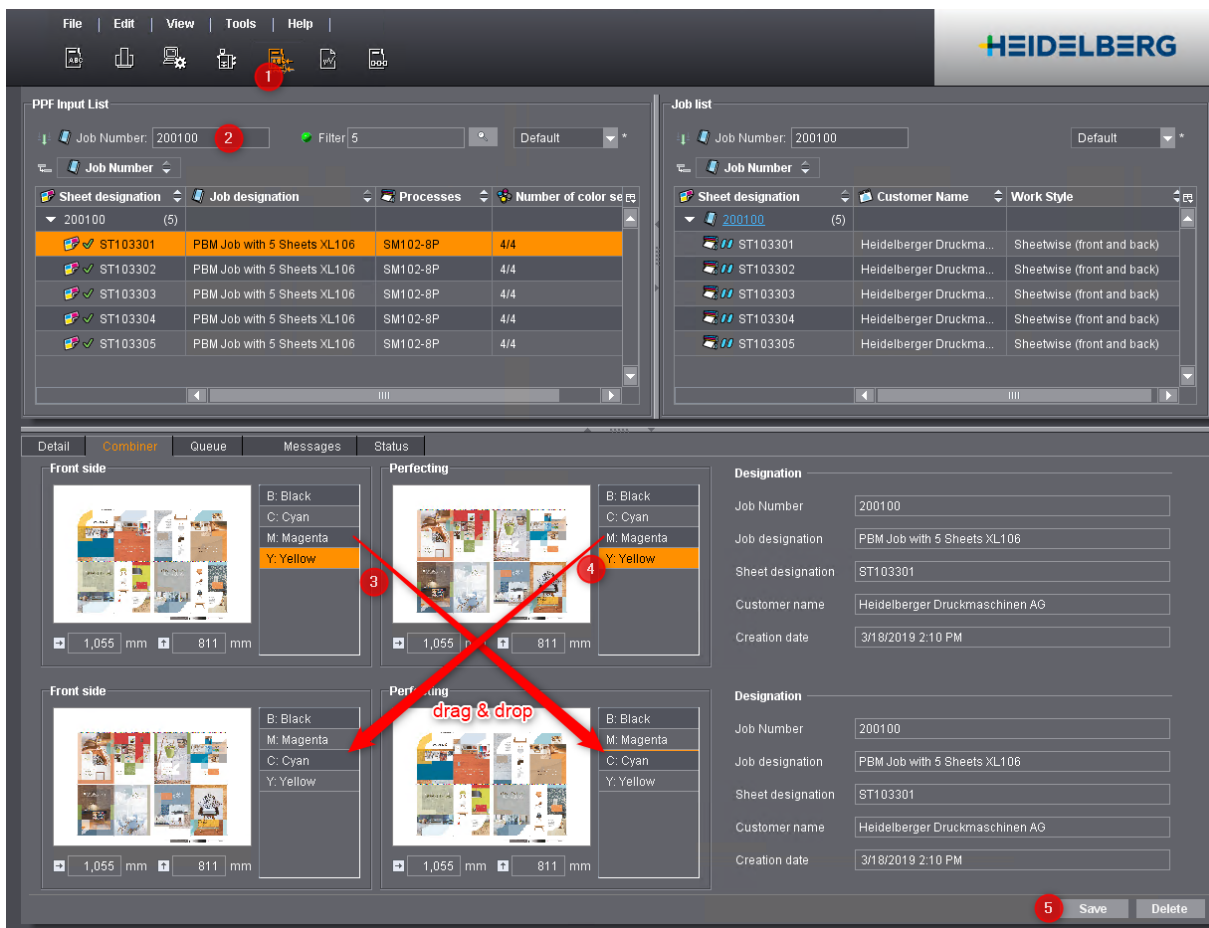
Job Combiner

In the Cockpit we can open the Job Combiner to merge JDF and PPF manually.

The Job Combiner displays PPF jobs like "Prepress Interface".

The job combiner allows to manipulate PressCenter jobs

- create new jobs
- delete jobs
- change ink order
- combine separate jobs to one Perfector job
- change Perfector job to two separate jobs
- change front & back



3.2.5 Fully Integrated Prinect Workflow

Approximately 15% of our customers have such a workflow.

Customer Equipment

- Prinect Business Manager
- Production Manager
- PressCenter / Data Terminal

In this workflow we get a MIS-JDF and PDF pages

1. The job will be calculated in the Prinect Business Manager or in a 3rd Party MIS and sent to the Production Manager via JDF.
2. The job is automatically created by the ICS Portal and visible in the Cockpit
3. A process net with quantities and times is automatically available, defined by MIS
4. The Sign Server has automatically generated a Layout - it is to edit in Signa Station when necessary.
5. Pages have to be assigned to the layout after "Qualify" and "Prepare".
6. The sheets have to be submitted to Imposition output > Sheetfed Printing...



Note: Step 3 -6 are explained in chapter 3.2.2.

3 Prinect Job

4 PressCenter Job

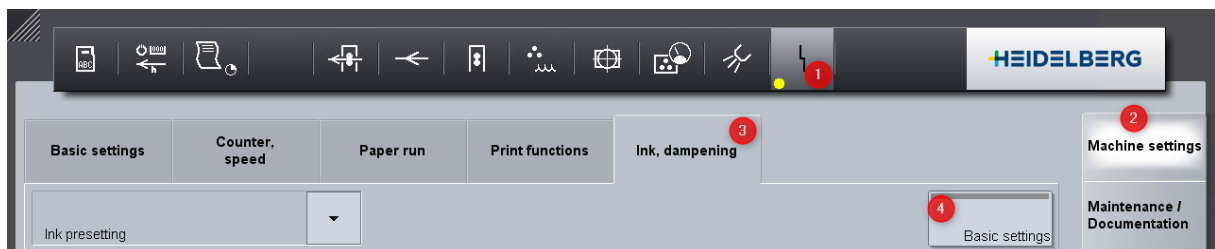
Motivation

In this chapter we want to explain PressCenter affects for job loading and how to "Release jobs" in the job queue for Push2Stop printing.

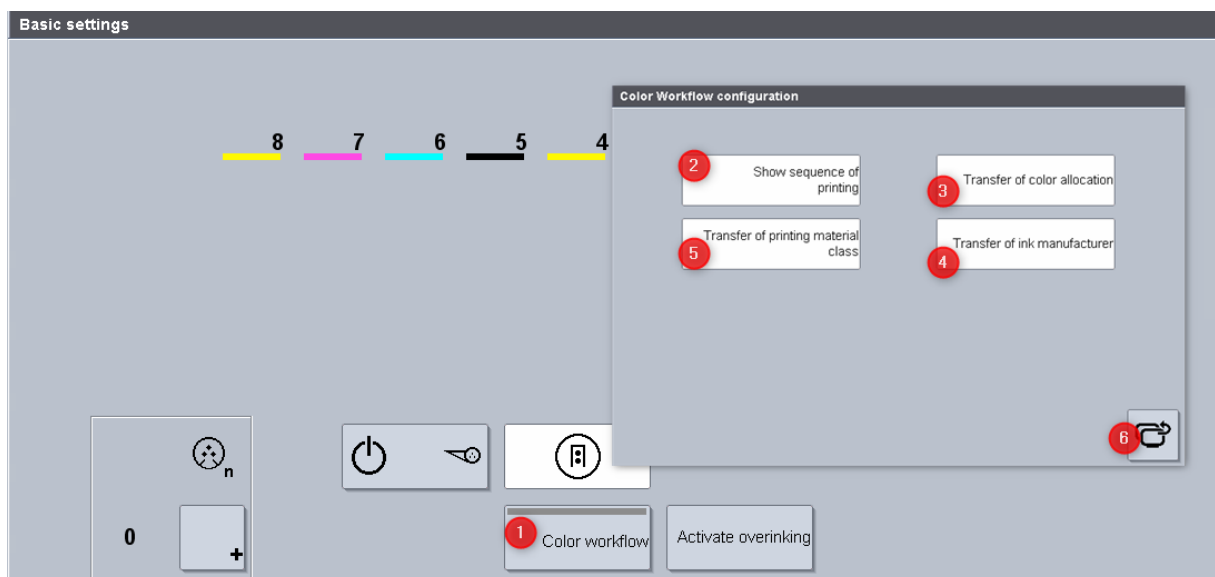
4.1 PressCenter Setup

4.1.1 Basic Color Workflow Configuration

With the "Basic settings" we can define which data are taken from the "Prinect Storage". When the presetting from the jobs are missing always a lot of information we can define to ignore these data.



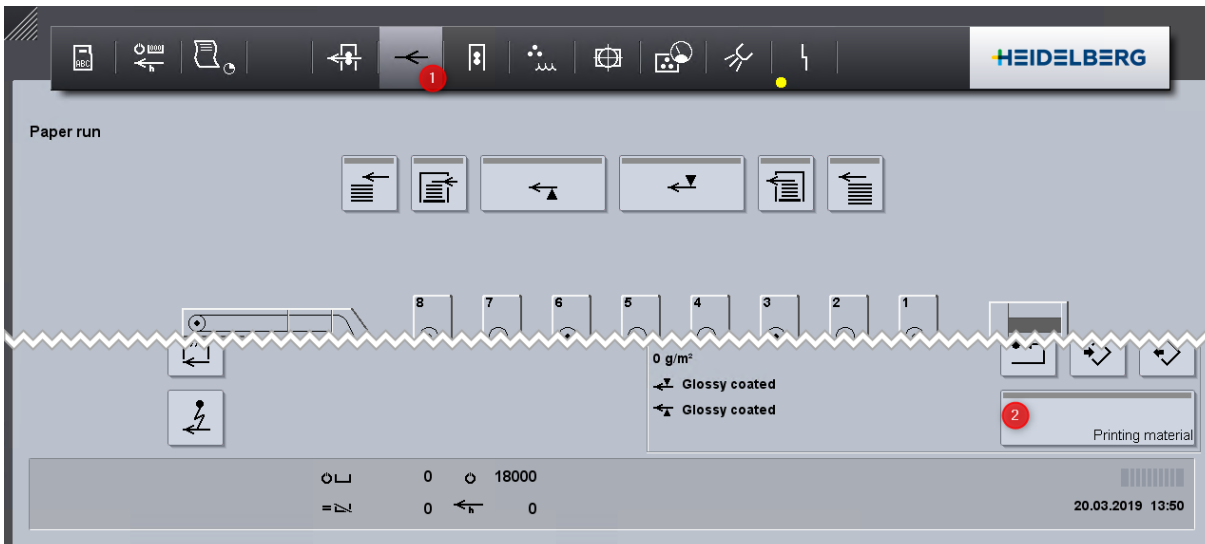
- 2. Show sequence of printing - the Cockpit job ink order will be respected by PressCenter
- 3. Transfer of color allocation - the inks will be assigned to the ink units at the PressCenter (at the moment not supported by Prinect)
- 4. Transfer of ink manufacturer - Ink serial will be transferred by calibration
- 5. Transfer of printing material class - the defined paper class will be transferred (glossy, matt,...)



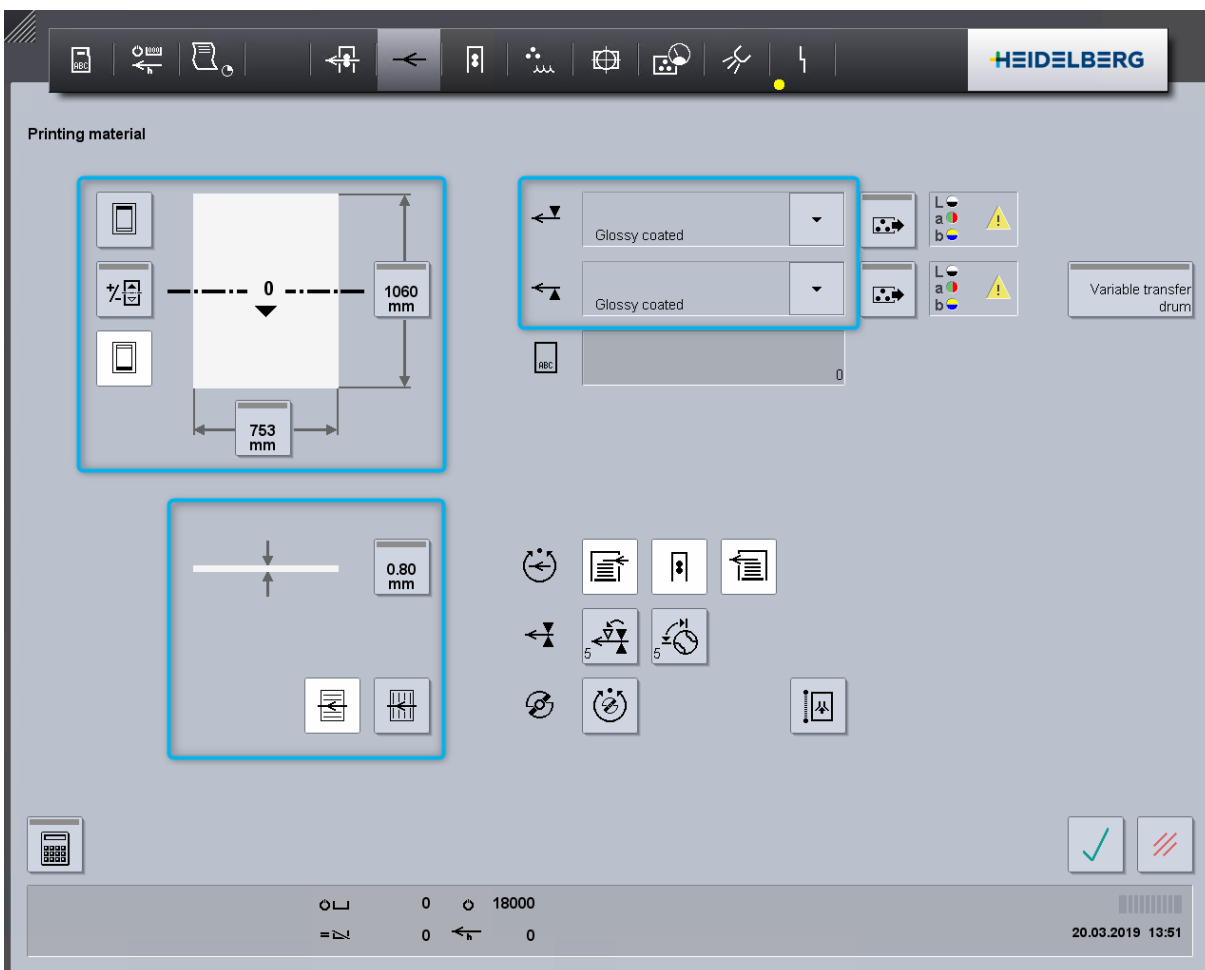
4 PressCenter Job

4.1.2 Take missing Paper Data from actual Machine Settings

Some actual machine settings are taken when no job data are available. These settings are defined...

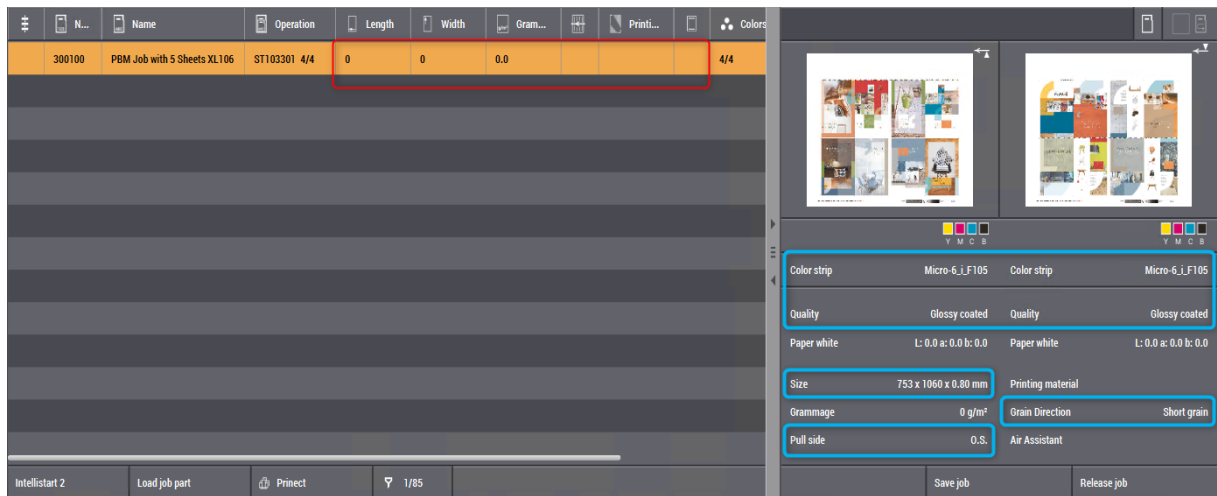


... in "Printing material": Actual machine settings.



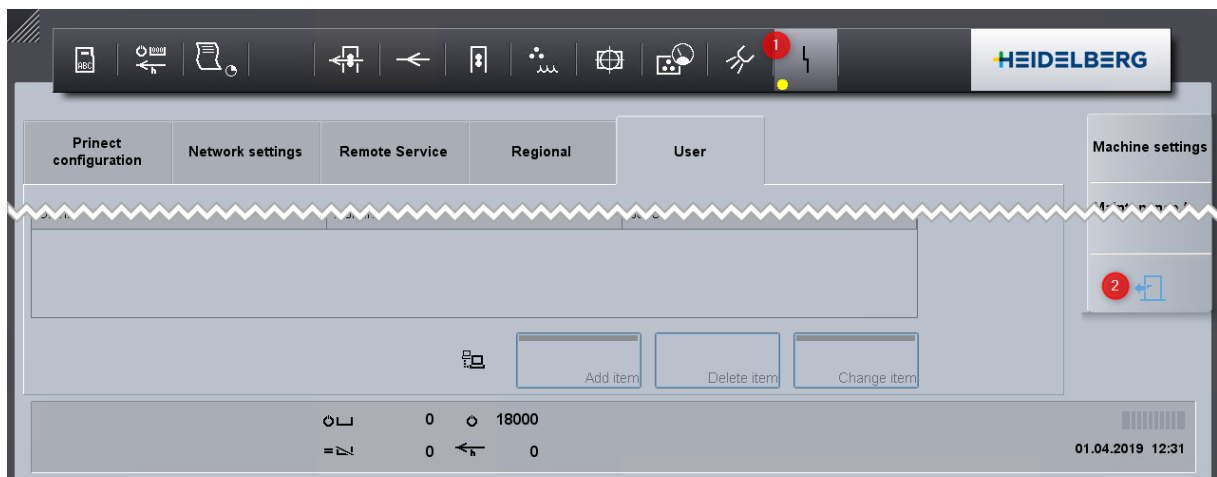
Operation settings from Prinect Storage

Actual machine settings

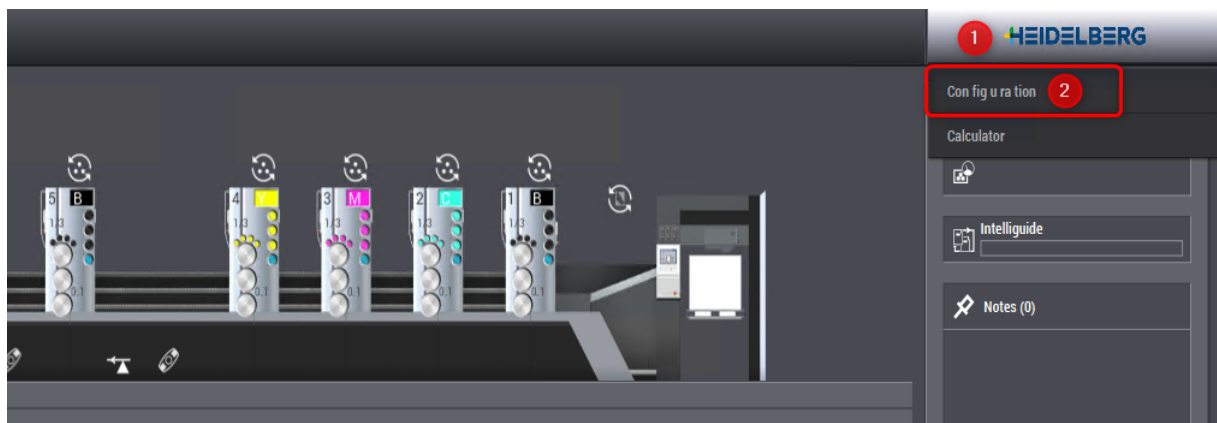


4.1.3 Wallscreen Preferences

After we are logged in as "Service" or as "Print shop administration"...



... we can change the advanced Wallscreen "Configuration".



4 PressCenter Job

1. Save job settings into the "Local Database" or "MS SQL Data Base" of the "Pressroom Manager"
2. "Preserve machine settings" activated => Preserve machine settings is active for the next job too
3. Show Instructions - chapter 5.4
4. The Log In User is visible in the right upper corner in the Wallscreen - chapter 4.2
5. Automatic processing of "Job Queue" interrupted" - next page
6. User specific settings to jump automatically into different views or to stay in the current view

Intellistart | Screen splitting, sum | Remote Desktop | Quality Assist configuration | General settings

Configurations for Intellistart

Configuration for units not used

- Suggest removing printing plate in units not used.
- Suggest washing inking unit in units not used.
- Suggest retaining ink in ink fountain in units not used.
- Apply roller protection paste in units not used.
- Suggest "Dust removal / sheet control" in unused units.

Configuration for automatic job saving function before job change

- 1 Prinect Pressroom Manager
- Database, machine

Preserve configuration for machine settings

- 2 When you select a job from the list box, the default setting "Preserve machine settings" is reset.

Configuration for the instructions display

- 3 Show instructions

Configuration for display of logged-in print job managers in the favorites bar

- 4 Show print job manager widget (default)
- Hide print job manager widget

Configuration for Job Queue display

- 5 Automatic processing of Job Queue interrupted.

User-specific configuration

Configuration for automatic window change during "Release job"

- Automatically change to "Intellistart 2 - Job Queue"
- Stay in window with "Job memory"

6 Configuration for automatic change of window after Intellistart 2 job change

- Stay in Job window
- Automatically switch to Production window

Configuration for automatic switching of windows after the number of impressions of the previous job has been reached.

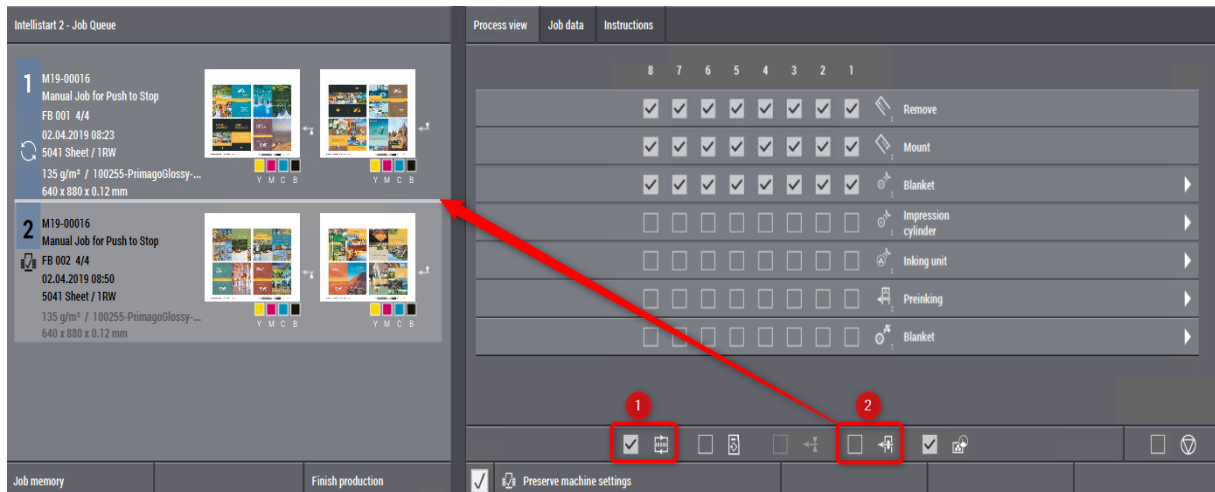
- Stay in Production window
- Automatically change to "Intellistart 2 - Job Queue"

5. Automatic processing of "Job Queue" interrupted.

Stop before the next job when one or both buttons are deactivated:

- 1. Automatic job change when the quantity of the previous job has been reached
- 2. Production will start in production speed

The "Stop" is displayed by a double line.



4 PressCenter Job

4.2 Cost Center & Employee Log In

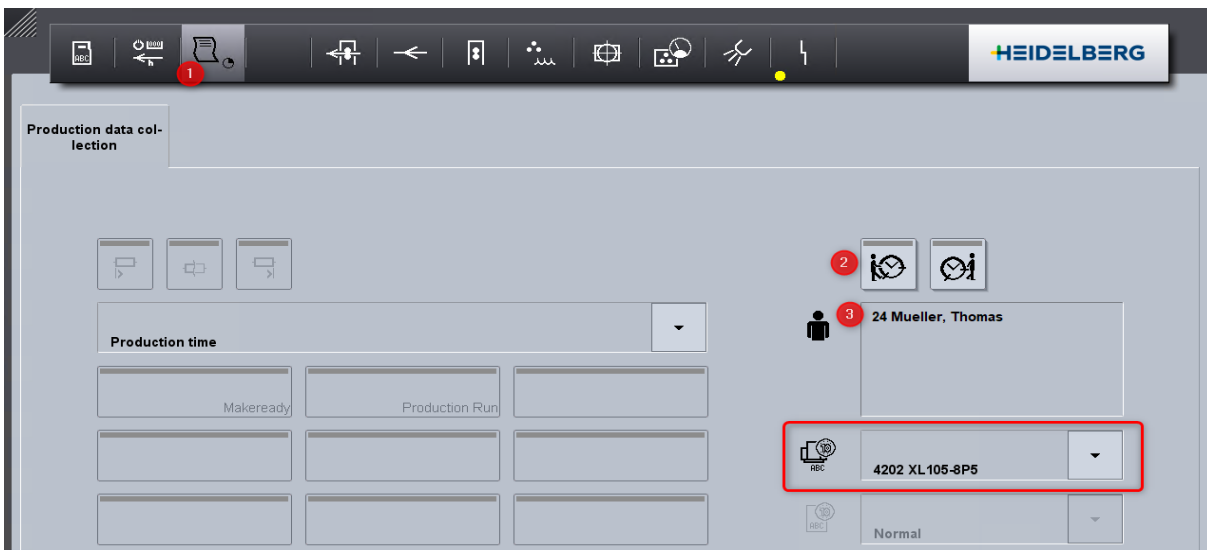
Motivation

Customers want to have a time sheet and statistics about employees.

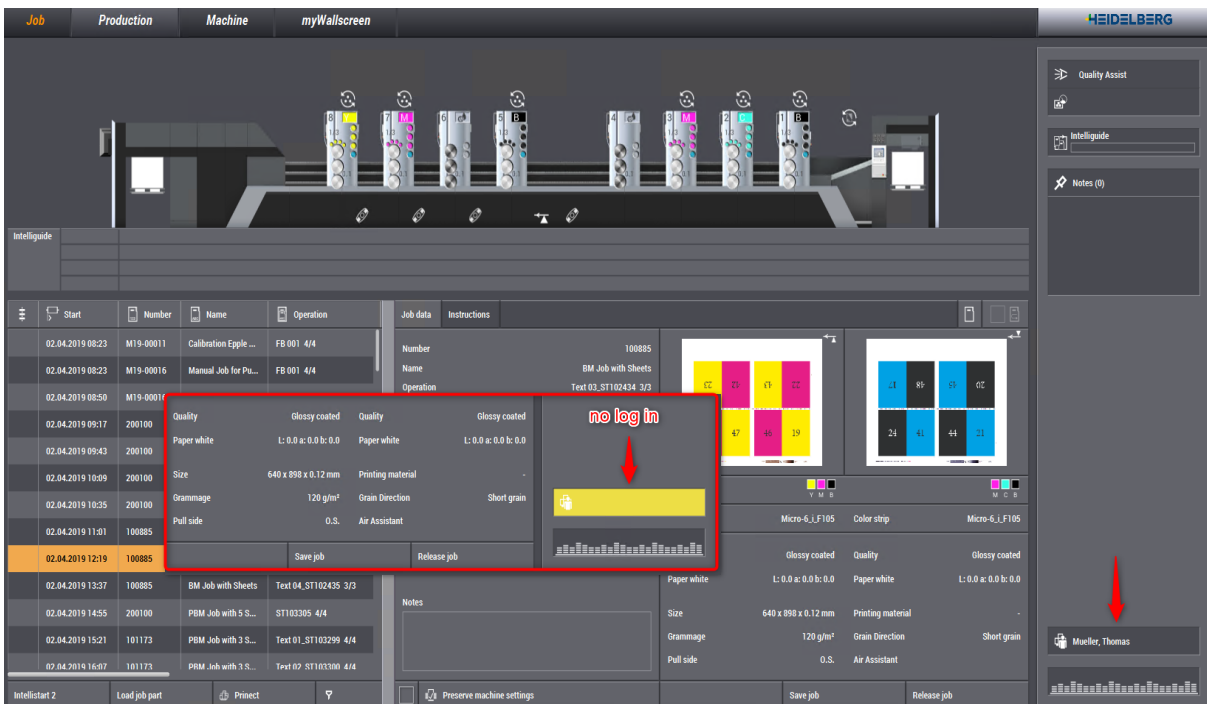
Description

After starting the machine the Cost Center is automatically selected.

For shift begin and shift end of the employees should login / logout to get "Time Sheets" and "Statistics" in Analyze Point and job costing in a connected MIS.



The log in user is visible in the Wallscreen when the option is enabled in "Configuration". When no operator is logged in, a yellow icon will warn us.





Note: When the PressCenter is connected to a Prinect Storage we will get automatically all assigned Operators / Assistants, which are defined in the Cockpit (chapter 1.1.4). It is not possible to create Employees in the PressCenter manually.

The screenshot shows the Heidelberg PressCenter interface. At the top, there is a navigation bar with various icons and the 'HEIDELBERG' logo. Below this, there are several tabs: 'Prinect configuration', 'Network settings', 'Remote Service', 'Regional', and 'User'. The 'User' tab is currently selected, displaying a table of employees. The table has three columns: 'Family Name', 'First name', and 'Employee ID'. The first row is highlighted in orange. Below the table, there are three buttons: 'Add item', 'Delete item', and 'Change item', which are enclosed in a red rectangular box. On the right side of the interface, there is a vertical menu with options like 'Machine settings', 'Maintenance / Documentation', 'Start-up / Press information', 'Integration / System', 'Remote Service', 'Optical measuring systems', 'Peripheral equipment', and 'Diagnosis'. At the bottom of the interface, there are some status indicators and a timestamp '02.04.2019 08:52'.

Family Name	First name	Employee ID
Paschirbe	Michael	2
CDOPERATOR	BM	8
Cerm employee		1000
Mueller	Thomas	24
Petersen	Michael	0009
Vieweg	Andreas	1
Engerer	Thomas	0011
XLOPERATOR	BM	3
Schoenbein	Peter	0014
Post	Andreas	0012
Stahl	Dominic	0013

4 PressCenter Job

4.3 Make Ready Assistant

Motivation

In this chapter we want to explain what's to respect before we can load a job (operation) into the queue.

Finally we want to queue the jobs so good as possible to use the Push to Stop mode.

The first Job of the shift

We have 2 sheets of one job with the same printing material and the same process colors.

1. After filtering a job (not necessary when we have "Planned Press Operations" (chapter 5)...
2. ...we can select a job (sheet operation).
3. For the first job of the shift we normally do not want to "Preserve machine settings"
4. We have to use the "Make Ready Assistant" before we can "Release the Job" into the queue.

The screenshot displays the PressCenter software interface. On the left, a table lists job details for M19-0016, including Name, Operation, and Length. A red circle '2' highlights the 'Manual Job for Push to Stop' operation. The main panel shows job data such as Quantity (5041), Planned Waste (136), and Production speed (18000). A red circle '4' is placed over the 'Production speed' field. Below the main panel, a 'Notes' field is visible with a red circle '3' next to it. At the bottom, a 'Release job' button is highlighted with a red box. The interface also shows a 'Preserve machine settings' checkbox and a 'Save job' button.

The "Make Ready Assistant".

The screenshot shows the 'Make Ready Assistant' interface. It features several input fields for job parameters: Number (M19-0016), Name (Manual Job for Push to Stop), Operation (FB 002_4/4), Customer (HEIDELBERG), and Article Numbers. On the right, there are counters for Quantity (5041), Job counter (0), Production speed (18000), Waste-sheet counter (0), and Planned Waste (136). A 'Production data collection' button is also present. Below these fields is a 'Notes' area. At the bottom, a process flow diagram shows the sequence: Job (highlighted in yellow), Printing material, Perfector, Color allocation, Measuring system, and Powder spray devices / Dryer. A '50' value is shown in a box on the right side of the flow.

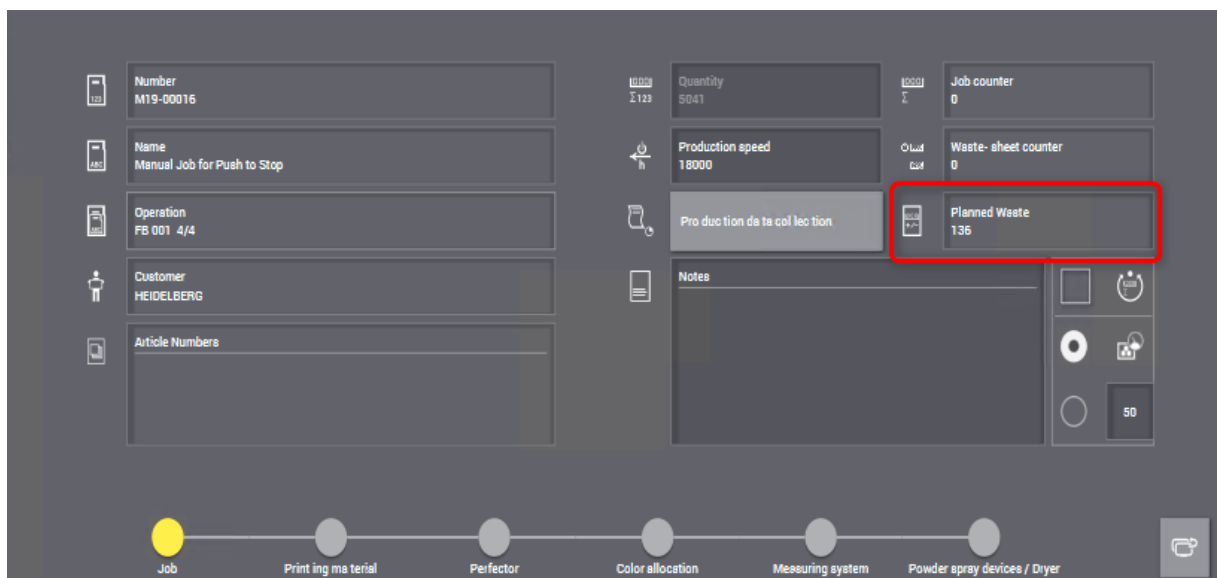
4.3.1 Job

In the first tab we can change the "Production speed" for this job - this is a default for following jobs. The paper weight and the quality of the paper has influence to the "Production speed" of the press.



The calculated waste of the job from MIS, W2P, CSV or Planning Assistant.

The operator has to press the "Good sheet counter" **manually** to change from "Waste" to "Good sheet production".

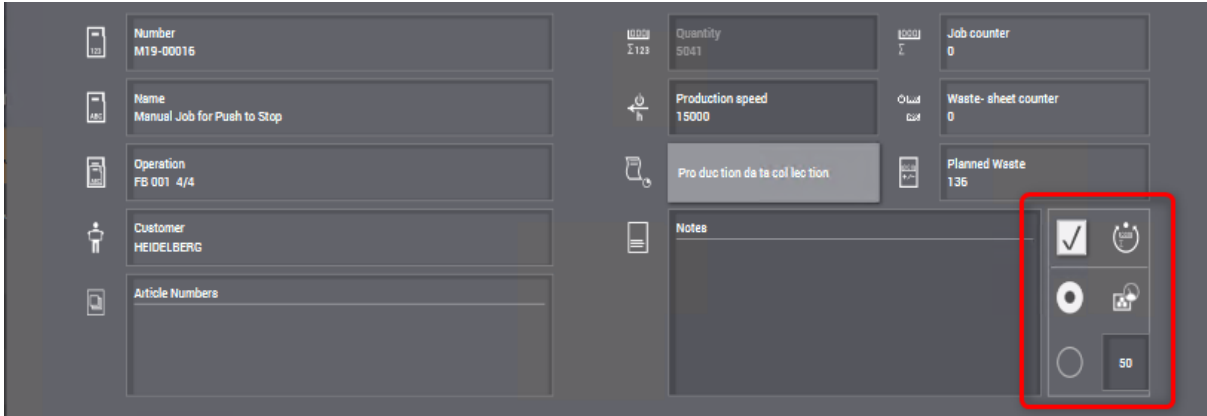


4 PressCenter Job

Recommendation for Push to Stop - Quality required

Automatic change from "Waste Production" to "Good Production" when print standard parameters from "Quality Assist" are reached.

We need approximately 70 sheets for the first color control.

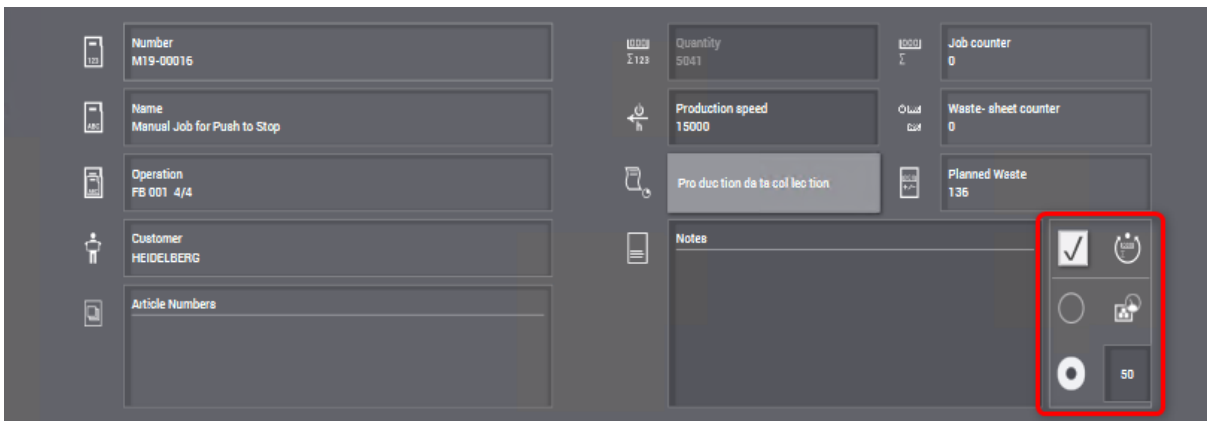


Recommendation for Push to Stop - minimized waste (for W2P shops)

Automatic change from "Waste Production" to "Good Production" after 50 (or a other fixed value) sheets are printed.



Note: In the training with a Simulation we should use this setting, because we do not get measurement files.



4.3.2 Printing Material



Note: All values are dimmed when "Preserve machine settings" is enabled.

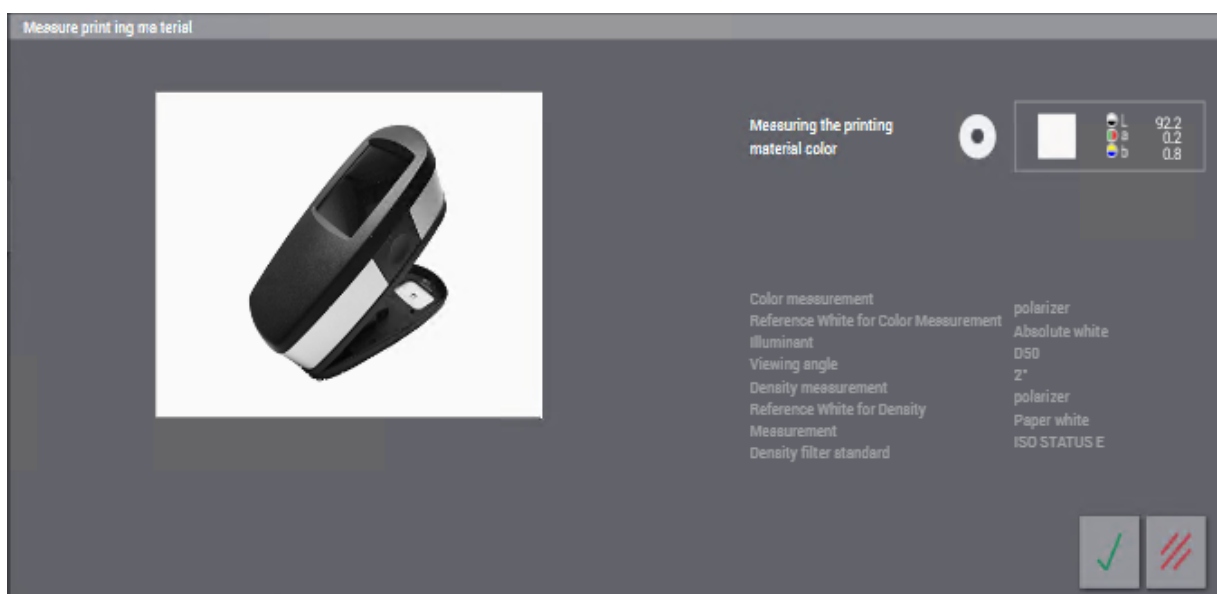
When all values are defined by Prinect the press operator has to doublecheck the accurate

- paper thickness - can be defined by Prinect Cockpit too
- Lab values for Front & Back - cannot be predefined by Prinect yet (Prinect 2020)

This is only necessary for the first sheet with this printing material!



Measurement dialog after pressing 2 and 3:



4 PressCenter Job



Note: In the PressCenter Simulation we can get fixed Lab values from CmsControl.

CmsControl (Builder: CMSBuilder, Version: tags/V19A.00.016_SFC, Date: 2019-01-29 15:35:46)

File View Extras Help

External equipment/Cpc20

Properties	Value
Printing material	glatt
Viewing angle	2A°
Illuminant	D50
Density filter sta...	STATUS E
Density filter	Auto-Filter
Polarization Lab	polarsiert
Polarization D	polarsiert
White reference	absoluter Weiss...
White reference D	relativer Weissb...
Calibration space	X-Rite Standard
Color difference	DEab

Status of the measuring device
Device ready
Hand-held measuring device in HDM
operating mode
Serial number: 4711/0815
Type: Simulated SpectroEye
Manufacturer: Heidelberger Druck
Settings:
Interface: void
Firmware version: without firmware

Quit HDM operating mode
Transport-sicherung setzen
Netprofiler testen
Stop Netprofiler Test

Please position the measuring device above the measurement field and start measuring.

Result

Paper white measurements Front & Back.

Matt coated

L 92.2
a 0.2
b 0.8

Grammage
135 g/m²

Printing material
100261-Matte Coated-880x630

Air Assistant
Impression pressure
Detailed values

880 mm
630 mm
0.12 mm

Job Printing material Perfector Color allocation Measuring system Powder spray devices / Dryer



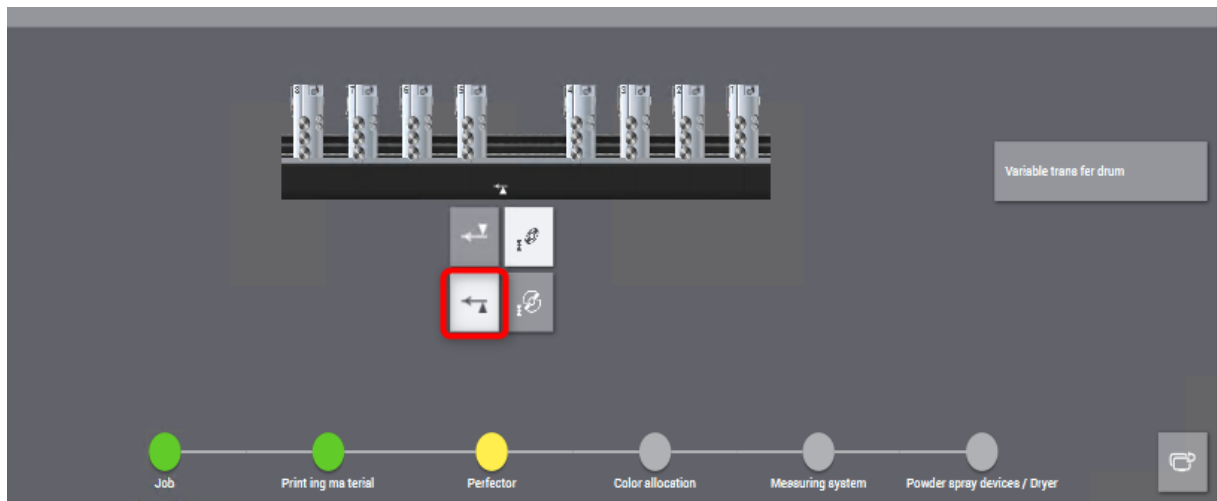
Note: The first measurement of paper white will be used for all following jobs!

4.3.3 Perfector

The "Workstyle" (Single sided, Perfector, Work&Turn, Work&Tumble) is defined by Prinect and normally we do not have to change settings.

Example

Perfector Job from Prinect.



4 PressCenter Job

4.3.4 Color Allocation

Motivation

Colors should be assigned to

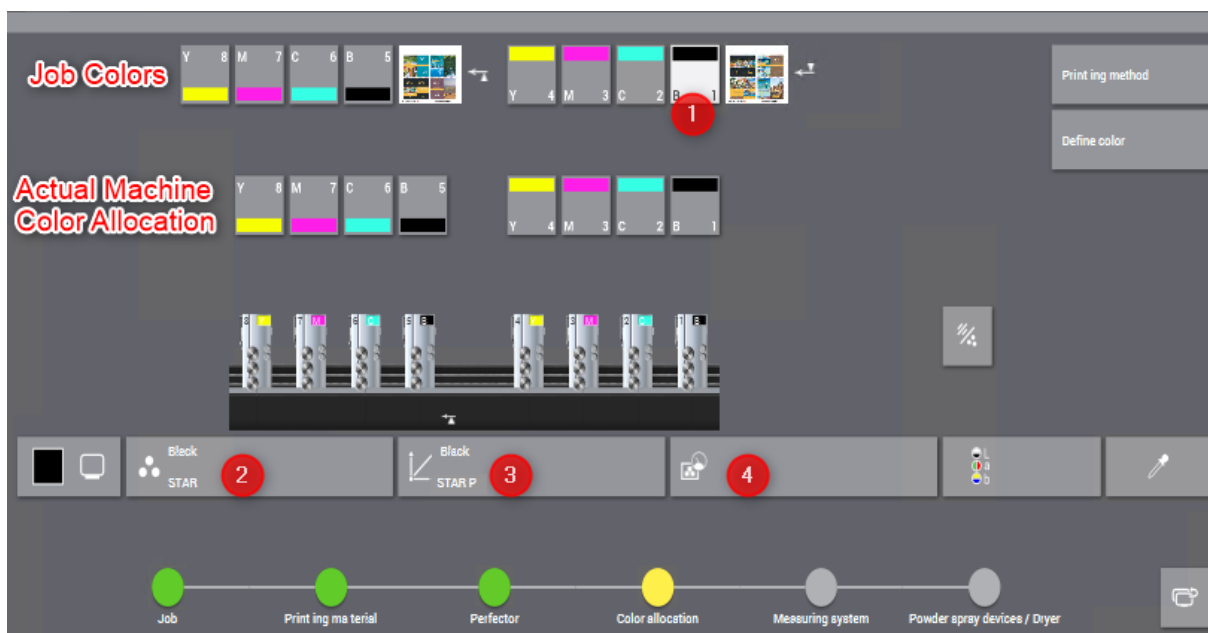
- ink series
- ink presetting curves
- color reference values for the measurement device

Description

1. Job Colors
2. Ink Series - predefined by calibration - chapter 2.1
3. Ink Presetting - predefined by calibration - chapter 2.1
4. Color Reference values for the measurement device

Example

In this example we have got the ink series and ink presetting curves from Prinect.

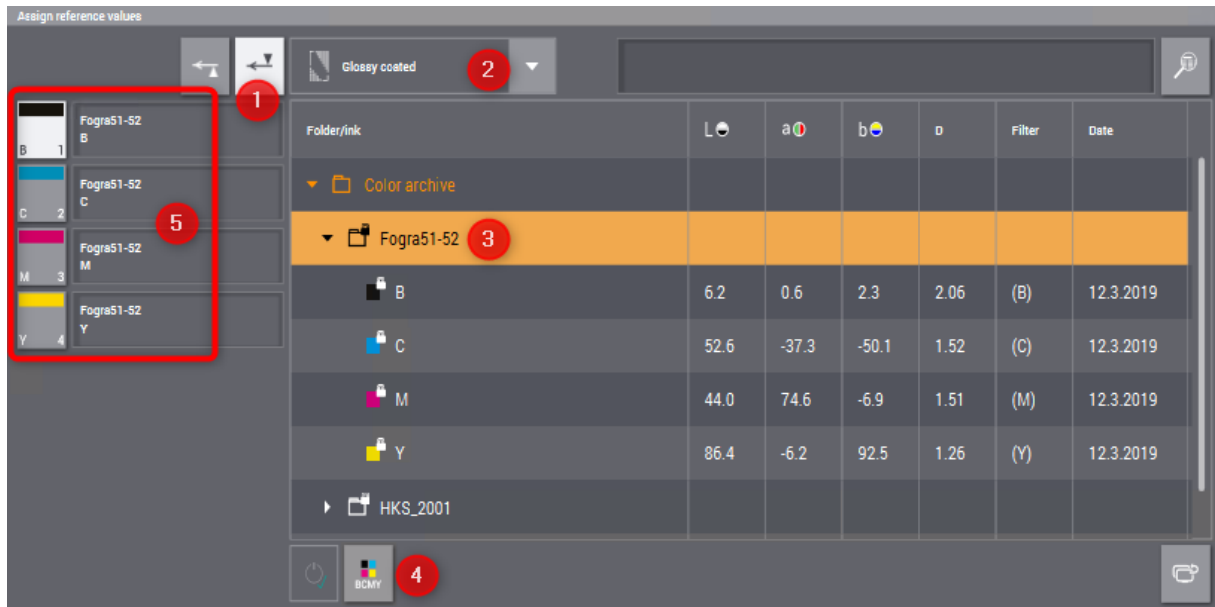


Note: Actual machine color allocation: Colors are not allocated for the first job.

In "Assign reference values" we are looking into the "Central Color Data Base".

In chapter 4.7.2 we explain how to create reference values for process and spot colors

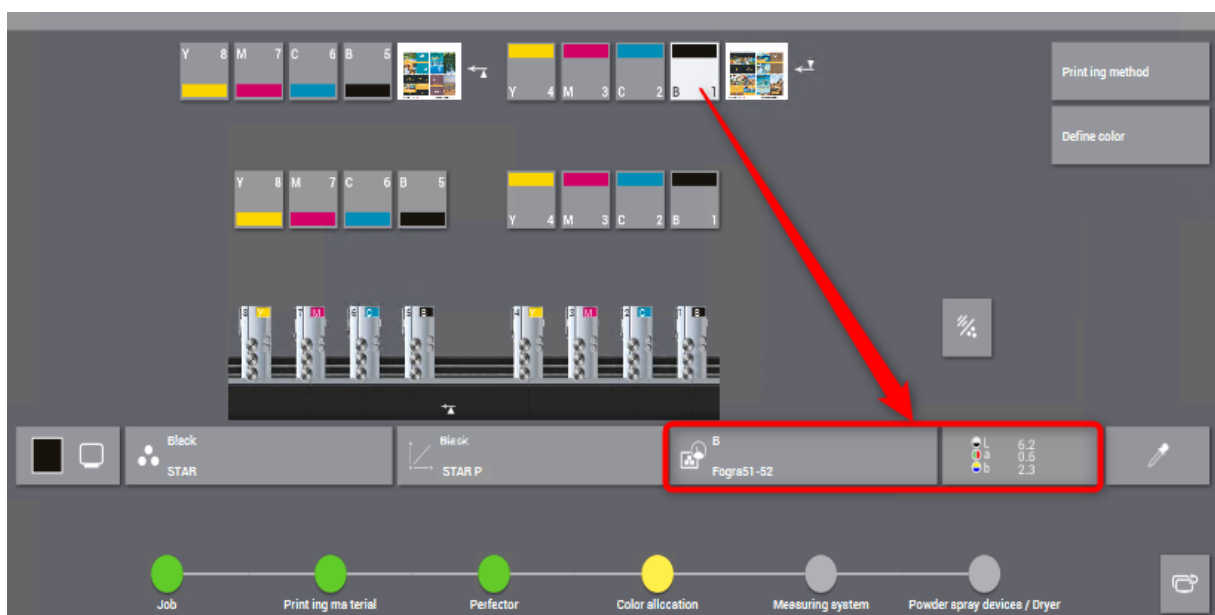
The assignment has to be done for Front & Back



Note: In a Simulation we have to leave the dialog after "Front" before we allocate "Back".

The Color References

- have to be assigned for all paper grades - glossy, matte, uncoated (after restart PressCenter too)
- the assignment will be used for all jobs with the same ink series
- without a color reference allocation the measurement system will not run



4 PressCenter Job

4.3.5 Measuring System

In this tab we can define values for the measuring system:

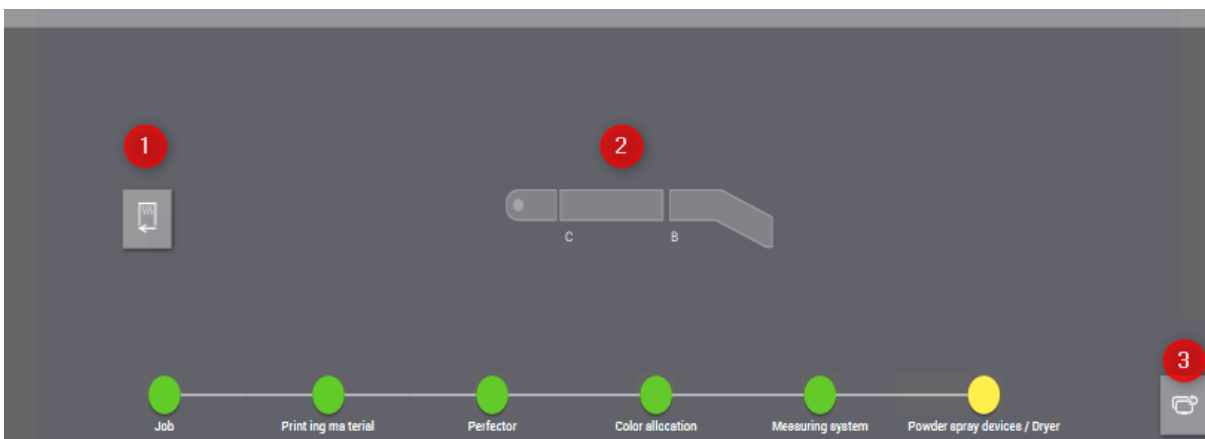
1. The setup is to enable for Front & Back separately
2. "Quality Assistant profiles" are required to select the preferred quality tolerances
3. The "Color bar" is predefined automatically when "Signa Station" has written the layout
4. It is possible to measure the "Printing Material" (paper white) like in the tab "Printing Material"
5. We automatically write Lab, density and dot gain back to the "Quality Report" in "Analyze Point"



4.3.6 Powder Spray Devices / Dryer

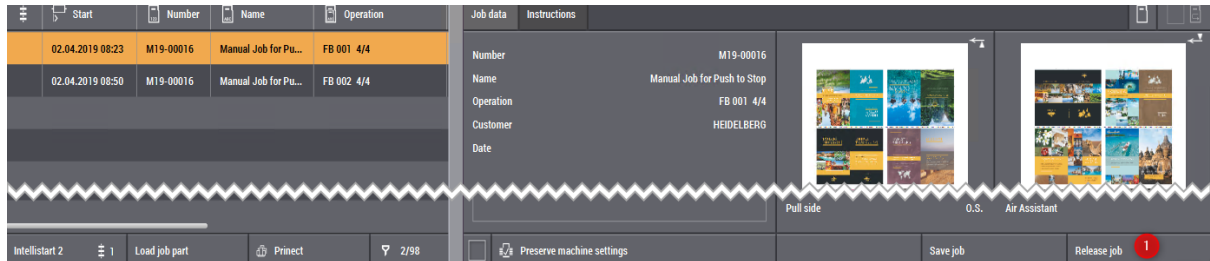
In this tab we can:

1. Enable a Dryer (when available)
2. Change powder spray settings
3. Finally we have to leave the "Make Ready Assistant".



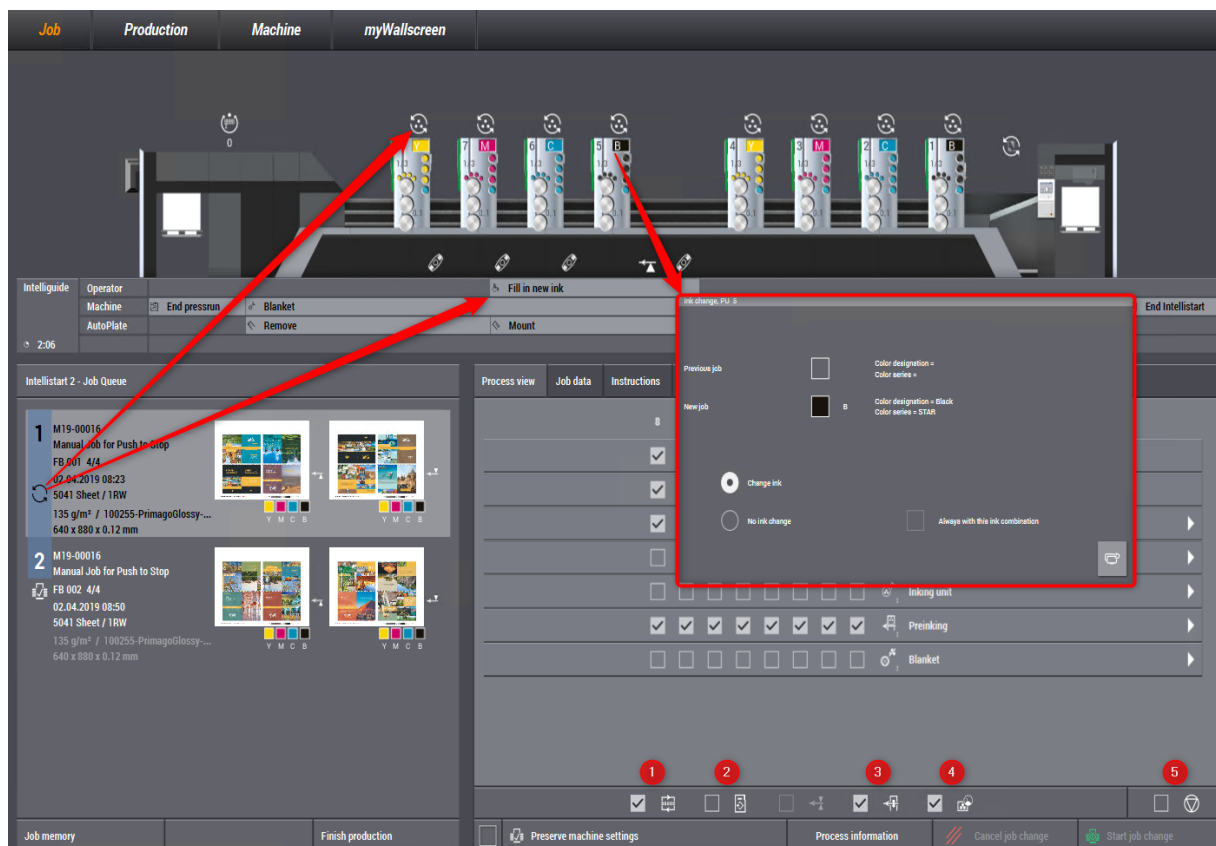
4.4 Release Job - Load Operation into Intellistart Queue

In this condition we can now release the job into the "Intellistart" queue.



For Push to Stop we have to enable some features

1. Automatic job change when the quantity of the previous job has been reached
2. Job will be saved automatically
3. Production will start in production speed
4. Enable / Disable Inpress Control - "Measurement" and "Follow up"
5. **Do not enable for Push to Stop:**
Manual stopping point after "AutoPlate" "Mount" and before "Preinking"

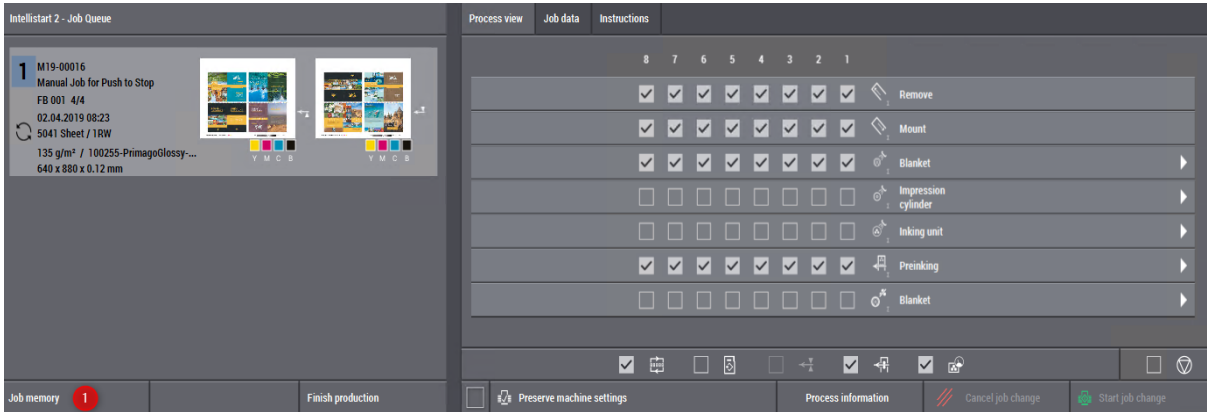


Icon: The operator has to do a manual action - "Fill in new ink" because this is the first job of the day.

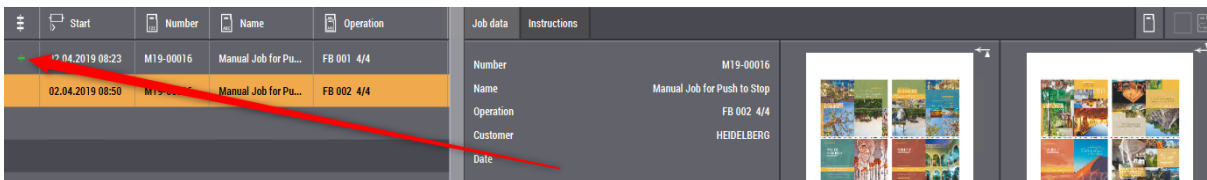
4 PressCenter Job

4.5 The Second Job with the same Printing Material

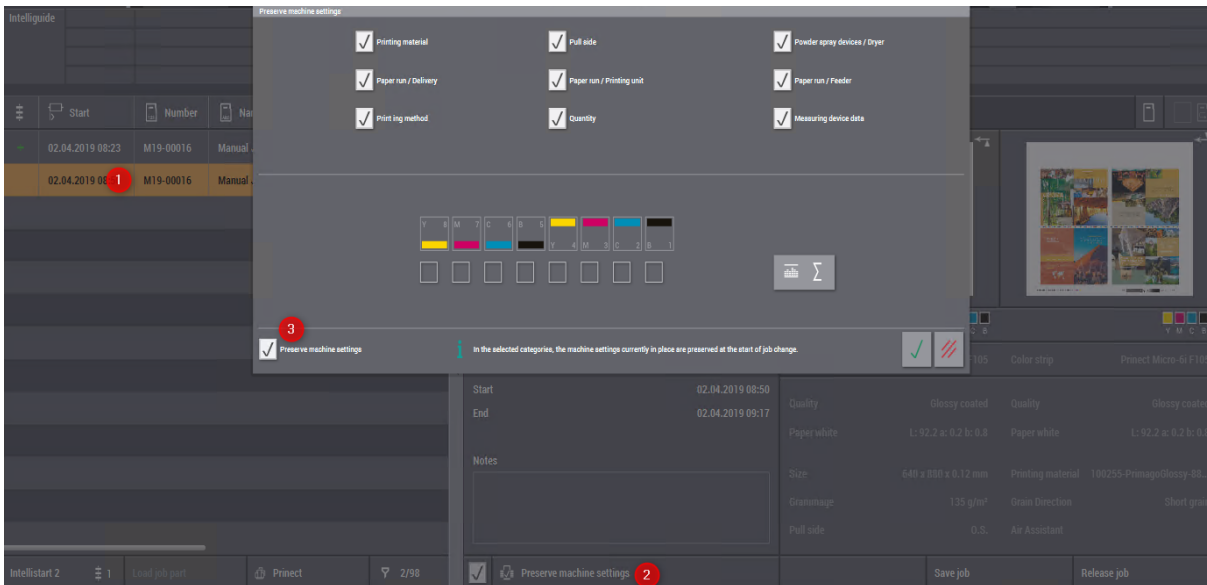
We have to change back into the "Job memory" view to load the second job (operation).



We can see at this button that the first job is queued in "Intellistart".



For the second job we want to "Preserve machine settings".



Preserve machine settings

We want "Preserve machine settings" because this job is using the same:

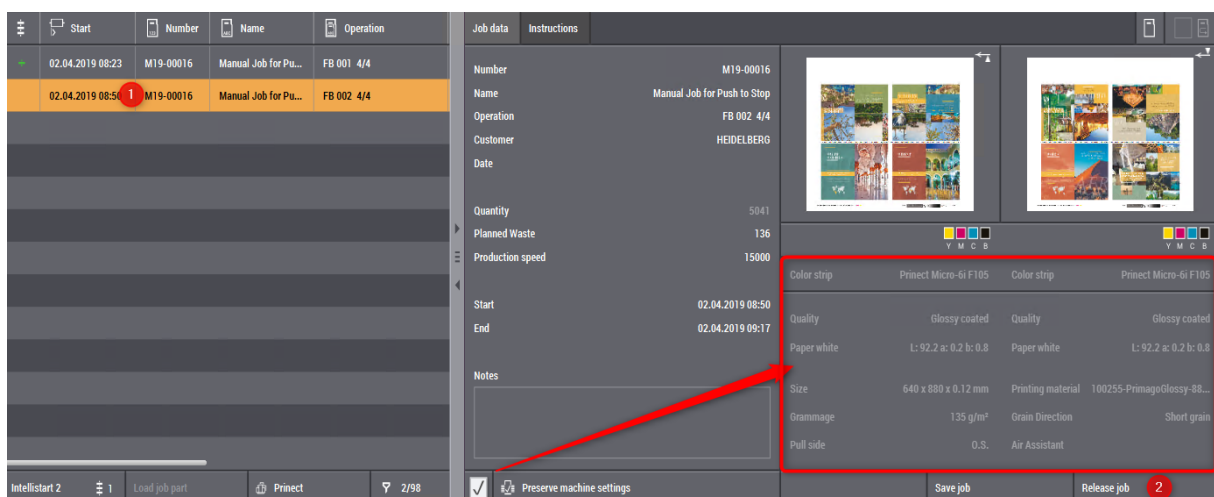
- Printing Material
- Inks
- Workstyle

We do not preserve the quantity when this is predefined by Prinect.



The values are gray marked when we are using "Preserver machine settings".

In this condition we can "Release job" to the "IntelliStart" job queue".



4 PressCenter Job

4.6 IntelliStart Job Queue & Job Change

Intellistart queue icons in PressCenter 2019



"Preserve machine setting" is enabled for this job - chapter 4.5



The operator has to do a manual action - description in chapter 4.4

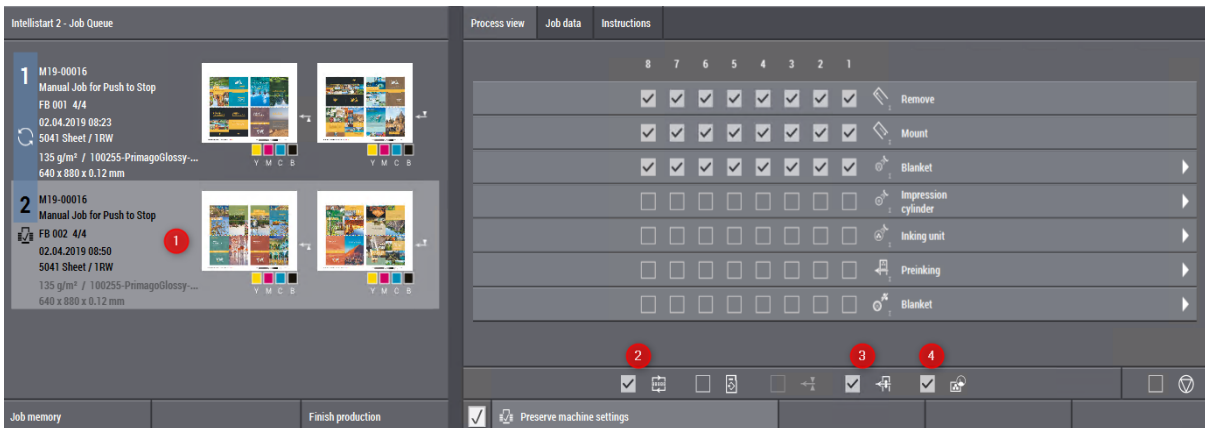


Insert Star - chapter 5.4



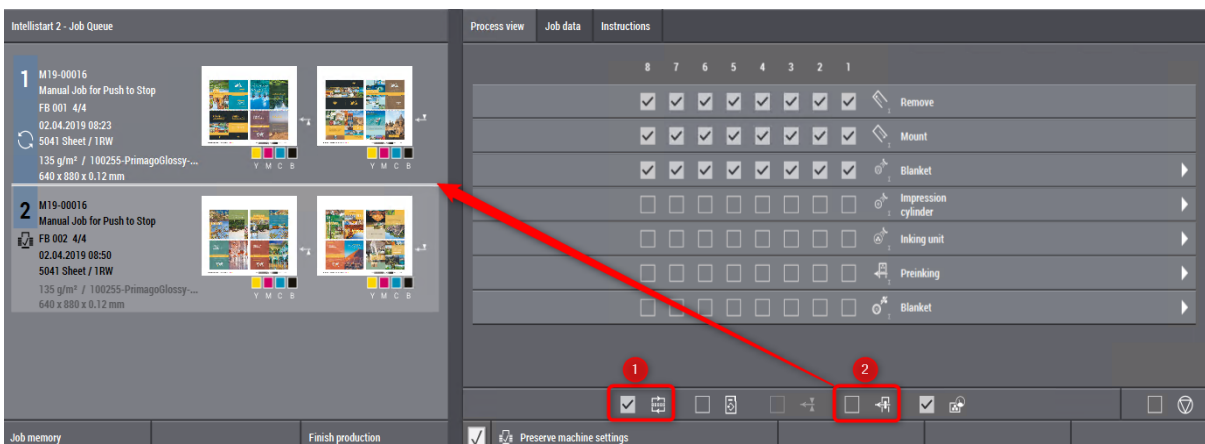
Instructions - chapter 5.4

In this condition job 1 and job 2 would run automatically one after another, when the plates are available in "AutoPlate".



When one of these functions is disabled, we would get a stop!

- Automatic job change when the quantity of the previous job has been reached
- Production will start in production speed



In the Intellistart context menu we can:

- Deactivate job - moves the job to the end of the queue
- Move job - moving of jobs in the queue
- Delete job - deletes the job out of the queue, but not from storage
- Delete all jobs - deletes all jobs out of the queue, but not from storage

Intellistart 2 - Job Queue

Process view | Job data | Instructions

8 7

1 M19-00016
Manual Job for Push to Stop
FB 001 4/4
02.04.2019 08:23
5041 Sheet / 1RW
135 g/m² / 100255-Prima
640 x 880 x 0.12 mm

2 M19-00016
Manual Job for Push to Stop
FB 002 4/4
02.04.2019 08:50
5041 Sheet / 1RW
135 g/m² / 100255-PrimagoGlossy-...
640 x 880 x 0.12 mm

JobQueue displays the jobs in the order in which they are to be prepared and printed. /n For the selected job further data of the job and on job change are displayed on the righthand side.

Auftrag deaktivieren
Move job
Delete job
Delete all jobs

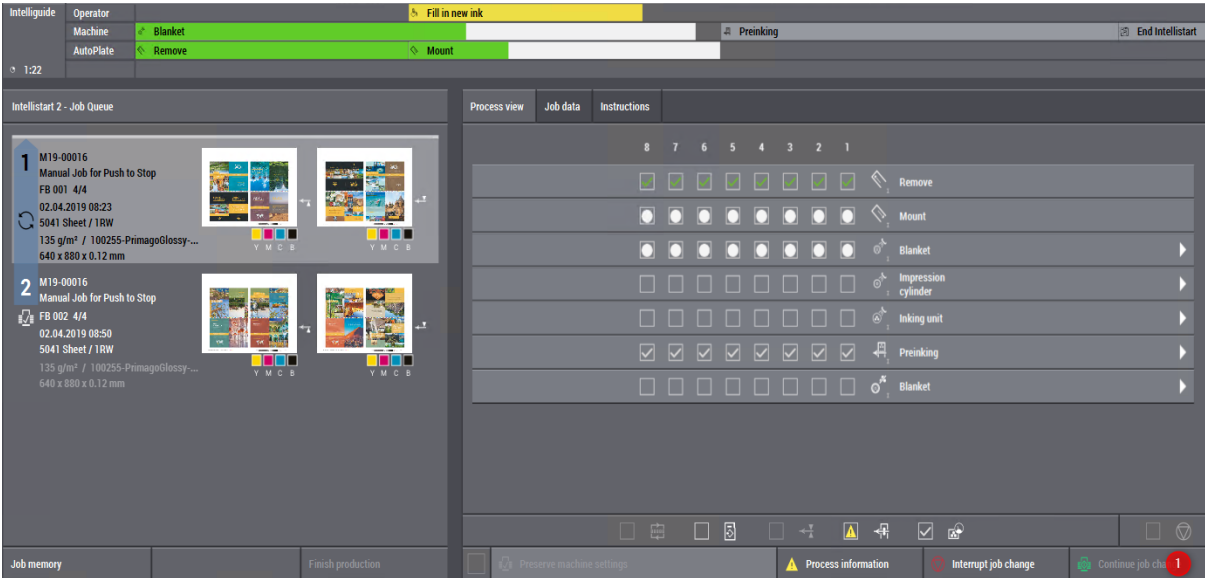
Process view	Job data	Instructions
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

4 PressCenter Job

Start Job Change

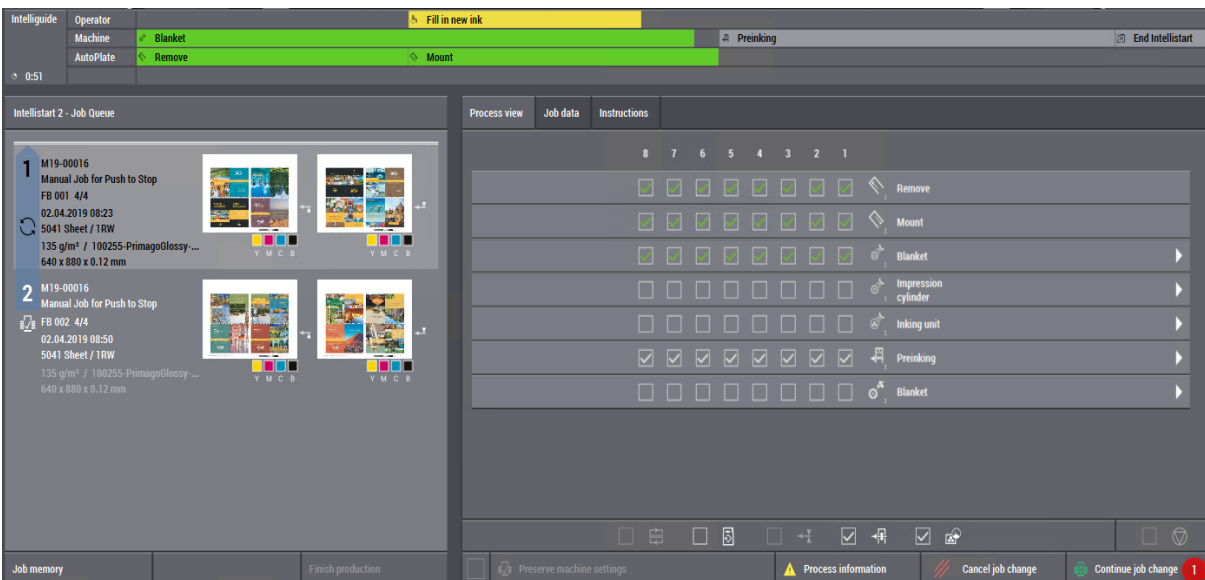
After pressing "Continue job change" "Intelliguide" will run through the preselected actions.

The first job of the day needs "Fill in new ink" and a "Preinking".

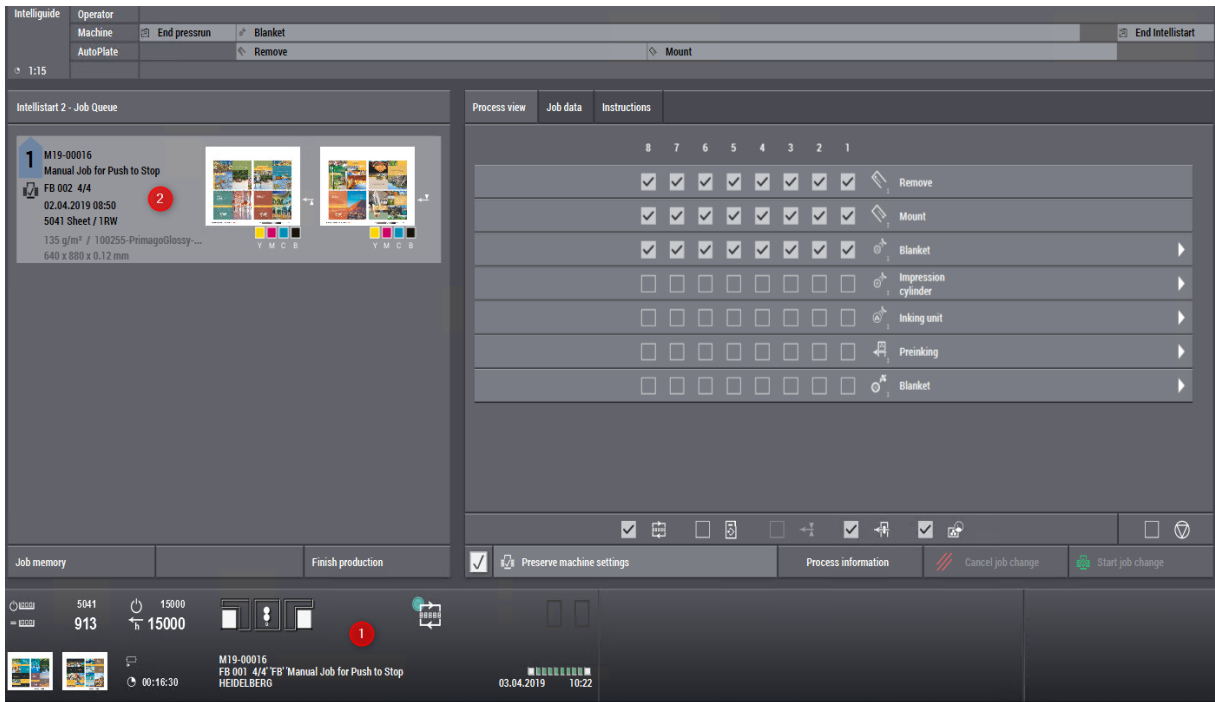


Before "Preinking" Intellistart will stop and is waiting for interaction "Fill in new ink".

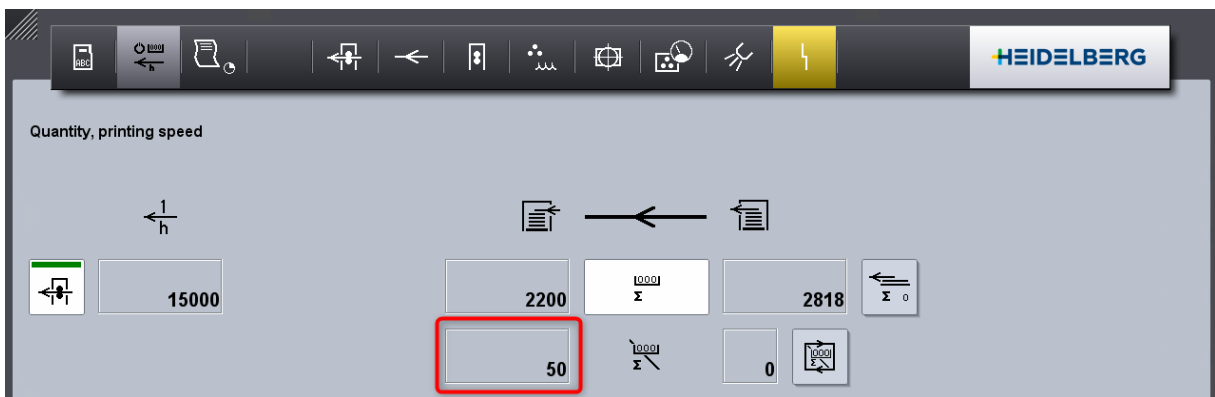
We have to "Continue job change" again to accept this manual step.



1. We can see that the first sheet FB001 is automatically running in good production
2. The second job is waiting in the queue

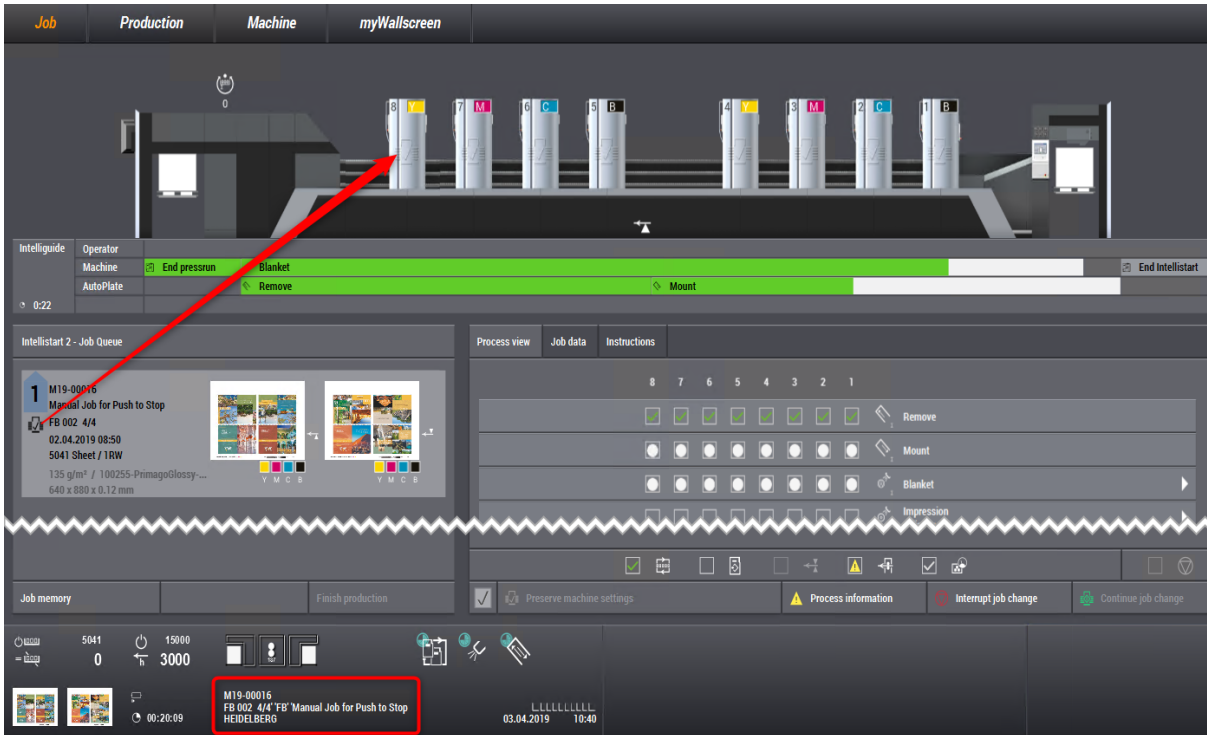


After the defined fixed waste has been reached, the job has changed automatically to good production.

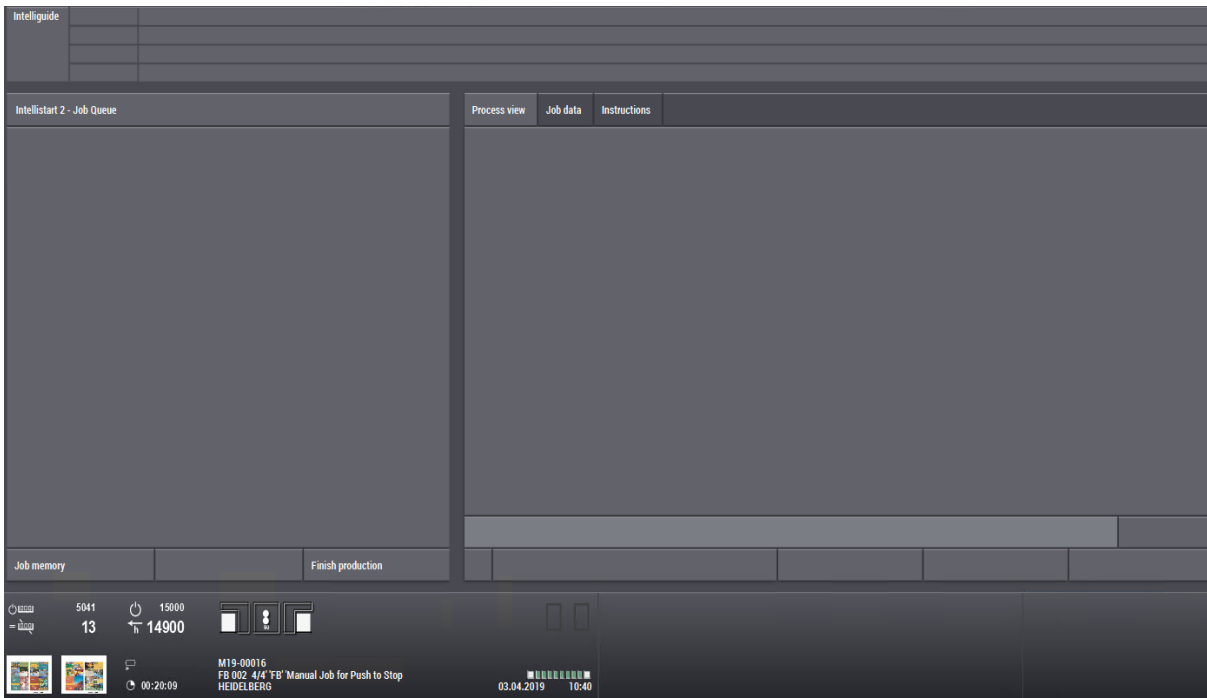


4 PressCenter Job

When the defined quantity has been printed, the job change to sheet FB02 has started automatically. The "Preserve machine settings" button is displayed in PressCenter 19A at the units.



The queue is empty when the last job in the Intellistart queue is printing.



Note: Do not forget to finish the last job manually!

4.7 Ink Presetting Curve for Process Colors

It is only possible to create a ink presetting curve while a job run at the PressCenter.

In our example we have to look that the ink series "STAR" was assigned to the Job
=> automatic allocation of the "STAR" ink presetting curves.

Motivation

The benefits of optimized "Ink Presetting Curves"

- Shorter make ready time
- Reduction of make ready sheets
- Quality optimization

Requirements

- PressCenter License "Color Assistant Pro"
- We have to print a job with Ink coverage values (Pressroom Manager, Prepress Interface...)
 1. "Ink coverage values" => 2. Presetting curve => 3. Ink zone opening

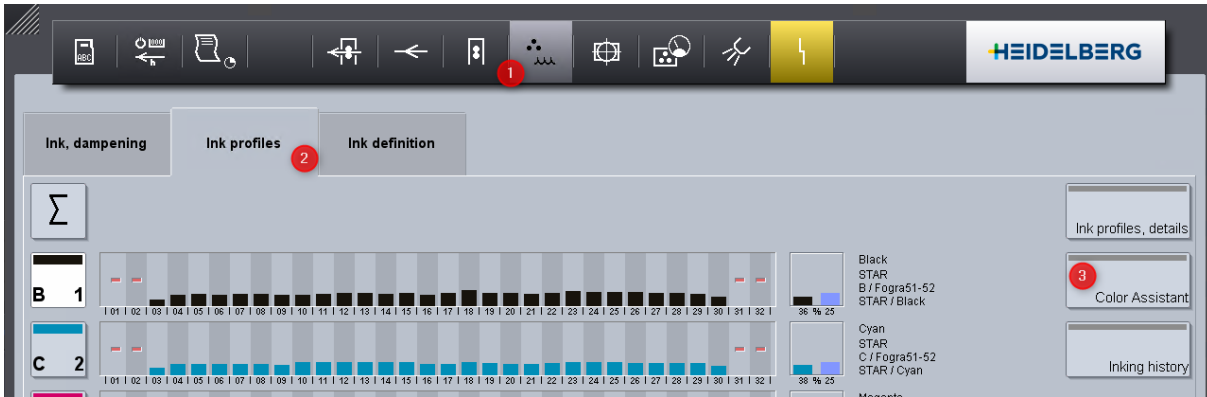
The job has been printed in good production!

The screenshot shows the Heidelberg PressCenter interface. At the top, there is a toolbar with various icons and the HEIDELBERG logo. Below the toolbar, the main area is titled "Ink profiles - details". On the left, there is a list of ink profiles: B 1, C 2, M 3, Y 4, B 5, C 6, M 7, Y 8. The profile "B 1" is selected. In the center, there is a preview of the printed job, showing various images and text. At the bottom, there is a color calibration bar with a red box highlighting the "1" and "3" markers. The bottom status bar displays job information: M19-00016, FB 002 4/4 'FB' 'Manual Job for Push to Stop', HEIDELBERG, 5041, 15000, 60, 3000, and the date/time 03.04.2019 13:29.

4 PressCenter Job

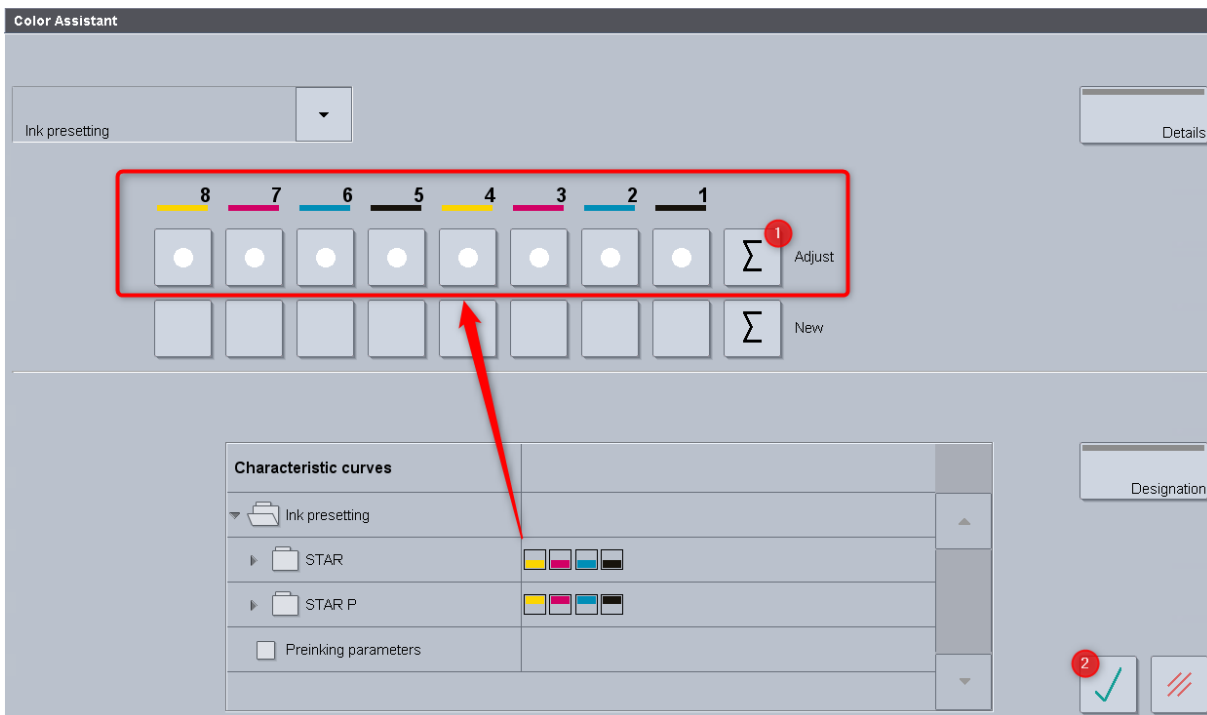
How to modify the allocated presetting curve "STAR"?

In the "Color Assistant"...



... we can see

1. the allocated "Ink presetting curves"
2. leaving the window will use the current ink key settings for optimization of the ink presetting curves



Note: All new jobs, which will be loaded to the queue will use the modified "Ink presetting curves".

4.8 Central Color Data Base

Motivation

We have to store color reference values as target values for the measurement system.

At the moment we just have the 3 standard color sets available

In a new installation Prinect 2020 we have 3 write protected default groups with all Paper Grades and all measurement filter:

- Fogra51-52
- HKS_2001
- PantonePlusV3

The screenshot shows the Heidelberg PressCenter software interface. The top menu bar includes File, Edit, View, Tools, and Help. The main window is titled 'HEIDELBERG' and has a 'Colors and Varnishes' tab selected. The interface is divided into three main panels:

- Folders:** A tree view showing folders for 'Fogra51-52', 'HKS_2001', and 'PantonePlusV3', all created by 'Heidelberg'.
- Colors:** A table of color data with columns for Color, L*, a*, b*, and Paper Grade. The table contains 12 rows of data, with the first row (Color M, L* 47.00, a* 74.12, b* -5.01, Glossy coated) highlighted in orange.
- Color Properties:** A panel showing details for the selected color (M). It includes fields for Type (Spectrum), Created on (30.01.2019 16:48:03), Created by (AdminService@HEIVM71412), Date Modified (12.03.2019 13:34:10), and Modified by (AdminService@HEIVM71412). Below this is a graph titled 'Measured Values' showing 'Spectrum' with 'Remission' on the y-axis (0.00 to 1.00) and 'Wavelength [nm]' on the x-axis (350 to 750). The graph shows a curve that rises from 0.00 at 350 nm to 1.00 at 750 nm. Below the graph are radio buttons for 'Measurement Condition' (M2, M3, M1).

We should create a clear folder structures for easy usage!

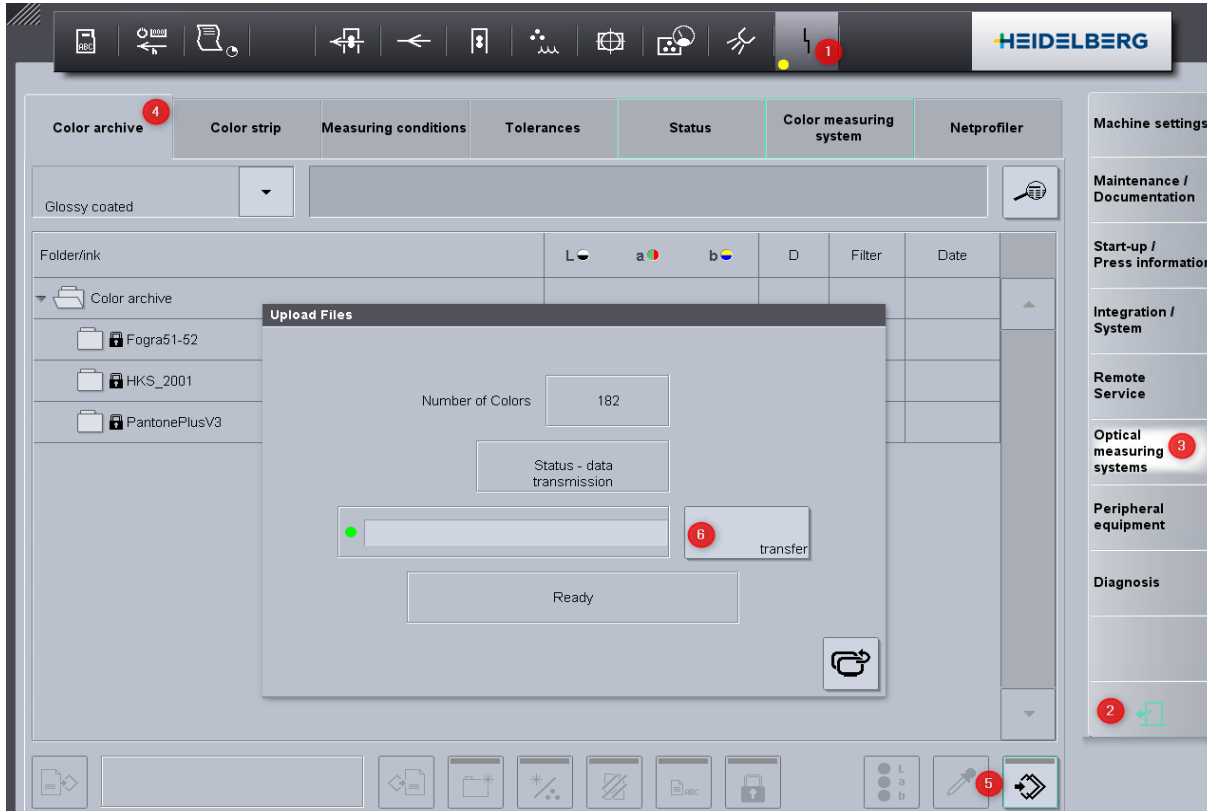
- Customer spot color folders e.g. SAP, IBM...
- Ink series folders e.g. STAR, EPPLE...
- Exported PressCenter colors - next page

4 PressCenter Job

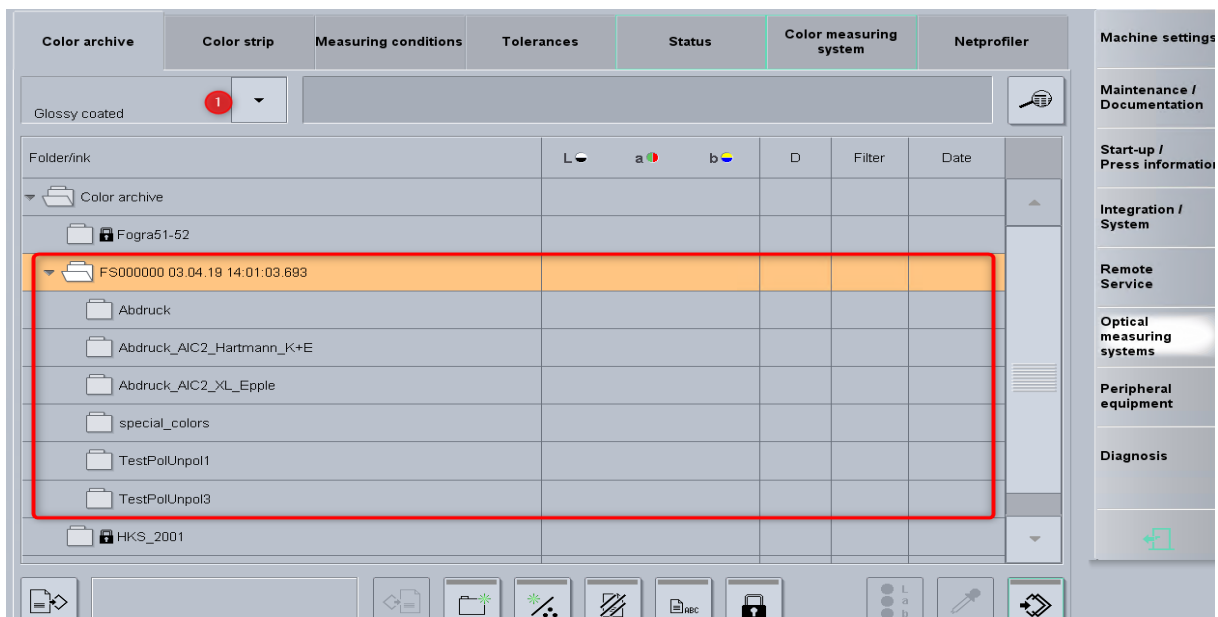
Central Color Data Base in PressCenter

- In PressCenter 19A a Variant key is required for using the Central Color Data Base
- In PressCenter 20A the Central Color Data Base is enabled by standard

We can transfer the "Local color data base" to the "Central Color Data Base".



We have to change the paper grade to force a refresh.



Attention: After Local Color Data Base Transfer

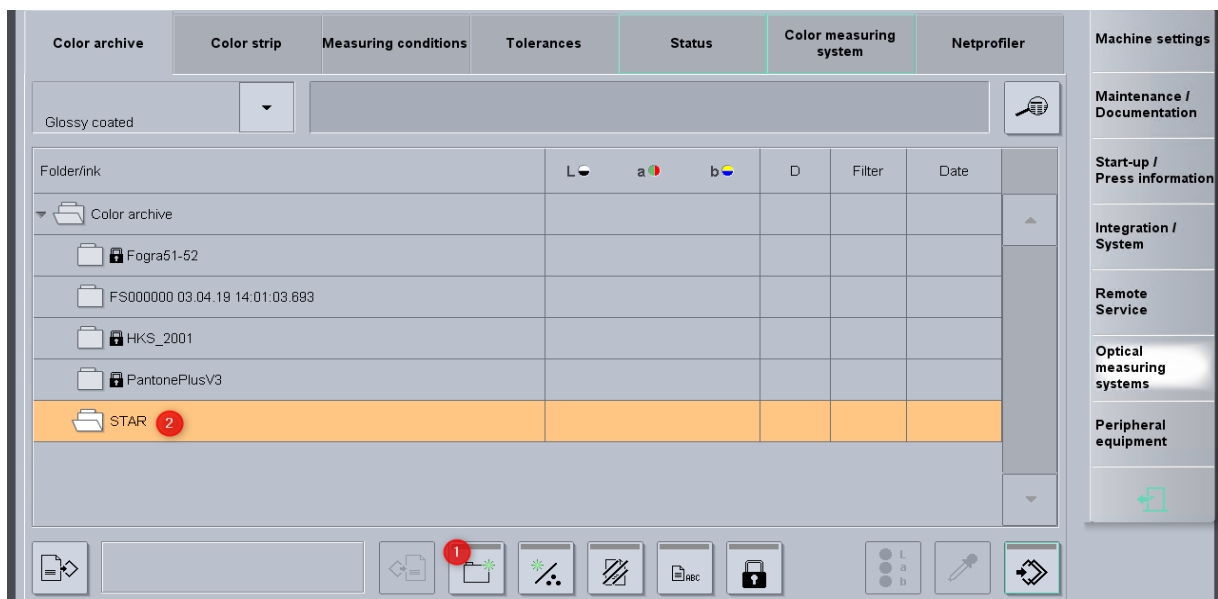
- All links to local spot colors get lost
- We have to link spot colors and process colors once => the PressCenter will remember this link
- After renaming folder structures, moving folders or renaming colors the link gets lost

We have 4 possibilities to get a new Colors into the Color Data Base:

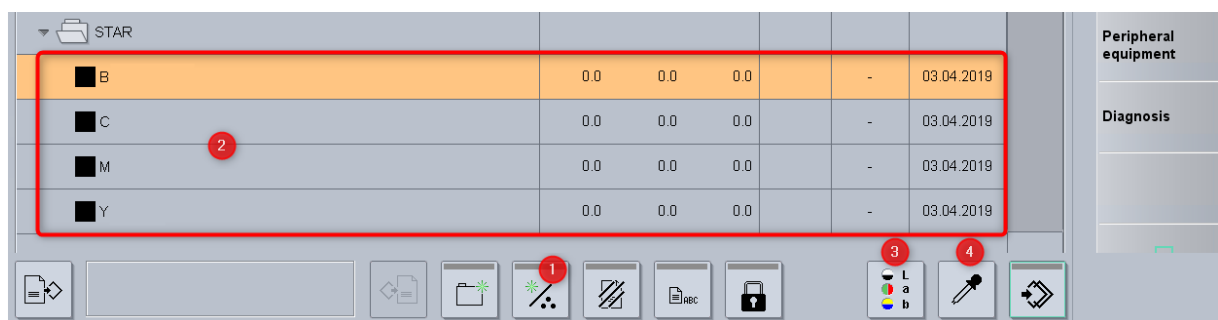
1. PressCenter / Inpress Control with X-Rite eXact directly into the Color Data Base
2. Directly from Color Bar with Easy Control, Axis, Inpress and Image Control
3. Manual Lab definition in PressCenter
4. X-Rite eXact measurement saved as a CXF file (download "X-Rite eXact Manager" from the Internet) and Cockpit import into the Color Data Base

4.8.1 Color Reference Values for Process Colors

For the ink series "STAR" we can create a folder structure "STAR" in the Central Color Data Base:



1. We can create 4 process colors and define manually by Lab values or with the X-Rite measurement device - the values are only to change in the PressCenter.



4 PressCenter Job

Result after value definition

Folderlink	L	a	b	D	Filter	Date
Color archive						
Fogra51-52						
FS000000 03.04.19 14:01:03.693						
HKS_2001						
PantonePlusV3						
STAR						
B	3.2	-0.1	0.9	2.36	(B)	03.04.2019
C	50.2	-39.9	-44.2	1.61	(C)	03.04.2019
M	41.1	70.8	-3.3	1.55	(M)	03.04.2019
Y	82.9	-3.6	95.0	1.50	(Y)	03.04.2019

2. We can define all colors in one step directly from color bar measurement.

This is only possible when measurement data are available.




In this dialog we can save colors to the Central Color Data Base.

Save Ink Set

Glossy coated

Folder/link	L	a	b	D	Filter
Color archive					
Fogra51-52					
FS000000 03.04.19 14:01:03.693					
HKS_2001					
PantonePlusV3					
STAR					
B	3.2	-0.1	0.9	2.36	(B)
C	50.2	-39.9	-44.2	1.61	(C)
M	41.1	70.8	-3.3	1.55	(M)
Y	82.9	-3.6	95.0	1.50	(Y)

Color set	L	a	b
B	3.2	-0.1	0.9
C	50.2	-39.9	-44.1
M	41.1	70.9	-3.3
Y	82.9	-3.6	95.0

 **Note:** Colors have to be defined for all Paper Grades!

4.8.2 Color Reference Values for Spot Colors

The procedure for spot colors is similar as for process colors (last chapter).

HEIDELBERG

Color archive | Color strip | Measuring conditions | Tolerances | Status | Color measuring system | Netprofiler

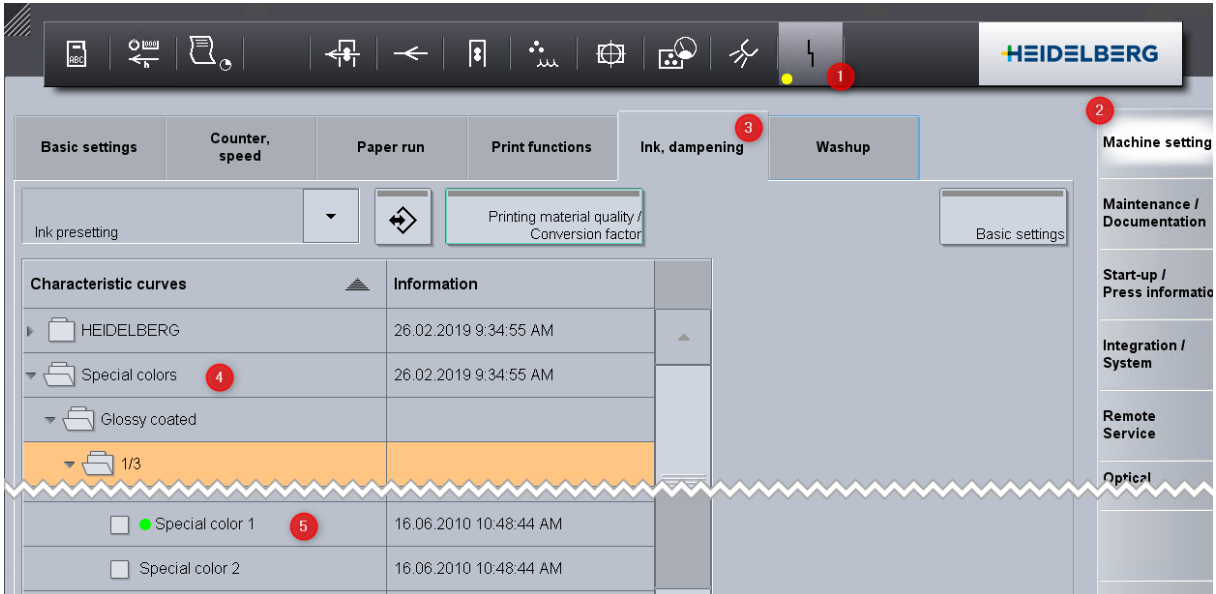
Glossy coated

Folder/link	L	a	b	D	Filter	Date
Color archive						
Fogra51-52						
FS000000 03.04.19 14:01:03.693						
HKS_2001						
IBM						
Blue	41.5	0.3	-45.7		(C)	03.04.2019
PantonePlusV3						
STAR						

Machine settings | Maintenance / Documentation | Start-up / Press information | Integration / System | Remote Service | Optical measuring systems | Peripheral equipment | Diagnosis

4 PressCenter Job

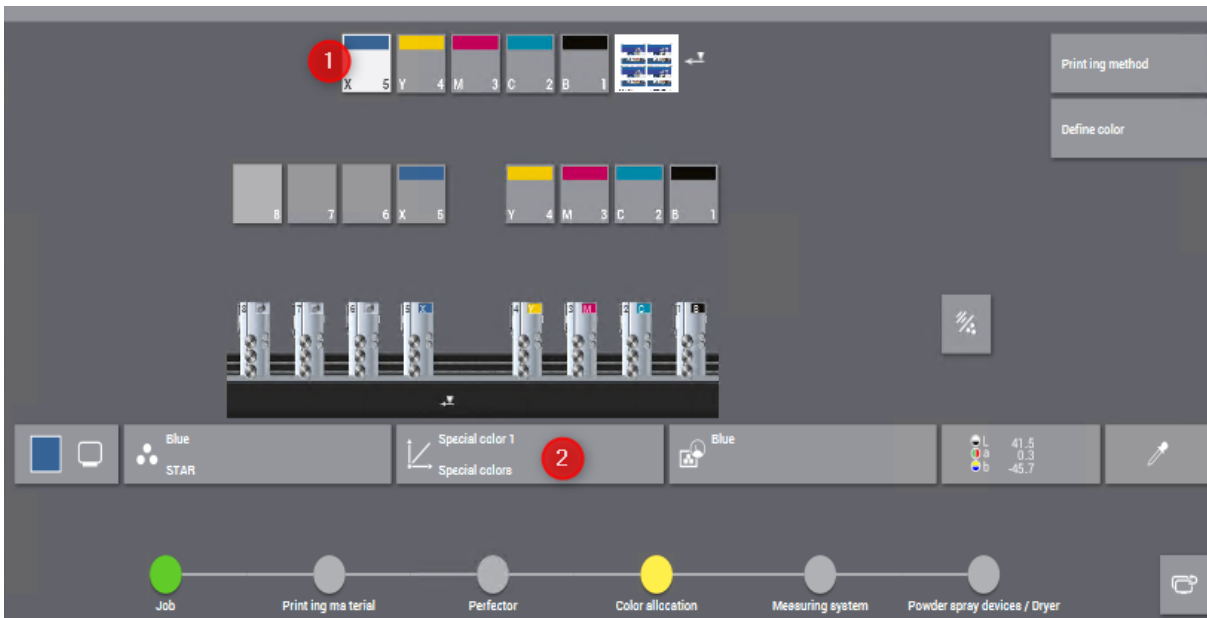
We are using for spot colors by default special ink presetting curves.



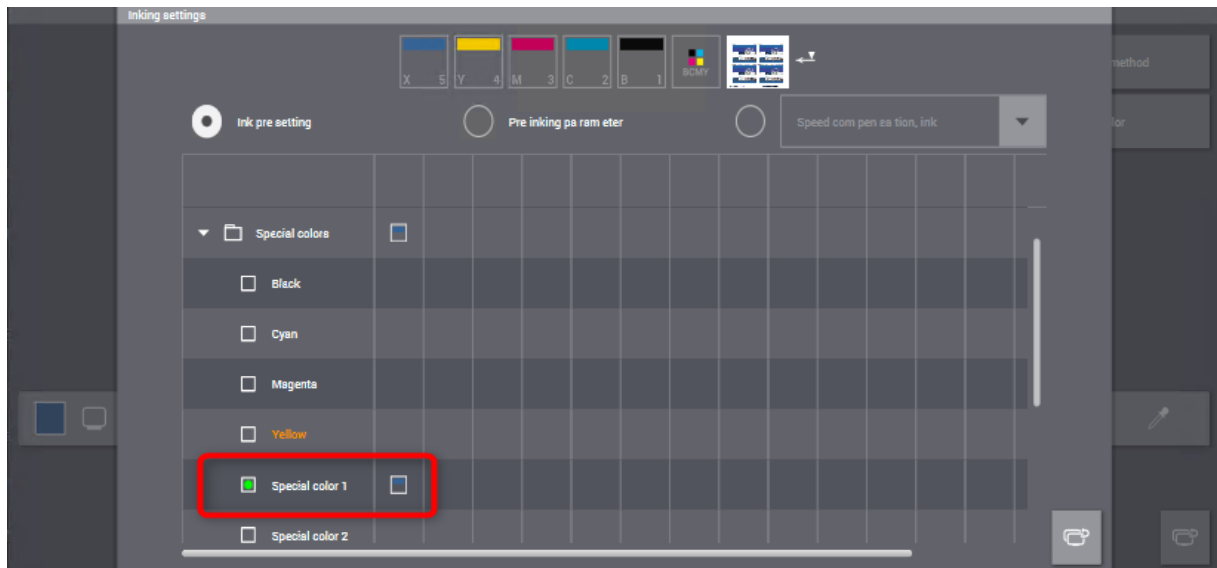
4.8.3 Ink Presetting Curve for a Spot Color

We have to print a job with the spot color "Blue" first.

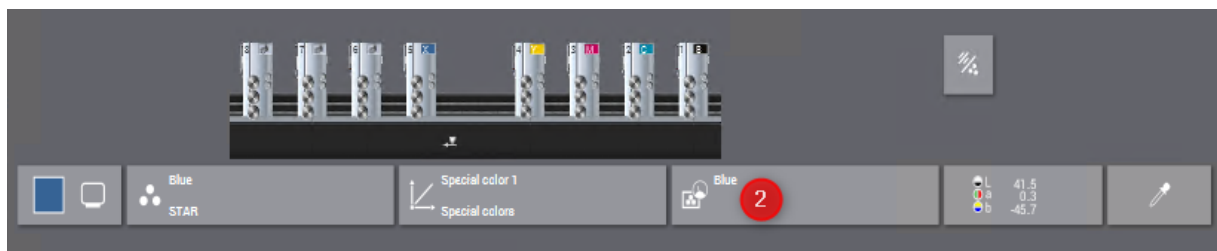
In the "Make Ready Assistant" we can see that the spot color "Blue" has automatically taken the ink presetting curve "Special colors"...



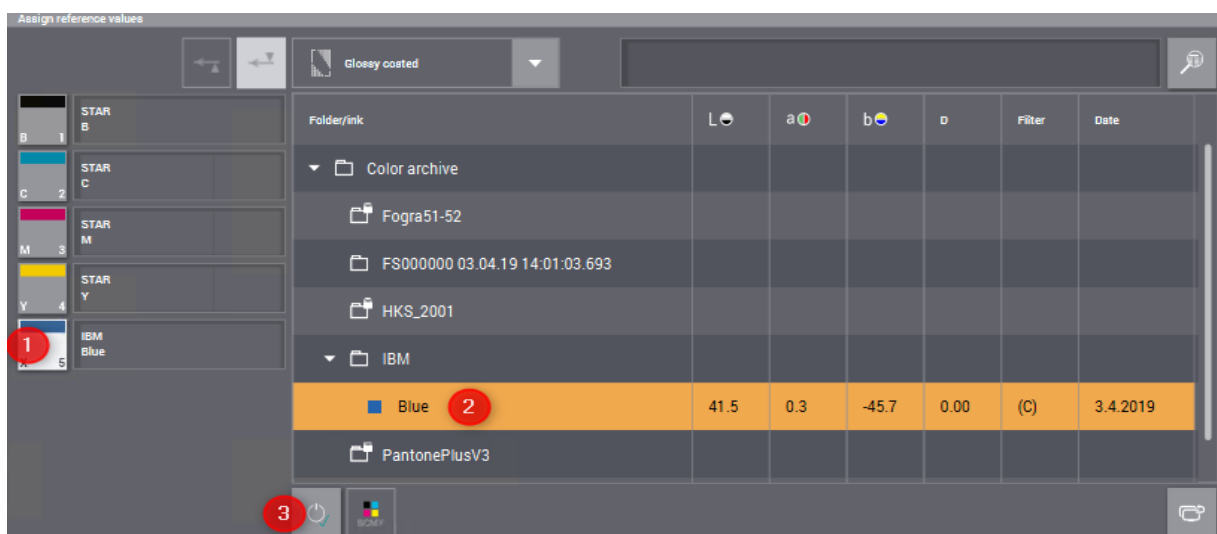
... because it is the default for all unknown spot colors (marked in green).



For the color "Blue" there is no reference defined at the moment in the Central Color Data Base.

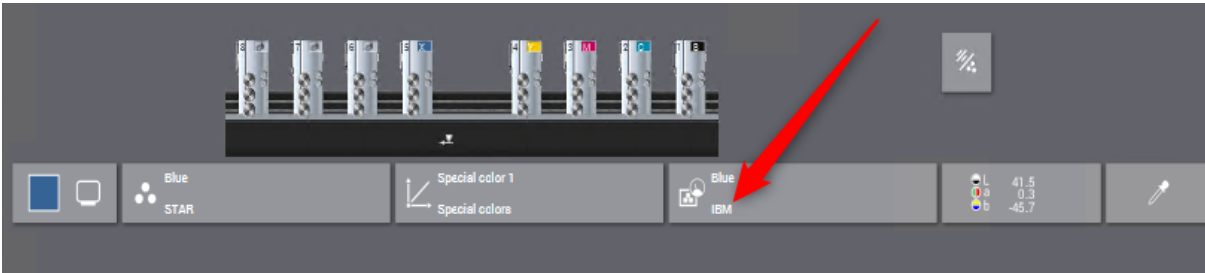


We can reference the color now in the Central Color Data Base. This reference is working the next time automatically for the spot color "Blue".



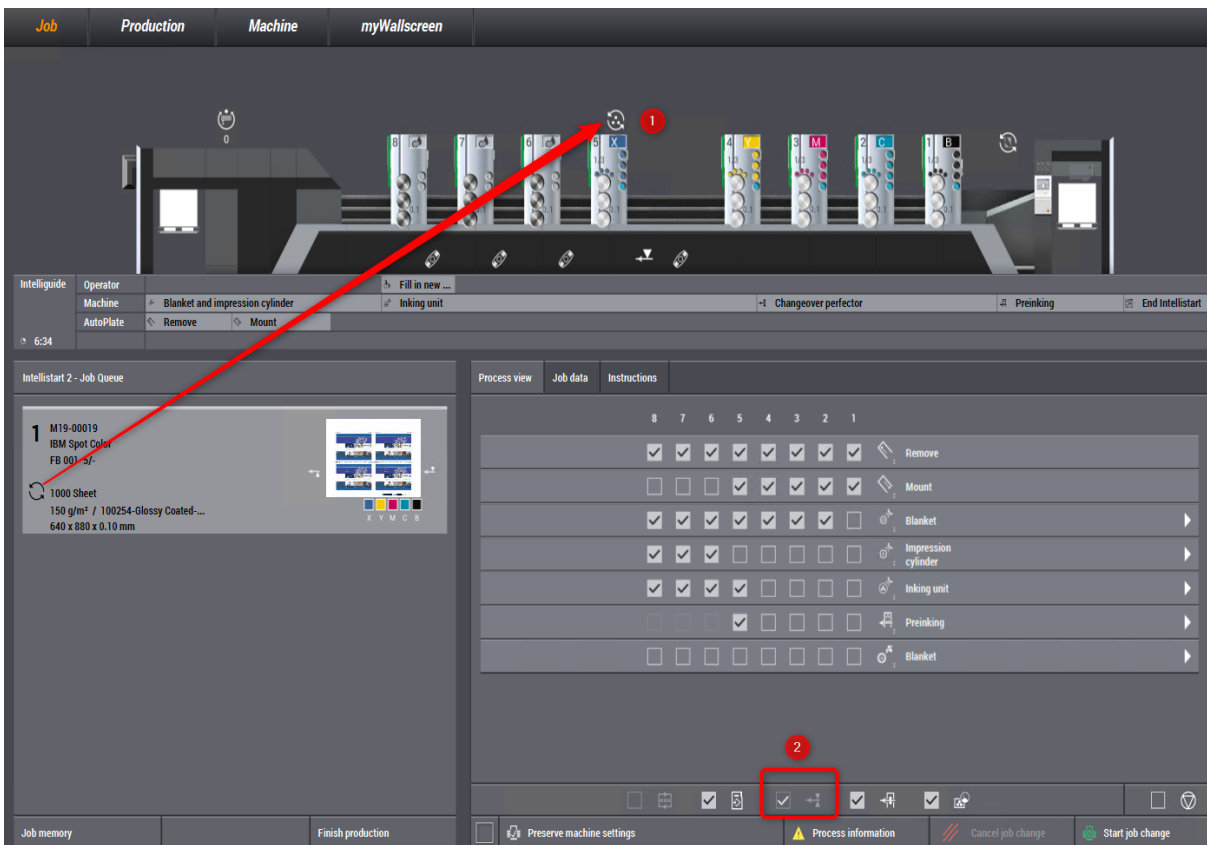
4 PressCenter Job

Now we can see that there was a referenced value found in the group "IBM".

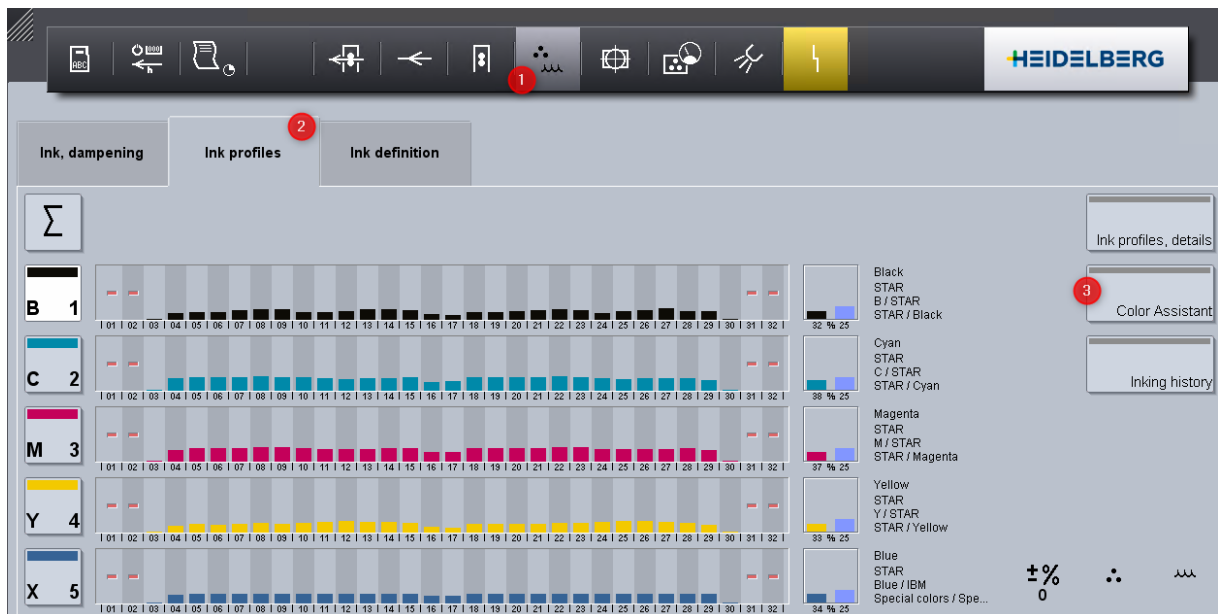


Intellistart displays that:

1. a new ink is to insert
2. the Perfector will change from perfecting to straight ahead printing.

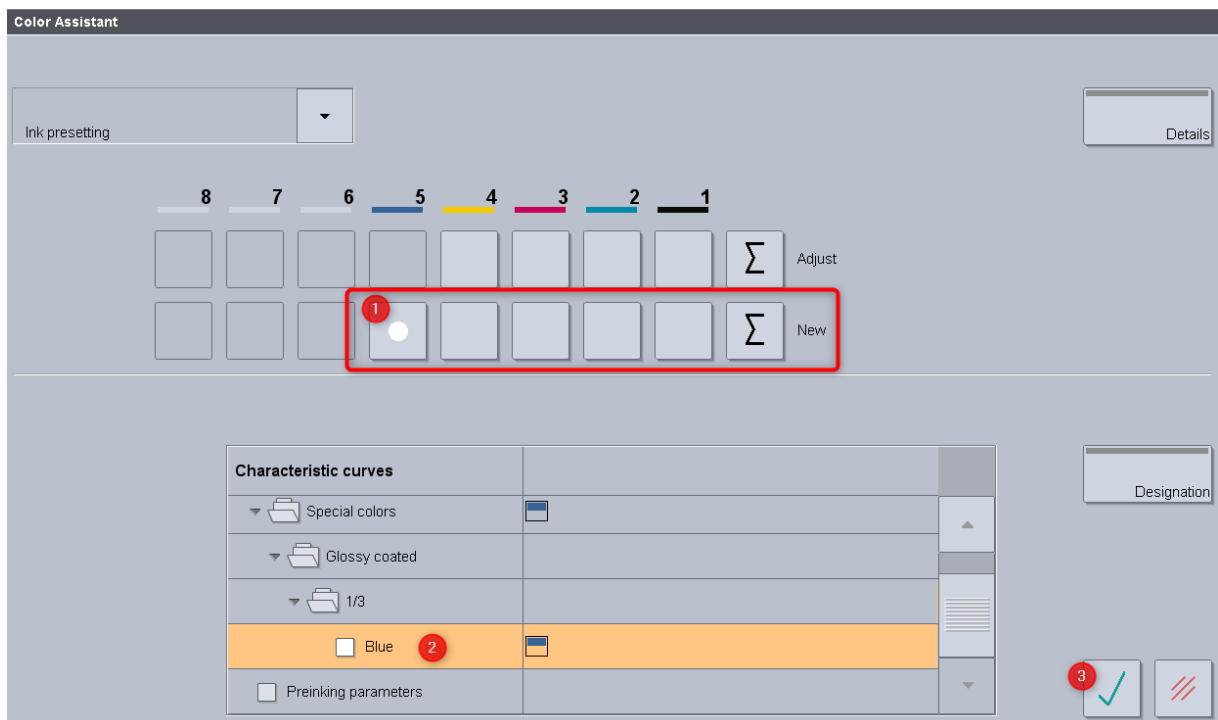


After we have printed good sheets for a while (we need measurement files to get optimized ink zones), we can use the "Color Assistant"...



... to save the current ink key settings as an ink presetting curve.

The next time the spot color "Blue" will find automatically the right ink presetting curve.

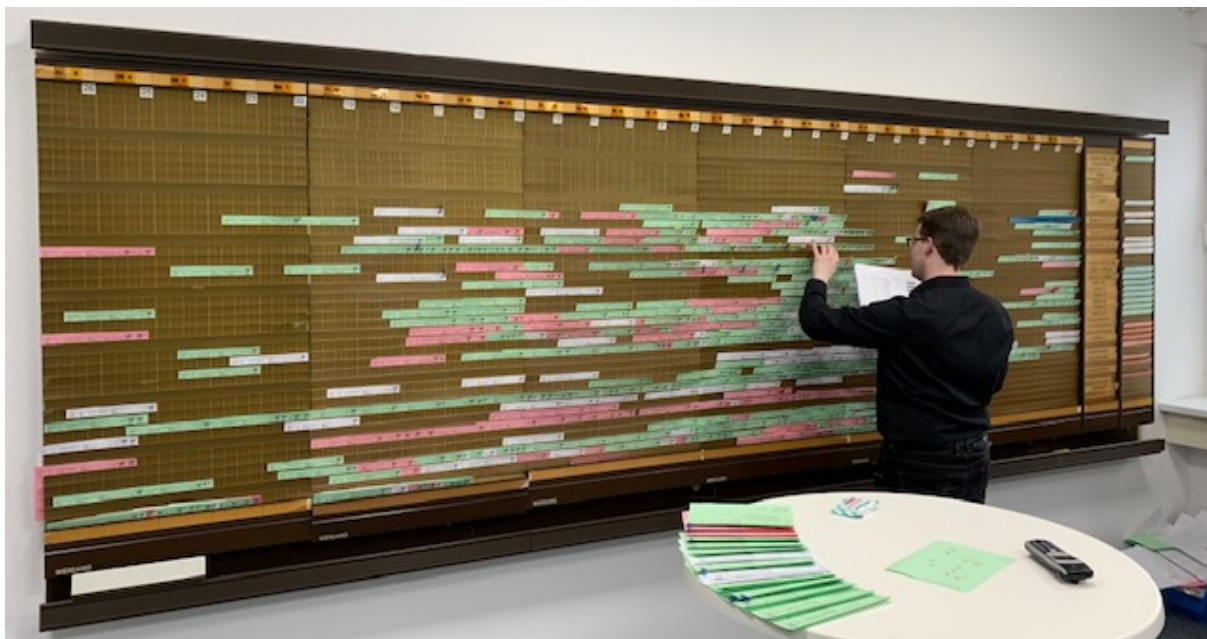


4 PressCenter Job

5 Planned Press Operations

Motivation

Customers wants to plan operations for press and Postpress in the Scheduler and not anymore on a planning board or Excel file.



When operations are planned the operator does not have to search jobs and operations, he has only to load the first operation in the job storage list.

Start	Number	Name	Operation
02.04.2019 08:23	M19-00016	Manual Job for Pu...	FB 001 4/4
02.04.2019 08:50	M19-00016	Manual Job for Pu...	FB 002 4/4
02.04.2019 09:17	200100	PBM Job with 5 S...	ST103301 4/4
02.04.2019 09:43	200100	PBM Job with 5 S...	ST103302 4/4
02.04.2019 10:09	200100	PBM Job with 5 S...	ST103303 4/4
02.04.2019 10:35	200100	PBM Job with 5 S...	ST103304 4/4
02.04.2019 11:01	100885	BM Job with Sheets	Text 02_ST102433 3/3
02.04.2019 12:19	100885	BM Job with Sheets	Text 03_ST102434 3/3
02.04.2019 13:37	100885	BM Job with Sheets	Text 04_ST102435 3/3
02.04.2019 14:55	200100	PBM Job with 5 S...	ST103305 4/4
02.04.2019 15:21	101173	PBM Job with 3 S...	Text 01_ST103299 4/4
02.04.2019 16:07	101173	PBM Job with 3 S...	Text 02_ST103300 4/4
02.04.2019 16:50	101173	PRM Job with 3 S...	Cover ST103298 4/4

Job data	Instructions
Number: M19-00016	Number: M19-00016
Name: Manual Job for Push to Stop	Name: Manual Job for Push to Stop
Operation: FB 001 4/4	Operation: FB 001 4/4
Customer: HEIDELBERG	Customer: HEIDELBERG
Date:	Date:
Quantity: 5041	Quantity: 5041
Planned Waste: 136	Planned Waste: 136
Production speed: 18000	Production speed: 18000
Start: 02.04.2019 08:23	Start: 02.04.2019 08:23
End: 02.04.2019 08:50	End: 02.04.2019 08:50
Notes:	Notes:
Color strip: Micro-6_i_F105	Color strip: Micro-6_i_F105
Quality: Glossy coated	Quality: Glossy coated
Paper white: L: 0.0 a: 0.0 b: 0.0	Paper white: L: 0.0 a: 0.0 b: 0.0
Size: 640 x 880 x 0.12 mm	Printing material: 100255-PrimagoGlossy-88...
Grammage: 135 g/m²	Grain Direction: Short grain
Pull side: O.S.	Air Assistant: Air Assistant

5 Planned Press Operations

5.1 Prinect Scheduler

The Prinect Scheduler is a professional tool to plan operations for Press and Postpress.

5.1.1 Operations with Start Date of the Scheduler

A user with scheduling-rights can plan operations for production.

The screenshot displays the Prinect Scheduler interface. The top part is a Gantt chart showing a production schedule from Tuesday, April 2nd to Thursday, April 4th. A red box highlights a job on machine XL105-10P6 on Tuesday, April 2nd, with a red arrow pointing to the 'Start' date in the table below. The table below the Gantt chart lists jobs with columns for Job, Sheet, Customer, Machine, Quantity, Start, Status, Duration, Size, and Inks. The 'Start' column is highlighted with a red box, and the first row shows a start time of 02.04.19 08:23.

Job	Sheet	Customer	Machine	Quantity	Start	Status	Duration	Size	Inks
M19-00011 - Calibration Apple Au...	FB 001		XL105-10P6	544	02.04.19 08:23	Waiting	00:07	880x640	4/4(CMYK)(C...
M19-00016 - Manual Job for Push...	FB 001	Heidelberger...	XL105-8P5	5.041	02.04.19 08:23	Waiting	00:27	880x640	4/4(CMYK)(C...
101160 - Brochure Klebebindung	ST103207 (Sammel 4...	Heidelberger...	XL105-10P6	15.305	02.04.19 08:30	Waiting	01:22	880x640	4/4(CMYK)(C...
M19-00016 - Manual Job for Push...	FB 002	Heidelberger...	XL105-8P5	5.041	02.04.19 08:50	Waiting	00:27	880x640	4/4(CMYK)(C...
200100 - PBM Job with 5 Sheets ...	ST103301	Heidelberger...	XL105-8P5	5.000	02.04.19 09:17	Waiting	00:26	880x640	4/4(CMYK)(C...
200100 - PBM Job with 5 Sheets ...	ST103302	Heidelberger...	XL105-8P5	5.000	02.04.19 09:43	Waiting	00:26	880x640	4/4(CMYK)(C...
101165 - 250Pages Tets 2	ST103220 (Text_ST1...	Heidelberger...	XL105-10P6	5.020	02.04.19 09:52	Waiting	00:35	880x630	4/4(CMYK)(C...

The "Start" date is to use at the PressCenter

The screenshot shows the PressCenter interface. On the left, a table lists operations with columns for Start, Number, Name, and Operation. A red arrow points to the 'Start' column. On the right, the 'Job data' section shows details for a job, including Number, Name, Operation, Customer, Date, Quantity, Planned Waste, Production speed, Start, End, Quality, and Paper white. The 'Start' date is 02.04.2019 08:23.

Start	Number	Name	Operation
02.04.2019 08:23	M19-00016	Manual Job for Pu...	FB 001 4/4
02.04.2019 08:50	M19-00016	Manual Job for Pu...	FB 002 4/4
02.04.2019 09:17	200100	PBM Job with 5 S...	ST103301 4/4
02.04.2019 09:43	200100	PBM Job with 5 S...	ST103302 4/4
02.04.2019 10:09	200100	PBM Job with 5 S...	ST103303 4/4
02.04.2019 10:35	200100	PBM Job with 5 S...	ST103304 4/4
02.04.2019 11:01	100885	BM Job with Sheets	Text 02_ST102433 3/3
02.04.2019 12:19	100885	BM Job with Sheets	Text 03_ST102434 3/3
02.04.2019 13:37	100885	BM Job with Sheets	Text 04_ST102435 3/3
02.04.2019 14:55	200100	PBM Job with 5 S...	ST103305 4/4

5.1.2 Grouped PressCenter Operations

This feature is only working with PressCenter 19A.

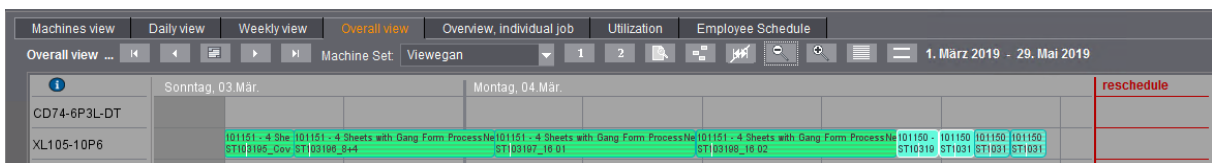
Motivation

In the Scheduler it is possible to group operations. This grouping should be available for the press operator as work packages.

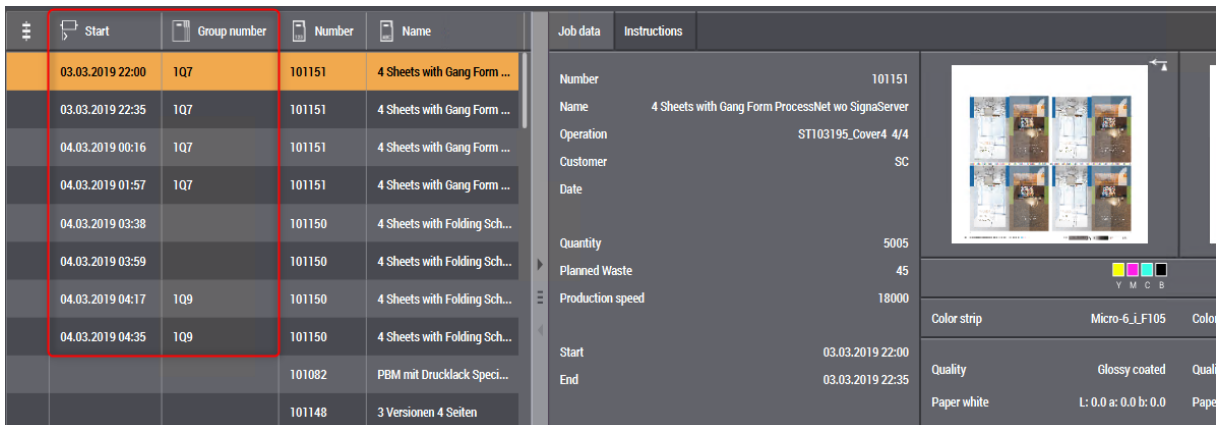
The goal of a work package at the press is to bundle successive operations that shall be placed on ONE pallet.

Description

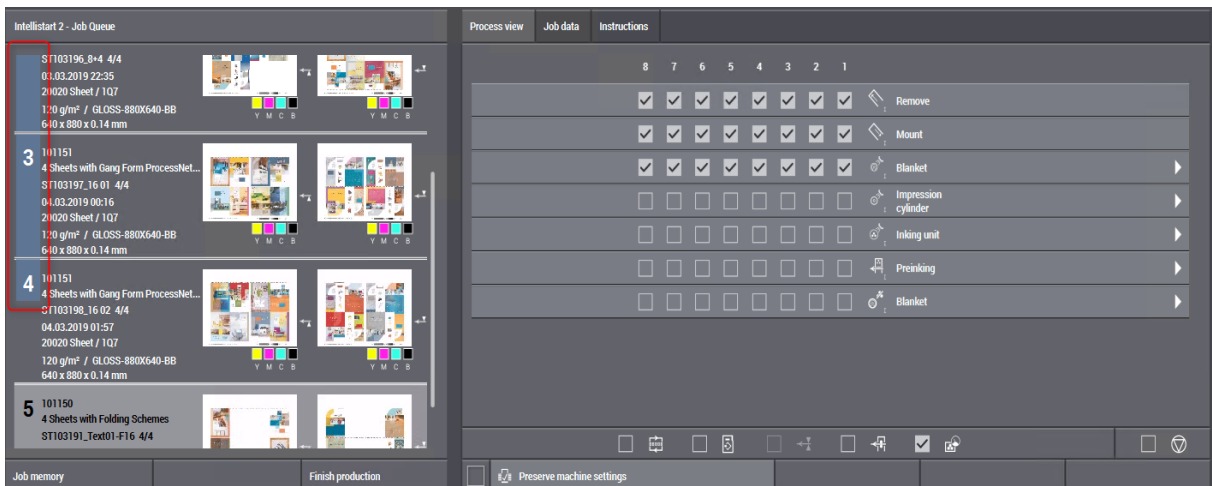
In the Scheduler we can create Groups automatically or manually. Groups are visualized by horizontal lines inside the rectangles.



Scheduling Time and groups are displayed in the PressCenter Storage and...



... in the job queue, symbolized with a blue bar.



5 Planned Press Operations

5.2 Prinect Portal - Machine Widget

Motivation

Even without Scheduler it should be possible to define a press operation order.

Description

With new user right ""Operations Sequence Order" it is possible to allow to order operations for the press operator in the "Prinect Portal". The permission group "PortalAdmin" has this right by default.

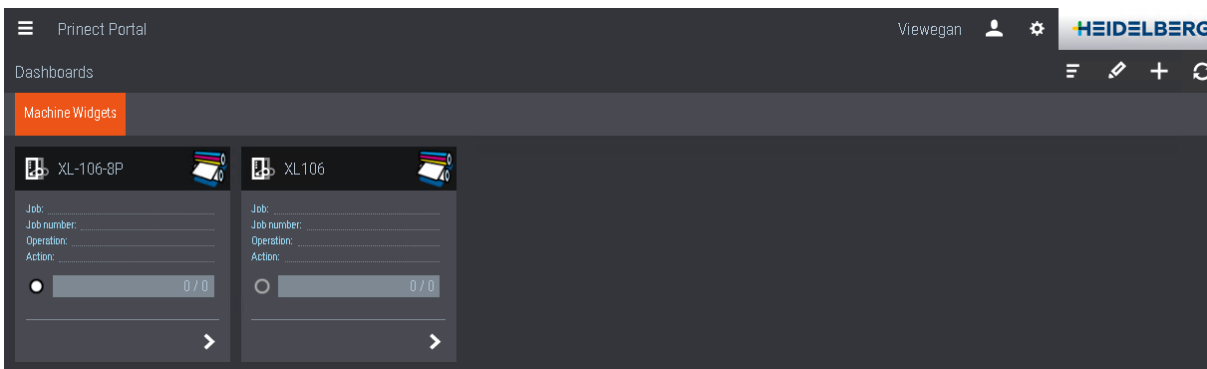
The feature to define a operation order is realized in the "Prinect Portal" / "Machine Widget".

The Portal can be installed at the Prinect Server or as a Standalone Portal Server:

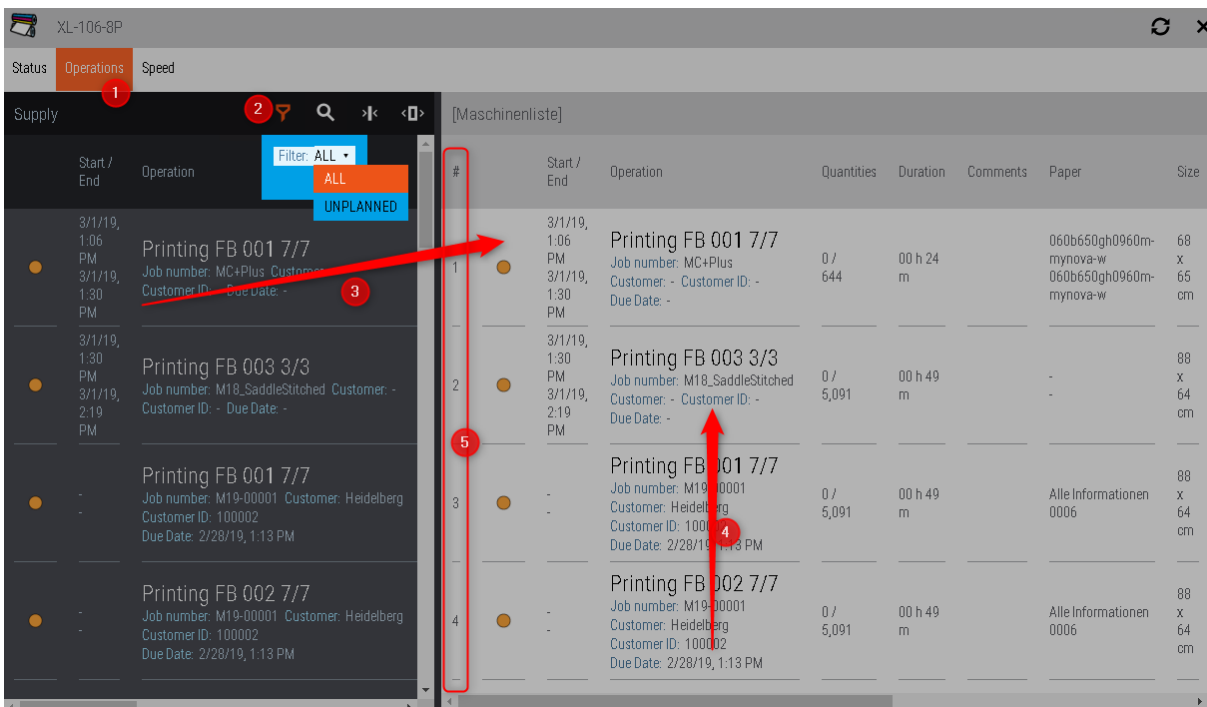
[http://\"PrinectServer\"/PrinectPortalLocal](http://\)

[https://\"PrinectPortalServer\"/PrinectPortal](https://\)

User: PortalAdmin PW: PortalAdmin



With permission we have a split window and can drag & drop operations in the right list.



Result

In the PressCenter the operation order is displayed by the "Start Date".

The screenshot displays the PressCenter interface. On the left, a table lists operations with columns for Number, Start, Name, and Operation. The 'Start' column is highlighted with a red box. The main area shows detailed job information for 'MC+Plus', including job data, instructions, quantity (644), planned waste (88), production speed (18000), and start/end times (01.03.2019 13:06 to 01.03.2019 13:30). It also features two color strip images and various technical specifications like paper type (Matt coated), size (650 x 680 x 0.06 mm), and grammage (60 g/m²).

Number	Start	Name	Operation
MC+Plus	01.03.2019 13:06	Plus+Version	FB 001 7/7
M18_SaddleStit...	01.03.2019 13:30	Immer fest im Sattel	FB 003 3/3
M19-00001		XL106-6P	FB 001 7/7
M19-00001		XL106-6P	FB 002 7/7
M19-00001		XL106-6P	FB 004 7/7
M19-00001		XL106-6P	FB 005 7/7
M19-00001		XL106-6P	FB 006 7/7
M19-00001		XL106-6P	FB 007 7/7
M19-00001		XL106-6P	FB 008 7/7



Note: This feature is only to define an operation order! Only in the Scheduler we can define and change exact start times.

5 Planned Press Operations

5.3 Jobs are locked by Intellistart or Plate Pilot

Motivation

Printing operations should be locked when:

- The operation was loaded in the "Intellistart Queue"
- The "plate set" is inside of a "plate stack" of the "Plate Pilot"

Description

When an operation was loaded into the Intellistart queue...

Intellistart - Job Queue

Process view | Job data | Instructions

Number 101150
Name 4 Sheets with Folding Schemes
Operation Text01-F16_ST103191 4/4
Customer ALDI
Date

... the operation is locked in the Machine Widget.

Prinetx Portal | Viewegan | HEIDELBERG

XL105-10P6

Status: Operations | Speed

[Maschinenliste]

#	Start / End	Operation	Quantities	Duration	Comments	Paper	Size	Grammage
1	18/03/2019 09:41 - 18/03/2019 10:02	Printing Text01-F16_ST103191 4/4 Job number: 101150 Customer: ALDI Customer ID: 100014 Due Date: 30/03/2019 00:00	0 / 2,020	350000 h 00 m		GLOSS-880X640-BB 100038	88 x 64 cm	120 g/m2
2	18/03/2019 10:02 - 18/03/2019 10:28	Printing 1Page Single sided_ST103004 5+/- Job number: 101082 Customer: BMW	0 / 5,000	00 h 26 m		100001	88 x 63 cm	120 g/m2

The operation is displayed in the Scheduler too.

Machines view | Daily view | Weekly view | Overall view | Overview, individual job | Utilization | Employee Schedule

Overall v... | Machine Set: All Machines | 18. März 2019 - 15. Ju

Montag, 18. Mär.

101150 - 4 Sheets with Folding Schemes
Text01-F16_ST103191

5.4 Work Instructions for PressCenter Operator

This feature was implemented in Prinect 2019.10 too and is working at PressCenter 19A only.

Motivation

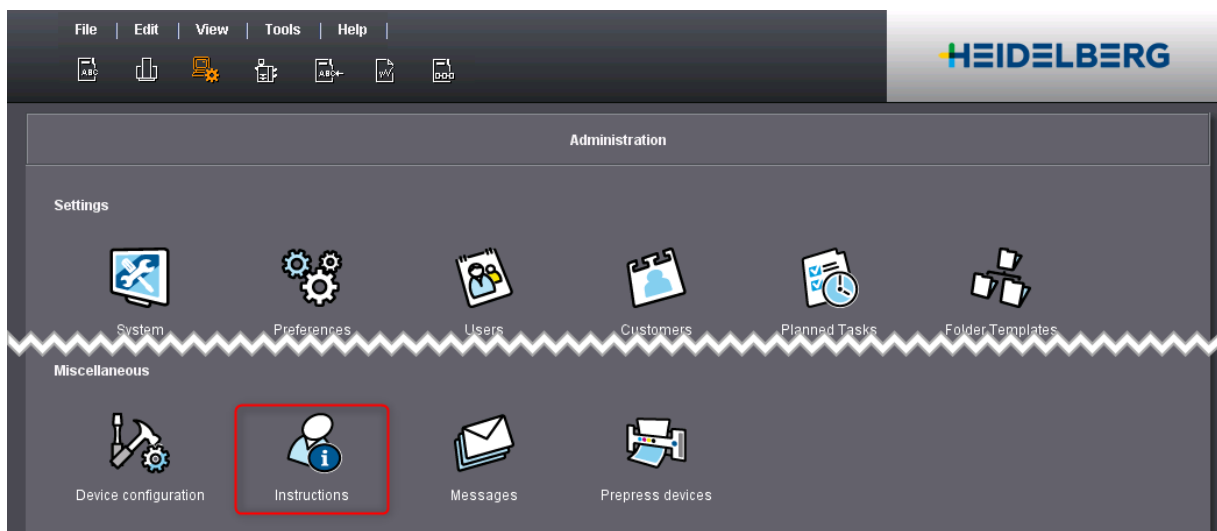
Customers wants to transfer important instructions to the press operator at the PressCenter.

Example: For this job the operator has to configure "Insert Star" to insert strips in a interval of 100 sheets.

Description

Instructions are based on "Product Codes" and displayed at the PressCenter 19A.

In Cockpit > Administration > Instructions...

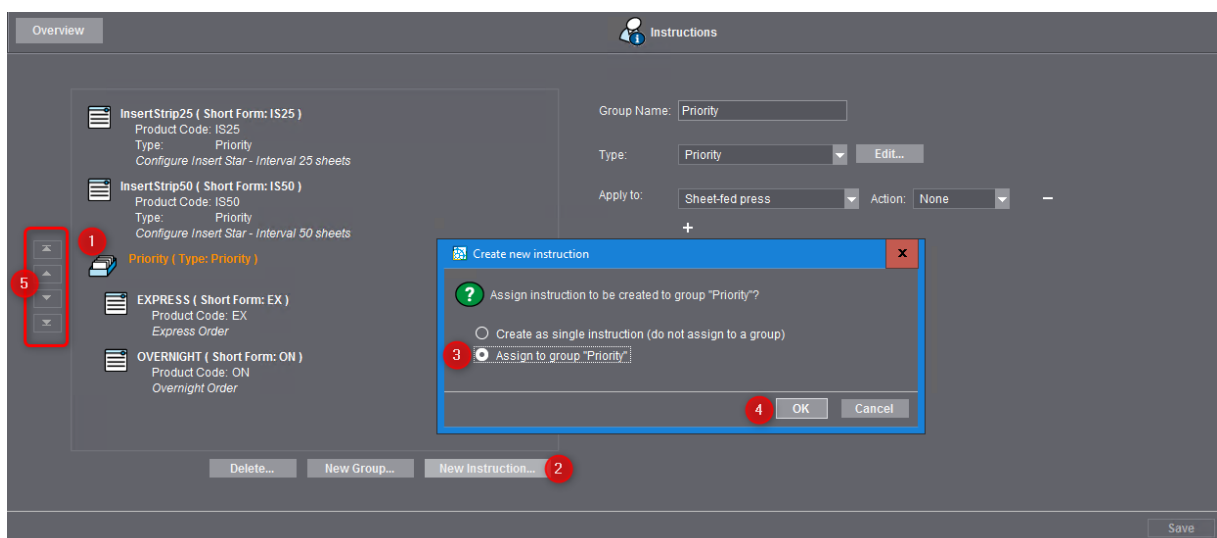


... we can create "Instructions" and "Instruction Groups".



Note: Instructions inside of a Group can be sorted for priority.

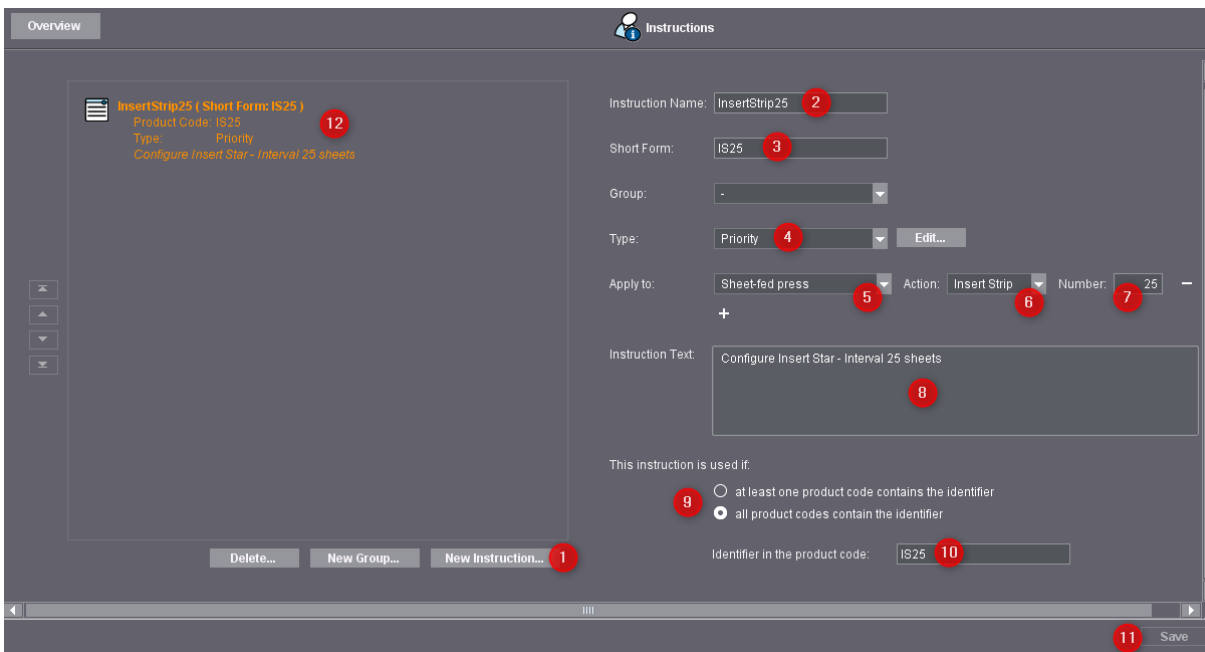
This is necessary for Gang Jobs with different priority: Overnight - Express - Normal



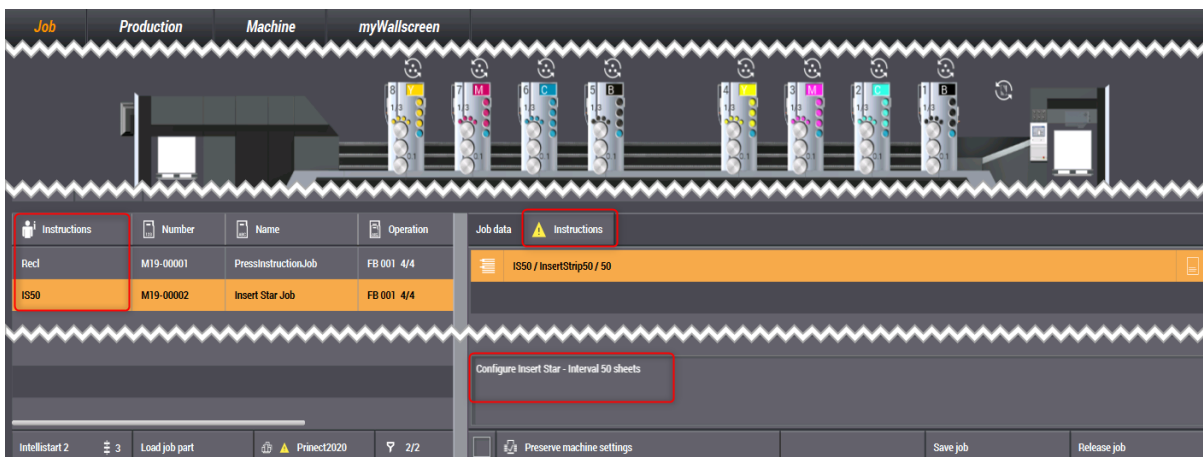
5 Planned Press Operations

It is also possible to generate instructions without any groups.

1. New Instruction - to create new instructions
2. Instruction Name - displayed at the PressCenter
3. Short Form - displayed at the Wallscreen
4. Group - only displayed in the Cockpit
5. Type - default types are "Priority" and "Approval" - only displayed in the Cockpit
6. Apply to "Device Class" - at the moment only "Sheet-fed press" is supported
7. Action / Number - defaults are "Insert Strip / interval number" or "None"
8. Instruction Text - displayed at the "PressCenter".
9. This instruction is used if - a Gang form can include jobs with different "Product Codes"
10. Identifier in the product code - this "text" has to be inside the "Product Code"

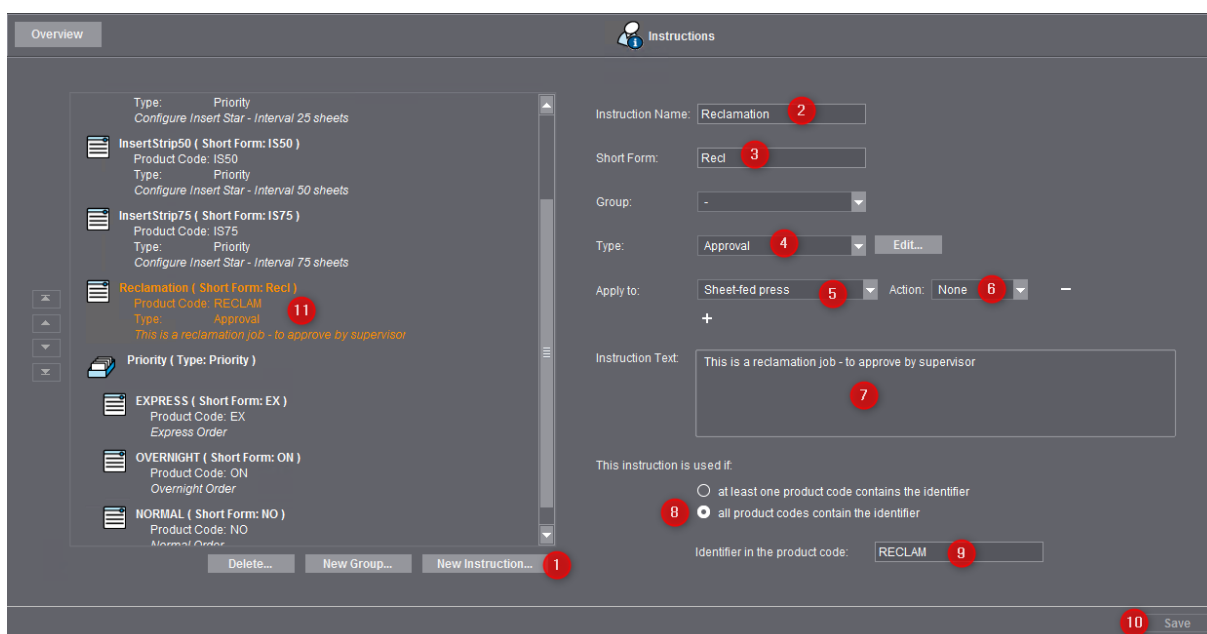


"Instruction Name", "Short Form" and "Instructions Text" are visible in PressCenter 19A.



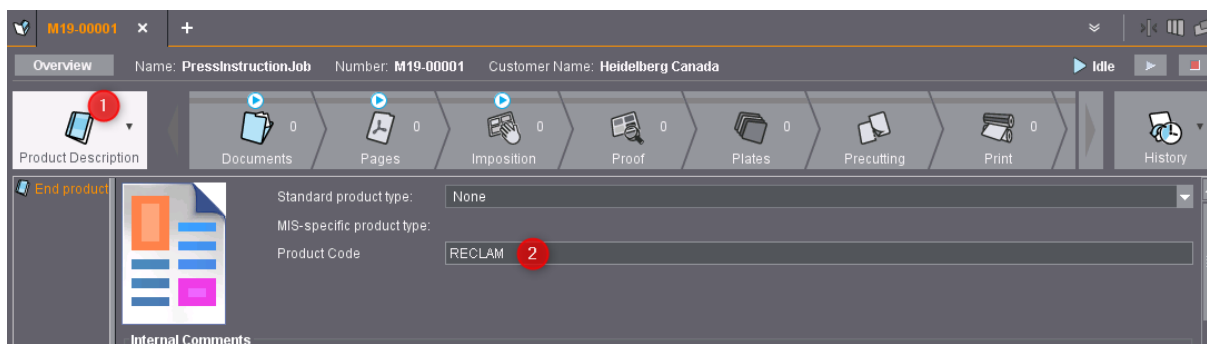
Customer examples for instructions:

- Priority Group
 - Overnight jobs
 - Express jobs
 - Normal jobs
- Insert Stripes 25 / 50 / 75 / 100
- Proof available / required
- Approval by supervisor necessary
- Reclamation => Special attention! One Sheet for archive



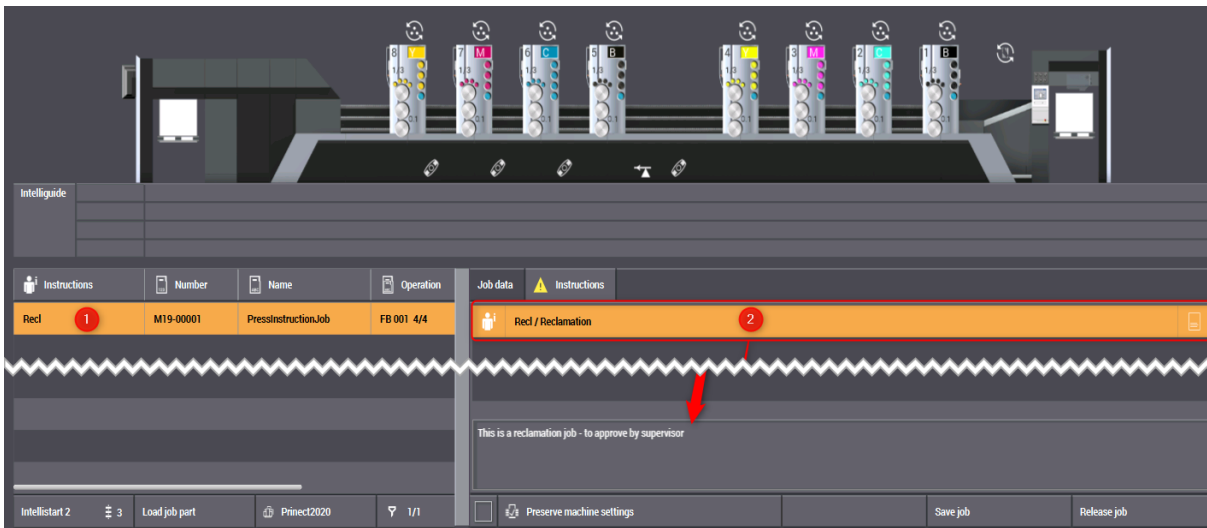
The "Product Code" has to be assigned for the job.

- This can be done by automatically by a W2P front-end or by MIS.
- It is also allowed to define the Product Code manually in the job.

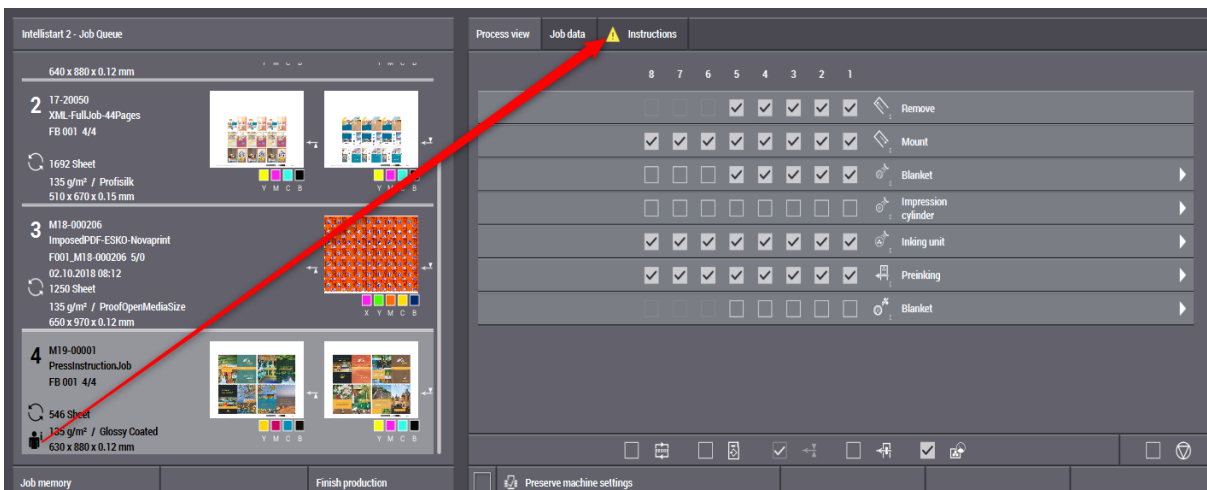


5 Planned Press Operations

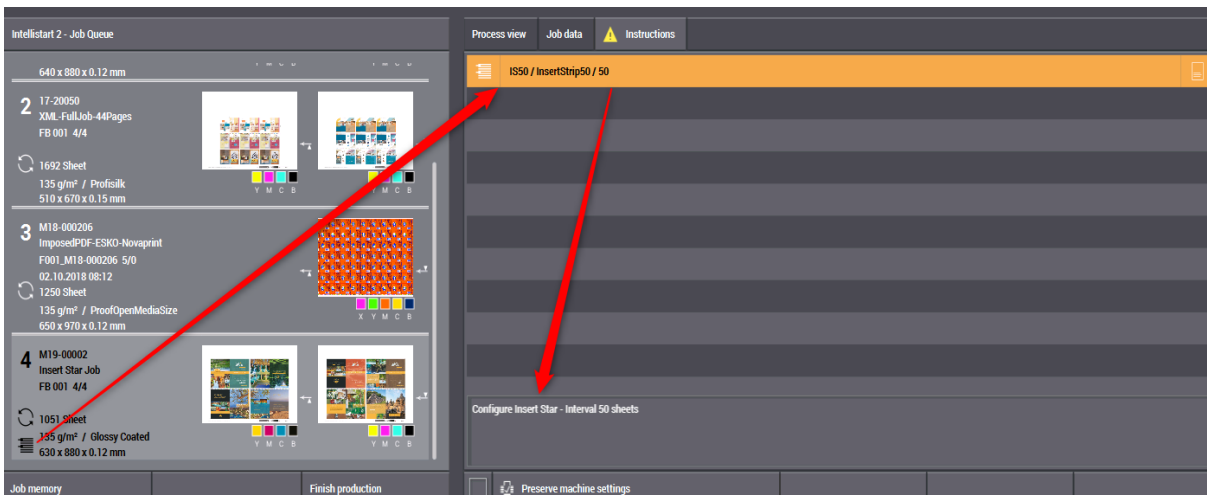
Display at the PressCenter storage - we have a new column "Instructions".



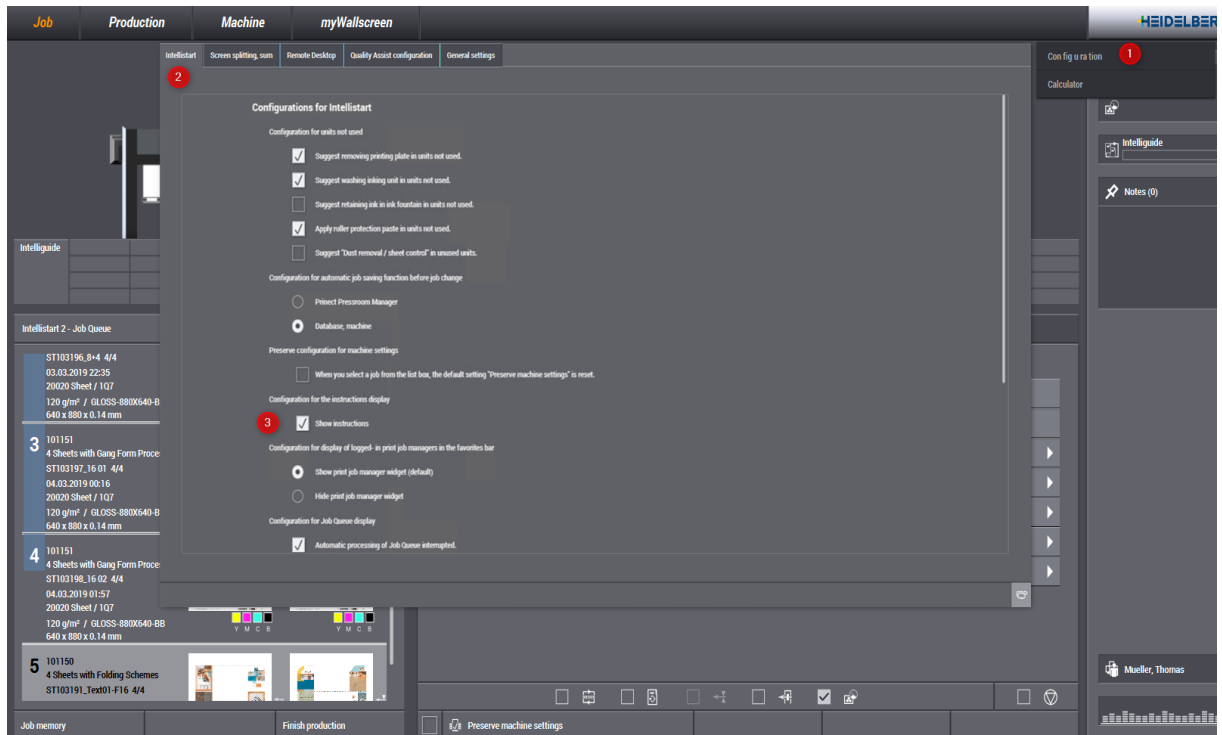
Displayed in the PressCenter queue - we have new instruction icon at the operation.



Only for the "Insert Strip" we have a own icon.



The PressCenter display of instructions is enabled by default in Press Center 19A. You can "Log in as Service" or "Print Shop Administrator" to change the default.



5.5 PressCenter Autofill

Motivation

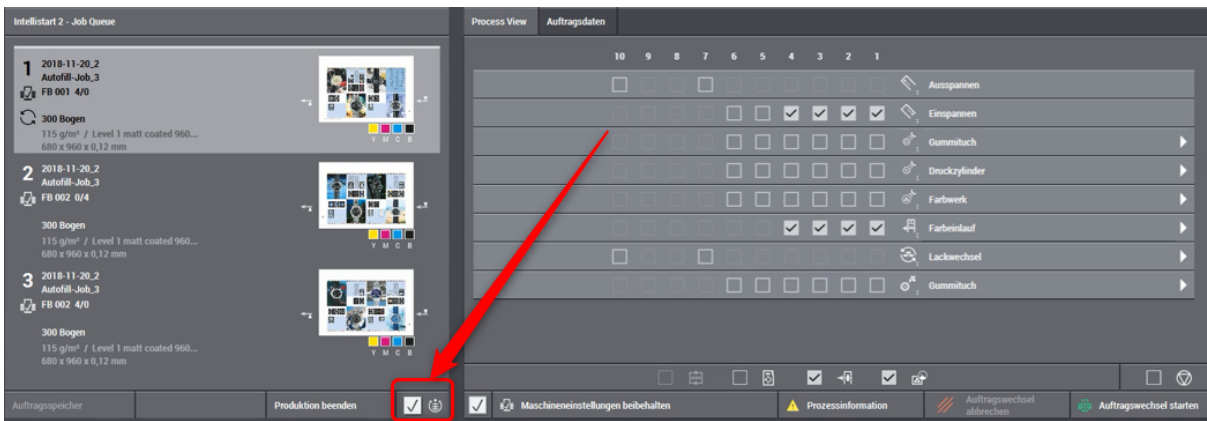
When a customer is using the Scheduler we should automatically load the planned operations into the Intellistart queue.

Description

When the customer is using the Scheduler or the Machine Widget for scheduling press operations, we can use "Autofill" at the PressCenter.

"Autofill" will automatically load scheduled press operations into the "Intellstart" queue

- minimum for 15 minutes or
- minimum 3 operations



Note: "Autofill" is an disabled option (variant key and configuration setting) at the Press-Center, which can be enabled by Press Service globalsupport.applications@heidelberg.com Before using "Autofill" we strongly recommend to contact the Sheetfed Product Management SF-PM-3, Nick.Trabold@heidelberg.com. A Training will be done onside at the customer.

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Revision 1.0

Version 2020

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