Digital Flexo Suite for Labels

6.1

USER MANUAL
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1 Introduction

LEN and TIF files are prepared for exposure on a CDI using the “Merge”. Several CDIs can be controlled via the network simultaneously.

The "merger" positions the images on the printing plate, whereby the images can also be rotated, mirrored, cut and inverted as required.

The "viewer" is used for viewing and measuring the Len/TIF files. The angle and the rasterization can also be measured.

2 System requirements

The PlatePrep computer must meet the following minimum requirements:

- Pentium 4 processor
- 2 GB RAM
- 100 GB hard drive for the data area
- Intel network board
- Screen resolution of 1024 x 768 pixels, true color
- CD ROM
- Microsoft Windows OS
- FTP server installed and activated
- Grapholas 5.5 MR2 Patch 6 on the CDI

The PlatePrep software requires Microsoft Windows as the operating system. We recommend Windows 2000 (at least SP2) or Windows XP Prof. 32-bit (at least SP1). Windows 2000 Server, Windows 2003 Server, Windows Vista and 64-bit systems may generally also be used.

The index and file names may not include special characters, umlauts or spaces. An underscore “_” is the only permitted special character and can be used as a substitute for a space.
3 Installation

After inserting the CD, the start screen is automatically displayed. If this screen is not displayed then start the "setup.bat" file in the root directory of the CD. Installation is started by "Install PlatePrep 6.0".

As the software may also be an update from a previous version, all PlatePrep programs such as the "Viewer", "Merger" and "Template Editor" must first be closed (if running). Confirm this with "OK".

In addition, a warning is shown in the event that there is not enough working memory or hard drive memory available.

Clicking on "Next" opens the license agreement screen that then guides you to the dialog window with user information (after confirming the agreement with "YES"). In this screen, you then only have to enter the "Product Id":

"Next" then moves you to the screen for entering the installation folder (the defaults are recommended) and after once more clicking on "Next" you are then prompted to enter the installation type ("PlatePrep"):
Another click on "Next" then moves you to the selection of the image viewer. Available choices are the "LenViewer", which was already contained in older versions of PlatePrep and Grapholas, and the new "ScopeViewer":

"Tif mirror" mirrors TIF files horizontally so that these files can be displayed just like in previous versions of PlatePrep und Grapholas.

"Next" and "Finish" starts the copy procedure into the selected installation folder.
The installation places the "Boot Grapholas Hardware" program into the "Autostart" folder and the "Merge", "View" and "Template Editor" programs into the "PlatePrep" start folder.

3.1 First start-up of Merge

The service for PlatePrep is automatically started after the user login:

In case of Windows XP SP2, the following programs must be allowed to run with "Unblock":

- gravurd -
- cmotsim -
The state of the service is shown in the Windows taskbar:

- ![Service started]
- ![Service stopped]
- ![Service error]

The service can be started or stopped manually by clicking with the right mouse button on the "Start services" and "Stop services" icon respectively.

### 3.2 Entering the license key

There is no license when you first start the merger. Licenses from versions lower than Version 6.0 MR1 are invalid:

A "ProductID" is displayed after clicking twice on "OK".

The ESKO-Service issues a serial number for this "ProductID"; this serial number is then entered in the "Serial Number" field and confirmed by ENTER.
4 FTP server installation

4.1 Windows 2000 / XP / 2003 Server

In most cases, installing an FTP server requires the installation of additional components. These are installed as administrator with "Add/Remove Programs" in the Windows "Control Panel" using the "Add/Remove Windows Components" function.

In case of Windows 2003 Server, "Application Server" must first be selected and then "Details".

Components can be selected by clicking on "Internet Information Services (IIS)" and "Details", selecting "File Transfer Protocol (FTP) Service" and then confirming with "OK".

The FTP server components are now installed and must be configured.
Calling up the "Internet Information Services" under "Administrative Tools" in the "Control Panel" displays the following screen in which the "Default FTP Site" must be selected.

Under **Windows 2000**, the "Computer Management" is called-up from the "Administrative Tools" in the "Control Panel" and you should then click twice on "Internet Information Service". The "Default FTP Site" is selected.

Virtual Directory Creation Wizard

Welcome to the Virtual Directory Creation Wizard

This wizard will help you create a new Virtual Directory on this FTP site.

Click Next to continue.
A drive can now be released for the FTP access via "Action" – "New" – "Virtual Directory".

"Next" moves you to the entry for "Alias". Here, the drive and the "Path" on which the "FILES" directory has been created must be entered, as indicated in the following figures.

The "Access Permissions" must be set to "Read" and "Write".

The configuration is completed by "Next".
4.2 Windows VISTA

Control Panel

Programs

Turn Windows features on or off

FTP Management Console / FTP Server

Control Panel

System and Maintenance
Digital Flexo Suite for Labels 6.1

Administrative Tools

IIS6 Manager

Default FTP Site

Action / New / Virtual Directory ...

Next

"D" - Next
d:\  -  Next

Virtual Directory Creation Wizard

FTP Site Content Directory
Where is the content you want to publish on the FTP site?

Path: d:\

Virtual Directory Access Permissions
Set the access permissions for this virtual directory.

Allow the following permissions:
- Read
- Write

To complete the wizard, click Next.

Finish

You have successfully completed the Virtual Directory Creation Wizard.

To close this wizard, click Finish.
4.3 Setting the firewall in Windows XP SP2

The firewall in Windows XP with Service Pack 2 blocks the FTP server that is required for the FTP connection to the CDI.

In the "Control Panel", open the "Windows Firewall" and in the "Advanced" section, mark the network that communicates with the CDI:

"FTP Server" is activated under "Settings" and then the setting is accepted by clicking on "OK" twice.
5 Merger

5.1 What’s new in Merger?

- Addition of images through automatic arrangement
- Removal of all images from workspace
- Optional automatic rotation of images during automatic arrangement
- Modules can be switched on and off
- The behavior during loading of images (copying or moving) can now be determined under "Edit Properties" - "Merge".
- Output path for job information can be configured in HTML file
- Drag & Drop of LEN, TIF and .CDI files in the Merger

5.2 Registering CDIs

One or more CDIs can be connected via the network by the menu item "Options" - "Edit Host List".

"New" activates the "Host" field in which the IP address or the network name of the corresponding CDI is registered. With ENTER the CDI will be searched in the network.

"Test" established the connection to the CDI.

After successful connection to the CDI and pressing "OK", this is then displayed under "Host".

If the connection fails then the IP address or the access rights in the ".host.perm" file on the CDI must be checked. Appropriate instructions are contained in the Grapholas 5.5 documentation of the CDI.

The PlatePrep computer is already entered with IP 127.0.0.1. This is required to transfer data to old CDIs using a SUN computer and for the working environment without CDIs. This entry can be deleted as necessary using "Remove".
5.3 Network configuration

The image data can be loaded from the local hard drive, by means of a network release, or by FTP. Transmission using FTP protocol is generally more secure than using a network release.

The path entered during installation for the "User Data" is already released as a network drive. To setup additional drives, run the "guinet.bat" program in the c:\bsl\ui directory:

Clicking on "Drive" in the field displays drives that have already been registered. If you select a drive then the access data that have been entered are then displayed. The selected drive can also be deleted or changed.

After clicking on "New", the local drive letter on this drive is shown under "Disk" and the subdirectory is shown under "Sub directory". The name of this drive link is entered in the "Drive Name" field. The merger later accesses the drive via this name.

In case of an FTP connection, the "FTP" option is activated and the IP number or the computer name of the FTP server is entered under "Host". The user name and password must be entered accordingly. Also here, a name for his link must be indicated under "Drive Name".

The connection can be selected by the "Test" button in order to test the user data using FTP. A new window - "Load Image" – opens:

"OK" cancels the test and accepts the selected directory.

"Cancel" closes this window without making changes to the path.

The entered data are accepted by "Accept". "Quit" closes the drive configuration. If changes have been made then these are stored with "OK".
5.4 Quick start

After starting the merger, load the required images via "Load Image" and select the required CDI via "Options" – "Select machine".

The plate list is automatically read out and displayed in the "Drum Window" under "Type". If the "Drum Window" can not be found then this can be made visible in the "Windows" menu item.

The engraving parameters are set by clicking once on the required plate. If there is a yellow icon in front of the plate then the laser energy parameters are automatically set for the corresponding resolution as soon as an image is positioned on the working surface.

After positioning the images on the working surface, the job is sent to the CDI by "Start" and the appropriate job name.
5.5 The merger

The merger on the PlatePrep works independently of the exposer on the CDI. Before positioning the images on the working surface, the CDI is contacted via the network to prompt for details of the drum circumference and the engraving parameters. After compiling and selecting the plate type, the data is transferred to the CDI in the exposer via FTP protocol.

The following figure shows the surface of the merger with four images already loaded and two positioned:
5.6 The surface (GUI)

1. "File": Load and store data – set working directory
   "Options": Change CDI – change defaults - templates
   "Window": Display drum window – change display mode of images
   "Help": Version number of the merger

2. Loaded LEN or TIF files – positioned images are highlighted in grey.

3. Work surface with positioned images. The entire surface in dark grey is the plate to be exposed.
   Clicking with the right mouse button on an image displays the information and a click with the right mouse button on the work surface displays additional information on the job.
   Depending on the CDI used, green and red strips are displayed indicating the level of productivity (green=100% - red=less than 100%). Images should be placed on top of each other and not intertwined, as in the Figure to the right.

4. To facilitate better positioning, a frame can be pulled from the frame area over the work surface using the left mouse button (hold pressed and pull). This frame can be reset by right-clicking in the frame area.

5. A click of the right mouse button on the work surface shows the use of the plate as a percentage and in cm².

6. "Start" transmits the compiled images in the exposure of the selected CDI.

7. Cutting an image manually

   The image can be cut using the mouse (as shown to the right) either using the naked eye or by entering the coordinates with the width and height of the image.
   Alternatively, you can switch over to entry of the absolute coordinates with "Coord". These are related to the left lower edge.
   The original state is reestablished with "Reset".
Cutting an image automatically. Border areas without information are removed.

Start the image viewer (Len Viewer or Scope Viewer) using the marked image.

Horizontal mirroring. The marked image is mirrored and stored with the "xmir" extension.

Vertical mirroring. The marked image is mirrored and stored with the "ymir" extension.

Inverting the image for film output. The marked image is inverted and stored with the "inv" extension.

90° rotation of the marked image. The actual rotation is only carried out after sending the job to the CDI by pressing "START".

5.7 "File" menu

"Load Image"
Calls up a file dialog box in which the LEN or TIF files can be selected.
Several files can be marked simultaneously by pressing the "Control" button or the CAPS button together with the left mouse button.
A drive is released by selecting ①.

Additionally, directories can be created and files can be deleted ②.
If a file is loaded a multiple number of times then this file already exists in the working directory. A dialog box is displayed. "OK" overwrites the file – "Cancel" cancels the copy procedure.

"Unload image"
The marked image is deleted in the merger (not on the data medium).

"Remove all positioned images"
All images positioned on the work area are removed.

"Select work dir"
All files are copied or moved to the work directory for further processing. The work directory can be selected here. This option is not available if images are loaded.

"Load Plate" – "New Plate" - "Save Plate" - "Save Plate as"
The compilation of the images on the work surface and the engraving parameters can be stored as a plate and re-loaded All images are removed in case of a new plate.

"Engrave Plate"
Has the same function as “Start” – the compilation is sent to the CDI.

"Calculate Plate"
The current compilation is calculated and stored for later processing at the CDI, but not yet transmitted.

"Engrave stored Plate"
A previously stored compilation can be directly sent to the CDI using this option.

The jobs that have been sent last can be directly reloaded underneath "Quit".
5.8 "Options" menu

"Edit Properties"
Open a new window in which the defaults for the merger can be changed.

"History depth:" determines the number of the previously sent jobs; these are listed for faster access under "Quit".

"Language" sets the language and "Units" switches between "mm" and "inch".

"Digits" and "Post colon" set the number of numbers or decimal points

"Lock circumference" blocks entry of the drum circumference in order to avoid unintentionally changing it.

"Check Images before start" checks the images of all outgoing jobs.

"Autoplacement mode:" sets the method (mode) of how the images are automatically arranged on the work surface. "Permutation", "Random", "Sorted" and 'MDB' can be selected as mode. MDB arranges the images in such a way that they can be easily cut later.

"Auto Rotate" activates the rotation of up to 7 images during automatic positioning. The selection of these images is via the aspect ratio using "Rotate Level".

"File copy method" sets the behavior while loading images. With the setting "Copy", the files are always copied, if "Move" is selected, they are deleted from the source directory.

"HTM Target Dir" determines the target directory for the job information (Chapter 7.7).
„Edit Properties“ - „Plugin Selection“

This is where the modules that were activated with the license can be switched on and off.

"Auto arrange images"
All loaded images are automatically positioned on the work surface.

"Auto arrange new images"
All those images not yet positioned are placed automatically on the working surface.

"Unplace all"
All images are removed from the working surface but not unloaded.

"Print Job Info" - “Print Display"
All relevant information on this job or on the work surface with the positioned images is printed.

"Select machine" - "Edit Host List"
The CDI must be selected before a job can be sent. If the drum circumference deviates from the previously selected CDI then the work surface is re-constructed accordingly and a message window is displayed showing the new circumference. Additional CDIs can be entered, or already existing CDIs can be changed, via "Edit Host List".

"Check Image"
The marked image is checked for file errors.

"Save Template" - "Use Template" - “Edit Template"
Templates store fixed sizes and positions for later positioning of images on the work surface. For additional information, refer to the "Templates" chapter.

"Copy FTP files(s)"
Using this function, LEN or TIF files can be copied from a drive link into the work directory. The files are not loaded into the merger.

"Zip Manager"
This is mainly used by the service department for solving any problems that might arise. In these cases, the log file or the configuration can be zipped into a file.

"View Logfile"
All sent jobs including their most important parameters can be listed by this.
5.9 "Windows" menu

"Show Images as .."
Selecting "Images" displays the content of the images in the merger, whereby only wildcards are entered by "Tiles".

"Display names"
The file names are displayed in the images positioned on the work surface.

"Drum Window"
If the "Drum Window" is not visible then it is displayed by this option.

5.10 "Drum Window" – job parameters

This window is required for every job as all required parameters such as performance, plate thickness, etc. must be set here.

"Drum"
"Circumference" sets the drum circumference. Unintentional changing of this parameter results in faulty plates. It is advisable that the field for the circumference be blocked by "Edit Properties" (Chapter 6.3).

"Speed" and "Laser power" directly influence the exposure on the CDI and automatically set based on the plate list. The speed can be subsequently changed.

"Superskip" shortens the exposure time as zones without data are skipped over.

"Plate"
The drum of the selected CDI is automatically set based on the drum circumference using the "Plate Sizes" setting. If only a part of a plate is to be exposed then "Free Format" should be set.

"Height" and "Width" are the heights and widths of the plate to be exposed.
"Type"

The plate type is selected here. The "Thickness" is important here. The exposure parameters and the plate thickness are stored in this list.

The yellow point is front of the name of the plate symbolizes control via the laser energy. The exposure parameters are automatically set according to the resolution of the image.

"Plate list editor"

"Edit Plate List" opens a new window in which a new plate can be stored by "New". "Name" determines the display names in the plate list and "Thickness" determines the thickness of the plates.

You can either set the "Speed" and "Laser power" or the "Laser Energy" by clicking on "Energy".

"Accept" accepts the set parameters. "Quit" closes the window.

The plate list can not be processed while the selected CDI is exposing a plate. After adding a new plate, the exposcer on the CDI must be restarted.

"Frame"

"Start (circ)" and "Stop (circ)" determine the upper and lower borders in mm. In case of a CDI with a terminal strip, this should be set to 20mm.

"Start (acr.)" and "Stop (acr.)" set the border to the left or the right.

"Image distance" places a border around each positioned image. "Insert cut marks" inserts cut marks for each image.
"Label"
A label is added to each marked image by "Use Label".
"Vertical" positions this label rotated by 90° at the left side of the image.
"Font" sets the font size.

"Image File"
One of the loaded images can be selected in "Actual Image".
"X Position" and "Y Position" change the position of this image. Positioning is carried out by "Set Position".
If you activate "Overlay" then the images can also be placed over each other.

The raster count and the angle of the image can be entered by "Linecount..." if the image does not already contain this information. Images without this information are marked in red on the work surface. "Testform" marks test wedges if these are not to be sent to the customer.
If these two fields are highlighted in grey then they are irrelevant for the selected CDI.

"Repeat"
"Repeat" sets the number of vertical repetitions with "around" and horizontal repetitions with "Across" for the marked image. "Gap" additionally adds a gap between each repetition.
"Seamless" and "Drop" are only available in the gapless exposure.
5.11 Templates

A template is a "mask" in which the positions, image sizes and plate parameters are stored in order to position images quickly at a later time. This working mode is interesting for register pinwheels such as, e.g. for Letterpress.

To create a template, you first position the required images onto the work area and then select the plate type.

This compilation is then saved by "Options" and "Save Template".

**IMPORTANT:**
The positioned images must NOT be cut or rotated in the merger.

The template is loaded by "Options" - "Use Template".

The stored positions and sizes are shown as yellow fields.

The images must be reloaded and then positioned in the yellow fields.

The images must be within a certain size tolerance in order to be assigned to a field.

This tolerance can be changed by a technician with "guiprop.bat".
5.11.1 Editing templates

The "Template-Editor" can subsequently change the positions in the template. It exists as a link in the start menu. The template must be previously loaded:

The position of single images or of several images can be changed horizontally by "Across" and vertically by "Circumference". The value is entered absolute or relative to the current position, ENTER is then pressed and the value is set by "Set Position".

Several images are marked by pulling a square around the required images with the left mouse button pressed.

The template is stored by clicking on the "Save" button.
5.12 Job information

An HTML file with job number is created in the respective work directory for each sent job:

![Job Information](image)

"Job" contains the "Job name", the date and the exposure parameters.

"Plate" shows the selected plate, the "Total used" amount of the plate and the surface not used, "Wastage".

"Images" provides information on the placed images including the "Width" and "Height" in mm and the "Area" in cm².

"Net used" is the exposed area in cm².
5.13 Loading images via „Drag & Drop“

„Drag & Drop“ is used frequently in Windows, and means that an object can be dragged to a different position while keeping the left mouse button pressed. When the left mouse button is released, the object is dropped.

Image files (LEN and TIF) and stored plates (CDI) can now be dragged into the Merger from the Windows Explorer. The files are first copied into the working directory and then shown on the right side. If the Ctrl key is pressed simultaneously, the files are always copied.
6  ScreenView

LEN and TIF files can be displayed any measured using the Screenview. An image is loaded via "File" – "Load Image":

1. The display can be changed here in order to view partial areas or the whole image.

2. The areas previously shown can be called up again here using the left arrow. The right arrow returns you to the previous screen.

3. The display is inverted, rotates and both horizontally and vertically mirrored here.
If the image is greatly enlarged then a grid can be placed over it.

This button activates the measuring function described in Item 6.

If "Control" is pressed together with the left mouse button then a line is drawn from this point in order to measure the image. The values are shown in "Display Panel" (Item 7).

All values relevant to the image such as the grid (raster) and angle information are displayed in "Display Panel" (if this info already exists in the LEN file). The current position of the mouse pointer in the image shows "Pos x / y". The measured values can be found in "Diff x / y".

6.1 "File" menu

"Load Image"
Load LEN or TIF files. Several separations for a job can be loaded by "Control".

"Add"
Separations can be added to the already loaded image.

"Compare"
The already loaded image is compared to another image with the same size and resolution. The differences are shown in red.

"Save Viewport"
The current image detail is stored as a new LEN file. The new file name is displayed.

"ColorChooser"
If several separations are loaded for one image then the color can be changed here.
The separation is selected by "File". The color can be selected by RGB "RGB Color Code", by clicking on the color button or by using the color selection list "Select Color".

"Print"
The first separation is printed. The print resolution can be selected.
"Print Viewport"
The current display is printed with all colors. The print resolution can be selected.

"Quit"
The ScreenView is completed.

6.2 "Options" menu

<table>
<thead>
<tr>
<th>Options</th>
</tr>
</thead>
<tbody>
<tr>
<td>✓ mm</td>
</tr>
<tr>
<td>inch</td>
</tr>
<tr>
<td>Enable print properties</td>
</tr>
<tr>
<td>✓ Maximize Viewport</td>
</tr>
</tbody>
</table>

"mm / inch"
Switch-over between metric and imperial display system.

"Enable print properties"
If the selection of the resolution has been deactivated when printing then it can be reactivated by this option.

"Maximize Viewport"
The selected image detail is adjusted to the ScreenView window.

6.3 Measuring the grid and angle

After a measuring function has been activated (Item 5), you click on a grid point by pressing "Control" and clicking on the left mouse button. In the required direction, the screen ruling is displayed by "LPI" and the angle in degrees on clicking with the right mouse button on the 11th grid point.
6.4 Displaying a job with all separations

As described in Chapter 7.1, a multi-color job is loaded. The colors can be assigned using the "ColorChooser".

Single separations can be shown and hidden in "Display Panel" by clicking on the color. Color assignment is displayed as a percentage in front of the color.

7 XL-CUT

The composition of several images is sent via the network to the CDI as one job. The position, the size of the images and additional information is made available on the Kongsberg table in the form of an ACM file.

7.1 What’s new in XL-CUT?

- Optional manual input of labeling for backsides
- Optional output of 4 positioning marks (marks on both sides)
- Output path for Kongsberg file (ACM) can be configured
- Distance between cutting lines can be adjusted (Save Distance)
- Cutting cap in the corners can be set (Cut Gap)
- Knife can be set to 45° angle
- Positioning marks can be selected
- XL-CUT can be switched off

### 7.2 Basic settings

After installation, XL-CUT has to be adjusted to the Kongsberg table. An output directory is also required for the ACM file.

The options can be called up after starting the Merger under "Options" – "Edit Properties" in the submenu "Kongsberg Table":

"Text Channel"

If the Kongsberg table has a pen for labelling the plate, it can be assigned a channel number. Channels 0-15 are available. If there is no pen, the channel should be deactivated with "Disabled".

"Text Width / Height / alignment"

The width and height of the lettering for later labelling of the plate can be changed. The text on the plate can be positioned within the image in the centre ("Center"), at the top ("Top") or at the bottom ("Bottom").
"Reserved Area"

An area (yellow) on the left-hand (and optionally the right-hand) edge ("Marks on both sides") on the working surface in the Merger is reserved for lettering and position markers for later alignment on the plate.

This reserved area can optionally be displayed at the top or bottom if "Align Vertical" is deactivated.

"Corner X – Corner Y"

If the edges are to be cut at an angle, the parameters for X and Y have to be specified (see sketch on the right).

"Text Line Mode"

If the text is wider than the image which is to be labelled, you can specify here whether the text is to be distributed over multiple lines ("Multiple Lines") or cut: Right ("Cut Right"), left ("Cut Left") or centre ("Cut Center").

"Mirror Plot-Text" / "Text as Barcode" / "Vertical Text"
The lettering can be output as a mirror image ("Mirror"), vertically ("Vertical") or as a barcode. The barcode output by the Kongsberg is very large. A maximum of 4 characters per image should therefore be used. **The text comprises the file names but can be subsequently changed in the Merger.**

"Align Vertical"
The reserved area is shown on the left and right of the working area in the Merger if this option is activated. If deactivated, it is shown at the top and bottom.

"Marks on both sides"
Optionally, the reserved area can also be displayed on the right and at the top.

"Translate Space"
The image labelling is extracted from the film name. If this function is active, underscores "_" are converted into spaces " ".

"Mirror X" / "Mirror Y"
The coordinates of the cut on the X axis and/or the Y axis can be mirrored depending on the alignment on the Kongsberg table.

"Kongsberg Target Path"
The output directory for the ACM file can be changed here using the "Browse" button. If no directory is specified, the file is copied to the working directory.

"Landscape"
In order to cut e.g. a 4260" plate on a XL20 Kongsberg table, it must be rotated by 90° before mounting it. The options "Vertical" and "Y-Mirror" are deactivated. In this case, the yellow reserved area is always on the bottom and optionally on the top.

"Knife Type"
If the 45° knife is used instead of the standard knife "Vertical", this must be set to "45°", as the distance between the cutting lines changes with plate thickness.

"Safe Distance"
In order to avoid double cuts, the distance between the cutting lines can be specified.
Cut Gap
In order to avoid parts of the plate coming loose during cutting, a base area that cannot be cut can be selected in the corners.

Register Mark
The positioning marks for the later alignment on the Kongsberg table can be selected from a list.

<table>
<thead>
<tr>
<th>Name</th>
<th>Size</th>
<th>Line thickness</th>
</tr>
</thead>
<tbody>
<tr>
<td>reg_2501</td>
<td>2,5mm x 2,5mm</td>
<td>1mm</td>
</tr>
<tr>
<td>reg_502</td>
<td>5mm x 5mm</td>
<td>2mm</td>
</tr>
<tr>
<td>reg_503</td>
<td>5mm x 5mm</td>
<td>3mm</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Name</th>
<th>Size</th>
<th>Line thickness</th>
</tr>
</thead>
<tbody>
<tr>
<td>reg_502_c</td>
<td>5mm x 5mm</td>
<td>2mm</td>
</tr>
<tr>
<td>reg_503_c</td>
<td>5mm x 5mm</td>
<td>3mm</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Name</th>
<th>Size</th>
<th>Diameter</th>
</tr>
</thead>
<tbody>
<tr>
<td>reg_5005_h</td>
<td>5mm x 5mm</td>
<td>0,5 mm</td>
</tr>
<tr>
<td>reg_5010_h</td>
<td>5mm x 5mm</td>
<td>1 mm</td>
</tr>
<tr>
<td>reg_5015_h</td>
<td>5mm x 5mm</td>
<td>1,5 mm</td>
</tr>
<tr>
<td>reg_5020_h</td>
<td>5mm x 5mm</td>
<td>2 mm</td>
</tr>
</tbody>
</table>
7.3 Options in the Merger

Once an image has been placed (1), you can click on the image with "shift + the right-hand mouse button" to change the lettering(2). This is useful, above all, for the use of a bar code. Because of the size of the bar code, a maximum of 4 characters are recommended.

When “Start !” is pressed, the right-hand reserved area is automatically moved to the right-hand edge of the used area to save plate material. This is not displayed in the Merger.

The reserved area can be switched on and off using the "XL-CUT" button (3). When switched off, no yellow area is visible and no ACM file is generated for the Kongsberg table.

7.4 Recommended settings in XL-CUT

The plate can be set up on the Kongsberg table more easily with vertically arranged positional markers ("Align Vertical"). This option is available with XL-Guide version 0632 and above. For older versions, this option and the option “Landscape” must be deactivated.

For small plate pieces a "Cut Gap" of 1 mm is recommended so that the plate pieces are not triggered automatically. The marks "reg_502_c" and "reg_503_c" are suited for positioning using the laser pointer on the Kongsberg table.
The Kongsberg file is generated automatically after each transmission to the CDI or each time a TIF file is generated in the output directory. The cutting settings on the Kongsberg table are made fixedly with the basic settings.

The following settings do not depend on the type of knife.

7.4.1 Cutting from the top

7.4.2 Cutting from the top (90° rotated)
7.4.3 Cutting from the back

7.4.4 Cutting from the back (90° rotated)
7.5 Kongsberg XL-Guide 0632

The software description applies to version 0632.

7.5.1 Basic settings

To achieve the ideal cut, the options "Sequencing", "Optimize tool use" and "Measure at laserpointer" should be activated in the "Options - System option…" system menu.

The knives can be set in "Job setup" in the "Options" menu. The active knife has to be set to channel 2, the pen for labelling the back has to be set to the channel selected in the merger (default=3).

The speed and the acceleration must be determined at the location.

Before using the "BevelKnife" (45° knife), the option "Single cut" must be activated in "Job setup" under "Extended setup …" as the step will otherwise not be performed.
7.5.2 Importing the ACM file

Double click the ACM file generated by the merger and it will be automatically loaded to the working surface on XL-Guide (1):

The plate has to be positioned using the register wizard. To do so, switch 2 and then the option "Register Wizard" (3) are activated. The "Scale" has to be deactivated (4).

IMPORTANT: The X and Y start position (5) must not be changed.

From version 0632 and upwards, a new symbol (6) is available which can be used to set the alignment of the register marks. If the recommended vertical alignment of register marks has been set, this has to be set in the "Register mark positions" dialogue as displayed.
7.6 Aligning the plate on the Kongsberg table

After the basic settings have been made in the merger and in the XL-Guide, the plate is always put in place with the same alignment. X designates the roll width, Y designates the roll circumference. With the option “Landscape”, the plate is rotated by 90°.

The positioning marks are ALWAYS on the operator's side, except for cases in which the alignment “Vertical” + “Landscape” has been deactivated.

If the option "X-Mirror" (X) or "Y-Mirror" (Y) for back labelling has been selected in the merger, the plate has to be rotated accordingly.

After the ACM file has been imported and the register wizard has been activated, the setup of the plate can be started with the 1 button on the Kongsberg operating panel. Move to the centre of mark No. 1 with the laser pointer. Press the 1 button again to move automatically to mark No. 2.

This position is corrected with the laser pointer and the cutting procedure is started by pressing the 1 button.
8 Hotfolder

LEN and TIF files are loaded into the Merger automatically from a pre-defined directory. Positioning on the working surface and transmission to the CDI is performed manually.

8.1 What’s new in Hotfolder?

- By selecting the option “Grapholas Image” as the “Input File Type”, LEN and TIF files are processed.

8.2 Setting up the Hotfolder

Before using the Hotfolder for the first time, it has to be set up using the “Hotfolder” programme (Windows start menu - PlatePrep - Tools):

- **Directories**
  - **Identification**: The designation for the Hotfolder specified here is displayed later on in the Merger.
  - **Hotfolder directory**: A directory from which the LEN or TIF files are loaded, has to be selected using the “Browse” button.
  - **Working Dir**: All the files are copied from the Hotfolder automatically into a working directory which has to be selected here using the “Browse” button.

- **Result Directory**: Optionally, you can define a subdirectory in the working directory. The files transmitted to the CDI are then saved in this subdirectory.

- **Style**
  - **Input File Type**: With “Grapholas Image” you can choose only LEN, only TIF or both file types.
8.3 Working with the Hotfolder in the Merger

The Hotfolder is active after the Merger is started. Files are loaded automatically and lined up on the right:

The Hotfolder must be deactivated by clicking on the Hotfolder icon, before the loaded images can be positioned on the work space:
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