

Variable Data - Production Workflow Piece Sequencing Process

HOW TO USE THIS TOOL:

1. Read 'THINGS TO KNOW' section
2. Refer to predefined examples on back of this page. If your job matches those steps, that is the OPTION your job needs to follow.
 - a. If your job does not match those steps, follow steps 3-7 below or contact the quality manager or a production manager.
3. Refer below to the PRINT section to identify what printing device will be used to apply the variable content.
 - a. In the provided Work Area column, mark this as Step #1. Always begin the process choosing OPTION1 for the appropriate device.
4. Refer to the FINISH section to identify what other production activities will have to be performed on the job AFTER the variable content has been applied to the piece.
 - a. In the provided Work Area columns, mark those steps #2, #3, etc.
5. Using the supplied PURPLE variable printed example pieces, simulate the production steps in the order that they will be performed.
 - a. Refer to the chart to determine how the pallet of material should arrive as well as how it goes in and out of the equipment in relationship to sequence order and address block orientation (for that OPTION)
 - b. Refer to the chart to determine whether the equipment feeds the material from the top or bottom (for that OPTION).
 - c. Refer to the chart to determine whether the equipment will reverse the sequence order or not (for that OPTION).
 - d. Refer to the chart to determine if skid flips are required in the process (for that OPTION)
6. Prior to the very last step in the production process, if your variable printed example pieces are in the order that that step requires, you have determined the option that should be used.
7. If it is NOT in the order that that step requires, choose the next choice available for that printing device and repeat step #5 - 7 using the GOLD colored variable printed example pieces.
 - a. If you are unsure, contact the quality manager or a production manager to walk through the steps with you.

THINGS TO KNOW:

OPTION #1 (DEFAULT):

DP designs piece with address block on **page 1** and outputs records in NORMAL - Low to High sequence.
PDF RESULT: Address block on **page 1** (odd), sequence #1 first on the file.

OPTION #2:

DP designs piece with address block on **page 2** and outputs records in NORMAL - Low to High sequence.
PDF RESULT: Address block on **page 2** (even), sequence #1 first on the file.

OPTION #3:

DP designs piece with address block on **page 2** and outputs records in REVERSE - High to Low sequence.
PDF RESULT: Address block on **page 1** (odd), sequence #999 first on the file.

OPTION #4:

DP designs piece with address block on **page 1** and outputs records in REVERSE - High to Low sequence.
PDF RESULT: Address block on **page 2** (even), sequence #999 first on the file.

IMPORTANT NOTE: When reversing the sequence, it will be done PER FILE so that print operators can print the files in normal order.

Non-required skid flips should be avoided when possible

PRINT	Variable data is applied to piece		Equipment type	DEFAULT Data read/write capabilities	Goes In to equipment:		Comes out of equipment:			WORK AREA
					Address side top or bottom	How material is fed	Address side top or bottom	Same seq order	Reverses seq order	
	OPTIONS 1 or 3	Indigo (Large or Small) (Simplex or Duplex)	First to Last Even Up (page 2)	bottom	top	bottom	x *first record in file on bottom of pallet			
	OPTIONS 2 or 4	Indigo (Large or Small) (Simplex or Duplex)	First to Last Even Up (page 2)	top	top	top		x *first record in file on bottom of pallet		
	OPTIONS 1 or 3	Variable Web (Simplex or Duplex)	First to Last Even Up (page 2)	bottom	top	bottom (inside of roll)	x *first record in file is on inside of roll			
	OPTIONS 2 or 4	Variable Web (Simplex or Duplex)	First to Last Even Up (page 2)	top	top	top (outside of roll)		x *first record in file is on inside of roll		
	OPTION 1	Laser (Simplex or Duplex)	First to Last Odd up (page 1)	top	top	bottom	x *first record in file on bottom of pallet			
	OPTION 2	Laser (Duplex only)	First to Last Odd up (page 1)	bottom	top	top		x *first record in file on bottom of pallet		
	OPTION 3	Inkjet	First to Last Odd up	top	bottom	top		x *low seq on bottom of pallet / back of tray		
					Goes In to equipment:		Comes out of equipment:			
FINISH	Piece remains flat	Equipment type	How material should arrive on skid	Address side top or bottom	How material is fed	Address side top or bottom	Same seq order	Reverses seq order	WORK AREA	
		BP/SP 629/640 Coating	Whatever side is being coated should be on top	Whatever side is being coated should be on top	top	same as received		x (each side)		
		BP Offline Coating	Whatever side is being coated should be on bottom Req skid flip	Whatever side is being coated should be on top	top	opposite of how received		x (each side)		
		Laminator	either should be opposite of diecut if applicable Req skid flip	either should mirror diecut if applicable	top	opposite of how received		x		
		DieCut	depends on art and purpose of Die	depends on art and purpose of Die	top	same as received		x		
		Cut	either Req skid flip	either	top	opposite of how received	x			
		Variable Web Finishing	either depends on next steps	either depends on next steps	outside of roll is on top	same as received		x		
		Auto-sorter/bander	Bottom *Needs low seq# on bottom of stack Req skid flip	Top **Needs low seq# on top of stack ## markings on 1st record of bundle/tray	bottom	top	x			
	Sitma	Top *Needs low seq# on top of stack Req skid flin	Bottom *Needs low seq# on bottom of stack	bottom	top	x				
	Piece transforms	FMS - converter	Top *Needs low seq# on top of stack Req skid flip	Bottom *Needs low seq# on bottom of stack	bottom	outside of piece	Depends on transformation			
		Folder	Bottom *Needs low seq# on bottom of stack Req skid flip	Top *Needs low seq# on top of stack	top	outside of piece	Depends on transformation			
		Stitcher	Top *Needs low seq# on top of stack Req skid flip	Bottom *Needs low seq# on bottom of stack	bottom	outside of book	Depends on transformation			
		Horizon Digital Stitcher	Top *Needs low seq# on top of stack	Top *Needs low seq# on top of stack	top	outside of book	Depends on transformation			
		Perfect Binder(SP) ...and GFS (vendor)	Bottom *Needs low seq# on top of stack	Bottom *Needs low seq# on top of stack	Top	outside of book	Depends on transformation			
Insertter			either	bottom	outside of piece	Depends on transformation				

Variable Data - Production Workflow Piece Sequencing Examples

FINISHING PROCESSES								Skid Flip Req	PRINTING PROCESSES	
Finish Flat					Finish Transformed				INDIGO or LASER	vWEB & FINISH
629/640 coat	BP UV Coater	Laminate	Diecut	Cut	Fold or Auto-sorter	Convert or Stitch	Perfect Bind		Option	Option
				X					1	2 - final cut inline 3 - final cut offline
		X	X ^{AFD}		X				4	2
		X	X ^{AFU}		X			*	1	3
			X ^{AFU}		X			*	2	4
1 side**			X ^{AFU}		X			*	4	2
2 sides			X ^{AFU}		X			*	3	1
	1 side**		X ^{AFU}		X			*	1	3
	2 sides		X ^{AFU}		X			*	2	4
			X ^{AFU}	X	X				2	4 - final cut offline
1 side**			X ^{AFU}	X	X				4	2 - final cut offline
2 sides			X ^{AFU}	X	X				3	1 - final cut offline
	1 side**		X ^{AFU}	X	X				1	3 - final cut offline
	2 sides		X ^{AFU}	X	X				2	4 - final cut offline
				X	X				4	3 - final cut inline 2 - final cut offline
1 side**				X	X				2	4 - final cut offline
2 sides				X	X				1	3 - final cut offline
	1 side**			X	X				3	1 - final cut offline
	2 sides			X	X				4	2 - final cut offline
			X ^{AFU}			X			2	4
1 side**			X ^{AFU}			X			4	2
2 sides			X ^{AFU}			X			3	1
	1 side**		X ^{AFU}			X			1	3
	2 sides		X ^{AFU}			X			2	4
			X ^{AFU}	X		X		*	2	4 - final cut offline
1 side**			X ^{AFU}	X		X		*	4	2 - final cut offline
2 sides			X ^{AFU}	X		X		*	3	1 - final cut offline
	1 side**		X ^{AFU}	X		X		*	1	3 - final cut offline
	2 sides		X ^{AFU}	X		X		*	2	4 - final cut offline
				X		X			1	2 - final cut inline 3 - final cut offline
1 side**				X		X		*	2	4- final cut offline
2 sides				X		X			4	2- final cut offline
	1 side**			X		X		*	3	1- final cut offline
	2 sides			X		X			1	3- final cut offline
			X ^{AFU}	X			X		4	2- final cut offline
1 side**			X ^{AFU}	X			X		2	4- final cut offline
2 sides			X ^{AFU}	X			X		1	3- final cut offline
	1 side**		X ^{AFU}	X			X		3	1- final cut offline
	2 sides		X ^{AFU}	X			X		4	2- final cut offline
				X			X		2	1 - final cut inline 4 - final cut offline
1 side**				X			X		4	2- final cut offline
2 sides				X			X		3	1- final cut offline
	1 side**			X			X		1	3- final cut offline
	2 sides			X			X		2	4- final cut offline

** Address face up to coat (DEFAULT)

X^{AFU} With address side face up (DEFAULT)

X^{AFD} With address side face down (RARE)