

# Printed Literature Parallel Glued / Parallel Folded Estimating Procedure

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Everything is the same for PG and PF as for RG/CF folds (right angle folds) until we get to the layout screen. The following steps must be performed to accurately generate an Estimate and Factory Ticket:

## Determine Grain / Layout on Press

1. Determine the grain direction on flat unit / blank and # up required on folder to maximize running efficiencies
  - a. General rule of thumb is the grain is preferred with the flat unit Width or **Xgrain = B** in the **Layout** screen in Estimate
  - b. If this is a bad layout due the desired number wide thru the folder or waste on the press, grain in flat unit Length is acceptable for most folds when using  $\leq$  #40 offset paper – See PL Management if unsure of proper layout (Randy Sutton / Jason Burgess)
  - c. See Attachment “A” for illustration for determining proper grain
  - d. PG styles (glued parallel folds) are limited to maximum of 9” sheet width (more than one up unit/blank) through the MV Section (applies glue, makes final fold and slits sheet to unit/blanks)
  - e. PF styles (not glued) are limited to maximum of 13” sheet width through station I/II fold sections

## XGrain = B

1. Start Estimate with correct PF / PG fold style (i.e. – PF8) which is a simple calculation, Flat unit/blank Length divided by Folded/Finished Length
  - a. In Estimate, **Specs tab**, Auto-calculate to determine the Flat Unit / Blank size
  - b. If the Flat Unit Size Auto-Calculates differently than the specified size adjust the flat size to match customer specification by Auto-Calculating again and adding or subtracting the difference in the appropriate field
    - i. If the Flat Unit Length is longer than the specified size, enter the difference in the “Tuck” field
    - ii. If the Flat Unit Length is shorter than the specified size, enter the difference in the “Lock Tab” field
2. In the **Layout** chose Auto-Calculate
  - a. Chose **XGrain = B**
  - b. Adjust the **Die Size “# On:” Width** and **Length** field according to required die / press layout (see Attachment “A” and Attachment “B”)
  - c. Unit / Blank width will be **Length** in the “# On” fields
  - d. Unit / Blank length will be **Width** in the “# On” fields
3. In the **Prep/Route Build** routing as usual
  - a. **Override “Out”** column field for machine 500 to be the # of sheets to be sent to machine 401P (see Attachment “A” – press sheet was 12 up and will be trimmed by 500)

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to 4 out going to next process = machine 401P or 1,000,000 units/12 up on press = 83,333 sheets to 500 \* 4 out = 333,333 sheets to machine 401P)

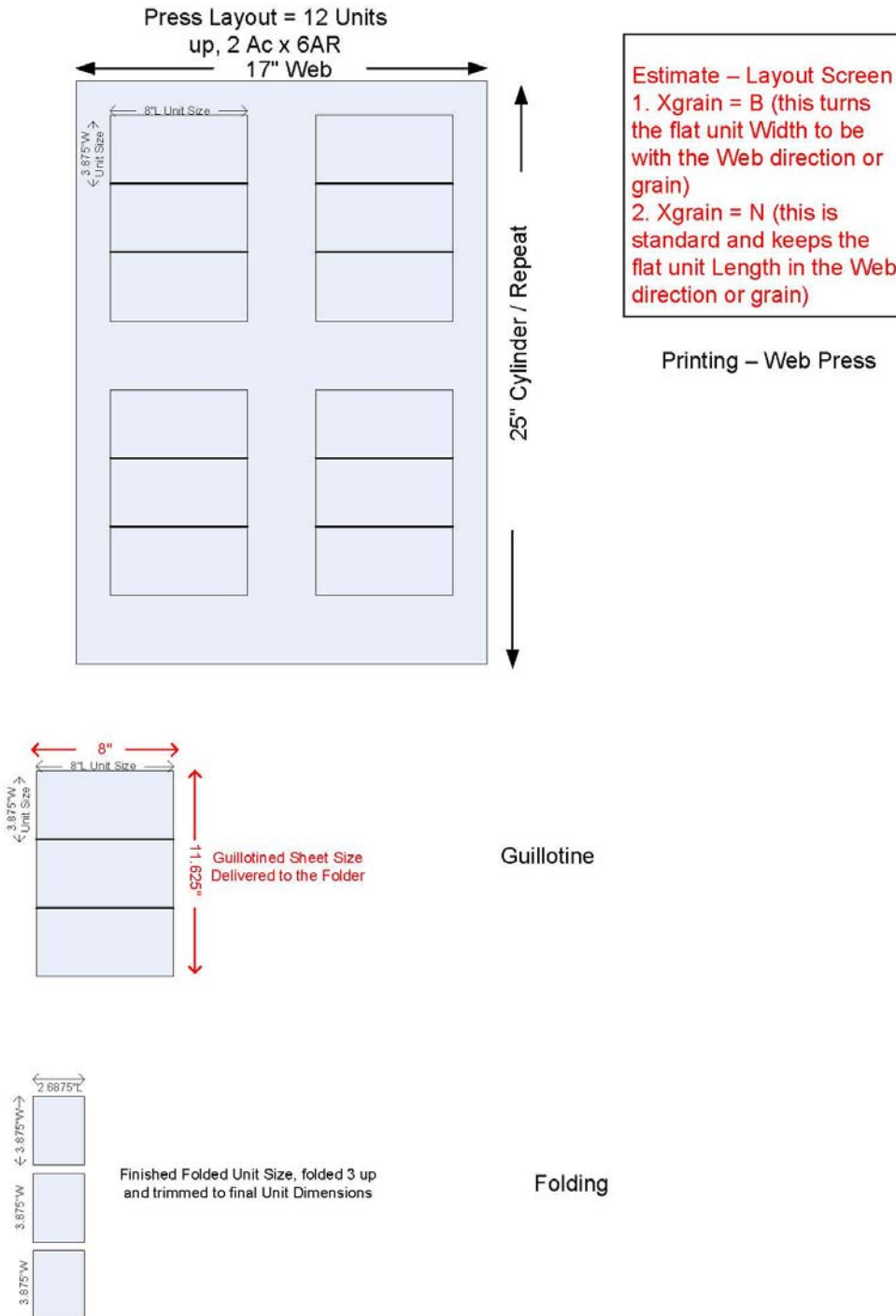
- b. **Override “Out”** column field for machine 401P to be the # of units/blanks on a sheet being feed into machine 401P (this is solely for the purposes of driving the correct **(Units/Shts UPS:** and the **Units Flat** information on Factory Ticket – see Attachment “D”)

## XGrain = N

1. Start Estimate same as described in XGrain = B scenario
2. In the **Layout** chose Auto-Calculate
  - a. Chose **XGrain = N**
  - b. Adjust the **Die Size “# On:” Width** and **Length** field according to required die / press layout (*Finished Folded Unit Length remains Length and Width remains Width in the Die Size “# On:” fields*)
  - c. Unit / Blank width will be **Width** in the “# On” fields
  - d. Unit / Blank length will be **Length** in the “# On” fields
3. In the **Prep/Route Build** routing as usual
  - a. **Override “Out”** column field for machine 500 to be the # of sheets to be sent to machine 401P same as in scenario XGrain = B
  - b. **Override “Out”** column field for machine 401P to be the # of units/blanks on a sheet being feed into machine 401P – same as in scenario XGrain = B

# Printed Literature Parallel Glued / Parallel Folded Estimating Procedure

Example of Printed Literature Job that requires multiple up Units processed through finishing equipment (Folders), Estimate Layout is Xgrain – “B”



## Attachment “A”

# Printed Literature Parallel Glued / Parallel Folded Estimating Procedure

**OE Estimate - Folding**

File Help

Notes Exist for Selected Record

Brws Est Estimate Specs Layout Inks/Pack Prep/Route Misc/Sub Box Design Print Quote Farm

Reference Information

Estimate #: 64158 Est Date: 04/19/2010 FORM: 1 of 1 Cust Part #: PF "B" GRAIN

Machine: 300 6C Diddle Side-Side: 17.0000 Front-Back: 23.2500 Xgrain: B

Board: W7017SEXN 70lb. Exact Natural Real: R

Caliper: 0.00480 Cost/MSF 0.000 Wt: 21.00 Freight/CWT 0.000 NC: C

	Width	Length	Sq. Inches	Width	Length	Total Up	Die Inches
<input checked="" type="checkbox"/> Roll	17.0000						
Gross Sheet:	17.0000	25.0000	#Out: 1			Cuts: 0	
Mach Feed:	16.5000	23.2500	#Out: 1				
Die Size:	16.0000	23.2500	# On: 2	6		= 12	0
Blank:	3.875	8.000	31.000				

Leaf/Film	Description	S / B	Width	Length
			0.0000	0.0000
			0.0000	0.0000
			0.0000	0.0000
			0.0000	0.0000

Save Cancel Auto-Calc Bom Leaf/Film Goto Sheet Calc Job Stds Copy

Enter Number of Blanks on Length.

Attachment "B"

# Printed Literature Parallel Glued / Parallel Folded Estimating Procedure

**OE Estimate - Folding**

File Help

Notes Exist for Selected Record

ADD

Brws Est Estimate Specs Layout Inks/Pack Prep/Route Misc/Sub Box Design Print Quote Farm

Reference Information

Estimate #: 64158 Est Date: 04/19/2010 Frm: 1 of 1 Blk: 1 of 1 Cust Part #: PF "B" GRAIN

**Preparation**

Sht #	B #	Code	Qty	Desc.	Cost	M/L	SIMON	Markup	Amort
1		PLATE	4.0	PRINTING PLATE	175.00	M	S	0.00	100.00
1		REPEA	4.0	REPEAT PLATE CHARGE	15.00	M	I	0.00	100.00

Update  
Reset  
Add  
Copy  
Delete  
Cancel  
Job Stds

Estimate Run Qty  
1,000,000

Update  
Reset  
Add  
Copy  
Delete  
Cancel

**Operations**

S	B	Machine	Desc	Out	MR-Hrs.	Waste	Speed	Spoil%	MRCrew	RunCrew	MRate
1	20		PLATE MAKING	0	1.33	0	0	0.00	1.00	0.00	78.88
1	300		6C Didge	0	2.00	1000	18000	1.00	1.00	1.00	61.88
1	500		Polar 115-EMC Cutter	4	0.75	250	1500	1.00	1.00	1.00	31.59
1	401P		Parallel Fld.	3	5.00	2500	8000	2.50	1.00	1.00	47.21
1	1600		Banding	0	0.50	250	20000	0.60	1.00	1.00	30.00

Add  
Add Stds  
Import  
Override  
Build  
Delete  
coPy  
Cancel

Sorted By:

Attachment "C"

# Printed Literature Parallel Glued / Parallel Folded Estimating Procedure

JOB NUMBER: **P19357-00** NEW **F A C T O R Y T I C K E T** JOB START DATE:

Customer Name: 3 C Packaging Acct Code: COL1000 SHIP DATE: QTY DUE: PO#: Customer Lot#: Estimate: Print Date:  
 Shipto: 3 C PACKAGING 05/20/10 1,000,000 XGrain=B FT 64158 04/20/2010  
 1000 CCC DR. 0 XGrain=B FT  
 QC/SPCH: 0 XGrain=B FT  
 0 XGrain=B FT  
 CLAYTON, NC 27520

## P R E S S

F/B	FG Item #	Description	Order Qty	MAX QTY	MIN QTY
1-1	PF "B" Grain	RUSSIA INSERT -	1,000,000	1100000	900000

STOCK CODE	DESCRIPTION	WEIGHT	WIDTH	CYLINDER	DIE SIZE	DIE#	PRINT QTY	PRINT FEET		
W7017.OExN	70lb. Exact Nat	6,219	17	25.0000	16x23.25	NAS 028	100,333	209,027.08		
PASS	SIDE	LBS	INK NAME	UNIT#	PASS	SIDE	LBS	INK NAME	UNIT#	PLATE #
1	B	37.32	PMS 1807	1	1	F	0.00	PMS 1807	3	
1	B	37.32	PMS 476	2	1	F	0.00	PMS 476	4	
UNIT SIZE: 8 x 3.875				#UP :12	Speed(FPM)		MR			
#AC:2 8					21,000		2.00			
#AR:6 3.875										

## F I N I S H I N G

UNIT SIZE	Packaging	Size	Units Per	QTY Trays Per case	Speed(UPH)	Case wt	Style
Flat	Finished Tray#Layer Pad	0x0x0	40	27500 160	8,000	28.80	PF3
8 x 11.625	2.6875 x 3.875						
	case#C6348	16x11.5x7.75	6400	172 Act A	Sample On ctn N		
Units/Shts UPS: 3	Pallet 4048GMPP				Shrink wrap no		

## DEPARTMENT INSTRUCTION NOTES

PLATE&DIE: NEED NEW LAYOUT. STRUCTURE #CC6348A. LAYOUT NUMBER NAS 028. THIS JOB IS 2 PASS ON CARTON PRINTER. PRINTS HEAD TO HEAD  
 FOLDING: FLAT UNIT SIZE = 3.875 X 8  
 FOLDING TOLERANCE +/- 1/32. MUST FOLD 3 UP. TRIM 3/8" FROM OUTSIDE LINES.  
 CUTS MUST BE CLEAN.  
 GUILLOTINE TRIM SHEETS: NUMBER UP: 3 TRIM SIZE IS 8 X 11.625

Attachment "D"