Printed Literature Parallel Glued / Parallel Folded Estimating Procedure

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 ≤ #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

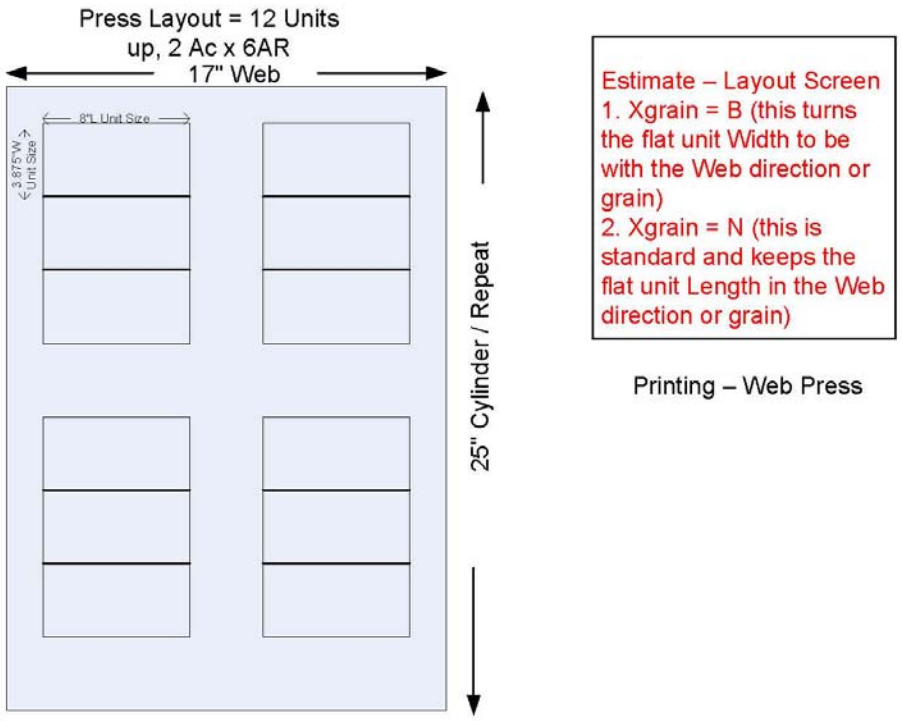
to 4 out going to next process = machine 401P or 1,000,000 units/12 up on press = 83,333 sheets to 500 * 4 out = 333,333 sheets to machine 401P)

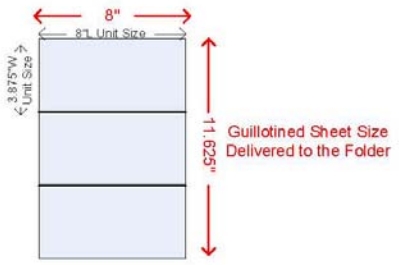
b. **Override "Out"** column field for machine 401P to be the # of units/blanks on a sheet being feed into machine 401P (this is solely for the purposes of driving the correct (**Units/Shts UPS:** and the **Units Flat** information on Factory Ticket – see Attachment "D")

XGrain = N

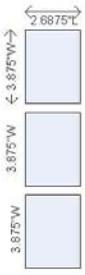
1. Start Estimate same as described in XGrain = B scenario
2. In the **Layout** chose Auto-Calculate
   a. Chose **XGrain = N**
   b. Adjust the **Die Size "# On:"** **Width** and **Length** field according to required die / press layout *(Finished Folded Unit Length remains Length and Width remains 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

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





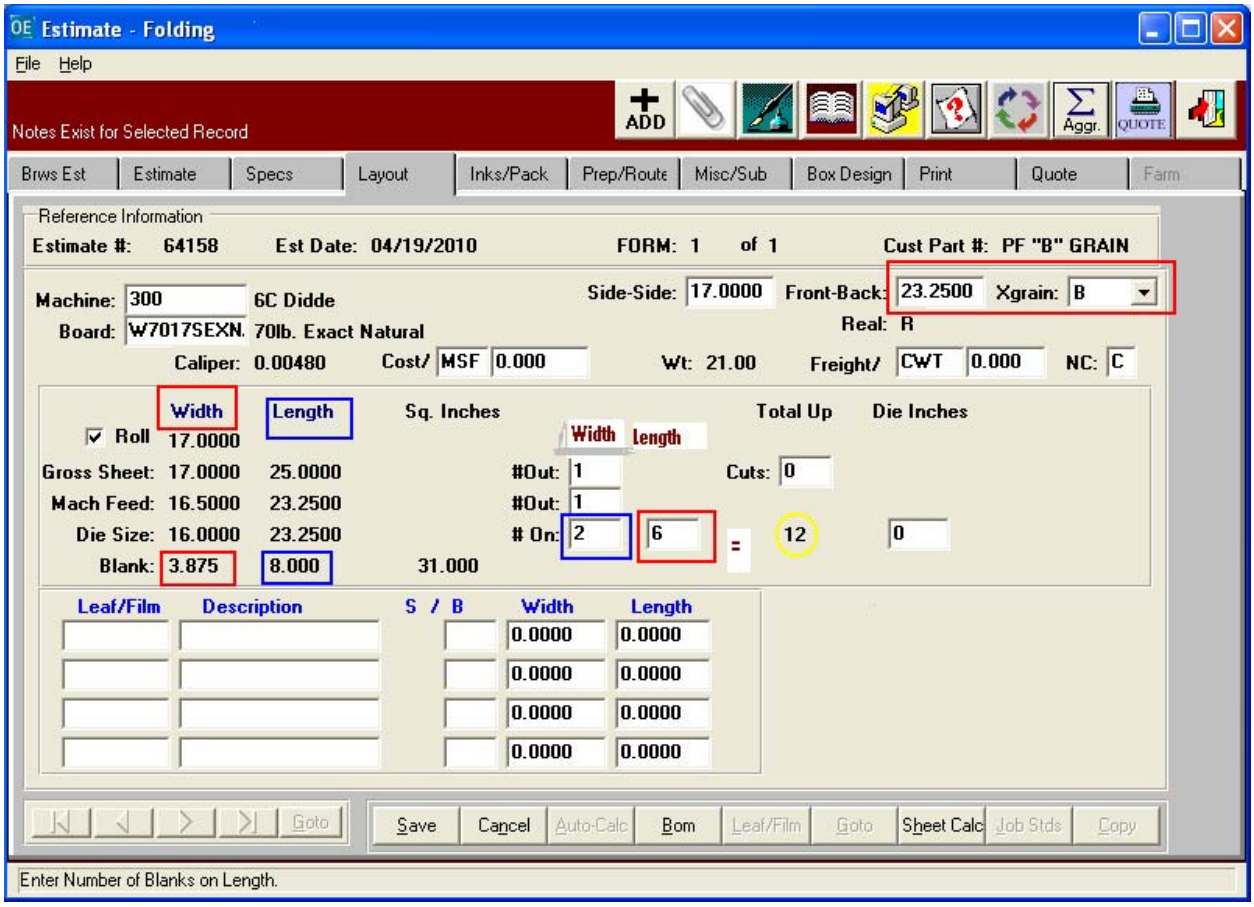
Guillotine



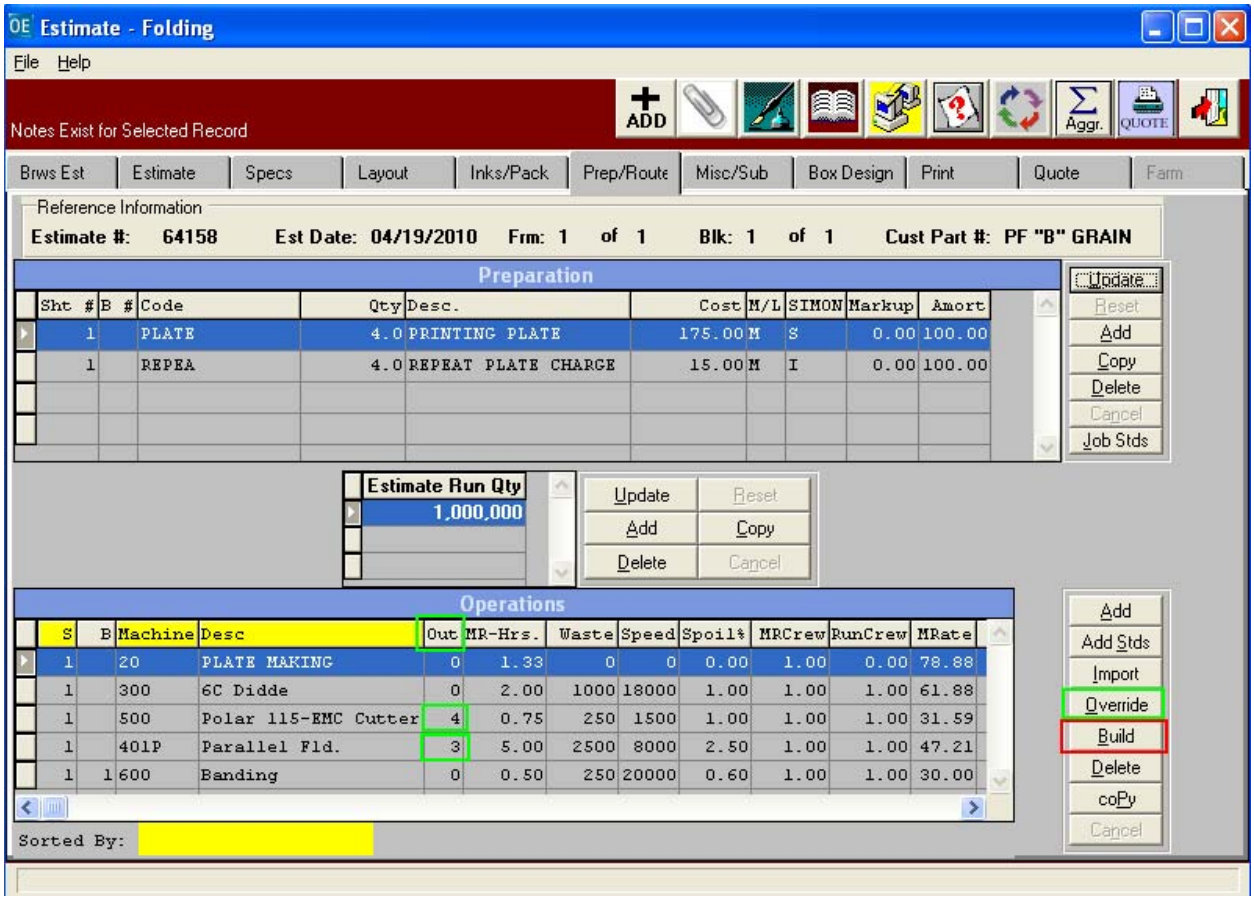
Finished Folded Unit Size, folded 3 up and trimmed to final Unit Dimensions

Folding

Attachment "A"



Attachment "B"



Attachment "C"

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/SPC#:						
			0	XGrain=B FT			
CLAYTON, NC 27520			0	XGrain=B FT			

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
W7017.0ExN	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"