

Xerox[®] FreeFlow[®] Core

EasyStart Workflows

Quick Guide



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ESv4-01 Preflight & Print

This workflow automates routine checks on incoming files.



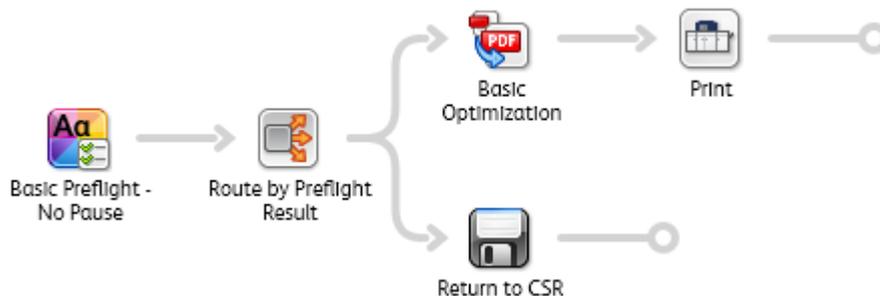
- Preflight ensures that image resolution is acceptable and that fonts are embedded in the document.
 - If a job fails preflight, FreeFlow® Core pauses the job before it is submitted to the printer.
 - If notification is enabled, FreeFlow® Core sends an email indicating preflight failed.
 - The user may then search for the job by Job ID  included in the notification email.
 - The user may review the preflight report. Every object that triggered a preflight warning or error is highlighted with an annotation. The annotation includes details indicating why the specific object triggered a preflight warning or error.
 - Finally, the user may cancel or resume the job.
- Jobs that pass preflight are automatically submitted to the selected printer.

Workflow Benefits

This Easy Start workflow shows a simple workflow to offload routine and repetitive tasks to FreeFlow® Core. Jobs are automatically inspected and those requiring attention are automatically identified and retained. If notification is enabled, selected users receive notification emails thus eliminating the need to actively monitor FreeFlow® Core job processing.

ESv4-02 Preflight, Optimize & Print

This workflow automates routine checks on incoming files and optimizes documents to remove potentially problematic content.



- Preflight ensures that image resolution is acceptable and fonts are embedded in the document
- If a job fails preflight and notification is enabled, FreeFlow® Core sends an email indicating preflight failed.
- After Preflight, jobs are Routed based on the Preflight Results.
 - If there are no Preflight warnings or errors, the job is routed to Optimize.
 - If there are Preflight warnings or error the job is saved to a predefined location. The FreeFlow® Core Job ID is added to the job name. This Job ID is included in the notification emails.
- Optimize downsamples images whose resolution is too high and remove non-print content such as PDF annotations and actions, hidden layers and content outside of the defined PDF box.
- FreeFlow® Core pauses jobs before submitting them to the printer. The operator has the option to review the Optimized job before releasing it to the printer.
 - The operator also has the ability to select the destination printer and edit the print ticket before resuming the job.

Workflow Benefits

This EasyStart workflow shows a simple workflow to offload routine and repetitive tasks to FreeFlow® Core. Jobs are automatically inspected and those requiring attention are returned to a predefined location. If notification is enabled, selected users receive notification emails thus eliminating the need to actively monitor FreeFlow® Core job processing. Jobs that pass preflight are optimized to create a more streamlined PDF.

The ability to route jobs based on the preflight results provides a flexible means for automating preflight checks and corrections as well as decisions about post-preflight job processing.

ESv4-03 Business Cards

This workflow demonstrates how the FreeFlow® Core approach to prepress makes automation simpler to implement and simpler to sustain.



- Preflight ensures that image resolution is acceptable and that fonts are embedded in the document.
 - See ESv4-01 Preflight & Print
- Imposition uses the incoming PDF bleed box to define the imposed trim size. With clustering enabled, all document pages are abutted in the layout. Trim marks are placed around the PDF trim box.
 - If the document does not have a bleed, PDF bleed and trim boxes are the same size and the document is imposed without gutters.
 - If the document has a bleed, the PDF bleed box is larger than the trim box and the document is imposed with a gutter that is based on the size difference between the bleed and trim boxes in the PDF.
 - Imposition uses Automatic orientation and Auto Rows and Columns. The imposed document orientation is automatically selected to maximize the number of rows and columns in the imposed document.
- Imposed documents are automatically submitted to the selected printer.
 - The print quantity is adjusted to ensure the requested number of business cards is printed.
 - The updated quantity is based on the number of rows and columns calculated during imposition.

Workflow Benefits

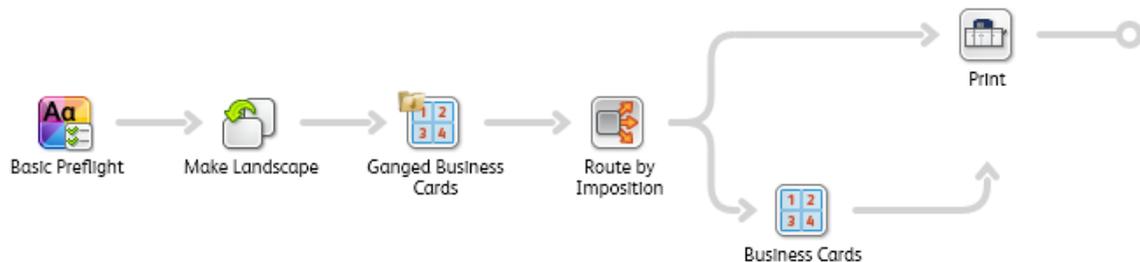
The Preflight, Business Cards and Print presets are shared with other workflows. The ability to share presets between workflows minimizes the total configuration that must be implemented and managed as part of enabling prepress automation.

This workflow highlights how FreeFlow® Core imposition helps simplify prepress automation. Instead of having multiple workflows or imposition templates for each type of business card, a single workflow uses a single imposition preset to impose landscape and portrait business cards with and without bleed.

FreeFlow® Core components are built to handle job variability. This simplifies implementation and sustainability of prepress automation.

ESv4-04 Ganged Business Cards

This workflow demonstrates how FreeFlow® Core automates not just imposition but also the decisions about how a given job should be imposed.



- Preflight ensures that image resolution is acceptable and that fonts are embedded in the document.
 - See ESv4-01 Preflight & Print.
- Rotate ensures all business cards are the same orientation.
- Ganged Business Card Imposition
 - Job Group Imposition is enabled when the Collect Job Documents option is enabled on the imposition preset within the workflow.
 - Imposition is performed in two stages:
 - On the Primary Stage, each business card is placed on media that's 19" x Automatic.
 - The resultant layout has as many business cards as fit on the 19" width. The height of the document is based on the number of rows plus gutter and margin distances. Since the number of rows is Automatic, FreeFlow® Core defaults to a single row.
 - The print quantity is adjusted once the number of business cards in the layout is determined.
 - On the Secondary (and final) Stage, Job Group Imposition modifies Cut & Stack behavior to place each business card in a different place in the layout on a 13 x 19 sheet.
- The resultant layout repeats the same business card horizontally but has different cards vertically to enable finishing in a sheet-fed cutter creaser table.
 - Business Cards that do not fill an entire layout pass through unimposed.
- After imposition jobs are routed based on whether they were imposed or not:
 - If a job was imposed, it is routed to Print.
 - If a job was not imposed, it is routed to the Business Cards imposition preset used in the previous business card easy start workflow.
- Imposed documents, with properly updated print quantities, are automatically submitted to the selected printer.

Workflow Benefits

The Preflight, Business Cards and Print presets are shared with other workflows. The ability to share presets between workflows minimizes the total configuration that must be implemented and managed as part of enabling prepress automation.

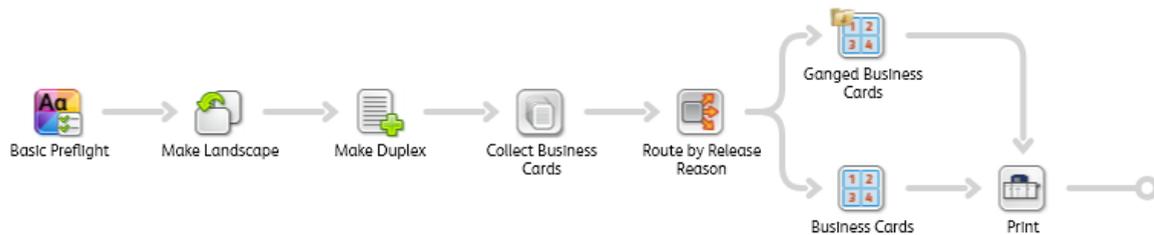
This workflow highlights how FreeFlow® Core automates both job processing and decisions about how jobs should be processed. Instead of having workflows for ganged and single business cards, a single workflow uses job group imposition to automatically gang up as many business cards as possible. The imposition places each business card in its own place in the layout – enabling ganging of simplex and duplex business cards. The remaining business cards are imposed as separate jobs. The only requirement is submission of all business cards as a single job.

Since FreeFlow® Core components are built to handle job variability, this workflow also imposes cards of any size – as long as all cards are the same dimensions.

FreeFlow® Core automates both prepress operations and the decisions about what prepress operations are applicable to a given job. This workflow also shows how a single workflow is able to automatically vary job preparation based on the most optimal scenario for a given job.

ESv4-05 Auto-Ganged Business Cards

This workflow automates both the decisions about whether jobs should be ganged or not and the collection of unrelated jobs into a Job Group for automated job ganging.



- Preflight ensures that image resolution is acceptable and that fonts are embedded in the document.
 - See ESv4-01 Preflight & Print.
- Rotate ensures all business cards are the same orientation.
- Collect pauses any jobs that reach it. When jobs are released they are released as a job group. Jobs are released based on the following conditions:
 - Jobs are released once 6 jobs are paused. These jobs are routed to the Ganged Business Cards imposition preset.
 - Jobs are released one they have been held for 1 minute. These jobs are routed to the Business Cards imposition preset.
- Route looks at the release condition used to resume job processing and submits the job to the correct imposition template.
- Jobs routed to the Ganged Business Card imposition:
 - Job Group Imposition is enabled when the Collect Job Document option is enabled on the imposition preset within the workflow.
 - Imposition is performed in two stages:
 - On the Primary Stage, each business card is placed on media that's 19" x Automatic.
 - The resultant layout has as many business cards as fit on the 19" width. The height of the document is based on the number of rows plus gutter and margin distances. Since the number of rows is Automatic, FreeFlow® Core defaults to a single row.
 - The print quantity is adjusted once the number of business cards in the layout is determined.
 - On the Secondary (and final) Stage, Job Group Imposition modifies Cut & Stack behavior to place each business card in a different place in the layout on a 13 x 19 sheet.
 - The resultant layout repeats the same business card horizontally but has different cards vertically to enable finishing in a sheet-fed cutter creaser table.
 - The workflow ensures job groups that reach this preset contain exactly 6 jobs. As such, all jobs that reach this template are ganged up as expected.
- Jobs routed to the Business Cards imposition are imposed per the previous business card easy start workflow.
- Imposed documents, with properly updated print quantities, are automatically submitted to the selected printer.

Workflow Benefits

The Preflight, Business Cards and Print presets are shared with other workflows. The ability to share presets between workflows minimizes the total configuration that must be implemented and managed as part of enabling prepress automation.

This workflow highlights how FreeFlow® Core automates both job processing and decisions about how jobs should be processed. Instead of having workflows for ganged and single business cards, a single workflow uses job group imposition to automatically gang up as many business cards as possible. The imposition places each business card in its own place in the layout – enabling ganging of simplex and duplex business cards. The remaining business cards are imposed as separate jobs.

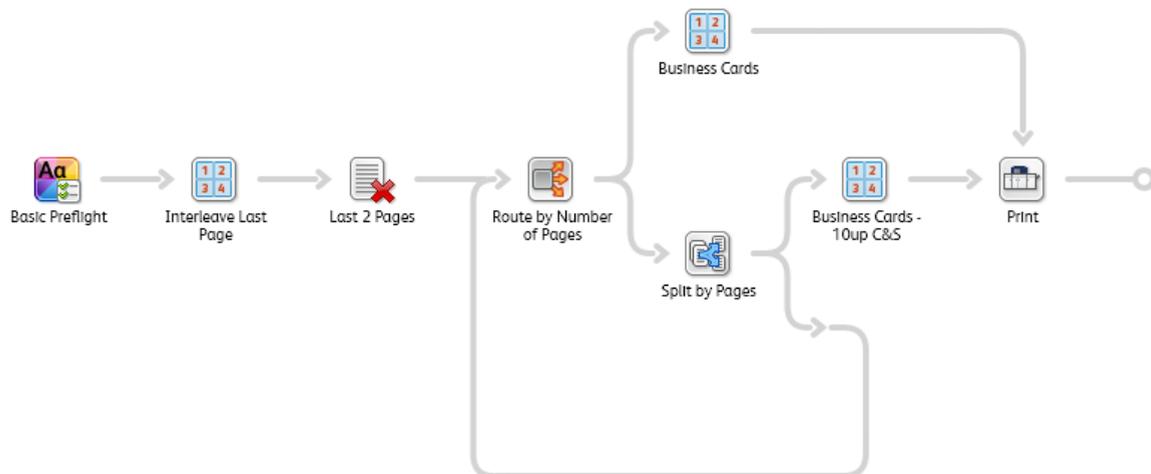
Incrementally, this workflow does not require the upstream system to know the jobs are being collected and ganged together. FreeFlow® Core accepts jobs as they are submitted. The Collect node is used to gather the jobs into Job Groups that are then submitted to imposition for ganging.

Alternatively, the Collect node can release jobs after a defined timeframe. Those jobs are imposed as separate jobs. This ensures the system does not wait indefinitely to fill a ganged layout.

By automating the aggregation of jobs this workflow shows how FreeFlow® Core can automatically streamline both printing and finishing operations. This workflow also shows how a single workflow is able to automatically vary job preparation based on the most optimal scenario for a given collection of jobs.

ESv4-06 Business Cards with Common Back

This workflow demonstrates flexibility in FreeFlow® Core by automating a job that would typically require manual prepress.



- Preflight ensures that image resolution is acceptable and that fonts are embedded in the document.
 - See ESv4-01 Preflight & Print.
- Imposition uses manual page order to define a pattern for placing the last page of the document as the back of all document pages. The output is 1-up business cards with bleed and trims marks.
- Delete removes the last two pages of the layout.
- The job is then routed based on the number of pages.
 - If the job has less than ten business cards it is routed to a 10-up repeated imposition template.
 - If the job has more than ten business cards it is routed to Split.
- Split creates a job with the first twenty pages and routes it to a ganged 10-up imposition template.
 - The remaining pages are returned to the routing node.
- The job remains in the loop until all pages in the document are dispatched to the proper imposition.
- Imposed documents are automatically submitted to the selected printer. If needed, the print quantity is adjusted to ensure the required number of business cards is produced.

Workflow Benefits

The Preflight, Business Cards and Print presets are shared with other workflows. The ability to share presets between workflows minimizes the total configuration that must be implemented and managed as part of enabling prepress automation.

This workflow highlights the flexibility in FreeFlow® Core by automating a job that would typically require manual prepress. This workflow can accept a document with an arbitrary number of business cards that all share a common back page. The workflow automatically creates as many ganged layouts as possible. The remaining business cards, if any, are imposed per the previous business card easy start workflow.

This workflow shows how a single workflow is able to automatically vary job preparation based on the most optimal scenario for a given job.

ESv4-07 Cards

This workflow demonstrates how the FreeFlow® Core approach to prepress makes automation simpler to implement and simpler to sustain.



- Preflight ensures that image resolution is acceptable and that fonts are embedded in the document.
 - See ESv4-01 Preflight & Print.
- Imposition uses the incoming PDF's bleed box to define the imposed trim size. With clustering enabled, all document pages are abutted in the layout. Trim marks are placed around the PDF trim box.
 - If the document does not have a bleed, PDF bleed and trim boxes are the same size and the document is imposed without gutters.
 - If the document has a bleed, PDF bleed box is larger than the trim box and the document is imposed with a gutter that is based on the size difference between the bleed and trim boxes in the PDF.
 - Imposition uses Automatic sheet size selection, Automatic orientation and Auto Rows and Columns. The imposed document size and orientation are automatically selected from the subset of sheet sizes specified in the imposition preset to minimize media waste.
- Imposed documents are automatically submitted to the selected printer.
 - The print quantity is adjusted to ensure the requested number of finished business cards. The updated quantity is based on the number of rows and columns calculated during imposition.

Workflow Benefits

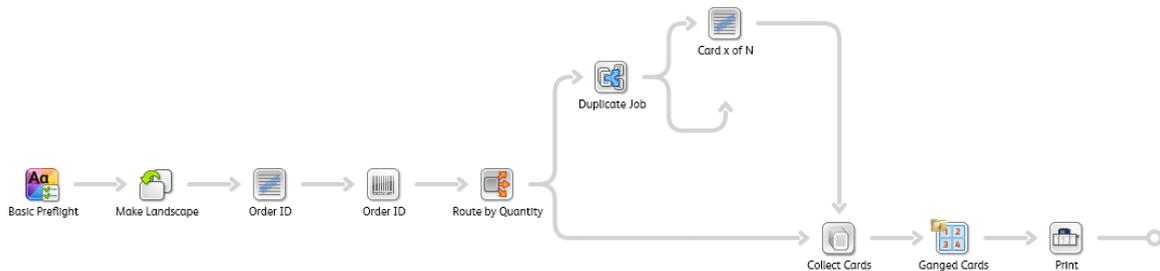
The Preflight and Print presets are shared with other workflows. The ability to share presets between workflows minimizes the total configuration that must be implemented and managed as part of enabling prepress automation.

This workflow highlights how FreeFlow® Core imposition helps simplify prepress automation. Instead of having multiple workflows or imposition presets for each type of card, a single workflow uses a single imposition preset to impose landscape and portrait cards with and without bleed on the most optimal press sheet size.

FreeFlow® Core components are built to handle job variability. This simplifies implementation and sustainability of prepress automation.

ESv4-08 Auto-Ganged Cards

This workflow automates the collection of unrelated jobs with multiple print quantities into a Job Group for automated job ganging.



- Preflight ensures that image resolution is acceptable and that fonts are embedded in the document.
 - See ESv4-01 Preflight & Print.
- Rotate ensures all business cards are the same orientation.
- Order ID Watermark and Barcode presets add the job's Order ID in the bleed area of the first page.
- Jobs are routed based on quantity.
 - Jobs with a quantity of 250 are route to the Split preset. Split makes two copies of the job and adjusts the quantity to 125 for each job. The Card x of N preset adds a watermark indicating that the job has been split into two jobs. Jobs are then sent to the Collect Cards preset.
 - Jobs with a quantity of 125 are sent to the Collect Cards preset.
- All jobs reaching Collect have a print quantity of 125. Collect pauses any jobs that reach it. Jobs are released as a job group once 10 jobs reach the Collect Cards preset.
- Job Group Imposition modifies Cut & Stack behavior to place each card in a different place in the layout on a 14.33 x 22 sheet
- Imposed documents are automatically submitted to the selected printer.

Workflow Benefits

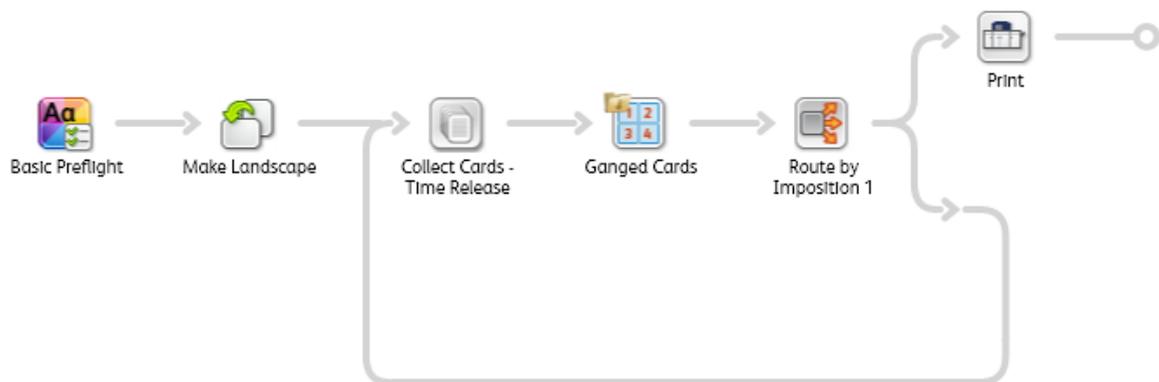
The Preflight, Make Landscape, Cards and Print presets are shared with other workflows. The ability to share presets between workflows minimizes the total configuration that must be implemented and managed as part of enabling prepress automation.

This workflow highlights how FreeFlow® Core automates both job processing and decisions about how jobs should be processed. FreeFlow® Core accepts jobs as they are submitted and automatically adjusts orientation and print quantity to enable ganged imposition. The imposition places each card in it's own place in the layout – enabling ganging of simplex and duplex cards.

By automating the aggregation of jobs this workflow shows how FreeFlow® Core can automatically streamline both printing and finishing operations.

ESv4-09 Auto-Ganged Cards with Overflow

This workflow automates the collection of unrelated jobs Job Groups for automated ganging.



- Preflight ensures that image resolution is acceptable and that fonts are embedded in the document.
 - See ESv4-01 Preflight & Print.
- Rotate ensures all business cards are the same orientation.
- Collect pauses any jobs that reach it. Jobs are released as a job group once jobs have been held for the defined period of time.
- Job Group Imposition modifies Cut & Stack behavior to place each card in a different place in the layout on a 14.33 x 22 sheet
 - Business Cards that do not fill an entire layout pass through unimposed.
- After imposition jobs are routed based on whether they were imposed or not.
 - If a job was imposed it is routed to Print.
 - If a job was not imposed it is routed back to the Collect Cards preset.

Workflow Benefits

The Preflight, Make Landscape, Ganged Cards and Print presets are shared with other workflows. The ability to share presets between workflows minimizes the total configuration that must be implemented and managed as part of enabling prepress automation.

This workflow highlights how FreeFlow® Core automates both job processing and decisions about how jobs should be processed. FreeFlow® Core accepts jobs as they are submitted and automatically adjusts orientation to enable ganged imposition. The imposition itself places each card in its own place in the layout – enabling ganging of simplex and duplex cards. The workflow uses job group imposition to automatically gang up as many cards as possible. The remaining cards are returned to the Collect Cards preset to away for additional cards.

By automating the aggregation of jobs this workflow shows how FreeFlow® Core can automatically streamline both printing and finishing operations.

ESv4-10 Booklets

This workflow demonstrates how the FreeFlow® Core approach to prepress makes automation simpler to implement and simpler to sustain.



- Preflight ensures that image resolution is acceptable and that fonts are embedded in the document.
 - See ESv4-01 Preflight & Print.
- Imposition uses the incoming PDF's bleed box to define the imposed trim size. Imposition also uses Automatic sheet size selection and automatic orientation to determine the most optimal sheet size for the job. Sheet size selection is constrained to the subset of sheet sizes specified in the imposition preset.
- Imposed documents are automatically submitted to the selected printer.

Workflow Benefits

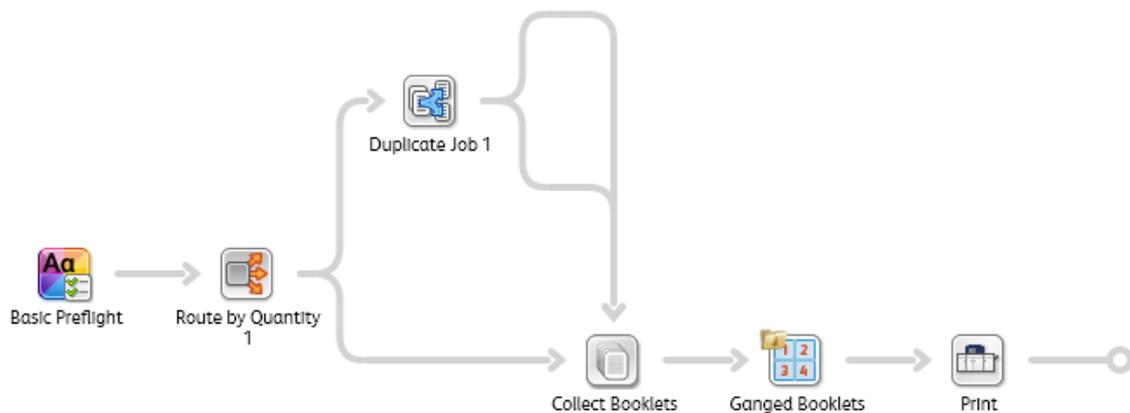
The Preflight and Print presets are shared with other workflows. The ability to share presets between workflows minimizes the total configuration that must be implemented and managed as part of enabling prepress automation.

This workflow highlights how FreeFlow® Core imposition helps simplify prepress automation. Instead of having multiple workflows or imposition presets for each type of booklet, a single workflow uses a single imposition preset to impose booklets with and without bleed on the most optimal press sheet size.

FreeFlow® Core components are built to handle job variability. This simplifies implementation and sustainability of prepress automation.

ESv4-11 Auto-Ganged Booklets

This workflow automates the collection of unrelated jobs with multiple print quantities into a Job Group for automated job ganging.



- Preflight ensures that image resolution is acceptable and that fonts are embedded in the document
 - See ESv4-01 Preflight & Print.
- Jobs are routed based on quantity.
 - Jobs with a quantity of 250 are route to the Split preset. Split makes two copies of the job and adjusts the quantity to 125 for each job. Jobs are then sent to the Collect Booklets preset.
 - Jobs with a quantity of 125 are sent to the Collect Booklets preset.
- All jobs reaching Collect have a print quantity of 125. Collect pauses any jobs that reach it. Jobs are released as a job group once 3 jobs reach the Collect Booklets preset.
- Job Group Imposition is enabled when the Collect Job Document option is enabled on the imposition preset within the workflow.
 - Imposition is performed in two stages:
 - On the Primary Stage, each booklet is imposed using the Automatic press sheet size.
 - The dimensions of the document are based on the PDF box used imposition plus gutter and margin distances.
 - On the Secondary (and final) Stage, Job Group Imposition modifies Cut & Stack behavior to place each booklet in a different place in the layout on a 14.33 x 26 sheet.
- Imposed documents are automatically submitted to the selected printer.

Workflow Benefits

The Preflight, Ganged Booklets and Print presets are shared with other workflows. The ability to share presets between workflows minimizes the total configuration that must be implemented and managed as part of enabling prepress automation.

This workflow highlights how FreeFlow® Core automates both job processing and decisions about how jobs should be processed. FreeFlow® Core accepts jobs as they are submitted and automatically adjusts print quantity to enable ganged imposition. The imposition itself places each booklet in its own place in the layout – enabling ganging of multiple booklets.

By automating the aggregation of jobs this workflow shows how FreeFlow® Core can automatically streamline both printing and finishing operations.

ESv4-12 Booklets with Leading Banner Page

This workflow demonstrates how to use Manifest Automation from Xerox (MAX) to build customized leading banner pages that enable inline printing of job order sheets.



- Preflight ensures that image resolution is acceptable and that fonts are embedded in the document.
 - See ESv4-01 Preflight & Print.
- Imposition uses Automatic sheet size selection and automatic orientation to determine the most optimal sheet size for the job. Sheet size selection is constrained to the subset of sheet sizes specified in the imposition template.
- Insert Pages adds a blank page to the start of the document. The page will contain the content for the leading banner page.
- Watermarks add text and images to the inserted blank page including order, printing, and workflow information.
- Barcode add the Job ID to the inserted blank page.
- Documents are automatically submitted to the selected printer. The print ticket specifies that the first page is a leading banner page. The DFE removes this page from the job and processes it using the internal logic for DFE-generated banner pages. The remainder of the document prints per the job print ticket.

Workflow Benefits

This workflow features one of the ways in which FreeFlow® Core can leverage arbitrary order information from upstream systems. In this specific case, order information, print information, and workflow processing information is added to a leading banner page that is printed inline with the job. Printing inline job sheets facilitates more efficient tracking when producing a large number of jobs.

ESv4-13 Booklets and Calendars

This workflow demonstrates how the FreeFlow® Core approach to prepress makes automation simpler to implement and simpler to sustain.



- Preflight ensures that image resolution is acceptable and that fonts are embedded in the document.
 - See ESv4-01 Preflight & Print.
- Documents are routed based on orientation. Landscape documents are routed to calendar imposition. Portrait documents are routed to booklet imposition.
 - For documents routed to calendar imposition templates, the last page is rotated 180 degrees.
- Imposition uses Automatic sheet size selection and orientation to determine the best sheet size for the job. Sheet size is constrained to the subset of sheet sizes specified in the imposition template.
- Imposed documents are automatically submitted to the selected printer.

Workflow Benefits

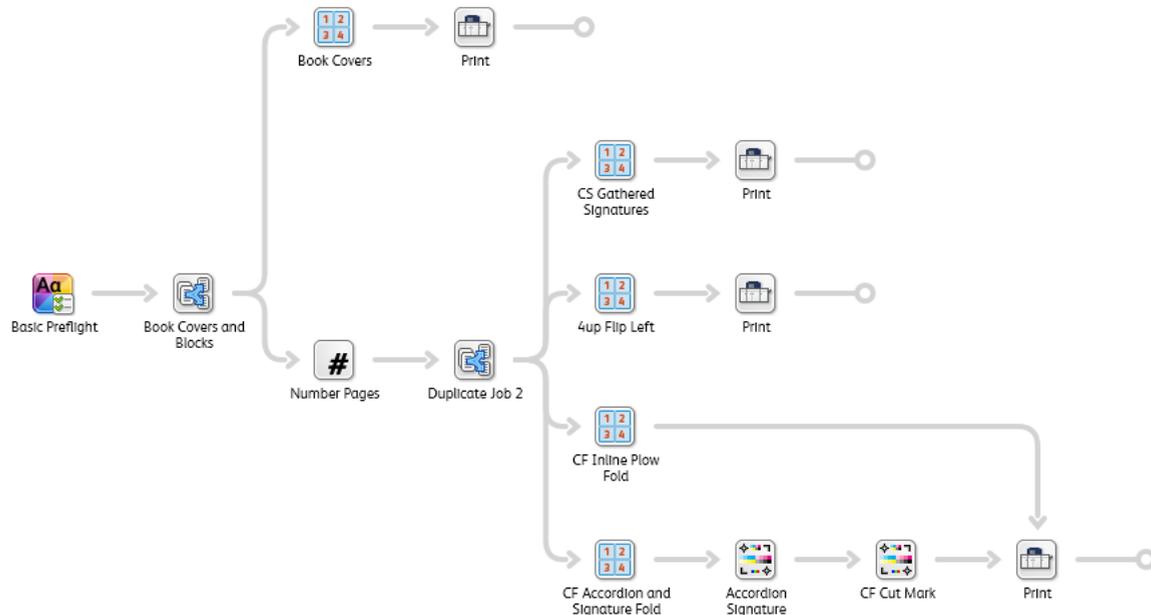
The Preflight, Booklets and Print presets are shared with other workflows. The ability to share presets between workflows minimizes the total configuration that must be implemented and managed as part of enabling prepress automation.

This workflow highlights how FreeFlow® Core imposition helps simplify prepress automation. Instead of having multiple workflows or imposition presets for each type of booklet or calendar, a single workflow using an imposition preset for each job type is able to impose booklets and calendars with and without bleed on the most optimal press sheet size. The workflow also automates both imposition and the selection of the right imposition preset.

FreeFlow® Core components are built to handle job variability. This simplifies implementation and sustainability of prepress automation.

ESv4-14 Books

This workflow demonstrates the FreeFlow® Core ability to automate prepress for different job components in a single workflow.



- Preflight ensures that image resolution is acceptable and that fonts are embedded in the document.
 - See ESv4-01 Preflight & Print.
- Documents are split into covers and blocks based on the orientation of the document pages.
- Covers workflow:
 - Covers are imposed Multi-up on 14.33in. x 20.5in.
 - Imposed documents are automatically submitted to the selected printer. The print quantity is adjusted to ensure the required number of covers is produced.
- Block workflow:
 - Book blocks are duplicated and submitted to multiple executions paths that automate book preparation for different printing and finishing configurations.
 - The cut sheet (CS) Gathered Signatures preset imposes book blocks as required for inline finishing using an inline cutter and perfect binder. Imposition is performed on two stages:
 - On the Primary Stage, books are imposed as single sheet booklets using the Automatic press sheet size.
 - The dimensions of the document are based on the PDF box used imposition plus gutter and margin distances.
 - On the Secondary Stage, booklets are imposed Cut & Stack using 1 sheet per signature.
 - The resultant layout produces a sheet that can be cut in half before folding and gathering in preparation for perfect binding.
 - The 4up Flip Left preset imposes book blocks 4up with the left column rotated so the spines abut in the center.

- The resultant layout produces book blocks that are separated before they are fed into an offline perfect binder.
- The continuous feed (CF) Inline Plow Fold preset imposes book blocks 3up using manual page order and per cell content alignment.
 - The resultant layout produces book blocks that can be printed on a CF printer with an inline plow folder configured to C-fold the web before sheeting and stacking book blocks for perfect binding.
- The CF Accordion and Signature Fold preset imposes book blocks 8up using manual page order.
 - The resultant layout produces book blocks that can be printed on a CF printer with an inline folder configured to perform three accordion folds followed by a cross fold.
 - The Accordion Signature pressmarks add signature sequence marks, fold registration marks and marks for demarcating the end of signature and end of book boundaries.
 - The CF Cut Mark preset adds a mark to trigger in inline cutter via OMR.
- Imposed documents are automatically submitted to the selected printer. If needed, the print quantity is adjusted to ensure the required number of book covers or blocks is produced.

Workflow Benefits

This workflow highlights how FreeFlow® Core automates both job processing and decisions about how jobs should be processed. FreeFlow® Core accepts jobs as they are submitted and automatically splits job components into multiple jobs. The output is two book components each prepared according to their respective requirements. Incrementally, the workflow creates 4 copies of the book block to highlight the FreeFlow® Core imposition capabilities.

This workflow shows how a single workflow is able to automatically perform different prepress operations on different job components.