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Xerox® FreeFlow® Variable Information Suite

Specialty or Security Imaging User Guide for VI Compose on a Fiery DFE and VI Design Express

xerox™

Produced in the United States of America.

BR39609

Contents

Introduction

This chapter contains:

This document is intended for Xerox® FreeFlow® VI Design Express (VDE) or EFI Fiery users, who want to design, print, and validate Specialty or Security Imaging (SI) effects.

Note: Users with a Fiery EFI DFE will require a special setup to utilize Variable Information Suite printing or imaging.

Note: Xerox FreeFlow VI Design Express (VDE) is a plug-in to Adobe's Creative Cloud InDesign.

FreeFlow Variable Information Suite Documentation

The Variable Information Suite of documentation and software can be found at FreeFlow Variable Information Suite – Windows 10 x64 – Xerox.

Overview of Steps to get SI Working in VDE or InDesign

1. Set up Adobe InDesign for One-Time: This section covers what option to select during VDE installation with SI plug-in (Fonts and Swatches).
2. Load SI Swatches in Adobe InDesign: This section guides on how to load SI color swatches in the document.
3. How to Add SI to a Document From Within Adobe InDesign: This section explains how to design your documents with various SI effects using VDE plug-in.
4. Generation or Export or Export of Printable Files: This section tells how to generate different print files in Adobe InDesign, such as Export as VPC and VI PDF.
5. Set up EFI Fiery DFE for One Time: This section covers how to do the setup, such as installation of VI Compose Software, installing SI Fonts, and configuring queue settings as Job Presets on Fiery Server (CWS).
6. Submission to Print Server: This section tells how to submit VIPP jobs to the DFE for the EFI Fiery Server.

Set up Adobe InDesign for One Time

This chapter contains:

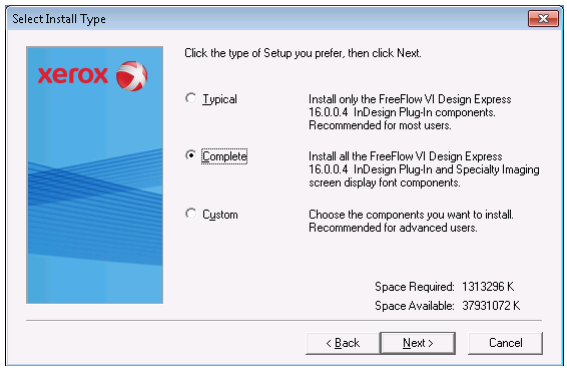
VDE Versions Supported

Xerox® FreeFlow® VI Design Express supports Adobe InDesign 2022 (version 17.4 or later) and Adobe InDesign 2023 (version 18.2 or later). For FreeFlow VI Design Express for Mac and Windows operating system support, refer to the Adobe InDesign System Requirements.

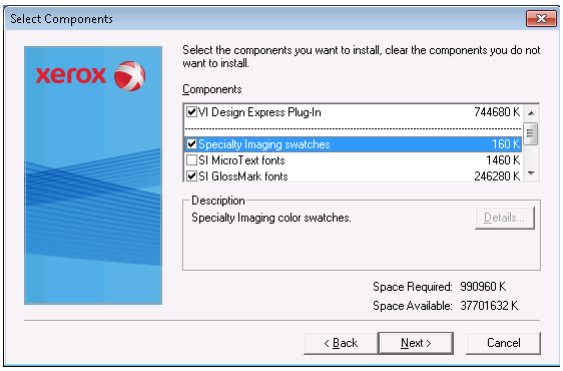
VDE Installation with SI Plug-in for Fonts and Swatches

There are two ways to install the SI plug-in for VI Design Express. One is by selecting **Complete** option in Select Install Type dialogue, which will install all the SI swatches and fonts. The second is by selecting the **Custom** option, to install only selected SI effects, you can use this option. Refer to Select Install Type dialogue below:

COMPLETE OPTION

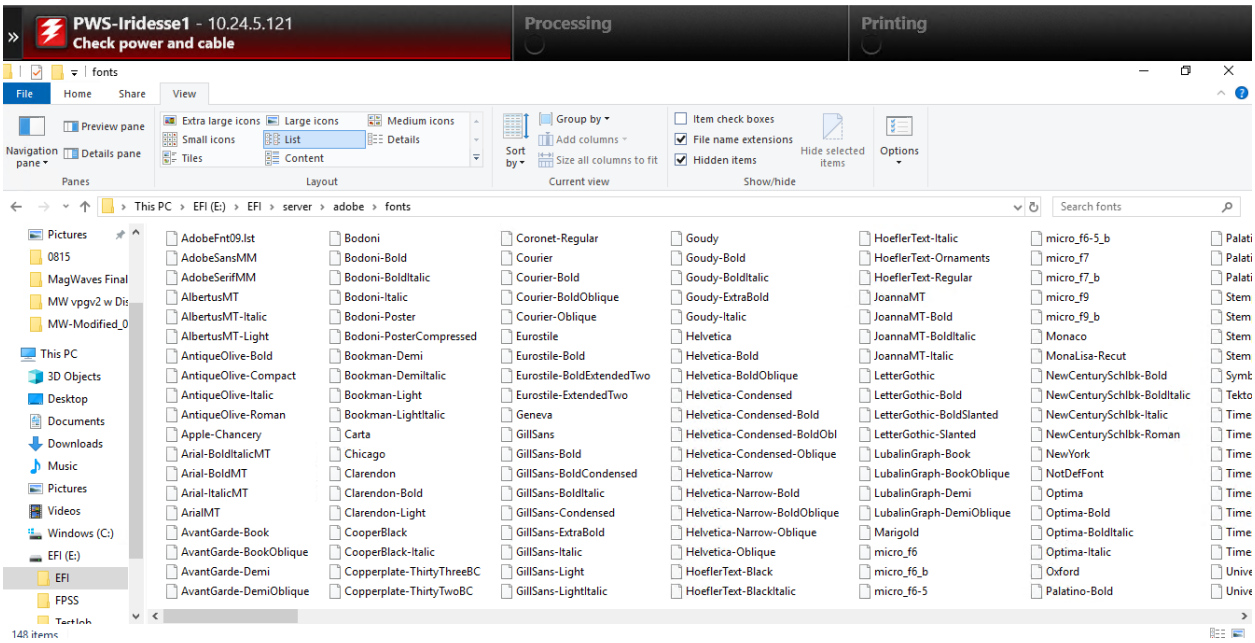


CUSTOM OPTION



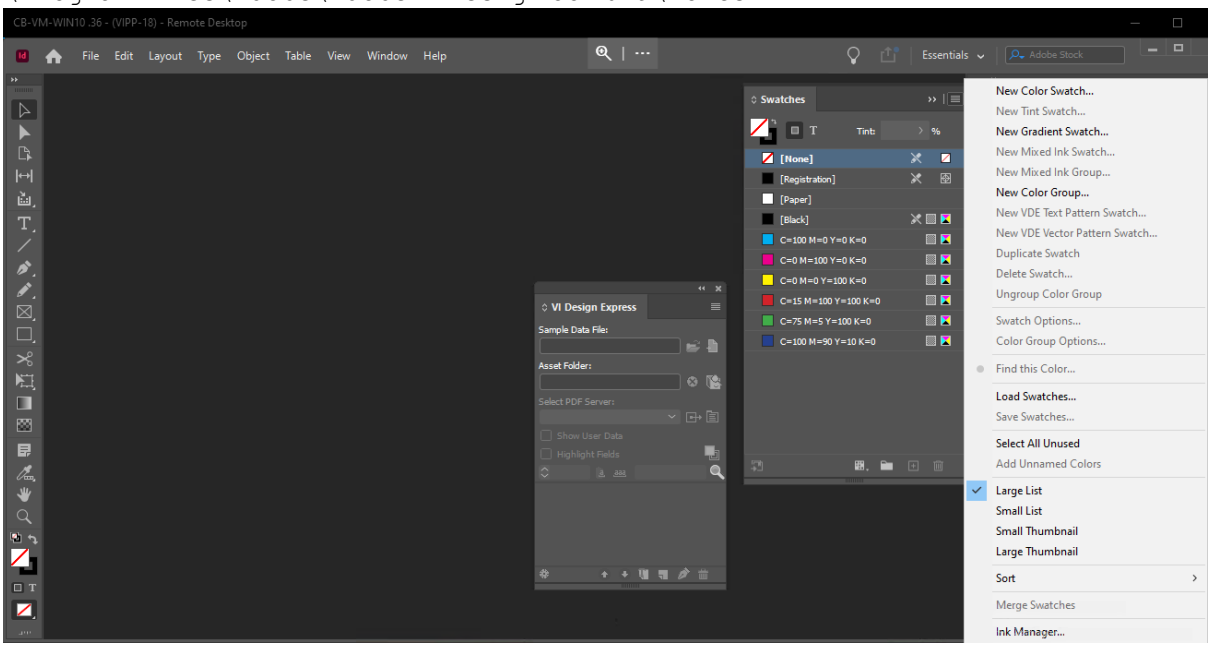
Note: After successful installation on an EFI Fiery DFE, the SI Fonts and Swatches will reside in `E:\EFI\server\adobe\fonts`.

The Xerox® VIPP® Manage Utility can also be used to list fonts and all loaded jobs and resources for your machine. The VIPP Manage Utility user guide can be found at Xerox® VIPP® Manage User Guide – FreeFlow Variable Information Suite – Xerox. Refer to the command list in the *Xerox® VIPP® Manage Utility User Guide*. Below is a partial list of fonts. You can see the SI microText fonts have been loaded, such as micro_f6-5_b, and so on.

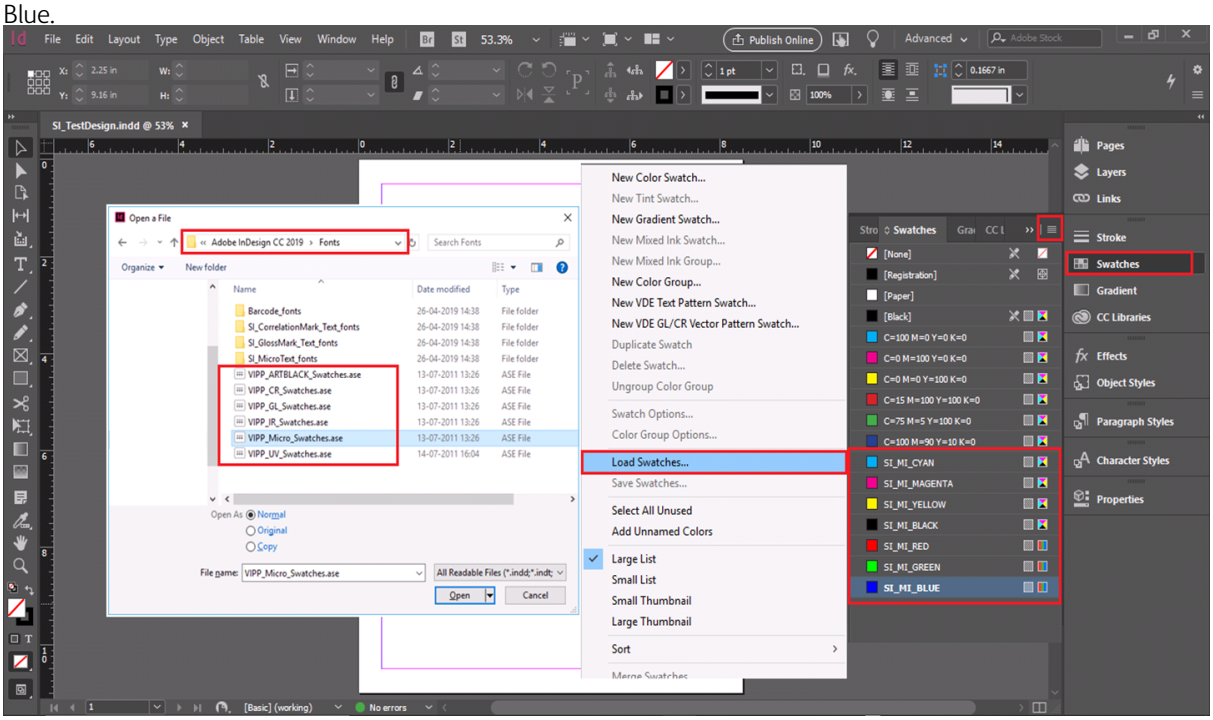


Load SI Color Swatches in Adobe InDesign

1. Open the Swatches panel, go to **Window > Color > Swatches** or press F5 function key.
2. Click on the top-right hamburger menu in Swatches panel, then click **Load Swatches…** and browse to `X:\Program Files\Adobe\Adobe InDesign CC xyz\Fonts`
   X is the drive where Adobe InDesign is installed and xyz is the version of InDesign installed, for example, `C:\Program Files\Adobe\Adobe InDesign CC 2019\Fonts`



3. Select **VIPP_SI_Swatches.ase** and see the SI colors are loaded in the Swatches panel, for example, SI_MI_Blue.



Setting Up Fiery DFE for the First Time

This chapter contains:

Fiery Server in Command Work Station (CWS)

INSTALLATION OF VI COMPOSE SOFTWARE

1. To determine the version of VIC software installed on Fiery DFE, go to `E:\EFI\server\xgf`. Using Notepad or a similar program open, **VER** file and version details are displayed. For example, `Xerox FreeFlow VI Compose 18.0.0 (Build 4252): Wednesday, March 1, 2023, 21:19:03 PM`.
2. Use 18.0.X or latest of the VI Compose software. You can download and install it from Drivers & Downloads – FreeFlow Variable Information Suite – Xerox.
3. Instructions for installation can be found in the *VICompose User Guide*.

DFE SETUP GUIDE AND REQUIRED MATERIALS

1. Download the `Xerox_EFI_DFE_Configuration_Setup.zip` file that contains all the Xerox custom VI Suite SI materials, so that you can customize your DFE for Xerox VI Suite. You can download and install it from Drivers & Downloads – FreeFlow Variable Information Suite – Xerox.
2. Look for a zip file, `Xerox_EFI_DFE_Configuration_Setup`.
3. Download this file and extract the contents for later use.

INSTALLATION OF SPECIALTY IMAGING FONTS

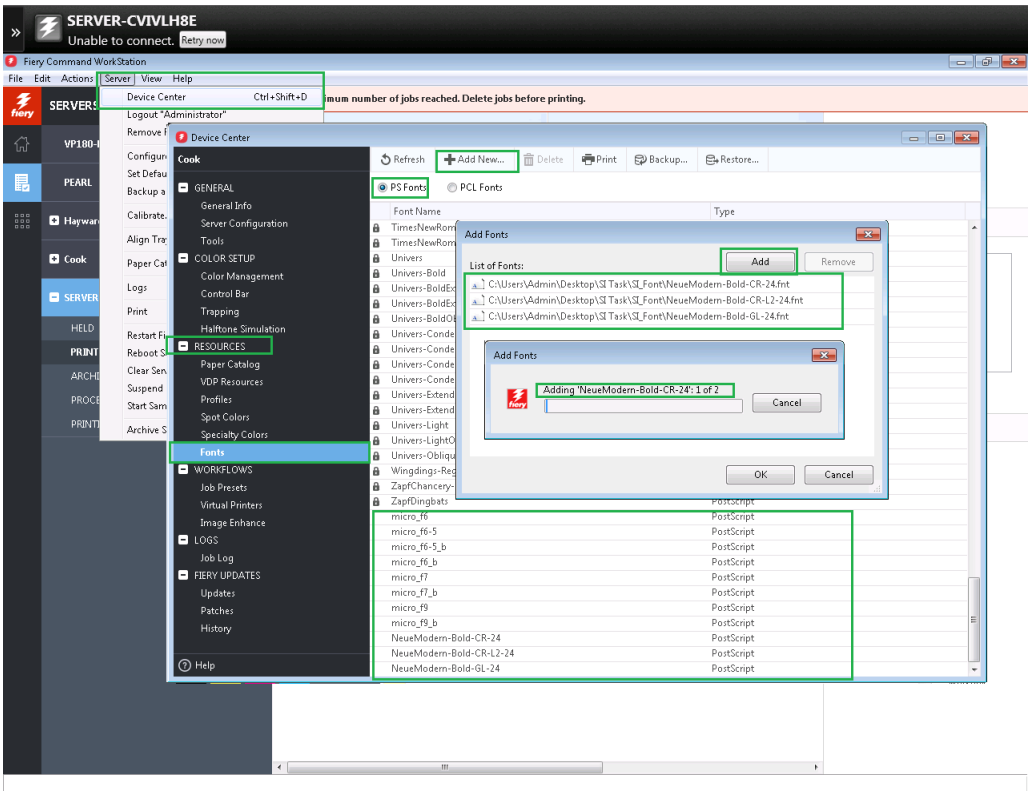
1. To print Specialty or Security printing, ensure that you install the SI Fonts for MicroText, Legacy GlossMark, and Legacy Correlation Mark effects.
2. The SI Fonts can be found in the **Xerox_EFI_DFE_Configuration_Setup.zip** file which was downloaded in the previous step from Drivers & Downloads – FreeFlow Variable Information Suite – Xerox.
3. Open `Xerox_EFI_DFE_Configuration_Setup.zip` file and extract it. You will see a zip file called FF VI SI Fonts.
   Extract this file to obtain the needed VI Suite SI fonts.
4. To install the fonts, open the Fiery Command Work Station (CWS).
5. Click **Server > Device Center** or Ctrl + Shift + D.
6. Select **Resources > Fonts > PS Fonts > + Add New**...
7. Click **Add > Browse** and select **SI Fonts** from the folder where it was downloaded and copied.

Tip: You can add multiple fonts at once, change the profile, then reboot once when all steps have been completed.

8. The Add Fonts dialogue is displayed showing the fonts are adding. After adding a font, it will be displayed as the last entry in display of fonts.

9. Restart the Fiery Server machine to take effect on VI Compose Software and SI Fonts installed on Fiery.

Tip: You can do all the preparation and loading of all required files in the following steps and then reboot once upon completion of all steps.

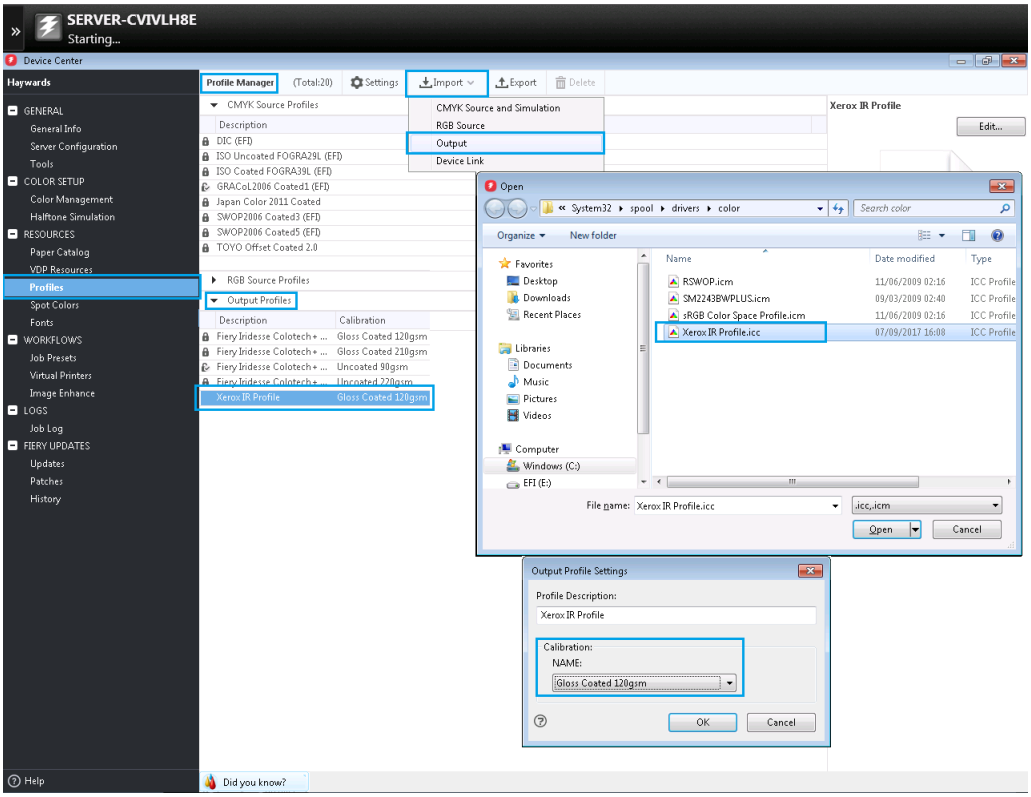


INSTALLATION OF XEROX IR OUTPUT PROFILE IN COMMAND WORK STATION

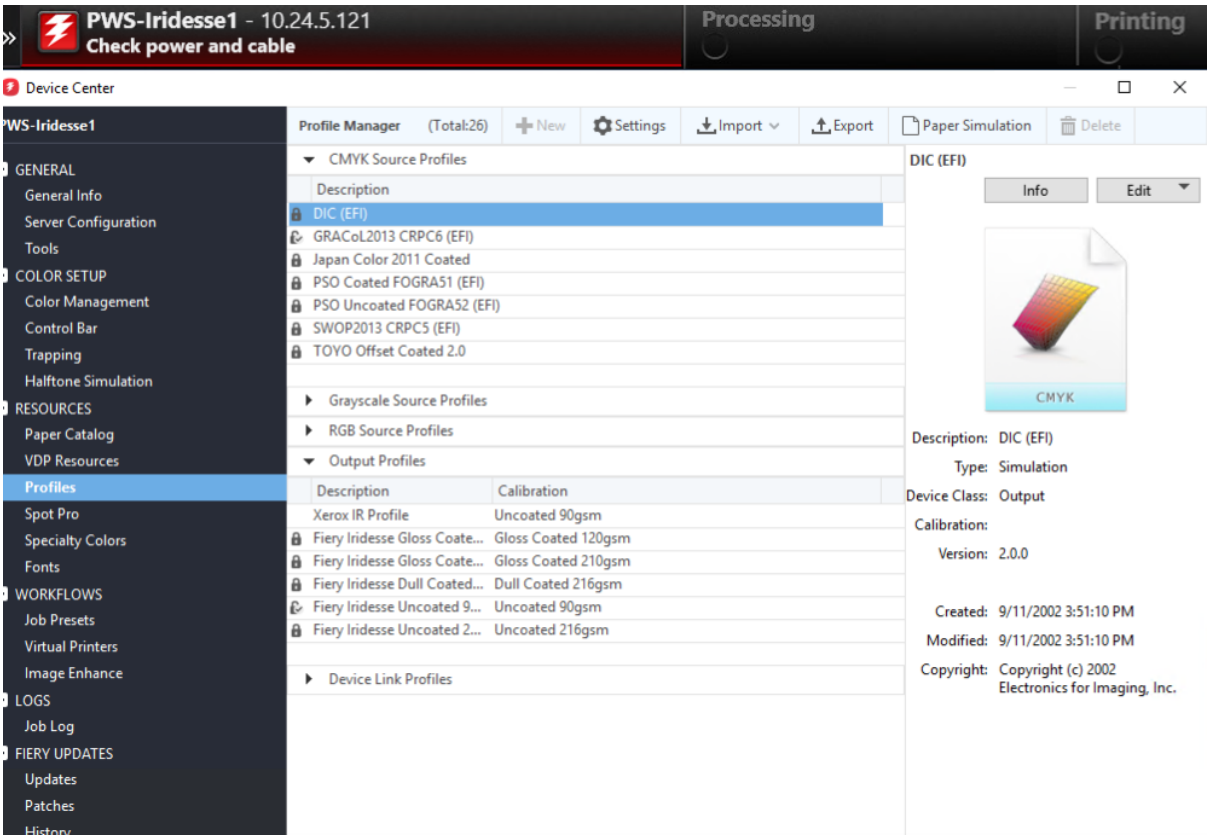
1. Next Installation of Xerox IR profile is required.
2. Locate the configuration zip file with the ICC profiles in it, that was downloaded earlier as `Xerox_EFI_DFE_Configuration_Setup zip` file in step 2 of Installation of Specialty Imaging Fonts.
3. Open Fiery Command Work Station (CWS).
4. Click **Server > Device Center** or Ctrl + Shift + D.
5. Select **RESOURCES > Profiles > Import > Output > Browse** to the **Xerox IR Profile.icc** file that was saved in your local folder.
6. Click **Open**.
7. In the Output Profile Settings dialogue, select the appropriate Calibration. For example, Gloss Coated 120 gsm and click **OK** button.
8. Expand the Output Profiles under **Resources > Profiles > Profile Manager** and confirm Xerox IR Profile is added.

9. Restart the Fiery Server machine to take effect on ICC profile installed on Fiery.

Tip: You can reboot once after all profile changes and other steps have been completed.



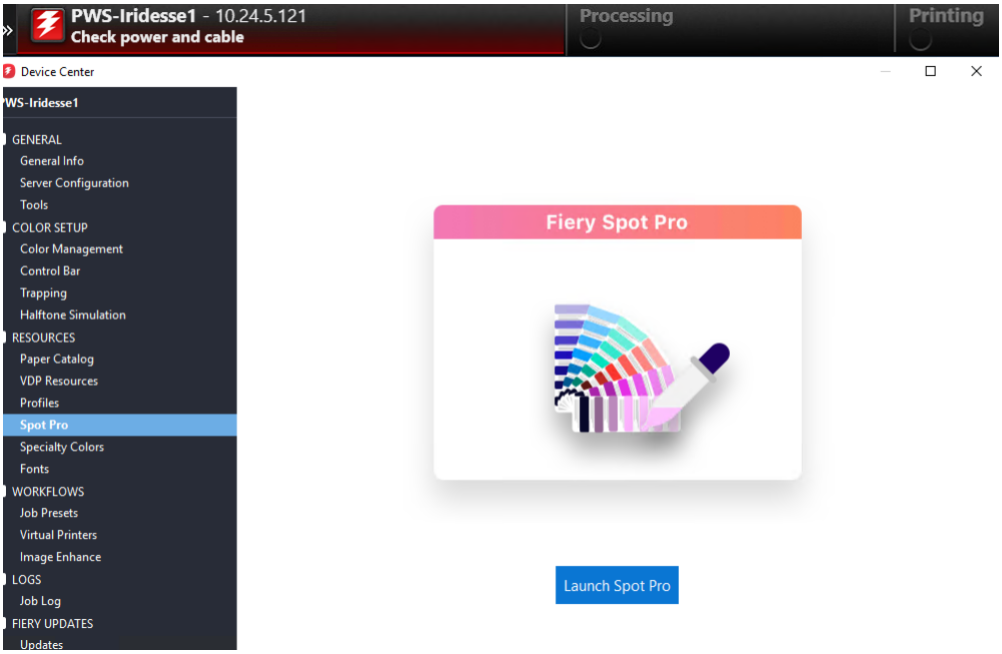
Once completed, you will see below screen.



INSTALLATION OF XEROX IR SPOT COLORS IN COMMAND WORK STATION

1. Add the Xerox VI Suite Spot Colors.
2. Locate the configuration zip file with the Spot color profile definition in it, that you downloaded earlier as Xerox_EFI_DFE_Configuration_Setup zip file in Step 2 of Installation of Specialty Imaging Fonts.
3. Open Fiery CWS and click **Server > Device Center** or Ctrl + Shift + D.

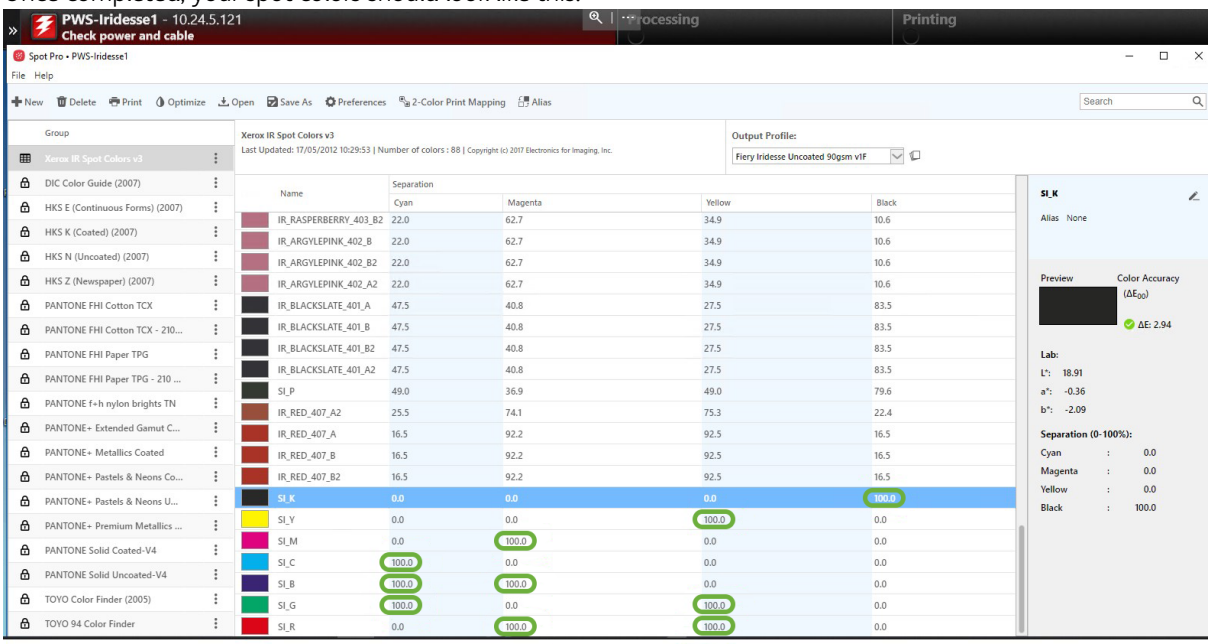
4. Select **RESOURCES > SpotPro > Open\Launch SpotPro**.



5. Select **Open > Browse** to select `Xerox IR Spot Colors v3.icc` file that was saved in your local folder above. Once completed, you will notice a new group called Xerox IR Spot Colors v3. Check to see if the spot colors for SI_P, SI_K, SI_Y, SI_M, SI_C, SI_B, SI_G, have been imported properly.

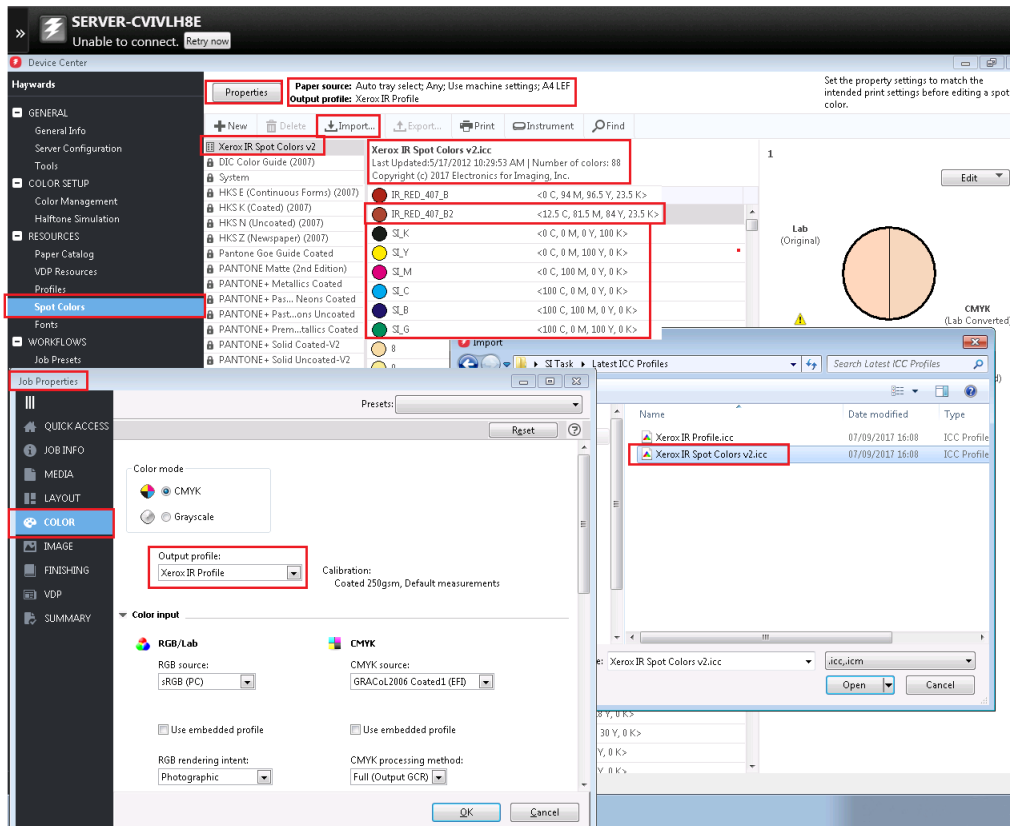
6. Scroll down through the Xerox IR Spot Colors group to check the SI spot color values, for example, SI_K, SI_Y, SI_M, SI_C, and so on, They should have solid values as 0s and 100s and not floating values like other IR spot colors such as IR_RED_407_B <0 C, 94 M, 96.5 Y, 23.5 K>. If the solid values are seen, then the Spot Color import and output profile mapping is done successfully. If the spot color definitions were not maintained during the import, ensure that you correct them.

7. To correct a spot color, double click it and then modify the separation values. Once completed, click **Save**. Once completed, your spot colors should look like this.



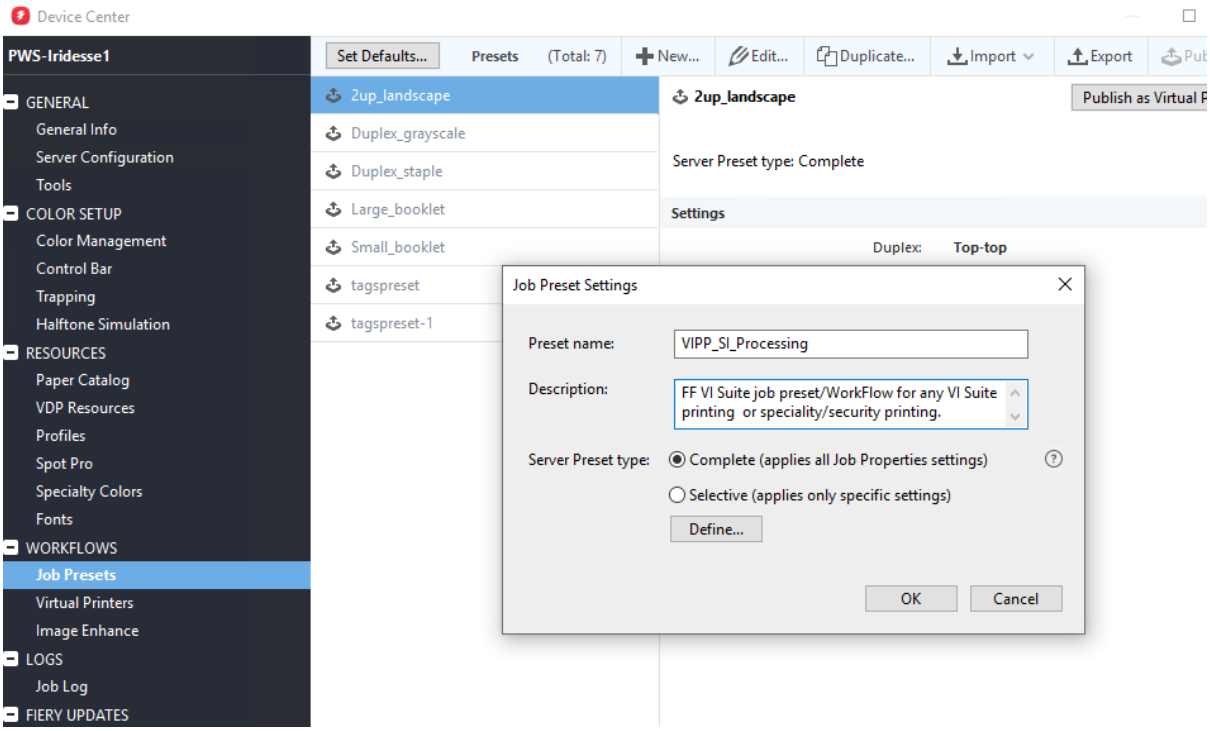
8. Restart the Fiery Server machine to take effect on ICC profile installed on Fiery.

Tip: You can reboot once after all profile changes and other steps have been completed.



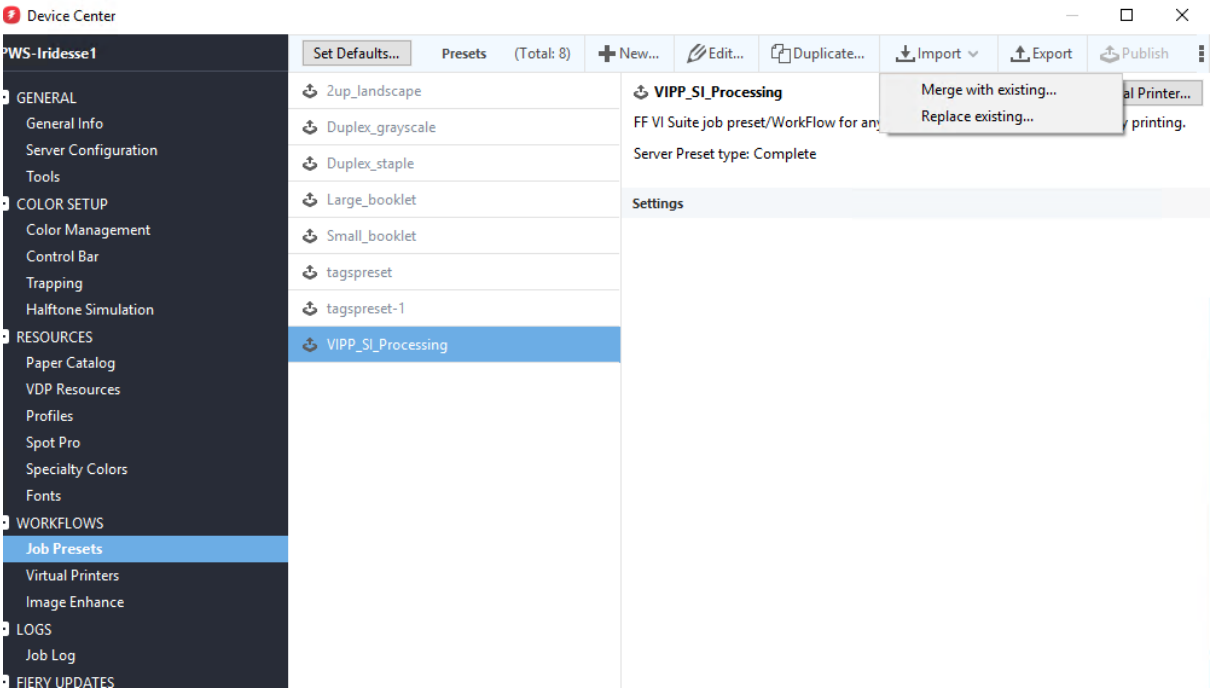
Configure Queue Settings as Job Presets in Command Work Station (CWS)

1. Locate the configuration zip file with the VIPP_SI_WorkFlow_Job_Presets_to_Import.fjp definition in it, that you downloaded earlier as Xerox_EFI_DFE_Configuration_Setup zip file in Step 2 of Installation of Specialty Imaging Fonts.
2. Open Fiery CWS (Command Work Station).
3. Click **Server > Device Center** or Ctrl + Shift + D.
4. Select **WORKFLOWS > Job Presets** and click + New button.
5. Enter Preset name, Description in Job Preset Settings dialogue and click **OK** button.



6. You can now import the VI Suite settings into this profile.
7. Ensure that the new VIPP_SI_Processing Workflow Job Preset is highlighted.
8. Select **WORKFLOWS > Job Presets** and click **Import** button.

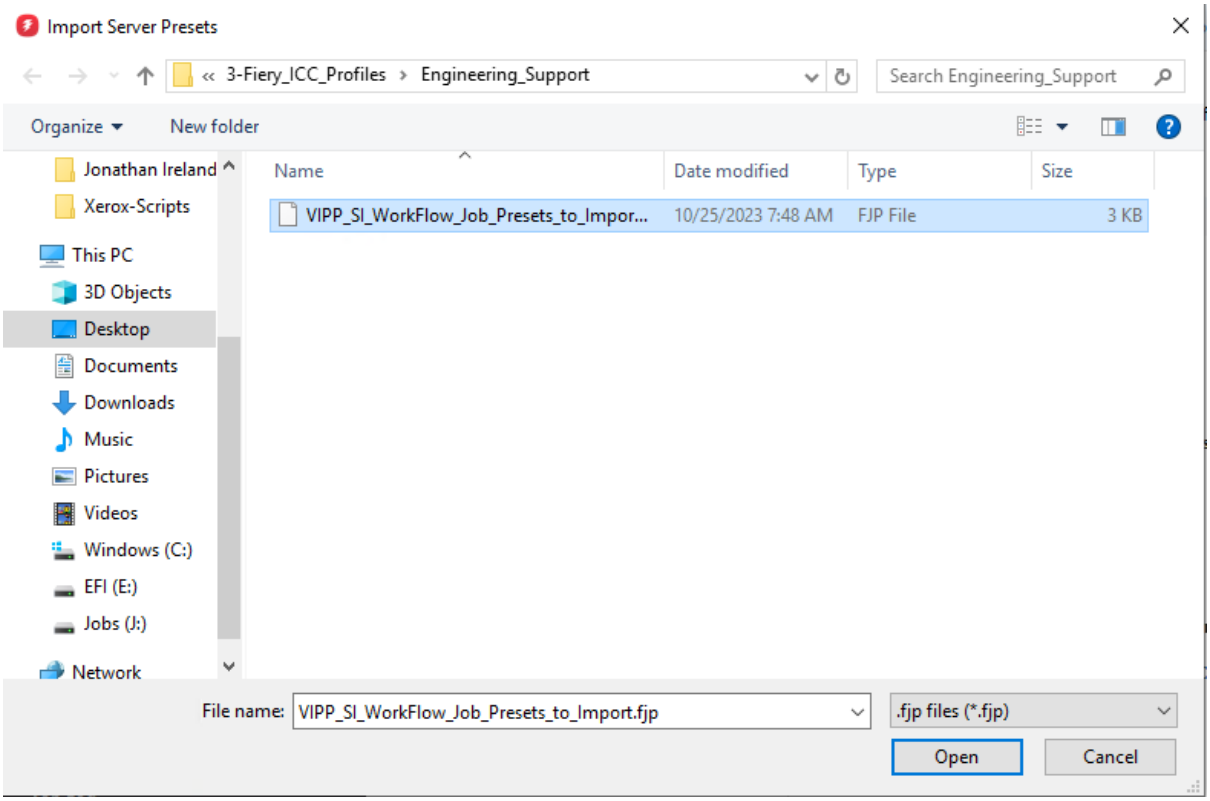
9. Select the **Replace existing…**



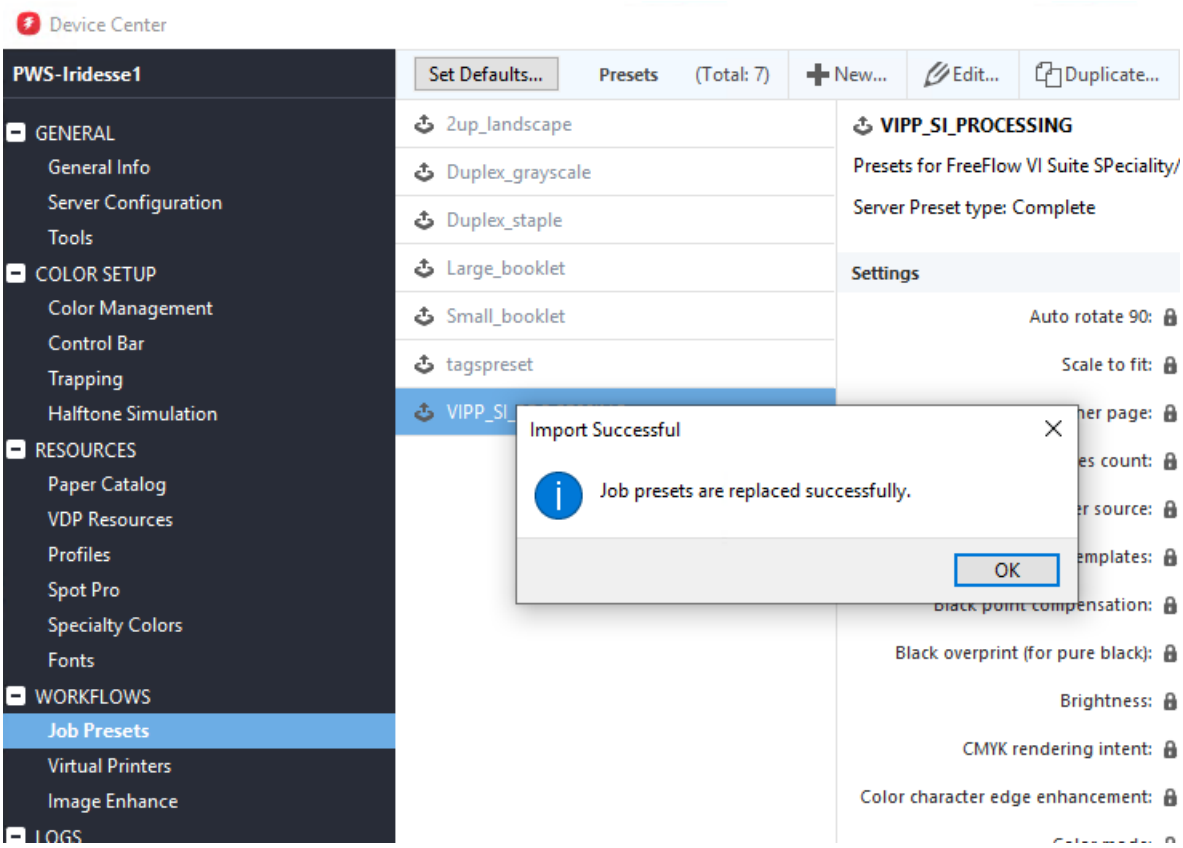
10. Select the `VIPP_SI_WorkFlow_Job_Presets_to_Import.fjp` file from earlier downloaded.

11. Click **Open**.
A warning appears as `Do not disrupt the progress of this action or unexpected results can occur.`

This will merge the imported values with your new Workflow job Preset. A pop-up will indicate the job presets have been replaced successfully.

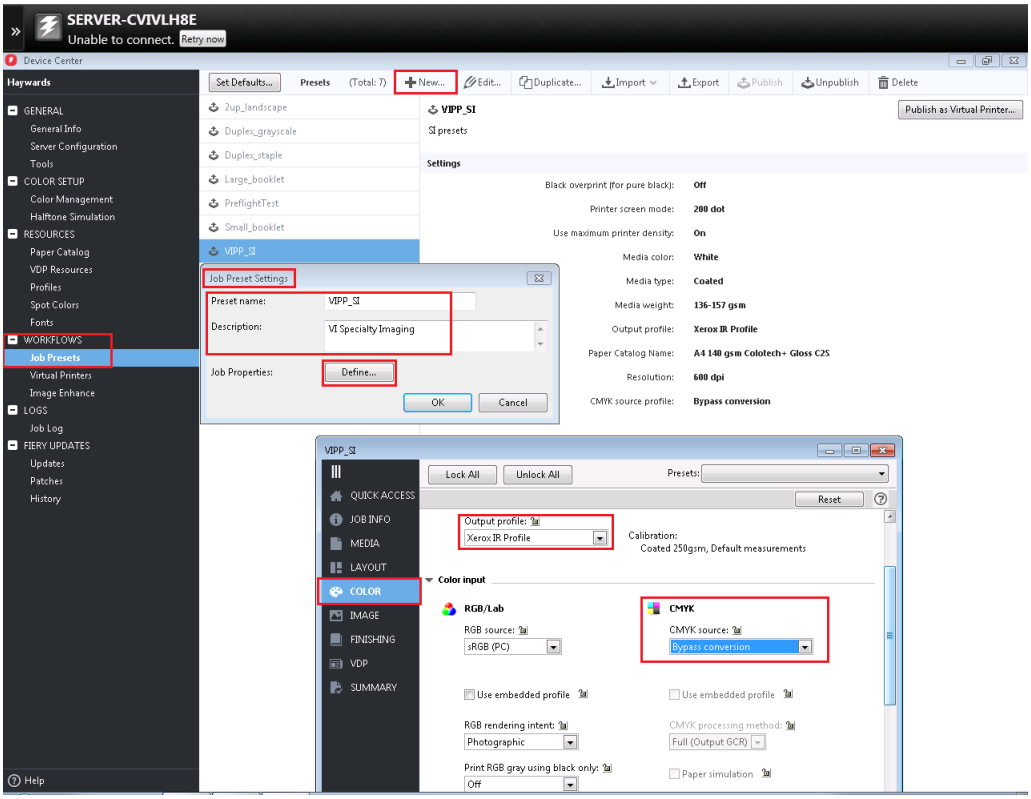


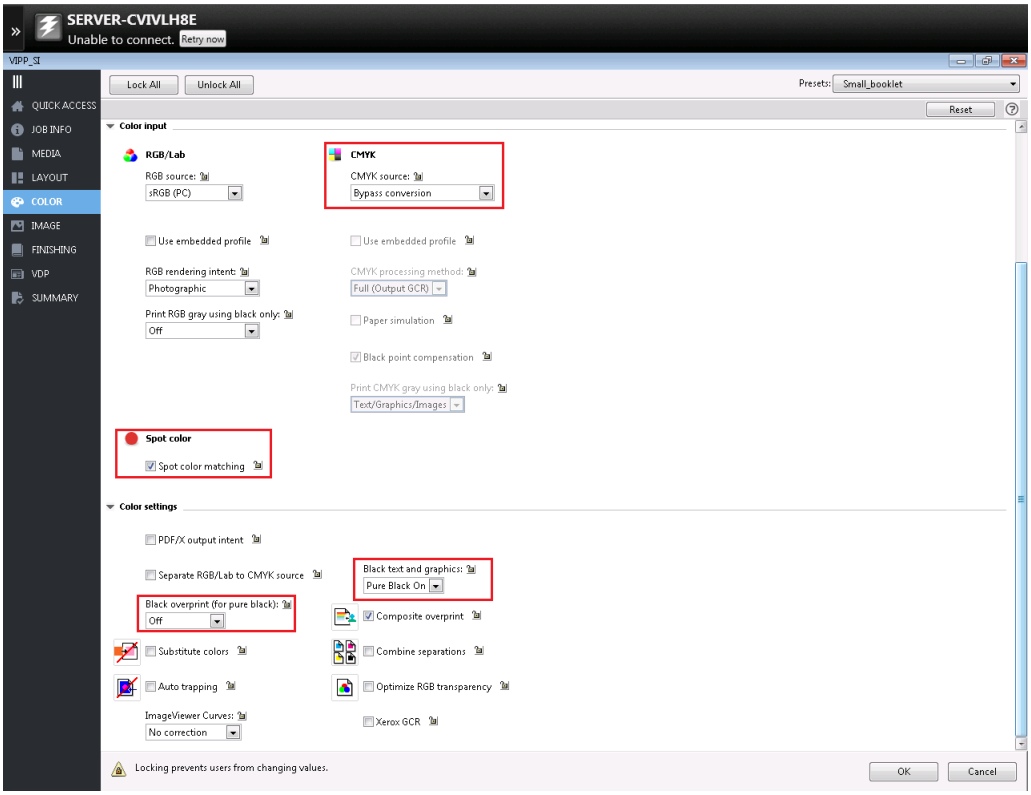
12. A pop–up message will appear as `Job presets are replaced successfully`.

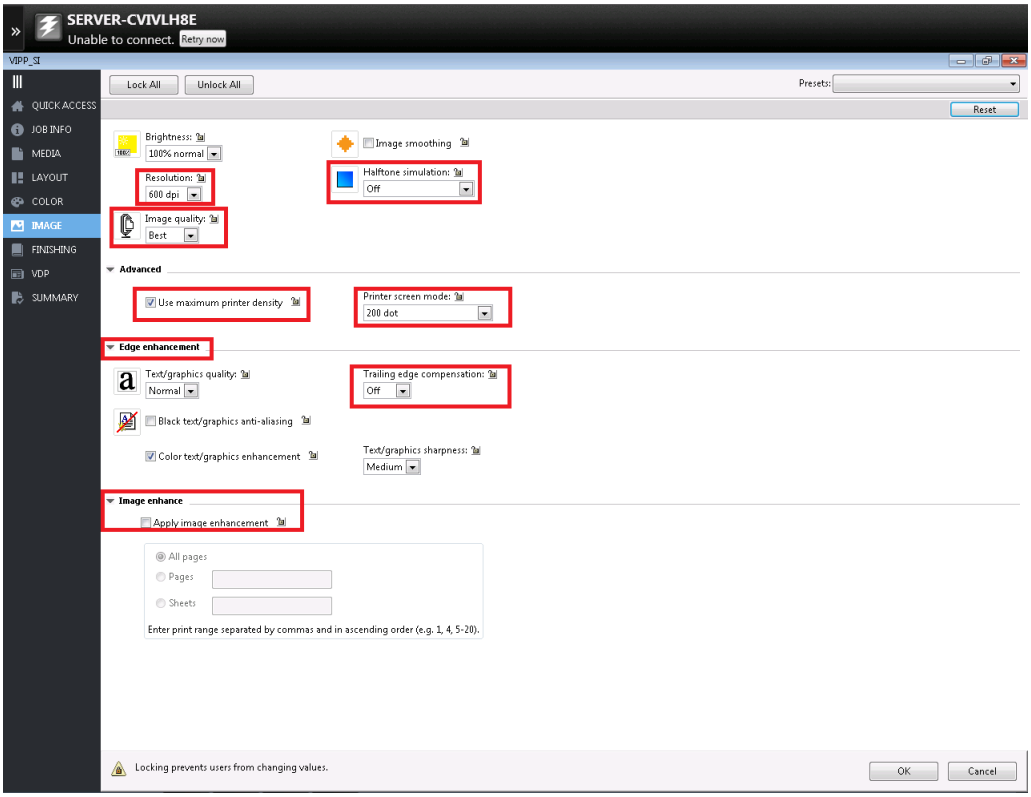


13. Click **OK**.
14. Reboot the EFI or Fiery DFE to changes to appear.
15. Once the reboot has occurred, you have successfully set up your EFI or Fiery DFE.

16. To view all the VI Suite settings, print the properties of any job queued up to your VIPP_SI_PROCESSING Workflow.






SERVER-CVIVLH8E
Unable to connect.
Retry now
VIPP_SI
Lock All
Unlock All
Presets:
Reset
QUICK ACCESS
JOB INFO
MEDIA
LAYOUT
COLOR
IMAGE
FINISHING
VDP
SUMMARY
Brightness:
100% normal
Image smoothing
Resolution:
600 dpi
Halftone simulation:
Off
Image quality:
Best
Advanced
Use maximum printer density
Printer screen mode:
200 dot
Edge enhancement
Text/graphics quality:
Normal
Trailing edge compensation:
Off
Black text/graphics anti-aliasing
Color text/graphics enhancement
Text/graphics sharpness:
Medium
Image enhance
Apply image enhancement
All pages
Pages
Sheets
Enter print range separated by commas and in ascending order (e.g. 1, 4, 5-20).
Locking prevents users from changing values.
OK
Cancel

How to Add SI to a Document Using VI Design Express

This chapter contains:

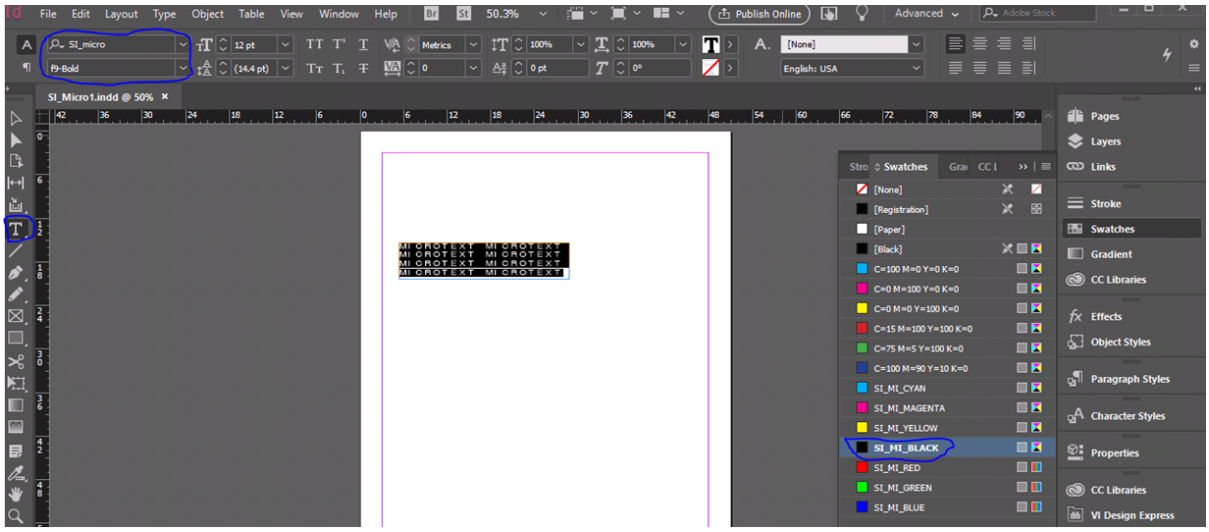
Note: Not all Specialty effects work on all MFD or print devices. To ensure that the specialty effect will work on the MFD or print devices that you are trying to use, refer to FreeFlow® VI Suite Specialty Imaging Customer Report – FreeFlow Variable Information Suite – Xerox.

Micro Text SI Effect

1. Create a new Adobe InDesign document using VI Design Express.
2. Load VIPP_Micro_Swatches.ase, then the new swatches (Micro Text colors) are loaded and named in the Swatches panel, for example, SI_MI_Black.
3. Select the text tool, add your text and ensure that it is selected, then select the SI_Micro font family name from within the Properties Tab, font drop-down list. Next, select the font style option. The available options are f6, f6-5, f7, f9, f6-5-Bold, f6-Bold, f7-Bold, and f9-Bold.
4. Next set the InDesign Font size option to 1 point. No other font attributes should be selected, and they will be ignored. To view the text on-screen, select a larger point size, such as 10 points., to verify that the correct text is being placed in the application. However, the text size attribute must be reset to 1 point before the application is saved and exported. Failure to do this will result in unpredictable results.

Note: If necessary, increase the view magnification of the document to see the MicroText.

5. Draw a TextBox inside the document and type a text or insert a variable data field from the VDE panel, for example, MICROTEXT.
6. Highlight the text, then select any SI font color from the Swatches panel, for example, SI_MI_Black.
7. Save the InDesign document and Export as VPC.



Vector Pattern Correlation Mark (1 Layer and 2 Layer) SI Effect

SINGLE OR 1-LAYER CR MARK

1. Create a new Adobe InDesign document using VI Design Express.
2. Load VIPP_CR_Swatches.ase, then new swatches (CR colors) are loaded and named in the Swatches panel. For example, SI_CR_Black50, Black75, Black100, and so on.
3. Click the top-right of the Swatches panel, click **New VDE Vector Pattern Swatch** to open Vector Pattern dialogue.
4. Enter or select the required values like Name (CR_1L_Black100), SI effect (Correlation (1 layer)), Color 1 (None or Paper is mandatory), Color 2 (SI_CR_Black100), Distraction (None or Light or Heavy), Linewidth, Horizontal and Vertical Adjustment, Rotation, and Horizontal and Vertical Scale fields, respectively and click **OK** to see the new SI_VP created at the bottom of the last SI_CR_Color, for example, SI_CR_1L_Black100.
5. Draw a TextBox inside the document and type a text or insert a variable data field from the VDE panel, for example, CorrelationMark.
6. Highlight the text inserted and select desired Font name and size and choose Font color as **Paper** from the Swatches Panel. After selecting the Font color as Paper, the text will be invisible or disappear [This is an expected behavior and no need to worry].
7. Select the Textbox object using Direct Selection Tool (A) and apply the SI_CR_1L_Black100 effect from Swatches Panel. You must be seeing some diagonal lines drawn on the Textbox.
8. Save the InDesign document and Export as VPC.

DOUBLE OR 2–LAYER CR MARK

1. Create a new Adobe InDesign document using VI Design Express.
2. Enter or select the required values, such as Name (CR_2L_Black100), SI effect (Correlation (2 layer)), Color 1 (None or Paper is mandatory), Colors 2 & 3 (SI_CR_Black100), Distraction (None or Light or Heavy), Linewidth, Horizontal and Vertical Adjustment, Rotation, and Horizontal and Vertical Scale fields, respectively and click **OK** to see the new SI_VP created at the bottom of the last SI_CR_Color, for example, SI_CR_2L_Black100.
3. Draw a TextBox (same size as of the one Layer) inside the document and type a text or insert a variable data field from the VDE panel, for example, SECOND LAYER.
4. Highlight the text inserted and select desired Font name and size and choose Font color as Paper from the Swatches panel. After selecting the Font color as Paper, the text will be invisible or disappear [This is an expected behavior and no need to worry].
5. Select the Textbox object using Direct Selection Tool (A) and apply the SI_CR_2L_Black100 effect from Swatches panel. You must be seeing some diagonal lines drawn on the Textbox.
6. Place the Second Textbox exactly on top of the First Textbox, so that it looks as only one textbox. Use InDesign to Group the two text frame objects.
7. Save the InDesign document and Export as VPC.

UV – Ultraviolet/Fluorescent SI Effect

BOTTOM OR 1–LAYER UV MARK

1. Create a new Adobe InDesign document using VI Design Express.
2. Load VIPP_UV_Swatches.ase then new swatches (UV colors) are loaded and named in the Swatches panel, for example, SI_UV_Blue1.
3. Draw a TextBox inside the document and type a text or insert a variable data field from the VDE panel, for example, UV Text.
4. Highlight the text inserted and select desired Font name and size and choose Font color as **Paper** from the Swatches panel. After selecting the Font color as Paper, the text will be invisible or disappear [This is an expected behavior and no need to worry].
5. Select the Textbox object using Direct Selection Tool (A) and apply the SI_UV_Blue1 effect from Swatches panel.
6. Save the InDesign document and Export as VPC.

TOP OR 2–LAYER UV MARK

1. Create a new Adobe InDesign document using VI Design Express.
2. Draw a TextBox (same size as of the one Layer) inside the document and type a text or insert a variable data field from the VDE panel, for example, TWO LAYER.
3. Highlight the text inserted and select desired Font name and size and choose Font color as any SI_UV_2L_XXXX color, for example, SI_UV_2L_CYAN from the Swatches panel. For appropriate 2L color selection, refer to the Color swatches for two-layer Fluorescent effect section in the *VDEUserGuide.pdf*.

Note: This 2L text will be visible when you print. [This is an expected behavior and no need to worry].

4. Place the Second Textbox exactly on top of the First Textbox, so that it looks as only one textbox. Use InDesign to Group the two text frame objects.
5. Save the InDesign document and Export as VPC.

IR – Infrared SI Effect

BOTTOM OR 1–LAYER IR MARK

1. Create a new Adobe InDesign document using VI Design Express.
2. Load VIPP_IR_Swatches.ase, then new swatches (IR colors) are loaded and named in the Swatches panel, for example, SI_IR_Blue1.
3. Draw a TextBox inside the document and type a text or insert a variable data field from the VDE panel, for example, IR Text.
4. Highlight the text inserted and select desired Font name and size and choose Font color as **Paper** from the Swatches Panel. After selecting the Font color as Paper, the text will be invisible or disappear [This is an expected behavior and no need to worry].
5. Select the Textbox object using Direct Selection Tool (A) and apply the (SI_IR_Color or SI_IR_2L_Color or SI_IR_DP_Color) SI color from Swatches Panel. For selection of IR colors, refer to the Infrared Color Swatches section in the *VDEUserGuide.pdf*.
6. Save the InDesign document and Export as VPC.

TOP OR 2–LAYER IR MARK

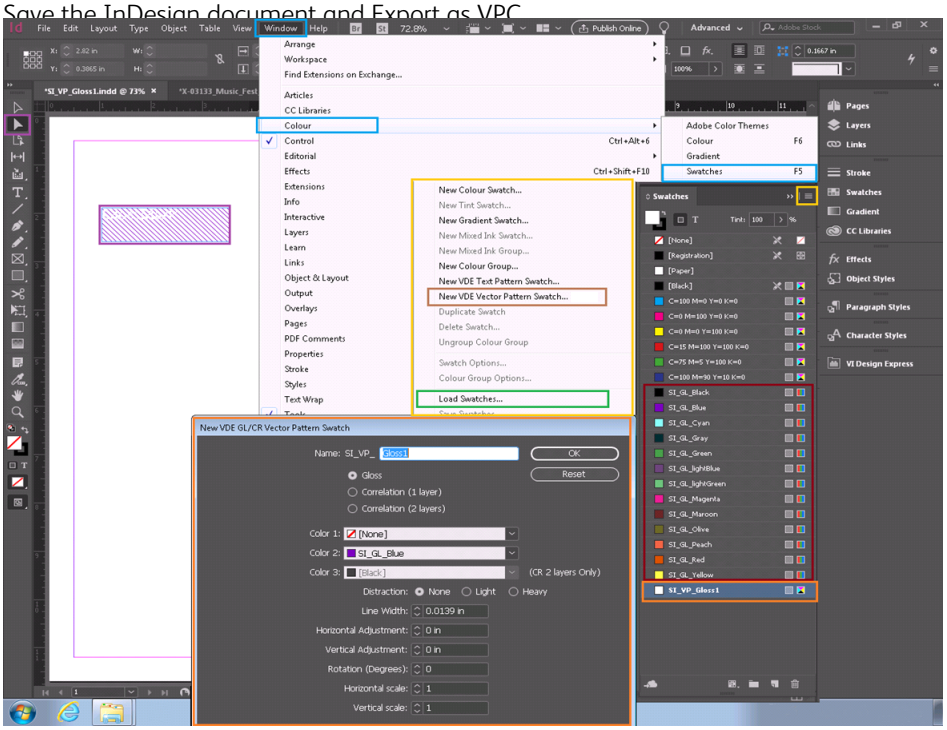
1. Create a new Adobe InDesign document using VI Design Express.
2. Draw a TextBox (same size as of the one Layer) inside the document and type a text or insert a variable data field from the VDE panel, for example, TWO LAYER.
3. Highlight the text inserted and select desired Font name and size and choose Font color as SI_IR_Black, Blue, Green, or Red, for example, SI_IR_Black from the Swatches Panel. For appropriate 2L color selection, refer to the Color swatches for two-layer Fluorescent effect section in the *VDEUserGuide.pdf*.

Note: This 2L text will be visible when you print. [This is an expected behavior and no need to worry].

4. Place the Second Textbox exactly on top of the First Textbox, so that it looks as only one textbox. Use InDesign to Group the two text frame objects.
5. Save the InDesign document and Export as VPC.

Vector Pattern Gloss Mark SI effect

1. Create a new Adobe InDesign document using VI Design Express.
2. Load VIPP_GL_Swatches.ase, then new swatches (GlossMark colors) are loaded and named in the Swatches panel, for example, SI_GL_Blue.
3. Click the top-right of the Swatches panel, click **New Vector Pattern Swatch** to open Vector Pattern dialogue.
4. Enter or select the required values such as, Name (Gloss1), SI effect (Gloss), Color 1 (None or Paper is mandatory), Color 2 (SI_GL_Blue), Distraction (None or Light or Heavy), Linewidth, Horizontal and Vertical Adjustment, Rotation, and Horizontal and Vertical Scale fields, respectively, and click OK to see the new SI_VP created at the bottom of the last SI_GL_Color, for example, SI_VP_Gloss1.
5. Draw a TextBox inside the document and type a text or insert a variable data field from the VDE pane, for example, GlossMark.
6. Highlight the text inserted and select desired Font name and size and choose Font color as **Paper** from the Swatches panel. After selecting the Font color as Paper, the text will be invisible or disappear [This is an expected behavior and no need to worry].
7. Select the Textbox object using Direct Selection Tool (A) and apply the SI_VP_Gloss1 effect from Swatches panel. You must be seeing some diagonal lines drawn on the Textbox.
8. Save the InDesign document and Export as VPC



Artistic Black SI Effect

For creating Artistic Black SI effect, refer to the Artistic Black VDE Text Pattern Swatch section in *VDE User Guide*.

Legacy SI Effects

XEROX® GLOSSMARK® TECHNOLOGY USING SI FONTS

For creating legacy GL mark SI effect, refer to section GlossMark® Text font (deprecated) in the *VDE User Guide*.

LEGACY CORRELATION MARK (1 LAYER) USING SI FONTS

For creating legacy CR mark 1 layer SI effect, refer to section Correlation Mark font (deprecated) in the *VDE User Guide*.

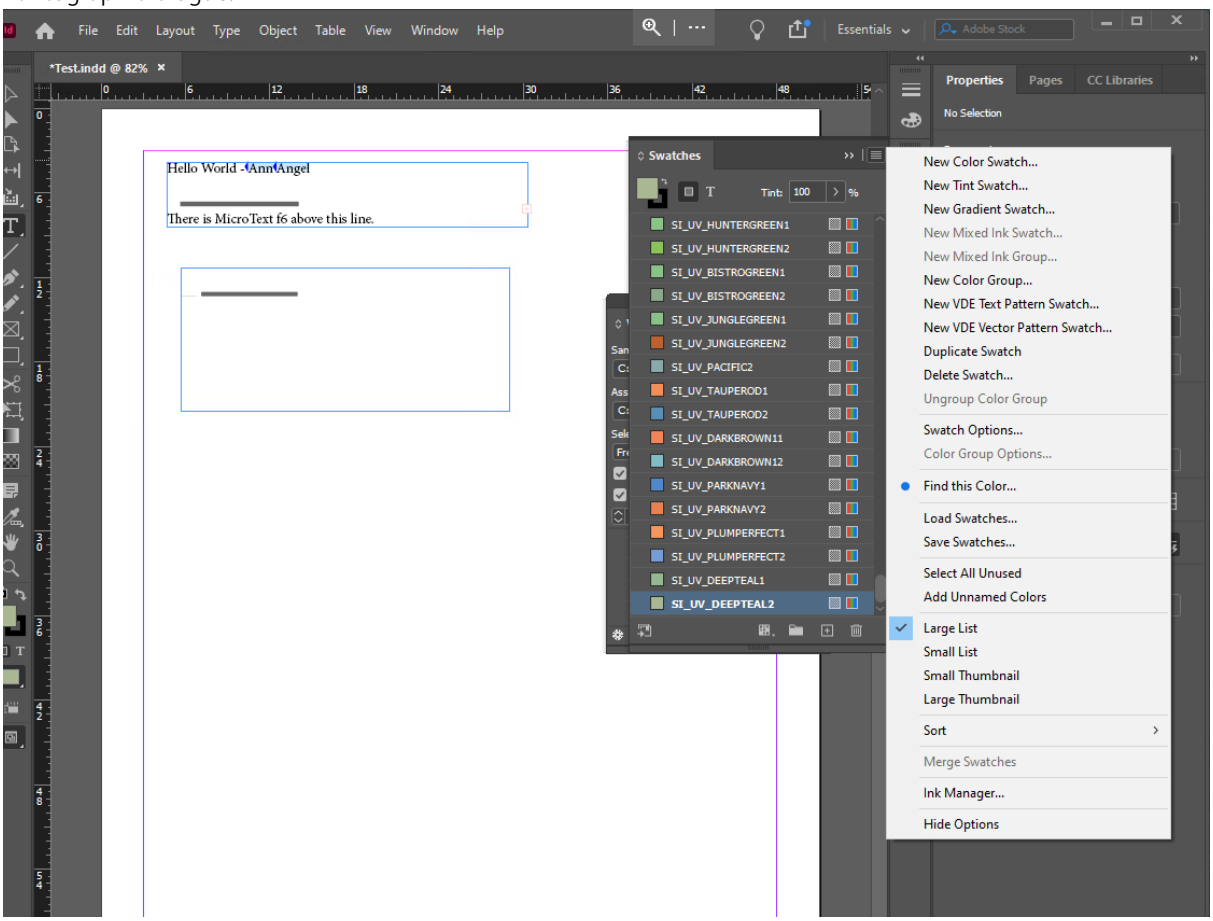
LEGACY CORRELATION MARK (2 LAYER) USING SI FONTS

For creating legacy CR mark 2 layer SI effect, refer to section Correlation Mark font (deprecated) in the *VDE User Guide*.

Void or Variable Pantograph

Note: Pantographs are complex and should only be inserted after a review with your Professional Services or XSA. Any Pantograph should be thoroughly tested on the customer device or similar device. As with all SI effects, usage of pdf is not supported, saved files should be of .ps or .vpc format.

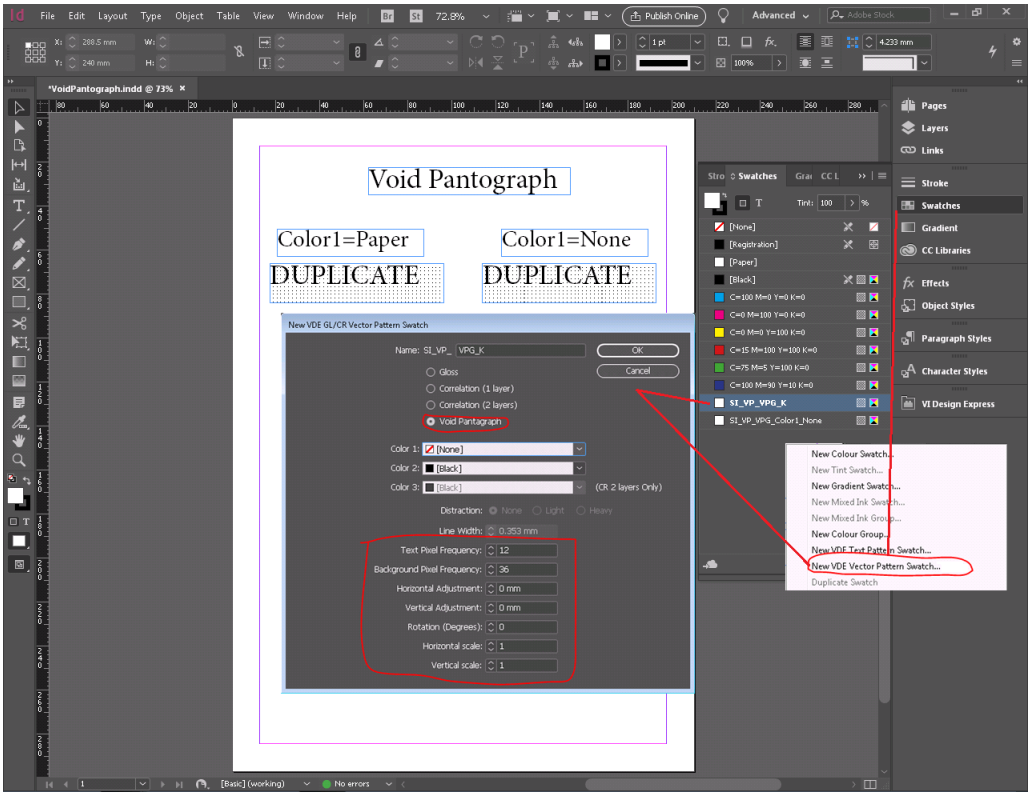
1. Create a new Adobe InDesign document using VI Design Express.
2. Click the top-right of the Swatches panel, click **New VDE Vector Pattern Swatch** to open Vector Pattern Void Pantograph dialogue.



3. Enter or select the required values like Name (VPG_K), SI effect (Void Pantograph), Color 1 (None or Paper is mandatory), Color 2 (Black), Text Pixel and Background Pixel Frequency, Horizontal and Vertical Adjustment, Rotation (degrees), and Horizontal and Vertical Scale fields, respectively and click **OK** to see the new SI_VP created at the bottom, for example, SI_VP_VPG_K.
4. Draw a TextBox inside the document and type a text or insert a variable data field from the VDE panel, for example, VoidMark.
5. Highlight the text inserted and select desired Font name and size.
6. Select the Textbox object using Direct Selection Tool (A) and apply the SI_VP_VPG_K effect from Swatches Panel. You must be seeing some dot pixels drawn on the Textbox.

7. Save the InDesign document and Export as VPC.

Note: The Text Pixel and Background Pixel Frequency shown in the below example may vary from printer to printer. To identify the best range that works for your printer, create a swatch file with different pixel ranges.



SI VP/GL, VP/CR, UV, IR on Monochrome TIFF Images

1. Create a new Adobe InDesign document using VI Design Express.
2. Create different SI swatches for each effect as described in sections below:
   - Single or 1–Layer CR Mark with no Distraction pattern
   - Bottom or 1–Layer UV Mark
   - Bottom or 1–Layer IR Mark
   - Vector Pattern Gloss Mark SI effect with no Distraction pattern
3. Draw Rectangle Frame/Tool inside the document and insert the monochrome images.
4. Select the Rectangle Frame/Tool object using Direct Selection Tool (A) and apply the SI effect from Swatches panel.
5. Save the InDesign document and Export as VPC.

Note: Specialty Imaging effects can only be applied to monochrome TIFF images, and they cannot be applied to grayscale or color TIFF images.

Using SI Effects in a Text Pattern Swatch

Xerox Specialty Imaging effects can be combined with VDE Text Patterns. There are six Specialty Imaging options to select from. Descriptions of these effects and sample Swatch Option definitions are found in these sections. For more information, refer to the *VDEUserGuide.pdf*.

- Artistic Black VDE Text Pattern Swatch
- Fluorescent VDE Text Pattern Swatch
- Infrared VDE Text Pattern Swatch
- Micro Text VDE Text Pattern Swatch
- GlossMark and Correlation Mark Text VDE Text Pattern Swatch

Generation of Print Files from VI Design Express

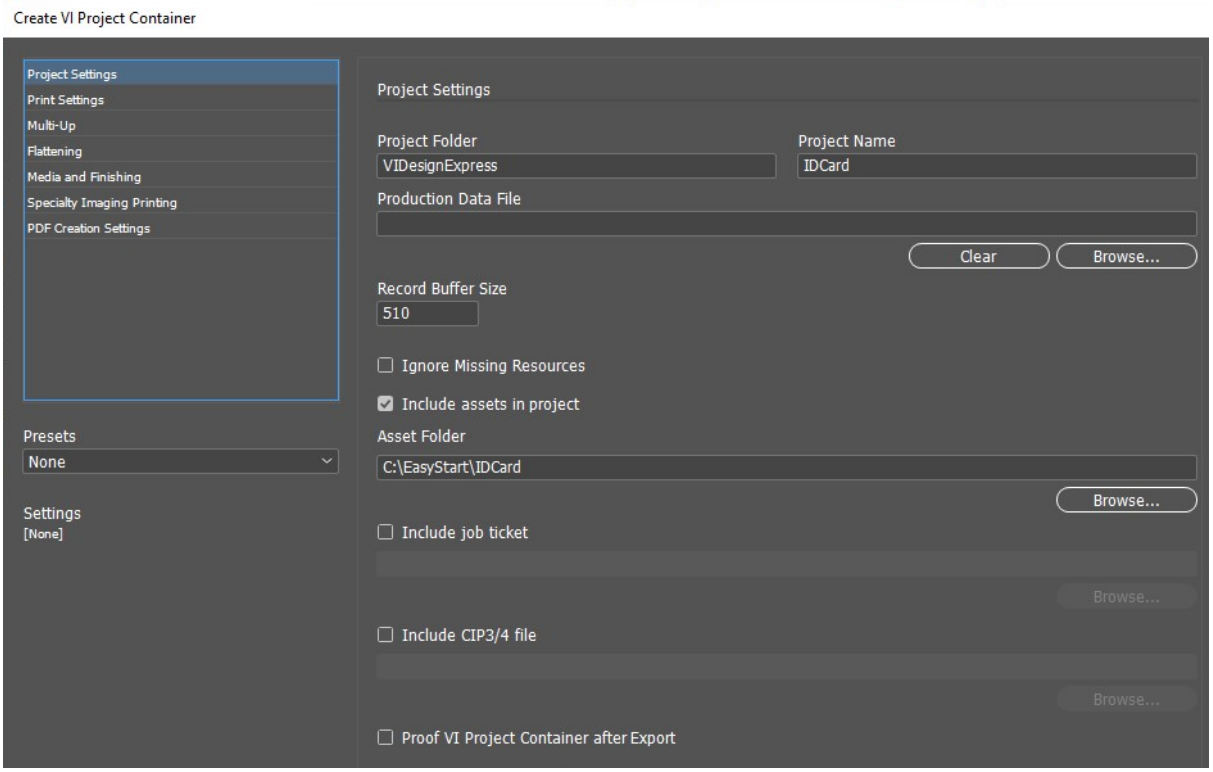
This chapter contains:

Now that you have set up VI printing, you can now send your VI projects or files to a printer to be printed or to a particular file format to be saved. The first two options are available within VDE, and the last option shows how to print from within Fiery direct.

Note: You can also submit jobs from VDE to either FreeFlow Core or to VI eCompose server. For additional information on these options, refer to the *Xerox® FreeFlow® VI Design Express Software User Guide* or any of the EasyStart Application Guides. All the guides can be found at www.xerox.com, under documentation for the Variable Information Suite.

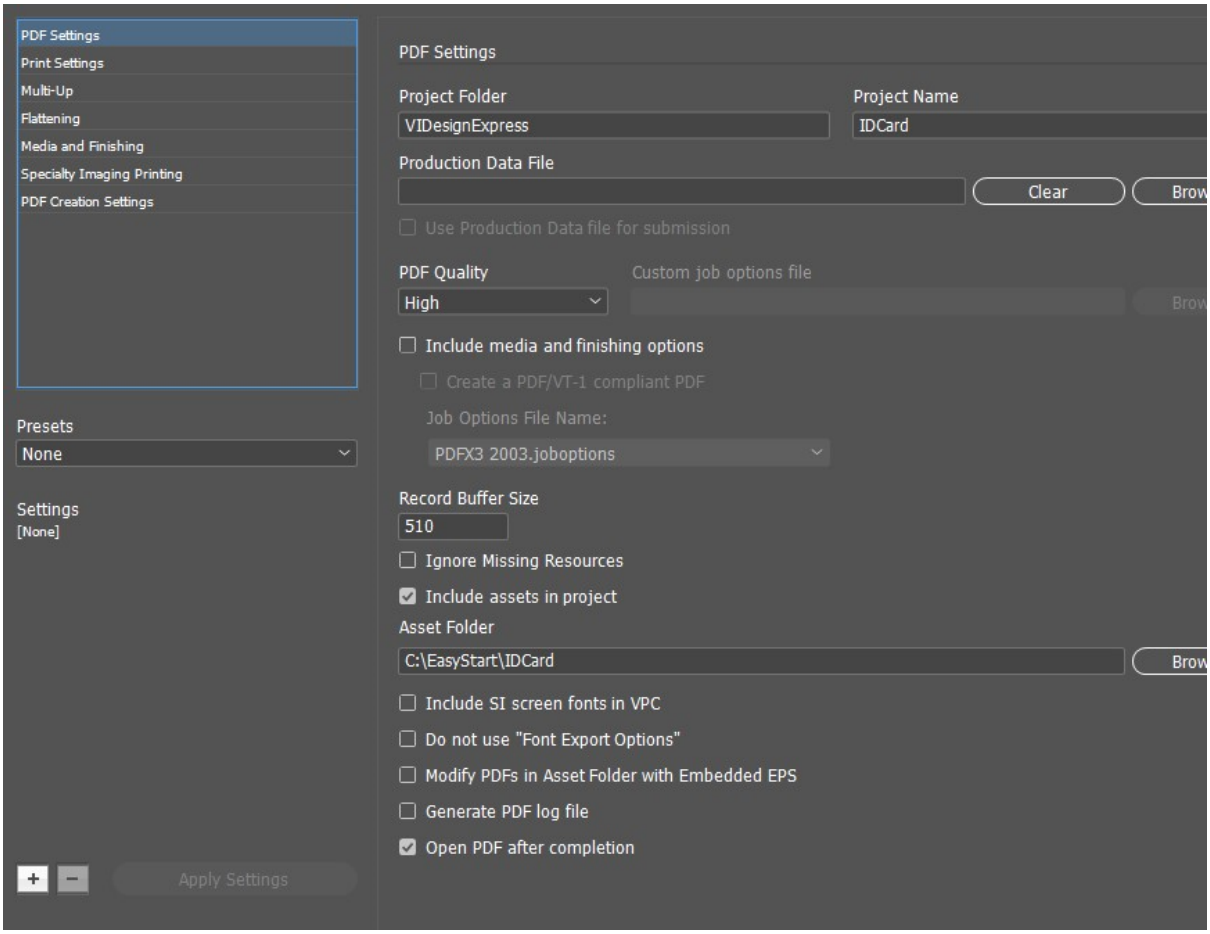
Export as VPC File from VI Design Express

1. In Adobe InDesign, click **File > Export** or Ctrl + E.
2. Select **Save As Type > VI Project Container**.
3. Enter required details in **Create VI Project Container > Project Settings**, such as Project Folder and Project Name.
4. Select **Include assets in project > ON** to browse and select the **Asset Folder** used for SI project.
5. Enter other necessary details as required for SI project in Print Settings, Multi-Up, Flattening, Media, and Finishing sections.



Export as VI PDF from VI Design Express

1. In Adobe InDesign, click **File > Export** or Ctrl + E.
2. Select **Save As Type > VI Design Express PDF**.
3. Enter required details in **Create VI Design Express PDF > PDF Settings**, such as PDF Quality and Custom job options file, for example, `C:\VDE\normalizer\Settings\Standard.joboptions`.
4. Select **Open PDF after completion > ON** to open PDF.
5. Enter other necessary details as required for PDF in Print Settings, Multi-Up, Flattening, Media, and Finishing sections.

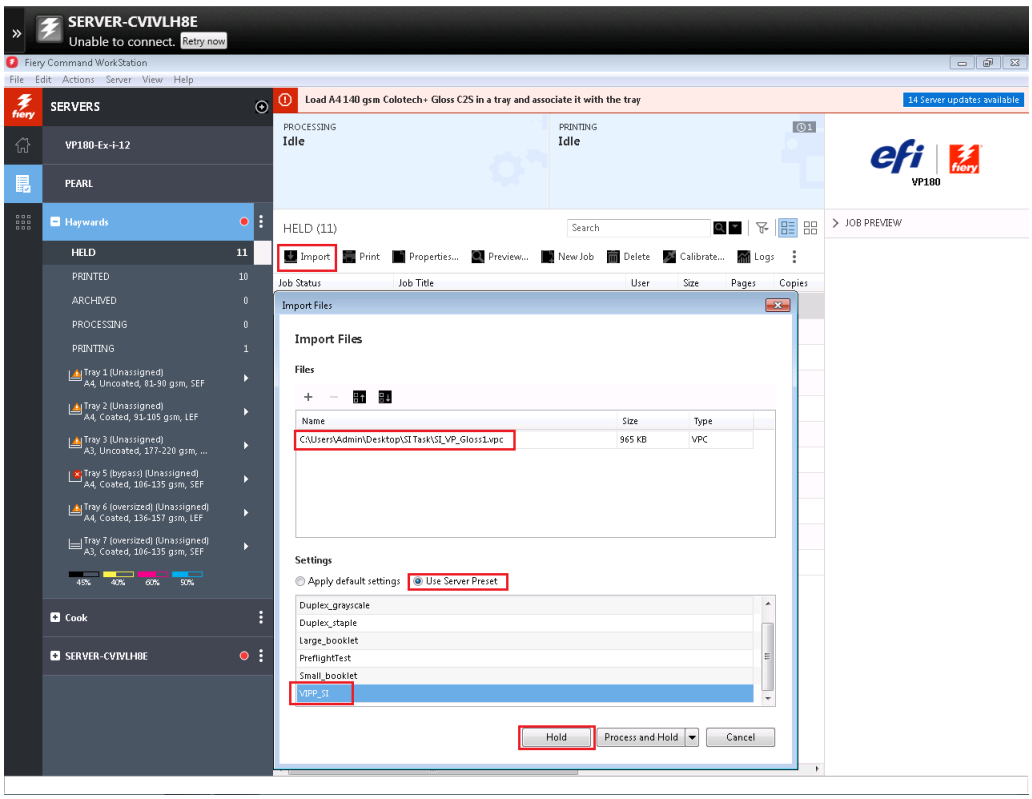


Submission to DFE

Your VI job can be submitted for printing in different ways. The first way is to set up the DFE. It can be done directly through Fiery's Command Workstation as shown in the below procedure. The second way is that you can also submit or save your VI jobs directly from VI Design Express. For additional information on how to perform this procedure, refer to VIPP Job Submission to FreeFlow Core section in *VI Design Express User Guide* or *VI Suite EasyStart Application Guides*.

FIERY SERVER IN COMMAND WORK STATION

1. Open Fiery in Command Work Station.
2. Click **Import > Browse** to select the VPC file (SI_VP_Gloss1) located locally.
3. Under settings, click **Use Server Preset** radio button and select VIPP_SI preset already created.
4. Click **Hold** button to submit the VPC file to Hold queue or select other options.



Specialty Imaging Validation Techniques and Recommended Devices

The following section briefly describes each specialty effect and how to see and validate each one.

Micro Text

A loupe or magnifier glass must be used to read the Micro Text.

CR/Correlation Mark Text Legacy and Vector Pattern

The content is not visible unless it is superimposed by a key transparency. For a 2-layer CR effect, when the key is used one way the first message is viewable. If the key is flipped or rotated the second string becomes visible.

UV/Fluorescent Mark Text

The text becomes visible under UV (black) light. A 2-layer UV effect is also available where a visible second string can be printed on top of the effect. When a UV light is used to illuminate the effect, the visible string fades to reveal the underlying hidden text string.

Infrared Mark Text

IR text is printed in a way that the content is virtually invisible under normal light but becomes visible under infrared light. A 2-layer IR effect is also available, where a visible second string can be printed on top of the effect. When an IR light source is used to illuminate the effect, the visible string fades to reveal the underlying hidden text string.

GlossMark Text Legacy and Vector Pattern

When viewed straight on, GlossMark Text is not visible. But as the printed page is tilted in 45 degrees and viewed at different angles in the light, the glossy content is revealed.

Artistic Black

When viewed straight on, Artistic Black Text is not visible. But as the printed page is tilted in 45 degrees and viewed at different angles in the light, the gloss/matt content becomes visible.

Void Pantograph

The text or image becomes visible only when it is scanned or copied from the original Print of the VI PDF or VPC.

Helpful Hints, Considerations, and Recommendations

- Do not apply any Text Fitting options to Micro Text, UV, and IR Specialty Imaging effects.
- You can use the Repeat Data Transform option with any standard font and apply the option to the SI Micro text, where it is recommended to always repeat a text string. The repeat value must be between 2 and 10,000.
- Microtext requires a smooth media to print on. Excessive fiber in the paper can make some micro characters unreadable, therefore the repetition of text items is recommended.
- For GlossMark Text and Correlation Mark Text it is recommended that you apply the text fitting option "Stretch in width." This will maintain the text effect at the current text frame width. While the visual appearance on the screen may look stretched, when printed the effect will print correctly.
- If you do not apply the Stretch in width option, the length of the GlossMark Text or Correlation Mark Text effect will grow and shrink based on the number of characters in the string being printed. Do not use Fit in width as this will distort the effect.
- As with all SI applications, test the application to validate the effect meets the design specifications and print performance. If required, print this patch book (FreeFlow VI Specialty Imaging Test Cases) to the target print device and review the output in FreeFlow® VI Suite Test Cases –FreeFlow Variable Information Suite – Xerox . This will help you select the SI effects and SI colors that work best for your application on the target print device. For more details, refer to SI Customer Report document, which contains a list of previously tested printers using FreeFlow VI Specialty Imaging Test Cases (`*.vpc` files) in FreeFlow® VI Suite Specialty Imaging Customer Report – FreeFlow Variable Information Suite – Xerox.
- Ensure to set up SI_Q and use it for any SI effects printing on your IOT or DFE. Use .vpc not .ps or .pdf for SI.

Printer Support Restrictions and Limitations

The use of Specialty Imaging can add a level of complexity to page processing on the printer that in certain circumstances can exceed the limitations of the printer. Thus, the effects cannot be guaranteed to work in all applications. SI is not validated on all office printers due to this restriction. The amount of Specialty Imaging effects on a page, the size of the effect and the media can all affect the look of the printed output. It is highly recommended that you review the Specialty Imaging section of the *FreeFlow VI Compose User Guide*, and that you test the application prior to running in production mode. Also refer to *FFVI_DesignExpress.pdf* or *en_VDEUserGuide.pdf* for more details.

For additional details on what printers are supported, refer to the Printer Support section in FreeFlow® VI Suite v18.x What's New Document –FreeFlow Variable Information Suite – Xerox.

Specialty Imaging Effects

This appendix contains:

Without the use of specialty inks or paper, Xerox print devices, the actual imaging engine, support five SI effects, plus additional extensions of these effects using Patterned Ink, Vector Pattern, and Variable Pantograph. Not all effects are supported on all devices, and not all colors fonts or patterns or effects will print the same across different print engines. So, perform your own testing and due diligence to ensure good results. If you have questions, contact your Xerox team, we will be glad to assist you.

SI effects can be used to provide low-cost document security or novelty effects designed to grab the reader's attention. While the effects may be reproducible on a good copier, by combining multiple effects with variable data, it becomes much more difficult to change or modify any of the SI effects without destroying the visual appearance. In addition, some effects can be hidden, or are not obvious to the casual observer. Also, some effects only function within certain printers, colors, and swatches which is why you should review the SI Customer Report to detect known good working selections. Examples are the two-layer UV or IR effects. CR and Variable Pantograph (VPG) require a background.

For more details, refer to SI Customer Report document, which contains a list of previously tested printers using FreeFlow VI Specialty Imaging Test Cases (`*.vpc`files) in FreeFlow® VI Suite Specialty Imaging Customer Report – FreeFlow Variable Information Suite – Xerox.

SI effects are especially useful in applications, such as parking passes, lottery and event tickets, Diplomas, degrees, DMV documents, ID Cards, or other types of personalized promotional documents that would benefit from some level of fraud protection. Xerox® VIPP® Language Specialty Imaging can provide this added protection at a low cost without the need to add additional hardware, toner, special paper, or expensive postprocessing equipment.

SI effects add the ability to enhance the design by including text that can only be viewed under special circumstances. These effects are achieved using color, media, and Xerox technology. Specialty or Security Imaging effects can only be reproduced when printed using the VIPP application, they are not reproducible when viewing on the screen.

SI effects are based on technologies used to embed an alphanumeric string into a print pattern in such a way that the string is indecipherable under normal viewing conditions, but, becomes visible under special viewing conditions, or with the aid of simple tools such as a loupe, UV light or infrared camera or when the page is copied. Due to the unique properties of the Specialty imaging fonts and colors, not all fonts and SI colors will work equally well across all Xerox production devices nor on all types of media. It is highly recommended that you use VDE to create a patch book of the effects you are interested in, using a combination of different font families and SI colors. Print this patch book to the target print device and review the output. This will help you select the effects and SI colors that work best for your application on the target print device. For more details, refer to FreeFlow® VI Suite Specialty Imaging Customer Report - FreeFlow Variable Information Suite - Xerox.

For a complete list of printers supported, refer to the Printers Supported section in FreeFlow® VI Suite v18.x What's New Document – FreeFlow Variable Information Suite – Xerox.

Additional information about the VIPP® Specialty Imaging support for these printers can be found at www.xerox.com. Select **Customer Support > All Support and Drivers**. For product type, select **Software & Platforms**, then select **FreeFlow > FreeFlow Variable Information Suite**. Refer to FreeFlow® VI Suite Specialty Imaging Customer Report - FreeFlow Variable Information Suite - Xerox.