

# How-to:

## Automate offline finishing with Duplo finishers

Part 3: Create a custom imposition  
layout with finisher settings for the  
Duplo DC-618 Slitter/Cutter/Creaser



## Part 3: Create a custom imposition layout with finisher settings for the Duplo DC-618

### Feature overview

Fiery® Impose is the most intuitive PDF-based sheet imposition software on the market. Tight integration with Fiery Command WorkStation®, makeready software, and prepress tools helps automate print job submission.

Fiery Impose templates allow users to save the most common job layouts to automate the imposition process. Templates can also include barcodes and registration marks. These are recognized by the barcode scanner in Duplo finishing equipment using the \* JobID \* format.

The barcodes and registration marks instruct the Duplo finisher on how to position blades, cutters, and creasers to finish the document.

Integrating Fiery Impose with Duplo finishers brings dramatic productivity gains to job preparation and finishing by automating the process. This saves time plus minimizes waste and errors.

This how-to guide is divided into the following three parts:

- **Part 1: Use templates from the library to automate most common jobs**

Part 1 provides a set of common Fiery Impose templates that include Duplo barcodes. The templates can be imported in the Duplo finisher equipment and used to make the printed output ready for finishing.

This feature is compatible with Duplo DC-615, DC-616, DC-618, DC-645, DC-646, DC-745 and DC-746 offline finishers.

- **Part 2: Create a custom layout to automate a coupon job**

Part 2 provides the steps to create a new layout on the Duplo finisher controller. This layout can be imported in Fiery Impose so that users can create a template to automate future jobs from job submission to finishing.

This feature is compatible with the Duplo DC-618, DC-646 and DC-746 offline finishers.

- **Part 3: Create a custom imposition layout with finisher setting for the Duplo DC-618**

Part 3 provides a simplified prepress setup for a custom job using integration for Fiery Impose and the Duplo DC-618 Slitter/Cutter/Creaser. A new finisher preset layout can be created in Fiery Impose and published to the Duplo controller. A preset layout created in the Duplo controller - as shown in Part 2 - can also be imported to Fiery Impose so that users can create a template to automate future jobs from job submission to finishing.

This feature is compatible with the Duplo DC-618 Slitter/Cutter/Creaser nearline finisher.

## Part 3: Create a custom imposition layout with finisher settings for the Duplo DC-618

### Objectives

- Fiery Impose preferences configuration for Finisher integration.
- Create a new finisher preset layout using the Create Finisher Preset wizard within Fiery Impose.
- Apply imposition to a finisher preset layout and publish it.
- Receiving the preset layout on Duplo DC-618 Finisher Controller to print.
- Import an existing layout preset from the Duplo finisher controller to Fiery Impose.

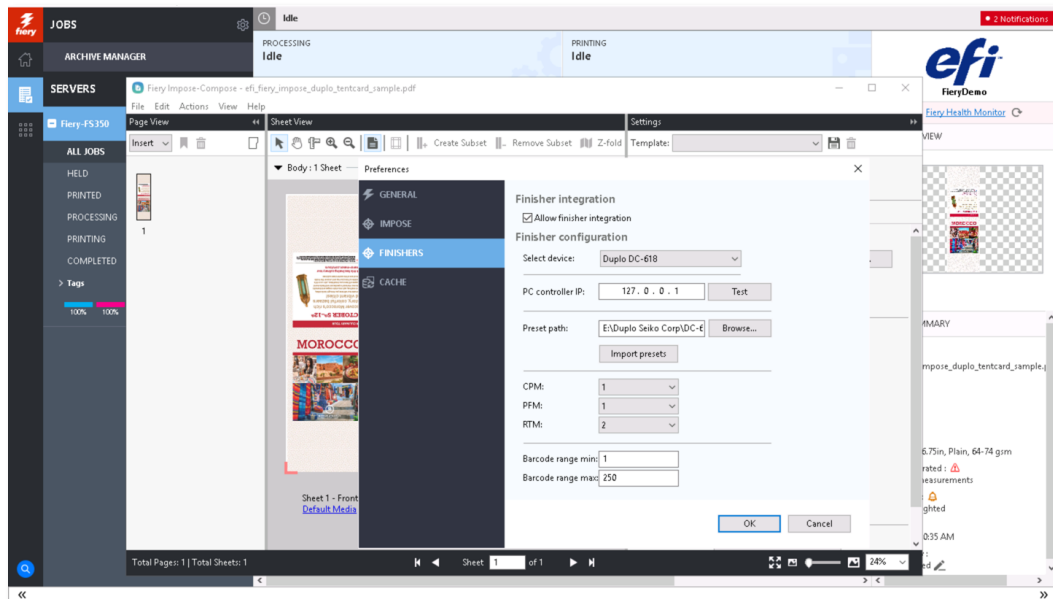
### Additional resources

For additional software downloads, training resources, and more, go to [Fiery Online Resources](#).

### Before you begin

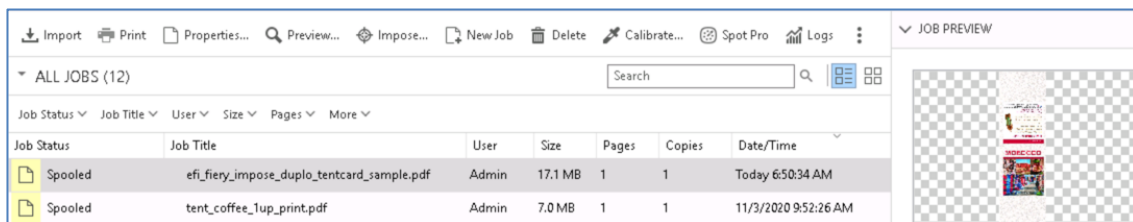
- In case you do not have the Duplo DC-618 Controller configured in your network, follow the instructions in the How-To Guide below, before using this Part 3 guide:  
**One-time setup configuration for Duplo DC-618 finisher integration with Fiery Impose.**
- Open Fiery Command WorkStation 6.6.0.456 or later and connect to at least one Fiery server running Fiery FS150.
- Place the sample file, **efi\_fiery\_impose\_duplo\_tentcard\_sample.pdf**, in the Fiery server HELD queue by dragging the file. Or use the Command WorkStation Import menu option.
- Ensure that the printer and Fiery server have been calibrated before printing any output.

### Fiery Impose preferences configuration for finisher integration

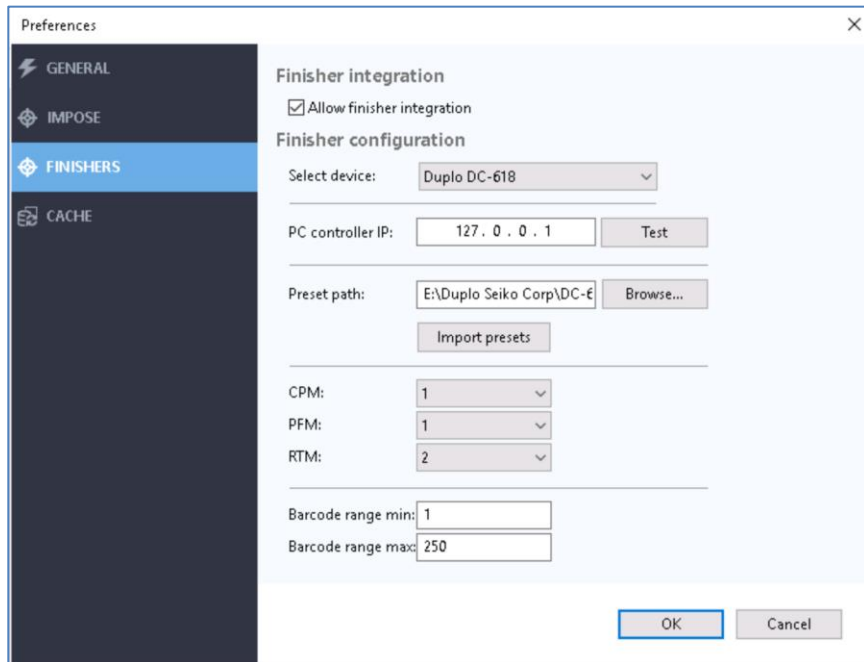


To start using this Duplo Finisher integration, select Duplo DC-618 as the preferred finisher device in Preferences.

1. To begin, place the **efi\_fiery\_impose\_duplo\_tentcard\_sample.pdf** file in the Held queue of the Fiery server using Command WorkStation.



2. Right-click on the sample file and select the **Impose...** option from the context menu.
3. Click the Edit menu and select the Preferences option.
4. Then, select the **FINISHERS** tab to enter to the finisher integration setup.
5. Select the **Allow finisher integration** checkbox to enable the finisher configuration.

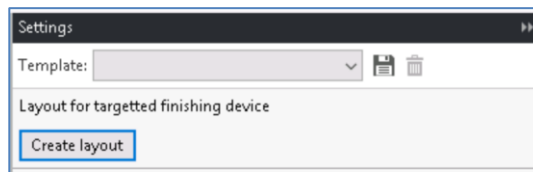


6. Use the **Select device** drop-down list to choose the **Duplo DC-618**.
7. Enter the Duplo **PC controller computer IP** number here to be tested.
8. Then click the **Test** button to check if the finisher controller is reachable through your network. The test will run, and if it finds the finisher controller, it will show a **Pass** message window to confirm the connection.
9. **Note:** The **Preset path** field is used to connect to the Duplo finisher controller to enable additional presets to be stored there, and they can be imported using the **Import presets** button in Fiery Impose. This will be covered later in this guide.
10. The **CPM**, **PFM**, and **RTM** modules devices configuration options here are used to define the number of Crease, Perforation, and Fold available at the Duplo DC-618 for use.
11. The **Barcode range** fields are used to define the **minimum** and **maximum** number range that will be available for the barcode for a specific DC-618.  
  
Note: Make sure that the barcode ranges matches the range configured on the DC-618 Unit. You will not be able to create a new finisher layout if the DC-618 unit does not match.
12. To finish the preferences configuration, click the **OK** button.
13. Note: Once the preferences settings are confirmed, you need to close the Fiery Impose window so that any configuration changes will be applied the next time that Impose is opened. Close the Fiery Impose now and start it again before creating a new finisher preset layout.

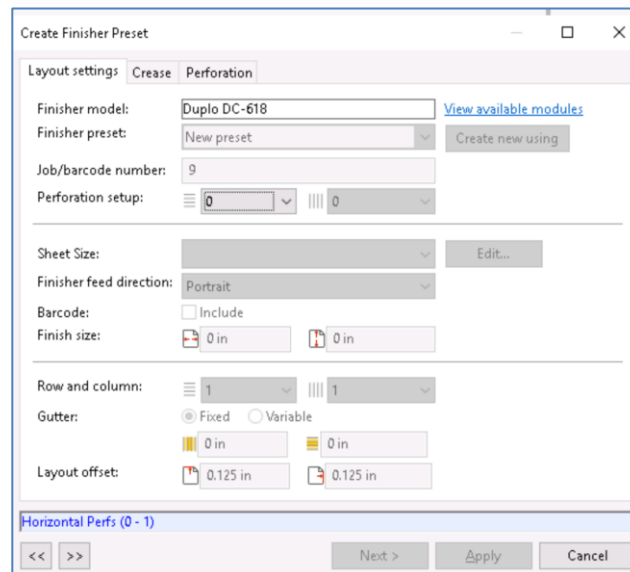
## Create a new finisher preset layout using the Create Finisher Preset wizard

In this section, you will see how to create a new Preset Layout for your print document that will use the Duplo DC-618 Slitter/Cutter/Creaser.

1. Locate **efi\_fiery\_impose\_duplo\_tentcard\_sample.pdf** in the Held queue of the Fiery server using Command WorkStation and right-click on it.
2. Choose the **Impose...** option from the context menu.
3. The Fiery Impose window will open. Click the **Create Layout** button in the Setting panel to start.



4. The Create Finisher Preset wizard window will present three tabs for the preset configuration: Layout settings, Crease, and Perforation tabs.



5. **Note:** This wizard is designed to guide the user to enter the required fields in its sequential order. Going by this sequence will ensure the finishing parameters are set correctly for the finisher. At the bottom of the window, acceptable value range for each field are shown in blue. They will change as you move from field to field.
6. Use the tab key to move to the next field. Back and forward navigation buttons at the bottom of the window can also be used to move across the fields.
7. Once all the required fields are completed, you can move to the next tab. Use the Next > button to go to the following tab or click the Apply button to finish your edits and exit the wizard.

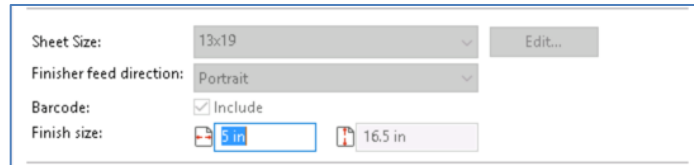
8. In this wizard, the Finisher model DC-618 defined in the Preferences, comes pre-filled. The **View available modules** link shows the number of device modules that are configured for this equipment. By default, the **Finisher preset** shows the **New preset** option. Use this option to create a new preset from scratch. Click on the **Forward Navigation button** to move to the following field, or alternatively, you can use the **Tab** key.

9. **Note:** You may also choose one of the existing presets from the drop-down list, and adjust if needed. Or you can create a new preset based on an existing preset's values by clicking the **Create new using** button.
10. Fill in the **Job/Barcode number** with the correspondent ID that will be used for the Duplo finisher controller to identify this finisher setup. For instance, type **12**, and then click on the **Tab** key or **Forward Navigation button** again.
11. For the Perforation setup, you can leave the Horizontal field as 0, and for the **Vertical** field type **1**, then move to the next field.
12. Now, choose the sheet size for this job. Select the **13x19** option from the drop-down list, and notice that the preview automatically adjusts the print document into the sheet size.

13. **Note:** You can also use the **Edit** button to choose a specific Media from the Paper Catalog.
14. Leave the Finisher Feed direction as **Portrait**.
15. Select the **Include Barcode** checkbox to apply the barcode impression on the sheet.

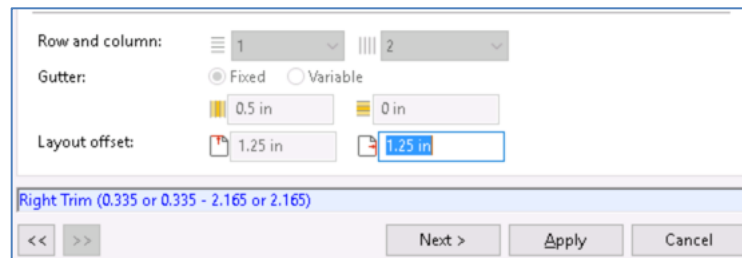


16. Fiery Impose uses the finishing information from the PDF file, so confirm the Finish size values: **5** inches for Finish Width, and **16.5** inches for the Finish Height.



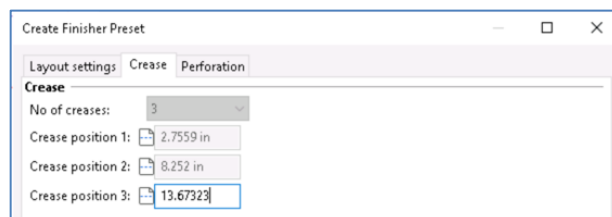
The screenshot shows a dialog box with the following settings: Sheet Size: 13x19 (with an Edit... button); Finisher feed direction: Portrait; Barcode: [x] Include; Finish size: 5 in (width) and 16.5 in (height). The '5 in' field is highlighted with a blue selection box.

17. In this layout, the Tent Card will be printed twice on this sheet, so leave the Row value as **1**, and change the **Column** value to **2**. Notice that the preview is adjusted to 2 columns automatically.
18. Don't change the Gutter values. Leave the **Fixed selection**, and Fixed Gutter Slit as **0.5** inches, and the Fixed Cutter Cut as **0**.
19. Here, you can also confirm the Layout offset values as they are: Lead Trim and Right Trim as **1.25** inches.



The screenshot shows a dialog box with the following settings: Row and column: 1 (rows) and 2 (columns); Gutter: [x] Fixed, [ ] Variable; Gutter: 0.5 in (slit) and 0 in (cutter cut); Layout offset: 1.25 in (lead trim) and 1.25 in (right trim). The '1.25 in' field for right trim is highlighted with a blue selection box. At the bottom, there is a text field containing 'Right Trim (0.335 or 0.335 - 2.165 or 2.165)' and buttons for '<<', '>>', 'Next >', 'Apply', and 'Cancel'.

20. At this point you can go back to the previous field, or move to do the Crease and Perforation configuration. Also, hit the Apply to finish the edition going back to the Imposition layout edit, or hit the Cancel button and exit ignoring any changes made. Click the **Next >** button to continue.
21. In the **Crease** tab choose the number of creases needed for the job. You can choose up to 20 creases in this layout. Select **3** in the combo list.
22. Now, enter the crease positions. Crease position number **1** is **2.7559 in**. Position **2** is **8.252 in**, and Position **3** is **13.632**. Notice that the preview shows the defined crease locations.



The screenshot shows the 'Create Finisher Preset' dialog box with the 'Crease' tab selected. The settings are: No of creases: 3; Crease position 1: 2.7559 in; Crease position 2: 8.252 in; Crease position 3: 13.67323 in. The '13.67323 in' field is highlighted with a blue selection box.

23. Click on the **Next >** button to continue.
24. Now, for this Tent Card sample, you will add one Vertical perforation. In the Module type list select the **RTM** option.



The screenshot shows the 'Create Finisher Preset' dialog box with the 'Perforation' tab selected. Under 'Horizontal perforation', 'No of horizontal perforation' is set to 'None', 'No of patterns' is 'None', and 'Tool ID' is 'None'. Under 'Vertical perforation', 'Module type' is 'RTM', 'No of vertical perforation' is '1', and 'RTM L/R' is set to 'Perf' for both left and right sides.

25. Then go to RTM L/R (Left and Right) and leave the **Perf** options as they are. Here it is where you can choose the different types of perforation styles that are available on the Duplo DC-618.

**Note:** It is important to note that you will need to define only one perforation for this Tent Card. Fiery Impose will automatically apply the same finishing to the second Tent Card in this layout.

26. Leave the No. of vertical perforations as 1.
27. In the Pattern 1 definition section, set the x coordination for the perforation line in **X1R field** and **enter 2.5 inches**.

The screenshot shows the 'Pattern 1 definition' section. 'X1R' is set to '2.5 in', 'Position' is '0 in', and 'X1L' is '0 in'. The 'Segments' dropdown is set to '2'. The 'End' positions are '15.5 in' for X1R and '16.5 in' for X1L.

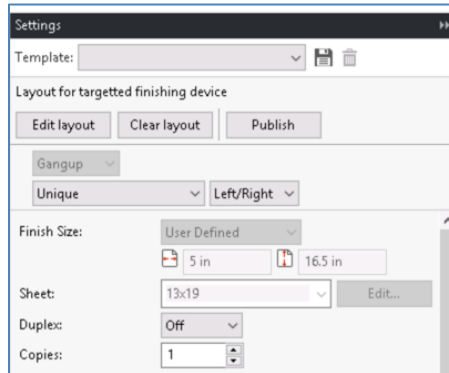
28. Select **2** in the **Segments** drop-down list. This will allow you to create two perforations on both sides of the Tent Card.
29. For the first perforation segment, **enter 0** for the y-coordinate.
30. The end y-coordinate for this first perforation segment is **1.752 in**.
31. Now for the second perforation position, enter **15.5 inches** as the start position.
32. This second perforation will end at **16.5 in**.

This screenshot shows the 'Create Finisher Preset' dialog box with the 'Pattern 1 definition' section visible. The 'X1R' field is set to '2.5 in', 'Position' is '0 in', and 'X1L' is '0 in'. The 'Segments' dropdown is set to '2'. The 'End' positions are '15.5 in' for X1R and '16.5 in' for X1L. On the left, there is a preview of the layout showing a tent card with the word 'MOROCCO' and a picture of a tent. At the bottom, there are buttons for '<<', '>>', '< Back', 'Apply & Publish', 'Apply', and 'Cancel'.

33. Now, click to the **Apply** button to exit the Preset Layout window. You can Publish it and save it later to the Duplo finisher controller after finishing the imposition.





## Apply the imposition to a finisher preset layout and publish it

Now that you have a preset layout defined for the Duplo DC-618, you can adjust the imposition settings as you normally do for any job in Fiery Impose.

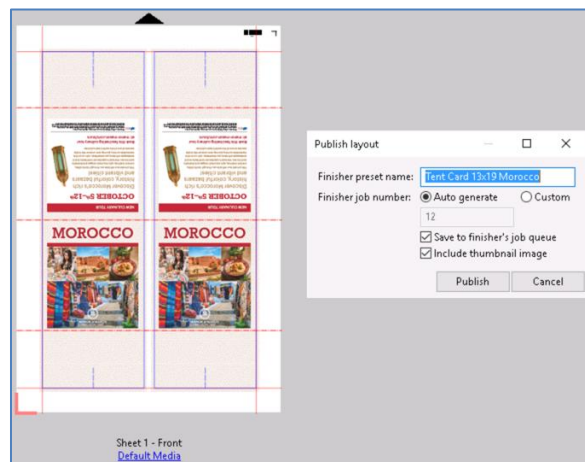


1. First, select the intent drop-down list and choose the **Repeat** option. You will see that the preview shows a second Tent Card in the sheet view panel, as it will be printed.

**Note:** At the bottom of the Settings panel, you will notice a new Preset validation information section. Errors need to be corrected before a Preset can be sent to the Duplo controller. This screenshot only shows a warning that may need operator attention.

Imported Layout: New preset*		
Type	Description	
	Job requires 1 feed direction perforato...	
	Job requires 1 slitter modules.	
	Media weight failed. Its value is: 64.00 ...	
	No Errors	

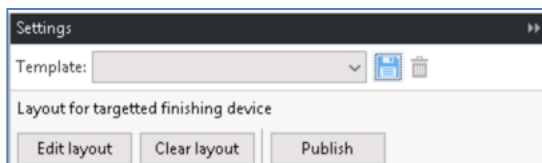
2. Click on the **Publish** button in the layout creation area of the settings panel to publish this Preset to the Duplo controller.



3. In the new pop-up window enter the desired finisher preset layout name that will be visible to the Duplo controller: **Tent Card 13x19 Morocco**.

## How-to: Part 3: Create a custom imposition layout with finishing setting for the Duplo DC-618

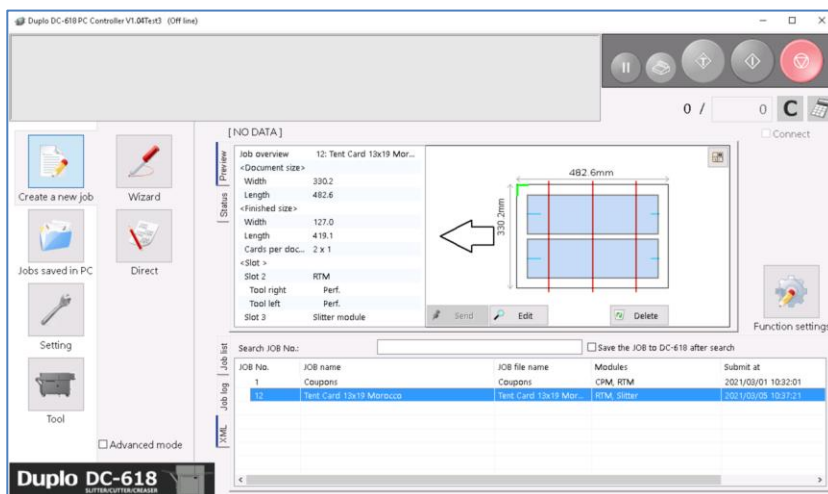
- The barcode number is retrieved from the preset layout definition. Select the check boxes to save the job to the finisher's queue, and to include the thumbnail image. Click the **Publish** button to confirm.
- After a finisher layout preset is created, this layout can be saved as a Fiery Impose template so that it can be used for future jobs. The Fiery Impose template can integrate with Fiery workflow automation applications such as Fiery Hot Folders, and Fiery JobFlow to automate the imposition for future jobs. To create a new Impose template, **click on the disk icon** located on the top of the settings pane.



- In the Save Template pop-up window, add the template's name - type **Tent Card 13x19 DC-618**.
- Then hit the **Ok button** to confirm. The Fiery Impose template has now been saved. All the preset info is saved with the Impose template.

## Receiving the preset layout on Duplo DC-618 Finisher Controller to print

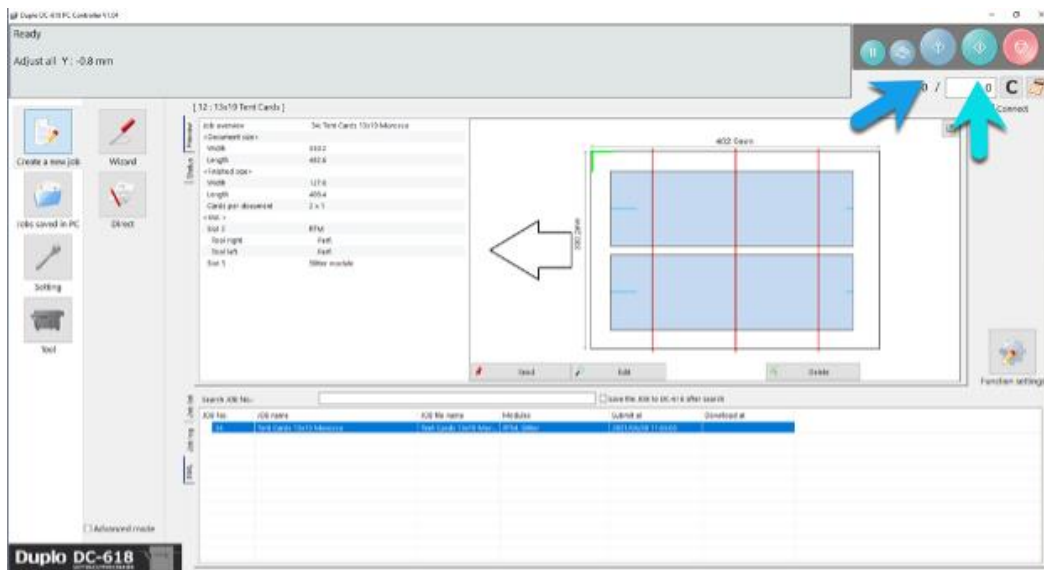
- Open the DC-618 Controller** software to check that the new preset job is added and stored under the 'XML' tab queue.
  - When the Finisher preset is sent to the DC-618 PC Controller, it is stored under the tab 'XML' queue. The job layout can be previewed in the image section of the PC Controller
  - With the job selected, users can choose to '**Send**,' '**Edit**' or '**Delete**' the preset job.



- When '**Send**' is selected, the preset job will be saved onto the PC Controller as an official job. This will override any previously stored job for that particular number.

## How-to: Part 3: Create a custom imposition layout with finishing setting for the Duplo DC-618

- When **'Edit'** is selected, the user can edit the parameter of the preset job.
- And, when **'Delete'** is selected, this will permanently delete the preset job from the job queue and Server.
- Finally, when the preset job template is ready to run. The user can choose to click the blue button on the upper right hand corner to **'Test'**, or the green button, to **'Run'** the preset job template on the DC-618.

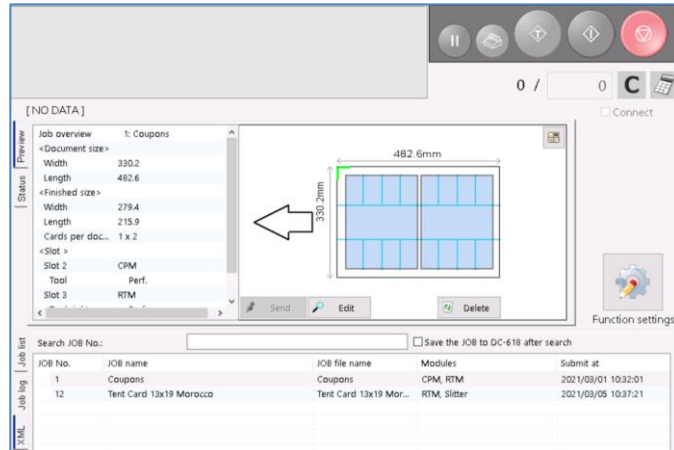


- This is the final Tent Card printed and finished using the preset layout.

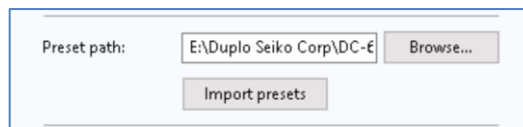


## Import an existing finisher layout preset from the Duplo controller to Fiery Impose

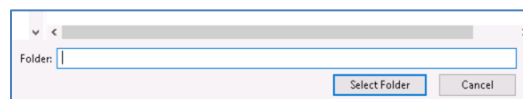
In case that you already have finishing layouts created in the Duplo Controller, you can import them into Fiery Impose and make edits.



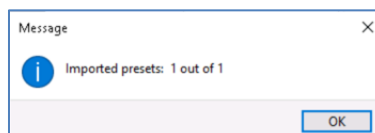
1. You can import any preset using the **Import presets** button from the **Finisher** option in the **Fiery Impose Preferences** window.



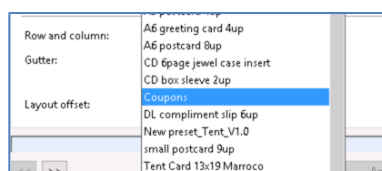
2. After clicking the Import presets button, you need to select the folder where the preset is located using the **Select folder** button.



3. If any new presets were found in that folder, the system will confirm how many were imported in a new window **Message**.



4. Now the preset will be listed in the **Finisher preset** list of the **Create Finisher Preset** wizard, and can be used in a new imposed job.



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