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Stripping for JDF 1.2 Application Note
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Abstract

This Application Note describes how pagination in a Stripping device works and contains recommendations as to how to paginate using JDF 1.2. The main interest is for Stripping consumers, but understanding the pagination method may be of interest for Stripping producers as well.

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65 1 Pagination

66 A **Stripping** device converts a **StrippingParams** resource into a **Layout**, through which an **Imposition** device
67 can flow pages in a straightforward manner. During **Stripping**, the device adds cell numbers to each
68 **BinderySignature** if they are not yet specified and it renumbers the **BinderySignatures** using the order
69 specified in the **Assembly**. The next two sections elaborate on each of these steps.

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71 1.1 Renumbering BinderySignatures

72 The **StrippingParams** resource places multiple **BinderySignatures** onto sheets. It is up to the **Stripping** device to
73 renumber the **BinderySignatures**. The value of **Assembly** /**@Order** determines how the renumbering happens.
74 When **Assembly** /**@Order**="None", the order of the sections is unspecified and renumbering happens as follows:

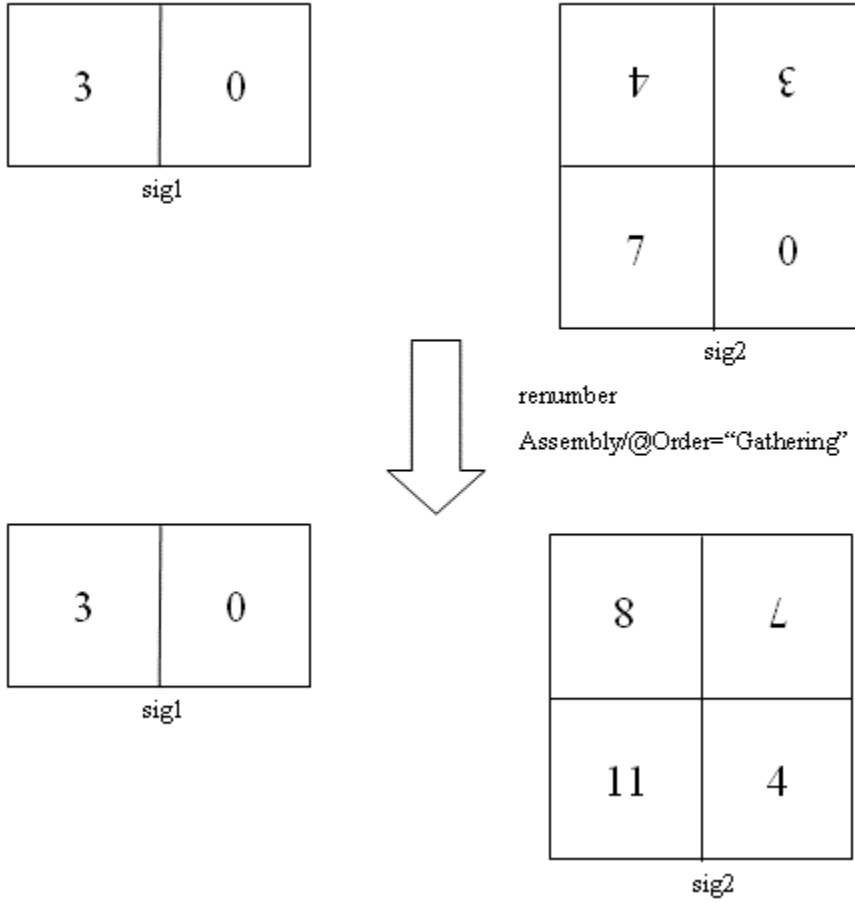
- 75 • For **BinderySignatures** based on **SignatureCells**, no renumbering happens.
- 76 • For other **BinderySignatures**, it is common practice to renumber according to the Gathering order.

77 The figure below illustrates a product with two **BinderySignatures**: **BinderySignature 1** is a 4-page signature and
78 **BinderySignature 2** is an 8-page signature. **BinderySignature 1** contains cell numbers ranging from 0-3 while the
79 second **BinderySignature** contains cell numbers ranging from 0-7. When combining those two **BinderySignatures**
80 into one **StrippingParams**, the cell numbers are renumbered according to the order of the sections defined in
81 **Assembly** /**@order**.

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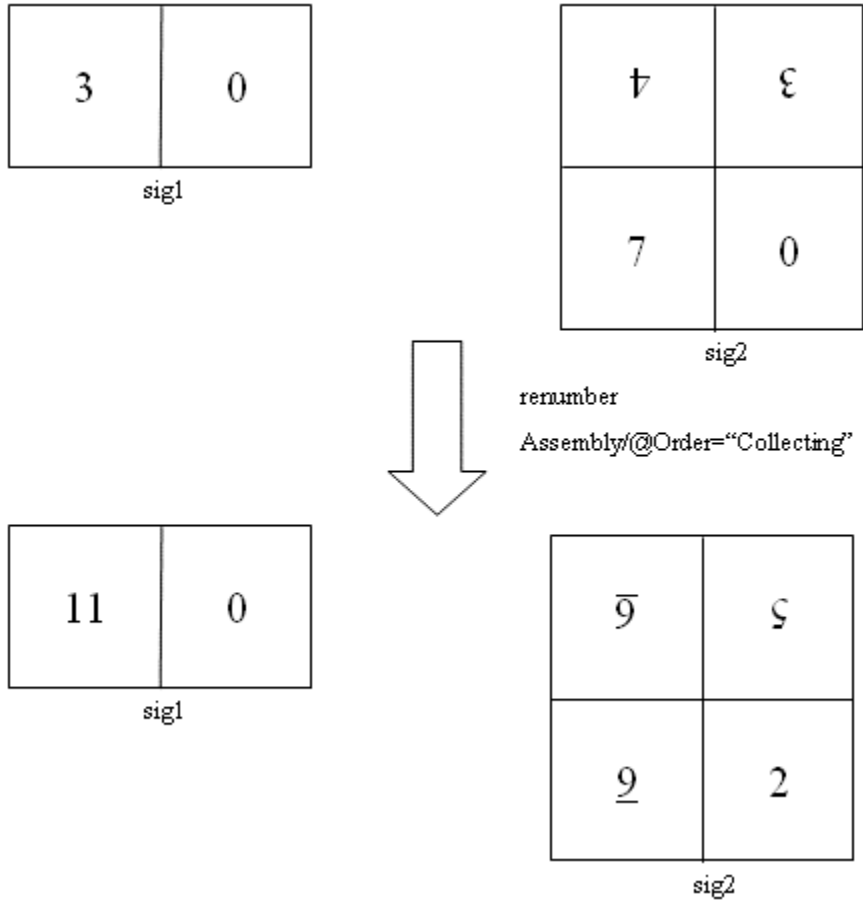
Figure 1 – Renumbering BinderySignatures Gathering order



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Figure 2 – Renumbering BinderySignatures Collecting order



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1.2 Adding cell numbers

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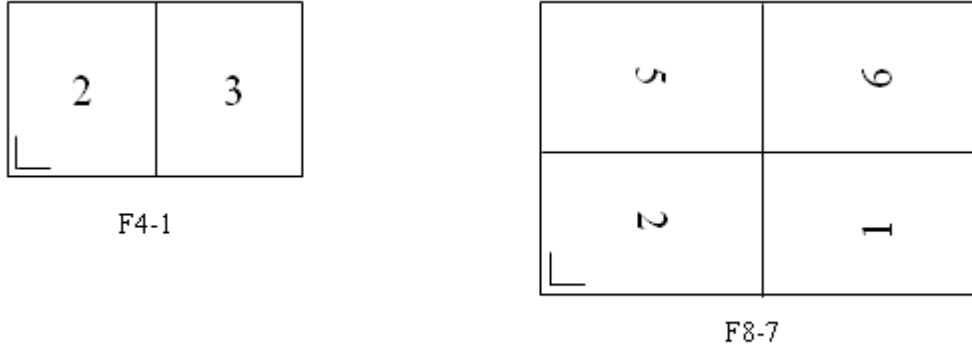
A BinderySignature specified by FoldCatalog or Folds must be expanded by the Stripping device into SignatureCells. In JDF 1.2 the method for generating SignatureCells is implementation dependent, but it is common practice to use the following procedure:

1. Fold the BinderySignature according to the FoldCatalog or Folds
2. Rotate and/or flip the folded BinderySignature to **closed head** position, except when there is no closed head.
3. Number the BinderySignature from top of the stack to the bottom

The figure below illustrates the expansion of FoldCatalog based BinderySignatures into SignatureCells. F4-1 is not rotated in step two of the procedure, because there is no closed head. F8-7 is rotated 90 degrees clockwise before numbering.

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Figure 3 - Adding cell numbers to BinderySignatures



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A Stripping device can use other procedures to add cell numbers to BinderySignatures than the one described above. In JDF 1.2 these procedures are implementation specific. In JDF 1.3 a Stripping procedure will be able to specify this procedure in more detail using new concepts like JogEdge and BindingOrientation.

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2 BindingSide and BindingEdge

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The **Assembly** resource is often referred to as the product view, while the **BinderySignature** is referred to as the production view. In this way, **Assembly** /@BindingSide typically refers to the bound side of the final product, while **BinderySignature** /@BindingEdge refers to the bound side during production. When both attributes are not equal, it is up to the Stripping device to modify the orientation and/or sequence of the cell numbers to synchronize product and production view.

The figure below illustrates a calendar product. The left side of the picture shows the product view where the spine of the calendar is at the top. The right side of the picture shows the production view where the spine of the calendar is at the left. The Stripping device can synchronize both views by rotating the content pages by 90 degrees before flowing them through the cells (after renumbering as explained in section 1).

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Figure 4 - Calendar: product and production view



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The next picture shows the JDF code for the calendar product. Assembly/@BindingSide="Top", while BinderySignature/@BindingEdge="Left" because from a production point of view, the calendar is produced like any other product.

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Figure 5 - Calendar

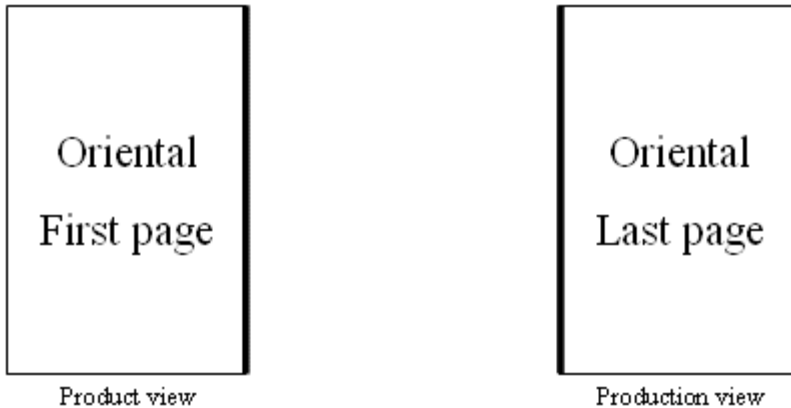
```

<Assembly Class="Parameter" ID="ASM000" Status="Available" BindingSide="Top" Order="Collecting"/>
<BinderySignature Class="Parameter" ID="BINSIG1" Status="Available" BindingEdge="Left"
FoldCatalog="F16-6"/>
<StrippingParams Class="Parameter" ID="STP000" PartIDKeys="SignatureName SheetName"
Status="Available">
  <StripCellParams BleedFace="5.66929" BleedSpine="0.0000" BleedFoot="5.66929" BleedHead="5.66929"
TrimFace="14.17323" Spine="0.00000" TrimHead="14.17323" TrimFoot="14.17323"
FrontOverfold="28.34646" BackOverfold="0.00000" MillingDepth="0.00000" TrimSize="595.27559
841.88976"/>
  <StrippingParams SignatureName="SIG1">
    <StrippingParams SheetName="SHT1" WorkStyle="WorkAndBack">
      <BinderySignatureRef rRef="BINSIG1"/>
      <Position RelativeBox="0.00000 0.00000 1.00000 1.00000" Orientation="Flip180"/>
    </StrippingParams>
  </StrippingParams>
  <StrippingParams SignatureName="SIG2">
    <StrippingParams SheetName="SHT2" WorkStyle="WorkAndBack">
      <BinderySignatureRef rRef="BINSIG1"/>
      <Position RelativeBox="0.00000 0.00000 1.00000 1.00000" Orientation="Flip180"/>
    </StrippingParams>
  </StrippingParams>
</StrippingParams>

```

148 The figure below illustrates an oriental book. The left side of the picture shows the product view where the spine of
149 the book is at the right. The right side of the picture shows the production view where the spine of the book is at the
150 left. The Stripping device can synchronize both views by flowing the content pages in reverse order through the
151 cells (after renumbering as explained in section 1).
152

153 **Figure 6 - Oriental book: product and production view**



154 The next picture shows the JDF code of the oriental book. From a product point of view the
155 Assembly/@BindingSide="Right", while from a production point of view BinderySignature/@BindingEdge="Left".
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159 **Figure 7 - Oriental Book**

```
160 <Assembly Class="Parameter" ID="ASM000" Status="Available" BindingSide="Right"  
161 Order="Collecting" />  
162 <BinderySignature Class="Parameter" ID="BINSIG1" Status="Available" BindingEdge="Left"  
163 FoldCatalog="F16-6" />  
164 <StrippingParams Class="Parameter" ID="STP000" PartIDKeys="SignatureName SheetName"  
165 Status="Available">  
166 <StripCellParams BleedFace="5.66929" BleedSpine="0.0000" BleedFoot="5.66929" BleedHead="5.66929"  
167 TrimFace="14.17323" Spine="0.00000" TrimHead="14.17323" TrimFoot="14.17323"  
168 FrontOverfold="28.34646" BackOverfold="0.00000" MillingDepth="0.00000" TrimSize="595.27559  
169 841.88976" />  
170 <StrippingParams SignatureName="SIG1">  
171 <StrippingParams SheetName="SHT1" WorkStyle="WorkAndBack">  
172 <BinderySignatureRef rRef="BINSIG1" />  
173 <Position RelativeBox="0.00000 0.00000 1.00000 1.00000" Orientation="Flip180" />  
174 </StrippingParams>  
175 </StrippingParams>  
176 <StrippingParams SignatureName="SIG2">  
177 <StrippingParams SheetName="SHT2" WorkStyle="WorkAndBack">  
178 <BinderySignatureRef rRef="BINSIG1" />  
179 <Position RelativeBox="0.00000 0.00000 1.00000 1.00000" Orientation="Flip180" />  
180 </StrippingParams>  
181 </StrippingParams>  
182 </StrippingParams>  
183  
184
```