

Binding ICS

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Finishing WG

Abstract

This ICS defines the conformance requirements for Saddle Stitching, Soft-cover and Hardcover Binding devices. These conformance requirements specify JDF Instances, JDF Messages and Processes. This ICS defines a single conformance level. Future ICS's may define additional conformance levels.



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1 Introduction

This ICS defines the Interface between the Manager and a *Binding System* – specifically *Binding Systems* that control Saddle Stitching, Softcover and Hardcover *Binding Devices*. This ICS defines Conformance Requirements for JDF Instances and JMF Messages that are suitable for producing bound products.

This ICS describes *Binding Systems* that

- Read JDF Instances, and
- Write back resulting JDF Instances.

This ICS specifies a subset of [JDF1.2] for Binding and this ICS depends on conformance requirements from [MIS-ICS] and [Base-ICS]. See [MIS-ICS], [Base-ICS] and [JDF1.2] for further information about JDF Instances and for communication of JDF Instances.

1.1 Conformance Requirements

This ICS defines only one Conformance Level, namely Level 1. Future ICS's may define additional conformance levels.

To be conformant to this ICS, a *MIS* and *Binding System* MUST Conform to:

- [Base-ICS] Level 1
- [MIS-ICS] Level 1 or higher
- Section 4 Conformance Tables – JDF Instances
- Section 5 Conformance Tables – Processes.
- Section 6 Conformance Tables – Parameter Resources

2 Terminology

This section defines terminology used throughout this document. References to other documents are indicated with square brackets, e.g. [JDF1.2]. For most terms, see the Terminology section in [Base-ICS] and [MIS-ICS].

This section contains Binding-related terms that pertain to this ICS:

Binding Device – A piece of equipment that performs some binding operation, such as saddle stitching.

Binding System – A Device or Controller that conforms to this ICS and consumes JDF Instances and JMF Messages defined herein. A Binding System is the software part of a *Binding Device*. The term *Worker* refers to the Binding System in this ICS.

MIS – A system that communicates with *Binding Systems* using JDF Instances and JMF Messages. The term *Manager* refers to the MIS in this ICS

Sheet – An unfolded sheet of paper

Signature – A folded sheet that is part of a final product.

3 Process Chains

This section describes typical process chains for binding.

All of the process chains for binding start with either a **Collecting** or **Gathering** Process. The input Resources for these two Processes include one or more **Components**, each representing a *Signature* denoted by **Component (Signature)** in this ICS or a *Sheet* denoted by **Component (Sheet)** in this ICS.

This ICS also specifies the processes for creating Signatures for the Saddle Stitching process chain.

3.1 Saddle Stitching:

Figure 1 and Figure 2 show the typical process chain for saddle stitching. Figure 1 shows the process chain that may create each Signature that is an input **Component** to the **Collecting** Process of the Saddle Stitching process chain. Figure 2 show the typical process chain starting with the **Collecting** Process.

Figure 1: Optional Processes before Saddle Stitching

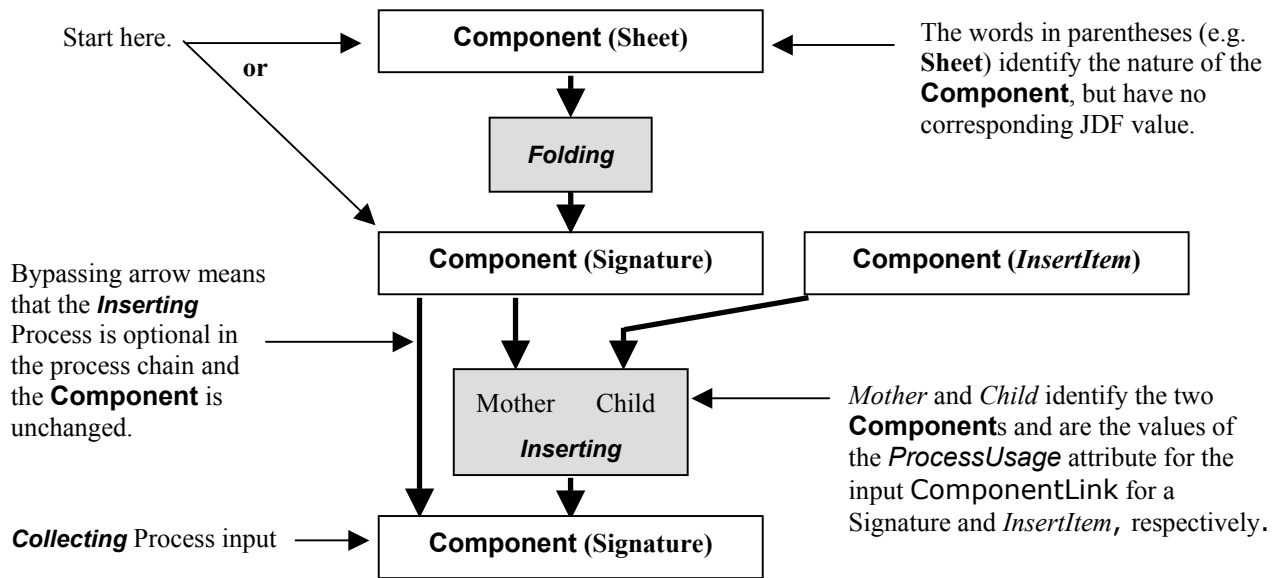
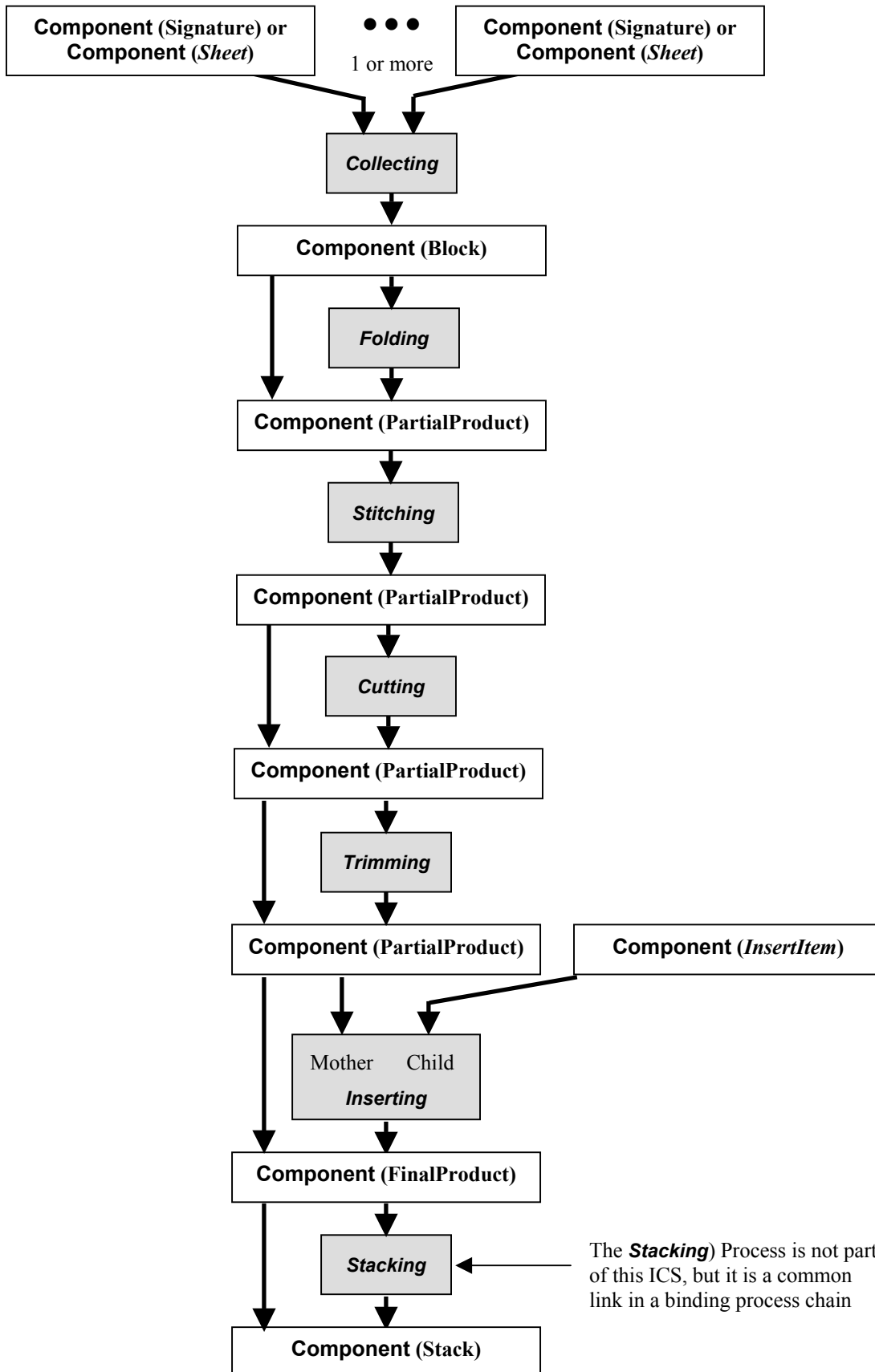
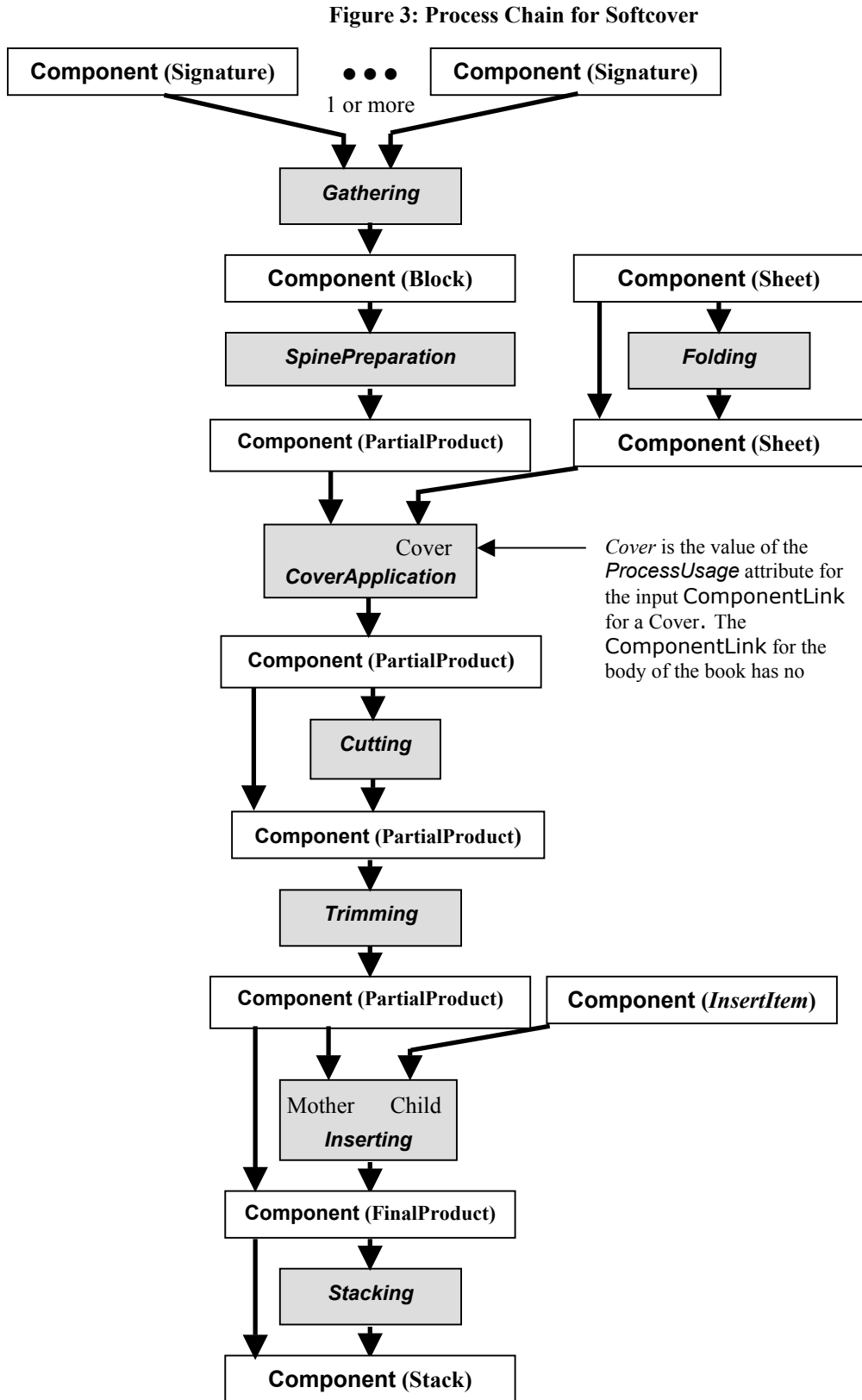


Figure 2: Process Chain for Saddle Stitching



3.2 Softcover:

Figure 3 shows the typical process chain for softcover book production, which is also called *Perfect Binding*.



3.3 Hardcover

There are two process chains in hardcover book production: Book Block Production (Figure 4) and Book Finishing (Figure 5). The output **Component** of Book Block Production is the input **Component** of Book Finishing

Figure 4 shows two ways to produce book blocks for hardcover books: Perfect Binding and Thread Sewing.

For both cases of book block production, Figure 5 shows that the *Binding System* uses the *CaseMaking* Process to make the cover and the *CasingIn* Process to apply the cover to the book block.

Figure 4: Process Chain for Hardcover – Book Block Production

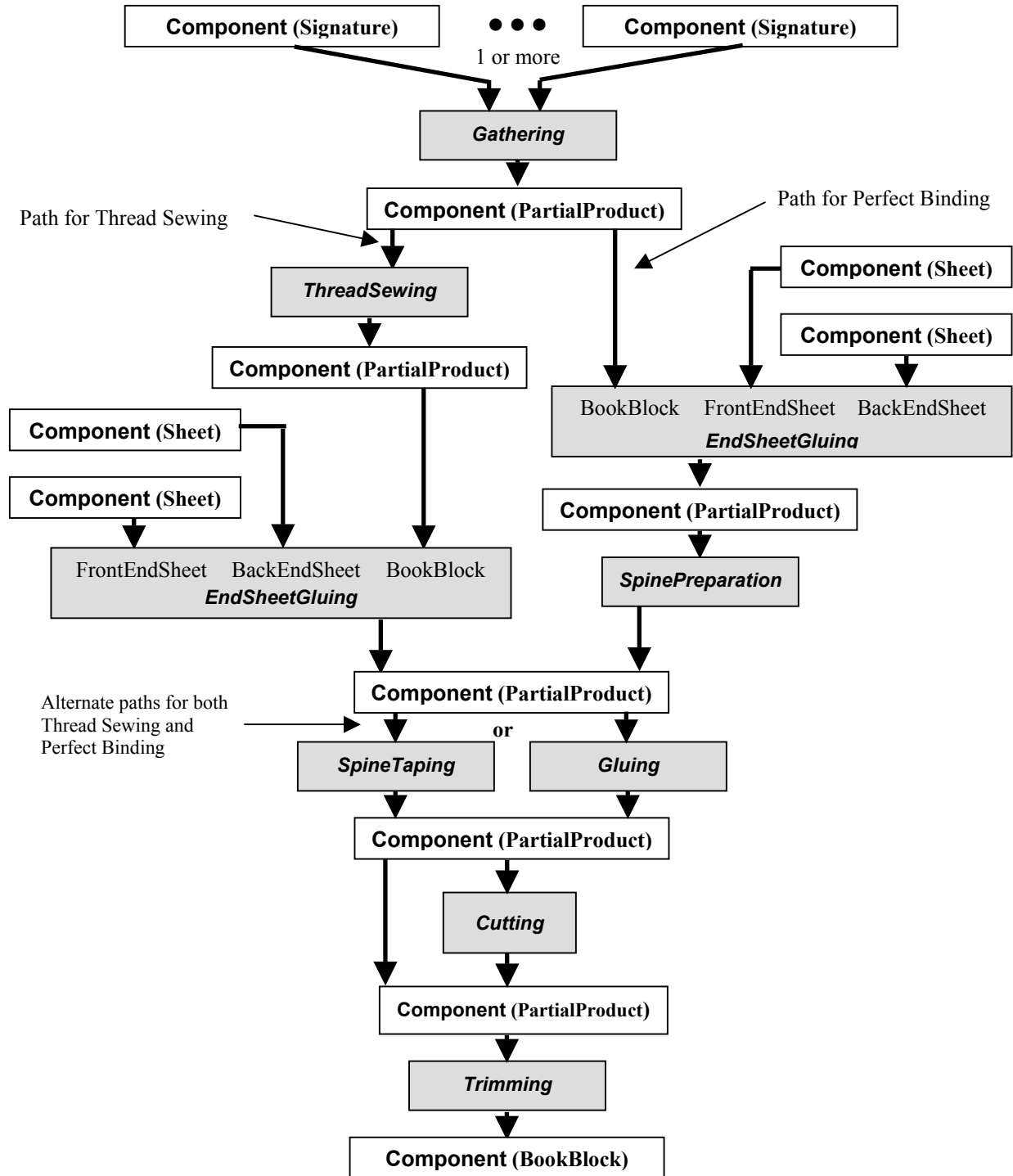
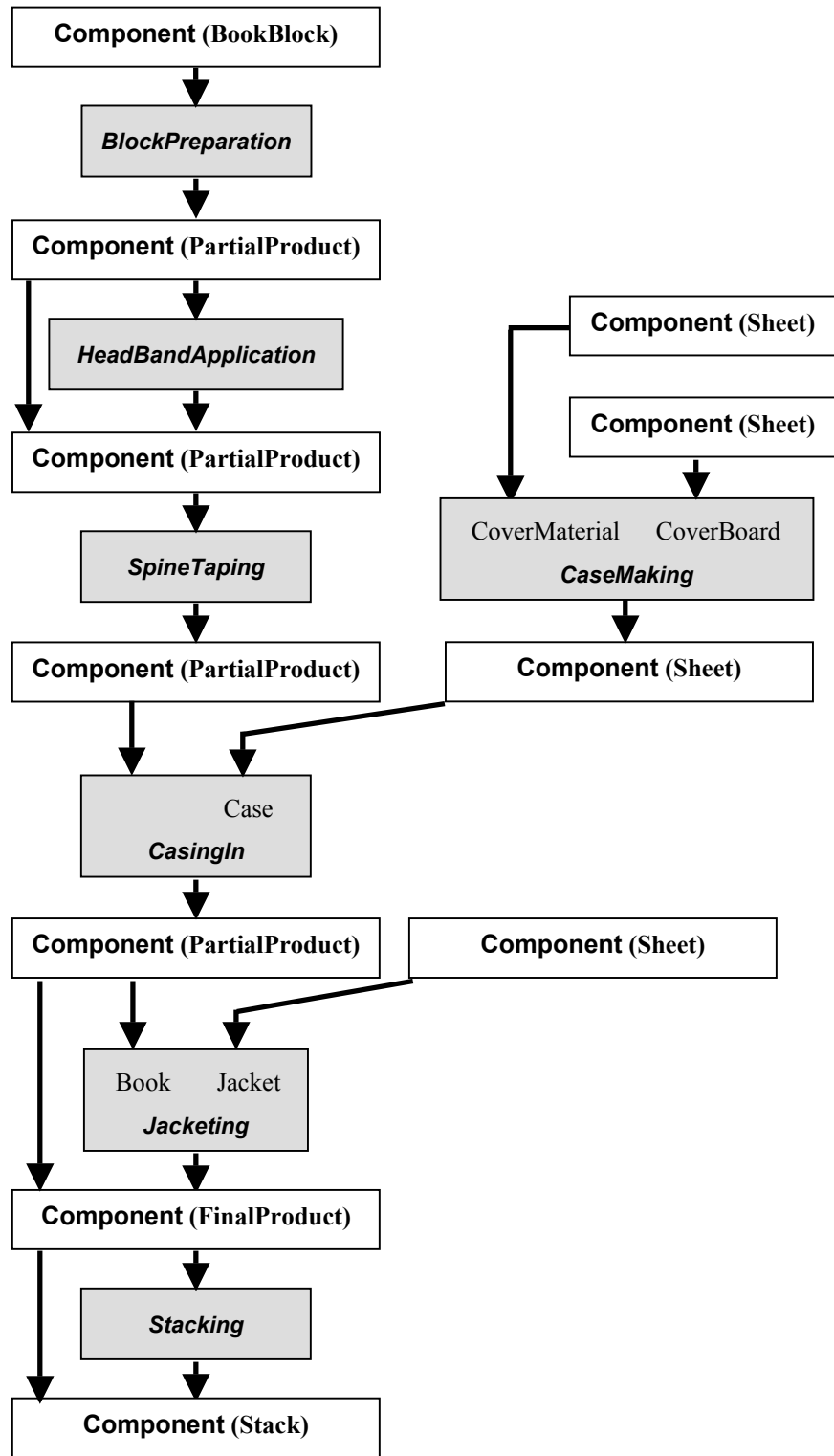


Figure 5: Process Chain for Hardcover – Book Finishing



4 Conformance Tables – JDF Instances

The following tables specify the Conformance Requirements for JDF Instances used by *Binding Systems*.

See Appendix A “*How to Read ICS Documents*” in [Base-ICS] for an explanation of the table format and the codes used to specify conformance

4.1 JDF Root Node for a Binding System

The JDF Root Node is from the perspective of the *Binding System*. The Manager may view this JDF Node as a JDF Subnode.

Table 1: Root for a JDF Instance

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
JDF	w			r			A JDF Root Node is required See Table 2: JDF Node

Table 2: JDF Node
Root Node of: JDF Instance

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
<i>Category</i>	w			r?			
<i>Binding</i>	w			r?			
<i>ICSVersions</i>	w←			r?			Example: “ <i>Base_L1-1.0 MISBC_L1-1.0 Binding_L1-1.0</i> ”
<i>Binding_L1-1.0</i>	w			r			Specifies that the JDF Instance conforms to [Binding-ICS] Level 1.
<i>Type</i>	w			r			
<i>all values</i>							See Table 12: Processes for Binding
<i>Types</i>	w←			r			
<i>all values</i>							See Table 12: Processes for Binding

4.2 ResourceLinks

4.2.1 ComponentLink – Input

This ComponentLink describes the Conformance Requirements for all Input **Components** of Processes described in this ICS.

Table 3: ComponentLink – Input

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
<i>Orientation</i>	w?			r			
<i>all values</i>	w←			r			If a Component is flipped or rotated and no Transformation is specified, the Manager MUST supply an <i>Orientation</i>
<i>Transformation</i>	w←			r			If an offset exists between two Components , the Manager MUST supply a <i>Transformation</i>
<i>Part</i>	w←			r			See Table 4: Part – Input

4.2.1.1 Partitioning – ComponentLink – Input

The Manager MUST be capable of supplying and the Worker MUST be capable of reading and supporting:

- Partitioned **Components** with links from ComponentLink/Part within processes, such as **Collecting** and **Gathering**.
- Multiple **Part** elements inside a ComponentLink,
- Multiple *PartIDKey* values inside a **Part**.
- Partition keys in Table 4 below

For the definitions of the partition key, see [JDF1.2].

Table 4: Part – Input

Referenced by: ComponentLink – Input

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
<i>SignatureName</i>	w			r			
<i>SheetName</i>	w			r			
<i>BlockName</i>	w←			r			
<i>Condition</i>	w?			r			Allows the consistent handling of good and waste throughout the whole postpress process.
<i>all remaining Attributes</i>	!w			r?			

4.3 Resources

4.3.1 Component

Table 5: Component

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
<i>Dimensions</i>	w			r			The Manager MUST specify at least the <i>X</i> and <i>Y</i> dimensions; <i>Z</i> MAY be zero
<i>Overfold</i>	w←			r?			The Manager MUST supply <i>Overfold</i> if the overfold > 0 for input Components of Collecting process
<i>OverfoldSide</i>	w←			r?			The Manager MUST supply <i>OverfoldSide</i> if it supplies <i>Overfold</i> and <i>Overfold</i> > 0
<i>all values</i>	w←			r			
<i>SurfaceCount</i>	w			r			A Manager MUST supply <i>SurfaceCount</i> for all input Components of Gathering and Collecting .
Layout	w←			r			A Manager MUST supply the Layout Element for all input Components of Gathering and Collecting . See Table 6: Layout

Table 6: Layout
Referenced by: Component

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
Media	w←			r			The Manager MUST supply the Media at least once in the Layout structure. See Table 11: Media
Signature	w←			r			If the Manager does not supply Media in the Layout , it MUST supply at least one Signature. See Table 7: Signature

Table 7: Signature
Referenced by: Layout

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
Media	w←			r			The Manager MUST supply the Media at least once in the Layout structure. See Table 11: Media
Sheet	w←			r			If the Manager does not supply Media in the Signature , it MUST supply at least one Sheet . See Table 8: Sheet

Table 8: Sheet
Referenced by: Signature

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
Media	w←			r			The Manager MUST supply the Media at least once in the Layout structure See Table 11: Media

4.3.2 GlueApplication

Table 9: GlueApplication
Referenced by: CoverApplicationParams, Glue, SpineTapingParams

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
<i>GluingTechnique</i>	w			r			
<i>all values</i>	w←			r			
GlueLine	w			r			See Table 10: GlueLine

4.3.3 GlueLine

Table 10: GlueLine

Referenced by: **CasingInParams, EndSheet, GlueApplication, InsertingParams**

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
<i>AreaGlue</i>	w←			r			
<i>GlueType</i>	w			r			
<i>all values</i>	w←			r			

4.3.4 Media

Table 11: Media

Referenced by: **Layout, Signature, Sheet**

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
<i>Weight</i>	w			r			
<i>MediaType</i>	w			r			
<i>Paper</i>	w			r			

5 Conformance Tables – Processes

Table 12 shows all of the Processes that this Binding ICS specifies.

A Worker MUST read and Support each Process (in Table 12) that its device is capable of supporting. A Manager MUST be capable of supplying a Node with all Processes that the Device needs to produce a product correctly within its capability

The rows of Table 12 contain the following information:

Process Name & Type: specifies the name of the Process and the value of the *JDF/@Type* Attribute.

ProcessUsage: specifies the value of the *ProcessUsage* Attribute in each *ComponentLink* for the Process. Multiple values mean that the Process has multiple input **Components**. The value *unnamed* means that the Process has an input **Component** that doesn't have a *ProcessUsage* Attribute. The value "one or more unnamed" specifies the "**Component +**" case.

Note: because each process has a single output **Component** with no *ProcessUsage* Attribute, the table says nothing about the output **Component**

Parameter Resource: a hot link to the Conformance Table for the Parameter Resource of the Process.

Description: provides additional conformance information about the Process. The cell also specifies in the first paragraph the process chain(s) that the Process can be a member of, such as "Hardcover".

Table 12: Processes for Binding

Process Name & Type	Process Usage	Parameter Resource	Description
BlockPreparation	<i>unnamed</i>	BlockPreparationParams	For Hardcover
CaseMaking	CoverMaterial CoverBoard	CaseMakingParams	For Hardcover For Media inputs, see [JDF1.2]
CasingIn	<i>unnamed</i> Case	CasingInParams	For Hardcover
Collecting	<i>one or more unnamed</i>	<i>none</i>	For Saddle Stitching The Manager MUST write the ComponentLinks into the ResourceLinkPool in the intended order of collection. The first in the collecting sequence is the center Component of the collected pile. The last one is the cover. To assure the correct collecting order for a partitioned Component , the Manager MUST include a separate ComponentLink/Part for each Component partition. If the Manager writes multiple Parts within a single ComponentLink , it MUST write the Parts into a ComponentLink in the intended order of collection. The Worker MUST collect the Components in the intended order of collection. <i>SheetName</i> , <i>SignatureName</i> and <i>BlockName</i> MAY partition the Components . See Table 4: Part – Input
CoverApplication	<i>unnamed</i> Cover	CoverApplicationParams	For Softcover The Manager MUST supply the offset between the cover and book block in ResourceLinkPool/ComponentLink/@Transformation for the Cover Component
Cutting	<i>unnamed</i>	CuttingParams	For Saddle Stitching, Softcover and Hardcover. For separating n-up products.
EndSheetGluing	BackEndSheet BookBlock FrontEndSheet	EndSheetGluingParams	For Hardcover The Manager MUST supply the offset between the end sheet and book block in ResourceLinkPool/ComponentLink/@Transformation for the BackEndSheet and FrontEndSheet Components

Process Name & Type	Process Usage	Parameter Resource	Description
Folding	<i>unnamed</i>	FoldingParams	For Saddle Stitching and Softcover
Gathering	One or more <i>unnamed</i>	GatheringParams	<p>For Softcover and Hardcover</p> <p>The Manager MUST write the ComponentLinks into the ResourceLinkPool in the intended order of collection. The first in the collecting sequence is the bottom Component of the collected pile. The last one is the top of the collected pile. To assure the correct collecting order for a partitioned Component, the Manager MUST include a separate ComponentLink/Part for each Component partition. If the Manager writes multiple Parts within a single ComponentLink, it MUST write the Parts into a ComponentLink in the intended order of collection.</p> <p>The Worker MUST collect the Components in the intended order of collection.</p> <p><i>SheetName</i>, <i>SignatureName</i> and <i>BlockName</i> MAY partition the Components. See Table 4: Part</p>
Gluing	<i>unnamed</i>	GluingParams	For Hardcover
HeadBandApplication	<i>unnamed</i>	HeadBandApplicationParams	For Hardcover
Inserting	Mother Child	InsertingParams	<p>For Saddle Stitching and Softcover</p> <p>The Manager MUST supply the offset between the Child Component and Mother Component in ResourceLinkPool/ComponentLink/@Transformation of the Child Component.</p>
Jacketing	Book Jacket	JacketingParams	For Hardcover
SpinePreparation	<i>unnamed</i>	SpinePreparationParams	For Softcover and Hardcover
SpineTaping	<i>unnamed</i>	SpineTapingParams	For Hardcover
Stitching	<i>unnamed</i>	StitchingParams	For Saddle Stitching
ThreadSewing	<i>unnamed</i>	ThreadSewingParams	For Hardcover
Trimming	<i>unnamed</i>	TrimmingParams	For Saddle Stitching, Softcover and Hardcover

6 Conformance Tables – Parameter Resources

This section contains the Parameter Resource for each Process listed in the previous section

See Appendix A “How to Read ICS Documents” in [Base-ICS] for an explanation of the table format and the codes used to specify conformance

6.1 BlockPreparationParams

Table 13: BlockPreparationParams

Input to: *BlockPreparation*

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
<i>TightBacking</i>	w			r			
<i>all values</i>	w←			r			

6.2 CaseMakingParams

Table 14: CaseMakingParams

Input to: *CaseMaking*

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
<i>CoverWidth</i>	w			r			
<i>Height</i>	w			r			
<i>JointWidth</i>	w			r			
<i>SpineWidth</i>	w			r			

6.3 CasingInParams

Table 15: CasingInParams

Input to: *CasingIn*

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
<i>GlueLine</i>	w			r			See Table 10: GlueLine

6.4 CoverApplicationParams

Table 16: CoverApplicationParams

Input to: *CoverApplication*

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
GlueApplication	w			r			See Table 9: GlueApplication
Score	w←			r			See Table 17: Score

Table 17: Score

Referenced by: *CoverApplicationParams*

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
Offset	w			r			
Side	w←			r			
<i>all values</i>	w←			r			

6.5 CuttingParams

Table 18: CuttingParams

Input to: *Cutting*

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
CutBlock	w←			r			For n-up Production, the Manager MUST write <i>n</i> CutBlock Elements. (e.g. 2 CutBlocks for 2-up) The cut-width of the cutting tool (e.g. a single knife, double knife or saw blade) defines the y-axis gap between the CutBlocks . See Table 19 - CutBlock
CutMark	!w			r?			

Table 19: CutBlock
 Referenced by: **CuttingParams**

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
<i>BlockSize</i>	w			r			The <i>X</i> of <i>BlockSize</i> MUST match the <i>X</i> of the collected Component The <i>Y</i> of <i>BlockSize</i> MUST indicate the new height of the Component
<i>BlockTrf</i>	w			r			<i>BlockTrf</i> MUST indicate the <i>Y</i> offset only.
<i>BlockType</i>	w			r			
<i>CutBlock</i>	w			r			

6.6 EndSheetGluingParams

Table 20: EndSheetGluingParams
 Input to: *EndSheetGluing*

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
EndSheet (Front)	w←			r			See Table 21: EndSheet
EndSheet (Back)	w←			r			See Table 21: EndSheet

Table 21: EndSheet
 Referenced by: **EndSheetGluingParams**

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
GlueLine	w			r			See Table 10: GlueLine

6.7 FoldingParams

Table 22: FoldingParams
Input to: *Folding*

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
<i>FoldCatalog</i>	w←			r			The supported values of <i>FoldCatalog</i> are Device specific
Fold	w←			r			The Manager MUST supply Fold if it doesn't supply <i>FoldCatalog</i> . See Table 23: Fold

Table 23: Fold
Referenced by: **FoldingParams**

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
<i>From</i>	w			r			
<i>all values</i>	w←			r			
<i>To</i>	w			r			
<i>all values</i>	w←			r			
<i>Travel</i>	w			r			

6.8 GatheringParams

Table 24: GatheringParams
Input to: *Gathering*

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
							The Element is optional

6.9 GluingParams

Table 25: GluingParams
Input to: *Gluing*

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
Glue	w←			r			See Table 26: Glue

Table 26: Glue
Referenced by: *GluingParams*

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
<i>WorkingDirection</i>	w			r			
<i>all values</i>	w←			r			
GlueApplication	w			r			See Table 9: GlueApplication

6.10 HeadBandApplicationParams

Table 27: HeadBandApplicationParams
Input to: *HeadBandApplication*

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
							All Attributes are optional

6.11 InsertingParams

Table 28: InsertingParams
Input to: *Inserting*

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
<i>FinishedPage</i>	w←			r			The Manager MUST supply this Attribute if and only if <i>InsertLocation</i> = " <i>FinishedPage</i> "
<i>InsertLocation</i>	w			r			
<i>Front</i>	w←			r			
<i>Back</i>	w←			r			
<i>Overfold</i>	w←			r			
<i>FinishedPage</i>	w←			r			
<i>Method</i>	w			r			
<i>all values</i>	w←			r			If supported by the device
<i>GlueLine</i>	w?			r?			See Table 10: <i>GlueLine</i>

6.12 JacketingParams

Table 29: JacketingParams
Input to: *Jacketing*

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
<i>FoldingWidth</i>	w			r			

6.13 SpinePreparationParams

Table 30: SpinePreparationParams
Input to: *SpinePreparation*

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
<i>MillingDepth</i>	w			r			Total amount to be cut off from the spine

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
<i>Operations</i>	w←			r			
<i>all values</i>	w?			r			

6.14 SpineTapingParams

Table 31: SpineTapingParams

Input to: *SpineTaping*

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
<i>GlueApplication</i>	w←			r			See Table 9: GlueApplication

6.15 StitchingParams

Table 32: StitchingParams

Input to: *Stitching*

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
<i>NumberOfStitches</i>	w			r			
<i>StitchType</i>	w			r			
<i>Saddle</i>	w			r			Only saddle stitching is supported

6.16 ThreadSewingParams

Table 33: ThreadSewingParams

Input to: *ThreadSewing*

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
<i>NumberOfNeedles</i>	w			r			

6.17 TrimmingParams

Table 34: TrimmingParams
Input to: *Trimming*

Name or Value	Manager			Worker			Description
	Level →	1	2	3	1	2	
<i>Height</i>	w			r			
<i>TrimmingOffset</i>	w			r			
<i>Width</i>	w			r			

7 References

7.1 Normative References

The following references are normative. Their conformance requirements are part of this ICS.

- [Base-ICS] Base ICS, Version 1.0, published December 2004, available at <http://www.cip4.org>.
- [JDF1.2] Job Definition Format (JDF), Version 1.2, published May 7, 2004, available at <http://www.cip4.org>.
- [MIS-ICS] MIS ICS, Version 1.0, published December 2004, available at <http://www.cip4.org>

7.2 Informative References

The following references are informative. Conformance to them is not required for conformance to this ICS.

- [FileURL-AN] “CIP4 Application Note: Use of the File URL in JDF”, published 12 November 2003, available at <http://www.cip4.org>.
- [MISPRES-Ex] MISPRE examples, available at <http://www.cip4.org>
- [MISPRES-AN] MIS-to-Prepress Application Notes, Version 1.0, work in progress, available at <http://www.cip4.org>
- [MIS-AN] MIS Application Notes, Version 1.0, work in progress, available at <http://www.cip4.org>
- [PP-AN] MIS Prepress Application Notes, Version 1.0, work in progress, available at <http://www.cip4.org>
- [PRE-Worker-AN] Prepress Worker Application Note, Version 1.0, work in progress, available at <http://www.cip4.org>