XJDF

ICS
INTEROPERABILITY CONFORMANCE SPECIFICATION

Quality Control – MIS

Release: 2.1

ORGANIZATION

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Table of Contents

1 Introduction

The MIS to Quality Control Interoperability Conformance Specification (ICS) defines the exchange of quality control data from MIS or print production system to quality measurement devices, using **XJDF**.

This ICS is part of a series of ICS documents that define the exchange of quality control data from *Customer* to *Print Provider*, *CusQC*, or *MIS* to device, *MisQC*, using **XJDF**. The ICS documents of the series are designed to enable end-to-end communication of quality targets and results from a conforming measurement device to the *Customer* at the level of detail that is appropriate for each interface. This encompasses both the definition of quality control requirements for the *Worker* as well as the reporting of quality control data by the *Worker*.

The major difference between the *CusQC* and *MisQC* ICS is that *CusQC* assumes that the data have been summarized for a *Customer* quality report whereas the *MisQC* ICS provides an interface for immediate data from quality control measurement devices to an *MIS* or print production system. This ICS provides information about the details of the **XJDF** data for quality control. Dynamic modification of quality control requirements by the *Manager* is out of scope of this ICS.

This ICS requires the use of at least **XJDF** version 2.1.

This initial version limits the scope to defining print quality inspection and color quality control of printed sheets and reels. This ICS has no additional normative ICS dependencies.

1.1 Specification of cardinality

The following table illustrates the notation of manager and worker requirements in ICS tables.

If an attribute, attribute value or element is not provided explicitly or implicitly by a table row of <all other values>, it is assumed to be out of scope. Out of scope values MAY be written and MAY be processed, but a conforming processor NEED NOT support them. The implied cardindality of out of scope values is therefore w? r?.

Table 1.1: Specification of cardinality

NOTATION	NAME	DESCRIPTION
w	Write Required	The element or attribute SHALL be written by the *Manager* or *Worker*.
w?	Write Optional	The element or attribute MAY be written by the *Manager* or *Worker*.
w←	Write Conditional	The element or attribute SHALL be written by the *Manager* or *Worker* depending on conditions. The details of the condition will be specified in the description.
w!	Write Forbidden	The element or attribute SHALL NOT be written by the *Manager* or *Worker*.
r	Read Required	The element or attribute SHALL be read by the *Manager* or *Worker*.
r?	Read Optional	The element or attribute MAY be read by the *Manager* or *Worker*.
r←	Read Conditional	The element or attribute SHALL be read by the *Manager* or *Worker* depending on conditions. The details of the condition will be specified in the description.

1.2 General Architecture

This ICS allows for 2 profiles.

- *Static Worker*: A *Static Worker* SHALL be capable of providing **XJMF** for quality reports. Setup of the equipment NEED NOT apply job specific details. *Static Workers* SHALL conform to level 1 of this ICS, MISQC_L1-2.1.
  Note: This allows simple devices to provide measurement feedback according to this ICS but allowing proprietary setup. *Static Workers* have no read requirements from this ICS.

- *Dynamic Worker*: A *Dynamic Worker* SHALL be capable of reading **XJDF** for setup and providing **XJMF** for quality reports. *Dynamic Workers* SHALL conform to level 2 of this ICS, MISQC_L2-2.1.

This ICS specifies the details of quality measurements and has no additional requirements on job submission and job reporting. See ▸[XJDF 2.1].

Returned reports SHALL be defined as individual measurements or summaries of the press runs or partial press runs in *SignalResource* **XJMF** messages.

1.3 Glossary

This section defines the terms and definitions that are required for quality measurements. For general **XJDF** terms, please see ▸[XJDF 2.1].

Table 1.2: Glossary

TERM	DEFINITION
Acceptance	Subjective or active consensus of satisfying the requested quality parameters.
Color Register	Accuracy of ink alignment "color-to-color", i.e. between the print forms of the individual process colors in 2, 3, 4 or multicolor printing.
CusQC	Interface between an end *Customer* and the *Print Provider.*
Customer	Company or person that procures printed material from a *Print Provider.*
Cutting Register	Register accuracy "print-to-cut", i.e. between printed pages and cut-off length after the former fold section in rotary presses.
Dynamic Worker	A worker that reads setup instructions from **XJDF** and sends measurements using **XJMF**.
Inline Measurement	Measurement by a measurement device that is tightly coupled to a *Production Device.*
Lighting Conditions	Quality feature of technical parameters prevailing during a color stimulus or visual assessment; include the illuminant of the light source, the influence of the surroundings and the glare and reflection-free angle of observation.
Measurement System	The device and software that provides the actual measurement, e.g. a spectrophotometer or camera.
MIS	Management Information System or production workflow system. The *MIS* can receive quality data from a *Measurement System* and provide a condensed summary of the quality data to the *Customer.*
MisQC	Interface between a *Print Provider*'s *MIS* and a *Measurement system.*
Offline Measurement	Measurement by a *Measurement system* that is not directly coupled to a *Production Device*, such as a handheld spectrophotometer.
Print Provider	The company that produces printed or finished goods for a *Customer.*
Production Device	The device that produces the material that is measured. For color measurements this is typically a printing press.
Recto-verso register	Register accuracy "front-to-back", i.e. between first and reverse printing on sheetfed and web gravure presses and between blanket-to-blanket printing in web offset presses.
Static Worker	A worker that does not read setup instructions from **XJDF**, but sends measurements using **XJMF**.
Target Value	Desired value of a quality parameter or setpoint in a control system.
Tolerance	Objective or passive consensus of satisfying requested quality parameters

2 XJDF Instance

The details of quality control SHALL be specified as a **QualityControl** process.

2.1 XJDF

XJDF SHALL specify the setup of the quality control process. **XJDF** NEED NOT be supported by *Static Workers*.

Table 2.1: XJDF Element

NAME	MANAGER	WORKER	DESCRIPTION
JobId	w r	r w	@*JobID* SHALL be used to identify the job for quality control and SHALL define the job identifier that is locally defined by the printer. **Note:** This is typically the job identifier of the printer's *MIS*.
Types	w r	r w	See ▸ [XJDF 2.1].
QualityControl	w r	r w	QualityControl SHALL be present.
<all other values>	w? r?	r? w?	Additional values MAY be specified but are out of scope for this ICS.
ICSVersions	w r	r w	The value of @*ICSVersions* SHALL specify the ICS that a conforming **XJDF** conforms to.
MisQC_L2-2.1	w r	r w	A *Dynamic Worker* SHALL support a value of MisQC_L2-2.1.
<all other values>	w? r?	r? w?	Additional values MAY be specified but are out of scope for this ICS.
ResourceSet [@*Name*="Color"]	w	r	A **Color** SHALL represent all color separations that are present in the print job. One Resource element SHALL be specified for each color separation. A Resource with no Part element MAY be provided as a container for ▸ [ISO 17972-4:2018].
ResourceSet [@*Name*="ColorantControl"]	w	r	A **ColorantControl** SHALL represent the print order of color separations that are present on a surface.
ResourceSet [@*Name*="Component"]	w	r	A **Component** SHALL represent the end result of the process that is controlled.
ResourceSet [@*Name*="Layout"]	w←	r←	A **Layout** SHALL define the geometry of the measurement patches. ***ResourceSet***[@*Name*="Layout"] SHALL be provided if the receiving system is intended to automatically find measurement patches on a Component such as a press sheet and NEED NOT be provided for manually positioned quality measurement systems.
ResourceSet [@*Name*="Preview"]	w←	r?	**Preview** SHOULD be specified to enable visualization of the press sheet or component that is quality controlled.
ResourceSet [@*Name*="PrintCondition"]	w←	r?	**PrintCondition** SHOULD be provided if scoring is requested from the *Worker*.

Table 2.1: XJDF Element

NAME	MANAGER	WORKER	DESCRIPTION
ResourceSet [@*Name*="QualityControlParams"]	w	r	A **QualityControlParams** SHALL contain the details of the quality control setup.
ResourceSet [@*Name*="QualityControlResult"]	r	w	A **QualityControlResult** SHALL contain the results of the quality control measurements.

3 XJMF Instance

XJMF is the preferred method to provide quality reports. See ▸ [XJDF 2.1] for additional details and a discussion of the network protocol for **XJMF**.

3.1 XJMF

Table 3.1: XJMF Element

NAME	MANAGER	WORKER	DESCRIPTION
SignalResource	r	w←	Reports that conform to the *MisQC* ICS SHALL be provided as *SignalResource* elements that contain a *SignalResource*/*ResourceSet*[@*Name*="QualityControlResult"]. Multiple *SignalResource* elements that contain different subsets of quality reports MAY be provided by the *Worker* and SHALL be processed by the *Manager.* Other **XJMF** message types MAY be sent but are out of scope for the *MisQC* ICS.
Header	r?	w	*Header* SHALL contain information about the sender of the XJMF. This NEED NOT be the creator of quality report. See *SignalResource*/*Header*.
<all other messages>	r?	w?	Additional messages MAY be present but are out of scope for this ICS.

3.1.1 SignalResource

SignalResource will typically contain individual measurements or sets of measurements that were collected during a production run.

Table 3.2: SignalResource Element

NAME	MANAGER	WORKER	DESCRIPTION
Header	r	w	*Header* SHALL contain information about the creator of the quality report.
ResourceInfo	r	w	Exactly one *ResourceInfo* that contains a *ResourceSet*[@*Name*="QualityControlResult"] SHALL be present.

4 Resources

4.1 Color

Color SHALL define target properties of individual color separations. Every colorant that is intended to be printed as a separation SHALL be provided as an individual Resource element.

4.1.1 ResourceSet

Table 4.1: Color ResourceSet element

NAME	MANAGER	WORKER	DESCRIPTION
Name	w	r	See ▸ [XJDF 2.1].
Color	w	r	The value of @*Name* SHALL be "Color".
Usage	w	r	See ▸ [XJDF 2.1].
Input	w	r	The value of @*Usage* SHALL be "Input".
Resource	w	r	See ▸ [XJDF 2.1].

4.1.2 Resource

Table 4.2: Color Resource element

NAME	MANAGER	WORKER	DESCRIPTION
Part	w←	r	***Part*** SHALL be specified if Color is present.
Color	w←	r	Exactly one of ***Color*** and ***cx:CxF*** SHALL be present.
cx:CxF	w?	r	***cx:CxF*** MAY be provided to describe color target requirements. Not more than one ***cx:CxF*** element SHALL be present. If ***cx:CxF*** is present, ***Part*** SHALL NOT be specified and ***Color*** SHALL NOT be specified. The requirements for ***cx:CxF*** are out of scope for this ICS. See ▸ [ISO 17972-4:2018] for more information on ***cx:CxF***.

4.1.3 Part

Table 4.3: Color Part element

NAME	MANAGER	WORKER	DESCRIPTION
Separation	w	r	@*Separation* SHALL be specified.
<all other attributes>	w!		Additional values SHALL NOT be specified.

4.1.4 Color

Table 4.4: Color element

NAME	MANAGER	WORKER	DESCRIPTION
ActualColorName	w←	r	See ▸ [XJDF 2.1].

Table 4.4: Color element

NAME	MANAGER	WORKER	DESCRIPTION
Density	w←	r	At least one of @*Density* or @*NeutralDensity* SHALL be provided if neither @*Spectrum* nor @*LAB* is present.
LAB	w←	r	If either *Manager* or *Worker* support colorimetric measurements, @*LAB* SHOULD be provided.
NeutralDensity	w←	r	At least one of @*Density* or @*NeutralDensity* SHALL be provided if neither @*Spectrum* nor @*LAB* is present.
Spectrum	w←	r	If either *Manager* or *Worker* support spectral measurements, the color reflectance spectrum SHOULD be provided.
ColorMeasurementConditions	w?	r	See ▸ [XJDF 2.1].

4.2 ColorantControl

ColorantControl SHALL define the sequence in whch individual separations SHALL be printed.

4.2.1 ResourceSet

Table 4.5: ColorantControl ResourceSet element

NAME	MANAGER	WORKER	DESCRIPTION
Name	w	r	See ▸ [XJDF 2.1].
ColorantControl	w	r	The value of @*Name* SHALL be "ColorantControl".
Usage	w	r	See ▸ [XJDF 2.1].
Input	w	r	The value of @*Usage* SHALL be "Input".
Resource	w	r	See ▸ [XJDF 2.1].

4.2.2 Resource

Table 4.6: ColorantControl Resource element

NAME	MANAGER	WORKER	DESCRIPTION
Part	w?	r	***Part*** MAY be specified if colors vary by press run.
ColorantControl	w	r	

4.2.3 Part

Table 4.7: ColorantControl Part element

NAME	MANAGER	WORKER	DESCRIPTION
Separation	w?	r	@*Separation* MAY be specified for all ***ColorantControl*** that apply to a print pass of one or more separations if multiple press runs are measured for the same value of @*SheetName* and @*Side*.
SheetName	w?	r	@*SheetName* MAY be specified for all ***ColorantControl*** that apply to an individual sheet or impression on a roll.
Side	w?	r	@*Side* MAY be specified for a ***ColorantControl*** that applies to an individual surface.

Table 4.7: ColorantControl Part element

NAME	MANAGER	WORKER	DESCRIPTION
<all other attributes>	w?	r?	Additional values MAY be specified but are out of scope for this ICS.

4.2.4 ColorantControl

Table 4.8: ColorantControl element

NAME	MANAGER	WORKER	DESCRIPTION
ColorantOrder	w	r	See ▸ [XJDF 2.1].
ColorantParams	w	r	See ▸ [XJDF 2.1].

4.3 Component

Components describe the physical objects such as press sheets of printed finished products that SHALL be controlled.

4.3.1 ResourceSet

Table 4.9: Component ResourceSet element

NAME	MANAGER	WORKER	DESCRIPTION
Name	w	r	See ▸ [XJDF 2.1].
Component	w	r	The value of @*Name* SHALL be "Component".
Usage	w	r	See ▸ [XJDF 2.1].
Input	w	r	The value of @*Usage* SHALL be "Input".
Resource	w	r	See ▸ [XJDF 2.1].

4.3.2 Resource

Table 4.10: Component Resource element

NAME	MANAGER	WORKER	DESCRIPTION
Part	w?	r	Part MAY be specified if properties of the physical product vary by press run.
Component	w←	r	***Component*** SHALL be present.

4.3.3 Part

Table 4.11: Component Part element

NAME	MANAGER	WORKER	DESCRIPTION
QualityMeasurement	w!		@*QualityMeasurement* SHALL NOT be specified for ***QualityControlParams***.
Separation	w!		@*Separation* SHALL NOT be specified ***Component***.
SheetName	w?	r	@*SheetName* MAY be specified for all ***QualityControlParams*** that apply to an individual sheet or impression on a roll.
Side	w!		@*Side* SHALL NOT be specified ***Component***.
<all other attributes>	w?	r?	Additional attributes MAY be specified, but are out of scope for this ICS..

4.3.4 Component

Table 4.12: Component element

NAME	MANAGER	WORKER	DESCRIPTION
Dimensions	w	r	The size of the measured object SHALL be specified.
MediaRef	w	r	@*MediaRef* SHALL reference a **Media** using the value of **ResourceSet**/**Resource**/@*ID*.

4.4 Layout

This ICS provides normative usage rules for **Layout** as used by a **QualityControl** process. **Layout** SHALL specify the geometry of the press sheets and measurement patches.

Note: Layout contains additional information for the **Stripping** and/or **Imposition** processes. The use of this information for imposition purposes is out of scope for this ICS.

4.4.1 ResourceSet

Table 4.13: Layout ResourceSet element

NAME	MANAGER	WORKER	DESCRIPTION
Name	w	r	See ▶ [XJDF 2.1].
Layout	w	r	The value of @*Name* SHALL be "Layout".
Usage	w	r	See ▶ [XJDF 2.1].
Input	w	r	The value of @*Usage* SHALL be "Input".
Resource	w	r	See ▶ [XJDF 2.1].

4.4.2 Resource

Table 4.14: Layout Resource element

NAME	MANAGER	WORKER	DESCRIPTION
Part	w	r	***Part*** SHALL be present.
Layout	w	r	***Layout*** SHALL be present.

4.4.3 Part

Table 4.15: Layout Part element

NAME	MANAGER	WORKER	DESCRIPTION
Separation	w!		@*Separation* SHALL NOT be specified for **Layout**.
SheetName	w	r	@*SheetName* SHALL be specified for **Layout**.
Side	w	r	@*Side* SHALL be specified for **Layout**.
<all other attributes>	w!		Additional attributes SHALL NOT be specified.

4.4.4 Layout

Table 4.16: Layout element

NAME	MANAGER	WORKER	DESCRIPTION
PlacedObject +			*PlacedObject* elements define the details of individual marks and content.

4.4.4.1 PlacedObject

PlacedObject SHALL provide a detailed definition of print content and production marks.

Table 4.17: PlacedObject element

NAME	MANAGER	WORKER	DESCRIPTION
CTM	w	r	See ▶ [XJDF 2.1].
ContentObject	w?	r?	*ContentObject* elements provide details of the print content. The evaluation of print content is out of scope for this ICS.
MarkObject	w←	r	*MarkObject* elements provide details of production marks. At least one conforming *MarkObject* that provides details for quality measurements SHALL be present.

4.4.4.2 MarkObject

Table 4.18: MarkObject element

NAME	MANAGER	WORKER	DESCRIPTION
ColorControlStrip *	w←	r←	*ColorControlStrip* SHALL define a set of color measurement patch target color definitions. This includes target positions and color targets. At least one *ColorControlStrip* SHALL be provided in the context of one **XJDF** by the *Manager* if @*QualityControlMethods* contains one of "Colorimetry", "ColorSpectrophotometry" or "Densitometry". *ColorControlStrip* SHALL be evaluated by the *Worker* if @*QualityControlMethods* contains one of "Colorimetry", "ColorSpectrophotometry" or "Densitometry".
RegisterMark *	w←	r←	At least one *RegisterMark* SHALL be provided in the context of one **XJDF** by the *Manager* if @*QualityControlMethods* contains "Registration". *RegisterMark* SHALL be evaluated by the *Worker* if @*QualityControlMethods* contains "Registration". See ▶ [XJDF 2.1].

4.4.4.3 RegisterMark

Table 4.19: RegisterMark element

NAME	MANAGER	WORKER	DESCRIPTION
Center	w←	r	@*Center* SHALL be specified by the *Manager* if *RegisterMark* is in a descendant of *Layout*.
MarkType	w!		Deprecated in **XJDF 2.1**.
MarkUsage	w	r	See ▶ [XJDF 2.1].
Color	w←	r	Color should be specified for register marks used for separation color registration.
<all other values>	w?	r?	All other values may be specified, but are out of scope of this ICS.

Table 4.19: RegisterMark element

NAME	MANAGER	WORKER	DESCRIPTION
Rotation	w←	r	@*Rotation* SHALL be specified by the *Manager* if @*Center* is present.
Separations	w!		Deprecated in **XJDF 2.1**.
Size	w←	r	@*Size* SHALL be specified by the *Manager* if @*Center* is present.
MarkElement	w?	r	See ▶ [XJDF 2.1].

4.4.4.4 MarkElement

Table 4.20: MarkElement element

NAME	MANAGER	WORKER	DESCRIPTION
Center	w	r	See ▶ [XJDF 2.1].
MarkType	w	r	See ▶ [XJDF 2.1].
MarkUsage	w	r	See ▶ [XJDF 2.1].
Rotation	w←	r	See ▶ [XJDF 2.1].
Separation	w	r	See ▶ [XJDF 2.1].
Size	w	r	See ▶ [XJDF 2.1].

4.5 Media

Media resources describe physical media e.g. that used by press sheets.

4.5.1 ResourceSet

Table 4.21: Media ResourceSet element

NAME	MANAGER	WORKER	DESCRIPTION
ID	w!		@*ID* SHALL NOT be specified for **Media** resources used by **Component**.
Name	w	r	See ▶ [XJDF 2.1].
Media	w	r	The value of @*Name* SHALL be "Media".
Usage	w	r	See ▶ [XJDF 2.1].
Input	w	r	The value of @*Usage* SHALL be "Input".
Resource	w	r	See ▶ [XJDF 2.1].

4.5.2 Resource

Table 4.22: Media Resource element (Sheet 1 of 2)

NAME	MANAGER	WORKER	DESCRIPTION
ID	w←	r	@*ID* SHALL be specified for **Media** resources used by **Component**.
Part	w?	r	**Part** MAY be specified if properties of the physical product vary by press run.

Table 4.22: Media Resource element (Sheet 2 of 2)

NAME	MANAGER	WORKER	DESCRIPTION
Media	w	r	*Media* SHALL be present.

4.5.3 Part

Table 4.23: Media Part element

NAME	MANAGER	WORKER	DESCRIPTION
QualityMeasurement	w!		@*QualityMeasurement* SHALL NOT be specified for *Media*.
Separation	w!		@*Separation* SHALL NOT be specified for *Media*.
SheetName	w?	r	@*SheetName* MAY be specified for all *Media* that apply to an individual sheet or impression on a roll.
Side	w!		@*Side* SHALL NOT be specified for *Media*.
<all other attributes>	w?	r?	Additional attributes MAY be specified, but are out of scope for this ICS..

4.5.4 Media

Table 4.24: Media element

NAME	MANAGER	WORKER	DESCRIPTION
Dimension	w	r	The size of the *Media* SHALL be specified.
ISOPaperSubstrate	w←	r	@*IsoPaperSubstrate* SHOULD be specified if scoring is requested from the *Worker*. **Note:** Trade associations define tolerances for measurements based on the paper substrate.
MediaType	w	r	@*MediaType* SHALL specify the type of the printed material.
Paper	w←	r	See ▸ [XJDF 2.1].
<all other values>	w?	r	Other media types MAY be specified but are out of scope for this ICS.

4.6 Preview

Preview SHOULD be specified to allow visualization of the press sheet or component that is quality controlled. If *Preview* is provided for color measurements, it SHALL contain the color control strips.

4.6.1 ResourceSet

Table 4.25: Preview ResourceSet element

NAME	MANAGER	WORKER	DESCRIPTION
Name	w	r	See ▸ [XJDF 2.1].
Preview	w	r	The value of @*Name* SHALL be "Preview".
Usage	w	r	See ▸ [XJDF 2.1].
Input	w	r	The value of @*Usage* SHALL be "Input".
Resource	w	r	See ▸ [XJDF 2.1].

4.6.2 Resource

Table 4.26: Preview Resource element

NAME	MANAGER	WORKER	DESCRIPTION
Orientation	w?	r	See ▶ [XJDF 2.1].
Rotate0	w←	r	See ▶ [XJDF 2.1].
Rotate90	w←	r	See ▶ [XJDF 2.1].
Rotate180	w←	r	See ▶ [XJDF 2.1].
Rotate270	w←	r	See ▶ [XJDF 2.1].
<all other values>	w?	r?	Mirrored images MAY be specified, e.g. to describe negative images, but are out of scope for this ICS.
Transformation	w!		Image rotation SHALL be specified in @*Orientation*. See ▶ [XJDF 2.1].
Part	w←	r←	**Part** SHALL be specified if multiple previews are provided.
Preview	w	r?	The **Preview** MAY be evaluated by the *Worker* to analyze quality issues that are image related..

4.6.3 Part

Table 4.27: Preview Part element

NAME	MANAGER	WORKER	DESCRIPTION
QualityMeasurement	w!		@*QualityMeasurement* SHALL NOT be specified for **Preview**.
Separation	w?	r	@*Separation* MAY be specified for all **Preview** resources that apply to a print pass of one or more separations if multiple press runs are measured for the same @*SheetName* and @*Side*.
SheetName	w?	r	@*SheetName* MAY be specified for all **Preview** resources that apply to an individual sheet or impression on a roll.
Side	w?	r	@*Side* MAY be specified for a **Preview** that applies to an individual surface.
<all other attributes>	w?	r?	Additional attributes MAY be specified, but are out of scope for this ICS..

4.6.4 Preview

Table 4.28: Preview element

NAME	MANAGER	WORKER	DESCRIPTION
CTM	w!		Deprecated in ▶ [XJDF 2.1].
PreviewFileType	w	r?	See ▶ [XJDF 2.1].
PNG	w	r	A value of "PNG" SHALL be specified.
FileSpec	w	r	See ▶ [XJDF 2.1].

4.7 PrintCondition

PrintCondition SHOULD be specified if scoring is requested from the *Worker*.
Note: Trade associations define tolerances for measurements based on the print condition.

4.7.1 ResourceSet

Table 4.29: PrintCondition ResourceSet element

NAME	MANAGER	WORKER	DESCRIPTION
Name	w	r	See ▸ [XJDF 2.1].
PrintCondition	w	r	The value of @*Name* SHALL be "PrintCondition".
Usage	w	r	See ▸ [XJDF 2.1].
Input	w	r	The value of @*Usage* SHALL be "Input".
Resource	w	r	See ▸ [XJDF 2.1].

4.7.2 Resource

Table 4.30: PrintCondition Resource element

NAME	MANAGER	WORKER	DESCRIPTION
Part	w←	r	***Part*** SHALL be specified if multiple print conditions are required within one job.
PrintCondition	w	r	The ***PrintCondition*** SHALL be specified.

4.7.3 Part

Table 4.31: PrintCondition Part element

NAME	MANAGER	WORKER	DESCRIPTION
SheetName	w←	r	@*SheetName* SHALL be specified for all ***PrintCondition*** that apply to an individual sheet or impression on a roll.
Side	w←	r	@*Side* SHALL be specified for ***PrintCondition*** that applies to an individual surface.
<all other attributes>	w?	r?	Additional attributes MAY be specified, but are out of scope for this ICS.

4.7.4 PrintCondition

Table 4.32: PrintCondition element

NAME	MANAGER	WORKER	DESCRIPTION
Name	w	r	See ▸ [XJDF 2.1].

4.8 QualityControlParams

QualityControlParams defines the setup for quality control.

4.8.1 ResourceSet

Table 4.33: QualityControlParams ResourceSet element

NAME	MANAGER	WORKER	DESCRIPTION
Name	w	r	See ▸ [XJDF 2.1].
QualityControlParams	w	r	The value of @*Name* SHALL be "QualityControlParams".

Table 4.33: QualityControlParams ResourceSet element

NAME	MANAGER	WORKER	DESCRIPTION
Usage	w	r	See ▶ [XJDF 2.1].
Input	w	r	The value of @*Usage* SHALL be "Input".
Resource	w	r	See ▶ [XJDF 2.1].

4.8.2 Resource

Table 4.34: QualityControlParams Resource element

NAME	MANAGER	WORKER	DESCRIPTION
Comment	w←	r	***Comment*** SHALL be specified for all manual quality control steps and SHALL specifiy the requested actions as human readable text. ***Comment*** NEED NOT be specified for fully auto-mated quality control.
Part	w?	r	***Part*** MAY be specified if measurement requirements vary by press run.
QualityControlParams	w	r	***QualityControlParams*** SHALL be present.

4.8.3 Comment

Table 4.35: Comment element

NAME	MANAGER	WORKER	DESCRIPTION
Type	w	r	@*Type* SHALL be present.
Instruction	w←	r	The human readable instructions SHALL be marked with @*Type*="Instruction".
<all other values>	w?	r?	Other comments with a different type MAY be specified, but are out of scope for this ICS.
<element text>	w	r	The human readable setup and measurement instructions SHALL be provided.

4.8.4 Part

Table 4.36: QualityControlParams Part element

NAME	MANAGER	WORKER	DESCRIPTION
QualityMeasurement	w!		@*QualityMeasurement* SHALL NOT be specified for ***QualityControlParams***.
Separation	w?	r	@*Separation* MAY be specified for all ***QualityControlParams*** that apply to a print pass of one or more separations if multi-ple press runs are measured for the same @*SheetName* and @*Side*.
SheetName	w?	r	@*SheetName* MAY be specified for all ***QualityControlParams*** that apply to an individual sheet or impression on a roll.
Side	w?	r	@*Side* MAY be specified for ***QualityControlParams*** that apply to an individual surface.
<all other attributes>	w?	r?	Additional attributes MAY be specified, but are out of scope for this ICS..

4.8.5 QualityControlParams

Table 4.37: QualityControlParams element

NAME	MANAGER	WORKER	DESCRIPTION
Position	w?	r	@*Position* SHALL NOT be specified if **Part**/@*Side* is present.
QualityBase	w?	r	See ▸ [XJDF 2.1].
Absolute	w?	r	Any calculations of **QualityControlResult**/@*Severity* SHALL be based on absolute values. See ▸ [XJDF 2.1].
Master	w?	r	Any calculations of **QualityControlResult**/@*Severity* SHALL be based on values provided in **QualityControlResult**[@*MeasurementUsage*="Master"]. See ▸ [XJDF 2.1].
QualityControlMethods	w	r	@*QualityControlMethods* SHALL be specified. If a reader encounters an unsupported value, it SHOULD reject the ticket. Values SHOULD be selected from the following:
Barcode	w←	r	Barcode SHOULD be specified for measurements that test the quality of barcodes. **Note:** This includes linear and 3-d barcodes.
Colorimetry	w←	r	Colorimetry SHOULD be specified for colorimetric measurements that cannot measure spectral data. At most one of Colorimetry, ColorSpectrophotometry and Densitometry SHALL be supplied.
ColorSpectrophotometry	w←	r	A value of ColorSpectrophotometry SHALL be specified for measurement devices that support spectral measurements. At most one of Colorimetry, ColorSpectrophotometry and Densitometry SHALL be supplied.
Densitometry	w←	r	Densitometry SHOULD be specified for color measurements that contain only density measurements. At most one of Colorimetry, ColorSpectrophotometry and Densitometry SHALL be supplied.
Inspection	w←	r	Inspection SHOULD be specified for measurements of general image and product quality.
Registration	w←	r	Registration SHOULD be specified for color separation registration measurements.
<all other values>	r?	r?	Additional methods MAY be specified but are out of scope for this ICS.
SampleInterval	w?	r	@*SampleInterval* SHALL specifiy the number of samples between tests. Not more than one of @*TimeInterval* and @*SampleInterval* SHALL be specified.
TimeInterval	w?	r	@*TimeInterval* SHALL specifiy the time span between tests. Not more than one of @*TimeInterval* and @*SampleInterval* SHALL be specified.
ColorMeasurement	w←	r←	**ColorControlStrip** SHOULD be supplied for **QualityControlParams** that conform to this ICS.
FileSpec (Image)	w←	r	**FileSpec** (Image) SHALL be specified by the *Manager* if @*QualityControlMethods*="Inspection" and the *Measurement System* is an automated image inspection system. See ▸ [XJDF 2.1].

Table 4.37: QualityControlParams element

NAME	MANAGER	WORKER	DESCRIPTION
FileSpec (Setup)	w!		A reference to a proprietary setup SHALL NOT be provided and is out of scope for this ICS.
RegistrationQuality	w←	r←	**RegistrationQuality** SHOULD be supplied if @*QualityControlMethods* contains "Registration".

4.9 QualityControlResult

4.9.1 ResourceSet

Table 4.38: QualityControlResult ResourceSet element

NAME	MANAGER	WORKER	DESCRIPTION
Name	r	w←	See ▶ [XJDF 2.1].
QualityControlResult	r	w←	The value of @*Name* SHALL be "QualityControlResult".
Usage	r	w←	See ▶ [XJDF 2.1].
Output	r	w←	The value of @*Usage* SHALL be "Output".
Resource	r	w←	See ▶ [XJDF 2.1].

4.9.2 Resource

Table 4.39: QualityControlResult Resource element

NAME	MANAGER	WORKER	DESCRIPTION
Part	r	w←	**Part** SHALL define the context of the measurement. The values of **Part** SHALL be retained from **QualityControlParams** to **QualityControlParams**. Missing partition keys SHALL be added to **Part** to provide additional context of the measurement.
QualityControlResult	r	w	**QualityControlResult** SHALL be present.

4.9.3 Part

Table 4.40: QualityControlResult Part element

NAME	MANAGER	WORKER	DESCRIPTION
QualityMeasurement	r	w←	@*QualityMeasurement* SHALL be specified for all **QualityControlParams** measurements where multiple measurements types are made for a single press run. **QualityControlResult**/@*Sample* SHALL NOT overlap if @*QualityMeasurement* differs.
Separation	r	w←	@*Separation* SHALL be specified for all **QualityControlParams** measurements that apply to a print pass of one or more separations if multiple press runs are measured for the same values of @*SheetName* and @*Side*.
SheetName	r	w←	@*SheetName* SHALL be specified for all **QualityControlParams** measurements that apply to an individual sheet or impression on a roll.
Side	r!	w←	@*Side* SHALL be specified for all **QualityControlParams** measurements that apply to an individual surface.

Table 4.40: QualityControlResult Part element

NAME	MANAGER	WORKER	DESCRIPTION
<all other attributes>	r?	w?	Additional partition keys MAY be specified, but are out of scope for this ICS..

4.9.4 QualityControlResult

Table 4.41: QualityControlResult element

NAME	MANAGER	WORKER	DESCRIPTION
End	r	w	Date and time when the measurement was completed.
Failed	r	w←	@*Failed* SHALL be specified, if any measurement was detected that did not pass the criteria as specified in **QualityControlParams**.
Measurements	r	w	Total number of measurements.
MeasurementUsage	r	w	See ▸ [XJDF 2.1].
Master	r	w←	A value of "Master" SHALL NOT be specified if the value of **QualityControlParams**/@*QualityBase*="Absolute". See ▸ [XJDF 2.1].
Standard	r	w←	See ▸ [XJDF 2.1].
Passed	r	w←	@*Passed* SHALL be specified, if any measurement was detected that passed the criteria as specified in **QualityControlParams**.
Position	r	w?	@*Position* SHALL NOT be specified if **Part**/@*Side* is present.
QualityControlMethods	r	w	@*QualityControlMethods* SHALL be specified and contain copies of the supported values specified in **QualityControlParams**/@*QualityControlMethods*. Values SHOULD be one of the following:
Barcode	r←	w←	Barcode SHOULD be specified for measurements that test the quality of barcodes. Note: this includes linear and 2-d barcodes.
ColorDensitometry	r←	w←	ColorDensitometry SHOULD be specified for measurements that contain only density measurements.
Colorimetry	r←	w←	Colorimetry SHOULD be specified for measurements that cannot measure spectral data.
ColorSpectrophotometry	r←	w←	A value of ColorSpectrophotometry SHALL be specified for measurement devices that support spectral measurements. Additional values MAY be supplied.
Inspection	r←	w←	Inspection SHOULD be specified for measurements of general image quality.
Registration	r←	w←	Registration SHOULD be specified for color separation registration measurements.
<all other values>	r?	w?	Additional methods MAY be specified but are out of scope for this ICS.
Sample	r	w←	@*Sample* SHALL be specified and SHALL not overlap if multiple measurements occur during one press run. **Note:** @*Sample* will typically be based on job good counters or device counters.
Severity	r←	w←	@*Severity* SHALL define the overall severity of all defects on a scale of 0(no defects present) ,1(trivial) to 100 (fatally severe).

Table 4.41: QualityControlResult element

NAME	MANAGER	WORKER	DESCRIPTION
SourceDeviceID	r	w←	@*SourceDeviceID* SHALL contain the identifier of the device if it is an *Inline Measurement* device. @*SourceDeviceID* SHOULD contain the identifier of the device if it is an *Offline Measurement* device.
Start	r	w	Date and time when the measurement was started.
ColorMeasurement	r←	w←	*ColorControlStrip* SHALL be supplied if the *Manager* provided *QualityControlParams*/*ColorMeasurement*. *ColorControlStrip* SHOULD be provided otherwise.
Inspection	r←	w←	*Inspection* SHALL be supplied if the *Manager* provided *QualityControlParams*/@*QualityControlMethods*="Inspection".
RegistrationQuality	r←	w←	*RegistrationQuality* SHALL be supplied if the *Manager* provided *QualityControlParams*/*RegistrationQuality*.
FileSpec		w!	A reference to proprietary data SHALL NOT be provided in the scope of this ICS.

4.9.5 Inspection

Inspection SHALL contain the details of an automated or visual inspection.

Table 4.42: Inspection element

NAME	MANAGER	WORKER	DESCRIPTION
Defect *	r	w←	One *Defect* element SHALL be provided for each detected defect. The detection threshold is implementation dependent.

4.9.6 Defect

Table 4.43: Defect element

NAME	MANAGER	WORKER	DESCRIPTION
Box	r	w←	If a defect size is known, the outer bounding box SHALL be specified in @*Box*. The details how the size of a defect is calculated are implementation dependent.
DefectType	r	w	@*DefectType* SHALL be specified.
ImageDefect	r	w←	ImageDefect SHOULD be specified by automated sytems that compare measured and target images.
<all other values>	r	w?	Other defect types MAY be specified, but are out of scope for this ICS.
DefectTypeDetails	r	w	@*DefectTypeDetails* SHALL be specified.
ImageMismatch	r	w←	ImageMismatch SHOULD be specified by automated sytems that compare measured and target images.
<all other values>	r	w?	Other defect type details MAY be specified, but are out of scope for this ICS.
Face	r	w←	See ▸ [XJDF 2.1].
Severity	r	w?	@*Severity* SHOULD be specified if a ranking of defects is implemented by the *Worker*.
Size	r	w←	If a defect size is known, the area of the defect SHALL be specified in @*Box*. The details how the size of a defect is calculated are implementation dependent.

Table 4.43: Defect element

NAME	MANAGER	WORKER	DESCRIPTION
Comment	r	w?	A human readable description of the individual defect MAY be provided. **Note:** This will typically be useful in manual quality measurement processes.

4.9.7 Comment

Comment SHALL contain a human readable description of the individual defect.

Table 4.44: Comment element

NAME	MANAGER	WORKER	DESCRIPTION
<element text>	r	w?	The *Worker* SHOULD provide human readable content in the body of the *Comment* element.

CIP4 INTEROPERABILITY CONFORMANCE SPECIFICATION

5 Subelements

5.1 ColorControlStrip

ColorControlStrip SHALL provide a detailed definition of the measurement patches. If *ColorControlStrip* is specified as a descendent of *Layout*, geometrical information SHALL be provided by the *Manager* as specified below. If *ColorControlStrip* is specified as a child of *QualityControlParams* it SHALL specify color quality *Target Values*. If *ColorControlStrip* is specified as a child of *QualityControlResult* it SHALL specify color quality measurements results.

Table 5.1: ColorControlStrip Element

NAME	MANAGER	WORKER	DESCRIPTION
Center	w← r?	r w?	@*Center* SHALL be specified by the *Manager* if *ColorControlStrip* is in a descendant of *Layout*.
Rotation	w← r?	r w?	@*Rotation* SHALL be specified by the *Manager* if @*Center* is present.
Size	w← r?	r w?	@*Size* SHALL be specified by the *Manager* if @*Center* is present.
StripType	w← r	r w←	@*StripType* is the name or type of the *ColorControlStrip*. At least one of *Patch* or @*StripType* SHALL be specified. **Note:** The exchange, synchronization and measurement setup for *ColorControlStrip* elements that are specified by @*StripType* is out of scope for this ICS.
ColorMeasurementConditions	w← r	r w	*ColorMeasurementConditions* SHALL specify the color measurement conditions that SHALL be or have been used for this *ColorControlStrip*. *ColorMeasurementConditions* SHALL be provided by the *Manager* if *ColorControlStrip* is in a child of *QualityControlParams*.
Patch *	w← r	r w	*Patch* provides the descriptions of the individual color patches. *Patch* NEED NOT be provided by the *Manager* if @*StripType* is present and refers to a standard strip that is known by the *Worker*. At least one of *Patch* or @*StripType* SHALL be specified.

5.2 ColorMeasurement

ColorMeasurement SHALL provide a detailed definition of the color measurements. If *ColorMeasurement* is specified as a child of *QualityControlParams* it SHALL specify color quality *Target Values*. If *ColorMeasurement* is specified as a child of *QualityControlResult* it SHALL specify color quality measurements results.

Table 5.2: ColorMeasurement Element

NAME	MANAGER	WORKER	DESCRIPTION
ColorControlStrip ?	r← w←	r← w←	Details of the color control strip.

5.3 ColorMeasurementConditions

ColorMeasurementConditions SHALL specify the requested or actual color measurement conditions.

Table 5.3: ColorMeasurementConditions Element

NAME	MANAGER	WORKER	DESCRIPTION
MeasurementMode	w r	r w	Measurement mode SHOULD be a valid mode as specified in ▸[ISO13655:2017]. **Note:** The exchange, synchronization and measurement setup for proprietary **ColorMeasurementConditions** that are not defined by ▸[ISO13655:2017] is out of scope for this ICS.
WhiteBase	w? r	r← w	See ▸[XJDF 2.1] for details. @*WhiteBase* SHALL be provided for actual measurements from the device. If a *Measurement System* is capable of switching white base modes and the *Manager* requests a certain value of @*WhiteBase*, the *Worker* SHOULD honour the request.

5.4 FileSpec

FileSpec SHALL reference explicit URLs in the context of this ICS.

Table 5.4: FileSpec Element

NAME	MANAGER	WORKER	DESCRIPTION
FileFormat	w!		See ▸[XJDF 2.1].
FileTemplate	w!		See ▸[XJDF 2.1].
ResourceUsage	w←	r	@*ResourceUsage* SHALL be specified if the parent contains muliple **FileSpec** elements. @*ResourceUsage* NEED NOT be specified if the parent contains a single **FileSpec** element. For multiple **FileSpec** elements with a common parent, values of **FileSpec**/@*ResourceUsage* SHALL be unique.
Image	w←	r	A value of "Image" SHALL be specified if the **FileSpec** element references a master image for image inspection.
<all other values>	w?	r?	Other values MAY be specified, but are out of scope of this ICS.
UID	w!		See ▸[XJDF 2.1].
URL	w	r	See ▸[XJDF 2.1].

5.5 Header

Table 5.5: Header Element

NAME	MANAGER	WORKER	DESCRIPTION
ICSVersions	r←	w←	The value of @*ICSVersions* SHALL specify the ICS that **SignalResource** conforms to.
MisQC_L1-2.1	r	w←	A conforming *MisQC* document from a *Static Worker* SHALL contain a value of "MisQC_L1-2.1".
MisQC_L2-2.1	r	w←	A conforming *MisQC* document from a *Dynamic Worker* SHALL contain a value of "MisQC_L2-2.1".
Time	r	w	@*Time* SHALL define the time when the quality report was generated. **Note:** Times of measurement are defined in **QualityControlResult**/@*Start* and **QualityControlResult**/@*End*.

5.6 Patch

Patch SHALL provide a detailed definition of the an individual color measurement patch. The usage of *Patch* as a target or a measurement is identical to the usage of the parent *ColorControlStrip*.

Table 5.6: Patch Element

NAME	MANAGER	WORKER	DESCRIPTION
Density	w? r	r? w←	@*Density* SHALL be provided by the *Worker* if the *Worker* measured the density directly.
Lab	w? r	r? w←	@*Lab* SHALL be provided by the *Worker* if the *Worker* is capable of measuring an Lab value. @*Lab* SHOULD be provided if @*Spectrum* is present.
NeutralDensity	w? r	r? w←	@*NeutralDensity* SHALL be provided by the *Worker* if the *Worker* measured the neutral density directly.
PatchUsage	w r	r w	See ▸ [XJDF 2.1].
Color	w← r	r w←	A value of @*PatchUsage*="Color" SHALL specify that the patch is present and SHALL be or has been measured.
Ignore	w← r	r w←	A value of @*PatchUsage*="Ignore" SHALL specify that the patch is present but not relevant for measurements. A value of @*PatchUsage*="Ignore" SHALL also be set by the *Worker* if measurement errors occured that make the measurement invalid.
<all other values>	w? r?	r? w?	Other uses for the patch MAY be specified, but are out of scope of this ICS.
Spectrum	w? r	r? w←	@*Spectrum* SHALL be provided by the *Worker* if the *Worker* is capable of measuring a color reflectance spectrum.
SeparationTint	w? r?	r w?	See ▸ [XJDF 2.1].

5.6.1 SeparationTint

Table 5.7: SeparationTint Element

NAME	MANAGER	WORKER	DESCRIPTION
Name	w r	r w	See ▸ [XJDF 2.1].
Tint	w r	r w	See ▸ [XJDF 2.1].

5.7 RegistrationQuality

Table 5.8: RegistrationQuality Element

NAME	MANAGER	WORKER	DESCRIPTION
Offset	w r	r w	See ▸ [XJDF 2.1].
Reference	w r	r w	See ▸ [XJDF 2.1].

5.8 ResourceInfo

This section defines the restrictions for a *ResourceInfo* that pertain to a quality report. *ResourceInfo* elements that are unrelated to quality control MAY be present in other *SignalResource* elements.

Note: For instance, *ConventionalPrintingParams*, *DigitalPrintingParams* and *PrintCondition* can be provided to specify the print method. *Media*, *MiscConsumable* or *Ink* can be provided to specify the paper and other consumables that were consumed. The details of these resources in the context of *ResourceInfo* are out of scope for this ICS.

Table 5.9: ResourceInfo Element

NAME	MANAGER	WORKER	DESCRIPTION
ResourceSet [@*Name*="QualityControlResult"]	r	w	A *QualityControlResult* SHALL contain the results of the quality control measurements. The value of @*Usage* SHALL be "Output".

A References

Table A.1: References

TERM	DEFINITION
[ICS-Cus-APP]	*Customer to Electronic Publishing* Date: April 2014 Version: 1.5 Produced by: CIP4 Organization Available at: http://www.cip4.org
[ICS-MIS-CP]	*MIS to Conventional Printing ICS* Date: April 2014 Version: 1.5 Produced by: CIP4 Organization Available at: http://www.cip4.org
[ICS-MIS-Fin]	*MIS to Finishing ICS* Date: April 2014 Version: 1.5 Produced by: CIP4 Organization Available at: http://www.cip4.org
[ISO12647-2:2013]	*Graphic technology -- Process control for the production of half-tone color separations, proof and production prints - Part 2: Offset lithographic processes* Date: 2013 Produced by: ISO Available at: https://www.iso.org/store.html
[ISO12647-3:2013]	*Graphic technology - Process control for the production of half-tone colour separations, proof and production prints - Part 3: Coldset offset lithography on newsprint.* Date: 2014 Produced by: ISO Available at: https://www.iso.org/store.html
[ISO12647-4:2014]	*Graphic technology - Process control for the production of half-tone colour separations, proof and production prints - Part 4: Publication gravure printing.* Date: 2014 Produced by: ISO Available at: https://www.iso.org/store.html
[ISO13655:2017]	*Graphic technology -- Spectral measurement and colorimetric computation for graphic arts images* Date: 2017 Produced by: ISO Available at: https://www.iso.org/store.html
[ISO 17972-4:2018]	*Graphic technology -- Colour data exchange format (CxF/X) -- Part 4: Spot colour characterisation data (CxF/X-4)* Date: 2018 Produced by: ISO Available at: https://www.iso.org/store.html

Table A.1: References

TERM	DEFINITION
[XJDF 2.1]	*Exchange Job Definition Format* *Version 2.1* Date: August 2020 Version: 2.1 Produced by: CIP4 Organization Available at: http://www.cip4.org

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