



GO™

PRODUCE

LASER EDITION

**User manual
Revision 006**

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1 INSTALLATION

1.1 General

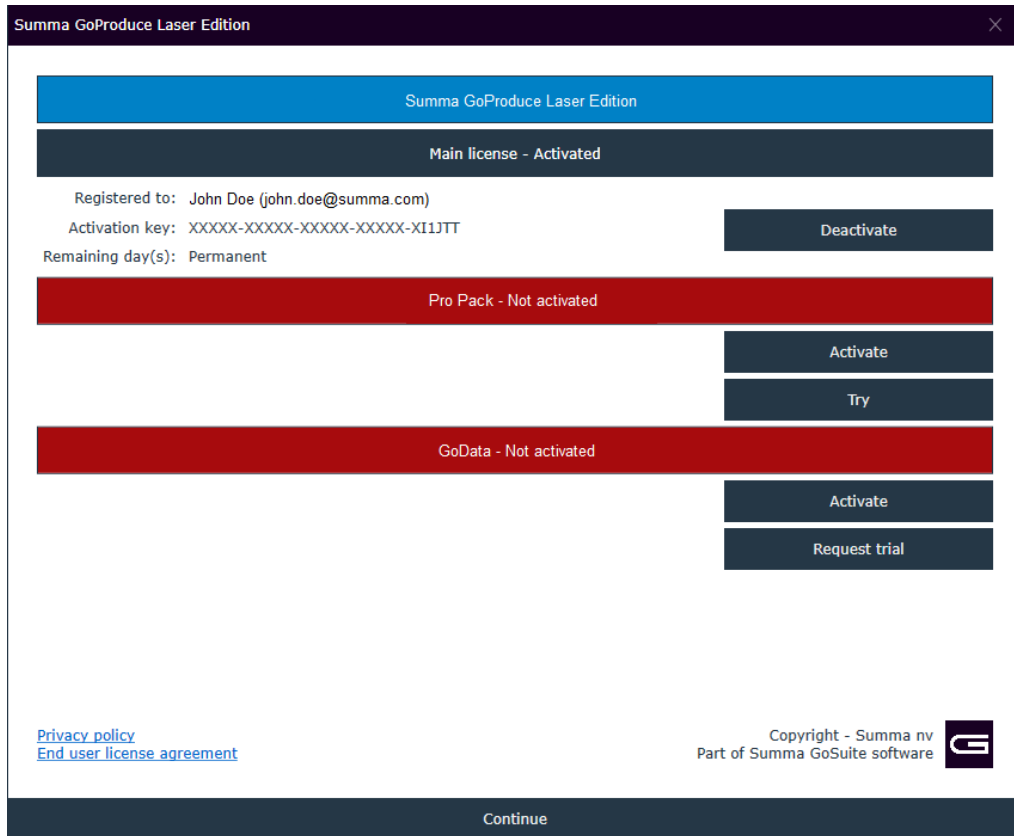
Summa GoProduce Laser Edition is a Windows-based production software that integrates the L-Series into the workflow. It is the perfect link between the design station, RIP station, printers and cutting devices. Once the workflow is set up, macros automate the process. Consequently, the number of times the operator has to intervene to start the next job is reduced to a minimum, as is the downtime of the machine.



NOTE: The program is copy protected with a license code. Different license codes can unlock different options in the program.

1.2 Installation

1. Double-click the installation program to start the setup. Follow the on-screen instructions to complete installation and click **Continue**. You can now activate or try the optional software programs by clicking the corresponding buttons.



NOTE: All license keys are sent to you by email.



NOTE: You can always access the license overview screen by clicking **General** > **About** in Go Produce Laser Edition, e.g., for activating the license keys later.



NOTE: The trial license key is linked to the computer. Only one trial version can be installed per computer. It is, however, possible to activate a purchased license code on that same computer afterwards.

2 SETUP


Before using the software, a few things must be set.

2.1 Device settings

2.1.1 Adding a cutter by autodetection

When starting the software, the following screen appears.

1. Make sure the computer is connected to the laser cutting machine.

2. Click  to detect your laser cutter. The name of your laser cutter will appear in the dialog window.

3. Click the connected laser cutter that you will work with.

4. If you want to cut on-the-fly, tick the corresponding box.

5. Select the camera system that you want to use (Vision or head camera).

6. Click **OK** to confirm.

This screen can be accessed at any time via **Devices > Edit**.

2.1.2 Plot to file

1. Click the **Plot to file** tab.
2. Change the parameters as necessary.



NOTE: Both the minimum possible width and length are 100 mm, the maximum possible width and length are 50 m.

Summa GoProduce Laser Edition - Device

Name

Address

Device family

Device model PlotToFile

Device serial number XXXXXX-XXXXX

Cut on the fly

Auto detect Plot to file

Width inch

Length inch

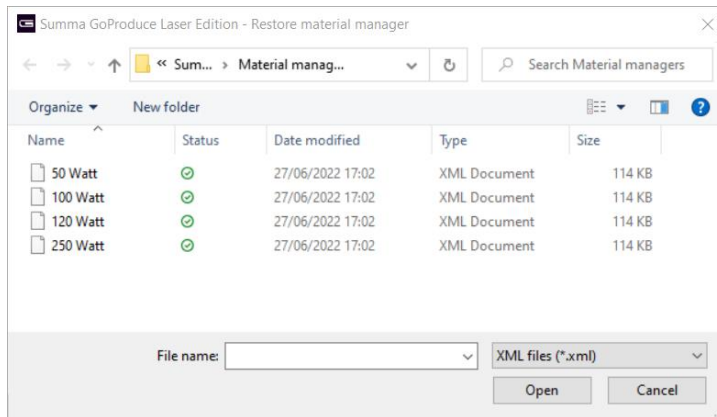
Output directory


OK Cancel

3. Click **OK** to confirm.

2.2 Material manager import

1. Click the **General** tab > **Restore** (in the **Material manager** category). The following screen appears.



2. Select the power rating of your laser unit (if you are unsure, you can check this by tapping  in the home screen on the touch panel). The table below will help you determine what material manager needs to be imported.

Laser source	Power rating
Universal ULR 50	50 watts
Universal ULR 100	100 watts
Luxinar SR10i	120 watts
Luxinar SR 25i	250 watts

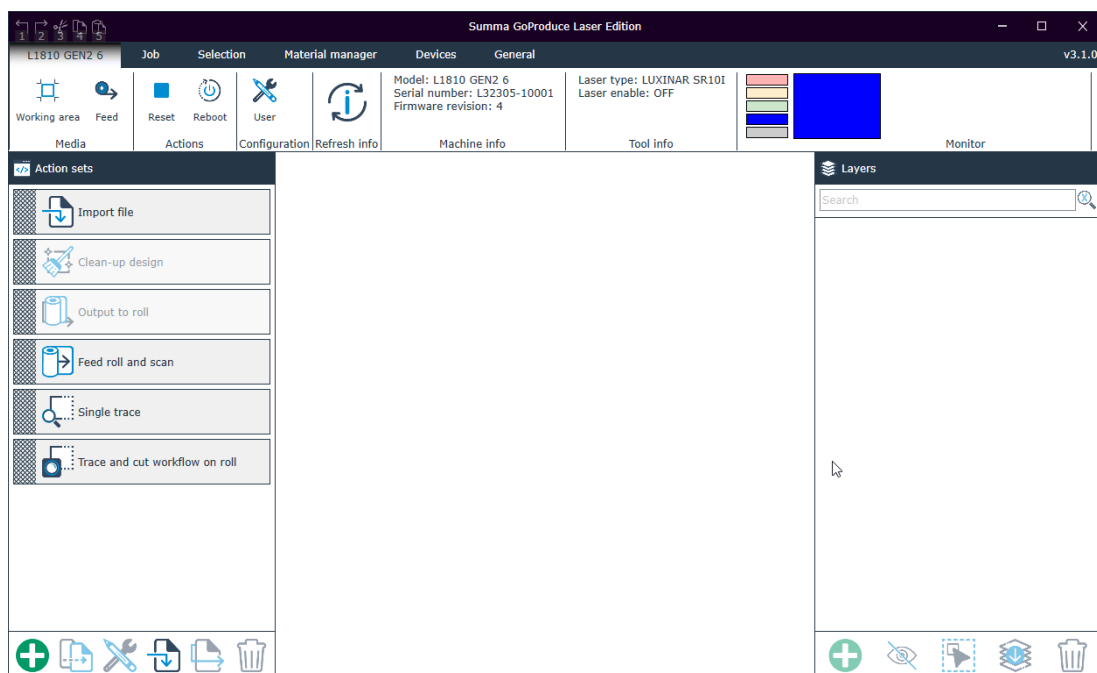
3 STANDARD PROGRAM



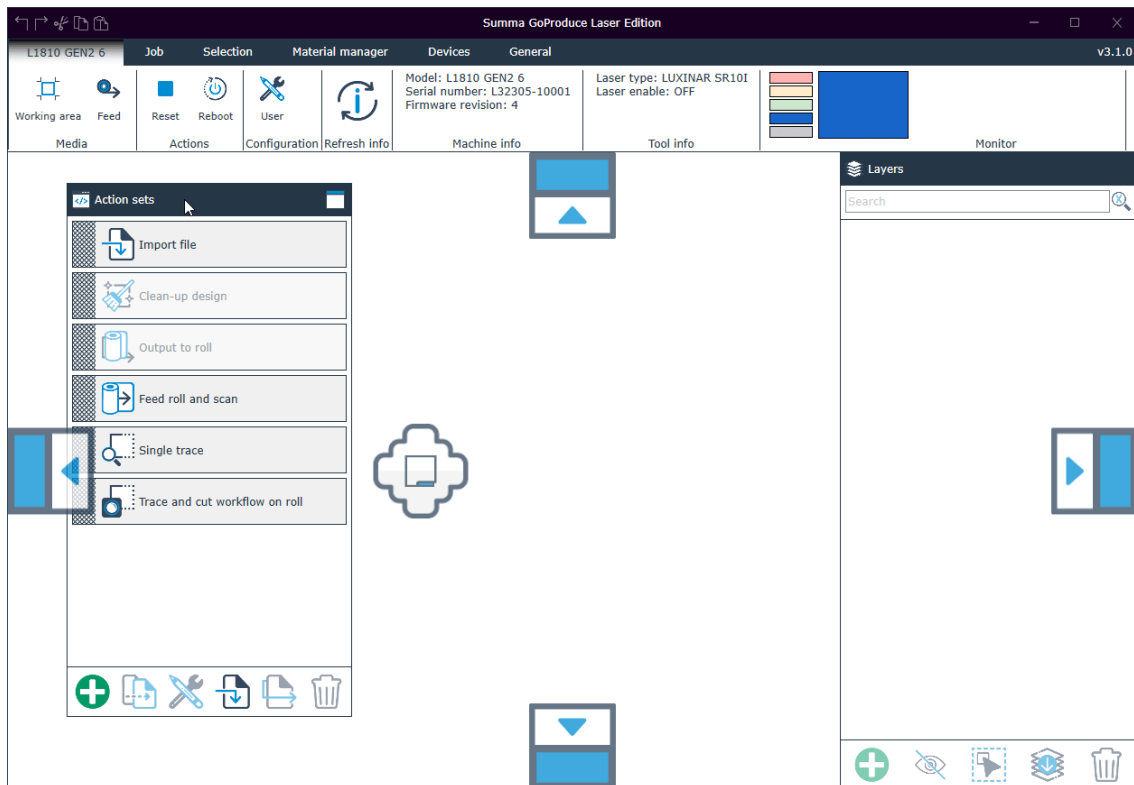
NOTE: When GoProduce Laser Edition communicates with the table, it first checks the firmware revision. If the firmware revision is not compatible with the current version of GoProduce Laser Edition, a message will appear. You will not be able to send any cut data to the table. The cutter firmware needs to be updated first. Please refer to the manual of Summa GoCare.

3.1 Main window

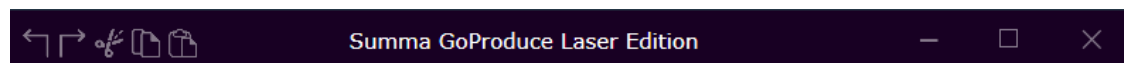
The window of the program Summa GoProduce Laser Edition has 4 main areas. The ribbon contains 6 tabs. At the left side, there is a docked window with the action sets. On the right side, there is a docked window with layer information. In the middle, a job preview will be shown. If multiple jobs are opened, they open in docked tabs of the middle window.



All docked windows can be set floating. Just click the name of the window and drag it where you want it to be. There are also shortcuts for docking the window on the left, right, top, bottom, or the rest of the free area.



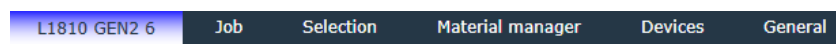
3.2 Quick access toolbar



The commands of the quick access toolbar are displayed in the title bar: undo, redo, cut, copy, and paste.

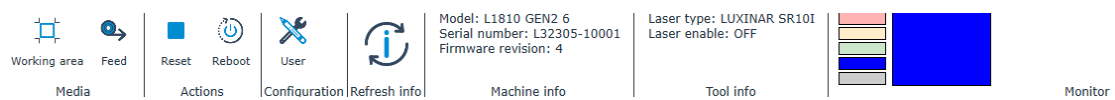
3.3 Ribbon

The ribbon has 6 tabs.

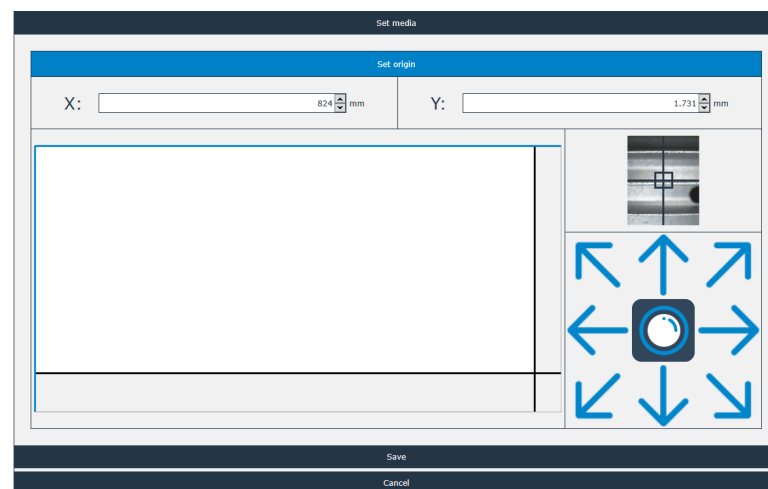



3.3.1 First tab

The first tab is named after the machine the computer is connected to.



Click the **Working area** icon to set the origin and size. The following window opens:

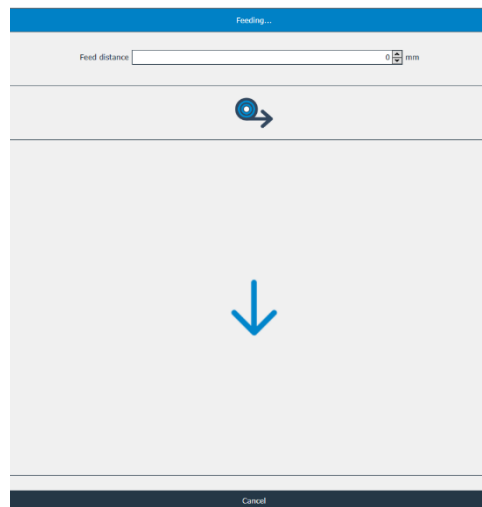


Use the camera image on screen or the laser nozzle on the machine as a reference. Click  to toggle between these two. Use the arrows, fill in the values or click in the area to set the media size. Click **Save** or **Cancel**.





Feed

Click the **Feed** icon to open the feed media window.



Use the up and down arrows or fill in a value to set the desired feed distance,

then press  to execute, or simply click and hold  to feed continuously.



Reset

Click **Reset** for stopping.



Reboot

Click **Reboot** for a warm reset (similar to rebooting, without having to switch off and on).




User

Configuration

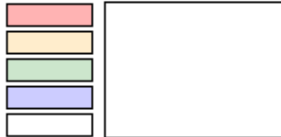
Click **User** for setting some parameters that will be used when initiating a test or calibration routine from the program GoCare. These settings will not be used for jobs started from the program GoProduce Laser Edition. This program will overwrite them.

Parameters that can be set:

Editing device user settings.	
LASER ENABLE	OFF
FEED VELOCITY	100
LASER MIN	10
LASER MAX	100
VELOCITY	1000
FEED DISTANCE	3,000
QUALITY LEVEL	QUALITY
Save	

	Model: L1810 GEN2 6 Serial number: L32305-10001 Firmware revision: 4	Laser type: LUXINAR SR10I Laser enable: ON
	Refresh info	Machine info

The machine info field shows the laser cutter type and its revision number. The tool info field shows the laser type. If this info is not shown, click [Refresh info](#).



This section shows the cutter status. Sometimes a message can appear to the right of the larger coloured rectangle to get the operators attention.

Idle Mode:



The cutter is in idle mode, waiting for user input or ready to start a job.

Warning:



The operator is requested to check the status of the cutter and, if necessary, take action to resolve the issue.

Error:



An error has occurred causing the cutter to become non-operational. The error must be resolved first. Intervention is required.

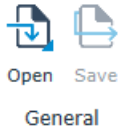
In Operation:



The cutter is currently actively performing a task or operation (loading, cutting,...).

3.3.2 Job tab

This tab contains some basic editing features that can optimize job cutting. Most of those functions can be included in the import action set. A default import action already includes some of these functions. You can create additional specific import actions that also include these features.



Click **Save** to save a job. They are stored as SGLJ files. Click **Open** to open a job. Jobs include the original cut data that was imported, and settings related to material and tools. Thus, if copies of previous jobs are needed, they can easily be created using the settings used earlier.

NOTE: The basic version of GoProduce Laser Edition allows importing the following file types:



- SGSJ files (*.sgsj; *.SGSJ)
- PDF files (*.pdf; *.PDF)
- DXF files (*.dxf; *.DXF)
- OXF files (*.oxf; *.oxf2; *.OXF; *.OXF2)
- SGP files (*.sgp; *.SGP)
- SVG files (*.svg; *.SVG)



Export

When the Pro Pack is installed, you can export the job to a PDF file.

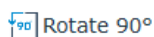


Fit working area
to device



Fit working area
to objects

Click **Fit working area to device** to reset the working area to the device size. The cutter needs to be connected, and the media loaded. Click **Fit working area to objects** to use the bounding box of all your objects as working area.



Mirror horizontal

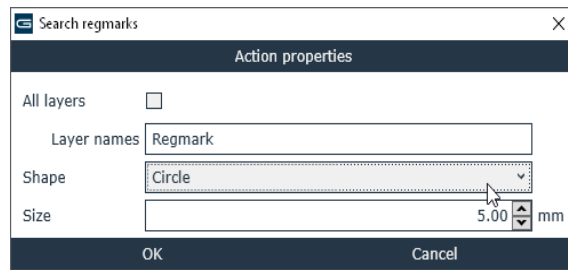
Mirror vertical

Click Rotate 90° to rotate the job 90° CCW. Click **Mirror horizontal** or **Mirror vertical** to mirror the job horizontally or vertically. The objects do not have to be selected first; clicking the action automatically selects all objects before the action is performed.



Print & cut

This function searches for the registration marks on certain layers. Usually, the registration marks are recognized while importing the file. In some cases, however, additional registration marks may have been added on special layers or the file to be imported may not have been prepared correctly. In that case, this function can be used to scan each layer for registration marks. First, right-click the icon. A settings window will open.



You can scan all layers or enter the name of a specific layer to be scanned and searched for marks. More parameters appear to define the shape and size of the registration marks. Set all the parameters to the desired value and click **OK**. Then click **Search remarks**. If registration marks are found on the selected layer, they are given this property and are made clearly visible on the screen.



This function checks whether all objects are closed. When an object is not closed, this function will close it. This action is applied to all objects. The standard import action will do this automatically (see section 3.4).



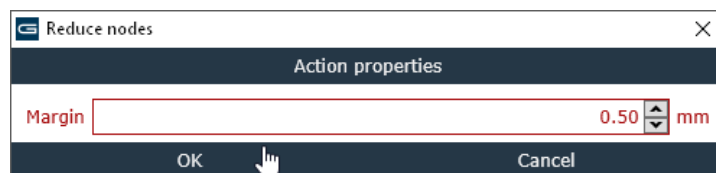
Right-click the **Close objects** icon to define the distance that can be covered to close an object. The maximum allowed value is set at 3 mm.



NOTE: The higher the chosen value, the more cut data and quality can be lost.



This function can be used to reduce the number of nodes. This action is applied to all objects. If the distance between three nodes is less than the set value, the middle node is deleted. The two nodes that remain are connected with a line.



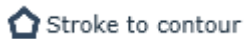
Right-click the **Reduce nodes** icon to define the distance below which the middle nodes must be deleted. The maximum allowed value is set at 3 mm.



This function breaks curves at intersections and is usually used in combination with other clean-up functions. It isolates common parts of different curves so that those double parts can be deleted. The downside is that after this, some curves will be open, which can negatively affect the sorting process. The maximum allowed value is set at 3 mm.



NOTE: The higher the chosen value, the more cut data and quality can be lost.



This function automatically converts all strokes to contours. Sometimes jobs are poorly designed, and a contour line was defined using a brush or other less appropriate tool, rather than by a single line. In that case, the program can convert those double lines into a single line. The inner lines will be deleted, and the outer line will be kept. We recommend to not rely on this feature too often but instructing designers to define correct cut lines.



This function automatically selects all lines (open curves) and deletes any double lines. Right-click the icon to set the maximum distance. The maximum allowed value is set at 3 mm.



NOTE: The higher the chosen value, the more cut data and quality can be lost.



This function automatically selects all objects (closed curves) and deletes any double objects. Right-click the icon to set the maximum distance. The maximum allowed value is set at 3 mm.



NOTE: The higher the chosen value, the more cut data and quality can be lost.



This function reveals or hides the orientation of the objects. When you click it, a triangle appears at the starting point of each object, indicating the direction of the curve. Click the triangle to reverse direction, if necessary.



These two shortcut keys allow you to easily zoom in on all objects or the work area.

3.3.3 Selection tab

This tab contains the basic editing functions such as duplicate, resize, ...



Click this icon to select all objects in the job. Individual objects can be selected by clicking on them. A group of objects can be selected by drawing a selection frame around them; the objects must then be completely inside the frame. Hold down the shift key to add objects to the already selected group. Black selection handles will appear around the selected objects if the node selection option is not activated. Use the outer selection handles to resize the objects. Use the middle one to move the objects around.



Click this icon to reveal or hide the nodes of the selected objects. The selection handles disappear, and the nodes are displayed as squares. The starting point is a square just slightly larger than the others.

Once the nodes are selected, certain properties can be adjusted. Editing the nodes is not possible. Click a node to make it the new starting point. Clicking on the starting point node reverses the direction of the curve (can be made visible by making the starting point visible with the action in the **Job** tab).



Click this icon to zoom in on the selected objects.



Duplicate

Click this icon to duplicate the selected objects. The duplicate is placed 5 mm higher and more to the left so that it is clearly visible.



Group Ungroup

Click one of these icons to group or ungroup the selected objects.



This function allows you to resize and reposition the selected objects. The anchor point of an object ("object origin") can be changed by clicking one of the circles. The object can then be moved by changing the X and Y values. This allows you to align objects. The object can be resized by changing the width and height values or the percentage value. You can lock the proportions by clicking on the padlock icon. The origin point remains stationary when the size of the object or group of objects is changed.



Rotates the selected objects. First enter the rotation value, then click the icon. The bottom two icons are used to flip the selected objects horizontally or vertically. When rotating and flipping, the center point always remains stationary.

3.3.4 Material manager tab



GoProduce Laser Edition includes a material database that can be adapted to specific needs. The material manager offers the advantage of working with methods, which means you only need to select the material you want to process, and then the material manager automatically chooses the correct tool and settings to process the job.








Some RIPs allow selecting the material to be selected already when printing the job. In that case, you do not need to select the material type again in Summa GoProduce Laser Edition. This tab is not used when processing a job, but to predefine settings for different materials.



NOTE: In this tab, the default properties of the materials, methods and tools are chosen. So, if a job is processed and a setting needs to be changed just for this one time, change it in the layer window and not in the **Material Manager** tab.




3.3.4.1 Materials




-  **Default** : Set the selected material as default material. If no material is defined in the cut data file, Summa GoProduce Laser Edition will automatically use the default material.
-  **New** : Create a material. This opens the material editor (see chapter 3.3.4.1.1 Material editor on page 21).
-  **Edit** : Edit the selected material. This opens the material editor (see chapter 3.3.4.1.1 Material editor on page 21).
-  **Delete** : Delete the selected material. A material cannot be deleted when it is being used.
-  **Import** : Import a material. Several predefined materials are available.
-  **Export** : Export the selected material to use on another computer.
-  **Duplicate** : Duplicate the selected material.

3.3.4.1.1 Material editor

- **Name** and **Category**: A material type is primarily defined by its name and is part of a category.
- **Description**: Add a description that clarifies the material type or add additional information that may be relevant for processing the material.
- **Camera profiles**: A series of default camera profiles are installed when the program is installed. Each material type has three camera type profiles linked to it:
 - *Remark* is used to recognize the registration marks.
 - *Barcode* is used to recognize the barcode.
 - *Trace* is used to recognize the object outlines and allows media edge recognition.
- **Methods** are chosen in the design program and are linked to a certain tool appropriate for this material.

-  : Create a method.
-  : Duplicate the selected method.
-  : Delete the selected method.

- **Tools**: Click the cross-hatched area of a method to see which tool is linked to it.

-  : Choose a tool to link to the selected method. Note: Each time a parameter for a certain tool is changed, a button pops up to make it possible to save it as the default value.



: Set the parameters for the selected tool. Select the tool by clicking the cross-hatched area in front of the tool name. You can have different sets of parameters for each tool:



: Create a set of parameters.



: Set this set of parameters as default.



: Delete this set of parameters.




: Duplicate this set of parameters.


3.3.4.1.2 Tool parameters

- **Minimum power:** During cutting, the power of the laser is controlled so that the quality of cut remains as constant as possible even when the laser is accelerating and decelerating. When the laser reaches a very slow speed, for instance on very tiny curves, the minimum power setting prevents the power from reducing to below zero. This is the minimum power output the laser will reach.
- **Maximum power:** The maximum power output of the laser during cutting. If the cut is too deep, even at maximum speed, then reduce the power. Also, if the cut depth is correct but the cut edge quality could be improved, try reducing both power and speed.
- **Number of passes:** The number of times the laser cuts the same line. Increasing this number may be necessary when cutting thick material.
- **Quality level:** This is an overall quality parameter, which is default set to 'High'. Setting it to 'Standard' increases the throughput.
- **Speed:** This is the speed at which the laser cuts. Reduce this speed for thicker materials.
- **Segment connector:** In long cut-only jobs, the segments may not join 100%. This parameter is created to solve this. It cuts small extra lines (3 mm in length), ensuring that closed curves are closed when they are cut in segments. This will make sure that large, closed curves are easy to weed. This option is set to *Keep inner shape* by default. **Length** (by default 3mm) and **Angle** (max. 45°) of the segment connector can be adjusted.

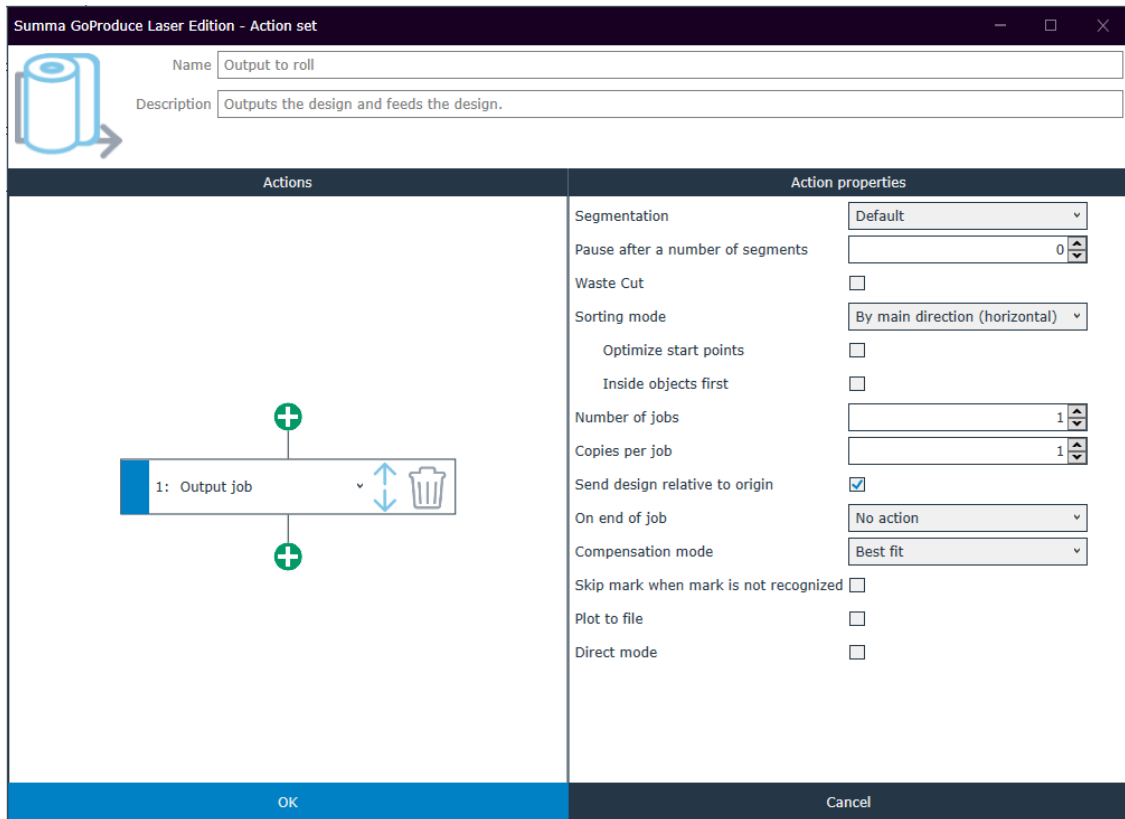
3.3.4.1.2.1 Power settings for a new material

This procedure describes how to determine the required power settings for a new material. Please use the cut file *Power Test* that is installed by default for this procedure.

1. Place a piece of the material you want to determine the power settings for on the conveyor.
2. Prepare the machine for a workflow (activate the chiller and fume extraction, power on protective equipment etc.).
3. Launch GoProduce Laser Edition and navigate to the **Material Manager** tab. In the **Materials** pane, click  **New**. The following window appears.

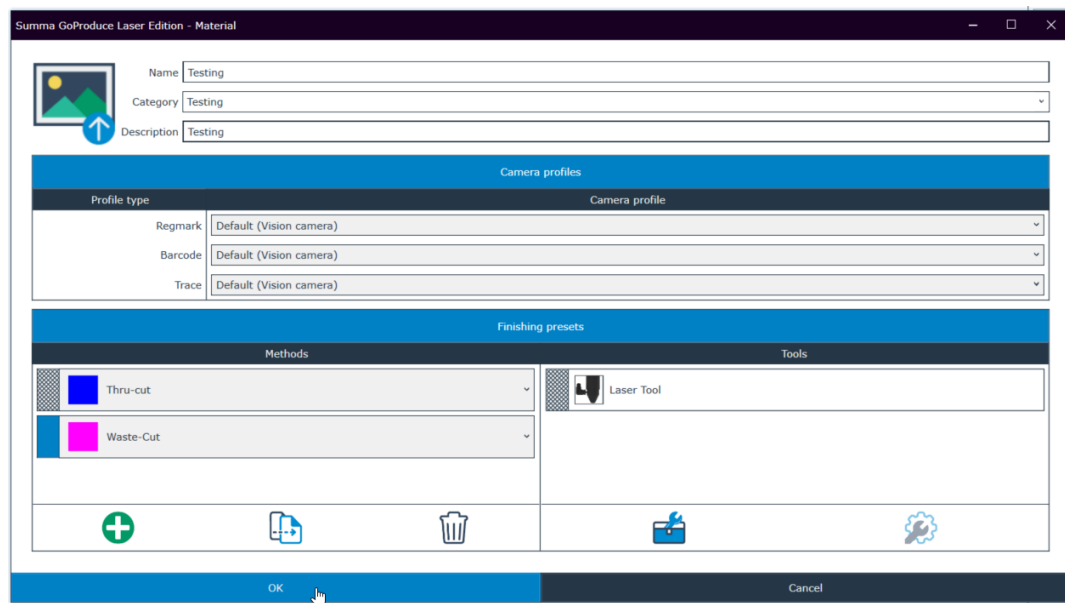
4. Enter the information of the new material (such as name, category, description).
5. Select the camera profiles you want to use in the workflow for cutting this material. More information on the camera profiles can be found in chapter 3.3.4.3 Camera profiles on page 26.
6. Manage the methods you want to use with this material. In general, you will need the *Thru-Cut* and *Waste-Cut* methods. More information on the methods can be found in chapter 3.3.4.2 *Methods* on page 25.
7. Change the laser tool properties by selecting the cross-hatched area of the laser tool. Click  to open the parameter settings screen.
8. Set the parameters of the Thru-Cut method to the following values:
 - Minimum power: 15%
 - Maximum power: 100%
 - Number of passes: 1
 - Quality level: Standard

- Speed: 1000mm/s
 - Segment connector: Off
9. Output the *Power test.pdf* job from the following folder: ... \Documents\Summa GoProduce Laser Edition\Sample files\Cut files. Make sure the output options are the same as shown below:



10. Check the cutting results from the previous step and check if the material is completely cut through or not:
- Completely cut through: Lower the power in increments of 5% until the material is not completely cut through anymore (e.g. 60%). Take the previous increment as a final maximum power setting (in this case 65%).
 - Not completely cut through: Lower the cutting speed in increments of 100mm/s until the material is not completely cut through (e.g. 400 mm/s).




11. When the power settings for the Thru-Cut method are set, set the parameters for the Waste-Cut method. As a rule of thumb, we use the same settings as for the Thru-Cut method, but we increase the power by 10% and lower the speed by 100 mm/s. This is to make sure the material is completely cut through with the waste-cut action, as the edges of some materials might be thicker than the rest.
12. When all parameters for all the different methods have been set, click **OK** to close the material editor. The power settings for your material are now correctly set and your material is ready to be used.



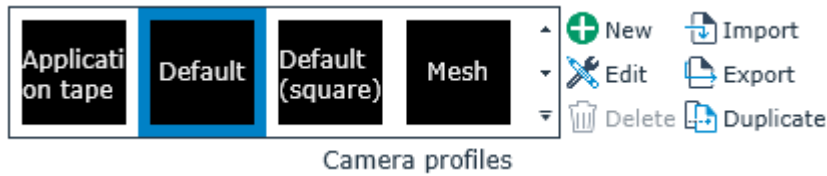
3.3.4.2 Methods



The different methods are also used in the design software. A method is material independent and only defines the action/result.







-  **New** : Create a method.
-  **Edit** : Edit the selected method (change its name or colour).
-  **Delete** : Delete the selected method. A method cannot be deleted when it is being used.

3.3.4.3 Camera profiles



There are three types of camera profiles: the *Remark* type camera profile (for detecting the registration marks), the *Barcode* type camera profile (for detecting the barcode), and the *Trace* type camera profile (for detecting the object outlines and media edges).

Different registration marks, different registration colours, different media colours... All these parameters influence the parameters that are needed for the camera to recognize the registration marks, the barcode, and the material edge. There are a couple of standard camera profiles installed when Summa GoProduce Laser Edition is installed. One camera profile can usually be used for a large range of materials.

-  **New** : Create a camera profile (ideally after having started a cutting job, so you can set the parameters according to the preview of the job that is shown on the screen).
-  **Import** : Import a camera profile.
-  **Edit** : Edit the selected camera profile (ideally after having started a cutting job, so you can set the parameters according to the preview of the job that is shown on the screen).
-  **Export** : Export the selected camera profile to use on another computer.
-  **Delete** : Delete the selected camera profile. A camera profile cannot be deleted when it is being used.
-  **Duplicate** : Duplicate the selected camera profile.



NOTE: We do not recommend changing the parameters of a profile that is installed by default. If parameters of a pre-installed profile need to be changed (for instance because of a strange ambient light source), then duplicate the profile, rename it, and change this profile.

3.3.4.3.1 Creating camera profiles

When using the head camera, a *Regmark* or *Barcode* camera profile can be created. When using the Vision camera system, a *Trace* camera profile can be created. The easiest way to create a camera profile for each of the profile types is described below.

3.3.4.3.1.1 *Regmark* - head camera

1. Load a job (that contains registration marks) on the conveyor and import the corresponding cutting file in the GoProduce Laser Edition software.
2. Click the **Output to Roll** action set and place the head camera above a registration mark when the software prompts you to.
3. Click **Edit profile settings**.
4. Change the parameter values as required for the software to detect the registration mark (see 3.3.4.3.2 *Parameters* on page 29 for tips). You can follow this in the preview. When a registration mark is detected, it is outlined in green.

3.3.4.3.1.2 *Barcode* - head camera

1. Load a job (that contains a barcode) on the conveyor and import the corresponding cutting file in the GoProduce Laser Edition software.
2. Click the **Output to Roll** action set and place the head camera above the barcode when the software prompts you to.
3. Click **Edit profile settings**.
4. Change the parameter values as required for the software to detect the barcode (see 3.3.4.3.2 *Parameters* on page 29 for tips). You can follow this in the preview.
5. Write down the parameter values.
6. Open the *Barcode* camera profile of the head camera and change the values to the values that you wrote down in the previous step.
7. Save the camera profile.

3.3.4.3.1.3 *Regmark* - Vision camera system

1. Click the **Feed roll and scan** action set to scan a job that contains registration marks.
2. Click the **Output to roll** action set and place the image above a registration mark.
3. Click **Edit profile settings**.
4. Change the parameter values as required for the software to detect the registration mark (see 3.3.4.3.2 *Parameters* on page 29 for tips). You can follow this in the preview. When a registration mark is detected, it is outlined in green.

3.3.4.3.1.4 *Barcode* - Vision camera system

1. Click the **Feed roll and scan** action set to scan a job that contains a barcode.
2. Click the **Output to roll** action set and place the image above the barcode.
3. Click **Edit profile settings**.
4. Change the parameter values as required for the software to detect the barcode (see [3.3.4.3.2 Parameters](#) on page 29 for tips). You can follow this in the preview.
5. Write down the parameter values.
6. Open the *Barcode* camera profile of the Vision camera and change the values to the values that you wrote down in the previous step.
7. Save the camera profile.

3.3.4.3.1.5 *Trace* - Vision camera system

1. Click the **Feed roll and scan** action set to scan a trace-and-cut job.
2. Make sure that **Direct mode** in the **Output job** action of the **Trace and cut workflow on roll** is off, before clicking the action set to perform the action.
3. Visually inspect if the software outcome corresponds to the real outcome: if the trace is bad, the parameter values should be altered (see [3.3.4.3.2 Parameters](#) on page 29 for tips). Then, repeat step 2 and 3 until the result is satisfying.



NOTE: If the trace outcome is satisfying but tracing took a long time, then change the **Radius** and **Constant** values (*Adaptive* threshold type).

3.3.4.3.2 Parameters

A brief description of all parameters is given below, but not all parameters are available for every type of camera profile. Depending on your choice of camera profile type, certain parameters may or may not need to be set.

- **Mark type:** Can be a circle, a square or a cross. If a registration mark is recognized, it will be outlined in green in the preview.
- **Median filter:** Preserves the edges but smooths out patterns. Tip: Start with a low value and increase if necessary.
- **Truncate filter:** All grey levels above the selected value are reduced to the selected value. Tip: Start with a high value and decrease if necessary.
- **Blur filter:** Blurs the picture slightly to smooth out sharper edges. Tip: Start with a low value and increase if necessary.
- **Edge smoothing filter:** Blurs out the pattern near the edges. Tip: Start with a low value and increase if necessary.
- **Threshold type:** *Global* (useful when there are no large differences in light intensity across the entire scan area) or *Adaptive* (takes into account the average value of the light intensity of a region of pixels and uses a threshold value for each region; useful when the light intensity in some areas in the scan area is a lot higher than in other areas).
- **Radius:** Determines the size of the adaptive threshold region. Tip: Start with a low value and increase systematically in increments of 10 if necessary, together with the **Constant** value.
- **Constant:** Determines the size of the adaptive threshold value. Tip: Start with a low value and increase systematically in increments of 10 if necessary, together with the **Radius** value.
- **Threshold filter:** Sets the level to decide whether an edge is white or black. Tip: Set this filter first. Start with a low value and increase systematically in increments of 10 if necessary.
- **Size margin:** Sets maximum deviation between the size of the printed registration mark and the size in the data file. Tip: Start with a low value and increase if necessary.
- **Minimum roundness:** Sets the maximum deviation between the roundness (difference x size – y size) of the registration mark. Tip: Start with a low value and increase if necessary.

3.3.5 Device tab



Edit

Device

Click this button to open the **Edit** screen. It shows the device your computer is connected to, the type and model of the laser cutter, and allows making changes to device-specific settings such as choosing which camera system should be used. If you want the Vision camera system to continuously scan the fabric and create the cut vector simultaneously, tick the **Cut on the fly** checkbox.

3.3.6 General tab

The fifth tab in the ribbon holds some general parameters and settings.



About
Info

Click this icon for information about the program. Also, the license manager is opened to add more licenses for extra options.



Tooltips
Help

Click this icon to switch the tooltips on or off.



Backup Restore Create pdf Create RIP xml

Click **Backup** to create a backup of the material manager. Click **Restore** to import an earlier saved backup or reset the material manager. Click **Create pdf** to generate a readable list of all the different materials in the material manager and the settings of the tools. The option **Create RIP XML** is used to create an XML that can consequently be imported into the RIP, so the material can be chosen at the time the job is printed.



Backup Restore Reset
Action sets

Click **Backup** to create a backup of the action sets. Click **Restore** to import an earlier saved action set. Click **Reset** to reset the action sets. The purpose of the action sets will be explained in the next section. We recommend taking a backup of your action sets before resetting, to avoid losing important action sets.



Backup

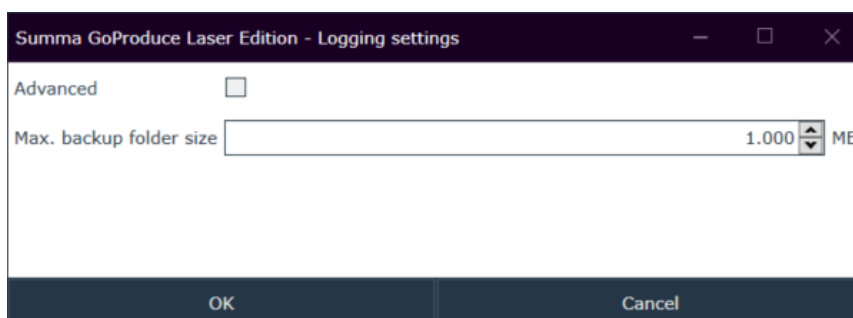
In the **Logging** pane, click **Backup** to create a backup of the loggings for future reference:

- Original design file
- Separate cut log for each workflow
- Vision scans and calibration file



Edit

Clicking **Edit** opens the following dialog window.



Ticking **Advanced** in this dialog window will also log:

- Job file in native format
- Metadata where possible
- Image processing

You can also define the maximum allowed backup folder size.



Language

The available languages are displayed here. Click a flag to change the display language of the program. A restart of the program is needed after changing the language.

mm

cm

inch

Unit

The user measurements units can be set and changed here.

Software rendering

Motion detection

Tick **Software rendering** when the camera window in GoProduce Flatbed Edition shows the video image but freezes when you move the cursor. This issue is possibly related to certain video cards. **Motion detection** can be enabled if it causes delays and noise with head cameras.



Edit

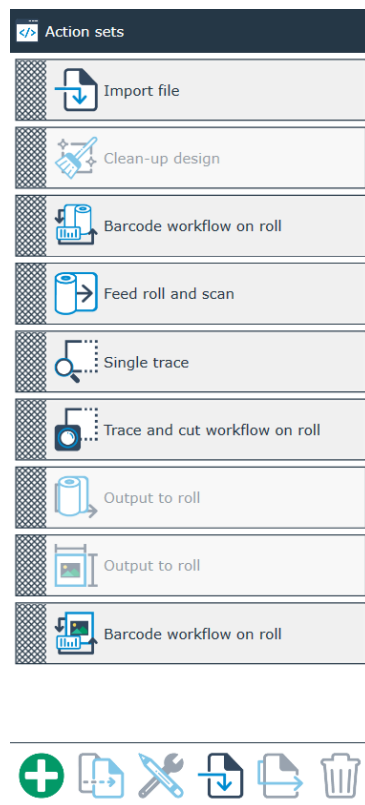


View

GoData







Only available if your GoData license is activated.

3.4 Action sets



Action sets can be workflows or a group of frequently recurring processing functions to determine how the material is to be processed. When Summa GoProduce Laser Edition is installed, a few default action sets are installed as well.

3.4.1 General

-  : Create an action set.
-  : Duplicate the selected action set.
-  : Edit the selected action set.
-  : Import a predefined action set.
-  : Export the selected action set.
-  : Delete the selected action set.



NOTE: Select an action set by clicking the cross-hatched area in front of the action set name.

3.4.2 List of available actions

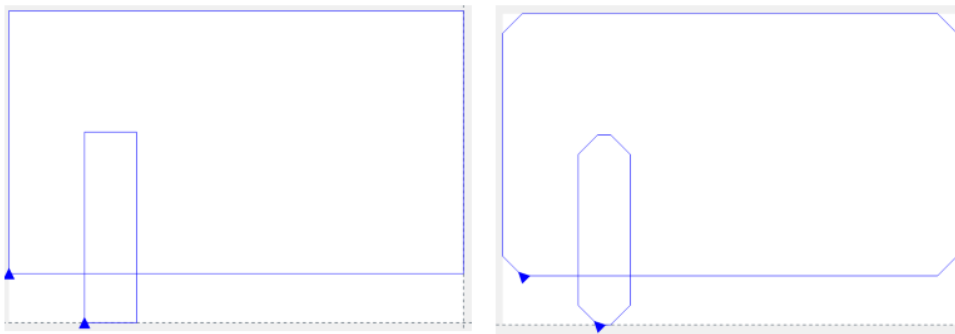
3.4.2.1 Clean-up

Add chamfers: This action changes corners of 90° into chamfers. **Distance** lets you choose the length of the chamfer (max. 50 mm) while **Mode** lets you choose which corners this action is applied to.

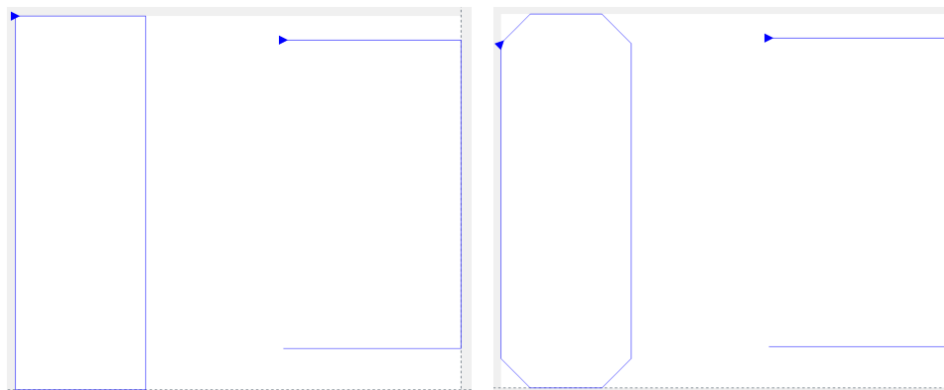
Add rounded corners: This action changes corners of 90° into rounded corners. **Distance** lets you choose the length of the rounded corner (max. 30 mm) while **Mode** lets you choose which corners this action is applied to.

Extra information concerning **Add chamfers** and **Add rounded corners** actions:

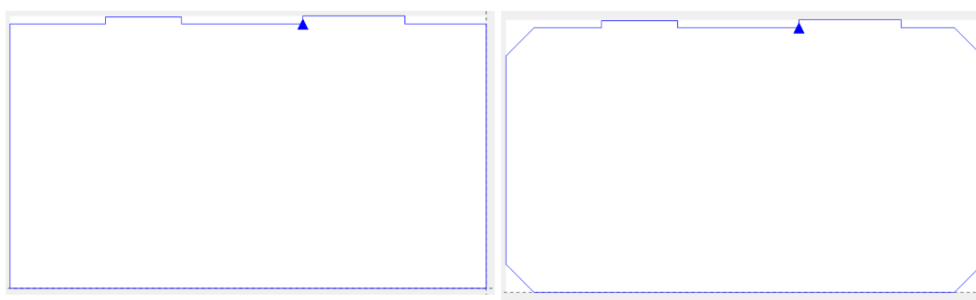
- If multiple figures overlap, all relevant figures are changed.



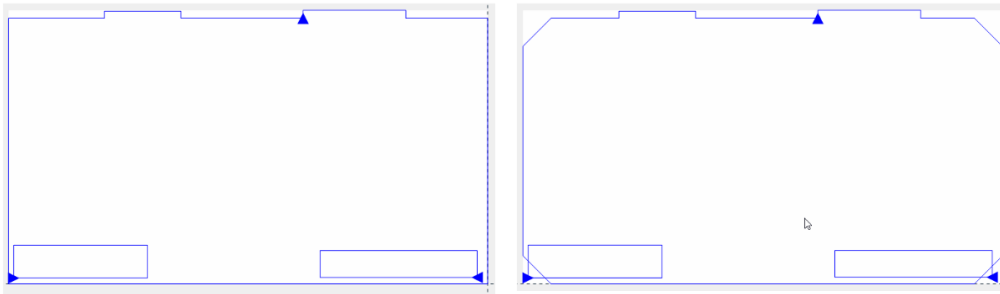
- Open figures are ignored.



- Corners smaller than the set distance are ignored.



- If another figure is too close to the corner, it will be drawn through.



Corners must be twice the chamfer length. The distance between the two nodes needs to be twice the set distance or radius, otherwise no chamfer or rounded corner will be added.

Break at intersections: This action breaks curves at intersections. You can also consider objects as intersection points if they are very close to one another. The maximum distance to still be considered intersection points can be set.

Close objects: This action checks whether all objects are closed. If an object is not closed, this action will close it.

Reduce nodes: This action reduces the number of nodes. The distance below which the middle nodes are to be deleted can then be set. This action is applied to all objects.

Remove double lines: This action removes double lines. The action automatically selects all lines (open curves) and deletes any doubles. The maximum distance between the lines can then be set before the software decides whether or not to delete the lines.

Remove double objects: This action removes double objects. This action automatically selects all objects (closed curves) and deletes any doubles. The maximum distance between the objects can then be set before the software decides whether or not to delete the objects.

Stroke to contour: This action converts strokes to contour lines. Sometimes jobs are poorly designed, and a contour line was defined using a brush or other less appropriate tool, rather than by a single line. In that case, the program can convert those double lines into a single line. The inner lines will be deleted, and the outer line will be kept.

3.4.2.2 Device

Load material: This action feeds material onto the conveyor bed and initialises the Vision camera system so a first scan is made. This action is required to start a first cutting job.

- **Reset vision camera:** Empties the camera buffer before scanning.
- **Request job name:** When this option is enabled, the user will be prompted to enter a job name to facilitate future reference.
- **Feed distance:** The distance that will be fed on the conveyor bed.

3.4.2.3 General

Go to: This action can be used to jump to a defined action in the action set. It is usually used to create a loop to automate jobs.

- **Action ID:** Specifies which action the sequence has to be restarted from.

Import job: This action imports a file. There are several parameters.

General

- **Import mode**
 - **Manual:** The operator manually searches and selects the required file.
 - **Barcode:** When this option is selected, more parameters appear:
 - **Barcode reader:** Default set to *Handheld scanner*. When the Pro Pack is activated, *Camera* is available.
 - **Import directory:** This is the folder that contains the cutting data. This is usually a folder on a server where the cutting data is sent from the RIP or design software (click the three dots to browse to the appropriate folder).
 - **Import order:** By creation date or alphabetical.
 - **Hot folder:** Only available with the Pro Pack. The hot folder system is especially useful when the design software is located on another computer on the network, because then the plug-ins cannot be used. Files stored in a folder can now also be automatically opened in GoProduce Laser Edition. Thanks to the flexible action sets, everything that happens next is completely customized to your needs.
- **Close active job:** You can choose to close the current job before opening a new one, or have a new tab opened containing the job.
- **Combine layers with same name:** Files that are imported sometimes contain multiple layers with the same name. If this option is checked, all these layers will be merged into one layer.
- **Scaling factor:** This is used when importing cut-only jobs drawn to scale from Illustrator or Indesign. This is sometimes used for jobs longer than 5 metres (200 inches).



NOTE: Do not use the scaling factor if a pdf creator has been used that scales automatically. Normal pdf export (as in Illustrator and InDesign) outputs files of max. 5 metres (200 inches) wide and long. Some other programs have pdf export filters that output larger pdf files. They have a scale factor in the file itself so the scale factor should stay on 100% for such files.

DXF

- **Import unit for DXF:** Auto, millimetres, inches.
- **Separate layers:** Methods can be separated by layer name, by spot colour name, or by colour. We recommend using colours for DXF.
- **Exclude layers:** You can exclude layers from the import. This is useful if the print data is still located in the file because opening the print data could slow down the program.

PDF

- **Separate layers:** Methods can be separated by layer name, by spot colour name, or by colour. We recommend using layers for PDF.
- **Exclude layers:** You can exclude layers from the import. This is useful if the print data is still located in the file because opening the print data could slow down the program.
- **Crop to page size:** For importing only the part of the design that is visible in the PDF file.

SVG

- **Exclude layers:** You can exclude layers from the import. This is useful if the print data is still located in the file because opening the print data could slow down the program.

ZCC (only supported when Pro Pack is installed)

- **Add remarks:** You can opt to import the registration marks. If this box is checked, the **Shape** and **Size** of the registration marks must be defined correctly in order to import the ZCC file correctly.

i-CUT (only supported when Pro Pack is installed)

- **Add remarks:** You can opt to import the registration marks. If this box is checked, the **Shape** and **Size** of the registration marks must be defined correctly in order to import the i-CUT file correctly.

Output job: This action sends the job to the cutter. A lot of parameters that are considered default values can be set here. However, when processing the job, these parameters reappear on the screen and, if necessary, can be changed to be applied only this one time. This depends on the parameter setting.

- **Segmentation:** If the job is very long, the software can divide the job into segments. Before the program starts sending the data to the cutter, a preview can be shown.

There are three options for defining segmentation:

- **Default:** This is normally used when the job is cut on a roll and if it does not matter where the segments are defined. The segments have the maximum size and the last one is the smallest one.
- **Equal length:** This option divides the entire job into equal parts. This can be useful when the jobs need to be applied to different panels that have the same size.
- **Minimize cut through:** This option tries to set the segment lines in a way the objects can be cut without segmenting them. This means the segments will be adjusted, so that all closed curves smaller than the length of the laser cutter bed, will be cut in one segment.
- **Pause after a number of segments:** Pauses the workflow per x segments, e.g., to retrieve the cut material from the bed. When set to 0, the job will not be paused.
- **Waste Cut:** This action cuts the material over the entire width of the conveyor bed for easier weeding of the cut objects. This option is checked by default. When this option is checked, the following parameters must be defined:
 - **Omit on first segment:** By enabling this option, you choose to not perform a waste-cut after the first segment.
 - **Omit inner shapes:** By enabling this option, you choose to not perform a waste-cut on inner shapes.
 - **Segments per waste-cut:** This defines how many segments are cut before a waste-cut is performed.

- **Sorting mode:** There are three basic sorting methods to control the order in which objects are cut: Sorting by the main direction in the length direction (vertically), sorting by the main direction in the width direction (horizontally), or sorting by nearest objects. The aim of sorting is to reduce the cutting time by having to move as little as necessary. There are two extra sorting parameters:
 - **Optimize start points:** By enabling this option, you allow the software to change the starting cut point of each object to achieve the most efficient cutting path (bear in mind that cutting faster does not necessarily lead to better results).
 - **Inside objects first:** When enabled, the software checks if closed curves (objects) have smaller closed curves (objects) inside them. If so, these smaller objects are cut first, to ensure their cutting accuracy.
- **Number of jobs:** This defines how many times the job needs to be repeated.
- **Copies per job:** Sets the number of copies to be processed with this parameter. If sheets are used, then this parameter applies to the number of copies per sheet. If the job is on a single sheet or on a roll, this parameter only determines the number of copies to be processed. There are a few additional options for this parameter if set to more than 1:
 - **Autofill:** If checked, the software checks how many copies can be cut side by side in width. This value then represents the number of copies in width. This option is not usually used in print and cut jobs.
 - **Number of copies - Width:** If the option **Autofill** is not checked, the required number of copies in width direction can be set here.
 - **Space between copies - Width:** Determines the distance between copies in width (imagine a frame around each copy, including registration marks - the distance between those frames is the space between the copies).
 - **Space between copies - Length:** Determines the distance between copies in length (imagine a frame around each copy, including registration marks - the distance between those frames is the space between the copies).



NOTE: If the distance between copies is not known for a print and cut job, enter 0. When processing the job, set the camera above the first regmark of the second copy. The program will then automatically use this distance for the third, fourth, etc. copy.

- **Send design relative to origin:** If not all objects are selected to be cut, the origin of the job is automatically set to the origin of the selection if this box is not checked. If this box is checked, the origin remains as defined in the job.
- **On end of job:** Defines the action after processing the job:
 - **Feed job length:** Feed the length of the job.
 - **Margin:** After processing a cutting job, the laser cutter will park the cutting nozzle behind the job. If desired, an extra margin can be added.
 - **Cut off:** The media is cut off after a job.
 - **No action**

- **Compensation mode:** There are five compensation modes to choose from, of which some are especially suitable for segmented jobs. The difference between the several methods is clarified with images below.

- **Cut to shape:** The cutter cuts the design exactly as it is printed and does not add extra nodes. The existing nodes remain the same as well as straight lines between nodes.
- **Cut to print:** The print is followed as accurate as possible; some extra nodes are added to try and take into account all the print distortions.
- **Cut to frame follow placement:** Only the rotation and displacement distortions are taken into account for compensation. The original design is cut out, only the placement of this design is influenced by the print-out.

When the job is segmented, the first segment determines everything: the rotation and displacement in the first segment are used for the entire job. This means that if the rotation and/or displacement in the first segment is significant, it's possible the cutter may cut outside the printed design in the later segments.

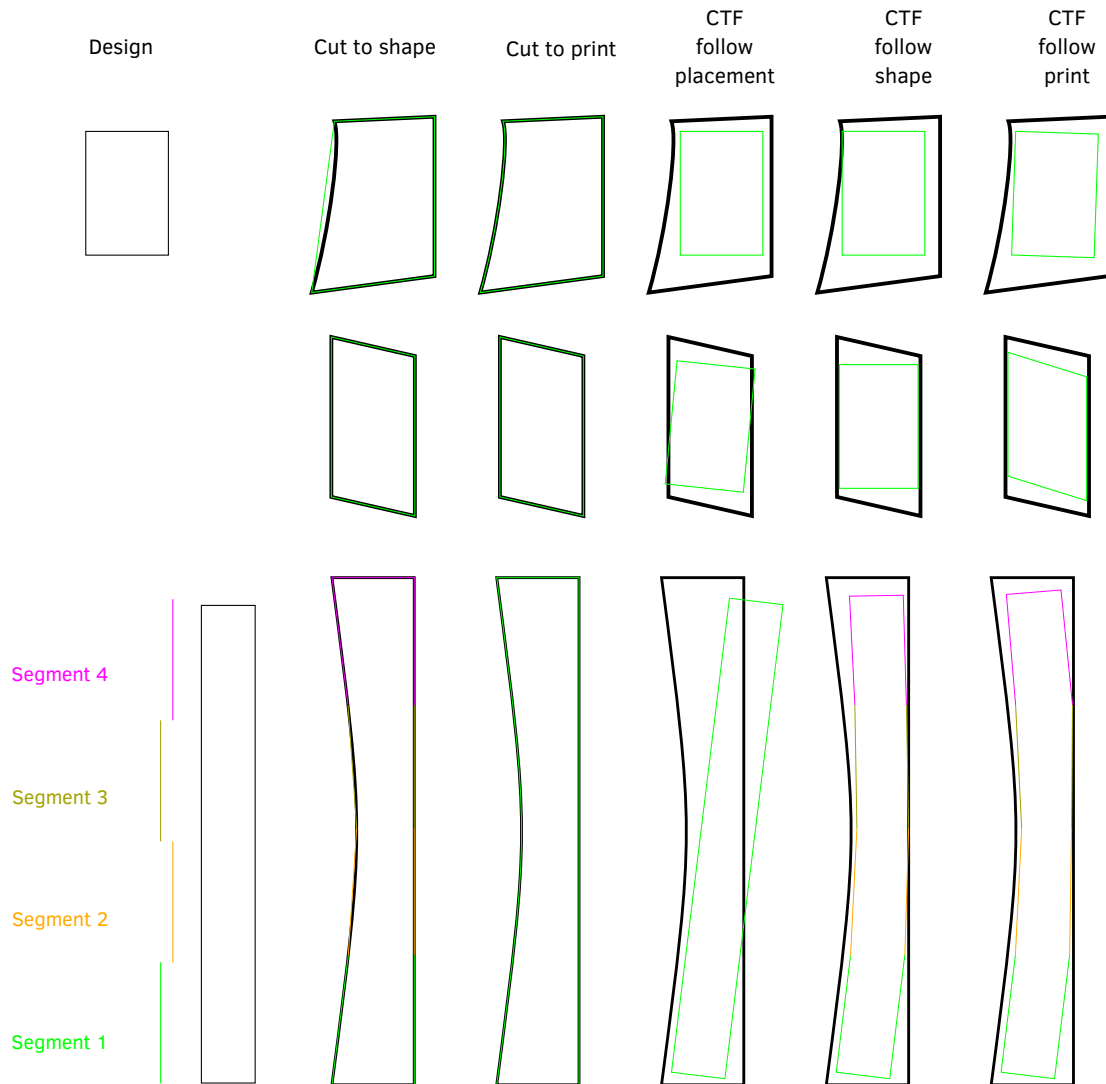
- **Anchor point:** Defines which point of the printed shape you are using to align the cut shape with.
- **Cut to frame follow shape:** Only the rotation and displacement distortions in X direction (media direction) are taken into account for compensation. The original design is cut out, only the placement (in X direction) of this design is influenced by the print-out.

When the job is segmented, an extra rotation is added with each segment to compensate for the disadvantages/shortcomings of the *CTF follow placement* compensation method.

- **Anchor point:** Defines which point of the printed shape you are using to align the cut shape with.
- **Cut to frame follow print:** In addition to rotation and displacement, skew is also compensated for. This adjustment is made to more accurately follow the printout while maintaining the original length and width dimensions of the design. As a result of this compensation, rectangles are "transformed" into parallelograms.

In addition to the extra rotation per segment, the skew for each segment is also taken into account so that the printout is followed even better. This approach is particularly beneficial for long jobs on textile materials, where long rectangles are often distorted into scaled parallelograms when processed on the L series machines.

- **Anchor point:** Defines which point of the printed shape you are using to align the cut shape with.



- **Skip mark when mark is not recognized:** Some registration marks might not be printed correctly. If this option is checked, marks that cannot be read by the program are ignored. If this option is not checked, the program will pause, so you can intervene. He will then either skip the registration mark or manually position the camera above it.
- **Direct mode:** If this option is checked, the program does not display the output parameters as described above when the output is started. The job is started immediately with the settings configured in the action set. This option is essential for the barcode workflow on a roll.

Trace: This action does not require a cutting design file or registration marks. The material is printed and there are black lines of several millimetres thick around each object to be cut. The Vision camera system and the software trace (recognize) these lines automatically, and automatically generate a cutting job.

- **Close active job:** You can choose to close the previous job before opening it or just open a new tab with the job.
- **Media edge left offset:** Determine the distance between the left media edge and the cut line.
- **Media edge right offset:** Determine the distance between the right media edge and the cut line.

- **Contour offset:** Determine the distance inwards or outwards between the contour line and the cut line.
- **Minimum object size:** All closed objects within a segment that are smaller than the value set here, will not be cut (this can be useful for e.g., registration marks).
- **Colour bar:** To cope with long printed colour bars at the sides of the job. This parameter can be set to *None, Left, Right, Left and Right*.

Undo: This action undoes the previous action.

3.4.2.4 Job

Fit working area to device: This action fits the on-screen working area to the loaded media.

Mirror horizontally: This action flips the entire job on a horizontal axis through the centre of the job.

Mirror vertically: This action flips the entire job on a vertical axis through the centre of the job.

Rotate 90°: This action rotates all objects and work area by 90° CCW.

Set job origin: This action starts a job at a certain offset from the origin. Change the values as necessary.

3.4.2.5 Layer

Remove layer: This action deletes a layer. Click the drop-down button in the Action Properties column to get a list of all methods and select the method (layer) to be removed.

Search remarks: This action searches the registration marks. You can scan **All Layers** for this purpose, or only specific layers by entering **Layer names** (layer names are case sensitive). The **Shape** and the **Size** of the registration marks to be searched need to be defined. If registration marks with these characteristics are found on the selected layer, they are given the "Remark" property. They are then moved to the **Remark** layer and are made clearly visible on the screen.



NOTE: When working with ZCC or i-CUT files, do not forget to set the **Shape** and **Size** parameters correctly in the **Search remarks** AND in the **Import Job** parameters action properties.

Select Layer: This action allows you to select a certain layer (**Method**). Click on the drop-down button to get a list of the methods and select one.

Set layer method: Choose the method for the selected layer.

Set layer properties: Layers have two properties. They can be (un)locked and made (in)visible. Set **Target** to determine which layer the properties should apply to.

3.4.3 Predefined actions sets

When Summa GoProduce Laser Edition is installed, the following predefined action sets are installed along with it:

- Import file
- Clean-up design (Note that using this option might leave you with a lot of open curves since double lines will be deleted, which can influence the sorting algorithms.)
- Output to roll




NOTE: When you import a PDF file (action set **Import file**), you will be given the option to choose which pages of the document should be imported.

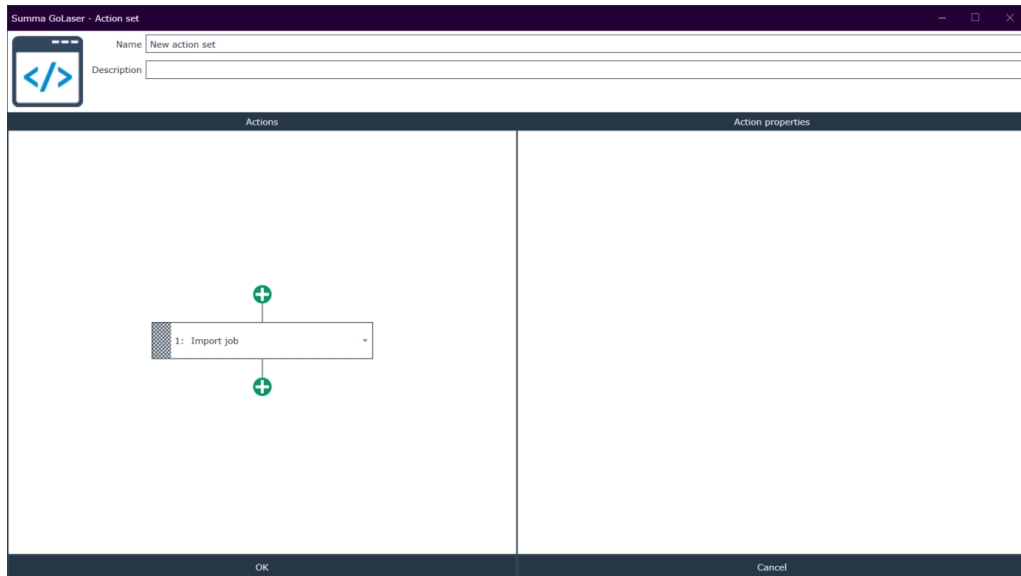
The following action sets can be imported from `..\Documents\Summa GoProduce Laser Edition\Action sets`:




- Output to roll (Cut-to-Frame)
- Barcode workflow on roll (works only if the Pro Pack is installed, see chapter 5.3 *Barcode workflow* on page 49 for more information)
- Barcode workflow on roll (Cut-to-Frame) (works only if the Pro Pack is installed, see page 48 for more information)
- Single trace (works only when the Vision camera system is activated)
- Feed roll and scan (works only when the Vision camera system is activated)
- Trace and cut workflow on roll (works only when the Vision camera system is activated)

If you are using predefined action sets, it is important to know what they do. Right-click in the cross-hatched area in front of the action set name so the structure of the action set appears. Then, by clicking in the cross-hatched area in front of the action set action, the specific action properties appear.

3.4.4 Creating action sets

1. Click  to create an action set. The following window appears.

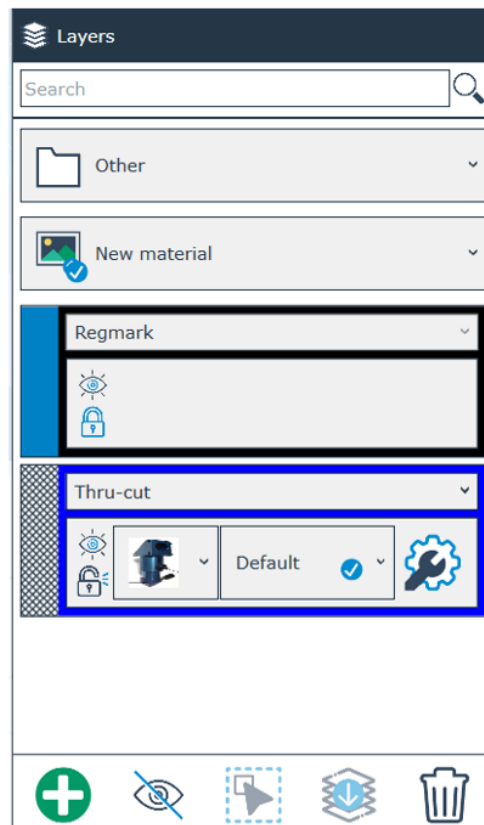


2. Name the action set, describing clearly what it is used for. You can also add a description and choose a different logo for the action set by clicking the default logo .
3. Click the drop-down button to the right of the action name to choose an action. This list contains all the actions from the **Job** and **Selection** tabs with some additional actions included.
4. Click in the cross-hatched area in front of the action number. If special settings need to be changed for this action, they are now listed in the right column.
5. Add as many actions as needed to create a new action set. If you need to change the order () of the actions or delete () an action, click in the cross-hatched area before the action number so these buttons become available.









3.5 Layers window

3.5.1 General

The Layers window on the right shows the material, method, and tool settings. If the RIP has a driver for Summa GoProduce Laser Edition and the settings in the RIP are correct, all the information in this window is automatically chosen as soon as the file with the cut data is imported. If the automatically chosen settings are not correct, you can set things manually. In that case, after importing the cut data file, the **Layers** window looks like this.



NOTE: When making changes in the **Layers** window, always work from top to bottom as changing a setting can influence all settings below.

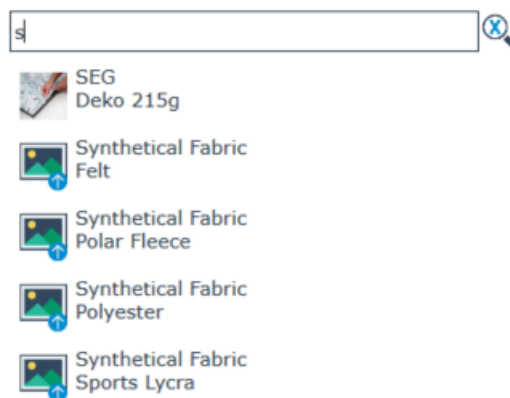
-  : Create a layer.
-  : Show only the selected layer.
-  : Hide only the selected layer.
-  : Select all objects on the selected layer.
-  : Move all current objects to the selected layer.
-  : Delete the selected layer.
-  : Lock or unlock this layer.
-  : Open a list of tool parameters to change the parameters. From the moment a parameter is changed, the **Save to material manager** button becomes available to change the setting permanently in the material manager.

3.5.2 Set materials

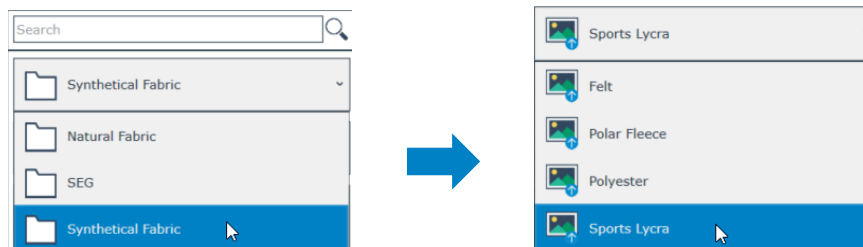


If the material is not specified in the cut data file, the default material is used. If you need to change the default material, you can do so before opening the cut data file (see page 20) or you can change the material in the **Layers** window when the cut data file is opened.

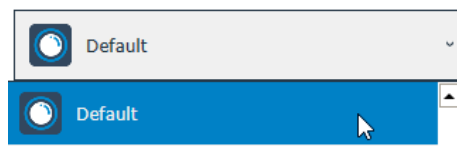
Option 1: Enter the name of the material in the search box.



Option 2: First select the relevant material group, then the material itself.



3.5.3 Set camera profiles



If the methods are set correctly in the cut data file, the camera profile should automatically be set correctly. If you want to use another camera profile, you can select it from the drop-down list (the registration marks need to be identified first by clicking **Search remarks** in the **Job** ribbon).

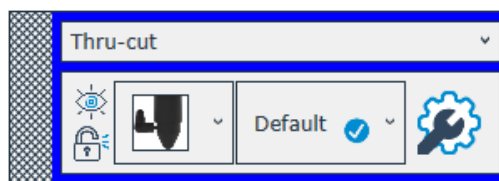
3.5.4 Set methods

If everything is set up correctly, it is not necessary to change the method setting. However, in case a special material is used or if the data in the cut file is not set up correctly, the methods can be set/changed.

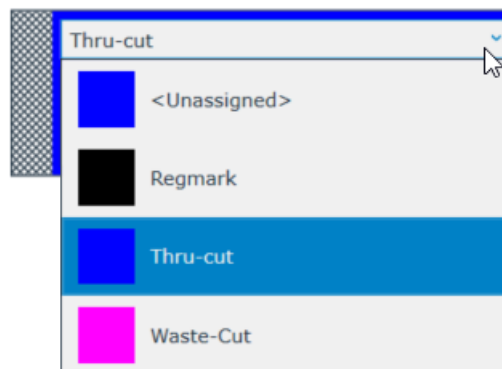
The cut data is shown on layers. With simple cut-only jobs requiring only one tool, there is only one layer. If it is a print-and-cut job, there is a **Regmark** layer and a layer per method since more than one tool is needed.

Possible layer properties after importing:

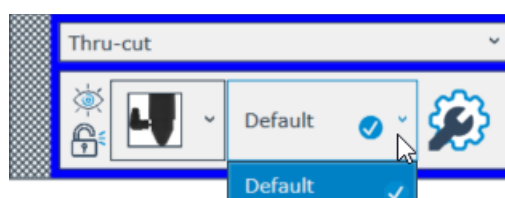
3.5.4.1 Case 1: Material and method set correctly in the cut data file



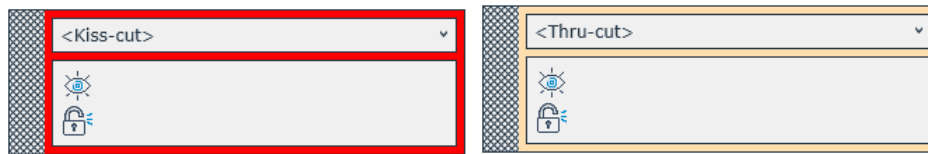
This means that a method has been assigned to the cut lines on that layer. Click the drop-down button of the layer name to change the method for the vectors on that layer.



Sometimes a list is available, situated next to the tool type, with predefined parameter sets for the chosen tool. The default setting will always be chosen, but alternative parameter sets (if available) can be chosen by clicking the drop-down arrow.

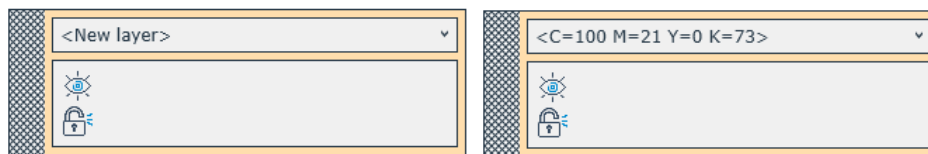



3.5.4.2 Case 2: Material not set correctly / wrong method chosen for material

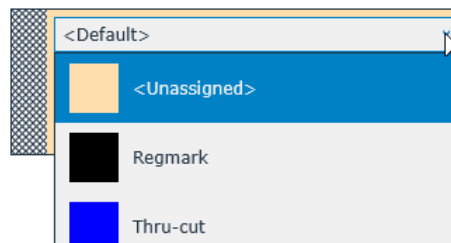


Either the material has not been set correctly or the wrong method for that particular material type was chosen. To set the material correctly, see section 3.5.2. If the material is set correctly, the tool will be assigned to it automatically. You can also click the drop-down button next to the method name to change the method. Once the method and material are set correctly, the parameters can be changed as described in section 3.5.4.1.

3.5.4.3 Case 3: Method is not known (or not correctly set in the design program)



When a new layer is created, when the method is wrongly assigned, or when there is no specific colour chosen in the design, the layer properties will look like shown above. In this case, the material settings must be checked first. If the correct material is not yet set, please do so first. Then click  to choose the correct method.



4 ADVANCED WORK METHODS

✓ **Cut-to-Frame** (requires head camera or Vision camera system)

Also known as Fixed Size Cutting, this functionality enables a perfect fit into SEG (Silicone Edge Graphics) frames. Depending on the type of CTF method, shrinkage, deformations, and skew that occurred during printing and calendaring are automatically detected and compensated for.

How does it work?

1. In pre-production a bleed and registration marks are added to the original artwork.
2. The camera reads the registration marks in the artwork and the software quickly compares the result with the original cut file.
3. Any shrinkage, deformations, and skew that occurred during printing and calendaring are automatically detected.
4. Depending on the type of CTF method, the detected shrinkage, deformations, and skew are used to calculate the transformations of the cutting data so that the design will fit exactly within the frame.
5. Sewing-in the silicone beading happens faster thanks to the perfectly sealed edges.

✓ **Barcode workflow** (requires Pro Pack, and head camera or Vision camera system)

More information can be found in chapter 5.3 *Barcode workflow* on page 49.

✓ **Trace & Cut** (requires Vision camera system)

The Vision camera system traces the contours of designs by detecting the black outlines. It allows for automatic processing of an entire roll with different jobs without pre-prepared cutting data.

How does it work?

1. The Trace & Cut method uses the Vision camera System to trace the contours of the artwork. The camera follows a black outline, which has been added to the print design, and detects the cutting area.
2. The software receives the data and automatically creates cut files after each scan, so there is no need to search or import files first.
3. Cutting starts when the first part of the design is scanned and the next part on the roll is scanned simultaneously. So, this work method also enjoys the benefits of the cut-on-the-fly process. Between the parts, the cutter adds a waste cut to split the waste into smaller pieces to avoid pulling on the uncut material.

✓ **Cut on-the-Fly** (requires no camera system, but can be used in combination with the head camera or the Vision camera system)

When the material is fed into the cutter, the design is immediately scanned (if applicable) and cut. This continues until the entire cutting job is done.

5 PRO PACK (OPTIONAL)

5.1 General

The optional GoProduce Laser Edition Pro Pack offers the following advanced features:

- Ability to import other file types
- Ability to export to PDF
- Barcode Workflow
- Hot folder support

5.2 Ability to import other file types

Thanks to the Pro Pack, the following file types can also be imported:

- PLT files (*.plt, *.PLT)
- HPGL files (*.hpgl, *.hpg, *.hgl, *.HPG, *.HGL)
- DMPL files (*.dmpl, *.dmp, *.DMPL, *.DMP)
- i-CUT files (*.cut, *.CUT)
- ZCC files (*.zcc, *.ZCC)

5.3 Barcode workflow

5.3.1 About barcode workflow

The barcode workflow allows you to process an entire roll with different cutting jobs without operator intervention.

How does it work?

1. Along with the design, a barcode is printed on the material that refers to the corresponding cutting file. Each printed roll can contain different cutting jobs, each of the jobs with its own barcode.
2. When the material is scanned, the cut file is identified and automatically retrieved by the software. Subsequently, it starts cutting.
3. This process will repeat itself until all cutting jobs have been processed.



NOTE: If there is no data on the material in the data file, the program uses the settings defined in the default material. In this case, before starting the workflow, check the setting of the default material and change if needed.



NOTE: Be sure to select the import directory in the **Import Job** action properties (see parameter **Import directory** on page 35 for more information).

5.3.2 Barcode workflow action sets

There are two barcode workflow action sets that can be imported from ..\Documents\Summa GoProduce Laser Edition\Action sets:

- Barcode workflow on roll
- Barcode workflow on roll (Cut-to-Frame)

5.4 Hot folder support

The hot folder system is specifically useful when the design software is located on another computer in the network, because in this case, the plug-ins cannot be used. Files stored in a folder can automatically be opened in GoProduce Laser Edition. Thanks to the flexible action sets, everything that happens next is completely customized to your needs.



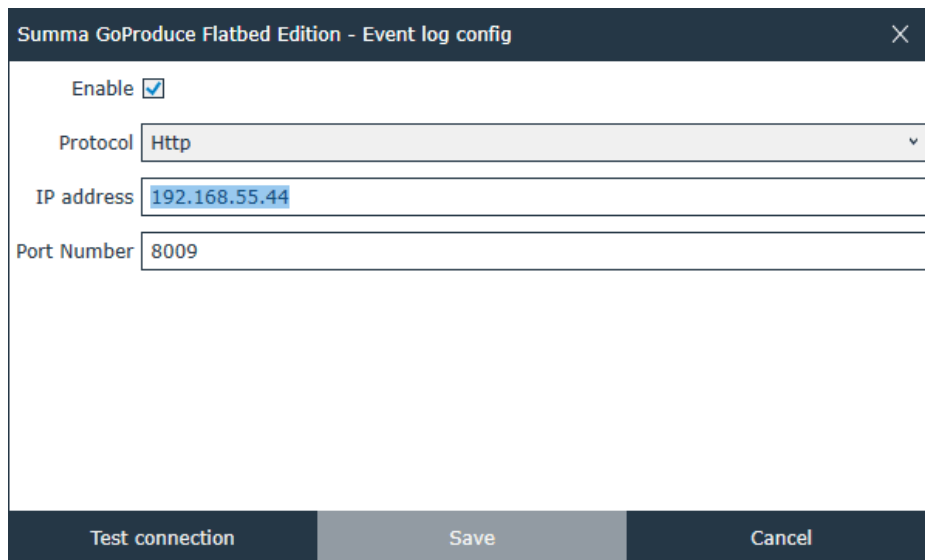
NOTE: Be sure to set the type of import to **Hot folder** and select the import directory in the **Import Job** action properties (see parameters **Import mode** and **Import directory** on page 35 for more information). In the output action, the property **Direct mode** needs to be checked.

6 GODATA



When GoData is activated, then extra icons are visible on the General tab.

Click the **Edit** icon to set up the connection with the server where the data will be saved.



Summa GoProduce Flatbed Edition - Event log config

Enable

Protocol

IP address

Port Number

Test connection Save Cancel

Click the **View** icon to view the dashboard with the stored info.

Go to the support pages on summa.com to download the GoData manual for more info.