GO™

SIGN

User's Manual
Rev 001

Summa

Revision History

Publication	version	
25/05/2021	Rev 001	First release

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1 NEW INSTALLATION

GoSign is a Windows-based production tool, acting as a bridge between the design software and a Summa Roll Cutter. It allows you to manage your preferred workflow with great flexibility. Enjoy automated cutting options, custom configuration of action sets, easy plug-ins for design programs and much more.

1.1 Installing the program

NOTE: While the program is installed it will do an automatic registration and link a free license code to your email address.

To install the software, make sure it is located in a directory where there are no other versions of the installation program.

NOTE: This means that if the program is downloaded from the Summa website, the directory it is saved to has to be checked to be sure there are no old versions of the installation program present. The easiest way to do this is to download to a new empty directory.

Double click the installation program to start the setup.
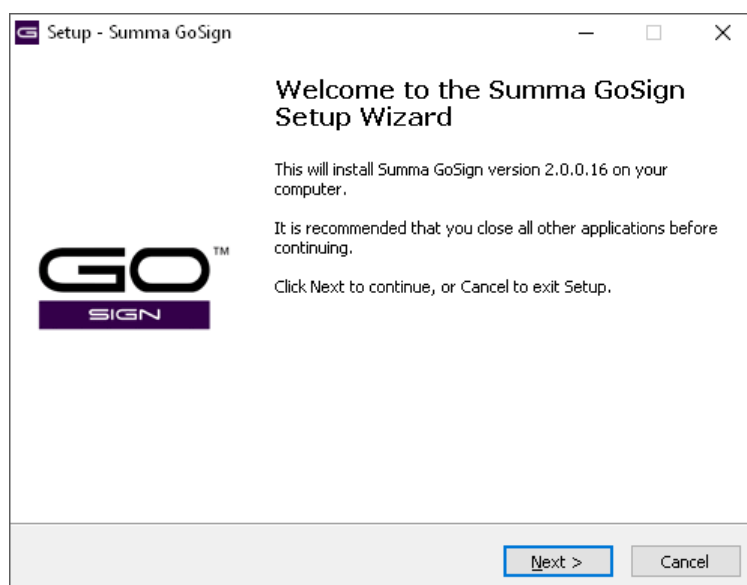
The installation directory can be changed if needed.

It is recommended to leave it as proposed.
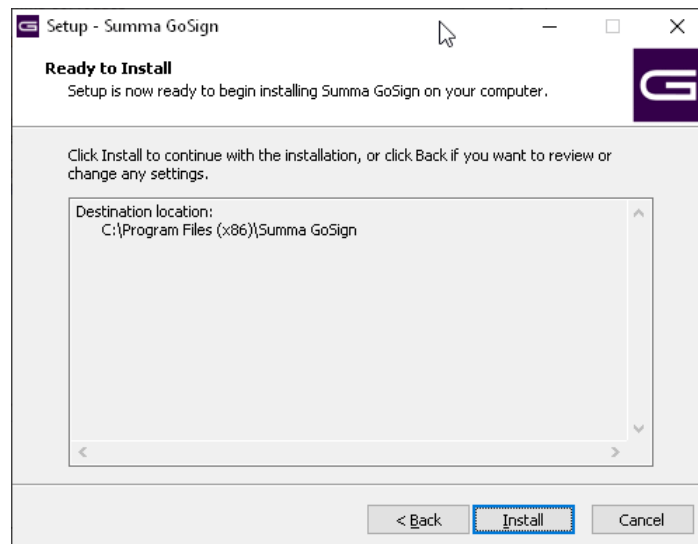
Click the install button to install the program. The program will now be installed.
Afterwards another window will open to install a couple of additional components that are needed to run the program.
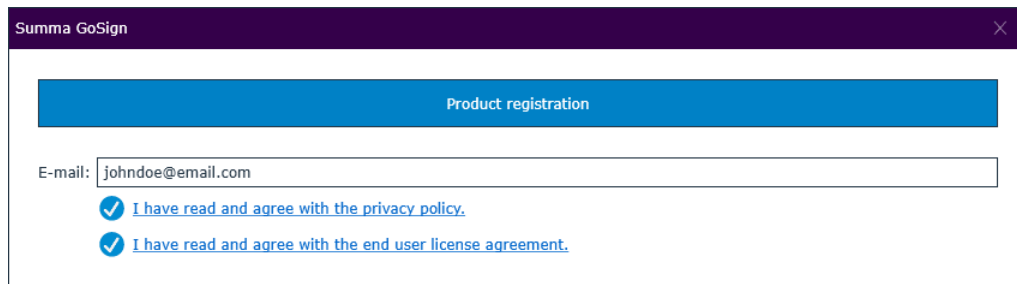
Click the install button to proceed. Some components will be installed automatically (without the intervention of the user) other components will come up with a pop-up window(s). It is recommended to click the highlighted button (Install – Next - Finish – Close) each time, when prompted.

The last step of the installation is the choice of the default action set.
Basic is used when colours are used in case methods are assigned to colours. The Advanced action set is used when methods are assigned to layers in your design software.
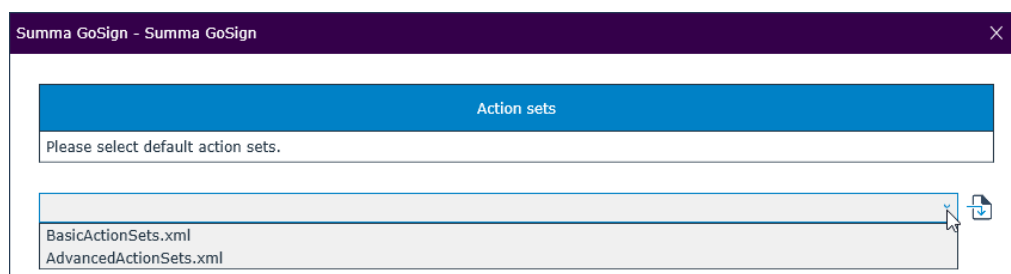
Choose the type and click OK. After that, the program will start up and go through the licensing procedure.

First, fill in your email, read the privacy policy and license agreement and check the boxes. Click continue.
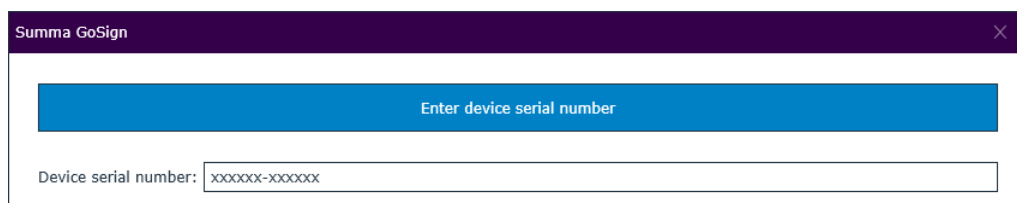
Click Continue.
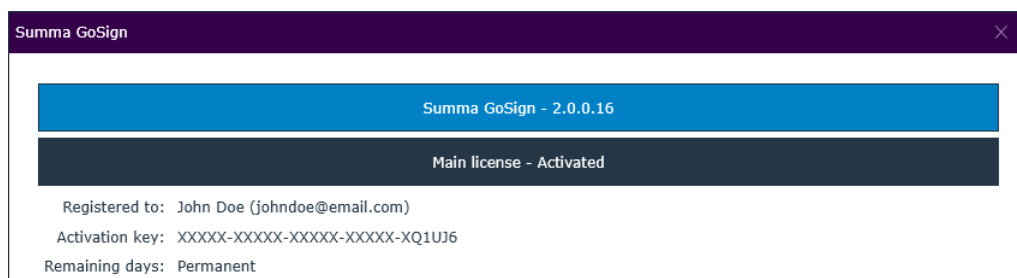
Finally, fill in the serial number of your cutter. A message will appear if the registration was successful.

An option to install an extension pack is displayed.
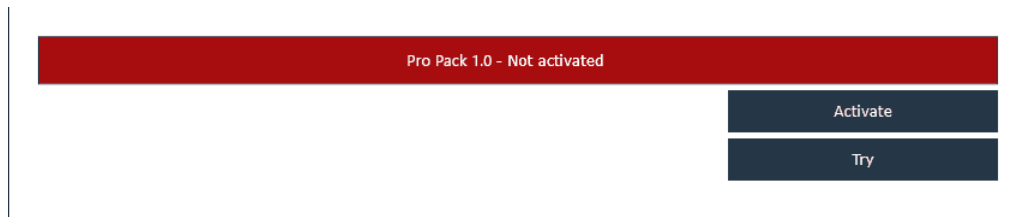
The extension pack includes the following:
- Barcode import mode
- Hot folder import mode
- Import plot files (DMPL and HPGL files)
- Camera support

You have the choice to activate or to activate a trial period of 30 days. This step can be skipped. This window can be opened at any time by clicking on the 'About button' once the program is started.

Click Continue to finish the installation of the program.

1.2 Setting up the program

During the last step of the program's installation, the program will open for the first time. When there is no cutter installed, the cutter setup window opens right after the program is started.
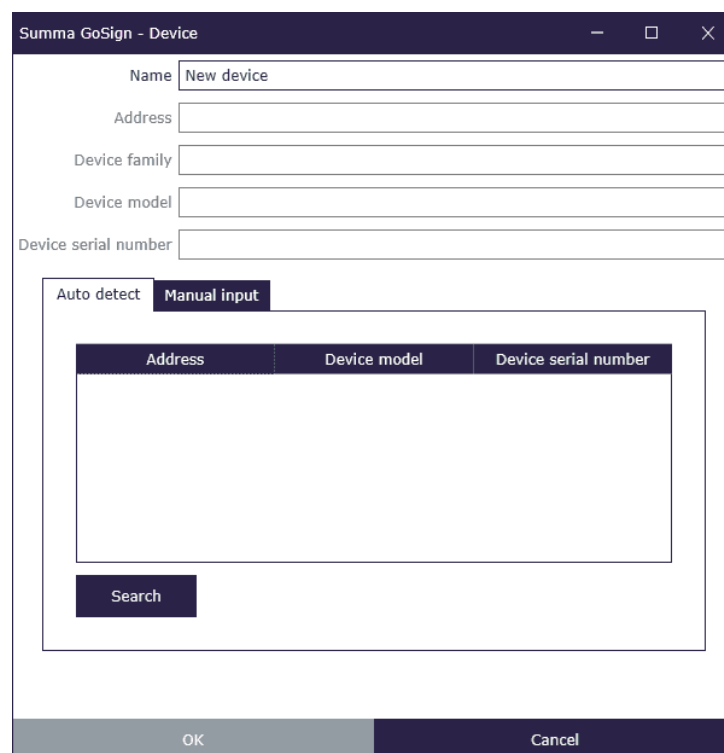
You have the choice to autodetect the connected cutters or to manually fill in the IP address from a cutter that is connected with Ethernet. For the autodetect to work the cutter must be switched on and media must be loaded.

> **NOTE:** When the cutter uses USB to connect to the computer, then the only procedure to install the cutter in GoSign is to use the Auto detect procedure.

Click on the search button to detect connected cutters. If the cutter is on and no media is loaded, the info might be incomplete. In that case, load the media and click on the search button again.

Click on the manual Input tab to fill in the IP address of your cutter if Auto detect did not find it. Refer to the manuals of the cutter on how to get the cutter's IP address.

> **NOTE:** In the field "Name" you can fill in something that facilitates identification of the cutter in case multiple cutters are connected to one computer (for instance "the cutter near the window")

2 STANDARD PROGRAM

The window of the program GoSign has 4 main areas.
At the top, you will see the different tabs (5 in total).
On 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, there is space for a preview of the job. If multiple jobs are opened, they open in docked tabs of the middle window.
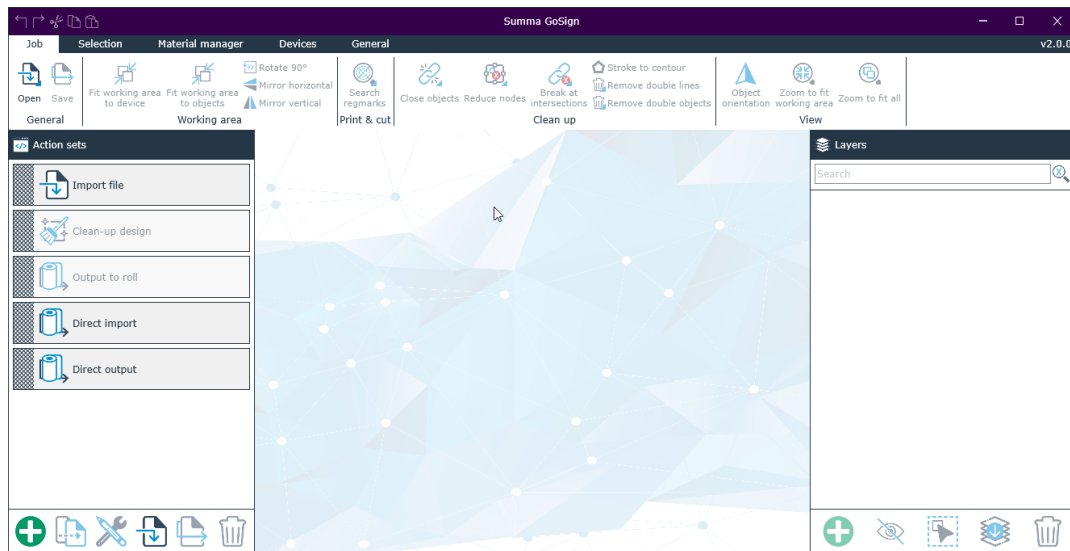
All docked windows can be set floating. Just click the icon in front of the name of the window and drag it where it needs to be. There are also shortcuts for docking the window left-right, top-bottom or the rest of the free area.
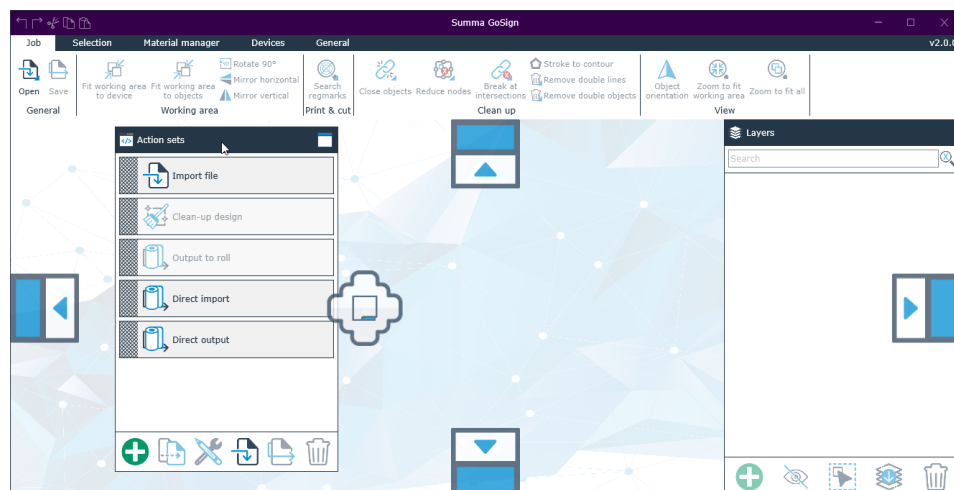
2.1 Quick access toolbar

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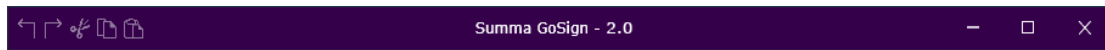
The commands are: undo, redo, cut, copy and paste.

2.2 Ribbon

The ribbon has 5 tabs.
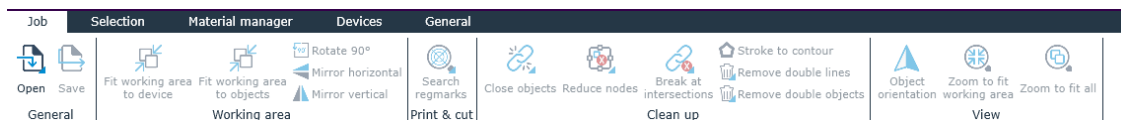
2.2.1 Job tab

This tab gives access to some basic editing functions, so the job can be optimised to cut. Most of those functions can be included in the import action set. A default import action includes already some of these functions. Special extra import actions can be made with these functions included.
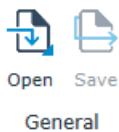
Jobs can be saved and reopened. The jobs are stored as SGSJ (SGS job files). They include the original cut data that was imported and also settings related to material and tools. So if extra copies of previous jobs are needed, that can easily be done with previously used settings.
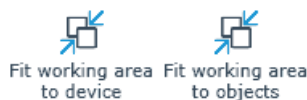
The first functions relate to the working area. You can either fit the working area to all the objects or if the default cutter is connected and media is loaded, fit the working area to the loaded media.

The next couple of functions imply rotating or mirroring the complete job or fit the working area to the job. There is no need to select the objects first. Simply click the action and all objects will be selected automatically before the operation is performed.

NOTE: OPOS jobs should not (cannot) be rotated or mirrored.

This function will search the registration marks on certain layers. Normally, the registration marks are recognised while importing the file. However, in some cases, extra registration marks on special layers may have been added or the file, which needs to be imported was not correctly prepared. In this case, this function can be used to scan each layer for registration marks. First, click right on the icon. A window will open with the settings.
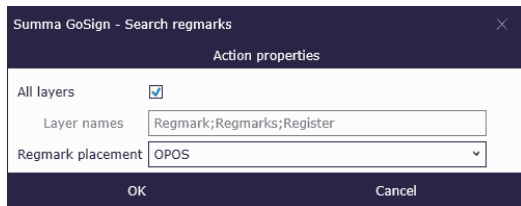
You can either scan all the layers or fill in the name of a specific layer. Also, the shape and size of the registration mark can be set. Or just search for OPOS marks. Set all the parameters to the desired value and click the OK button. Then click the search regmarks icon. If there are any registration marks on the chosen layer, they will get the property 'registration mark' and they will be made visible on the screen.

This function checks whether each object is closed or not. When it is not closed, this function will close it. Right-click on the icon to set the maximum distance the function is allowed to close. All objects are selected when this function is used. The maximum distance it closes is set at 0.5 mm.
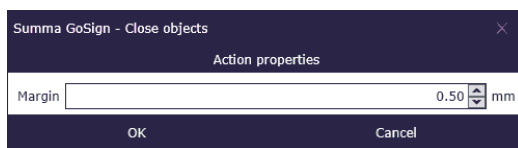
Right-click the close objects' icon to set the maximum distance that is used for closing objects.

With this function, the number of nodes can be reduced. Right-click the icon to set the maximum margin for the distance between the nodes. All objects are selected when this function is used. If the distance between three nodes is less than the set margin, the node in the middle is deleted. The two nodes that are left are connected with a line.
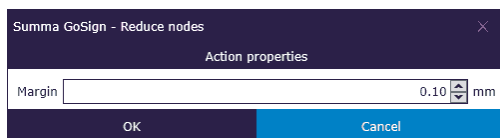
Right-click the reduce nodes icon to set the maximum distance, used to delete a node. The maximum value is 0.5 mm.

This function breaks curves at intersections. It is usually used in combination with other clean-up functions. It is used to isolate common parts of different curves, so those double parts can be deleted. The downside is that after the clean-up some curves will be open. This may intervene in the sorting process.
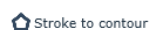
This function converts strokes to contours. Sometimes jobs are badly designed and brushes or other tools have been used for defining a contour line instead of a simple line. In that case, the program can convert those double lines to a single stroke. The inner lines will be deleted and the outer line will be kept. It is recommended not to use this function too much and instruct the designers to create correct cut lines.

Remove double lines   This function removes double lines. Nothing needs to be selected; the function selects all lines (open curves) automatically and deletes any double lines.
The maximum distance can be set by right-clicking the icon.

Remove double objects   This function removes double objects. Nothing needs to be selected; the function selects all objects (closed curves) automatically and deletes any double objects.
The maximum distance can be set by right-clicking the icon.

Use the object orientation action to reveal the orientation of the object. Click it and a triangle will be shown at the start point of each object, showing the direction of the curve. Click the triangle to reverse the direction, if necessary.

These are two shortcuts to quickly zoom to all objects or the working area.

2.2.2 Selection tab

This tab includes the basic editing functions such as duplicating, resizing,...

Click this icon to select all objects in the job. Individual objects can be selected by clicking them. A group of objects can be select by dragging a selection box around them. The objects need to be completely inside the box. Holding down the shift key will add objects to the objects that are already selected. Black selection handles will be shown around the selected objects. The outer selection handles can be used to resize the objects. The middle one can be used to move the objects around.

Click the node selection icon to show the nodes of the selected objects. The selection handles will disappear, and the nodes will be shown using little squares. The start point has a second larger square around the first one.

When the nodes are selected, some properties can be changed. Editing the nodes is not possible.
Click a node to make it the new start point.
Clicking the start point node reverses the direction of the curve (can be made visible by making the start point visible with the object orientation action).

Click this icon to zoom in on the selected objects.

Click this icon to duplicate the selected objects. The duplicate is offset by 5 mm to the top and the left. This to make sure the duplicate is visible.

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

With this option, the size and position of selected objects can be changed.
The anchor point of an object, also known as "object origin", can be changed by clicking one of the circles.
The object can then be moved by changing the X and Y value. This can be used for aligning objects. The object can be resized by either changing the width and height values or by changing the percentage value. You can constrain the proportions by clicking the padlock icon. The origin point remains stationary when resizing the object or group of objects.

Use this to rotate selected objects. First, fill in the value, then click the rotate icon.
The other two icons are used for flipping selected objects horizontally or vertically.
Rotating and flipping is always done with the middle point staying stationary.

2.2.3   Material manager tab
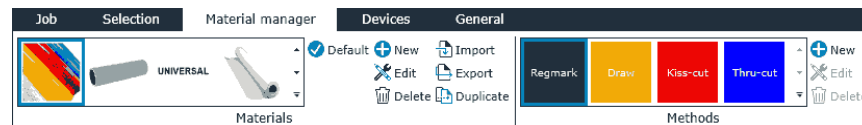
GoSign contains a material database, which includes a small list of standard materials. It can be adapted to specific needs. The material manager offers added value by working with methods, meaning that you only choose the material you want to process and the material manager itself automatically chooses the correct tool and settings to process the job.
Some RIPs will have the possibility to select the material when the job is printed. In that case, it will not be necessary to choose the material type in GoSign. This tab is not used when processing a job. It is used to predefine settings for different materials.

> **NOTE:** This tab is for setting the default properties of the materials, methods and tools. If a job is processed and a setting needs to be changed, do not change it here but use the settings in the layer window. Unless the changes of the setting need to be permanent, then change the setting for the material here.

2.2.3.1 Materials

The different materials are categorised into groups to facilitate retrieving the needed material. Click the drop-down arrow at the right side of the materials' pictures to see the categories. Then select the material. The selected material has a blue contour around it.
Materials can be added or deleted, edited or set as default.

A default material can be set by first selecting the material from the list and then clicking the default icon. If the file with the cut data does not include a defined material, GoSign will automatically use the default chosen material.

New material can be added by importing data about a material, duplicating a material that is already in the list and editing some minor specs or by creating a completely new material setting. A material with its settings can also be deleted or exported for use on another computer.

To add another material from a known source: Click the import icon, select the XML file and click 'Open'.

To export material for use on another computer, first, select the material type and then click the export icon. Keep the proposed file name and click 'Save'.

To delete an unused material type, select it and click the delete icon.

To change the settings of a certain material type, right-click it (or click the edit icon after it has been selected).
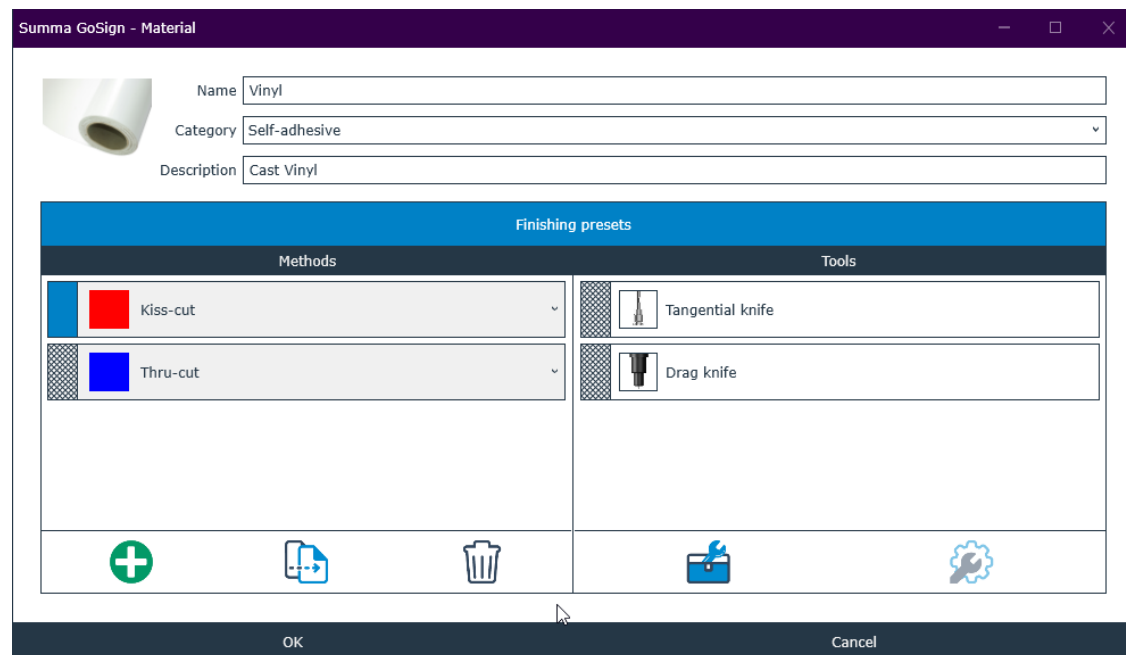
A material type is primarily defined by its name and is part of a category.
You can add a description to clarify what type of material it is or to add some extra info, which can be important to process the material.

The first column has a list of used methods for this material. These methods are chosen in the design program and are linked to a certain tool, suitable for this material. Methods can be added by clicking the add icon and deleted by selecting a method and clicking the garbage can. A method can be chosen by clicking the finely checkered rectangle just in front of the name. Click the toolbox icon to link a tool with the method.

The tools that are linked to this method are highlighted. To add a tool for this method, just click the non-highlighted tool. To remove a tool that is suited for this method, just click the highlighted tool. The highest tool in the list will be the default tool, to change the default tool, change the order. Click OK or Cancel to close the window.

The second column shows the possible tools for the method. Different tools might have different parameters. To change the parameters of a tool, select the tool first by clicking the finely checkered rectangle just in front of the tool name. Then click on the tool icon.
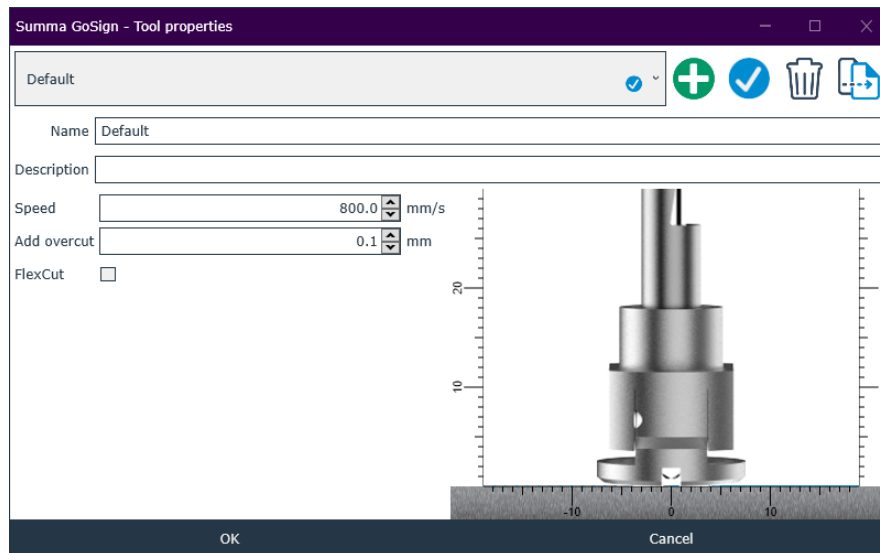
For each tool, you can make several sets of parameters. For instance, a set with the setting for high speed (draft) or low speed (quality), etc. With the plus icon, such a set can be added. With the check icon, a certain set can be set as default. With a garbage can, a set can be deleted. A set can also be duplicated. Each set has a name and an additional description can be included to clarify for instance the reason for the set.

The parameters for the tangential knife are:
Speed: This is the speed at which the knife cuts. Reduce this speed for thicker materials.

Add overcut: Is used for easier weeding. Each time the knife goes up or down, the cutter cuts a bit further. The distance the knife cuts further is determined by this parameter. This overcut is the overcut of the centre of the knifepoint. Do not use a high overcut when a lot of small curves are used in the job.

FlexCut: This is used for cutting through.

The different parameters for drag knife.
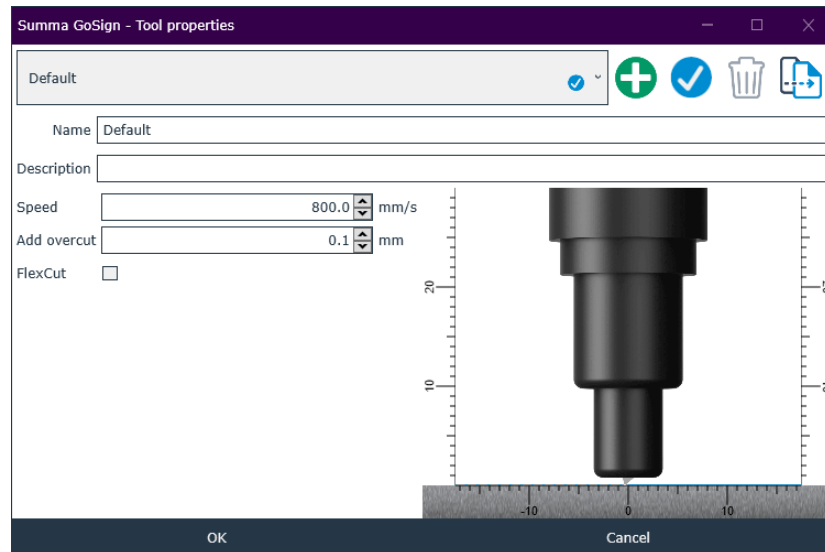
Speed: This is the speed at which the knife cuts. Reduce this speed for thicker materials.

Add overcut: Is used for easier weeding. Each time the knife goes up or down, the cutter cuts a bit further. The distance the knife cuts further is determined by this parameter. This overcut is the overcut of the centre of the knifepoint. DO not use a high overcut when a lot of small curves are used in the job.

FlexCut: This is used for cutting through.

The different parameters for the pen.
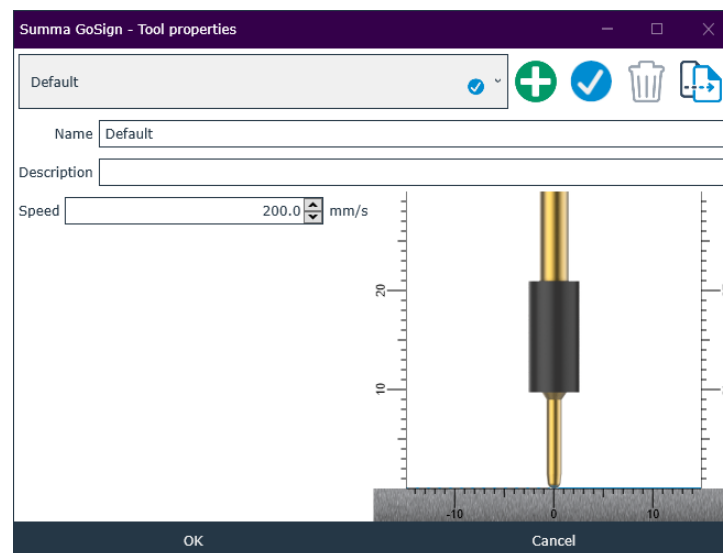
Speed: This is the speed at which the pen draws. Reduce this speed for thicker materials.

> **NOTE:** The type of pen depends on the model of cutter that is used.

2.2.3.2 Methods

The different methods are used in the design software. A method is material-independent. It simply describes the action/result that is used. Click the add icon to add a method. If a method is selected, the colour can be changed by clicking the edit icon. A method can be deleted by clicking the garbage can. If a method is used in the materials manager, it cannot be deleted.

2.2.4 Devices tab
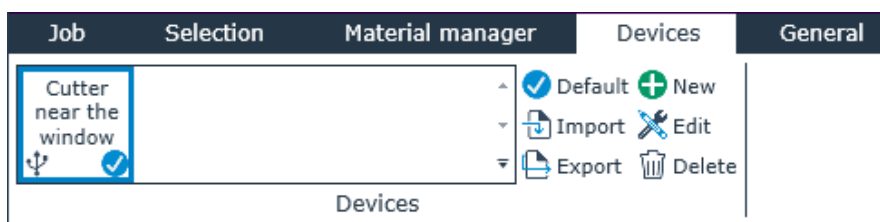
This tab is used to add or delete cutters that need to be controlled by GoSign. When the program is started up for the first time, then a window pops up to install a cutter. If that is not done, use this tab to do so. A default cutter can be set by first selecting the cutter from the list and then clicking the default icon. If there is only one cutter installed, this cutter becomes automatically the default cutter.

To add another cutter setup that has already been used (on this computer or another): Click the import icon, select the XML file and click 'Open'.

To export a cutter setup for later use or use on another computer, first, select the cutter and then click the export icon. Keep the proposed file name and click 'Save'.

To delete an unused cutter setup, select it and click the delete icon.

2.2.5 General

The last tab in the ribbon holds some general parameters and settings.
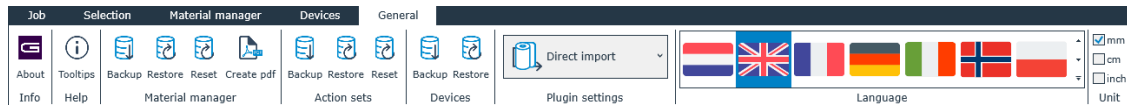
Click the icon for information about the program. Also, the license manager is opened to add more licenses for extra options.
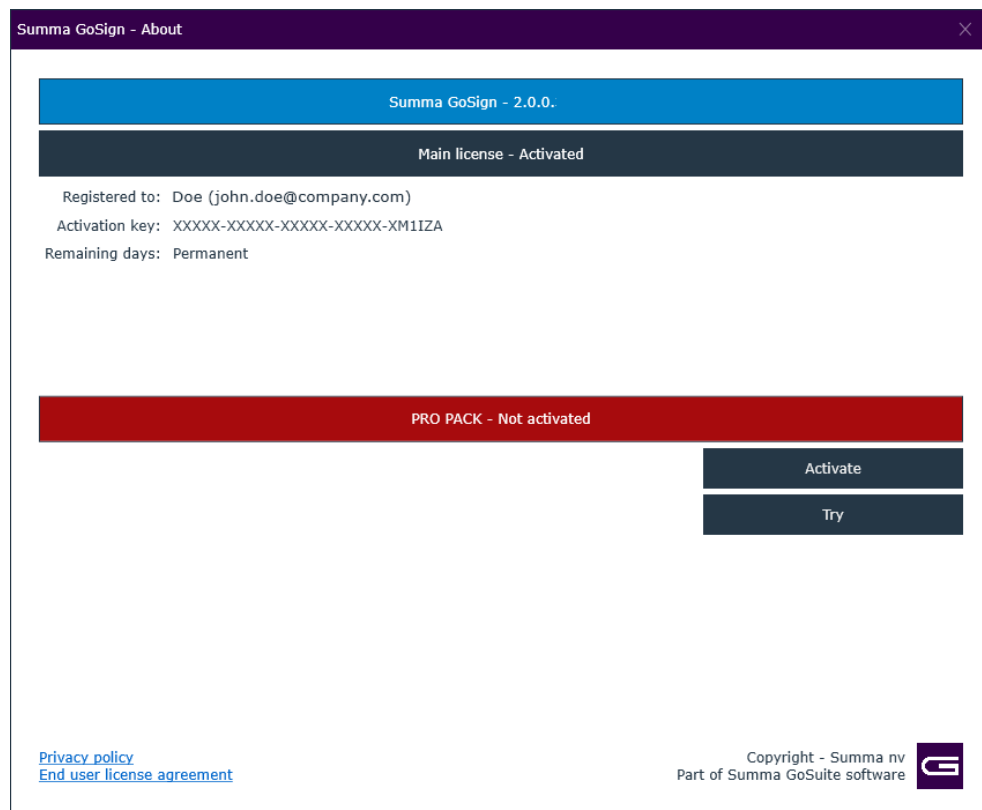
With this button, the Tooltips can be switched on or off.

Use this for making a backup of the material manager. The option Restore can import an earlier saved backup. The option Reset allows reloading the material manager as it was possible at the time of the installation of the program. The option Create pdf makes a readable list of all the different materials in the material manager and the settings of the tools.

A backup of the action sets can be made and an earlier made backup can be restored. The purpose of the actions sets will be explained in the next section.

A backup of the cutter setup can be made and an earlier made backup can be restored.
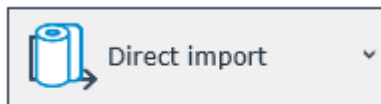
This sets the action that will be used when GoSign is opened with the plug-in from CorelDRAW or Adobe Illustrator. Clicking on the dropdown arrow will show the list of currently installed actions. Choosing direct import will open the job in GoSign when the plug-in button is clicked in the design software. Choosing a direct output will send the job with GoSign directly to the cutter when the plug-in button is clicked in the design software.

NOTE: Choosing any other action set other than these two is not advised since the resulting action will not be usable.

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.

The user measurements units can be set and changed here.

2.3   Action sets

2.3.1   List of available actions

Action sets can be workflows or a group of often recurring editing functions. There are some default actions installed when GoSign is installed. Action sets can be added, copied, edited imported and exported. And finally can also be deleted.

Click the plus icon to make a new action set. The action set editor opens.
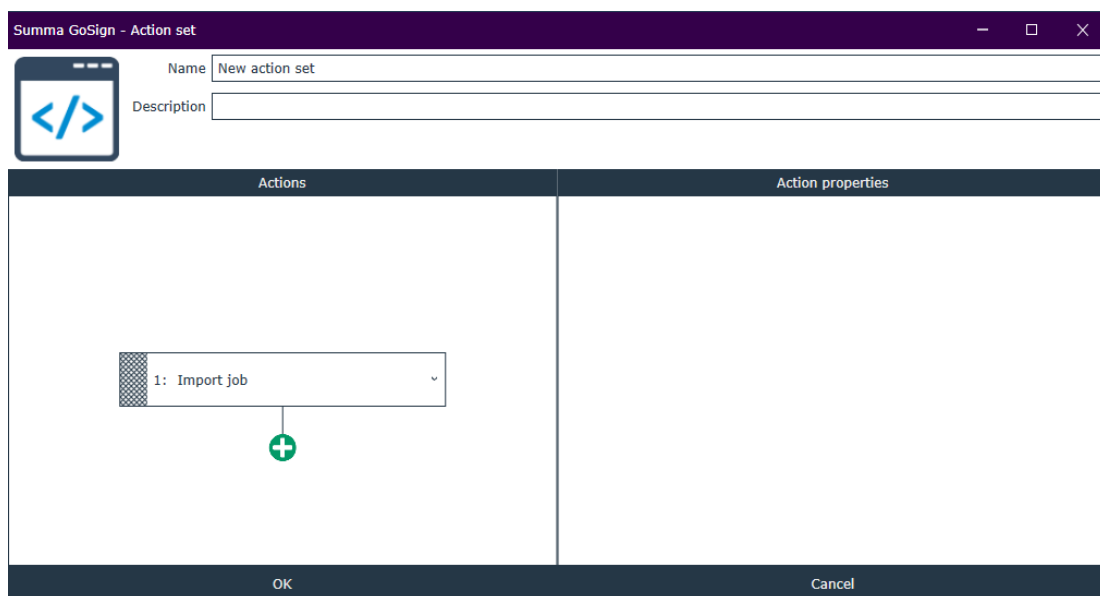
Give the action set a name, describing clearly what it is used for.
You can add a description to add some extra info. Click on the dropdown arrow to select the first action in the action set. A list of actions is shown, grouped per type. The list of actions is all the actions from the job and selection tab with some extra actions included.
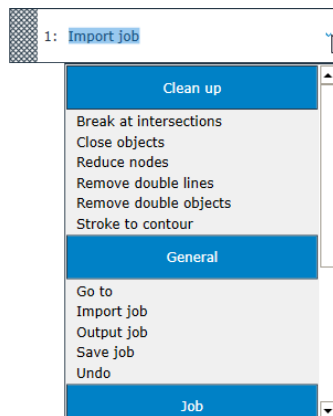
Select the first action. When the finely checkered rectangle before the action is selected, the action properties will appear to the right. Also, an icon of a waste bin will be shown right next to the action so it can be deleted if necessary.
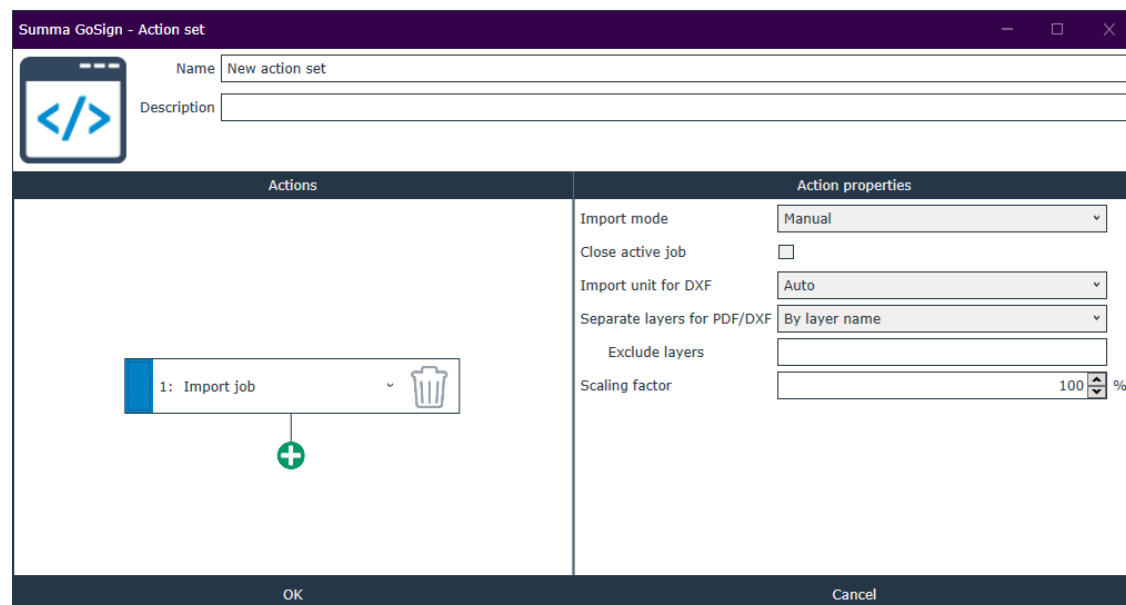
NOTE: Action properties depend on the chosen workflow (cut only – print&cut job) and on the setup configuration (model cutter and pro pack installed or not). This section explains all possible action properties. However, they might not always be available in your configuration.

2.3.1.1 Clean up actions

Break at intersections: This action breaks curves at intersections. There is also the possibility to regard objects as intersection when they are located very close to one another. The maximum distance for being regarded as intersecting or not can be set.

Close objects: This action checks whether each object is closed or not. When it is not closed, it closes it. The maximum distance the action closes can be set.

Reduce nodes: With this action, the number of nodes can be reduced. The maximum margin for the distance between the nodes can then be set. All objects are selected when this function is used.

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

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

Stroke to contour: This action converts strokes to contours. Sometimes jobs are badly designed and brushes or other tools have been used for defining a contour line instead of a simple line. In that case, the program can convert those double lines to a single stroke, delete the inner lines and keep the outer line.

2.3.1.2 General

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

Import job: This action imports a file. There are several parameters to set. Import mode can be set manually (the operator browses to search what he needs). Or you can use a barcode. If the barcode is selected, two extra parameters are made visible: the type of barcode reader and the directory where the jobs are located. Click the 3-dot icon to browse for the correct directory. The third import mode is the direct import mode. The direct mode is used when the job is imported directly from the design software with the plug-in installed by GoSign tools.
You can choose to close the previous job before opening it or just open a new tab with the job (only when a manual import is chosen).
For DXF files, you can set units to mm or inch or automatic.
When the pdf file is made correctly, the data is visible on layers. A layer for the registration marks and a layer per method. Choose here to separate the layers in the same way the layers in the pdf file separates the data.
You can also exclude layers for importing. This is useful if the print data is still located in the pdf file. Opening the print data could slow down the program.
Finally, a scaling factor is possible.

> **NOTE:** When the Pro Pack option is not installed, it is only possible to use a handheld scanner. When using a barcode, the filename should at least be 8 characters long and should not be longer than 13 characters.

Output job: This action sends the job to the cutter. There are a lot of parameters that can be set here and that are considered default values. However, when the job is processed, those parameters can appear on the screen again and can be changed, if necessary. This depends on the setting of the parameter.

Action properties	
Segmentation	Off ⌄
Number of jobs	1 ▲▼
Copies per job	1 ▲▼
Tiling	☐
Weed box	☐
Send design relative to origin	☐
On end of job	Feed job length ⌄
Feed margin	0 ▲▼ mm
Cut off	☐
Preload	☑
Margin	150 ▲▼ mm
Compensation mode	Best fit ⌄
Skip mark when mark is not recognized	☐
Plot to file	☐
Direct mode	☐
Cancel	

Segmentation: If the job is very long, GoSign can divide the job into segments. Before the program starts sending the data to the cutter, a preview can be shown. If Segmentation is set to on, then the length of the segments can be set.

Number of jobs: This parameter is used when using sheets. This determines the number of sheets that need to be processed.

Number of copies: Sets the number of copies to be processed with this parameter. If the sheets are used, then this parameter sets the number of copies per sheet. If the job is on a single sheet or a roll, then this parameter just determines the number of copies that need to be processed. The number of copies comes with a couple of options. If the number of copies is more than 1, then extra parameters appear.

- **Autofill**: When this option is checked, GoSign checks how many copies can be cut next to one another in the width. It then uses this value as the number of copies in the width direction. This option is usually not used in print and cut jobs.
- **Number of copies - Width**: If the option autofill is not checked, the needed number of copies in the width direction can be set here.
- **Space between copies - Width**: Sets the distance between the copies in the width direction (imagine a box around one copy – registration marks included - the distance between those boxes is then the distance between copies).
- **Space between copies - Length**: Sets the distance between the copies in the length direction.

> **NOTE:** If the distance between copies is not known for a print and cut job, fill in 0. When processing the job, set the camera above the first mark of the second copy. The program will then automatically use the distance for the third, fourth... 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 will stay as defined in the job.

On end of job: Determines the action after processing the job. According to the setting of this option, extra parameters are shown or hidden. You can choose whether to send the message to replace the sheet, feed the length of the job or feed a fixed length. Extra options are:

- **Replace sheet**: When doing jobs on a sheet, this can be used to give the operator a message if the sheet needs to be replaced.
- **Feed job length**: After a job on a roll, the cutter will move the tool at a point after the job. Two extra parameters can then be used. An extra margin can be added. And there is the choice to cut off the media after a job.

NOTE: If the cutter has no cut off knife, FlexCut is used as a cut off tool.

Compensation mode: There are 3 compensation modes to choose from:

- **Best fit**: The program decides for each curve which registration marks are the closest (best placed) registration marks to recalculate the shape of the curve to follow the printout.
- **Best fit (smart compensation)**: In this case, all the registration marks are used for the compensation of each curve. If necessary, the curves are even split up, so the printed line can be followed more precisely.
- **Fixed-size**: 'Fit to job' means that the shape and size of the cutting lines are fixed and that they don't follow the printed data. The cut data is just positioned in the best position about the registration marks. If the cut data is a perfect square, then the cut shape will be a perfect square, regardless of whether the printout was scaled in one direction or warped.

NOTE: When OPOS is the regmark placement method, then there is no choice in compensation mode, it will always be 'Best fit'.

Skip marks when not detected: Some registration marks might not be printed correctly. Consequently, these marks, can't be read by the program. If this option is checked, these bad printed marks are ignored. If this option is not checked, the program will pause, so the operator can intervene. He will then either skip or position the camera manually above the registration mark.

NOTE: This is only applicable for round marks (not for standard OPOS marks).

Direct mode: If this option is checked, the program will not show the output parameters as described above when the output is started. It will start the job immediately with the settings that were set in the action set. This option is essential for using the direct mode to cut directly from the design software when using the plug-in installed by GoSign Tools.

Save job: This action makes it possible to save the current job as a GoSign file (sgsj file type).

Undo: This action undoes the previous action.

2.3.1.3 Job-related actions

Fit working area to device: This action fits the working area to the loaded media (cutter must be connected and media must be loaded).

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

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

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

Set default material: This action sets the default material. Click the drop-down box in the action properties column to get a list of the materials and select the needed one.

Set job origin: This action can start a job at a certain offset from the origin. Change the x and y value as needed.

2.3.1.4 Layer related actions

Remove layer: With this action, a layer can be removed. Click the drop-down box in the action properties column to get a list of the methods and select the one that needs to be removed.

Search regmarks: This action searches for the registration marks. You have the option to search all layers or just certain named layers (layer names are case sensitive). The regmark placement method is fixed at OPOS.

Select layer: With this action, a layer can be selected. Click the drop-down box in the action properties column to get a list of the methods and select one.

Set layer properties: Layers have two properties. They can be made visible or invisible. They can also be locked or unlocked. This action can change the properties of all layer or just the selected layers. Select it to show the setting in the action properties column.

2.3.2   Actions sets maintenance

The previous section describes how to make an action set. Action sets can be duplicated and edited and can be exported and imported. Action sets, which are not used any more, can be deleted.
Select an action set by clicking the finely checkered rectangle in front of the name.
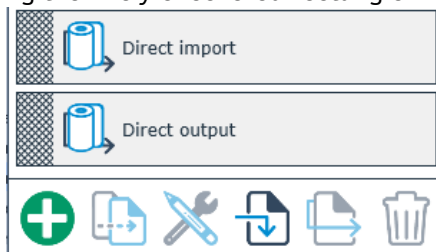
Click the icons to work with the action set. After the plus icon, you can find the duplicate icon and the editing icon. After these, you can find the import and export icon. Finally, you will see the garbage icon to delete the action set, if it is not needed any more.

2.3.3   Predefined actions sets

When GoSign is installed some pre-defined action sets are also installed. These action sets and some settings of the properties of the actions are influenced by the choice that is given when the program is set up.
BasicActionSets: Only the basic needed action sets and the manner to define the methods are set by the use of different colours.
AdvancedActionSets: More actions and the manner to define the methods are set by the use of layers in pdf files.

2.3.3.1
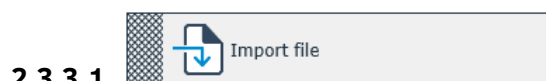
Three types of files can be imported: SGSJ, SGP, OXF, PDF and DXF files. This action set opens a window, so the user can browse for the needed file.
The action set closes the currently open job, if any, and opens the selected file. The vectors will be split up into different layers (methods) according to the chosen action setup during program setup. All open objects, which are not opened more than 0.5 mm, will be closed and the program will also search for registration marks (OPOS squares and OPOS line) on the Regmark layer.
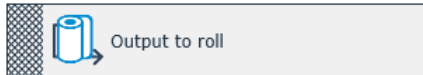

2.3.3.2
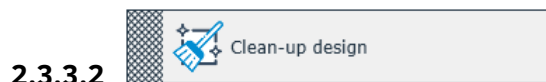
This action can be used to clean up files. If there are any objects in the job that have curve segments common with other objects, they will be deleted. Using this option might leave you with open curves, which can influence the sorting algorithms.
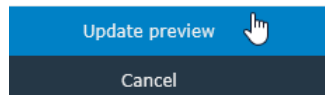
> **NOTE:** Action set only available in Advanced action set.

2.3.3.3

This action set outputs the already open job. Standard, it is set this way the output parameters are shown, so they can be changed, if necessary. After the job, the roll is moved forwards by the length of the job.

NOTE: The output parameters are set in the output action set. However, they can be changed before the job is started. If parameters are changed that affect the preview, there is the possibility to refresh the preview. Just click the refresh preview button, appearing just above the cancel button.

2.3.3.4
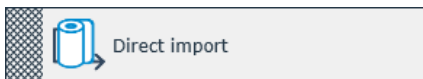
This action set is used when importing a file from your design software by using the plug-in. The methods are linked to colours or layers depending on the chosen setup (Basic or Advanced). There is the possibility to check some things before sending the job to the cutter.

2.3.3.5
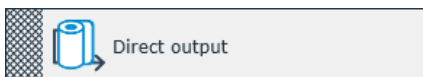
This action is used to cut directly from the design software in combination with the plug-in.

2.4   Layer Window

2.4.1   General

The window on the right side shows the Material/ Method / Tools/ setting. All the settings are filled in with the info from the imported file. If not all settings are filled in correctly, then they cannot be set correctly. If that is the case, the right window should look like the below screenshot if a file is imported.
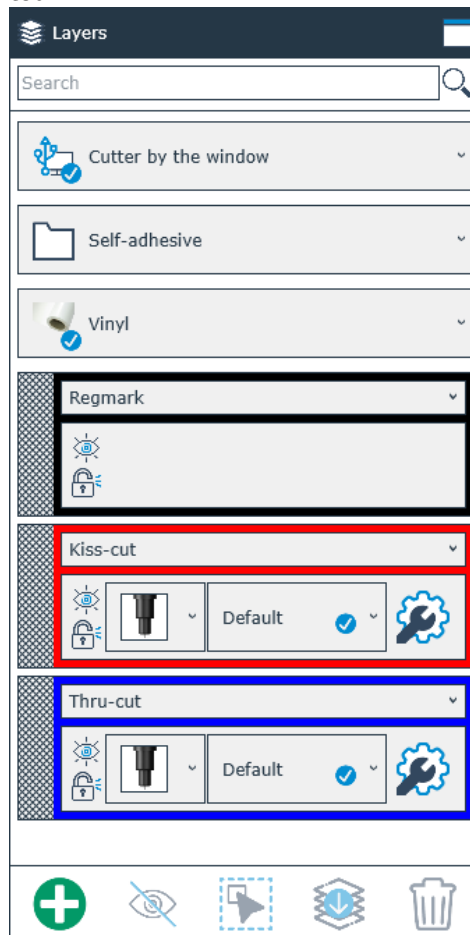
> **NOTE:** When making changes in the layer window, always work from top to bottom. A change of a setting can change/influence all settings below.

> **NOTE:** If the import action set is set to separate layers by layer name, all objects in unknown layers names (methods) will be put in the top layer (highest in the list).

2.4.2 Set material correctly

Normally there is no data on the material in the file with the cut data. The file is opened and the default material is used. If this is not correct, change the default material before opening the file or change the material in the layer window.
To change the material, either use the search box or set it by first choosing the material group and then selecting the correct material from that group.
When using the search box, just fill in a couple of letters. A list of materials, holding the letter combination that was filled in, will appear below the search box. Choose the correct one.
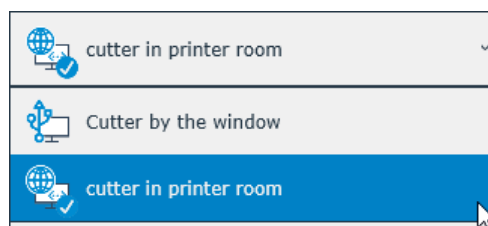

Or first, choose the material group, then the material itself.
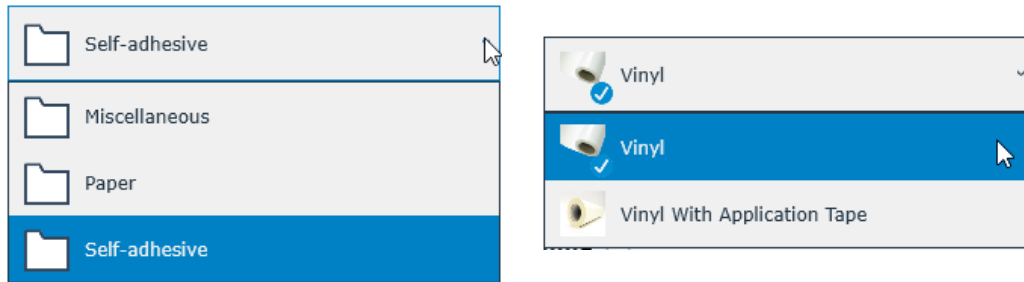
2.4.3 Select cutter

If more than one cutter is connected, then the default is chosen when a file is opened, if the job needs to be cut on another cutter, then select the cutter from the list.


Selecting another cutter automatically sets it as the default cutter. So, all consecutive jobs will be done on that cutter until another cutter is chosen again.

2.4.4   Set Methods/Tool parameters

Again, if everything is set up correctly, it is not necessary to change the method or tool or tool setting. However, in case a special material is used or if the data in the cut file is not set up correctly, the methods and the corresponding tools can be set/changed.
The cut data is shown on layers. With simple cut only jobs, needing only one tool, there may be only one layer. If more than one tool is needed, there will be more layers. If it is a print and cut job, there is the regmark layer and the layer(s) with one or more methods.

#### 2.4.4.1   Case 1: Default material and method set correctly in the cut data file
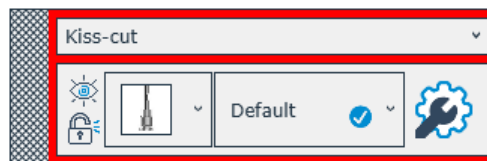
This means that a method has been assigned to the cut lines on that layer and a tool has been assigned to the methods, according to the data in the material manager. The settings are also copied from the material manager for that tool.
A layer can be made invisible/visible by clicking the eye icon.
Clicking the padlock locks or unlocks the layer.

Click the dropdown list of the layer name to change the method for the vectors on that particular layer. A list of available methods for the chosen material will appear.
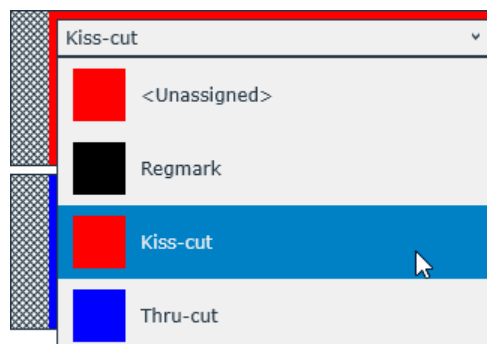

Click the dropdown list next to the tool icon to change the tool, if necessary. The program will always show the default tool after importing the file and the assigned layer/method. If available and needed, an alternative tool can be used.
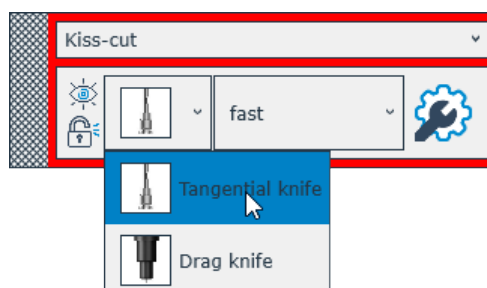
Sometimes a list is available, situated next to the tool type, with predefined parameter sets for the chosen tool. The default setting will always be chosen, but alternative parameter sets, if available, can be chosen by clicking the dropdown list.
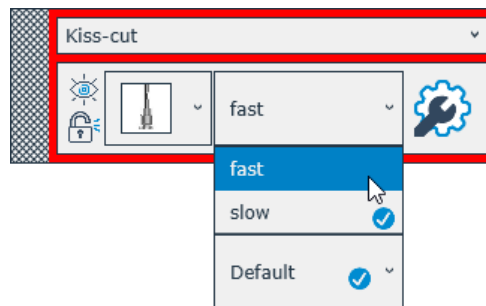
Click the gear/wrench icon to change the parameter of the selected tool. A window with all the parameters will be shown on the screen. Change a parameter, if necessary. At the bottom of the window, a button is highlighted when a parameter is changed. Click it if the change must be permanent. The setting will then change permanently in the material manager.
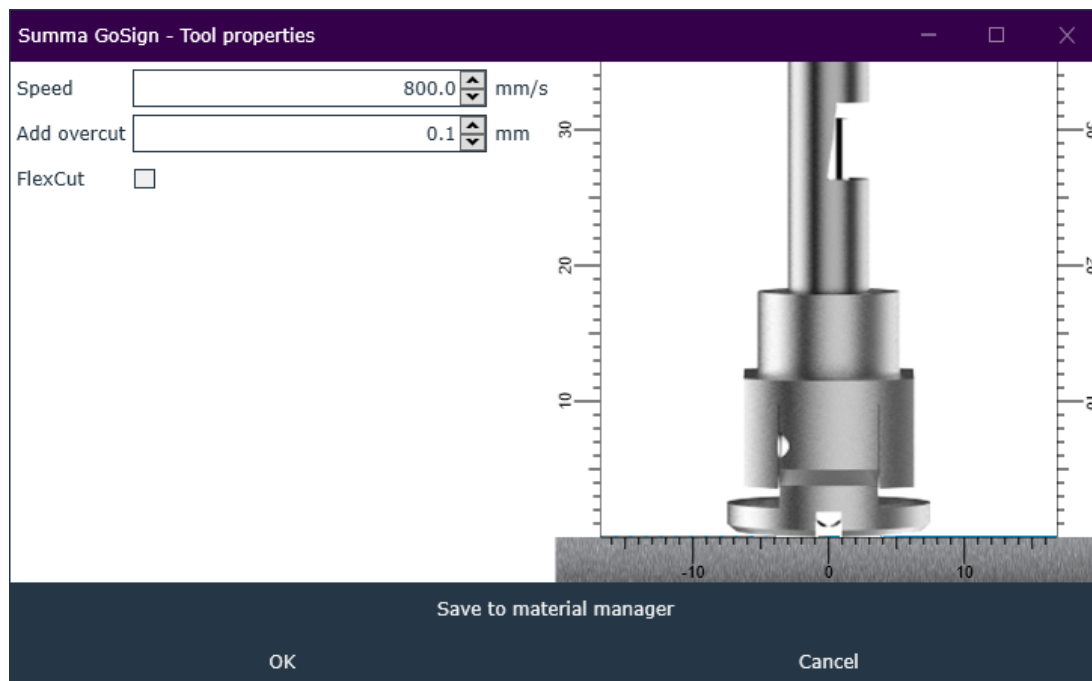
2.4.4.2 Case 2 material not set correctly / wrong or unknown method

Either the material has not been set correctly or a wrong method for that particular material type was chosen. To set the material correctly, see section 2.4.2. If the material is set correctly, a tool will be assigned to it automatically.

By default, GoSign will assign the Kiss-cut tool to all the cut data of which the method is unknown. It will however keep the cut data on separate layers if an unknown method (layer or colour – depending on the setup: Basic or advanced).

> **NOTE:** This is only the case if the import action is set to separate layers by colour. If the action set is set to separate by layer name, then all objects of unknown layer names will be put in the Kiss-cut layer.
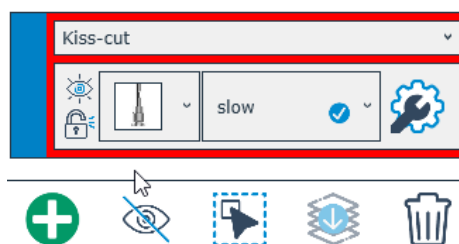
You can also change the method by clicking the dropdown list next to the method name. Once the method and material are set correctly, the parameters can be changed as described in section 2.4.4.

Set the material correctly first because only then a method can be chosen. Click the dropdown list to choose the correct method if needed.
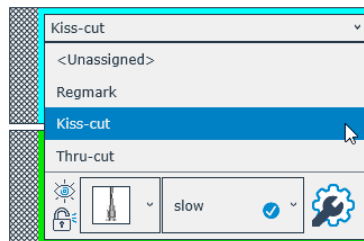
2.4.4.3 Editing with Layers

Click the finely checkered rectangle of the layer to select it.

Click this icon to select all objects on the selected layer

Click this icon to move all current objects to the selected layer.

Use the garbage icon to delete a selected layer with all its objects on it.

Click this icon to create a new layer

3 PRO PACK (optional)

3.1 General

The Pro Pack is an optional (payable) addition for GoSign. The extra features that are unlocked with this Pro Pack are:

- Ability to import plot files
- Support for OPOS CAM machines
- Barcode functionality
- Twin Workflow
- Possibility to use hot folders

3.1.1 Importing plot files

The figure below shows which file types can be opened with GoSign. The plt, DMPL and HPGL file types will only be shown if the Pro Pack is installed.
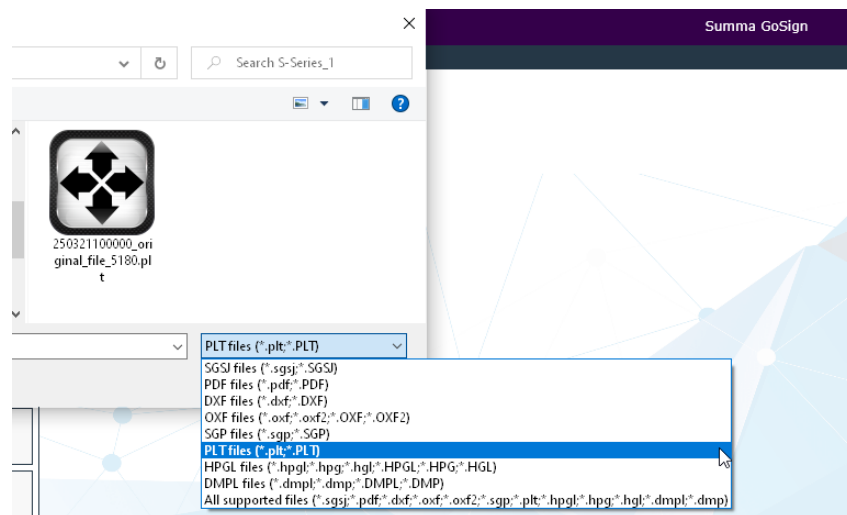
SGSJ files types are the files that were saved by GoSign.
SGP files are files that were created by programs that have drivers for GoProduce.
PLT, HPGL and DMPL files can have different origins, they can be created by design programs that can export to a plt file or programs that have drivers for roll cutters.

3.1.2 OPOS CAM support

Pro Pack enables the program GoSign to process jobs on an OPOS CAM cutter the same way jobs are processed on the F Series table. The program GoSign can import SGP files that were created by programs that have a driver for the F Series. These files have round marks and the position of the marks is not so restricted as the OPOS marks. Marks can be put randomly. Also, extra compensation methods are unlocked (smart compensation and fixed-size).

> **NOTE:** The traditional camera control functionality is still available for free in Summa Cutter Control. So an OPOS CAM cutter can be used in combination with GoSign and process jobs in the same way as roll cutters with an OPOS sensor.

3.1.3 Barcode support

The barcode functionality is an expansion of previous barcode functionality with Summa Cutter Control (which is still free).
The setup of the barcode workflow with GoSign has advantages such as:

- Possibility to adjust speed and tool pressure if necessary (when these parameters are set in the cut file by the RIP, they cannot be changed using the standard barcode workflow with Summa Cutter Control).
- Possibility to process barcode jobs that were initially created for jobs on an F Series flatbed table or an OPOS CAM roll cutter.
- Ability to set up barcode workflow with PDF (or DXF) files.

When the Pro Pack is installed, install the action set for the OPOS Barcode Workflow on a roll.

To do so, click on the import action set icon in the action set column ( ) and navigate to the ..\Documents\Summa GoSign\Action sets directory. Now, open the OPOS Barcode Workflow on a roll file. The action set will then appear in the list of action sets:
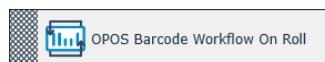
3.1.4   Twin Workflow

By combining the best of both worlds, kiss-cutting on a roll cutter and Thru-Cut on the F Series flatbed cutter, a significant performance increase can be achieved.
The media rolls are first processed on a roll cutter cutting kiss cutting lines only. Kiss-cutting goes much faster on a roll cutter than on any flatbed cutter.
After that, the media is loaded on the F Series and here the cut-through lines are cut. This is useful should a complete cut through-line is needed and it also creates the possibility to lower the workload on your roll cutters, so more jobs can be processed.

There are two different Twin Workflows. The difference between the two is the driver that was used for preparing the files with the cut data for the jobs in combination with the type of roll cutter that is used.

3.1.4.1 Twin X Mode

This Twin mode is developed for roll cutters with a standard OPOS sensor in combination with the F Series flatbed cutters. The files needed are provided by RIP's that have drivers for roll cutters. They create plt files (either DMPL or HPGL files).
First, the action sets for this workflow need to be imported. To do so click on the import

action set icon in the action set column (⬇️). Navigate to the ..\Documents\Summa GoSign\Action sets directory and open the Twin X Mode file.
Three action sets will then appear in the list of action sets:
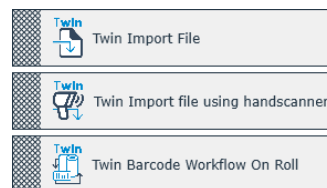
Typically, a plt file created by a RIP that is used in Twin X mode is a cut file with data for the position of the OPOS marks, kiss-cut lines and FlexCut lines. When such a file is opened with one of these action sets, the OPOS marks are put on one layer. The lines that need to be kiss cut on another layer and the lines that need to be cut through on a third layer. This third layer with the lines that need to be cut through will then be made invisible.
This way, when the job is sent to the cutter, only the kiss-cut lines will be cut. If this same file is then opened with GoProduce to cut the cut-through lines on the flatbed, the layer with the kiss-cut lines will be made invisible in that program.
The figures below first show the printed file and then the plt file that has been imported for the Twin X mode workflow.
The plt files were made with a driver for the roll cutters and used as OPOS mode OPOS Xtra. This means that extra XY lines are created between copies.
These lines can be read by the OPOS sensor on the roll cutter, but not by the camera on the flatbed cutter.
For this reason, these extra lines are shown in GoProduce as lines. They will not be cut because they are in a layer that has no tool assigned to them. In GoSign the position is shown where the sensor will detect the edge of the printed line to compensate.
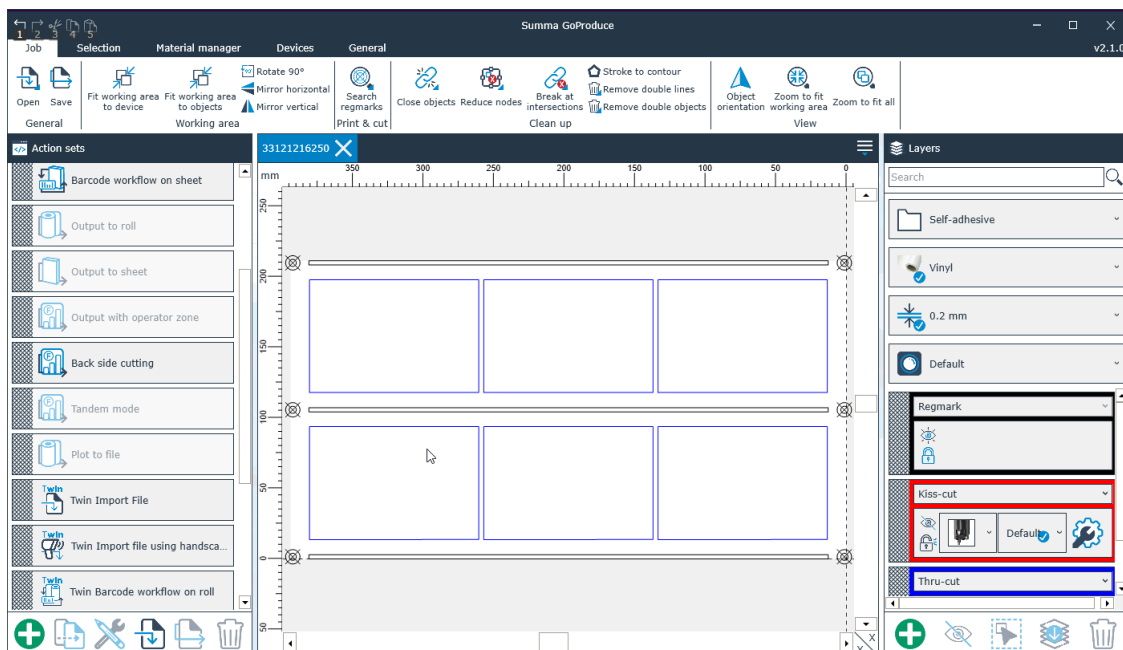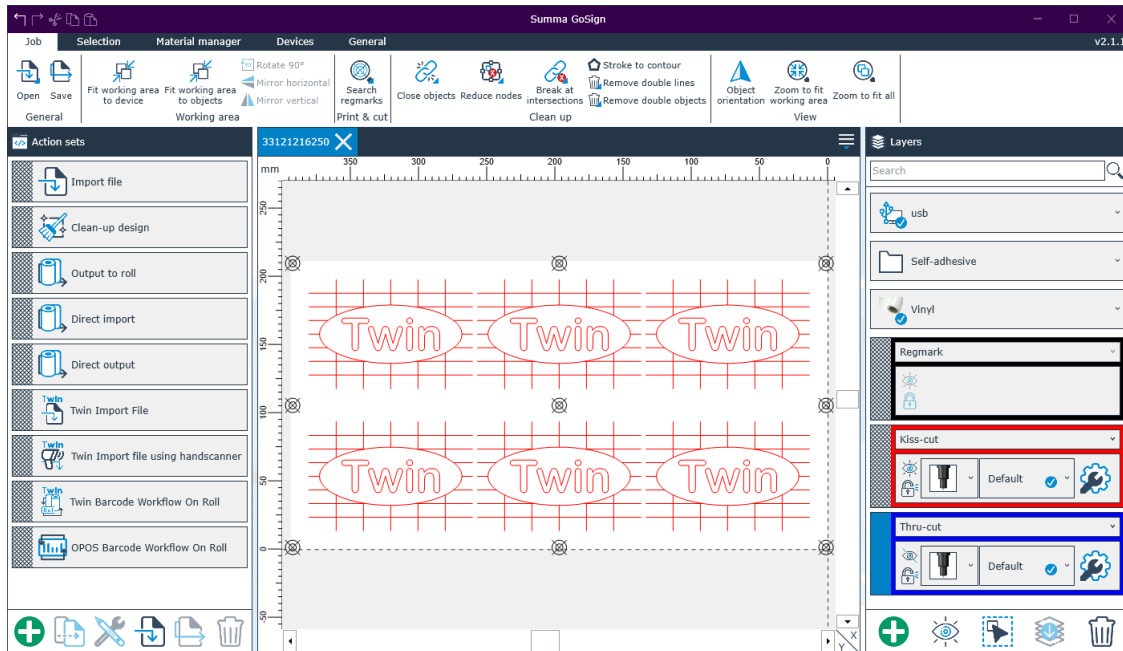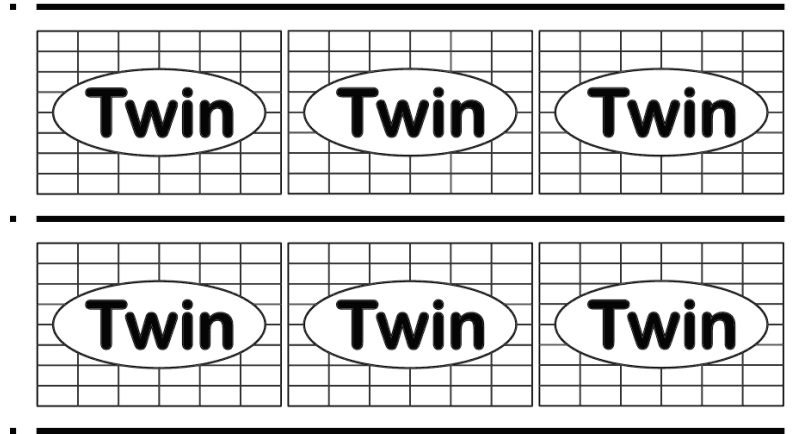
3.1.4.2 Twin Mode

The Twin mode is developed for roll cutters with a standard camera sensor in combination with the F Series flatbed cutters. The files needed are provided by RIP's that have drivers for the F Series or GoProduce. They create SGP files (older versions might still create OXF files).
First, the action sets for this workflow need to be imported. To do so, click on the import action set icon in the action set column ( ). Navigate to the ..\Documents\Summa GoSign\Action sets directory and open the Twin Mode file.
Three action sets will then appear in the list of action sets:
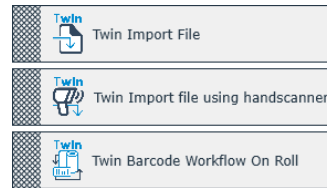
Typically, an SGP file created by a RIP that is used in Twin mode is a cut file with data for the position of the round registration marks, the Kiss-cut lines and Thru-cut lines. When such a file is opened with one of these action sets, the round marks are put on one layer. The lines that need to be kiss cut on another layer and the lines that need to be cut through on a third layer. This third layer with the lines that need to be cut through will then be made invisible.
This way, when the job is sent to the OPOS CAM cutter, only the kiss-cut lines will be cut.
If this same file is then opened with GoProduce for cutting the cut-through lines on the flatbed, the layer with the kiss-cut lines will be made invisible in that program.
The figures below first show the printed file and then the SGP file that has been imported for the Twin mode workflow.
All registration marks are circles. Both the OPOS CAM roll cutter and the F Series flatbed table have a camera that will read all these marks to compensate for the print and cut job.
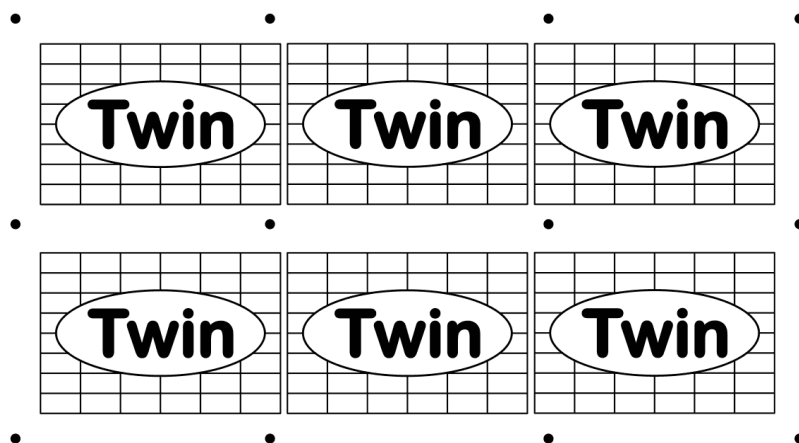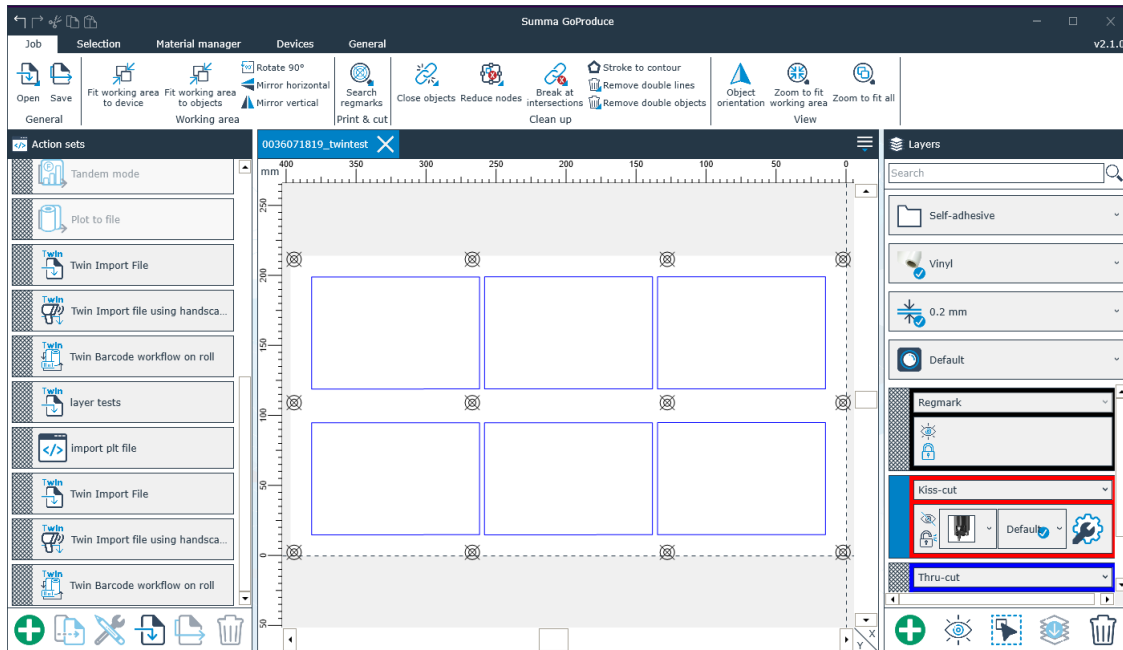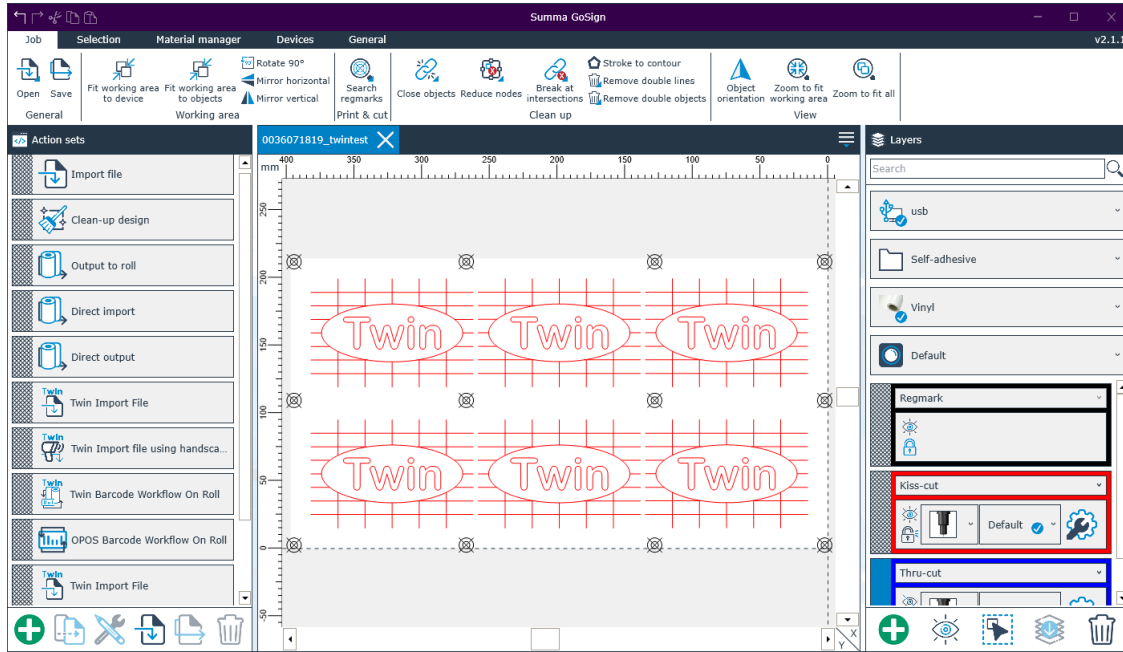
3.1.5   Hot Folders

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 dropped in a folder can now also be opened automatically in GoSign. The flexible action sets ensure that what happens next is fully customisable.
Below is a sample of an action set that picks up all files dropped on a server directory called GoSign_in and sends them directly to the cutter. You can see that in the properties of the import action the type of import is set to 'hot folder' and the import directory is set. In the output action, the property Direct mode is checked.