

# IOLINE™



## User Guide



# IOLINE FLEXPLOT

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**Ioline Corporation**  
**14140 NE 200th Street**  
**Woodinville, Washington 98072 U.S.A.**

Ioline Customer Service Department  
Monday through Friday  
7:00 A.M. - 5:00 P.M. U.S. Pacific Time  
**Voice: 1.425.398.8282**  
**Fax: 1.425.398.8383**  
**techsupport@ioline.com**  
**www.ioline.com**



# IOLINE FLEXPLOT

## User Guide

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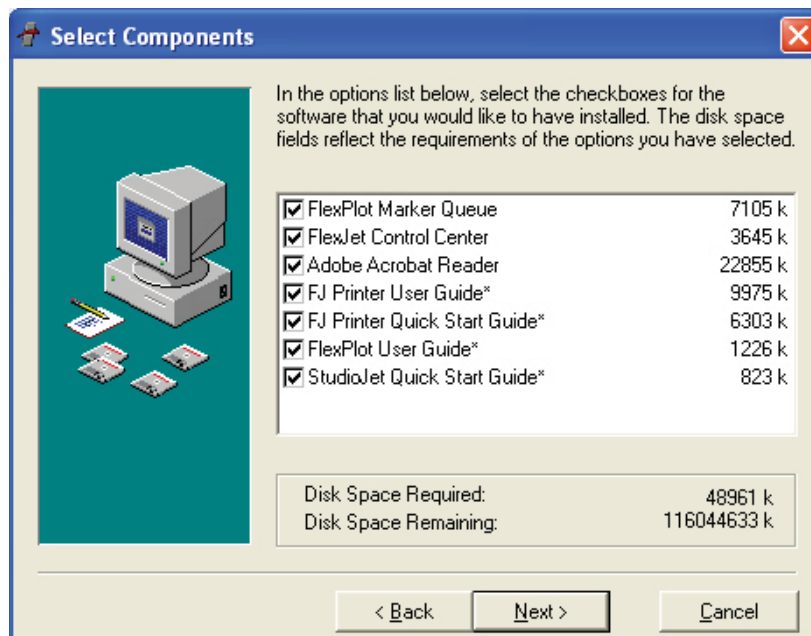
# Installation & Setup

The Ioline FlexPlot Software will convert and send HPGL, DM/PL, DXF, ASTM 6959 and MicroMark™ output files to Ioline apparel printers. Users of Gerber™, Lectra™, PAD™ and many other design systems can now create markers with familiar software but use Ioline apparel printers for marker output.

System requirements: 32 bit version of Windows 2000/XP/Vista, ~25 MB of hard disk space, 1024 x 768 minimum screen resolution and an Ioline FlexJet connected to a communication port.

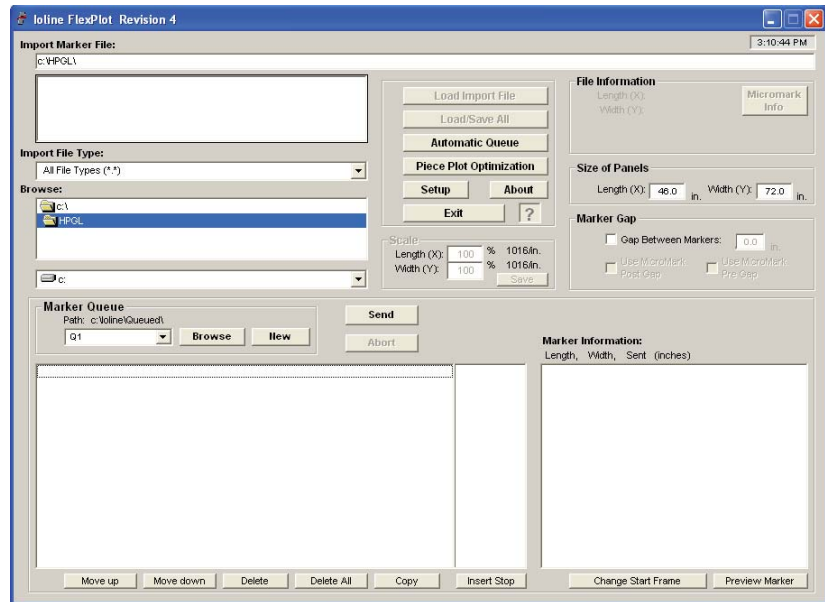
## Installing FlexPlot

1. Close all other applications prior to installation.
2. Insert the installation CD-ROM into the computer CD-ROM drive.



**Figure 1.** Insert the Installation Disk in your CD-ROM drive to install **FlexPlot**.

- The installation program should start automatically. If not, go to the *Start Menu*, and click on *Run*. Browse the CD-ROM drive (usually *D:\*), and double left-click on *iosetup.exe*.
- Follow the self-guided installation procedure. The default settings are acceptable for most users. Ioline recommends that you install the manuals and the Adobe® Acrobat® viewer along with the **FlexPlot** software. (See *Figure 1*.)



**Figure 2.** The Main **FlexPlot** Window.

## Setup

- The Ioline **FlexPlot** program icon is stored on the desktop or under *Start/Programs/Ioline*. Start **FlexPlot** by clicking the program icon. The main program window will appear. (See *Figure 2*.)
- Determine the serial port number on the PC that is used to send data to the printer. The **FlexPlot** software can use COM 1 through 8.
- Press the **Setup** button to open the *Setup Window*. (See *Figure 4*.)
- Choose the port and communication baud rate on the **Device Communications** dialog box. The default baud rate is 38,400 for the FlexJet and 9600 for the 600Ae, 28Ae, and 600AeX. Default settings for the other features typically work best for most users. See the *Command Index* for a description of each feature in the setup window.
- Press the **OK** button.
- Exit when the settings are complete.



**Figure 3.** The **FlexPlot** icon.

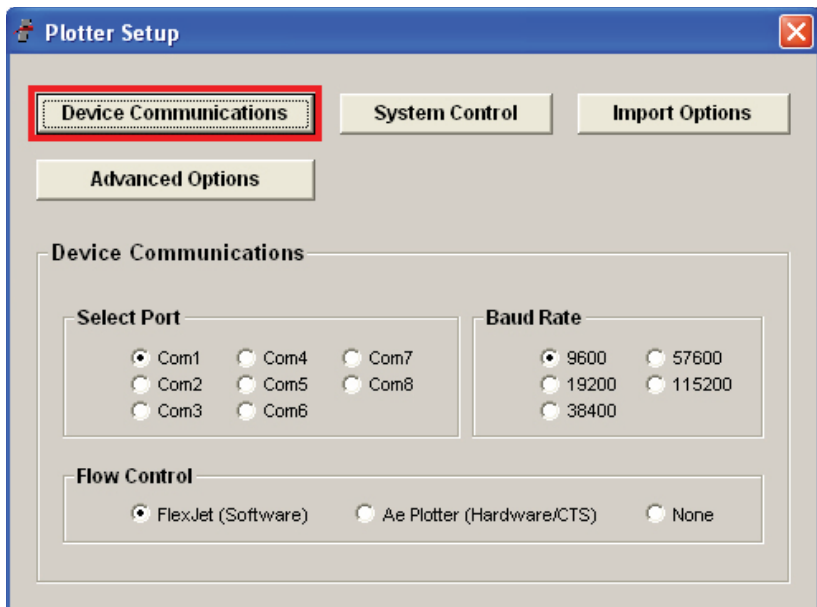


Figure 4. The FlexPlot Device Communications Setup Window.

### Import Marker Files

1. Start the FlexPlot software if it is not already running. The main program window will appear. (See Figure 2.)
2. Choose the location of the files to import in the folder and file lists on the left side of the FlexPlot window. If the files are not visible, choose the correct file type in the Import File Type list.
3. Left click on the desired file name then press the Load Import File button to convert the file and send it to the Marker Queue shown in the spooler window. Use the CTRL and SHIFT keys to select multiple files at a time. The FlexPlot software creates a new file in the queue with the source file name but with a .PLX file extension.

### Print Markers

1. The current Marker Queue is shown in the bottom window, Figure 5. Markers added in Step 3 above are displayed in the Marker Queue list. (The file will stay in the list until the Send button is pressed or the file is deleted.)

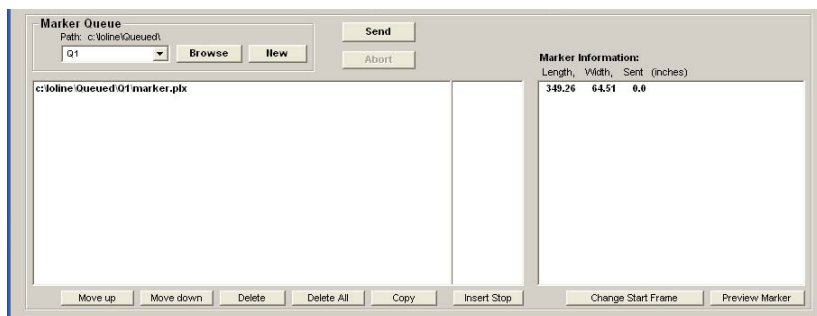


Figure 5. The FlexPlot Marker Queue.



**Hint**

The default FlexPlot file location is **C:\HPGL**.



**Hint**

Hint: Choose **All File Types (\*.\*)** in the **Import File Type** list to see all the files in the folder. **FlexPlot** will automatically recognize files that it is compatible with when they imported.

2. Make sure that FlexJet power is on, loaded with paper and an **Origin** is set (**OK** = Green). *See the FlexJet User Guide for details on preparing the FlexJet to print.*
3. Press the **Send** button in the spooler window to send all of the markers listed in the **Current Marker Queue** to the printer. The file at the top of the list is sent first followed by the other files in the order they are shown.
4. Press the **Abort** button if you ever need to stop printing. Position the carriage and press **Set Origin** on the FlexJet keypad to reset the printer and prepare to send new markers.



### Hint

The **Move Up** and **Move Down** buttons in the **Send Queue** move the selected file printing order up or down one position.



### Hint

The **Send** and **Save Queues** can hold many marker files. After the **Send** button is pushed, each file is printed in the order that it is displayed in the queue. The top files are printed first. Files added before the queue is emptied are included in the active queue.



### Hint

Once **Automatic Queue** imports and converts a file, it deletes it from the queue folder.

## Using Automatic Queue

**Automatic Queue** provides a way for users to automatically send files to the FlexJet without having to interact with the **FlexPlot** software. Once **Automatic Queue** is active, any file copied to the queue folder is automatically imported and sent to the FlexJet. Multiple users can all copy marker files to the same location on a network and **FlexPlot** will add them to the queue in the order that they appear in folder. To **Enable Autoqueue**:

1. Choose the queue folder in the Browse window where users will copy marker files to. This folder can reside on the local hard drive or a network.
2. If the **Automatic Queue** button is grayed out, select the **Enable Automatic Queue** option in the Setup window..
3. Press **OK** then **Start** when you are ready to start importing files and sending them to the FlexJet.



Figure 6. The FlexPlot Marker Queue.

4. When a file is written to the folder shown in the **Browse** window, it is automatically shown in the **Automatic Queue Window** (may take a few seconds). The first file in this window is sent directly to the printer then removed from the list. As files are added to the folder, they will appear in the **Automatic Queue Window** where you can reorder them. Only the file that **FlexPlot** is currently sending to the printer is shown in the **Send Queue Window**.
5. Press the **Abort** button if you ever need to stop printing. Position the carriage and press **Set Origin** on the FlexJet keypad to reset the printer and prepare to send new markers.



# Command Index

## Main Window

<b>About</b>	Displays program and version information.
<b>Automatic Queue</b>	Opens the <b>Automatic Queue</b> window. Files sent to the current <b>Browse</b> location are automatically converted and sent to the FlexJet. If this button is disabled, go to the <b>Advanced Options</b> tab in <b>Setup</b> to enable it.
<b>Browse</b>	This window shows the current folder and drive (volume) list.
<b>Exit</b>	Exits the <b>FlexPlot</b> software.
<b>File Information</b>	Displays length, width and name of the imported file. When using <b>STD</b> files, the <b>Micromark Info</b> button is activated. Pressing it shows detailed information about the marker.
<b>Help (?)</b>	Enable/Disable help buttons for pop-up tips.
<b>Import File Type</b>	Lists the file types compatible with <b>FlexPlot</b> . Selecting a single file type from the list will make only that file type appear in the <b>Import Marker File</b> window. Choose <i>All Files (*.*)</i> to display all files in the folder.
<b>Import Marker File</b>	The selected file name is displayed in the top window and other available files in the <b>Browse</b> folder are displayed in the smaller window below.
<b>Load Import File</b>	Loads the currently selected file into the <b>FlexPlot</b> software. File length, width, etc. is displayed in the <b>File Information Window</b> . <i>See also, Using Automatic Queue in this chapter.</i>
<b>Load/Save All</b>	Automatically converts all files in the current folder and adds them to the <b>Marker Queue</b> .
<b>Marker Gap</b>	Add a gap (blank space) after each marker.
<b>Micromark Info</b>	When importing <b>STD</b> files, the <b>Micromark Info</b> button is activated. Pressing it shows detailed information about Micromark markers.
<b>Piece Plot Optimization</b>	Conserve paper by stacking narrow piece jobs or other small markers across a wider marker. <i>See the Piece Plot Optimization Window below.</i>
<b>Scale</b>	Adjust the scale of the imported marker. The <b>Save</b> button makes the settings permanent.
<b>Setup</b>	Displays the <b>FlexPlot</b> Setup window. <i>See Setup Window, below.</i>
<b>Size of Panels</b>	Displays the width of the Y (carriage motion) and length X (paper motion) panels. Setting these values smaller than the imported marker will break it into smaller pieces. Smaller Y makes multiple columns for printing extra wide markers on narrow printers. Smaller X speeds up printing.



### Hint

**FlexPlot** breaks a wide marker into columns if the width (**Y**) of the file is larger than the **Y** value shown in the **Size of Panels** box. Each column is stored in the queue as a separate file with the same name but with a number after each one indicating the column number. This way, the user can print markers that are wider than the printer.

**Hint**

Press the **Set Origin** button after aborting a print job. This clears the memory and prepares the printer for the next plot.

**Hint**

To use **Change Start Frame**, select the file in the **Send Queue** list then press the **Change Start Frame** button. Determine a *Starting Frame Number*. The frame size and starting point is displayed under the file name. **Example:** A marker failed 125 inches from the beginning and it has 46 inch frames. The first two frames printed 92 inches (46 x 2) of the marker. Enter '3' in the *Start Frame Number* box so that the two frames are skipped and the missing portion of the third frame (between 92 inches and 136 inches) is printed.

**Note**

To stop printing immediately, press **Start/Stop** on the FlexJet keypad. Consult the **FlexJet User Guide** for more information on pausing and cancelling printing.

**Note**

The **Insert Stop** command does not pause the FlexJet in the middle of printing. The printer will continue to print all the data in the buffer until it encounters a **Pause Marker** at the end of a file.

## Marker Queue

<b>Abort</b>	Stops sending data to the printer. The FlexJet will halt after printing the data in its buffer. Press <b>Start/Stop</b> on the keypad to immediately stop printing.
<b>Browse</b>	Choose a queue on a hard disk or network volume.
<b>Change Start Frame</b>	If the FlexJet runs out of paper or ink before completing a marker, you can reprint the marker from the <b>Frame</b> at which the media ran out to save time and consumables. See side bar for more information.
<b>Copy</b>	Creates multiple copies of the selected marker.
<b>Delete</b>	Remove the selected marker from the <b>Marker Queue</b> list.
<b>Delete All</b>	Removes all markers from the <b>Marker Queue</b> list.
<b>Insert Stop</b>	Places a stopping point between the selected marker and the next marker in the list. The <b>FlexPlot</b> stops sending print data after the marker with the <PAUSE> symbol is complete then waits for the user to press the OK button to continue printing.
<b>Marker Information</b>	Displays length, width, and progress data for files in the queue.
<b>Marker Queue</b>	Shows the queue to which files are saved and sent.
<b>Move Up/Down</b>	Change the order markers are listed (and sent) in the queue. These buttons do not work on the marker currently printing.
<b>New</b>	Create a new queue.
<b>Preview Marker</b>	Displays a preview of the currently selected marker.
<b>Send</b>	Sends all files listed in the <b>Marker Queue</b> window. Files at the top of the list are sent before files listed below them.

## Setup Window: Device Communications

<b>Baud Rate</b>	Choose the speed of communication over the port connected to the FlexJet. This must match the baud rate in the printer. <i>See the FlexJet User Guide for more information.</i> The default is 38,400.
<b>Flow Control</b>	Choose <b>FlexJet (software)</b> for printers or <b>Ae Plotter (Hardware/CTS)</b> for a pen plotter. The default is <b>FlexJet (software)</b> .
<b>Select Port</b>	Choose the computer communication port connected to the FlexJet. <b>COM1</b> is the default.

## Setup Window: System Control

<b>Delete Source File</b>	Remove the original plot file from the <b>Import Marker</b> folder after loading and converting the file in the queue folder. This option is default <b>OFF</b> .
<b>Empty Converted File Archive</b>	When files are converted by <b>FlexPlot</b> , an archive copy of the output <b>PLX</b> file is stored in <i>C:\Ioline\Converted\</i> . Pressing this button will delete all the copies from this folder. Press the <b>Show Archive Size</b> button before deleting the files to see how much space the files use.
<b>In Preview, ...</b>	When checked, text labels in markers are displayed in the <b>Preview Window</b> . While useful, slower computers may take a long time to show this information. The default is <b>OFF</b> .
<b>Max Plotter Width 86-in</b>	Increase maximum <b>Y</b> panel width from 72-in to 86-in (for 2.2m eX models). This option is default <b>OFF</b> .
<b>Overwrite Files...</b>	When checked, the <b>FlexPlot</b> will automatically overwrite duplicate files in the <i>C:\Ioline\Converted\</i> folder without asking the user. This feature is default <b>ON</b> .
<b>Save a Copy...</b>	When checked, a copy every marker file converted by <b>FlexPlot</b> is stored in <i>C:\Ioline\Converted\</i> . This is useful as an archive of past jobs. The folder size can get very large. Use the <b>Show Archive Size</b> and <b>Empty Converted</b> buttons to manage the <i>Converted</i> archive. This option is default <b>ON</b> .
<b>Show Archive Size</b>	When files are converted by <b>FlexPlot</b> , an archive copy of the output <b>.PLX</b> file is stored in <i>C:\Ioline\Converted\</i> . Pressing this button will show how much space the archive files are using. Press the <b>Empty Converted</b> button to delete the files.
<b>Show Total Inches...</b>	Displays the total inches printed on an inkjet (does not work on pen plotters). Make sure the printer is turned on and not in use before checking this value.
<b>Suppress Normal...</b>	Enabling this feature will hide the non-critical messages that <b>FlexPlot</b> displays. These are related to verification for overwriting files, sending files to the printer, etc. This feature is default <b>OFF</b> .
<b>Units</b>	Choose between inches or centimeters. The default setting is inches. The default is inches.



### Note

Some markers do not use label commands and show the labels as pure vectors. The *In Preview,...* setting will **NOT** affect labels of this type.

## Setup Window: *Import Options*

<b>DXF Scale Factor</b>	Some DXF files use non-typical scaling commands that FlexPlot cannot interpret. When that is encountered, use the scale factor box to make adjustments to correct the converted file size. This option is default <b>OFF</b> .
<b>DXF Use Dimen...</b>	Uses image boundary settings imported from the DXF file. These are usually much larger than the image and can cause problems. Occasionally they are required for images from some CAD programs or the image is clipped. This option is default <b>OFF</b> .
<b>Enable Rotation</b>	When checked, HPGL files that use the rotation command are properly printed. This option is default <b>ON</b> .
<b>Shift Origin</b>	Move marker data to positive space. This option is default <b>OFF</b> .

## Setup Window: *Advanced Options*

<b>Enable Automatic...</b>	Enables the <b>Automatic Queue</b> button on the main screen. This option is default <b>ON</b> .
<b>Reset Defaults</b>	Restores all default values to the <b>Setup</b> options.
<b>Save Plot Log file</b>	Saves a diagnostic log file into the C:\Ioline folder. Only required if requested by Ioline Customer Service. This option is default <b>OFF</b> .
<b>Send End_Queue...</b>	When checked, a file called <i>End_queue.plt</i> (stored in the C:\Ioline folder) is sent whenever a queue finishes the last file. The user may modify the file as desired. This feature is default <b>OFF</b> .
<b>Show Plot Progress...</b>	When checked, the progress bar is displayed during plotting. Requires up-to-date firmware and <i>only works in printers</i> . This option is default <b>ON</b> .



### Hint

The **Piece Plot Optimization** window uses whatever folder was selected in the main FlexPlot window as the source for files to optimize.

## Piece Plot Optimization Window

<b>Add to Piece Plot...</b>	Add highlighted files to the <b>Piece Plot File list</b> .
<b>Delete Piece Source...</b>	Deletes the source file after it is converted and added to the optimized list.
<b>Cancel</b>	Abandon conversion and exit the window.
<b>Clear Piece Plot...</b>	Remove all files from the list.
<b>Clear Selection</b>	Remove highlighted files from the list.
<b>Convert</b>	Convert files in the list to .PLX files and send file to <b>Marker Queue</b> .
<b>Select All</b>	Highlights all files in the <b>Import</b> folder.

## Setup Gerber™ Accumark™ 7.x for HPGL Export

Follow these steps to configure Gerber™ Accumark™ version 7 to create HPGL formatted files for use with the Ioline FlexPlot. It is also possible to plot direct from the Gerber Software to the FlexJet. Visit the Ioline Support website for more information.

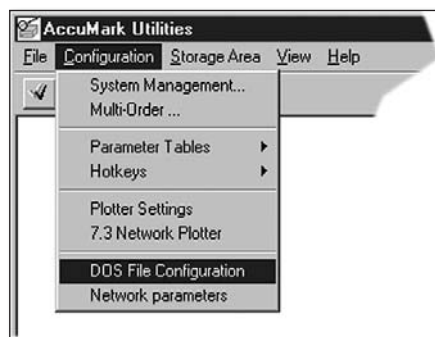


Figure 6. The Gerber™ Accumark™ Menu.

1. Double-click the program icon to start the Gerber™ Accumark™ Utilities.

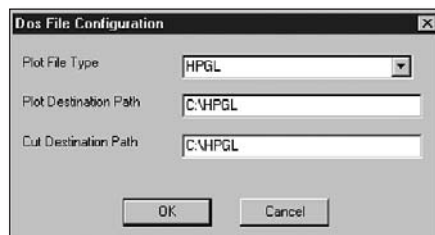


Figure 7. Accumark™ DOS Configuration.

2. Open the Configuration menu and select DOS File Configuration.
3. In the window choose HPGL as the plot file type. Enter a path for the Plot and Cut files.



### Hint

Use the folder **C:\HPGL** for the **Plot Destination Path** if you want to store the Gerber output files in the default input folder for the **FlexPlot**.

## Export HPGL Files From Gerber™ Accumark™

1. Start the Gerber™ System Management program by double clicking the program icon.

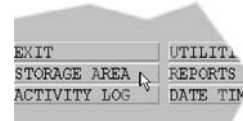


Figure 8. Accumark™ Storage Area.

2. Choose the **Storage Area** where the marker files are stored. Choose *Enter* when finished. (Figure 8.)

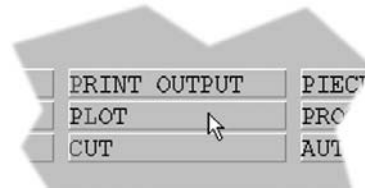


Figure 9. Accumark™ Plot Window.

3. Choose **Plot** to open the **Plot Window**. (Figure 9.)

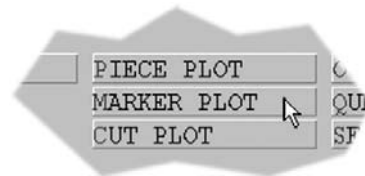


Figure 10. Accumark™ Marker Plot button.

4. Press the **Marker Plot** button to open the marker plot export utility. (Figure 10.)

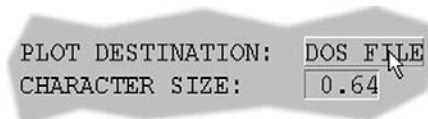


Figure 11. Accumark™ Plot Destination button.

5. Click on the **Plot Destination** button until it reads *DOS FILE*. (Figure 11.)

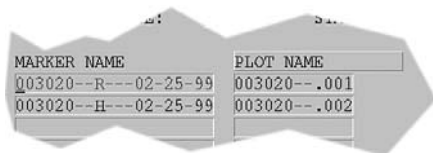


Figure 12. Accumark™ Marker Name Window.

6. Enter the plot file names in the **Marker Name Window**. Use the **F4** key to browse. (Figure 12.)



Figure 13. Accumark™ Process button.

7. After all of the plot file names are entered, click the **Process** button. The files are saved with the first eight characters of the marker name. They typically have numeric extensions like, *.000* or *.001*. (Figure 12 & 13.)
8. Exit the **System Manager** program by pressing **Exit** three times.

### Setup FlexPlot to find the files

1. Open **FlexPlot**.
2. Use the **Browse Window** to find the folder where **Accumark™** will store the files (chosen above). You may have to choose a new hard drive or mapped network location from the drive window before you can see the folder.
3. Once the folder is selected, use the normal methods of importing files. **AutoQueue** is also compatible with this method.

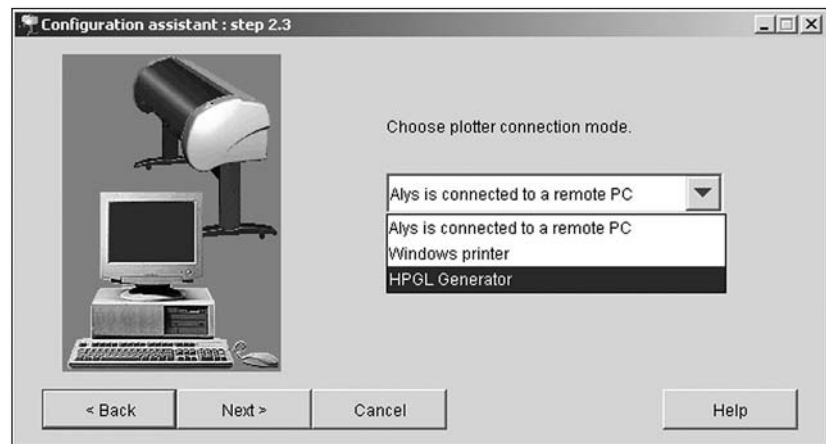
# Setup Lectra™ JustPrint™ for ASTM 6959 File Export

## Installation Option 1: Installing the JustPrint Software for the First Time (if required)

1. Install **JustPrint** and **IManager** as instructed in the documentation from the vendor.
2. When the installation is complete, a small box will appear labeled *Configuration Assistant Step 2.1*.
3. Follow the steps shown in *Install the First Printer* below.

### Install the First Printer

1. Choose the default language and unit system, pressing *Next* after making a selection.



**Figure 14.** Lectra™ connection mode.

2. When the **Configuration Assistant** reaches **Step 2**, Choose *HPGL Generator* from the list. (*Figure 14*).
3. Give the peripheral a name and place a check in the box next to *Yes* to make this the default. (*Figure 15*).
4. Click *Next* in the **Summary Window**. A **Configuration Recap Window** will appear. (*Figure 16*).
5. Choose a **Generation Directory** (the default location where marker files are stored by the program). You will setup **FlexPlot** to look in this location later. If the folder is located on a network, you may have to provide login information. Also remember to *uncheck* the *Vectorize the Character Font* box. (*Figure 17*).



#### Hint

Use the folder **C:\HPGL** for the **Plot Destination Path** if you want to store the ASTM6959 output files in the default input folder for the **FlexPlot**.



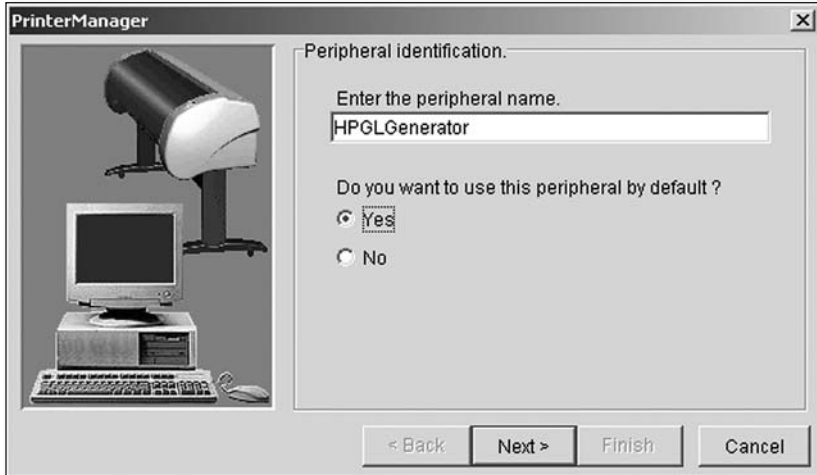


Figure 15. Assign a peripheral name.

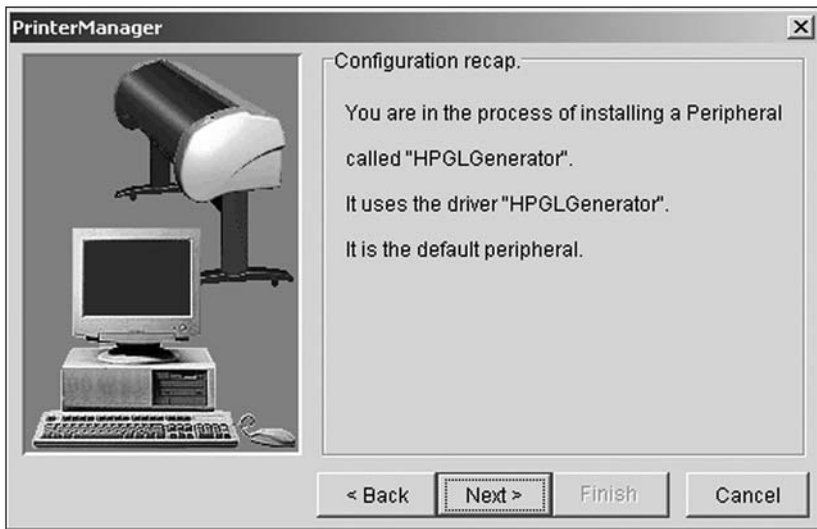


Figure 16. The system will confirm the peripheral name.

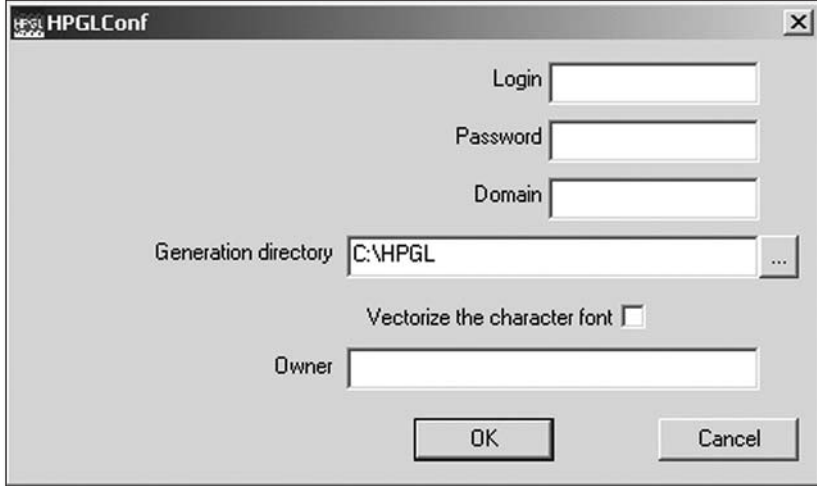


Figure 17. A Generation Directory where FlexPlot will find the files.

## Testing the Installation



**Figure 18.** The **Plot Test Window**.

1. Press the **Plot Test** button to ensure that the program can write a file to the chosen location. (*Figure 18*).



**Figure 19.** Accept settings if the test was successful. Otherwise, go back to make adjustments.

2. Press *Finish* if the test was a success. If there was a problem, return to the previous step to make any adjustments necessary.
3. Click *Next*, then *Finish*.
4. If there are no more peripherals to install, press *No*.
5. Installation is complete.

## Installation Option 2: Adding a Printer to an Existing JustPrint Installation

1. Open the folder *Start>Lectra>PlotterList V5xxxx*, where *xxxx* represents the version number.
2. Click on 'New Plotter'
3. Choose *HPGL Generator* from the list then press **Next**.
4. Give the Peripheral a name like "HPGL Printer" and place a check in the box next to *Yes* to make this the default. Click *Next*.
5. Click *Next* in the summary window.
6. Click *Next*.
7. Choose a **Generation Directory** which is the default location where marker files are stored by the program. You will setup **FlexPlot** to look in this location later. If the folder is located on a Network, you may have to provide log in information. Also remember to uncheck the *Vectorize the Character Font* box.
8. Click **Finish** to exit the program. Close the PlotterList application.

### Setup JustPrint (for options 1 and 2)

1. Open **JustPrint**.
2. Select **Tools>Activity Management**.
3. Click on *Create*.
4. Type a name into the **Activity** window, then choose the plotter name from the list that matches what was used in the steps above. Choose *Roll 180* in the **Paper Format** box. **Do not** check the *Plots in a File Window*. Click **Save**. Click **Close**. The changes will show up in the **Activity** window. Click **Close** again.

### Printing a File

1. Choose the **Activity** name from the drop down list.
2. Click **Add** and choose the markers that you wish to print. Press **Add to Batch**.
3. When all markers are added, click **Close**.
4. Click on the **Plot** button to generate HPGL files in the default folder chosen during setup.
5. Close **JustPrint**, open **FlexPlot**, choose the files from the folder and send them to the FlexJet.

Should you require any additional information concerning the installation procedure, please contact Lectra™ support.

# Setup PAD™ Plot Network™ for HPGL File Export

## Setup PAD System™ for HPGL Export

1. Open Pad System™ Plot Network

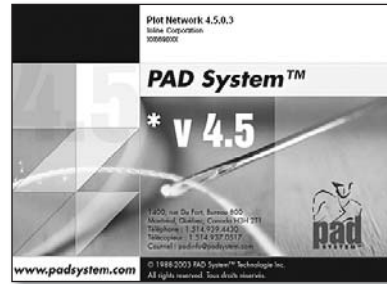


Figure 20. PAD™ System splash screen.

2. Select *File > Preferences > Plotter*

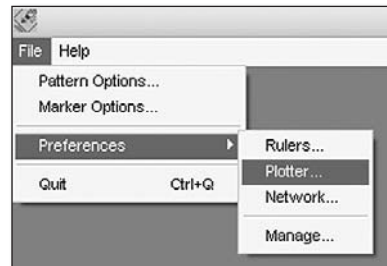


Figure 21. Pick **Plotter** from the File Menu.

3. In the plotter window select:
  - a. *Plotter: HPGL2*
  - b. *Plotter Port: File...*
  - b. Click **OK**.



Figure 22. Select a plotter and port.

4. When the *Plotting to a File* window comes up, choose a default location to store the files created by the program. You will setup **FlexPlot** to look in this location later. If the folder is located on a network, you may have to provide log in information. Click **OK** to close this window.



**Figure 23.** Choose a default file folder.

5. Back on the plotter window, under **Plotter Parameters**, make sure **METRIC** is selected. As for the rest of the settings:
  - a. **Paper Width:** Actual width of the paper installed on the plotter
  - b. **Frame Length:** Ioline recommends 35 inches.



**Figure 24.** Select the metric measurement system.



### Hint

For more information on the rest of the settings, please consult the user's guide provided by PAD Systems™.

## Setup FlexPlot to find the files

1. Open **FlexPlot**
2. Use the browse window to find the folder where PAD Systems™ will store the files (chosen above). You may have to choose a new hard drive or mapped network location from the drive window before you can see the folder.
3. Once the folder is selected, use the normal methods of importing files. **AutoQueue** is also compatible with this method.

# NOTES