

Color iQC Print Packaging Features Guide

Version 8.0 | July 2012

Color iQC and Color iControl | QC include features to assist in print / packaging workflows (for iQC print version, or when user settings have "Print Packaging Workflow" setting enabled). Many factors can influence the quality of a print job, and when a color is off the corrective action is not always apparent. Print Job Templates coupled with QC Sets bring together many important metrics, like dot gain, trapping, gray balance, and others, in to a common framework. QC Sets provide the press operator with the critical information needed to determine corrective actions and ensure a successful print run.

The basic steps to implement a procedural workflow for monitoring and controlling a print job are as follows:

1. Create a new e-Job

Col	or	iContro	- [QC Set Der	no [data	base=Plas	tics.mo	
e-Jo	b	Data	Application	<u>V</u> iew	<u>Spectro</u>	Acco	
Ľ	N	ew e-Jo	b		Ctrl+N	N A	
-	New e-Job from Template Ctrl+T						

- 2. Within the new e-Job template create a Print Job Template to define the QC Set workflow (see below)
- 3. Measure or import the required standards in to the e-Job template
- 4. Appropriately name and save the e-Job template

Save <u>A</u> s	Ctrl+R
Save as Template	
Save Settings	

On initiating the print job workflow, the first step would be to create a new e-Job from the template created above:

6	Colo	or iContro	I - [QC Set Der	no [data	abase=Plas	tics.mo
	e-Joł	Data	Application	<u>V</u> iew	Spectro	Acco
-	Ĵ	New e-Jo	b		Ctrl+1	N A
	New e-Job from <u>T</u> emplate Ctrl+T					
	· Open Existing e-Job Ctrl+O					

The new e-Job will open with the appropriate Print Job Template settings defined and including the required standards. The next step is to initiate measurements using a QC Set. Select the "Measure QCSet..." option from the Data | Measure with Spectro... menu item:



The Read QC Sample Set dialog box will be displayed:

Read QC Sample Set	0000	a a l at l		
Design: GRACoL P2	WB			
Machine	QC Job:	QC S	et Te	st
QCSet Comment:				
GRACoL #2 Paper wb	P	rocess Color Tints (TVI) 25% 50% 7	Spot Color Tints (TVI)
Standards	Solid	35% 60% 8	15%	
K-2-wb-u-Reference	Í			
C-2-wb-u-Reference	ĺ			
M-2-wb-u-Reference				
Y-2-wb-u-Reference	-	Press <enter> to begin measureme</enter>	ents.	
R-2-wb-u-Reference	-			
G-2-wb-u-Reference	-			
B-2-wb-u-Reference	-			
GRACoL #2 wb HC	-			
GRACoL #2 wb HR	-			
GRACoL #2 wb SC				
	Solid DE	25% DotArea	50% DotArea	75% DotArea
Irend dLab Tags				
Selected Color				
Static				
Done	P	int Report View Report	<<< >>>	Cancel

After entry of the initial QC Set run information (Machine, QC Job, etc.), the software will prompt you sequentially for the required measurements as indicated by the blue arrow:

Read QC Sample Set	just Maps	(14)				
Design:	GRACoL P2 WE	3				
Machine	e Number 1	QC Job:	Print Job	QC Set 1	Test	
QCSet C	Comment:	Print job to monitor product	tion run			
GRACoL	#2 Paper wb		Process Color Tints (TVI) 25% 50%	75%	oot Color Tints (TVI)	
Standa	ards	Solid	35% 60%	85%		
K-2-wb	o-u-Reference					
C-2-wb	o-u-Reference					
M-2-wb	o-u-Reference					
Y-2-wb	o-u-Reference					
R-2-wb	o-u-Reference		(0.0) (0.0)	(0.0) CMYSp	read	
G-2-wb	o-u-Reference					
B-2-wb	o-u-Reference					
GRACo	oL #2 wb HC					
GRACo	oL #2 wb HR					
GRACo	oL #2 wb SC					
Trend dLab Tag	35 V 100		Ught dL* = 0.00 da* = 0.00 db = 0.00 dE = 0.00 Dens 0.000 %Densty= 0.00 Dans			
Done			Print Report View Re	oort	>>>	Cancel

The system will continue to prompt for measurements until all of the required measurements, as defined in the Print Job Template, have been completed: The fields Machine, QC Job, and QC Set are mandatory and will persist from run to run.

Read QC Sample Set		
Decises - GRACel B23	MØ	
Design: GRACOL P2	OC loh: Driet John OC Set 1 Tort	
Machine Number 1		
QCSet Comment:	Print job to monitor production run	
GRACoL #2 Paper wb	dE = 2.02 dL=-1.73 Process Color Tints (TVI) Spot Color Tints (TVI) 25% 50% 75% 75%	
Standards	Solid 35% 60% 85%	
K-2-wb-u-Reference	dE= 4.49 dns=1.43	
C-2-wb-u-Reference		
M-2-wb-u-Reference		
Y-2-wb-u-Reference		
R-2-wb-u-Reference	[0.0] (0.0] (0.0] CMYSpread	
G-2-wb-u-Reference		
B-2-wb-u-Reference		
GRACoL #2 wb HC		
GRACoL #2 wb HR		
GRACoL #2 wb SC		
Trend dLab Tags	1 K-2-wb-u-Reference_Solid 10 $4E^{-2}$ 4.41 Lighter $4E^{-2}$ 0.53 Redder $4E^{-2}$ 0.69 Yelower $4E^{-2}$ 4.41 Lighter $4E^{-2}$ 4.41 Lighter $4E^{-2}$ 0.53 Redder $4E^{-2}$ 0.69 Yelower $4E^{-2}$ 4.49 $4E^{-2}$ 4.49	
Done	Print Report <<<	Cancel



When all of the required measurements have been completed, the options to exit the Read QC Sample Set dialog box, <Done>, or read another QC Set, <Next QCSet>, will be enabled:

Design: GRACoL P2 V	WB	
Machine Number 1	QC Job: Print Job QC Set 1 Test	
QCSet Comment:	Print job to monitor production run	
GRACoL #2 Paper wb	dE= 2.02 dL=-1.73 Process Color Tints (TVI) Spot Color Tints (TVI) 25% 50% 75%	
Standards	Solid 35% 60% 85%	
K-2-wb-u-Reference	dE= 4.49 dns=1.43 17.5 23.0 16.0	
C-2-wb-u-Reference	dE= 3.19 dns=1.23 11.3 17.5 12.3	
M-2-wb-u-Reference	dE= 4.12 dns=1.18 12.4 18.2 13.5	
Y-2-wb-u-Reference	dE= 4.55 dns=0.94 12.6 17.5 13.1	
R-2-wb-u-Reference	dE= 3.73 %trp=73.5 (1.4) (0.7) (1.3) CMYSpread	
G-2-wb-u-Reference	dE= 8.84 %trp=85.8	
B-2-wb-u-Reference	dE= 4.94 %trp=69.7	
GRACoL #2 wb HC	dE = 1.85 $dL = 1.45$ $dF = 1.14$	
GRACoL #2 wb HR	dE= 2.08 dL=-1.20 dF= 1.70	
GRACoL #2 wb SC	dE= 1.85 dL=-1.43 dF= 1.18	
d dLab Tags	1_GRACoL #2 wb HR_Solid to the second secon	

Selecting <Done> will save all of the measurements to the active e-Job. A new data item corresponding to the complete QC Set run will be added to the QC Tree View under the QC Sets node.



Selecting to run measure another QC Set will display the Read QC Sample Set dialog box and automatically increment the QC Set number:

Design: GRACoL P2	WB				
Machine Number 1	QC	Job: Print Job	QC Set 2	Test	
QCSet Comment:					
GRACoL #2 Paper wb		Process Color Tints (25%	TVI) 50% 75%	Spot Color Tints (TVI)	
Standards	Solid	35%	60% 85%		
K-2-wb-u-Reference					
C-2-wb-u-Reference					
M-2-wb-u-Reference					
Y-2-wb-u-Reference		Press <enter> to</enter>	begin measurements.		
R-2-wb-u-Reference			-		
G-2-wb-u-Reference					
B-2-wb-u-Reference					
GRACoL #2 wb HC					
GRACoL #2 wb HR					
GRACoL #2 wb SC					
d dLab Tags	10 05 065 -05 -10 -10 -05 50 0.5 1.0	Light dL* = 0.00 as da* = 0.00 as db* = 0.00 as db* = 0.00 as db* = 0.00 as db* = 0.00 bs db* = 0.00	.00		
Done		Print Report	liow Roport		

Subsequent runs of the QC Set will add new items to the QC Set node within the QC Tree View.

Color iControl - QC Set Demo [database=Plastics.n	ndb]		-		_	_						- 0 ×
e-Job Data Application View Spectro Ac	count <u>W</u> indow <u>T</u> ools Mac <u>r</u> o <u>H</u> e	lp.										×
D B B M B B B) 🗛 🚣 🔊											
	: = = = = i 👝 👑 🔜				÷							
QC Set Demo [database=Plastics 🔀 siJob	QCSet [database=Plastics.mdb]											4 Þ 🗙
Select new standard		14		14		10	254	D	000 - T (100)			
	Inal Name	L.	a.	0.00	0.00	N°	DE.	UNS I ANSI	%Uns I ANSI			
- → □, 2+ +	1 K 2 wb u Reference Sold	20.40	-0.01	-0.02	0.02	237.00	1 4 Q	1.59	00.00			
	1 K-2-wb-u-Reference 25	74.85	0.11	-2.45	2.45	272 64	58.90	0.23	42.03			
<no standard=""></no>	1 K-2-wb-u-Reference 50	56.26	-0.01	-1.93	1.93	269.73	40.31	0.53	72.13			
Data Data	1 K-2-wb-u-Reference 75	38.05	0.01	-1.16	1.16	270.45	22.08	0.91	89.90			
🕀 🔘 K-2-wb-u-Reference 😣	C-2-wb-u-Reference	54.96	-37.00	-50.23	62.38	233.62	N/A	1.37	98.25			
🗄 🔤 🞯 C-2-wb-u-Reference 🕺	1_C-2-wb-u-Reference_Solid	55.84	-34.44	-48.54	59.52	234.65	3.19	1.23	98.32			
🗄 🔜 🞯 M-2-wb-u-Reference 🕺	1 C-2-wb-u-Reference 25	83.01	-7.65	-14 29	16.21	241.84	54 22	0.18	35.68			*
🗄 📒 🎯 Y-2-wb-u-Reference 🛛 😒	1											
🗄 📕 🎯 R-2-wb-u-Reference 🛛 🕺												
🗄 📕 🎯 G-2-wb-u-Reference 🛛 😒												
🗄 🔜 🎯 B-2-wb-u-Reference 🛛 🕺												
🗄 🔲 🎯 GRACoL #2 wb HC 🛛 😣												
🕀 🔜 🎯 GRACoL #2 wb HR 🔗												
🗄 📕 🎯 GRACoL #2 wb SC 🛛 😣												
C Sets												
Print Job-1												
Print Job-2												
Print Job- 3												
Print Job- 4												
Print Job- 5												
C. El Substrates												
C GRACel #2 Paper wh	dCl	EL ab: D50.02						CIELat	5 D50.02			
	81.7 Yellow	2200.000 02	81.7 Light		00.00							Light
Calcolate	(%) ±		65.3					┢┓┷╹				**
Colorants			*	1.2								
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	-327		-32.7	9	0.00		· • • •	•••				* * *
	-49.0 🗸		-49.0 -		00.00						•	Blue
	-653 +		-65.3									
	-81.7		-\$1.7									
	-73.5 -49.0 -24.5 80	24.5 49.0 73.5	Uark	•								F K F
For Help, press F1						DERCENT	1.1		0/10/34	D50-02	0-Default (EXP)	NO alore

Print Job Template

The parameters that determine the operation of the Read QC Set Sample procedure are defined in the Print Job Template dialog box. The Print Job Template dialog box is accessed from the main Settings dialog box.



Match Jo	o Settings					
J	ob Options		Autoname		IFS Colora	ant Collection
System	eSubmit	Tag Format	General	QC	QC Printing	Print Job Template

These settings are stored within an eJob or settings / template file (depending on your e-Job options) and define a workflow for the QCSet read procedure for measuring and controlling multi-color designs in the print / package industry.

Job Options			Autoname	•	IFS Colorant	IFS Colorant Collection	
System	eSubmit	Tag Format	General	QC	QC Printing	Print Job Templa	
Template Na	ame GRACol	P2 WB	P G7	•	Save to Shared Folder	Clear	
Substra	ate GRACoL	#2 Paper v 👻	Comr	ment			
		DE tolerance		Densit	y tolerance	dSpread tol	
Solids	Substrate	Process	Spot Color	Process Color	Spot Color	Tints	
4 •	3.0	5.0		2	2	3	
Process Colo	r Tints			Spot Color Tints			
3 🔻	% Tint 25	50	75	0 -	% Tint		
Target	Dot Area 35	60	85	Target [Dot Area		
OverPrints							
3 🔻	Name	R-2-wb-u-R	eference 👻	G-2-wb-u-Refere	nce 👻 B-2-wb-	u-Reference 👻	
DE tol	Ink 1	[3]M-2-wb-u	-Referen 🔻	[2]C-2-wb-u-Refe	eren -	wb-u-Referen 🔻	
6.0	Ink 2	[4]Y-2-wb-u	-Referen: 🔻	[4]Y-2-wb-u-Refe	eren 🔻	-wb-u-Referen 🔻	
Gray Balance	9						
3 👻	Name	GRACoL #	2 wb HC 👻	GRACoL #2 wb	HR - GRACol	L#2 wb SC 👻	
DE tal	Tint	% 25		50	75		
3.0	lnk 1	[2]C-2-wb-u	-Referen: 🔻	[2]C-2-wb-u-Refe	ren 🔻	vb-u-Referen 🔻	
	lnk 2	[3]M-2-wb-u	-Referen 🔻	[3]M-2-wb-u-Refe	eren 🔻 [3]M-2-	wb-u-Referen 🔻	
	Ink 3	[4]Y-2-wb-u	-Referen: 🔻	[4]Y-2-wb-u-Refe	ren: •	wb-u-Referen 🔻	

These settings are stored within an eJob or settings / template file (depending on your e-Job options) and define a workflow for the QCSet read procedure for measuring and controlling multi-color designs in the print / package industry:

Template Name	Print Job Templates can be stored as named objects (*.NGHdesign) files so that they can be used across multiple e-Jobs and templates.
Substrate	The substrate, or paper type, associated with print job template. Substrates are measured in to the system from the Date Measure with Spectro Measure Substrate menu option.
Comment template.	Test field for adding descriptive information about the design
Solids	Drop down control to set the number of Solid colors used in the design template. Available settings are Auto or 0 to 10. The Auto option will set the number of solids based on the total number of Standards identified as Solid and Process colors in the associated e-Job. The maximum number is 10. <i>Please note that Standards can be identified as a Solid or</i> <i>Process color under the Name tab on the Standard Properties</i> <i>dialog box (shown below).</i>

-						
tion Spectral Data	Image Recipe/Fo	mula Editor St	ored Tolerances	Tolerances Used		
wb-u-Reference				perator ID: TWM hique ID: 0EL2D0al reated: 2/14/2012	1360871ff [0] 11:24:09 AM	
		Data Type Standard	PERCEN • 0.00000	T Substrate Fa	actor SWL for Stree	ngth
	User D)efined Group De	esignation		Color Type	Density
	Group	1:			Process	
	Group	2:			Spot	
	Group	3:			Process Overprint GrayBalance	-
			Visual Comment			*
	Data		Using		Data	*
ier			Job Send	er		
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DE Tolerance Numeric edit fields allowing you to enter DE pass / fail tolerances for the Substrate, Process, and Spot Colors.

Density Tolerance

Numeric edit fields allowing you to enter density pass / fail tolerances for the Process and Spot Colors.

The next entry field will vary based on the particular workflow selected: Simple, PSO, G7, etc.

J	ob Optio	ns		Aut	toname		IFS Colo	rant Collection
System	eSi	ubmit	Tag Format	0	General	QC	QC Printing	Print Job Template
Sub	strate	GRACol	#2 Paper v 👻		General C Simple			
			DE tolerance		G7 PSO		ity tolerance	DotArea tol
Solids	S	ubstrate	Process	Spot Co	lor Undefined	8	Spot Color	Tints

dSpread Tol Tints

Numeric edit fields to enter the tolerance for tone value increase between cyan, magenta, and yellow in a G7 workflow.

dTVI Tol Tints	Numeric edit fields to enter the tolerance for tone value increase in a PSO workflow.	
Dot Area Tol Tint	S Numeric edit fields to enter the dot area tolerance limits in the General and Simple workflows.	
Process Color Tints	Grouping of entries to define the number of Process Colors (0 to 3) and their associated Tint percentages and Target Dot Area values.	
Spot Color Tints	Grouping of entries to define the number of Spot Colors (0 3) and their associated Tint percentages and Target Dot Ar values.	
OverPrints	Grouping of entries to define the number (0 to 3), targets, and tolerance for controlling OverPrints. OverPrints are defined by the Standard and the two inks used.	

3 🗸	Name	R-2-wb-u-Reference -	G-2-wb-u-Reference 💌	B-2-wb-u-Reference 👻
DE tol	lnk 1	[3]M-2-wb-u-Referen 🔻	[2]C-2-wb-u-Referen 💌	[2]C-2-wb-u-Referen 💌
6.0	lnk 2	[4]Y-2-wb-u-Referen	[4]Y-2-wb-u-Referen	[3]M-2-wb-u-Referen 💌

Gray Balance

Grouping of entries to define the number (0 to 3), targets, and tolerance for controlling Gray Balance. Gray Balance is defined by the Standard, the tint percentage, and the three inks used.

	Name	GRACoL #2 wb HC 👻	GRACoL #2 wb HR 👻	GRACoL #2 wb SC 👻
3 🔻	Tint %	25	50	75
DE tol	lnk 1	[2]C-2-wb-u-Referen V	[2]C-2-wb-u-Referen 🔻	[2]C-2-wb-u-Referen 💌
	Ink 2	[3]M-2-wb-u-Referen 💌	[3]M-2-wb-u-Referen 💌	[3]M-2-wb-u-Referen 💌
	Ink 3	[4]Y-2-wb-u-Reference	[4]Y-2-wb-u-Reference	[4]Y-2-wb-u-Referen ▼

Read QCSets

A QCSet Read dialog uses a Print Job Template (described above) to automatically step the user through measurement of a multi-colored print design (with solids, tints, process colors, spot colors, Overprints, and Gray balance patches), and reports on the QCSet as a complete quality control test.

Read QC Sample Set	50 C	
Design: GRACoL P2 W	8	
Machine Number 1	QC Job: Print Job QC Set 1 Test	
QCSet Comment:	Print job to monitor production run	
GRACoL #2 Paper wb	dE= 2.02 dL=-1.73 Process Color Tints (TVI) Spot Color Tints (TVI) 25% 50% 75%	
Standards	Solid 35% 60% 85%	
K-2-wb-u-Reference	dE= 4.49 dns=1.43 17.5 23.0 16.0	
C-2-wb-u-Reference	dE= 3.19 dns=1.23 11.3 17.5 12.3	
M-2-wb-u-Reference	dE= 4.12 dns=1.18 12.4 18.2 13.5	
Y-2-wb-u-Reference	dE= 4.55 dns=0.94 12.6 17.5 13.1	
R-2-wb-u-Reference	dE= 3.73 %trp=73.5 [1.4] [0.7] [1.3] CMYSpread	
G-2-wb-u-Reference	dE= 8.84 %trp=85.8	
B-2-wb-u-Reference	dE= 4.94 %trp=69.7	
GRACoL #2 wb HC	dE= 1.85 dL=-1.45 dF= 1.14	
GRACoL #2 wb HR	dE= 2.08 dL=-1.20 dF= 1.70	
GRACoL #2 wb SC	dE= 1.85 dL=-1.43 dF= 1.18	
Trend dLab Tags	1_GRACoL #2 wb HR_Solid 1_{0}^{2} $1_{$	
Done Next QC	Print Report View Report >>>	Cancel

Design	The name of the Print Job Template used within the QCSet procedure.
Machine	Mandatory edit field allowing you to enter a press number or description.
QC Job	Mandatory edit field allowing you to enter the name for this instance of the QCSet. Subsequent runs of this QCSet will persist this name.
QC Set	Numeric edit field to identify a print run. This value will be automatically incremented in subsequent runs of this QCSet.
QCSet Comment	Edit field to allow information pertinent to the QCSet to be entered.

The middle portion of the Read QCSet dialog will vary based on the number and type of elements in the design: solids, tints, process colors, spot colors, Overprints, and Gray balance patches.

10 Targets: 4 Solids, 3 OverPrints, and 3 Gray Balance

GRACoL #2 Paper wb	dE= 2.02 dL=-1.73	Process Color	Tints (TVI)		Spot Color Tints (TVI)
		25%	50%	75%	
Standards	Solid	35%	60%	85%	
K-2-wb-u-Reference	dE= 4.49 dns=1.43	17.0	22.1	14.9	
C-2-wb-u-Reference	dE= 3.19 dns=1.23	10.7	16.3	10.8	
M-2-wb-u-Reference	dE= 4.12 dns=1.18	11.9	17.2	12.2	
Y-2-wb-u-Reference	dE= 4.55 dns=0.94	12.3	16.9	12.3	
R-2-wb-u-Reference	dE= 3.73 %trp=73.5	(1.6)	(0.8)	[1.5]	CMYSpread
G-2-wb-u-Reference	dE= 8.84 %trp=85.8				
B-2-wb-u-Reference	dE= 4.94 %trp=69.7				
GRACoL #2 wb HC	dE= 1.85 dL=-1.45 d	F= 1.14			
GRACoL #2 wb HR	dE= 2.08 dL=-1.20 d	F= 1.70			
GRACoL #2 wb SC	dE= 1.85 dL=-1.43 d	F= 1.18			

5 Targets:

	dF= 9 31 dI = 9 25	Process Color Tints	Spot Color Tints
Paper		75% 25% 30%	75%
Standards	Solid	60% 40% 50%	60%
Cyan	dE= 0.23 dns=1.54		88.9%
Magenta	dE= 3.26 dns=1.42		93.6%
Yellow	dE= 5.24 dns=1.25		90.2%
Black	dE= 2.56 dns=1.40		86.2%
B1720	dE= 9.95 dns=1.02		92.1%

The lower portion of the Read QCSet dialog provides options to display a trend plot (showing the progression of information across multiple runs of the QCSet), a delta Lab plot, or the tag information associated to each measurement.



The up and down arrow controls allow you to cycle through the various color targets contained with the QCSet.

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The remaining controls within the Read QCSet dialog box include:

Done	The <done> control becomes active on completion of the QCSet and closes the QC set view.</done>
Next QCSet	The <next qcset=""> control becomes active after completion of a QCSet run to allow you to increment to the next instance of this QCSet.</next>
Export CxF	Exports the contents of the QCSet to a CxF3 file. Please note that this option is only available if a QC Set is re-opened, otherwise the CxF file is exported automatically.
< >>>	If a QCSet has been run multiple times, these controls allow you to move between the different runs.
Cancel	Cancels and exits the Read QCSet dialog.

QC Set Score

There is an additional field in the lower left corner of the Read QCSet dialog box. This is the QCSet score.



The "score" is a measure of the "goodness" of the QCSet. It is based on a ranking from 0 (poor) to 100 (perfect). 50% of the score comes from the average DE of all of the solids, 25% of the score comes from the percentage of the number of failed solids (can be failed for DE or for density), and 25% of the score comes from the percentage of failed tints.