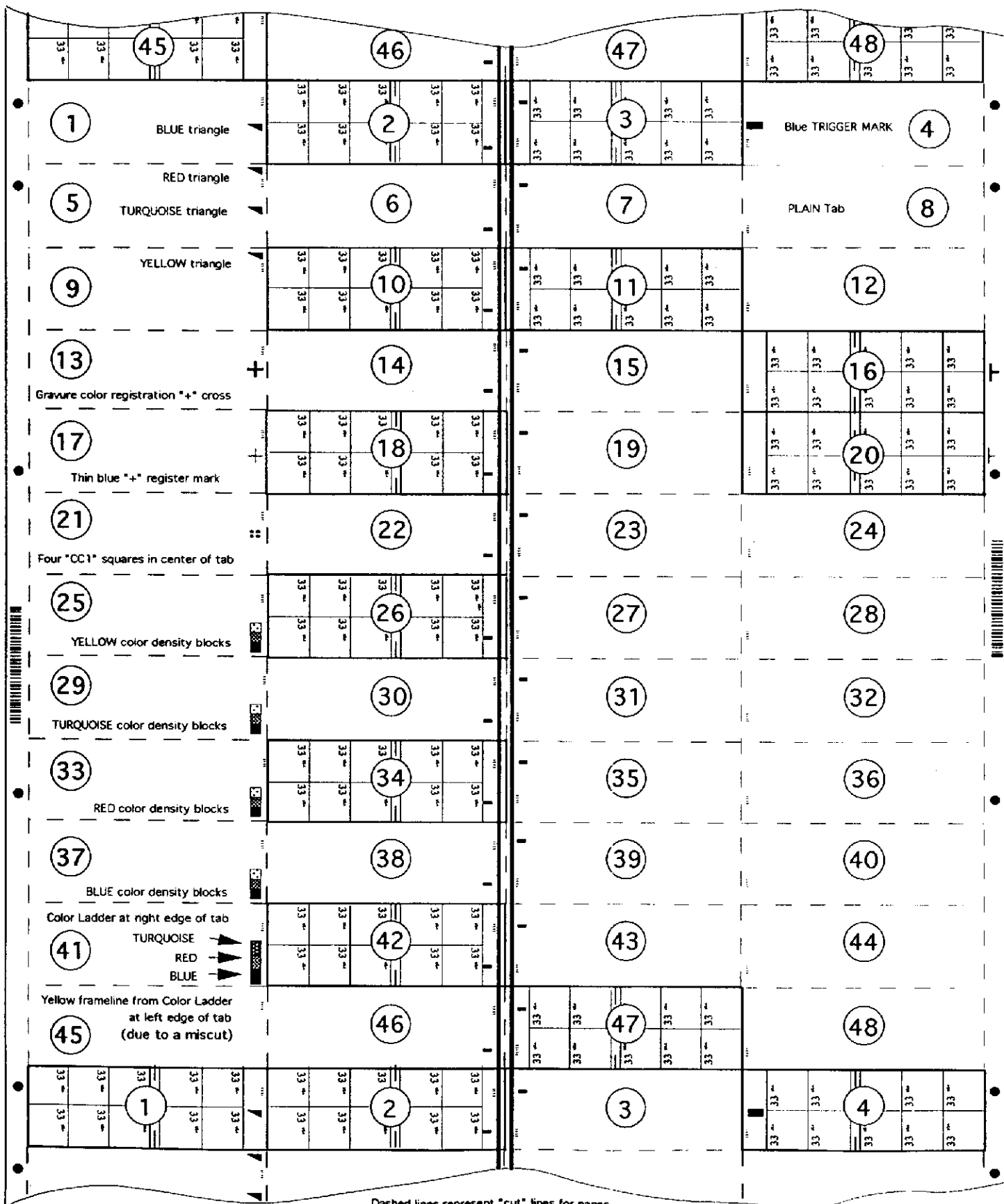


# \$6.60 SELF-STICK FLAG & CITY LAYOUT

This drawing represents a web segment printed from gravure cylinders for \$6.60 self-stick Flag & City 20-stamp booklets... this drawing has NOT been verified. Note that this drawing is similar to the revised layout for \$6.40 self-stick Flag over Porch booklet panes shown on page 43. The two half-register crosses printed in the right margin may or may not exist, but would only be found on miscut panes. Panes from the right half of the web are inverted in relation to panes from the left half. The location of the solid circles (Tie Points) is a guess - those marks are used by the BEP's electronic Stamp Inspection System and are intended to be trimmed off.

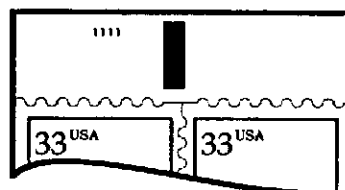


NOTE: The bar codes shown in the left and right margins (under panes 24 & 28, and 25 & 29) are applied to the printed web during the SIS inspection.

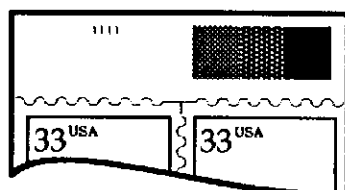
# \$6.60 Self-Stick Flag & City Booklets

(Bureau of Engraving & Printing)

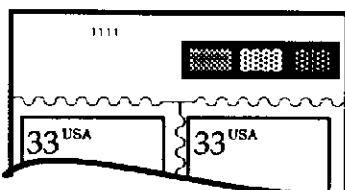
Position	Panes	Selvage Markings found on the BOTTOM pane	1111	1121
A	2 - 1	Dark Blue Triangle over right stamp		
B	6 - 5	Red and Turquoise (Light Blue) Triangles		
C	10 - 9	Yellow Triangle over left stamp		
D	14 - 13	Gravure 4-color Register "+" Mark in center of tab		
E	18 - 17	Thin Blue "+" Mark in center of tab		
F	22 - 21	CC1 squares in center of tab		
G	26 - 25	Yellow "color density blocks"		
H	30 - 29	Turquoise (Light Blue) "color density blocks"		
I	34 - 33	Red "color density blocks"		
J	38 - 37	Dark Blue "color density blocks"		
K	42 - 41	Turquoise, Red, & Blue Color Ladder above right stamp		
L	46 - 45	MISCUT - Yellow Frameline from Color Ladder at left		
M	3 - 4	Dark Blue Trigger Mark above UR corner of left stamp		
N	7 - 8	Plain (no marks in tab or at bottom of pane)		
P	15 - 16	Part of 4-color register mark @ bottom (due to miscut)		
Q	19 - 20	Part of thin blue register line @ bottom (due to miscut)		



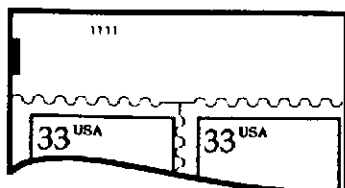
Position 4 - Blue Trigger Mark



Position 25, 29, 33, or 37 -  
Color Density Blocks



Position 41 - Color Ladder



Position 45 - Yellow Frameline of  
Color Ladder at left (MISCUT pane)

The Flag & City booklet pane layout is similar to the layout used for the revised \$6.40 self-stick Flag over Porch booklets found in early 1998 - the main difference being there are just four colors of ink rather than five. All register marks found in the tab (except the Trigger Mark, LRM, and CRL) are located in the left column of panes to accommodate the BEP's new inspection system. The layout drawing on page 48 shows the positions for the registration markings.

The BEP continues to use its new electronic Stamp Inspection System to insure the four ink colors printed in the stamp images are correctly aligned. The Trigger Mark found on the position 4 pane plus the eight solid dots ("Tie Points") found in the left and right margins are printed with the same cylinder as the dark blue LRM and CRL markings that are found in the tabs of the two center columns of booklet panes. The SIS is still being used as an off-line system to inspect printed rolls prior to their being converted into booklets.

As the printed web passes in front of a high resolution digital camera, the register mark on the position 4 pane triggers a photo-electric eye. This in turn, tells the camera to take a picture of the web when a strobe light is activated. Then, using the "Tie Points", the image is compared to a previously established reference image using the Print Inspection (PIN) System. The PIN determines if the web is in or out of sync or if there are unacceptable defects in the work and then sends a digital map to a computer. The computer reads the map and graphically shows the operator which rows were rejected. The digital map is then sent to an ink jet printer which waits until it receives a signal from the computer before printing the map (in bar code form) in the left and right margins. Once the bar code has been printed, it passes by a bar code scanner to verify the ink jet printer printed the correct map and that it is readable. After reading the bar code map, the scanner sends it back to the computer so it can verify the two maps are the same, and then the whole process repeats.

Position 16 and 20 panes (position P and Q books) are unreported, and may not exist (they would require a severe miscut). However, such miscuts are a distinct possibility; the Stamp Inspection System only looks for defects in the printed stamp images, prior to diecutting. In the past, the BEP has produced booklets with panes miscut to the bottom, so we need to look for these two marks. While it has been confirmed that those two register marks existed on the revised \$6.40 Flag over Porch booklet layout, we are not positive they exist on the \$6.60 Flag & City booklet layout... but there is no reason to believe they don't.

Position 45 panes (position L books) have been reported in books with plate 1111 panes. To find them requires a slight miscut to the left for the edge of the yellow frameline to show.