



Printing Configuration

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1 Printer Preparations

It is possible to print the Seco labels with printers from other brands than Intermec, but since these are the printer we use internally we support the installation and use of Intermec printers. This means that installation and use of other printers must be handled without help from Seco Tools.

If you are using Intermec see this section to pick the appropriate model and latest driver, and the next section to set up the printer driver.

1.1 Printer selection

Label	Printer
Seco	Intermec EasyCoder PM4i, PX4i, PM43, PM43c
Secolor	Intermec EasyCoder PM4i, PX4i, PM43, PM43c
SecoMill	Intermec EasyCoder PM4i, PX4i, PM43, PM43c
Tool	Intermec EasyCoder PM4i, PX4i, PM43, PM43c
Drill	Intermec EasyCoder PM4i, PX4i, PM43, PM43c
Snap-off(W)	Intermec EasyCoder PX6i
Jabro	Intermec EasyCoder PM4i, PX4i, PM43, PM43c
Wraparound	Intermec EasyCoder PX6i
Cuttingdata 6x3	Intermec EasyCoder PM4i, PX4i, PM43, PM43c
Hoffman	Intermec EasyCoder PM4i, PX4i, PM43, PM43c
Wise Colli ID	Intermec EasyCoder PM4i, PX4i, PM43, PM43c
Seco Tap Single	Intermec EasyCoder PX6i
Seco Tap 5-pack	Intermec EasyCoder PM4i, PX4i, PM43, PM43c
Feedmax Universal	Intermec EasyCoder PM4i, PX4i, PM43, PM43c
Niagara Label	Intermec EasyCoder PM4i, PX4i, PM43, PM43c
Drill Small	Intermec EasyCoder PM4i, PX4i, PM43, PM43c
Tool Small	Intermec EasyCoder PM4i, PX4i, PM43, PM43c
Tool Large	Intermec EasyCoder PM4i, PX4i, PM43, PM43c
Jabro	Intermec EasyCoder PM4i, PX4i, PM43, PM43c
Free Text	Intermec EasyCoder PM4i, PX4i, PM43, PM43c

1.2 Printer Specifications

If a new printer needs to be bought, make sure it has the following specifications:

- Resolution: 300 dpi

More Printer information:

PX4i & PX6i: <https://www.honeywellaidc.com/-/media/en/files-public/technical-publications/printers/px6i-px4i/px4i%20and%20px6i%20high%20performance%20printer%20users%20manual%20pdf.pdf>

PM43 & PM43c: <https://www.honeywellaidc.com/-/media/en/files-public/technical-publications/printers/pm43-pm23/935-046.pdf>

1.3 Driver

Download the latest driver.

Driver:

Go to <https://hsmftp.honeywell.com/>

Latest driver package is found at:Software>Printers>Printer Software and Drivers>Printer Drivers>Intermec Windows driver

Run the downloaded file to unpack the driver files.

Run the DriverWizard.exe file.

When installing, make sure you choose the correct printer, it should look like:

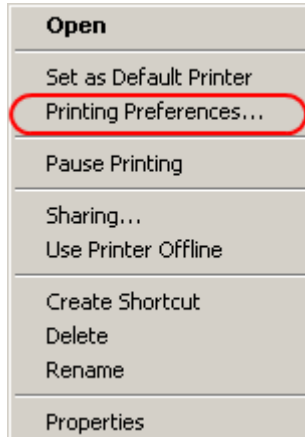
EasyCoder [printer model] (300 dpi) – DP

Ex: EasyCoder PX6i (300 dpi) – DP

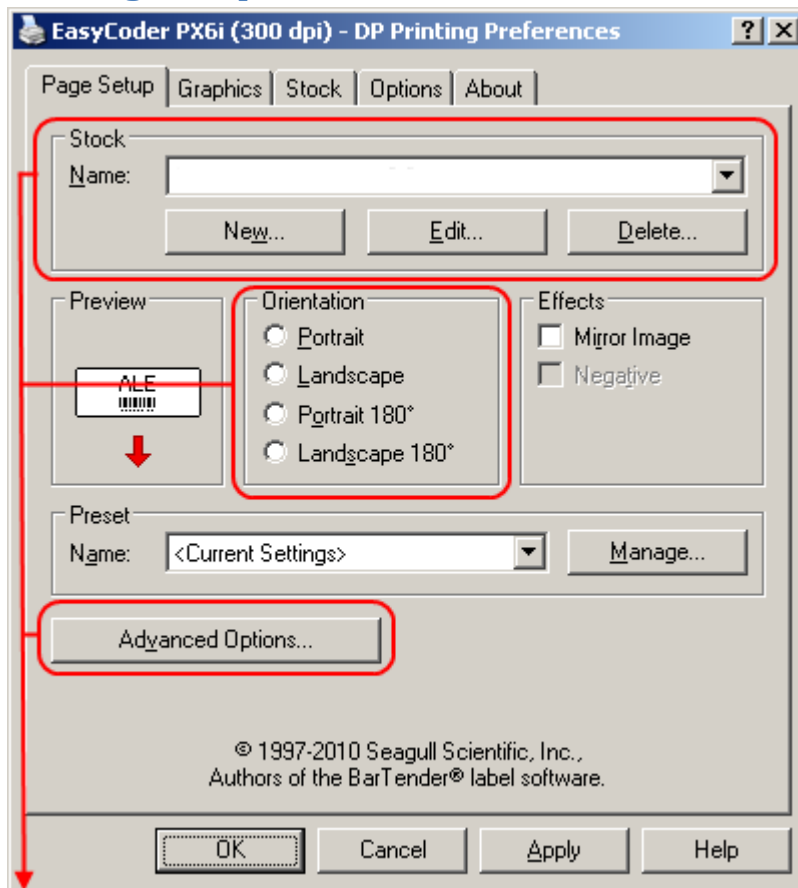
2 Printing Preferences

Go to Start->Settings->Printers and Faxes...

Right click on the printer and select "Printing Preferences..."



2.1 Page Setup



Set up according to tables below

2.1.1 Stock

Size of the label. Click “Create New” and set the width and height of the label used.

Label	MM		IN	
	Width	Height	Width	Height
Seco	72	29	2,83	1,14
Secolor	82	29	3,23	1,14
SecoMill	82	29	3,23	1,14
Tool	100	14	3,94	0,55
Drill	43	23	1,69	0,91
Snap-off(W)	143	88	5,63	3,46
Jabro	40	20	1,57	0,79
Wraparound	170	28	6,69	1,10
Cuttingdata 6x3	43	23	1,69	0,91
Hoffman	63	24	2,48	0,94
Wise Colli ID	110	162	4,33	6,38
Seco Tap Single	122	13	4,80	0,51
Seco Tap Small	78	54	3,07	2,13
Seco Tap Medium	94	76	3,70	2,99
Seco Tap Large	99	92	3,90	3,62
Feedmax Universal Single	19	68	2,68	0,75
Feedmax Universal Small	107	175	4,21	6,89
Feedmax Universal Medium	131	175	5,16	6,89
Feedmax Universal Large	161	175	6,34	6,89
Niagara Label	50	33	1,97	1,30
Drill Small	74	29	2,91	1,14
Tool Small	80	22	3,15	0,87
Tool Large	121	28	4,76	1,10
Jabro	40	20	1,57	0,79
Free Text	72	29	2,83	1,14

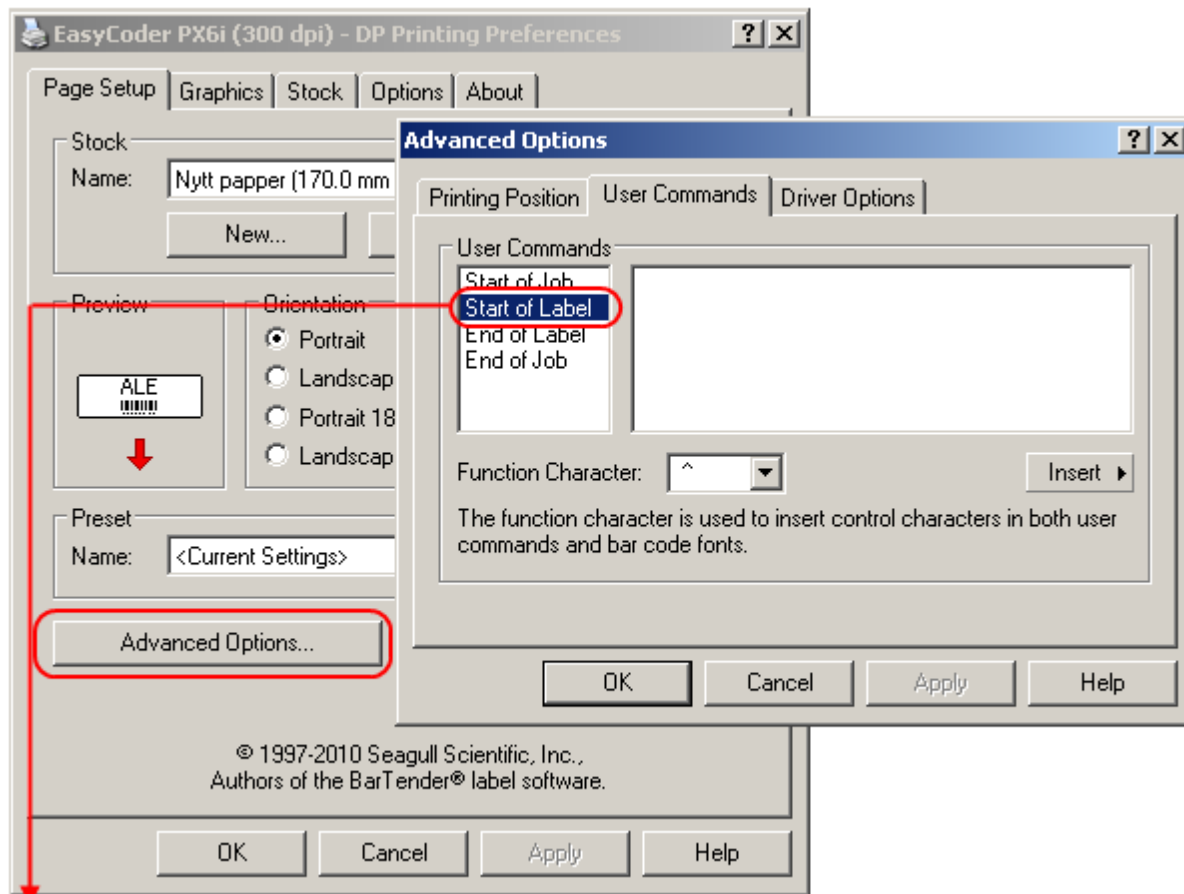
2.1.2 Orientation

Rotates the label printout.

Label	Orientation
Seco	Portrait
Secolor	Portrait
SecoMill	Portrait
Tool	Portrait
Drill	Portrait
Snap-off(W)	Landscape 180°
Jabro	Portrait
Wraparound	Portrait
Cuttingdata 6x3	Portrait
Hoffman	Portrait
Wise Colli ID	Portrait
Seco Tap	Portrait

Feedmax Universal	Portrait 180°
Niagara Label	Portrait
Drill Small	Landscape
Tool Small	Portrait
Tool Large	Portrait
Jabro	Portrait
Free Text	Portrait

2.1.3 Advanced Options



Set up according to table below

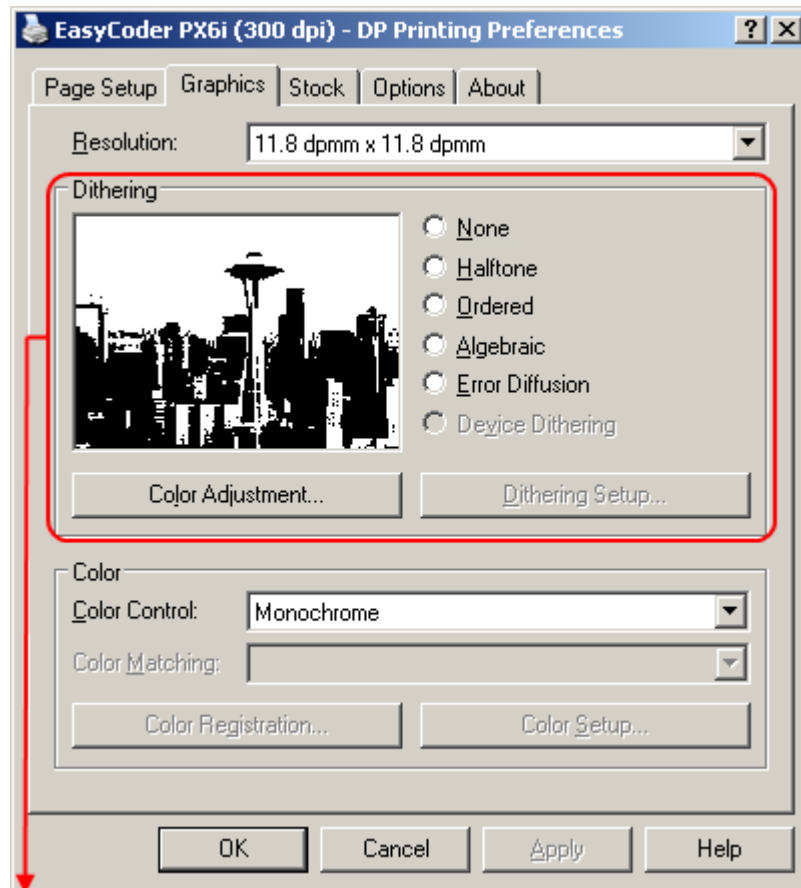
2.1.3.1 User Commands

Used for sending extra commands to the printer.

Example of usage can be to start a program in the printer or to adjust the position of the printout in the X direction (MEDIA, MEDIA SIZE, XSTART=20).

Label	Start of Label
Wraparound	SETUP WRITE"SECOSET.UP" RUN "LABEL.PRG"

2.2 Graphics

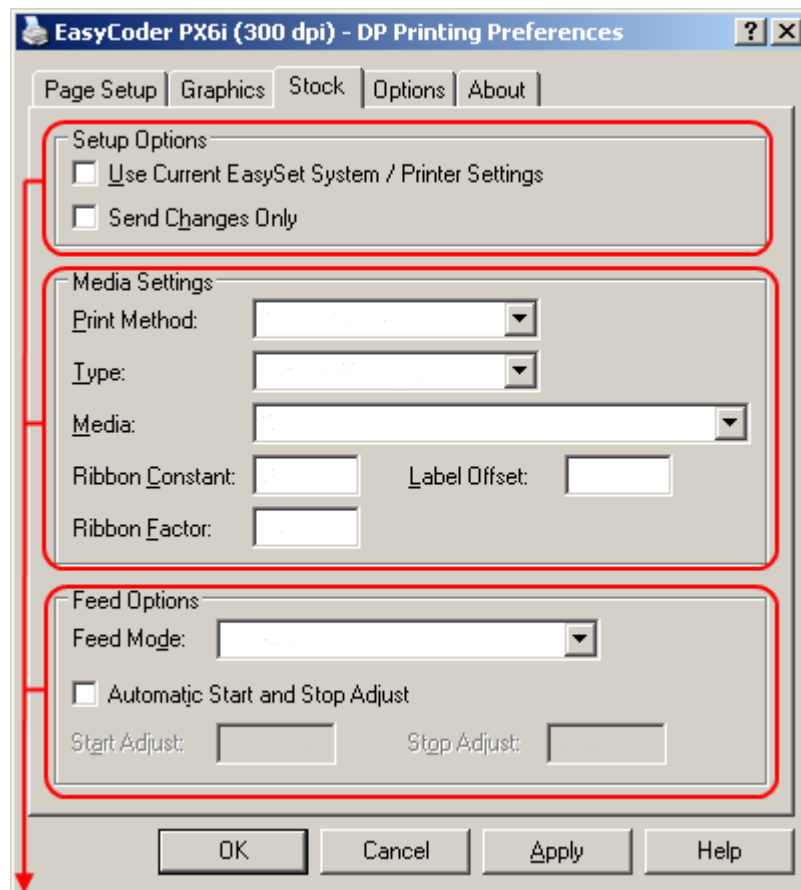


Set up according to table below

2.2.1 Dithering

Label	Dithering
All Labels	None

2.3 Stock



Set up according to tables below

2.3.1 Setup options

No matter what label is used, “Send changes only” should always be unchecked.

When unchecked, the driver will send all the settings to the printer every time a label is printed.

Label	Use current EasySet System / Printer Settings	Send changes only
All Labels	Unchecked	Unchecked

2.3.2 Media Settings

Thermal Transfer -> when black ribbon is used (default)

Direct Thermal -> when no black ribbon is used

Ribbon Constant & Factor = the amount of heat used when printing, high value = harder printout

Label	Print Method	Type	Ribbon Constant	Ribbon Factor
All Labels	Thermal Transfer	Label With Gaps	80	25

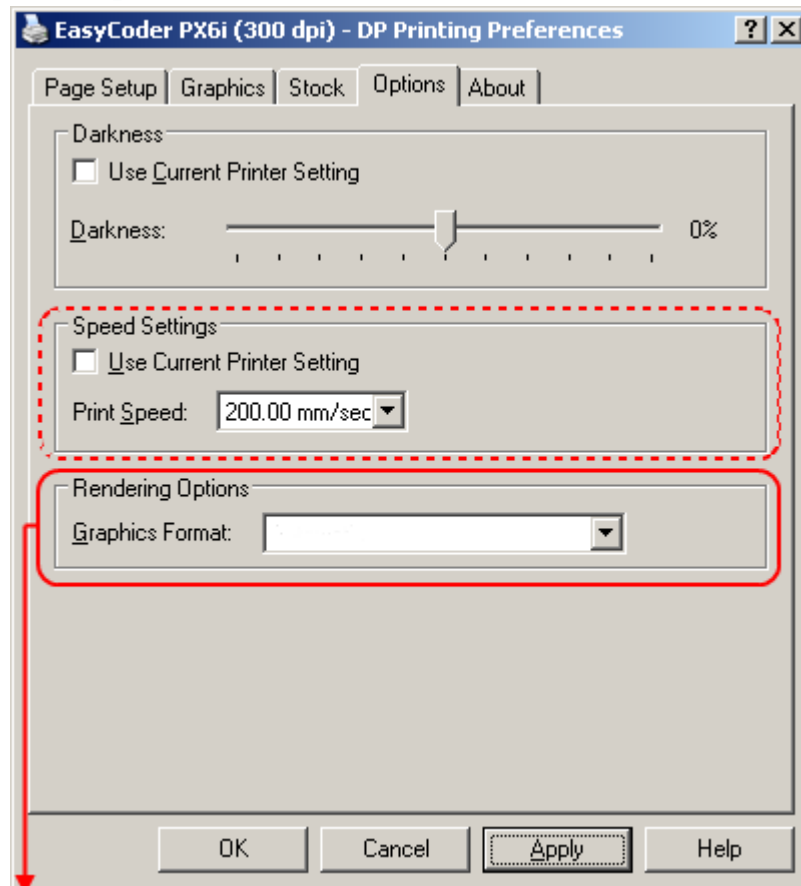
2.3.3 Feed options

Use automatic Start and Stop Adjust as default. If the label is shifted up or down, use manual values.

Note that Wraparound labels always need manual values.

Label	Feed Mode	Start Adjust	Stop Adjust
Wraparound	Tear Off	-26.5 mm	10.5 mm
All other Labels	Tear Off	Automatic	Automatic

2.4 Options



Set up according to table below

2.4.1 Speed Settings

Use default. If problem with printing quality, print speed can be lowered.

For example, if barcode is printed in “wrong” direction (ex. Snap-off) lower the print speed to get better quality.

2.4.2 Rendering Options

Graphics format = the way that the driver is sending images to the printer.

Label	Graphics format
Wraparound	PCX
All other Labels	Automatic

3 Printing

3.1 SecoMenu (RAPS)

SecoMenu is Seco Tools MES system. Label printing in SecoMenu is found in the subsystem RAPS.

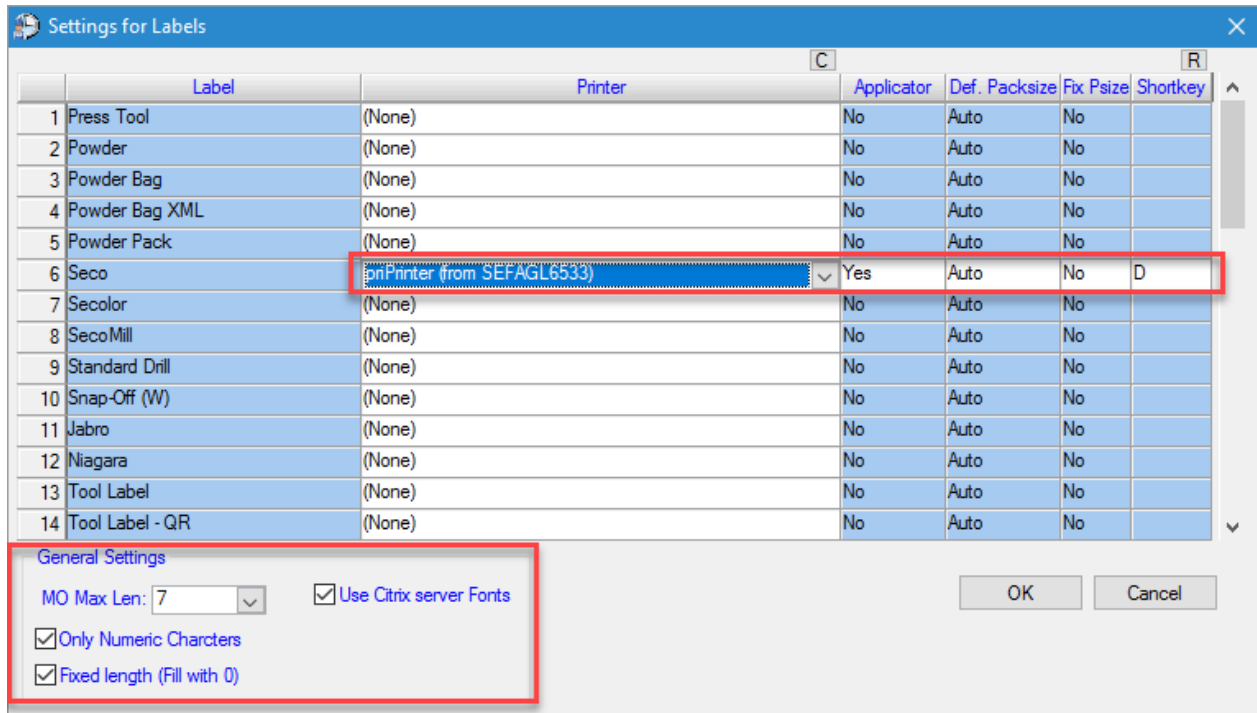
If you are using GLP (Global Label Printing) skip to section 3.2



In the Shop Floor Menu you can find the Option "E – Labels".



In the menu that opens, select option “S – Settings” to access label printing settings. If no label has been previously set, settings will automatically be opened.



To activate a label, assign a printer to it from the list of printers.

3.1.1 Applicator

If Applicator is set to “Yes” then that label will always only send 1 print copy of the label. By default set to “No”, meaning user specifies how many copy should be printed.

3.1.2 Default Packsize

Def. Packsize can be set to a value between 1-50 (or empty), if the printing window should always set the selected value for that label by default. This settings is by default set to “Auto”, meaning RAPS will automatically try to set the correct packsize.

3.1.3 Fixed Packsize

Fixed Packsize (Fix Psize) can be set to “Yes” if packsize in the printing window should be fixed and not possible to change. Default is “No”, meaning Packsize can be changed manually.

3.1.4 Shortcut

Shortcut set what shortcut selected label should have in the label menu.

3.1.5 General Settings

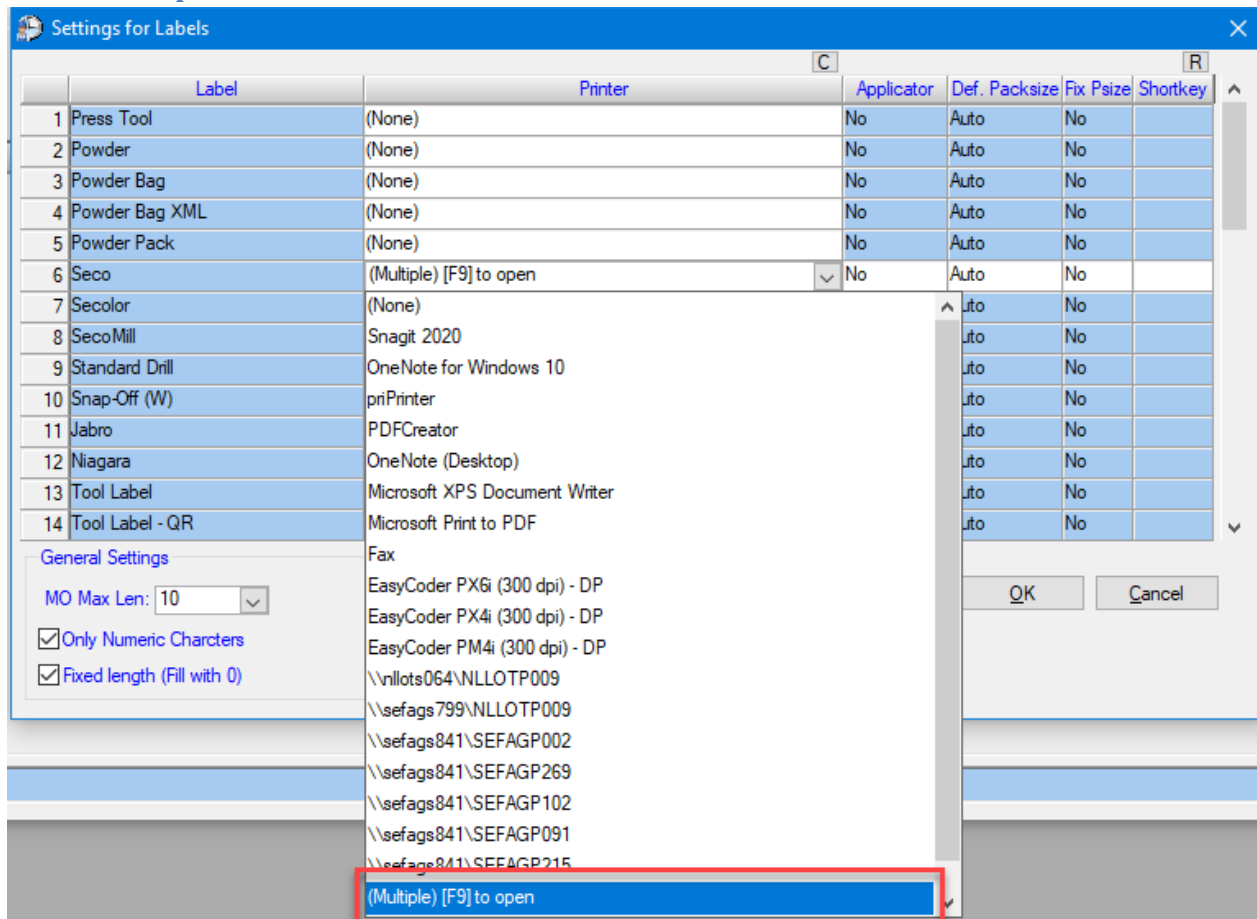
Mo Max Len: Sets the maximum length (no of characters) of the MO field (default is 7).

Only Numeric Characters: Checked means that only characters 0-9 are allowed in the MO field. It is checked by default.

Fixed length: Checked means that the MO field will be filled with zero (0) so the length is always as the maximum length set. It is checked by default.

Use Citrix server Fonts: If you are running RAPS via Citrix you need to check this checkbox, in order for Fonts to work properly.

3.1.6 Multiple Printers



	Label	Printer	Applicator	Def. Packsize	Fix Psize	Shortkey
1	Press Tool	(None)	No	Auto	No	
2	Powder	(None)	No	Auto	No	
3	Powder Bag	(None)	No	Auto	No	
4	Powder Bag XML	(None)	No	Auto	No	
5	Powder Pack	(None)	No	Auto	No	
6	Seco	(Multiple) [F9] to open	No	Auto	No	
7	Secolor	(None)		Auto	No	
8	SecoMill	Snagit 2020		Auto	No	
9	Standard Drill	OneNote for Windows 10		Auto	No	
10	Snap-Off (W)	pnPrinter		Auto	No	
11	Jabro	PDFCreator		Auto	No	
12	Niagara	OneNote (Desktop)		Auto	No	
13	Tool Label	Microsoft XPS Document Writer		Auto	No	
14	Tool Label - QR	Microsoft Print to PDF		Auto	No	

General Settings

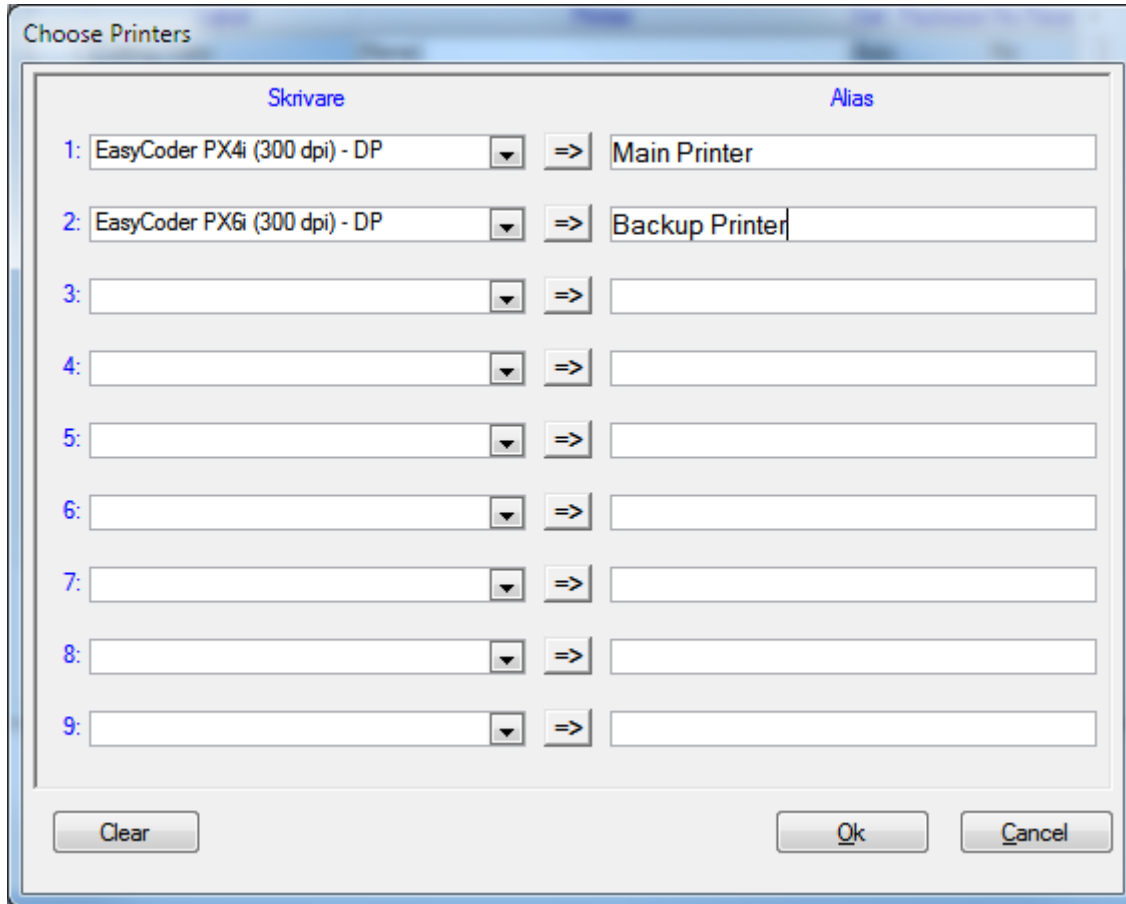
MO Max Len: 10

☒ Only Numeric Characters

☒ Fixed length (Fill with 0)

OK Cancel

If you have more than one printer dedicated for the same label, it is possible to register multiple printers for that label. In the printer list, scroll to the bottom and choose (Multiple).

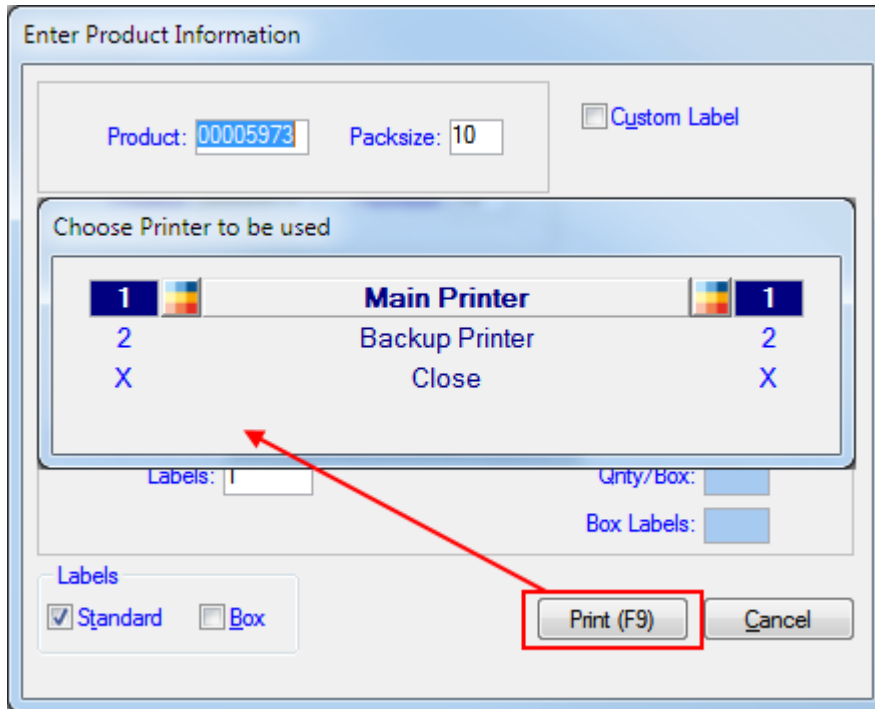


The "Choose Printers" dialog box is used to assign printers to different labels. It features a table with two columns: "Skrivare" (Printer) and "Alias". There are nine rows for assignment. The first row is pre-filled with "EasyCoder PX4i (300 dpi) - DP" and "Main Printer". The second row is pre-filled with "EasyCoder PX6i (300 dpi) - DP" and "Backup Printer". The remaining seven rows are empty. At the bottom, there are "Clear", "Ok", and "Cancel" buttons.

	Skrivare		Alias
1:	EasyCoder PX4i (300 dpi) - DP	=>	Main Printer
2:	EasyCoder PX6i (300 dpi) - DP	=>	Backup Printer
3:		=>	
4:		=>	
5:		=>	
6:		=>	
7:		=>	
8:		=>	
9:		=>	

Buttons: Clear, Ok, Cancel

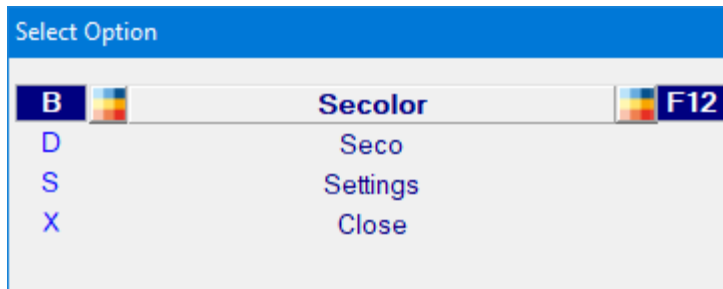
Then this new window opens, where you can choose up to nine different printers for the chosen label. You can also give the printer an Alias (optional) so that you more easily can separate the different printers.



When printing a label with multiple printers registered, you get to choose which of the printers you want to send the print to.

3.1.7 Printing Labels

After the settings are done, it is now possible to print the label(s). In the label menu you can now find the labels you have set up for printing.



Here you select which label to print by double-clicking on the row, or pressing the corresponding shortcut.

3.1.7.1 Standard labels

Label: Seco

MO/Product: Packsize:

☐ Custom Label

MO: Product: Edpno:

Description(Iso): Grade:

Description(Ansi):

Label Free Text: Qty:

Country Code: Manuf. Year: Week: ☐ Edit

Labels: Qty/Box:

Box Labels:

Labels

☐ Standard ☐ Box ☐ Diff. Qty

Print [F9]

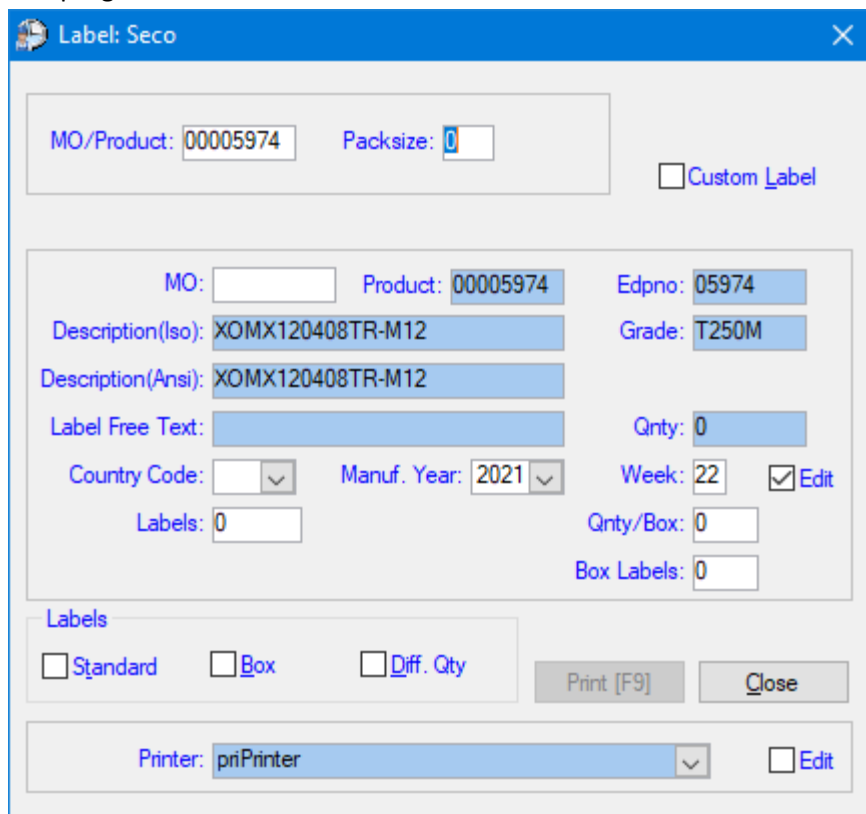
Close

Printer:

☐ Edit

Start by filling out the MO/Product number.

The program will fill in the correct information



The screenshot shows a software window titled "Label: Seco" with a close button (X) in the top right corner. The window contains several input fields and checkboxes for product labeling information.

At the top, there is a section with "MO/Product: 00005974" and "Packsize: 0". To the right of this section is a checkbox labeled "Custom Label".

Below this, there is a larger section with multiple fields:

- MO: (empty field)
- Product: 00005974
- Edpno: 05974
- Description(Iso): XOMX120408TR-M12
- Grade: T250M
- Description(Ansi): XOMX120408TR-M12
- Label Free Text: (empty field)
- Qty: 0
- Country Code: (dropdown menu)
- Manuf. Year: 2021 (dropdown menu)
- Week: 22
- ☒ Edit
- Labels: 0
- Qty/Box: 0
- Box Labels: 0

Below these fields, there is a section labeled "Labels" with three checkboxes: ☐ Standard, ☐ Box, and ☐ Diff. Qty. To the right of these checkboxes are two buttons: "Print [F9]" and "Close".

At the bottom, there is a section with "Printer: priPrinter" (dropdown menu) and an ☐ Edit button.

Type in the MO number and No of Labels.

Packsize, Country Code, Manuf. Year and Week if needed.

3.1.7.2 Box labels

Enter Product Information

Product: 00005974 Packsize: 10 ☐ Custom Label

MO: Product: 00005974 Edpno: 05974
Description(Iso): XOMX120408TR-M12 Grade: T250M
Description(Ansi): XOMX120408TR-M12
Label Free Text:
Country Code: Manuf. Year: 2021 Week: 22
Labels: Qty/Box: Box Labels:

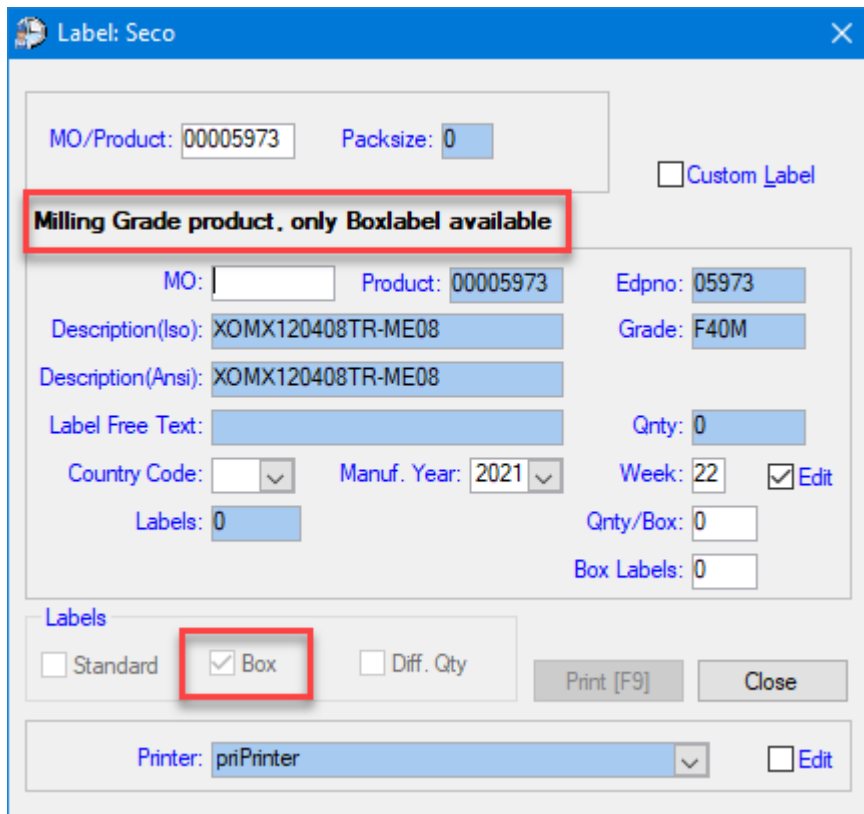
Labels
☐ Standard ☒ Box

Update(s) Available
Update Now... Print (F9) Cancel

For some labels there is also an option to print Box labels (same label with different layout).

If box labels are needed, check the “Box” checkbox, fill in the box quantity and the number of box labels to print.

3.1.7.2.1 Box labels Seco Standard

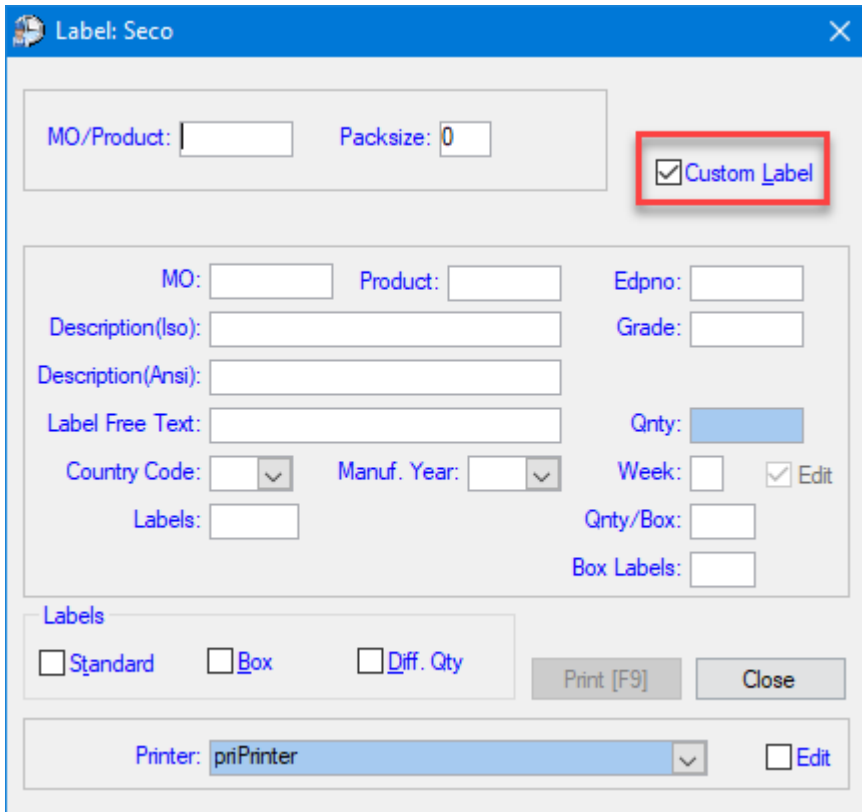


The screenshot shows a software window titled "Label: Seco". At the top, there are input fields for "MO/Product: 00005973" and "Packsize: 0". To the right is a checkbox for "Custom Label". Below this, a red-bordered box contains the text "Milling Grade product, only Boxlabel available". The main area contains several input fields: "MO:" (empty), "Product: 00005973", "Edpno: 05973", "Description(Iso): XOMX120408TR-ME08", "Grade: F40M", "Description(Ansi): XOMX120408TR-ME08", "Label Free Text:" (empty), "Qty: 0", "Country Code:" (dropdown), "Manuf. Year: 2021" (dropdown), "Week: 22", and an "Edit" checkbox. Below these are "Labels: 0", "Qty/Box: 0", and "Box Labels: 0". At the bottom, there is a "Labels" section with three checkboxes: "Standard", "Box" (which is checked and highlighted with a red box), and "Diff. Qty". To the right of these are "Print [F9]" and "Close" buttons. At the very bottom, there is a "Printer: priPrinter" dropdown and an "Edit" checkbox.

It is possible to print boxlabels on Seco Standard label for any type of product. Then the window looks like above, only the Box option is available.

3.1.7.3 Custom Label

If a label with special text is needed, there is a possibility to “unlock” the fields by clicking the Custom Label checkbox.



Label: Seco

MO/Product: Packsize:

☒ Custom Label

MO: Product: Edpno:

Description(Iso): Grade:

Description(Ansi):

Label Free Text: Qty:

Country Code: Manuf. Year: Week: ☒ Edit

Labels: Qnty/Box:

Box Labels:

Labels

☐ Standard ☐ Box ☐ Diff. Qty

Print [F9] Close

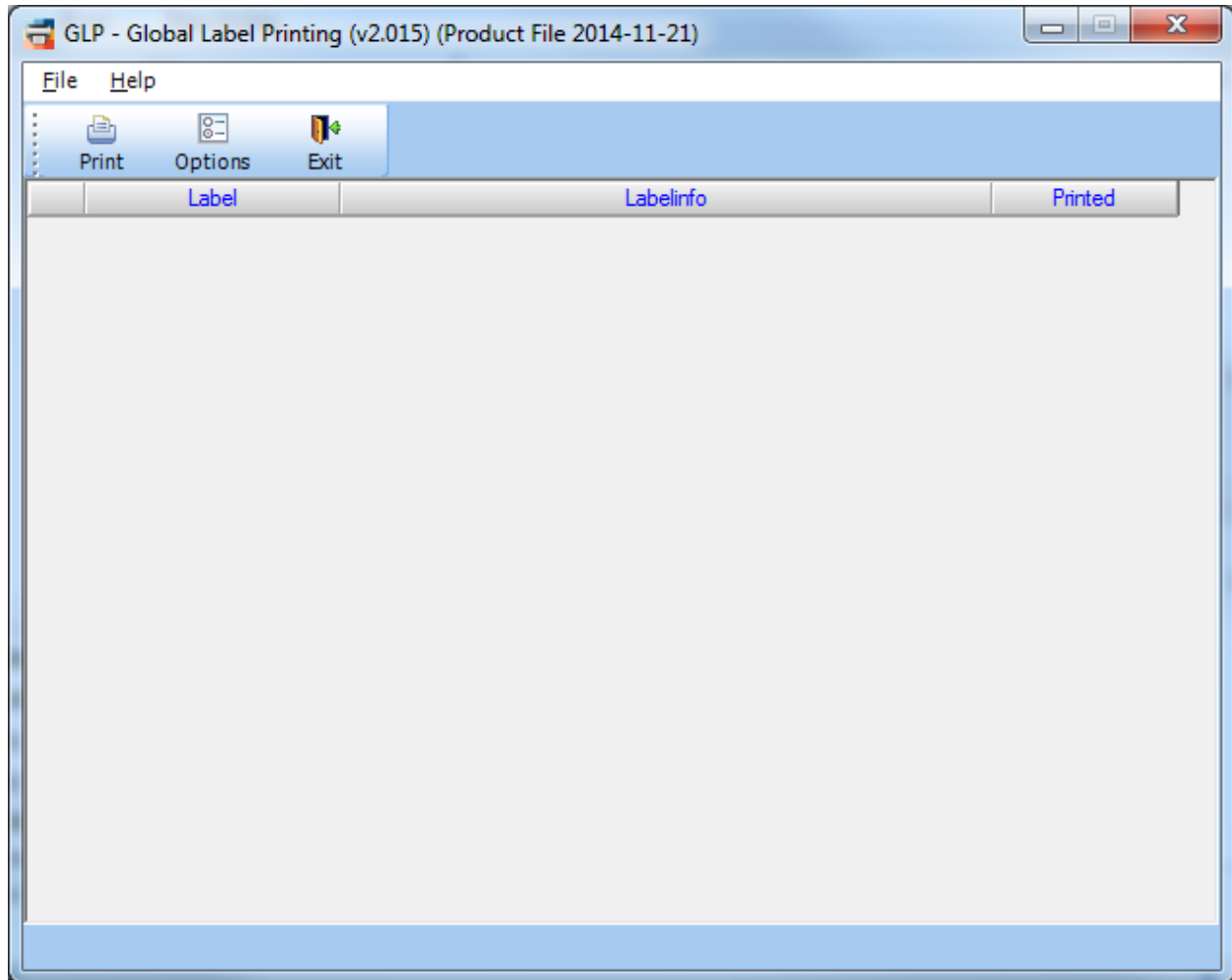
Printer: Edit

3.2 Global Label Printing (GLP)

3.2.1 General

GLP is an application used for printing of Seco Tools specific labels. It is designed for an automatic update of product data needed for printing.

Setup file can be downloaded from: <http://files2.secotools.com/webfiles/glp/setup/setup.exe>





This is the screen shown when starting the application.

The first time it is started after install, the set up screen will automatically popup, see next chapter.

3.2.2 Label settings

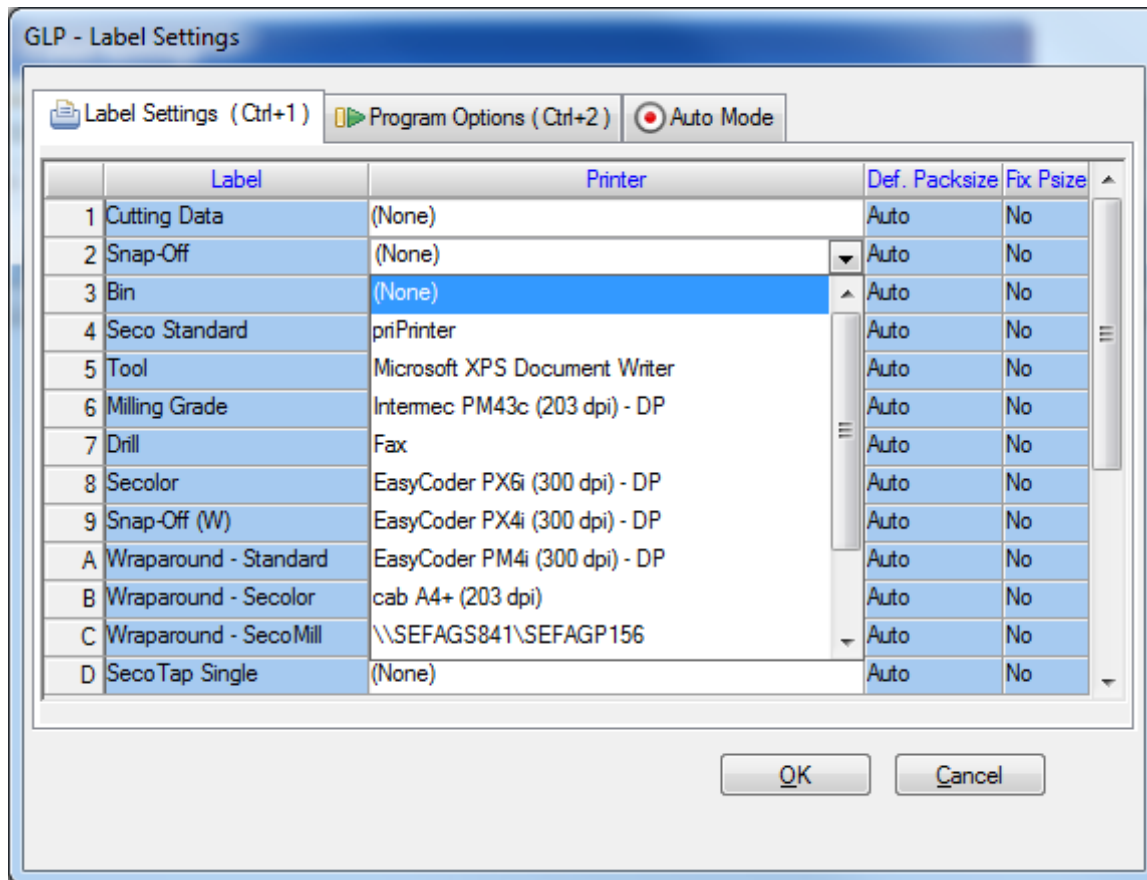
GLP - Label Settings

 Label Settings (Ctrl+1)  Program Options (Ctrl+2) ☒ Auto Mode

	Label	Printer	Def. Packsize	Fix Psize
1	Cutting Data	(None)	Auto	No
2	Snap-Off	(None)	Auto	No
3	Bin	(None)	Auto	No
4	Seco Standard	(None)	Auto	No
5	Tool	(None)	Auto	No
6	Milling Grade	(None)	Auto	No
7	Drill	(None)	Auto	No
8	Secolor	(None)	Auto	No
9	Snap-Off (W)	(None)	Auto	No
A	Wraparound - Standard	(None)	Auto	No
B	Wraparound - Secolor	(None)	Auto	No
C	Wraparound - SecoMill	(None)	Auto	No
D	SecoTap Single	(None)	Auto	No

OK Cancel

The grid shows all labels available for printing.



Select printer for the label(s) that should be printed

GLP - Label Settings

☐ Label Settings (Ctrl+1)
 ☐ Program Options (Ctrl+2)
 ☒ Auto Mode

	Label	Printer	Def. Packsize	Fix Psize
1	Cutting Data	(None)	Auto	No
2	Snap-Off	EasyCoder PX6i (300 dpi) - DP	Auto	No
3	Bin	(None)	Auto	
4	Seco Standard	(None)	Empty	
5	Tool	(None)	1	
6	Milling Grade	(None)	2	
7	Drill	(None)	3	
8	Secolor	(None)	4	
9	Snap-Off (W)	(None)	5	
A	Wraparound - Standard	(None)	6	
B	Wraparound - Secolor	(None)	7	
C	Wraparound - SecoMill	(None)	8	
D	SecoTap Single	(None)		

OK Cancel

When a Printer has been chosen for a label it is also possible to set the Default Packsize for that label. “Auto” means that GLP will automatically set the packsize like before. “Empty” means that the packsize will be empty by default and the user will have to type it manually every time.

Please note that the packsize can still be changed when printing even if a default packsize has been chosen.

GLP - Label Settings

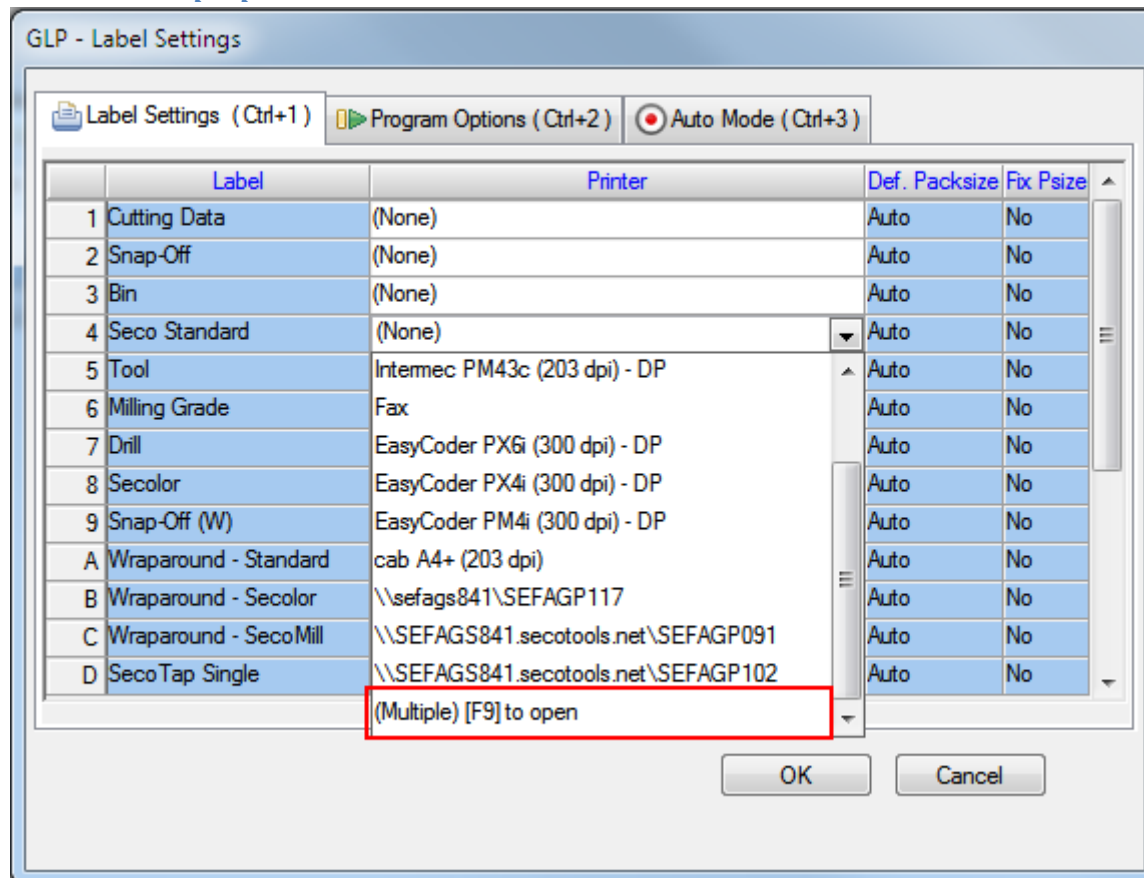
☒ Label Settings (Ctrl+1)
 ☐ Program Options (Ctrl+2)
 ☐ Auto Mode

	Label	Printer	Def. Packsize	Fix Psize
1	Cutting Data	(None)	Auto	No
2	Snap-Off	EasyCoder PX6i (300 dpi) - DP	Auto	No
3	Bin	(None)	Auto	Yes
4	Seco Standard	(None)	Auto	No
5	Tool	(None)	Auto	No
6	Milling Grade	(None)	Auto	No
7	Drill	(None)	Auto	No
8	Secolor	(None)	Auto	No
9	Snap-Off (W)	(None)	Auto	No
A	Wraparound - Standard	(None)	Auto	No
B	Wraparound - Secolor	(None)	Auto	No
C	Wraparound - SecoMill	(None)	Auto	No
D	SecoTap Single	(None)	Auto	No

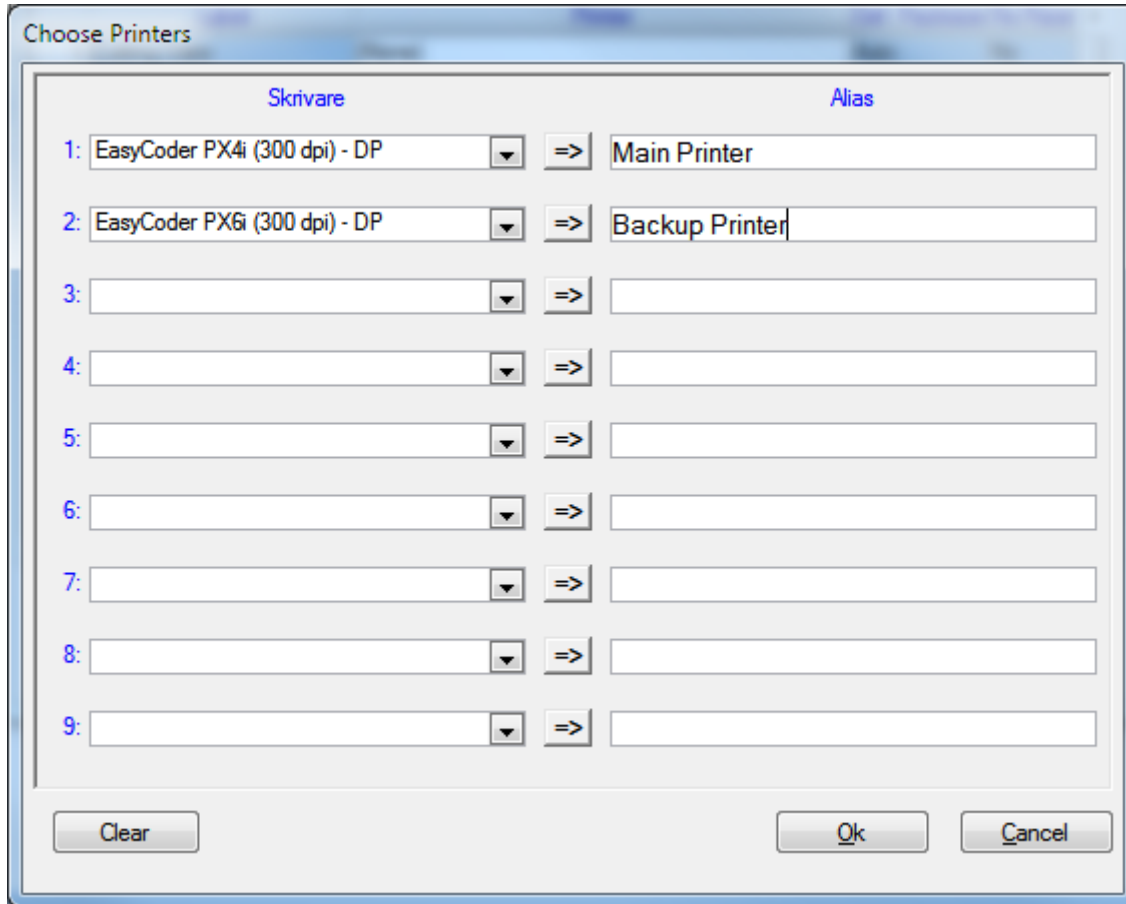
OK Cancel

Fixed Packsize (Fix Psize) can be set to "Yes" if packsize in the printing window should be fixed and not possible to change. Default is "No", meaning Packsize can be changed manually.

3.2.2.1 Multiple printers



If you have more than one printer dedicated for the same label, it is possible to register multiple printers for that label. In the printer list, scroll to the bottom and choose (Multiple).

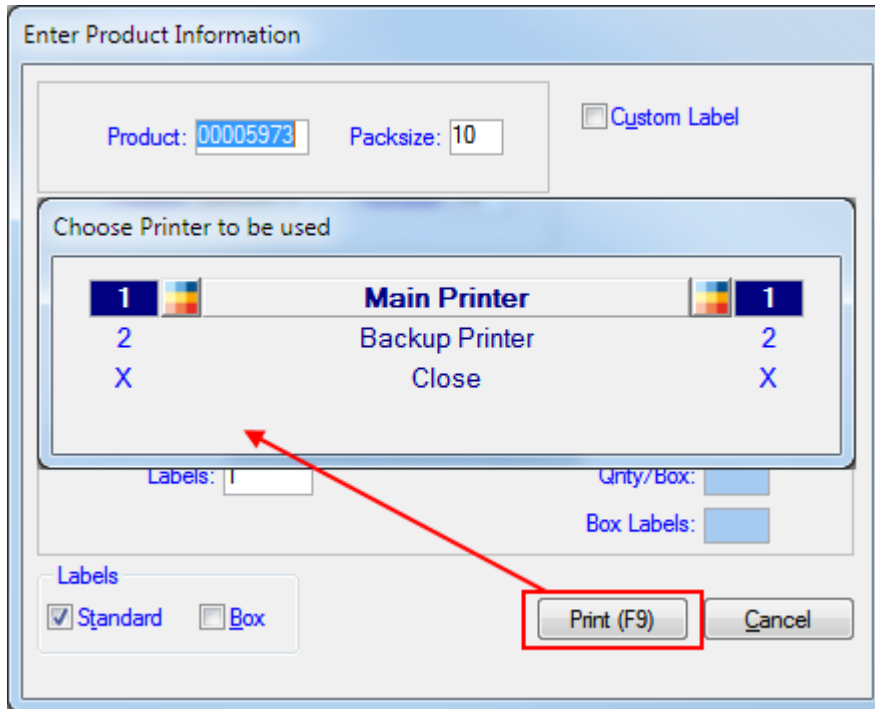


The "Choose Printers" dialog box is used to assign printers to different labels. It features a table with two columns: "Skrivare" (Printer) and "Alias". There are nine rows for assigning printers to labels 1 through 9. The first row is pre-filled with "EasyCoder PX4i (300 dpi) - DP" for label 1 and "Main Printer" as the alias. The second row is pre-filled with "EasyCoder PX6i (300 dpi) - DP" for label 2 and "Backup Printer" as the alias. The remaining seven rows are empty. At the bottom of the dialog are three buttons: "Clear", "Ok", and "Cancel".

	Skrivare		Alias
1:	EasyCoder PX4i (300 dpi) - DP	=>	Main Printer
2:	EasyCoder PX6i (300 dpi) - DP	=>	Backup Printer
3:		=>	
4:		=>	
5:		=>	
6:		=>	
7:		=>	
8:		=>	
9:		=>	

Buttons: Clear, Ok, Cancel

Then this new window opens, where you can choose up to nine different printers for the chosen label. You can also give the printer an Alias (optional) so that you more easily can separate the different printers.



Enter Product Information

Product: 00005973 Packsize: 10 ☐ Custom Label

Choose Printer to be used

1	Main Printer	1
2	Backup Printer	2
X	Close	X

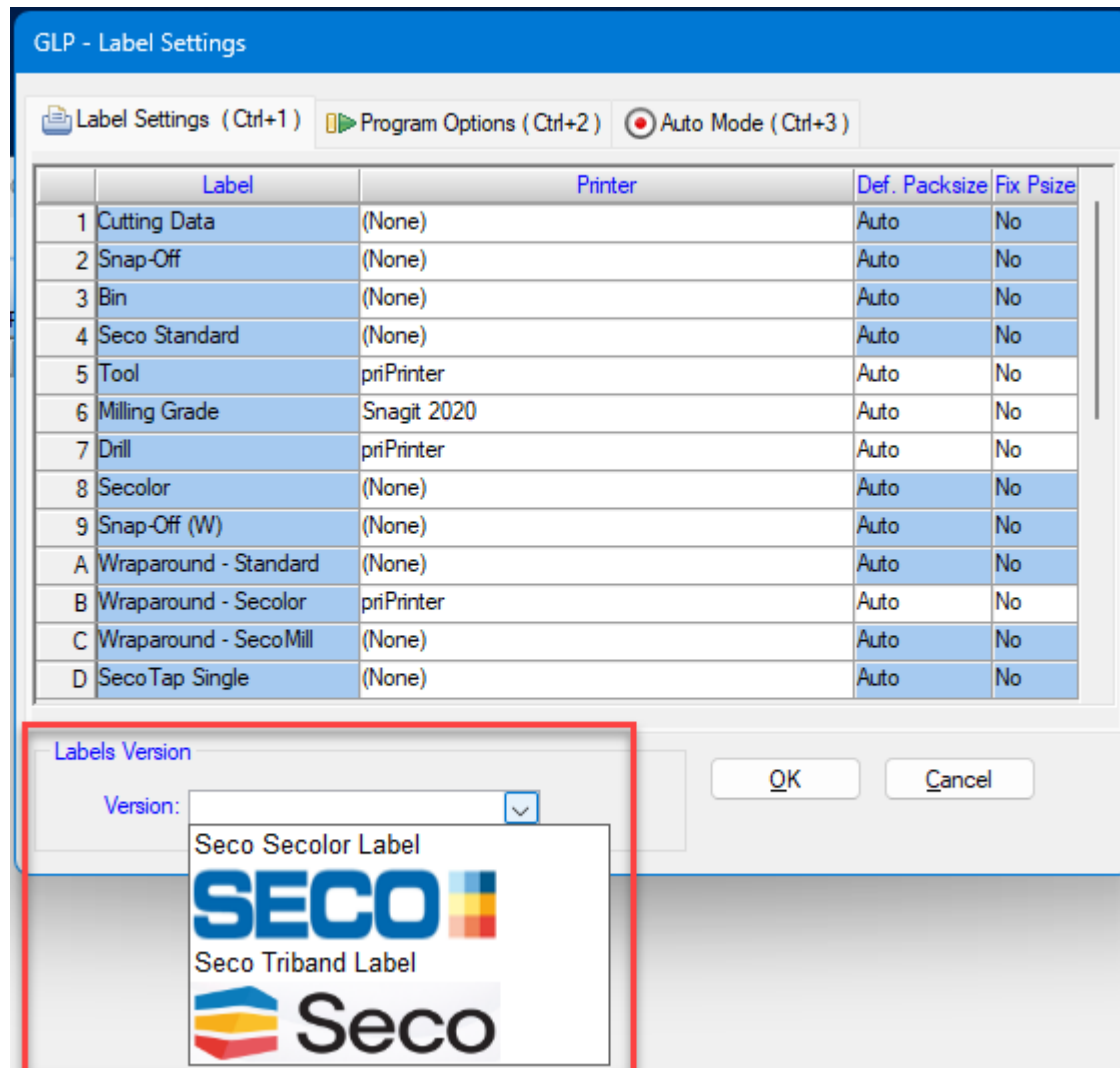
Labels: Qty/Box: Box Labels:

Labels
☒ Standard ☐ Box

Print (F9) Cancel




When printing a label with multiple printers registered, you get to choose which of the printers you want to send the print to.

3.2.2.2 Label version



Some labels can exist in several versions. If that is the case a label version selection might be necessary in the Label Settings. In the drop down menu you can see the available versions.

GLP - Label Settings


 Label Settings (Ctrl+1)
  Program Options (Ctrl+2)
  Auto Mode (Ctrl+3)

	Label	Printer	Def. Packsize	Fix Psize
1	Cutting Data	(None)	Auto	No
2	Snap-Off	(None)	Auto	No
3	Bin	(None)	Auto	No
4	Seco Standard	priPrinter	Auto	No
5	Tool	priPrinter	Auto	No
6	Milling Grade	Snagit 2020	Auto	No
7	Drill	priPrinter	Auto	No
8	Secolor	(None)	Auto	No
9	Snap-Off (W)	(None)	Auto	No
A	Wraparound - Standard	(None)	Auto	No
B	Wraparound - Secolor	priPrinter	Auto	No
C	Wraparound - SecoMill	(None)	Auto	No
D	SecoTap Single	(None)	Auto	No

Labels Version Select Version required
 Version:

If you set a printer for a label that is available in several versions without having selected version the label name will indicate this with a red background and the label version menu will also have a text prompting you to select a version.

Info

 Label version must be selected to save

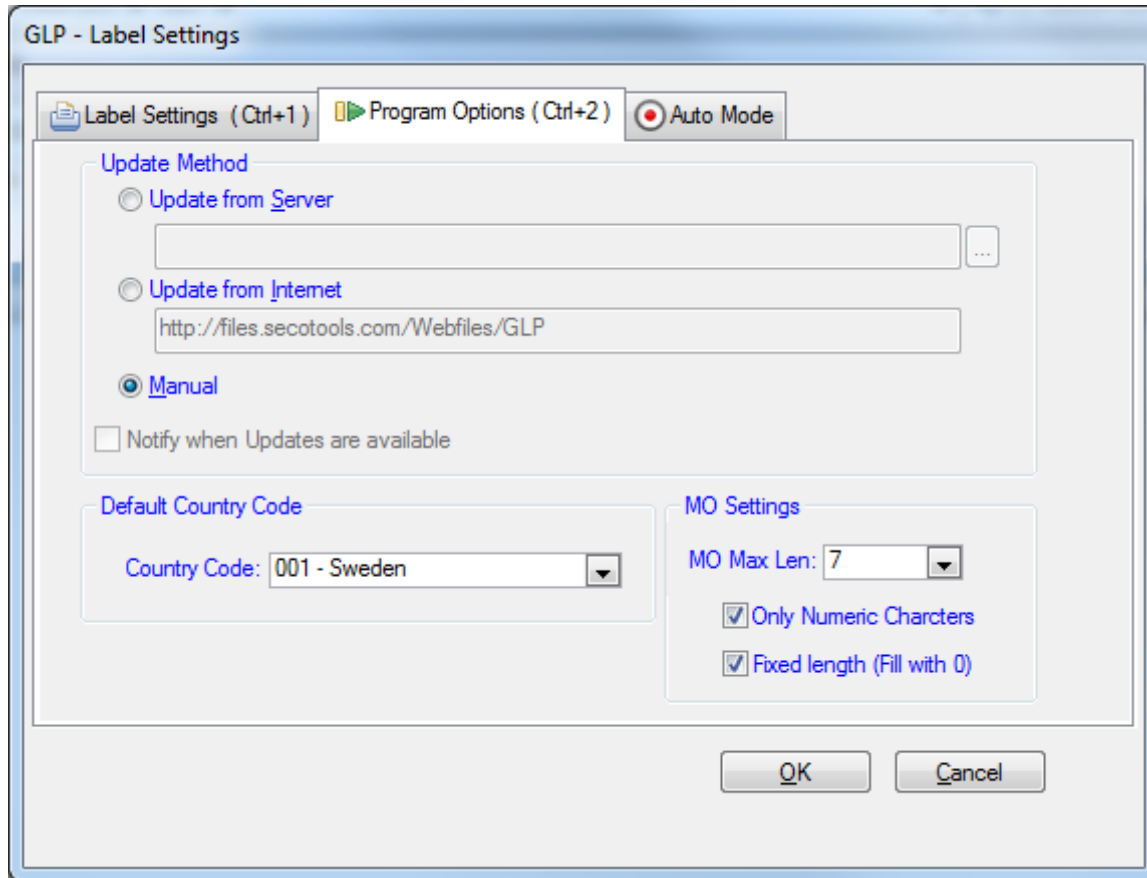
OK

OK Cancel

If you try to save without selecting version in this scenario, you will get the above error message.

3.2.3 Program options

GLP can be configured for automatically checking of new versions.



3.2.3.1 Update from Server

If you have multiple machines printing labels, or if connected to Seco Tools network, select this as the update method. Enter the path to where the master data and program files are stored.

3.2.3.2 Update from Internet

Use this option if you don't have access to Seco Tools internal network.

3.2.3.3 Manual

No version check is done, new files has to be placed manually in the program folder. This option should only be used when none of the two options above are possible. To update GLP manually see 5.2 Manual Update.

3.2.3.4 Notify when Updates are available

Enable if you want GLP to check for updates automatically and notify when available (not possible when update set to Manual).

3.2.3.5 Default County Code

Set the default country code (origin for manufacturer).

3.2.3.6 MO Settings

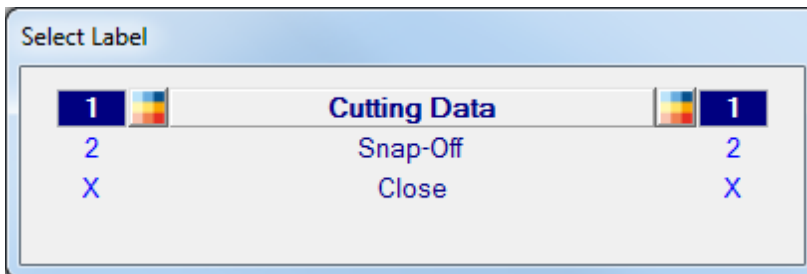
Set the maximum length (no of characters) of the MO field (default is 7).

When “Only Numeric Characters” is checked it means that only characters 0-9 are allowed in the MO field. It is checked by default.

When “Fixed length” is checked it means that the MO field will be filled with zero (0) so the length is always as the maximum length set. It is checked by default.

3.2.4 Printing Labels

After the setup is done, it is now possible to print the label(s). If the computer is allowed to print more than one label, the following screen appears

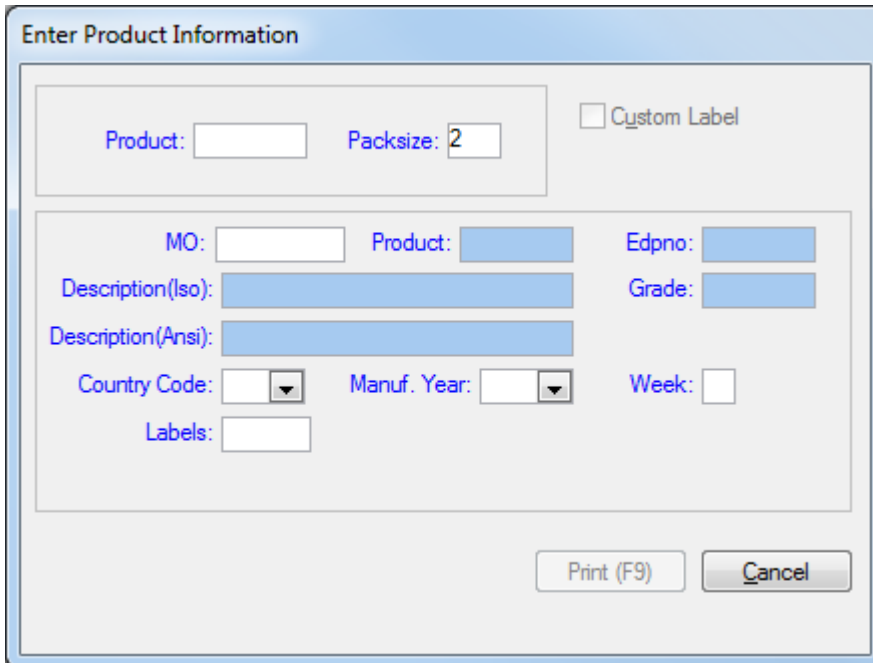


The "Select Label" dialog box displays a table with three columns. The first column contains a list of labels: 1, 2, and X. The second column contains the label descriptions: Cutting Data, Snap-Off, and Close. The third column contains a list of labels: 1, 2, and X. Each label in the first and third columns is preceded by a small icon consisting of three colored squares (blue, yellow, and red).

1	Cutting Data	1
2	Snap-Off	2
X	Close	X

Here you select which label to print by double-clicking on the row, or pressing the corresponding number.

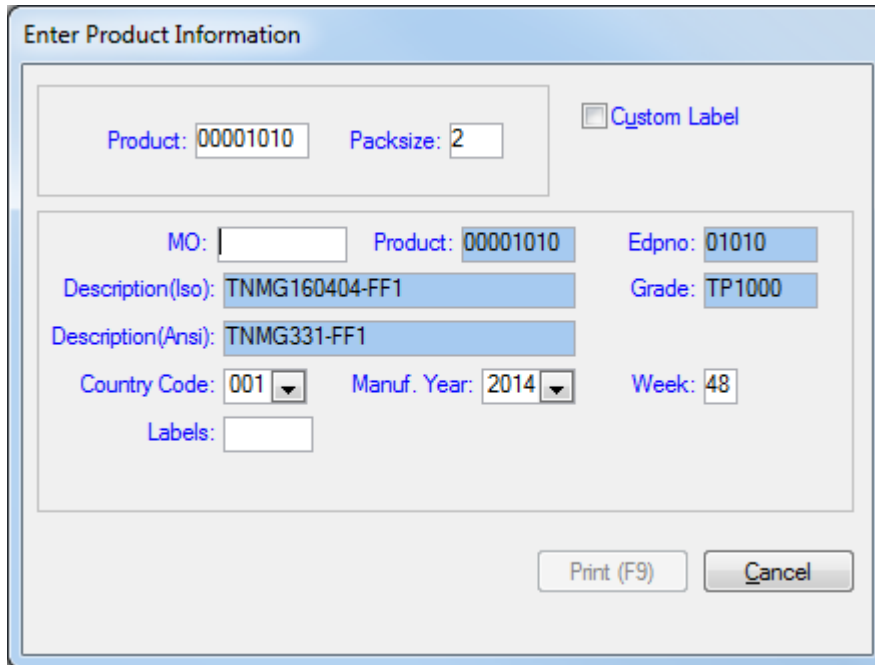
3.2.4.1 Standard labels



The "Enter Product Information" dialog box contains several input fields and a checkbox. At the top, there is a checkbox labeled "Custom Label". Below it, there are two input fields: "Product:" and "Packsize:" with the value "2". Below these, there are three input fields: "MO:", "Product:", and "Edpno:". Below these, there are two input fields: "Description(Iso):" and "Grade:". Below these, there are two input fields: "Description(Ansi):" and "Country Code:". Below these, there are two input fields: "Manuf. Year:" and "Week:". Below these, there is one input field: "Labels:". At the bottom right, there are two buttons: "Print (F9)" and "Cancel".

Start by filling out the product number.

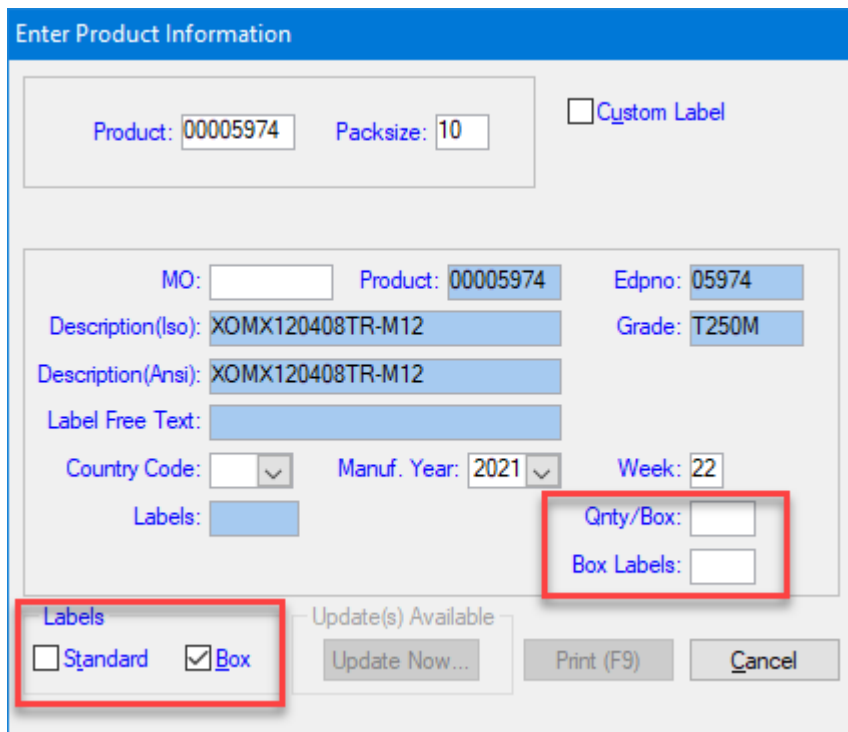
The program will fill in the correct product information



Type in the MO number and No of Labels.

Change Country Code, Manuf. Year and Week if needed.

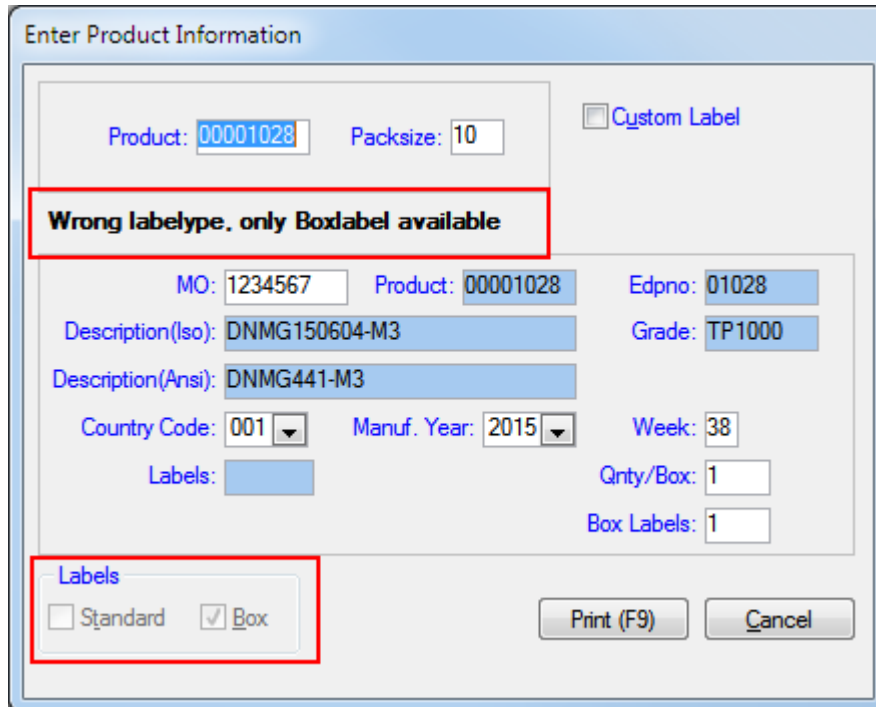
3.2.4.2 Box labels



For some labels there is also an option to print Box labels (same label with different layout).

If box labels are needed, check the “Box” checkbox, fill in the box quantity and the number of box labels to print.

3.2.4.2.1 Box labels Seco Standard



Enter Product Information

Product: 00001028 Packsize: 10 ☐ Custom Label

Wrong labeltype, only Boxlabel available

MO: 1234567 Product: 00001028 Edpno: 01028
 Description(Iso): DNMG150604-M3 Grade: TP1000
 Description(Ansi): DNMG441-M3
 Country Code: 001 Manuf. Year: 2015 Week: 38
 Labels: Qty/Box: 1
 Box Labels: 1

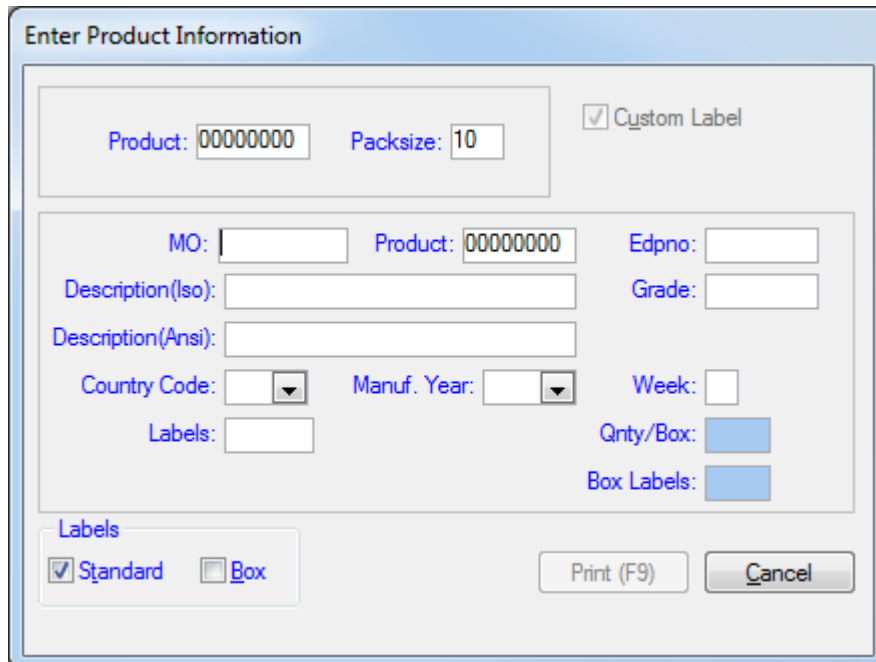
Labels
☐ Standard ☒ Box

Print (F9) Cancel

It is possible to print boxlabels on Seco Standard label even if the product is a Secolor or Secomill product. Then the window looks like above, only the Box option is available.

3.2.4.3 Custom Label

If a label with special text is needed, there is a possibility to “unlock” the fields with Description, EDP Number and Grade. To do this, type “00000000” as product number.



Enter Product Information

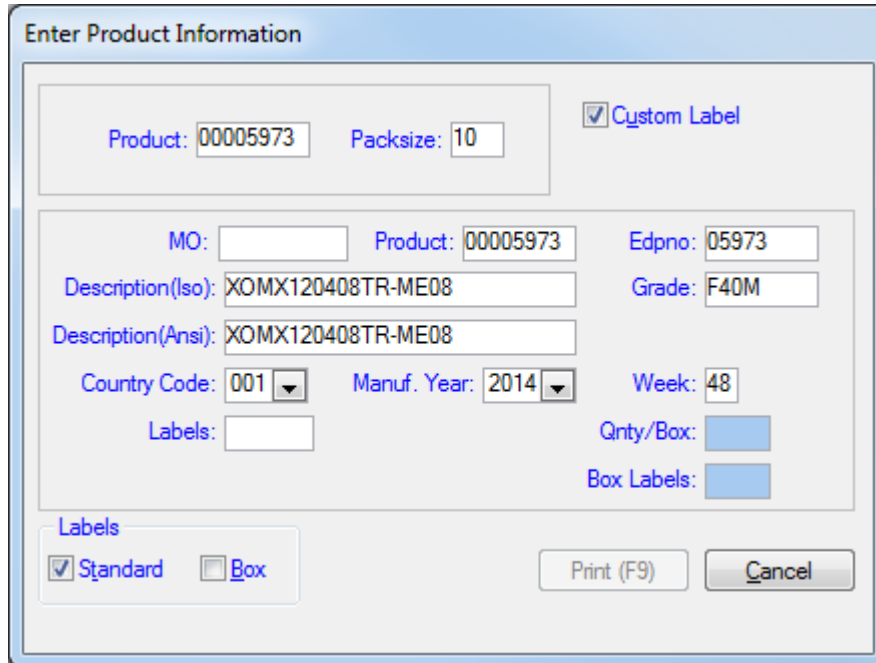
Product: 00000000 Packsize: 10 ☒ Custom Label

MO: Product: 00000000 Edpno:
 Description(Iso): Grade:
 Description(Ansi):
 Country Code: Manuf. Year: Week:
 Labels: Qty/Box:
 Box Labels:

Labels
☒ Standard ☐ Box

Print (F9) Cancel

If some customer specific info is to be added, check the “Custom Label” box, and the fields are unlocked but the data remains.



Enter Product Information

Product: 00005973 Packsize: 10 ☒ Custom Label

MO: Product: 00005973 Edpno: 05973

Description(Iso): XOMX120408TR-ME08 Grade: F40M

Description(Ansi): XOMX120408TR-ME08

Country Code: 001 Manuf. Year: 2014 Week: 48

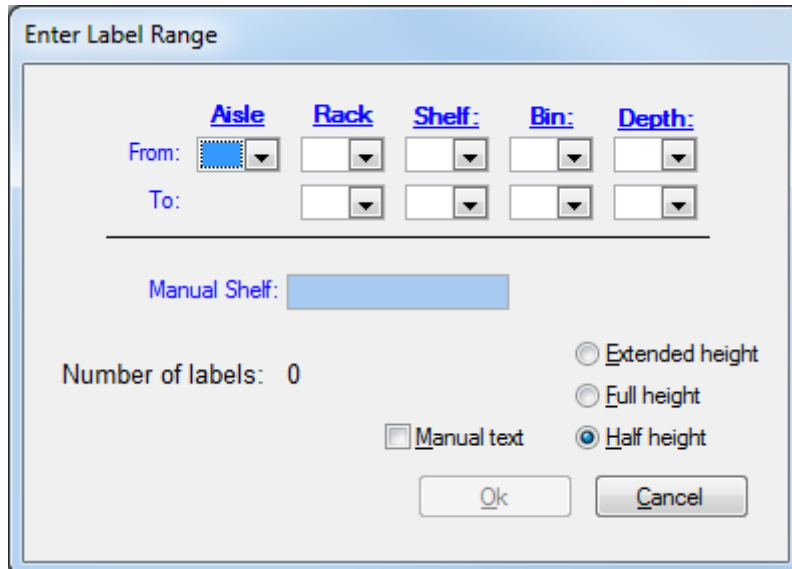
Labels: Qty/Box: Box Labels:

Labels

☒ Standard ☐ Box

Print (F9) Cancel

3.2.4.4 Bin Label



Enter Label Range

From: Aisle: Rack: Shelf: Bin: Depth:

To:

Manual Shelf:

Number of labels: 0

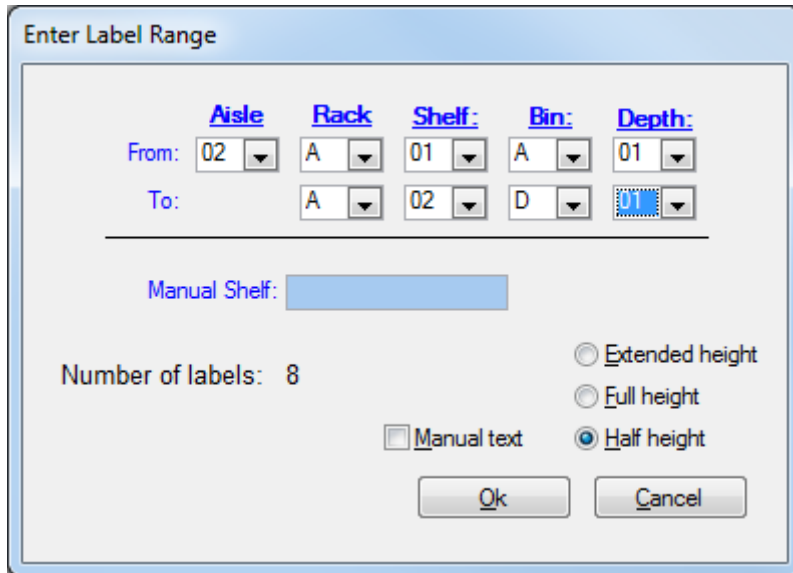
☐ Extended height
☐ Full height
☒ Half height

☐ Manual text

Ok Cancel

Fill in the range of the bin labels to print

- Aisle 01-99
- Rack A-Z
- Shelf 01-99
- Bin A-Z
- Depth 01-09



The dialog box is titled "Enter Label Range". It contains several input fields and options:

- From:** Aisle (02), Rack (A), Shelf (01), Bin (A), Depth (01).
- To:** Aisle (A), Rack (A), Shelf (02), Bin (D), Depth (01).
- Manual Shelf:** A text input field.
- Number of labels:** 8.
- Height options:** ☐ Extended height, ☐ Full height, ☒ Half height.
- Manual text:** ☐ Manual text.
- Buttons:** Ok, Cancel.

When the data is entered, Number of labels to print is calculated and shown.

If manual text is desired, check the "Manual text" Box and type the text in "Manual Shelf".

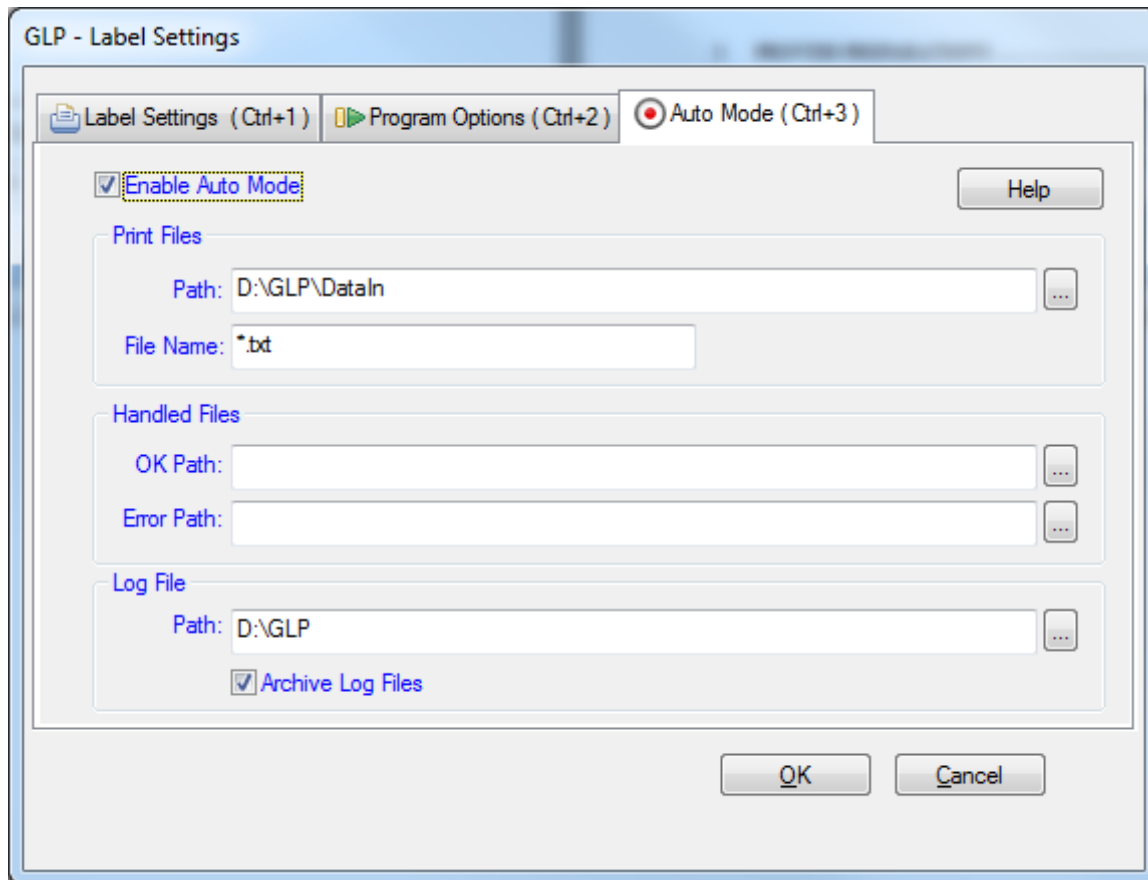
Set if the label(s) should be printed as "Extended", "Full" or "Half" height, ("Half" is chosen as default).

3.2.5 GLP Auto Mode

GLP Auto Mode is a feature that makes it possible for external systems to trigger label print via GLP. This is done by creating a Print File with required input data that GLP processes to create the wanted print. Below is described how to set up and use Auto Mode.

3.2.5.1 Setting up Auto Mode

Label Settings and Program Options needs to be set up even if you only use GLP in Auto Mode. See 3.2 Label Settings and 3.3 Program Options.



File>Options>Auto Mode

To use Auto Mode it needs to be enabled and set up. Enable Auto Mode by checking the checkbox "Enable Auto Mode". By doing so you will be able to make the other required settings.

3.2.5.1.1 Print Files

In path, specify a path where GLP should search for the externally created Print Files that should generate a print in GLP. By default the path is set to [GLP install dir] + "\DataIn". This path must be specified.

Also, it's recommended to specify a File Name that tells GLP what files to look for. By default the File Name is set to "*.txt", meaning GLP will search for all txt-files. If GLP should process all files, regardless

of name and fileformat, type “*.*”. Note that by using “*.*” GLP will process ALL files in the Print Files path, meaning it needs to be dedicated only for GLP Print Files.

The Print File is discussed in more detail under *3.5.2.1 Auto Mode Print File* in section *3.5.2 Using Auto Mode*.

3.2.5.1.2 Handled Files

OK path is the path where GLP should place Print Files that have generated a print job that is OK, without errors. If left empty GLP will delete the Print File.

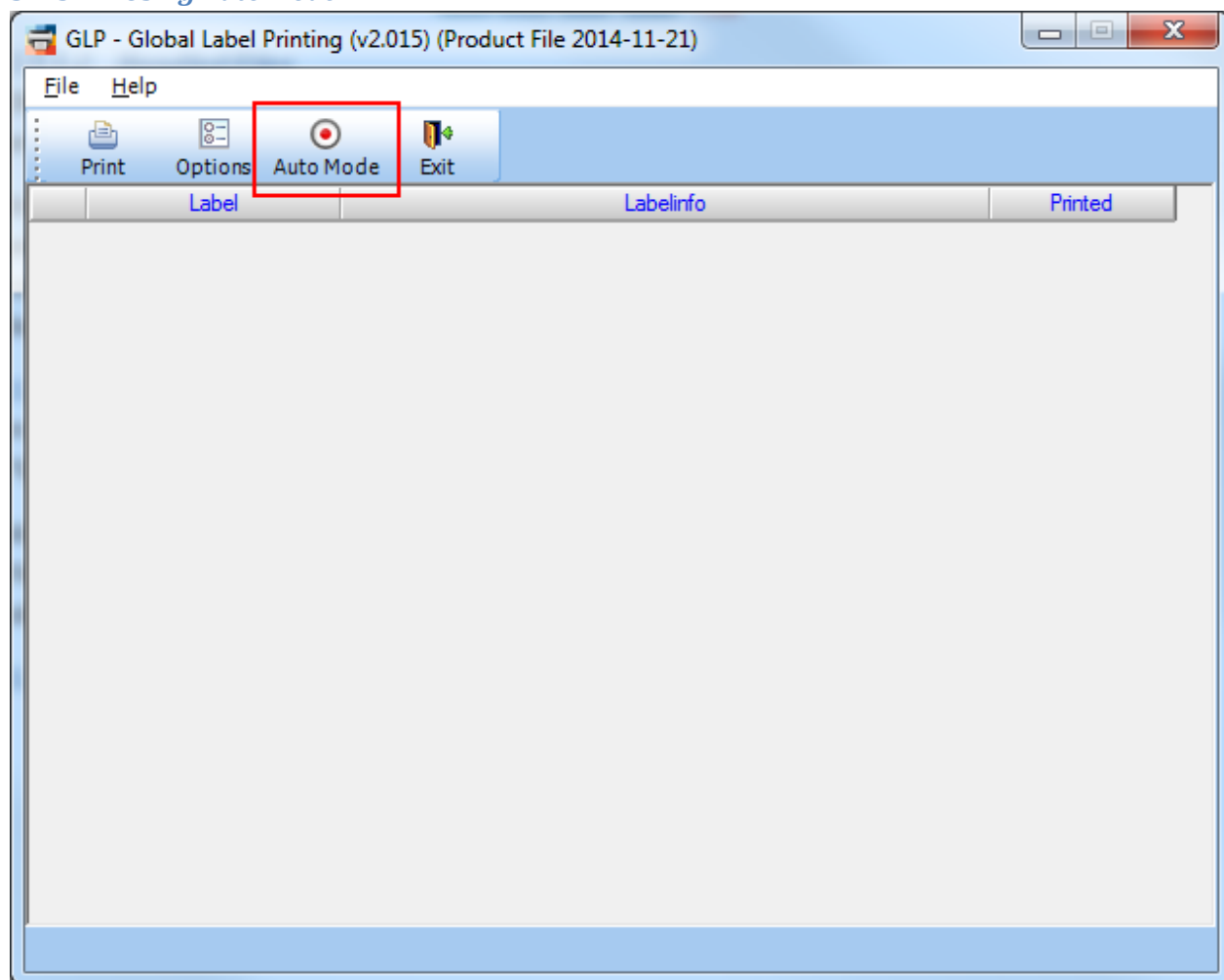
Error path is the path where GLP should place Print Files that have generated a print job with error. If left empty GLP will delete the Print File. Also, if a Error path is specified GLP will create a error message file containing the error that occurred. It will be placed in the same path and be named same as the Print File but with “.err” as file format.

3.2.5.1.3 Log File

In path, specify a path where GLP should create its log file. The file name for the Log file is “GLP_AutoMode.log”. By default the path is set to [GLP install dir]. This path must be specified.

Also, it’s recommended to check the “Archive Log Files” checkbox. By doing so GLP will archive the Log File when it reaches 10MB in size. Archive is done in Log File path + “\Archive”. If unchecked, the old Log File is deleted.

3.2.5.2 Using Auto Mode



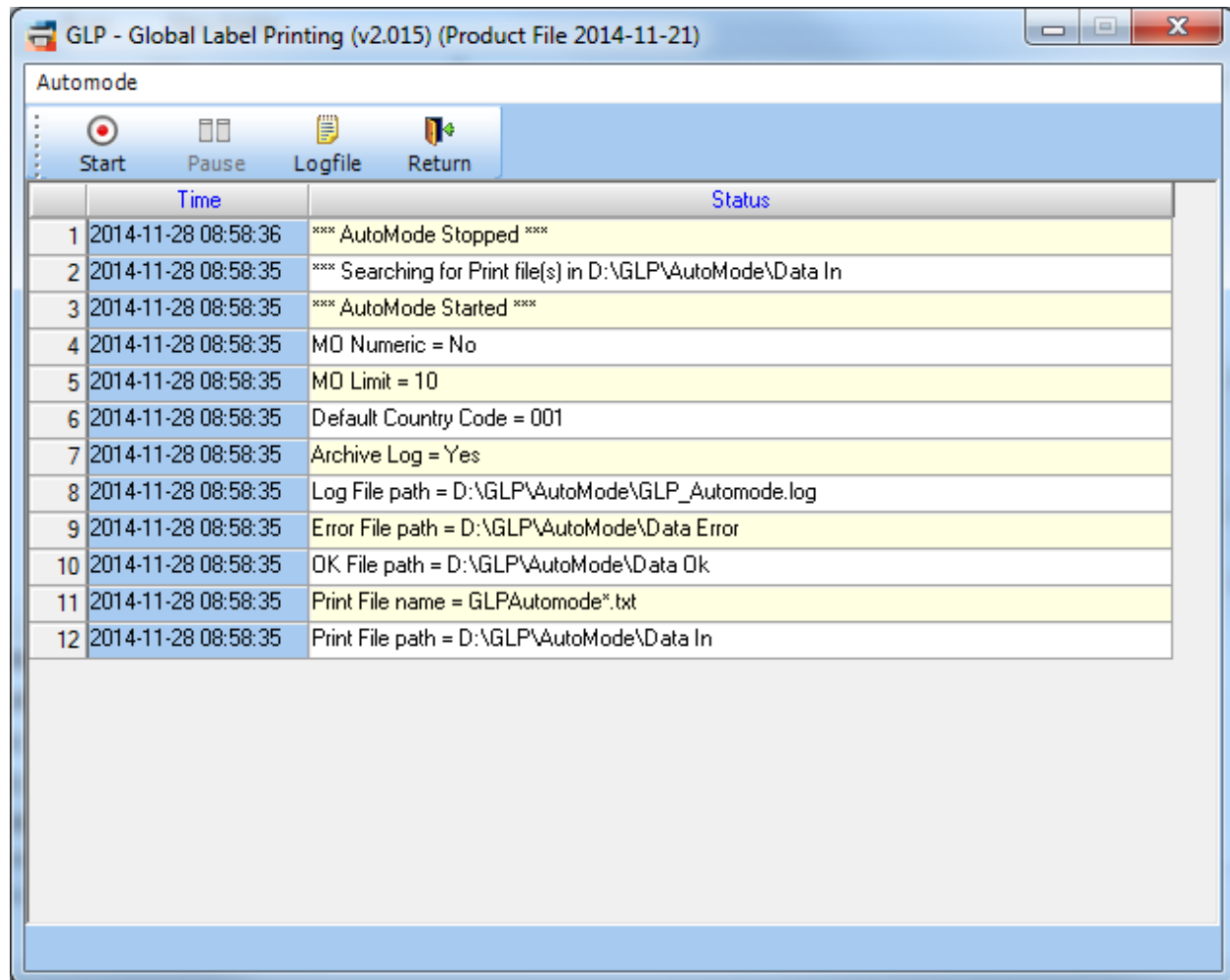
When Auto Mode has been enabled, the Auto Mode icon is visible in the main window toolbar. Auto Mode is started by clicking this icon.

GLP - Global Label Printing (v2.015) (Product File 2014-11-21)		
Automode		
<div> <div>Start</div> <div>Pause</div> <div>Logfile</div> <div>Return</div> </div>		
	Time	Status
1	2014-11-27 15:57:29	**** Searching for Print file(s) in D:\GLP\AutoMode\Data In
2	2014-11-27 15:57:29	**** AutoMode Started ****
3	2014-11-27 15:57:29	MO Numeric = No
4	2014-11-27 15:57:29	MO Limit = 10
5	2014-11-27 15:57:29	Default Country Code = 001
6	2014-11-27 15:57:29	Archive Log = Yes
7	2014-11-27 15:57:29	Log File path = D:\GLP\AutoMode\GLP_Automode.log
8	2014-11-27 15:57:29	Error File path = D:\GLP\AutoMode\Data Error
9	2014-11-27 15:57:29	OK File path = D:\GLP\AutoMode\Data Ok
10	2014-11-27 15:57:29	Print File name = GLPAutomode*.txt
11	2014-11-27 15:57:29	Print File path = D:\GLP\AutoMode\Data In

When entering Auto Mode the needed settings are read and checked to make sure they are they are set (logged above on rows 3-11). After that Auto Mode is activated and GLP starts searching for Print Files in the Print File path.

GLP - Global Label Printing (v2.015) (Product File 2014-11-21)		
Automode		
<div> <div>Start</div> <div>Pause</div> <div>Logfile</div> <div>Return</div> </div>		
	Time	Status
1	2014-11-28 10:17:33	**** Searching for Print file(s) in D:\GLP\AutoMode\Data In
2	2014-11-28 10:17:33	**** Print Job Ended OK
3	2014-11-28 10:17:33	Print File GLPAutomode1.txt moved to D:\GLP\AutoMode\Data Ok
4	2014-11-28 10:17:33	Printing Label
5	2014-11-28 10:17:33	Loading Product Data
6	2014-11-28 10:17:31	Loading Label Data
7	2014-11-28 10:17:31	Reading file D:\GLP\AutoMode\Data In\GLPAutomode1.txt
8	2014-11-28 10:17:31	1 File(s) found
9	2014-11-28 10:17:31	**** Searching for Print file(s) in D:\GLP\AutoMode\Data In
10	2014-11-28 10:17:31	**** AutoMode Started ****
11	2014-11-28 10:17:31	MO Numeric = No
12	2014-11-28 10:17:31	MO Limit = 10
13	2014-11-28 10:17:31	Default Country Code = 001
14	2014-11-28 10:17:31	Archive Log = Yes
15	2014-11-28 10:17:31	Log File path = D:\GLP\AutoMode\GLP_Automode.log
16	2014-11-28 10:17:31	Error File path = D:\GLP\AutoMode\Data Error
17	2014-11-28 10:17:31	OK File path = D:\GLP\AutoMode\Data Ok
18	2014-11-28 10:17:31	Print File name = GLPAutomode*.txt
19	2014-11-28 10:17:31	Print File path = D:\GLP\AutoMode\Data In
Label: Seco Standard Printer: EasyCoder PX6i (300 dpi) - DP		

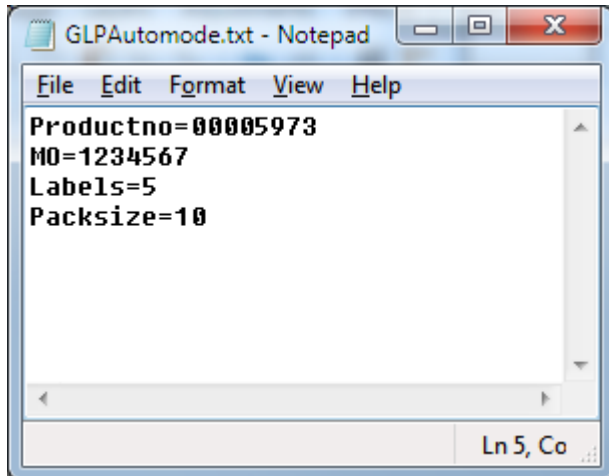
When a Print File is found, GLP starts processing it and initiates a print job. After the print job is completed, GLP searches for Print Files in the Print File path again.



To end the Auto Mode, press the Pause icon in the toolbar. Auto Mode can be restarted again by pressing the Start icon on the toolbar. When clicking the Return icon, the Auto Mode menu is closed and GLP will return to the main window.

3.2.5.2.1 Auto Mode Print File

The contents of the Print File must be arranged like in the screenshot below, meaning it should be [attribute]=[value]. It makes no difference in which order the attributes are written, but every attribute must be on a separate row in the file. See the next subsection for which attributes are needed in the Print File.



Print File example (see section below to know what data you need to include)

3.2.5.2.1.1 Data in Print File

Below the different attributes that can be included in the Print File are described.

Mandatory attributes (must always be included):

- ProductNo - Unique Product number used for identifying which product to print
- MO - Manufacturing Order number, reference number for traceability

Optional attributes (may be possible to exclude):

- Labels - Number of Labels to print (set to 1 if not included)
- Packsize - Packed quantity, can be excluded if default Packsize is set in GLP settings
- Boxlabels - Number of Boxlabels to print (availability depending on label type)
- Boxsize - Packed quantity if Boxlabels are to be printed
- LabelProd - Product number for Label, include if automatic label not available
- BoxProd - Product number for Box, only applicable for Wraparound labels
- ManYear - Custom Manufacturing year, only include if not current year
- ManWeek - Custom Manufacturing week, only include if not current week
- CountryCode - Custom Country code, only include if not default Country code from GLP settings
- Printer - Custom Printer, not needed if printer set for label in GLP settings

4 Labels

Pictures of the Labels available in GLP.

4.1.1 Cutting Data

Label type = 1

Label Image missing

4.1.2 Snap Off

Label type = 2

SNAPOFFLABEL43X23MM – 02451477



4.1.3 Bin

Label type = 3

Label Image missing

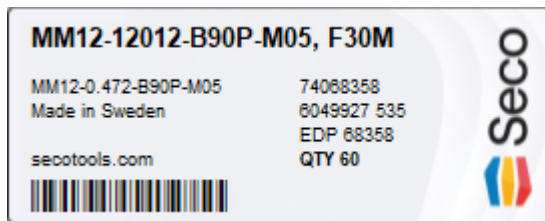
4.1.4 Seco Standard

Label type = 4

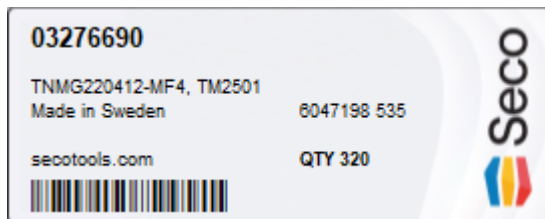
SECOLABEL803/72X29MM - 02414744

Triband version

Standard



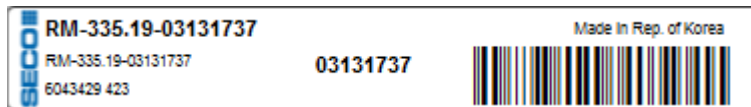
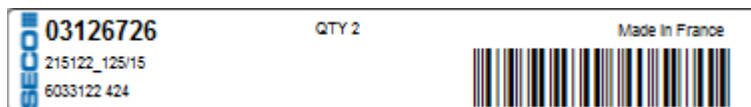
Box



Secolor version (phased out)**Standard****Box****4.1.5 Tool Label**

Label type = 5

TOOLLABEL100X14MM - 02552518

Standard**Box****4.1.6 Tool Small**

Label type = 0



4.1.7 Tool Large

Label type = N



4.1.8 Milling Grade

Label type = 6

SECOMILLABEL82X29MM – 02563239



4.1.9 Drill

Label type = 7

DRILLABEL43X23MM - 02531040

Standard



Box



4.1.10 Secolor

Label type = 8

SECOLORLABEL802/82X29MM - 02414745

Standard



4.1.11 Snap Off (W)

Label type = 9

CBNLABEL23X88MM – 02587479



4.1.12 Wraparound Standard

Label type = A

WRAPAROUNDLABEL6X3/NEUTRAL – 02667401



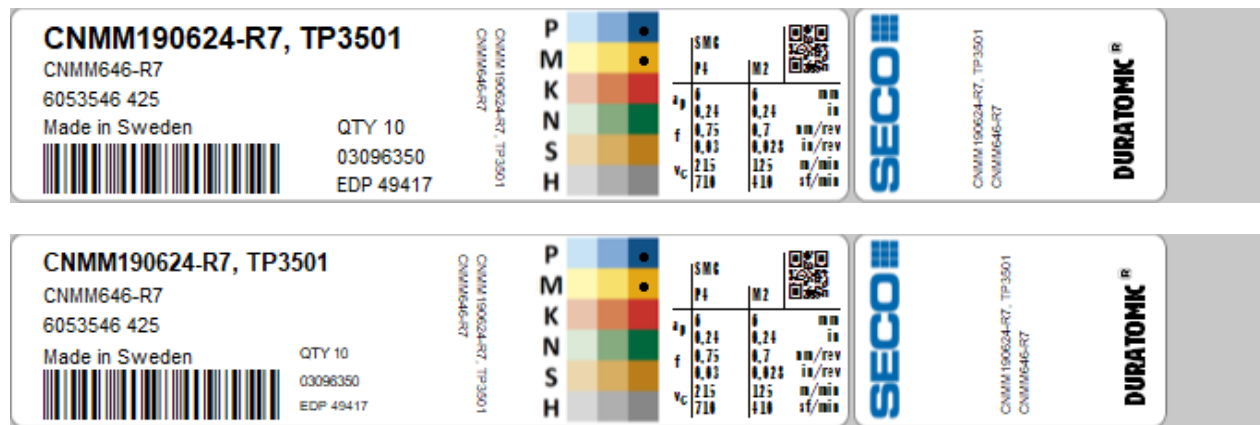
WRAPAROUNDLABELONESIDE/NEUTRAL – 03181759

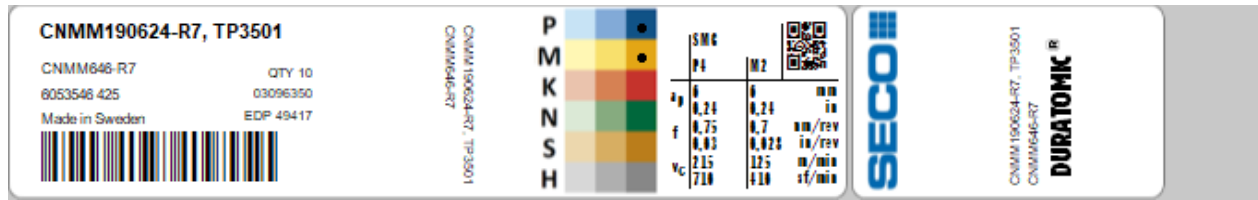


4.1.13 Wraparound Secolor

Label type = B

WRAPAROUNDLABEL6X3/SECOLOR – 02667402





4.1.14 Wraparound Secomill

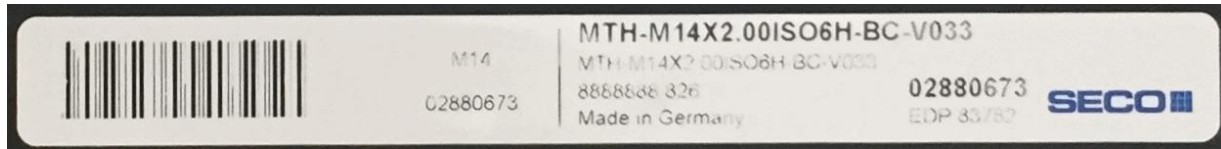
Label type = C

WRAPAROUNDLABEL6X3/SECOMILL – 02667403

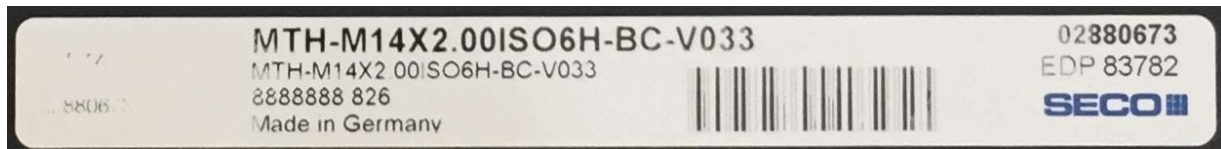


4.1.15 SecoTap Single - 02892148

Label type = D



SecoTap Single Large Size



4.1.16 SecoTap 5-pack Small - 02892143

Label type = E



4.1.17 SecoTap 5-pack Medium - 02892144

Label type = F



4.1.18 SecoTap 5-pack Large - 02892146

Label type = G



4.1.19 Feedmax Universal Single - 02922405

Label type = H

**4.1.20 Feedmax Universal Small - 02922406**

Label type = I

**4.1.21 Feedmax Universal Medium - 02922407**

Label type = J

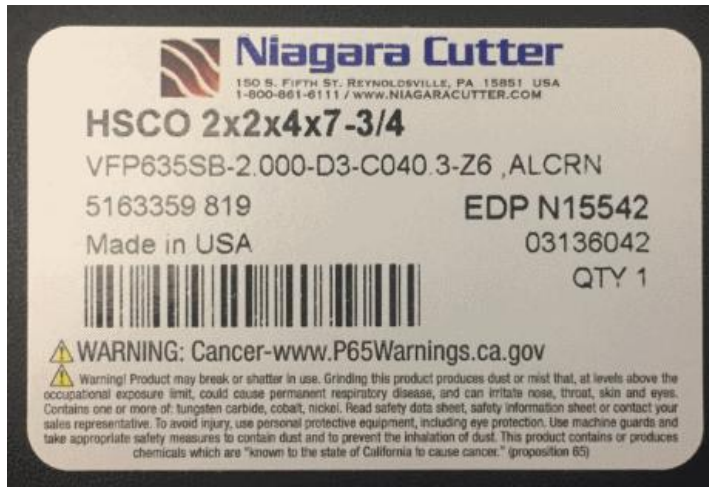
**4.1.22 Feedmax Universal Large - 02922410**

Label type = K



4.1.23 Niagara

Label type = L



4.1.24 Drill Small

Label type = M



4.1.25 Jabro

Label type = Q

Triband version



Secolor version (phased out)



4.1.26 Free Text

Label Type = R

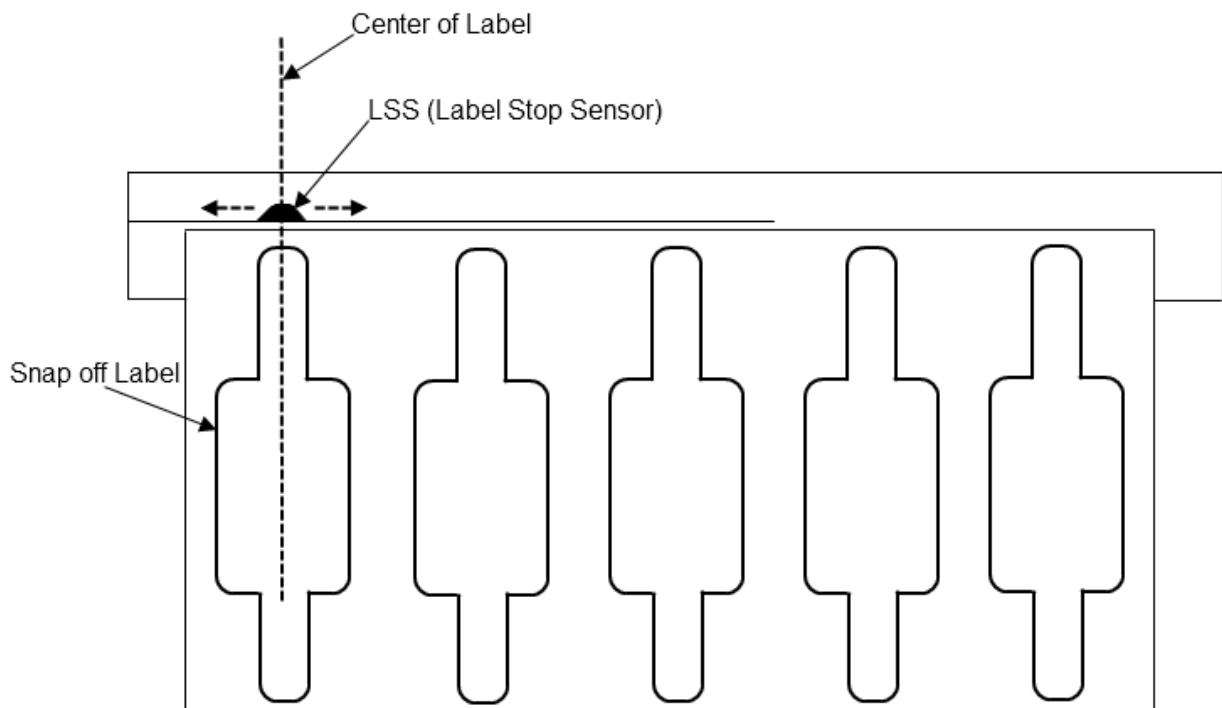
Label image missing

5 Troubleshooting

5.1 Label is shifted vertically

If the printout seems to be shifted vertically it could be because of the Label Stop Sensor (LSS). It is very important that the LSS is configured correctly. To configure it, do the following:

1. Adjust the sensor so that the center of the sensor is in the center of the first label from the left. It is very important that it's really in the center of the label so please pay attention to this and adjust it as close to the center of the label as possible.
2. On the printer press and hold *Shift* and then press *Feed* to calibrate the new position of the sensor.



Label Stop Sensor set correctly (in this example for Snap off label).

5.2 Manual Update

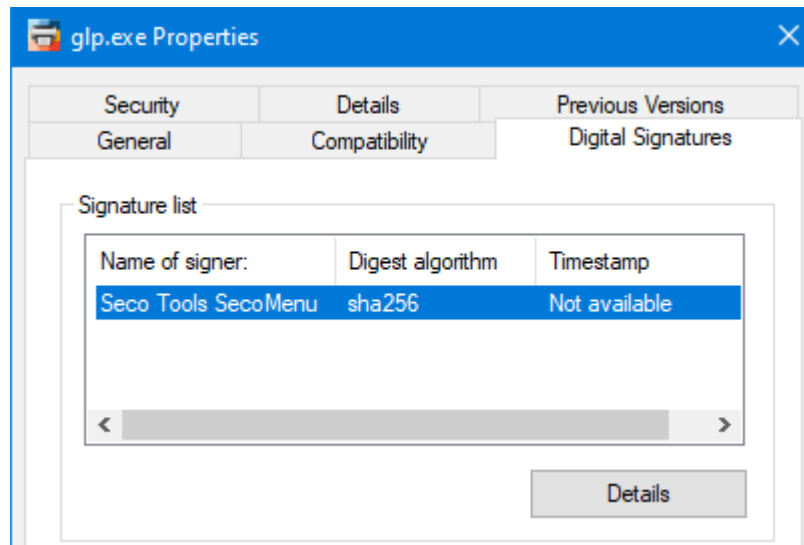
If product data is missing in GLP it's probably because the product data files have not been updated. If neither Server or Internet update (see 3.3 Program Options) are possible, then GLP needs to manually update. To update GLP manually do the following steps:

1. Close down your GLP application if open.
2. Download: http://files2.secotools.com/webfiles/glp/manual_upd/manual_upd.zip
3. Unzip the files into your local GLP installation folder. Replace all files.

5.3 GLP quarantined by antivirus

When we release new GLP versions some antivirus softwares may place the executable (GLP.exe) in quarantine as a safety threat, causing the application to be unavailable. If this happens, you need to whitelist GLP.exe in your antivirus software. However, there is also another option. Every executable we distribute has been digitally signed with our certificate (see screenshot below). If you whitelist this certificate instead, you don't need to whitelist each new GLP executable file. Note that the certificate is renewed once per year, meaning the whitelisting also needs to be updated when that happens.

If you need more information regarding the certificate, please get in contact with us.



Version Changes

1.16	2021-12-06	Section 5.3 GLP quarantined by antivirus added
1.15	2021-06-02	Section 3.1 SecoMenu (RAPS) added
1.14	2019-09-23	Free Text label added
1.13	2018-07-04	Label pictures updated, Jabro label added
1.12	2018-06-26	New labels Tool Small & Tool Large added
1.11	2016-08-16	In “2.1.1 Stock” label dimensions in Inches have been added
1.10	2015-12-09	“3.2.1 Multiple printers” is new “3.4.5 Box labels Seco Standard” is new “3.5 GLP Auto Mode” has been updated
1.09	2014-12-04	New feature “3.5 GLP Auto Mode” New Label Drill Small GLP screenshots updated
1.08	2013-11-28	New Label Niagara
1.07	2013-10-14	Feedmax Universal, new labels added under “2 Printing Preferences”
1.06	2013-09-16	“5.2 Manual Update” is new Seco Tap, new labels added under “2 Printing Preferences”
1.05	2013-06-18	“3.3.6 MO Settings” is new
1.04	2013-05-14	“3.2 Label Settings” has been updated with Default Packsize.
1.03	2013-03-14	“3 Global Label Printing” screen shots updated
1.02	2012-10-29	“4 Labels” is new
1.01	2012-09-04	“2 Printing Preferences” screen shots updated “3 Global Label Printing” screen shots updated “3.3.4 Notify when Updates are available” is new
1.00	2012-01-12	New