Stuga Zebra Label Batch File Specification

The requirement is for a separate file to directly print labels from the Stuga machinery, driven by the third party software company. To maintain backwards compatibility, a third saw link file will be generated – a Zebra print file written in the zebra printer language. This allows graphic and font information to be transferred to create a more visually appealing label.

Contents

Specification for Zebra Printer File Format

Extension	Description
449	Stuga Saw link containing piece sawing and prepping information
PRN	Stuga Label file to drive standard printers
ZEB	Additional file to drive zebra printers directly for third-party software barcode tracking

The file will consist of Zebra print records in the following format:

```
Z,<PieceNo>,<LabelData>
```

Field	*Length*	*Description*	*Example*
Z	1A	Z signifies a zebra record	Z
PieceNo	12A	Piece number from 449 file	000000000001
LabelData	256A	Data to send to printer	^XA^LH30,30^FO20,10^AD^FDZEBRA^FS^XZ

Notes

1. DO NOT exceed the maximum field lengths
2. There may be several records / lables for each piece, each record is one label
3. All piece records must be grouped together. Printing will end when the pieceno group stops.
4. Records must end with <CR> <LF>.
5. The file name will be the same as the saw (.449) batch name with a .ZEB extension.

Example (This is not valid Zebra printer language)

```
Z,000000000001,^XA^LH30,30^XA^LH30,30^FO20,10^AD^FDZEBRA^FS^XZ
Z,000000000001,^AD^FDLine1^FS^XZ^XA^LH30,30^FO20,10^AD^FDZEBRA^FS^XZ
Z,000000000001,^AD^FDLine2^FS^XZ^XA^LH30,30^FO20,10^AD^FDZEBRA^FS^XZ
Z,000000000002,^XA^LH30,30^XA^LH30,30^FO20,10^AD^FDZEBRA^FS^XZ
Z,000000000002,^AD^FDLine1^FS^XZ^XA^LH30,30^FO20,10^AD^FDZEBRA^FS^XZ
Z,000000000002,^AD^FDLine2^FS^XZ^XA^LH30,30^FO20,10^AD^FDZEBRA^FS^XZ
```

Label Size

If using Stuga standard labels, the label should be formatted to 36mm x 98mm. However this can be any size if the printer and labels are specified correctly.
The standard printer head is 200dpi.

Checking Output Data

There is a really useful online tool for checking the output data
http://labelary.com/viewer.html
The output code for a label can be pasted in to the box and it will render the output on screen instantly

Stuga Controlled Fields

Special field codes are allowed to enable the Stuga machine to replace a given string of characters with live data that is not avalaible when the label file is created, for example the machine build number that produces the part, or the time and date of production. This data is very useful for tracing changes and diagnostics

Field Specification

Field Code	Replacement on Printing	Example
BN	Unique Build number of machine	Z087
$Date$	Date of production (dd/mm/yy)	12/08/22
$Time$	Time of Production (hh:mm:ss)	15:32:17

The text is replaced in the zebre string so will be subject to whatever formatting the surrounding characters are.