

DVLA – Driver and Vehicle Licensing Agency



WI6 web inspection: an investment in security and quality

When producing vehicle registration certificates and other documents, the Driver and Vehicle Licensing Agency faces a particularly big challenge in achieving perfect quality. With the WI6 web inspection system, in-line process monitoring was placed on a secure, integration-ready foundation.

For roughly a year, the Driver and Vehicle Licensing Agency (DVLA) in Swansea (Wales) have been doing production with the latest pre- and post-processing technology from Hunkeler. Two identically configured lines, each equipped with a Kodak VL4200 printing system, are designed to work with the roll-to-stack production. These production lines are installed in two centres located six miles from each other for security reasons, and for cases that require a back-up system.

Overall monitoring

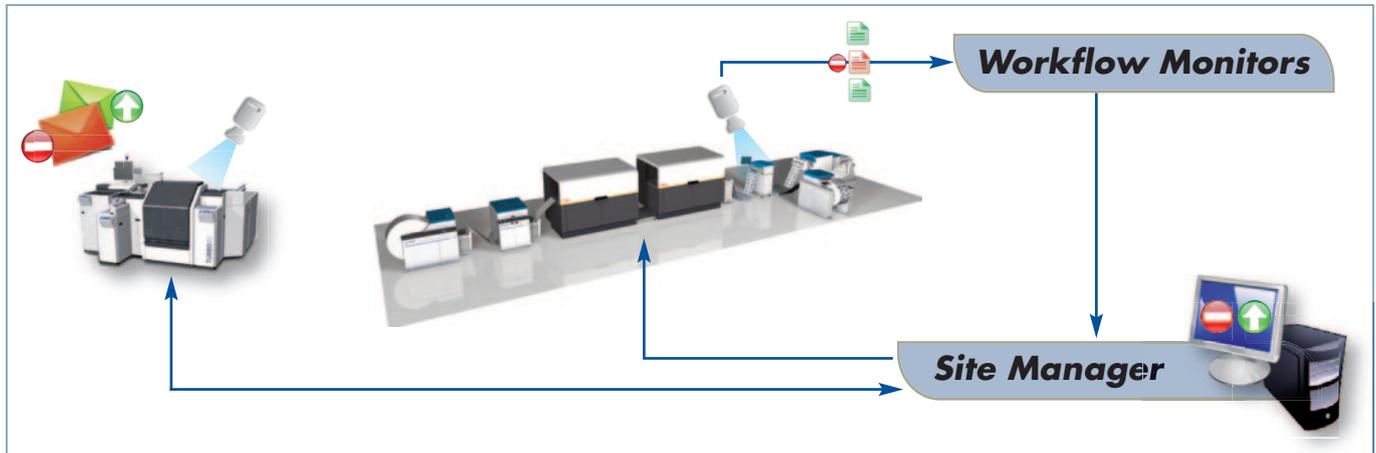
With the selection of the Hunkeler solution, the DVLA made an investment above all in security and qua-



The WI6 web inspection system is integrated into the production line following the Kodak VL4200 printer. The monitor shows the image captured by the cameras at every point in time. Possible errors can then be quickly identified by the operator.

lity. Here, the in-line monitoring of the paper web printed on both sides with the WI6 web inspection system plays a key role. A high-resolution camera on each side of the paper web captures the printed image across the entire width. A comparison with stored reference files makes it possible to recognise faulty printed images and divert the affected copies out of production. Overall print quality, including photographs, illustrations, logos and script, is monitored as is the consistency of full colour and process colour printing with the target values as well as the register. The examination of content includes all static and variable information, whether barcodes (1D or 2D) or

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The DVLA currently examines the printed paper web with high-resolution cameras. Bad printed images are recognised, and the affected copies are diverted. With the planned expansion to a closed-loop system, the DVLA will soon have at its disposal comprehensive functions for monitoring quality and process analysis.

alphanumeric sequences, as well as checking if the front and back sides of every single document are in agreement. The W16 web inspection system also makes it possible to compare the content of individual data fields within a document and check their integrity.

Pre-requisite for economic operation

For project manager Stephen Hartnoll, the W16 puts its particular strengths to full use, especially with regard to increased productivity. While manual monitoring was economically viable with the relatively small stacks of the previous system, a completely different situation arose with the 700 mm high stacks in the FS6 folder stacker during roll-to-roll production. "If we are to take advantage of the new system's productivity, electronic in-line monitoring with the W16 is essential. With it, we can maintain a constant high level of quality, even at fast production speeds, all the while guaranteeing cost-effective operation."

Company-wide integration

The W16 web inspection system is a component of the Hunkeler Control Platform and makes it possible to integrate process and quality monitoring in a company-wide workflow. For example, production monitoring and quality assurance can be set up in a closed-loop control system with a link to a central database.

At the DVLA, quality monitoring alone is the functionality being used for the time being. The moment the W16 detects an error on the paper

web, the production system is automatically stopped and the bad document is removed from the material flow manually. In addition, according to Mr Hartnoll, triggering the reproduction of documents is still currently reserved for the operator for organisational reasons.

W16 with extensive uses

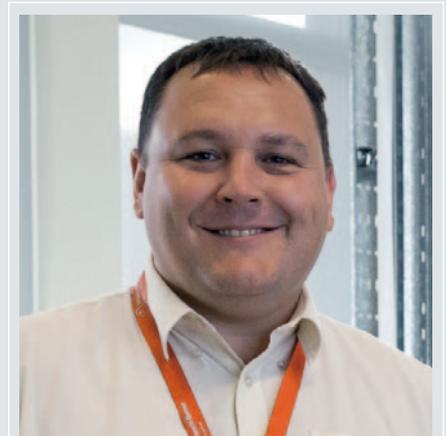
With upcoming plans for the integration of the Hunkeler Site Manager, the DVLA will further increase production efficiency. In a closed-loop system it will be possible to collect variable data with the W16 in real time during running production and compare it with a XML file on the DVLA server. Errors will then be reported directly to the control system of the Böwe insertion line. For its part, the Böwe system ensures that the affected documents are automatically diverted out of the process immediately prior to insertion.

The extensive benefits of process integration go even further. All production data related to evaluating quality – correctly output pages, bad pages, number of diverted documents, etc. – are recorded in the Hunkeler Site Manager and transferred to the DVLA server. At the same time, the Page Manager of the Böwe insertion system is supplied with information about the documents to be diverted and the correctly output documents.

Potential for growth in sight

Mr Hartnoll has high expectations from the closed-loop process. "Due to the fact that bad

documents will be automatically diverted, the entire production process will gain further stability. That will help us to increase net performance even more and achieve overall better production results at yet lower costs."



As Business Implementation Manager, Stephen Hartnoll is responsible for the latest investment project at DVLA. He attributes key importance to the W16 saying: "Here at the DVLA, we place very high value on reliable quality monitoring. The largest portion of our products consists of legal documents where absolute quality is required, in particular with regard to data integrity. The W16 web inspection system makes our production significantly more reliable because the high-resolution cameras immediately register every trouble spot in a document, no matter if it concerns problems related to printing or the content. Besides perfect quality and low waste, it takes a load off our operator, who can then dedicate himself to his primary responsibilities."