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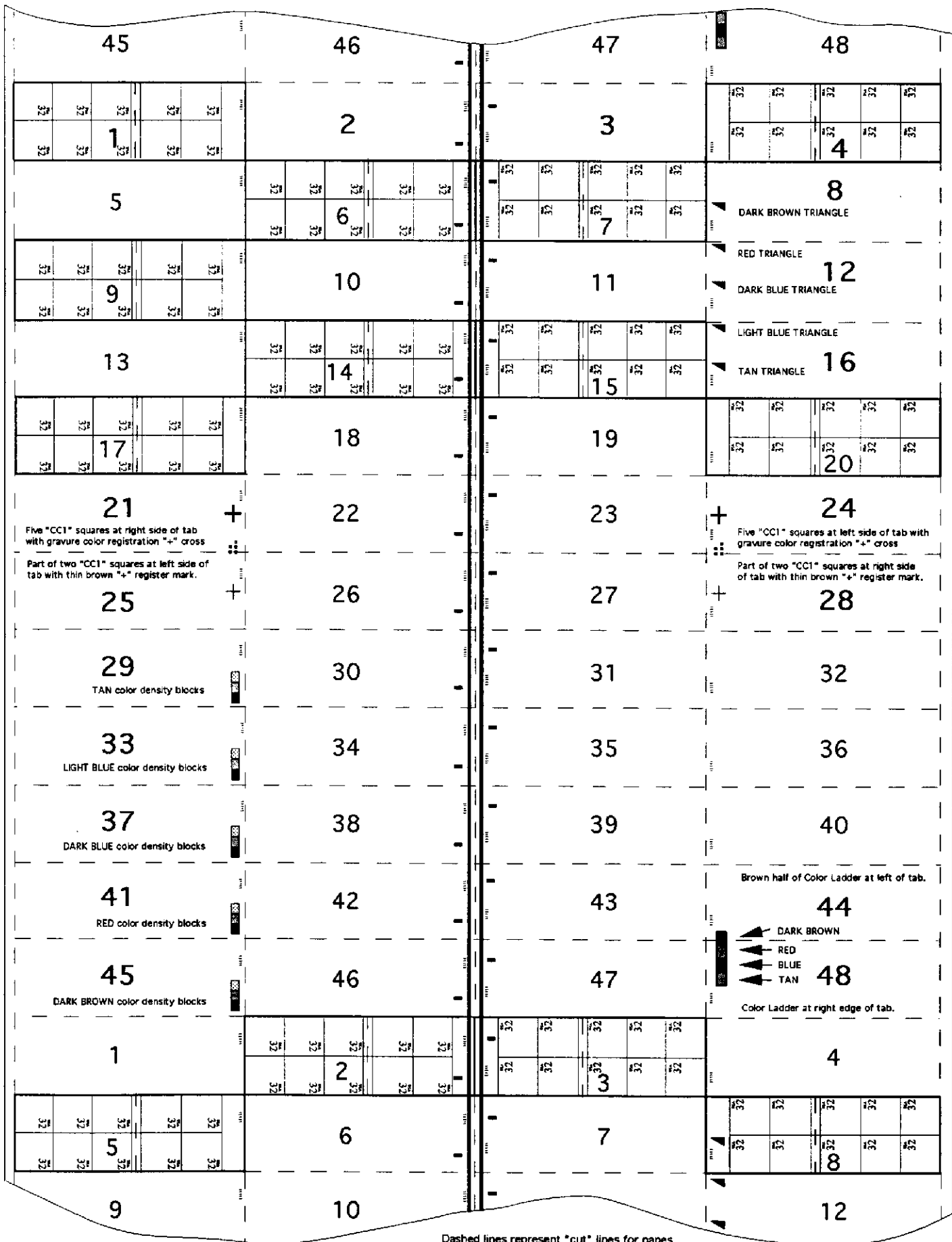
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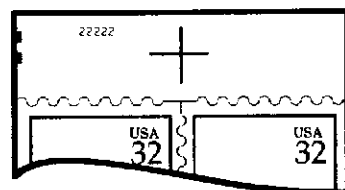
# \$6.40 SELF-STICK FLAG OVER PORCH BOOKLET PANE LAYOUT

This drawing represents a web segment printed from a set of gravure cylinders used for the \$6.40 self-stick 20-stamp booklets made by the Bureau of Engraving & Printing in 1996. While similar to the layout for regular gummed lick 'n' stick" booklet panes, the BEP had to make new cylinders to accommodate the peel strip located where the panes are folded. Panes from the right half of the web are inverted in relation to panes from the left half.

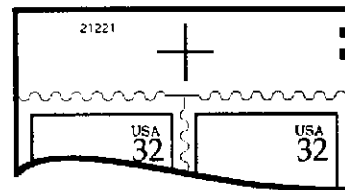


Dashed lines represent "cut" lines for panes.  
Large numbers represent arbitrary booklet pane positions.

\$6.40 Flag Over Porch Books			11111		13111			21221		22221		22222		44434			44444		55555		55556		66666	
			TN	MN	MN	US	EFO	TN	MN	TN	MN	TN	MN	MN	US	EFO	US	US	US	BONE	US			
Pos	Panes	Selvage Marks on BOTTOM pane																						
A	2 - 1, etc.	Plain tab																						
F	22 - 21	Color Register "+", CC1 squares @ right																						
G	26 - 25	Brown "+", 2 partial CC1 squares @ left																						
H	30 - 29	Tan "color density blocks"																						
I	34 - 33	Light Blue "color density blocks"																						
J	38 - 37	Dark Blue "density blocks"																						
K	42 - 41	Red "density blocks"																						
L	46 - 45	Dark Brown "color density blocks"																						
N	7 - 8	Dark Brown Triangle																						
O	11 - 12	Dark Blue and Red Triangles																						
P	15 - 16	Tan and Light Blue Triangles																						
R	23 - 24	Color Register "+", CC1 squares @ left																						
S	27 - 28	Brown "+", partial CC1 squares @ right																						
W	43 - 44	Half of Brown color ladder at left																						
X	47 - 48	Tan, Blue, Red, & Brown color ladder																						



Position 25 - Brown Register Mark with 2 partial CC1 squares at left. Note the "Valley" at beginning of horizontal "perforations" at LEFT side of the vertical "perforations".



Position 28 - Brown Register Mark with 2 partial CC1 squares at right. Note "Valley" at beginning of horizontal "perforations" at RIGHT side of the vertical "perfs".

**\* LEFT/RIGHT DIE CUT VARIETIES:**  
The following only applies to unfolded panes, and not panes found in booklets. The horizontal wavy die cut at the left or right of the vertical "perfs" can start with either a "valley" or a "hill" - panes from the left half of the web have a "valley" at the left while panes from the right half of the web have the "valley" at the right. Thus, position 1 and 4 (and position 2 and 3) panes can be differentiated. This can also be useful in identifying position 25 and 28 panes that don't show part of the two CC1 squares at the edges of the panes.

TN = IBC has Memphis, TN address; IFC has "© United States Postal Service"; OBC has large Recycle emblem.  
MN = IBC has 6-line Grand Rapids, MN address; IFC has "© United States Postal Service"; OBC has Recycle.  
US = IBC has 5-line Grand Rapids, MN address; IFC has "© USPS"; OBC has Recycle with 16631 UPC code.  
EFO = IBC has 5-line Grand Rapids, MN address; IFC has "© USPS"; OBC has Recycle with 16656 UPC code.  
BONE = IBC has 5-line Grand Rapids, MN address; IFC has "© USPS"; OBC has Marrow Donor Program text.  
NOTE: Many \$6.40 Flag over Porch booklets exist with either 5-1/4 or 8-3/4 gauge roulettes on the pane's removable center strip (measured by counting the number of slits per 2 cm); they are not listed at this time.

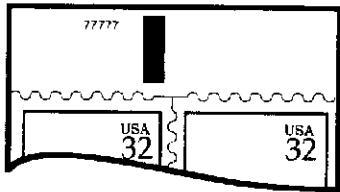
### Unfolded FOP Self-Stick Panes from \$6.40 booklet

POS	IDENTIFYING SELVAGE (TAB) MARKINGS	21221	22221	22222
1*	Plain - plate number at left ("valley" at left*)			
2*	CRL and LRM - (die cut perf "valley" at left*)			
3*	CRL and LRM - (die cut perf "valley" at right*)			
4*	Plain - plate number at left ("valley" at right*)			
8	Dark Brown Triangle over left stamp			
12	Dark Blue and Red Triangles			
16	Tan and Light Blue Triangles			
21	Color Register "+", 5 CC1 squares at right			
24	Color Register "+", 5 CC1 squares at left			
25	Brown "+" Mark, two CC1 squares at left			
28	Brown "+" Mark, two CC1 squares at right			
29	Tan "color density blocks" over right stamp			
33	Light Blue "density blocks" over right stamp			
37	Dark Blue "density blocks" over right stamp			
41	Red "color density blocks" over right stamp			
44	Portion of Brown color ladder at left edge			
45	Dark Brown "density blocks" over right stamp			
48	Tan, Blue, Red, and Brown color ladder at right			

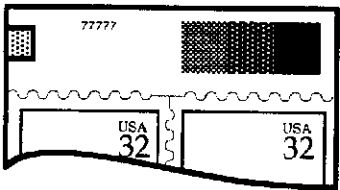
NOTE: Position 33 and 37 panes are hard to tell apart - the "light" and "dark" blue density blocks are similar.

## \$6.40 Self-Stick Flag Over Porch Books - revised plate layout

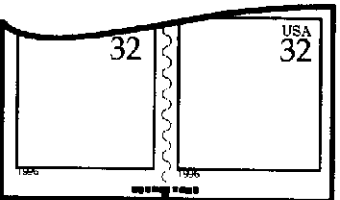
Pos.	Panes	Selvage Markings found on the BOTTOM pane	77777	88788	88888	99999
A	2 - 1	Dark Brown Triangle over right stamp				
B	6 - 5	Red and Dark Blue Triangles				
C	10 - 9	Light Blue and Tan Triangles				
D	14 - 13	Gravure Color Register "+" Mark in center of tab				
E	18 - 17	Thin Brown "+" Mark in center of tab				
F	22 - 21	CC1 squares in center of tab				
G	26 - 25	Tan "color density blocks"				
H	30 - 29	Light Blue "color density blocks"				
I	34 - 33	Dark Blue "color density blocks"				
J	38 - 37	Red "color density blocks"				
K	42 - 41	Brown, Red, Blue, & Tan Color Ladder above right stamp				
L	46 - 45	Tan color ladder at left, Brown Density Blocks at right				
M	3 - 4	Dark Brown 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 Gravure register mark @ bottom (due to miscut)				
Q	19 - 20	Part of thin brown register line @ bottom (due to miscut)				



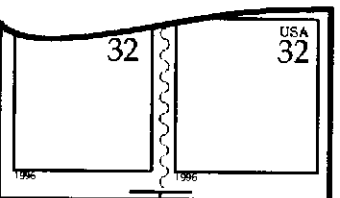
Position 4 - Brown Trigger Mark



Position 45 - Part of Color Ladder and Dark Brown Density Blocks



Pos. 16 - Gravure Color register mark at bottom edge of pane



Pos. 20 - Brown Line @ bottom

In early 1998, collectors found \$6.40 self-stick Flag over Porch booklets with a new outside back cover (National Marrow Donor Program). The panes in those initial books were printed from plates 77777. Later, the Bone Marrow covers were also found containing 55556 panes. While the new covers were interesting, the big news was that the BEP had changed the plate layout on the 77777 gravure cylinders. The location of the stamps was unchanged, but most register marks were relocated to accommodate a new inspection system. The layout drawing on page 43 shows the new positions for the registration markings. All of the register marks that used to be on the right side of the old web had to be moved to the left side to allow the new "Trigger Mark" to be placed in the tab of the position 4 pane (see illustration at the left).

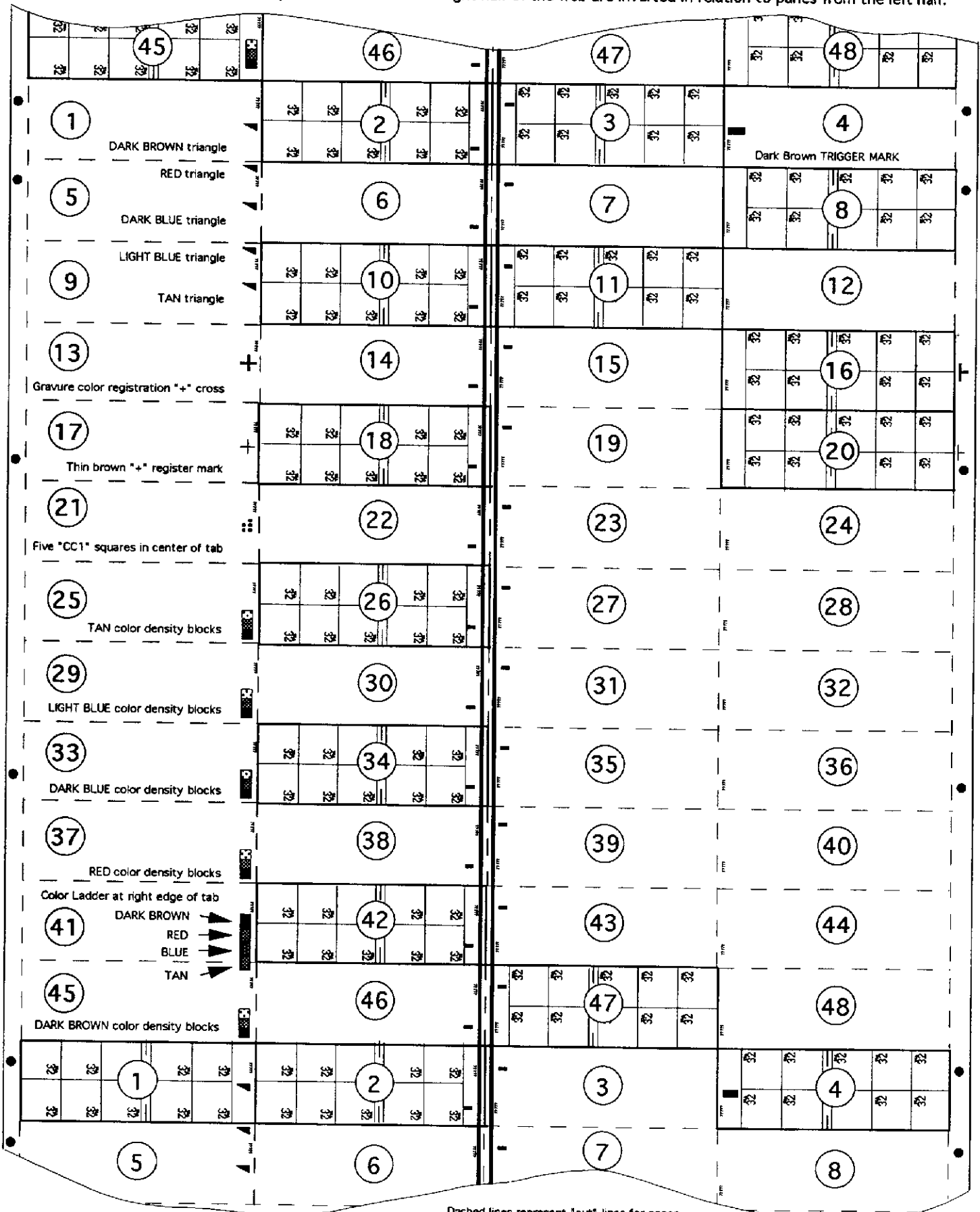
The BEP has experimented with new registration systems frequently as technology improves. That is why we have seen so many different sets of registration marks on booklets, coils, and sheet stamps over the last few years. The BEP's latest system is the Electronic Stamp Inspection System (SIS), and it requires the Trigger Mark found on the position 4 pane plus the eight dark brown dots ("Tie Points") found in the left and right margins. At this time, the SIS is being used as an off-line system to inspect printed rolls from all of the BEP's printing presses. 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.

Since the registration marks on the left side of the web are used during printing, the BEP will continue to print all the register marks that could be used on any press. The BEP can't mix the older cylinders (1 to 6) with the new ones (7 and above). Some "hybrid" 77777 and 88788 books were found with 8-3/4 scoring on one pane and 5-1/4 scoring on the other. Previously, both panes in a booklet had the same gauge rouletting (8-3/4 or 5-1/4).

Position 16 and 20 panes are unreported, and may not exist (they would require a miscut).

# REVISED \$6.40 SELF-STICK FLAG OVER PORCH LAYOUT

This drawing represents a web segment printed from gravure cylinders 77777 used for \$6.40 self-stick 20-stamp booklets first found in early 1998. While similar to the layout for \$6.40 self-stick Flag over Porch booklet panes listed on pages 40 and 41, the BEP made new cylinders to incorporate all of the "old" registration markings in the left column of panes, and then added a new mark on the right side of the web ("Trigger Mark" on the position 4 pane). The solid circles ("Tie Points") and two half-register crosses printed in the margins will only be found on miscut panes. Panes from the right half of the web are inverted in relation to panes from the left half.



Dashed lines represent "cut" lines for panes.  
Large numbers represent arbitrary booklet pane positions.