



IN HOUSE CAPABILITIES *and* PARAMETERS

All Digital Printing — Toner and Inkjet Presses

Quantity*: 50 – 2,500 Saddle-stitch & Perfect Binding // 50 – 500 Coil and Case Binding

*pre-approval is required for quantity outside of these amounts.

Color: One-Color and Four-Color

(black & white and CMYK applications)

BINDING:

- Saddle-stitch
- Plastic Coil
- Perfect w/hinge score
- Adhesive Hard Cover: Printed or Stamped Cloth Wrap

	◆◆ BOOK TRIM SIZE (W x H) ◆◆		Text Book-Block Bulk	
	Minimum	Maximum Printed	Minimum	Maximum
Saddle-stitch* ⁹	4.0" x <u>6.0"</u>	9.0" x <u>11.625"</u>	8 Pages	0.108" (0.216" Folded) <i>or</i> 96-pgs.
Plastic Coil * ¹	5.5" x <u>6.0"</u>	11.5" x <u>11.5"</u>	12 Pages	0.94" (1.81")
Perfect EVA 470 / 480 * ^{2 *⁹}	4.25" x <u>6.0"</u>	11.75" x <u>11.69"</u>	0.06"	2.38" / 2.44"
Perfect PUR 470 * ^{2 *⁹}	4.5" x <u>6.54"</u>	11.75" x <u>11.69"</u>	0.06"	2.38"
Perfect PUR SB-17 * ²	4.5" x <u>6.54"</u>	11.75" x <u>12.0"</u>	0.12"	1.85"
Case * ³	5.0" x <u>7.0"</u>	11.0" x <u>11.0"</u>	0.063"	2.04" (2.19") / 1.70"

◆ Non-Standard trim sizes are subject to additional production time and/or custom box availability.

◆ Not all book trim sizes are available for the toner press or for the roll coated stocks.

*¹ Coil Bound: Numbers listed are before adding the covers. The 1.81 coil book-block option requires pre-approval and has a limited print quantity.

*² Perfect Bound: Numbers listed are before adding the binding glue and cover sheet.

*³ Case Bound Text: Book-block weight cannot exceed six pounds. Bulk listed above is before adding the binding glue and end-sheets.

While we case-in books-block as small as 0.063" we recommend a minimum text book-block bulk of at least 0.094". Our minimum case-in cover spine width including the text pages and end-sheets is 0.313". The 2.19" cased-in book-block option requires pre-approval and has a limited print quantity. Toner press has a 1.70 maximum text book-block with or without a Dust Jacket*⁶. Roll stock text book-block with Dust Jacket*⁶ max is 1.85".

- Perfect & Case bound – Flat Back Spines
- Minimum printable spine bulk width to include type is 0.1875"
- Square or Landscape (oblong) size options will depend on the Binding style. Minimum height listed above is required. End-sheets will limit cased-in sizes.
- Saddle-Stitch – rounded spine, page count must be divisible by 4 | Max oblong book width is 9.0"
- Coil, Perfect & Case bindings – page count divisible by 2
- Contact us for a current Cover Layouts and Binding Guidelines

COVER TREATMENTS:

- Inside Cover Printing*⁴
- Lamination*⁵ – Gloss (lay-flat) | Matte (lay-flat) | Soft Touch Matte (scuff proof)
- Dust Jackets*⁶ (Max laminated area is 28" with 27.25 image print area)
- Stamping (not registered to an image)
- Blind Emboss (Perfect Bind only, not registered to an image)

ADDITIONAL SERVICES:

- Variable Data Printing, Scratch-Off
- Shrink-wrapping
- Drilling – Three-Hole and Five-Hole
- Perforation
- Kitting

*⁴ Perfect bound Books | Coil Bind | Saddle Stitch except on self-cover booklets

*⁵ Outside Cover Only | Lamination is required on: Perfect Bind, Printed Case and Dust Jacket Covers (recommend reviewing our book storage fact sheet)

*⁶ Dust Jackets require pre-approval. Max quantity of 250 and limited page count. Roll Stocks max pages, use the numbers listed under the SB-17 Binder Max.

MATERIALS

TEXT AND COVER STOCKS - are subject to change

Estimated page counts...																				
CONTINUOUS FEED (ROLL)	Coil		Booklets* ⁸		470 PUR & 470 - 480 EVA					480 EVA		Faster Binder								
	0.94"	1.81" REQUIRES PRE-APPROVAL	0.06"	0.108"	0.06"	2.38" Roll Toner see SB-17	0.063"	Roll+DJ see SB-17 Numbers	2.04" Roll 1.70" Toner	2.19" Roll REQUIRES PRE-APPROVAL	2.44"	0.12"	Perfect Min	Perfect Max						
33# White Offset	.0025	830	49	80	84.5	—	—	—	48	1904	50	1632	1752	1952	96	1480				
40# White Offset	.0029	688	59	92	88	—	—	—	42	1640	44	1406	1510	1682	84	1276				
50# White Offset - Pixelle	.0039	512	74.03	92	92	480	926	64	96	32	1220	34	1046	1122	1250	62	948			
60# White Offset * ⁸ - Pixelle	.0048	420	88.83	92	94	390	752	52	88	26	990	28	850	912	1016	50	770			
50# Cream HighBulk - Pixelle/Finch	.0050	400	74.03	81	74	374	722	52	84	24	952	26	816	876	976	48	740			
45# Matte Coated * ⁷	.0027	756	66.62	88	93	694	1338	—	—	46	1762	48	1510	1622	—	90	1370			
50# Matte Coated * ⁷ - Somerset	.0029	700	74.03	88	92	646	1244	—	—	42	1640	44	1406	1510	—	84	1276			
70# Matte Coated * ⁷ - Billerud	.0036	526	103.64	88	93	520	1002	68	96	34	1322	36	1132	1216	—	68	1028			
80# Gloss Coated * ⁷ - Billerud	.00354	564	118.44	97	96	530	1020	68	96	34	1344	36	1152	1236	—	68	1044			
Supplemental Stocks...										Estimated Min and Max Numbers are based on the expected calipers. If the book is within 50 pages of the listed max please confirm the current caliper.										
Treated Roll Stocks																				
CUT SHEET (Toner)	CALIPER	PPI	GSM	BRIGHT	OPACITY															
50# Opaque White	.0039	512	75	96	93.5	480	926	64	96	32	—	34	872	—	—	62	948			
60# Opaque White	.0046	434	90	96	95	408	784	56	92	26	—	28	738	—	—	52	804			
70# Opaque White	.0052	384	104	96	96	360	694	48	80	24	—	26	654	—	—	46	710			
80# Opaque White	.0061	328	118	96	96	306	592	40	68	20	—	22	556	—	—	40	606			
100# Opaque White	.0074	270	150	96	97	252	488	36	56	18	—	18	458	—	—	34	500			
70# Silk Coated	.0040	500	104	95	91.5	468	902	64	96	30	—	32	850	—	—	60	924			
70# Gloss Coated	.0034	588	104	93	91	552	1062	72	96	36	—	38	1000	—	—	72	1088			
80# Silk Coated	.0045	444	118	95	93.5	416	802	56	96	28	—	28	754	—	—	54	822			
80# Gloss Coated	.0038	526	118	93	93	494	950	68	96	32	—	34	894	—	—	64	972			
100# Silk Coated	.0056	344	148	95	97	334	644	44	76	22	—	24	606	—	—	44	660			
100# Gloss Coated	.0046	416	148	94	97	408	784	56	92	26	—	28	738	—	—	54	804			
COVER STOCK (Toner)										<ul style="list-style-type: none"> Mills could have up to a +/- 5 percent caliper fluctuation on all stocks. SB-17 PUR (Carousel) – Perfect bound books only per production. HP Press in-line Perforation Stock recommendations: 60lb – Preferred 50lb – light coverage only Book trim sizes, please reference the Perfect (PUR) numbers on the front of this sheet. 										
65# Opaque Smooth * ⁸	.0088	226	175	96	98.5															
80# Opaque Smooth	.0110	190	216	96	98.5															
100# Opaque Smooth	.0113	190	270	96	98.5															
80# Silk Coated	.0092	222	216	96	99															
80# Gloss Coated * ⁹	.0073	274	216	94	98.5															
100# Silk Coated	.0109	182	270	96	99															
100# Gloss Coated	.0090	216	270	94	99															
10pt. CIS * ⁸ 10pt. C2S	.0100	210	195 220	92	—															
12pt. CIS 12pt. C2S	.0120	166	230 260	92	—															
14pt. CIS 14pt. C2S	.0140	142	260 295	92	—															

COIL COLORS: *⁷

- Black
- White 101
- White 102 (soft)
- Clear
- Navy Blue
- Royal Blue
- Red
- Ruby Red
- Burgundy
- Forest Green
- Yellow
- Gold
- Silver

// Additional premium colors available for an extra charge and will require additional production time.

HEAD & FOOT BANDS:

- White
- Black & White
- Blue & White
- Red & White
- Green & White
- Black & Yellow
- Red & Yellow

END-SHEETS:

- 80# White
- 80# Off-White

CLOTH: A variety of Colors and Textured materials from **Skivertex**, **Roxite C**, and **Arrestox B** are subject to availability

FOIL STAMP COLORS: Gold Silver // Additional colors available for an extra charge and are subject to availability