

## 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* <sup>9</sup>	4.0" x <u>6.0"</u>	9.0" x <u>11.625"</u>	8 Pages	0.108" (0.216" Folded) or 96-pgs.
Plastic Coil * <sup>1</sup>	5.5" x <u>6.0"</u>	11.5" x <u>11.5"</u>	12 Pages	0.94" (1.81")
Perfect EVA 470 / 480 * <sup>2</sup> * <sup>9</sup>	4.25" x <u>6.0"</u>	11.75" x <u>11.69"</u>	0.06"	2.38" / 2.44"
Perfect PUR 470 * <sup>2</sup> * <sup>9</sup>	4.5" x <u>6.54"</u>	11.75" x <u>11.69"</u>	0.06"	2.38"
Perfect PUR SB-17 * <sup>2</sup>	4.5" x <u>6.54"</u>	11.75" x <u>12.0"</u>	0.12"	1.85"
Case * <sup>3</sup>	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.

\*<sup>1</sup> 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.

\*<sup>2</sup> Perfect Bound: Numbers listed are before adding the binding glue and cover sheet.

\*<sup>3</sup> 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\*<sup>6</sup>. Roll stock text book-block with Dust Jacket\*<sup>6</sup> 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\*<sup>4</sup>
- Lamination\*<sup>5</sup> – Gloss (*lay-flat*) | Matte (*lay-flat*) | Soft Touch Matte (*scuff proof*)
- Dust Jackets\*<sup>6</sup> (*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*)

\*<sup>4</sup> Perfect bound Books | Coil Bind | Saddle Stitch except on self-cover booklets

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

\*<sup>6</sup> 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.

### ADDITIONAL SERVICES:

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

TEXT AND COVER STOCKS - are subject to change

CONTINUOUS FEED (ROLL)	CALIPER	PPI	GSM	BRIGHT	OPACITY
33# White Offset	.0025	830	49	80	84.5
40# White Offset	.0029	688	59	92	88
50# White Offset - Pixelle	.0039	512	74.03	92	92
60# White Offset *8 - Pixelle	.0048	420	88.83	92	94
50# Cream HighBulk - Pixelle/Finch	.0050	400	74.03	81	92
45# Matte Coated *7	.0027	756	66.62	88	93
50# Matte Coated *7 - Somerset	.0029	700	74.03	88	92
70# Matte Coated *7 - Billerud	.0036	526	103.64	88	93
80# Gloss Coated *7 - Billerud	.00354	564	118.44	97	96

Supplemental Stocks...					
50# White Text Grade	.00385	512	74.03	92 Blue-White	89
50# White Offset - Finch	.0038	526	74	92 Blue-White	91
60# White Offset *8 - Finch	.0045	444	90	92	93
60# White Text Grade	.0042	476	88.83	91	90

Treated Roll Stocks					
CUT SHEET (Toner)	CALIPER	PPI	GSM	BRIGHT	OPACITY
50# Opaque White	.0039	512	75	96	93.5
60# Opaque White	.0046	434	90	96	95
70# Opaque White	.0052	384	104	96	96
80# Opaque White	.0061	328	118	96	96
100# Opaque White	.0074	270	150	96	97
70# Silk Coated	.0040	500	104	95	91.5
70# Gloss Coated	.0034	588	104	93	91
80# Silk Coated	.0045	444	118	95	93.5
80# Gloss Coated	.0038	526	118	93	93
100# Silk Coated	.0056	344	148	95	97
100# Gloss Coated	.0046	416	148	94	97

COVER STOCK (Toner)	CALIPER	PPI	GSM	BRIGHT	OPACITY
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		Booklets *8		470 PUR & 470-480 EVA				480 EVA	Faster Binder SB-17 PUR	
0.94"	1.81" REQUIRES PRE-APPROVAL Coil Max *1	0.06"	0.108"	0.06"	2.38" Roll Toner see SB-17	0.063"	Roll+DJ see SB-17 Numbers 2.04" Roll 170" Toner	2.44"	0.12"	1.85"
Preferred Coil Max		Preferred Stitch Max	Non-Preferred Stitch Max	Perfect Min *9	Preferred Perfect Max	Case Min *3	Preferred Case Max	Non-Preferred Perfect Max	Perfect Min	Perfect Max
—	—	—	—	48	1904	50	1632	1752	1952	96
—	—	—	—	42	1640	44	1406	1510	1682	84
480	926	64	96	32	1220	34	1046	1122	1250	62
390	752	52	88	26	990	28	850	912	1016	50
374	722	52	84	24	952	26	816	876	976	48
694	1338	—	—	46	1762	48	1510	1622	—	90
646	1244	—	—	42	1640	44	1406	1510	—	84
520	1002	68	96	34	1322	36	1132	1216	—	68
530	1020	68	96	34	1344	36	1152	1236	—	68
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.										
486	938	64	96	32	1234	34	1058	1136	1266	64
494	950	64	96	32	1252	34	1072	1152	1284	64
416	802	56	96	28	1056	28	906	972	1084	54
446	860	60	96	30	1132	30	970	1042	1162	58
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.										
480	926	64	96	32	—	34	872	—	—	62
408	784	56	92	26	—	28	738	—	—	52
360	694	48	80	24	—	26	654	—	—	46
306	592	40	68	20	—	22	556	—	—	40
252	488	36	56	18	—	18	458	—	—	34
468	902	64	96	30	—	32	850	—	—	60
552	1062	72	96	36	—	38	1000	—	—	72
416	802	56	96	28	—	28	754	—	—	54
494	950	68	96	32	—	34	894	—	—	64
334	644	44	76	22	—	24	606	—	—	44
408	784	56	92	26	—	28	738	—	—	54

- ♦ 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.
- \*7 Subject to availability
- \*8 Booklets: Self-Cover offset stock minimum text weight is 60#. Booklets with a covers are bound with either 65# Opaque Smooth Cover or 10pt CIS Cover. Stitcher GSM range is 64 uncoated or 80 coated to a max of 209. Recommend moving page counts that fall above the listed number in the "preferred stitch max" column to a perfect bound book.
- \*9 Perfect bound: Text book-block with a bulk under 0.14" (0.12+0.02 glue) are PUR and bound with 80# gloss cover. This applies to books with page counts under the minimum listed in the SB-17 binder column.

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