

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

BINDING:

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

| | ◆ ◆ BOOK TRIM SIZE (W x H) ◆ ◆ | | SPINE BULK | * Before End-sheets (+0.125) |
|---------------|--------------------------------|-----------------------------------|----------------|------------------------------|
| | Minimum | Maximum Printed | Minimum | Maximum |
| Saddle-stitch | 4.0" x 6.0" | 9.0" x 12.0" | 8 Pages | 0.094" |
| Plastic Coil | 6.0" x 6.0" | 11.5" x 11.5" | 0.125" | 0.75" |
| Perfect (EVA) | 4.5" x 6.0" | 12.0" x 11.7" | 0.06" | 2.40" |
| Perfect (PUR) | 4.7" x 6.54" | 12.0" x 12.0" | 0.06"/0.125" * | 1.87" |
| Case (EVA) * | 5.0" x 7.0" | 12.0" x 11.0" or 12.0" Foil Stamp | 0.125" * | 2.31" * |
| Case (PUR) * | 5.0" x 7.0" | 12.0" x 11.0" or 12.0" Foil Stamp | 0.125" * | 1.78" * |

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

◆ Not all book trim sizes are available for web coated stocks

* Case bound text: book-block weight cannot exceed six pounds

* 0.125 minimum bulk for orders binding on SP-17 and/or orders with quantities of 500 +

Notes:

- Perfect & Case bound – Flat Back Spines
- Minimum printable spine bulk with type is 0.1875"
- Landscape (oblong) format optional – *inquire about trim size parameters*
- Saddle-stitch – page count divisible by 4 with a max bulk of 0.094"
- Coil, Perfect & Case bindings – page count divisible by 2

COVER TREATMENTS:

- Inside Cover Printing
- Lamination – Gloss and Matte (*lay-flat*)
Soft Touch Matte (*scuff proof*)
- Stamping (*not registered to an image*)
- Blind Emboss (*not registered to an image*)

ADDITIONAL SERVICES:

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

MATERIALS

| TEXT AND COVER STOCKS - are subject to change | | | | Booklet | | SP-17 PUR | | | 470-480 EVA | | | | |
|---|------------|---------|------|-------------------------|---|-------------|-------------|----------|-------------|-------------|-------------|----------|------|
| | | | | Preferred Stitch Max | NON-Preferred Stitch Max | Perfect Min | Perfect Max | Case Max | Case Min | Perfect Min | Perfect Max | Case Max | |
| CONTINUOUS FEED (ROLL) | BRIGHTNESS | OPACITY | PPI | | | | | | | | | | |
| 33# White Offset * | 0.0025 | 80 | 84.5 | 830 | — | — | 84 | 1480 | 1400 | 58 | 34 | 1900 | 1828 |
| 40# White Offset * | 0.0029 | 92 | 88 | 688 | — | — | 70 | 1274 | 1210 | 50 | 28 | 1640 | 1578 |
| 50# White Offset | 0.0039 | 92 | 92 | 512 | 56 | 96 | 54 | 948 | 900 | 36 | 20 | 1220 | 1174 |
| 60# White Offset | 0.0048 | 92 | 94 | 420 | 44 | 76 | 42 | 770 | 730 | 30 | 18 | 990 | 954 |
| 50# Hi-Bulk Cream | 0.0050 | 74 | 92 | 400 | 44 | 72 | 48 | 746 | 710 | 30 | 24 | 960 | 924 |
| 45# Matte Coated ** | 0.0027 | 88 | 93 | 756 | — | — | 76 | 1370 | 1300 | 54 | 30 | 1762 | 1696 |
| 70# Silk Coated * | 0.0042 | 96 | 96 | 476 | 52 | 88 | 50 | 880 | 836 | 36 | 20 | 1132 | 1090 |
| 80# Gloss Coated * | 0.0036 | 93 | 93 | 552 | 60 | 104 | 56 | 1026 | 974 | 40 | 22 | — | — |
| CUT SHEET | | | | | <i>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.</i> | | | | | | | | |
| | BRIGHTNESS | OPACITY | PPI | | | | | | | | | | |
| 50# Opaque White | 96 | 93.5 | 512 | | 60 | 104 | 56 | 1026 | 974 | 40 | 22 | 1322 | 1272 |
| 60# Opaque White | 96 | 95 | 434 | | 48 | 80 | 44 | 804 | 762 | 32 | 18 | 1034 | 994 |
| 70# Opaque White | 96 | 96 | 384 | | 40 | 72 | 38 | 698 | 662 | 28 | 18 | 898 | 864 |
| 80# Opaque White | 96 | 96 | 328 | | 40 | 68 | 38 | 684 | 648 | 28 | 18 | 880 | 848 |
| 80# Satin Coated * | 92 | 93.5 | 478 | | 48 | 84 | 48 | 840 | 798 | 34 | 20 | — | — |
| 80# Gloss Coated * | 92 | 93.5 | 556 | | 60 | 100 | 56 | 1000 | 948 | 40 | 22 | — | — |
| 100# Satin Coated * | 92 | 95.5 | 364 | | 40 | 64 | 38 | 660 | 626 | 26 | 18 | — | — |
| 100# Gloss Coated * | 92 | 95.5 | 436 | | 44 | 76 | 44 | 770 | 730 | 30 | 18 | — | — |
| COVER STOCK | | | | | ♦ Mills could have up to a +/- 5 percent caliper fluctuation on roll stocks. | | | | | | | | |
| 100# Gloss Coated * | 92 | 99 | 210 | | ♦ Booklets – NON-Preferred Stitch Max are subject to additional fees, Recommend moving higher page counts to perfect binding. | | | | | | | | |
| 10pt. CIS * | 92 | N/A | 210 | | ♦ SB-17 PUR (Carousel) – High volume orders (500+) | | | | | | | | |
| 12pt. CIS ** | 92 | N/A | 167 | | ♦ HP Press in-line Perforation stock recommendations: 50lb – light coverage / 60lb (preferred) – medium to heavy coverage. | | | | | | | | |

* Subject to availability

* Not available for all binding styles

COIL COLORS: *

- Clear • White 101 • White 102 • Black • Yellow • Gold • Silver • Red • Ruby Red • Burgundy
- Forest Green • Royal Blue • Navy Blue // Additional premium colors available for an extra charge

HEAD & FOOT BANDS: • White • Blue & White • Red & White • Red & Yellow • Black & Yellow • Green & White

ENDSHEETS: • 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