

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* ⁸	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>	0.125"	0.95"
Perfect EVA 470 / 480 * ¹ * ⁸	4.25" x <u>6.0"</u>	11.75" x <u>11.69"</u>	0.06"	2.38" / 2.44"
Perfect PUR 470 * ¹ * ⁸	4.5" x <u>6.54"</u>	11.75" x <u>11.69"</u>	0.06"	2.38"
Perfect PUR SB-17 * ¹	4.5" x <u>6.54"</u>	11.75" x <u>12.0"</u>	0.12"	1.85"
Case * ²	5.0" x <u>7.0"</u>	11.0" x <u>11.0"</u>	0.063"	2.29" / 1.75"

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

*² Case Bound Text: book-block weight cannot exceed six pounds. Toner press has a 1.75 maximum book-block.

Bulk listed above is before adding end-sheets. While we case-in books-blocks 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 0.25". With a Dust Jacket see *⁵ (1.85" / 1.75")

- 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
- Coil, Perfect & Case bindings – page count divisible by 2
- Contact us for a current Cover Layouts and Binding Guidelines

COVER TREATMENTS:

- Inside Cover Printing*³
- Lamination*⁴ – Gloss (*lay-flat*) | Matte (*lay-flat*) | Soft Touch Matte (*scuff proof*)
- Dust Jackets*⁵ (*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*)

*³ Perfect bound Books | Coil Bind | Saddle Stitch except on self-cover booklets

*⁴ Outside Cover Only | Lamination is required on: Perfect Bind, Printed Case and Dust Jacket Covers (*recommend reviewing our book storage fact sheet*)

*⁵ 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)					Coil		Booklets*7		470 PUR & 470-480 EVA				480 EVA	Faster Binder SB-17 PUR	
CALIPER	PPI	BRIGHT	OPACITY		0.125"	0.95"	0.06"	0.108"	0.06"	2.38" Roll Toner see SB-17	0.063"	2.29" Roll Roll+Dj see SB-17 175" Toner	2.44"	0.12"	1.85"
Coil Min	Coil Max	Preferred Stitch Max	Non-preferred Stitch Max		Perfect Min*8	Preferred Perfect Max	Case Min*2	Case Max	Non-preferred Perfect Max	Perfect Min	Perfect Max				
33# White Offset	.0025	830	80	84.5	—	—	—	—	48	1904	50	1832	1952	96	1480
40# White Offset	.0029	688	92	88	—	—	—	—	42	1640	44	1578	1682	84	1276
50# White Offset - <i>Pixelle</i>	.0039	512	92	92	66	486	64	96	32	1220	34	1172	1250	62	948
60# White Offset - <i>Pixelle</i> *7	.0048	420	92	94	54	396	52	88	26	990	28	954	1016	50	770
50# Cream HighBulk - <i>Pixelle/Finch</i>	.0050	400	74	92	52	380	52	84	24	952	26	916	976	48	740
45# Matte Coated *6	.0027	756	88	93	96	704	—	—	46	1762	48	1696	—	90	1370
50# Matte Coated *6 - <i>Somerset</i>	.0029	700	88	92	88	654	—	—	42	1640	44	1578	—	84	1276
70# Matte Coated *6 - <i>Billerud</i>	.0038	526	88	93	68	500	64	96	32	1252	34	1204	—	64	972
80# Gloss Coated *6 - <i>Billerud</i>	.00354	564	97	96	74	536	68	96	34	1344	36	1294	—	68	1044
Supplemental Stocks...															
50# White Text Grade - <i>Gordon</i>	.00385	512	<i>Blue-White</i> 92	89	68	490	64	96	32	1234	34	1188	1266	64	960
50# White Offset - <i>Finch</i>	.0038	526	<i>Blue-White</i> 92	91	68	498	64	96	32	1252	34	1204	1284	64	972
60# White Offset - <i>Finch</i> *7	.0045	444	92	93	58	420	56	96	28	1056	28	1016	1084	54	822
60# White Text Grade	.0042	476	91	90	62	452	60	96	30	1132	30	1090	1162	58	880
Treated Roll Stocks															
CUT SHEET (Toner)					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.										
CALIPER	PPI	BRIGHT	OPACITY		66	486	64	96	32	—	34	896	—	62	948
50# Opaque White	.0039	512	96	93.5	56	412	56	92	26	—	28	760	—	54	804
60# Opaque White	.0046	434	96	95	50	364	48	80	24	—	26	672	—	48	710
70# Opaque White	.0052	384	96	96	42	310	40	68	20	—	22	572	—	40	606
80# Opaque White	.0061	328	96	96	34	256	36	56	18	—	18	472	—	34	500
100# Opaque White	.0074	270	96	97	64	474	64	96	30	—	32	874	—	60	924
70# Silk Coated	.0034	588	93	91	76	558	72	96	36	—	38	1028	—	72	1088
80# Silk Coated	.0045	444	95	93.5	58	422	56	96	28	—	28	776	—	54	822
80# Gloss Coated	.0038	526	93	93	68	500	68	96	32	—	34	920	—	64	972
100# Silk Coated	.0056	344	95	97	46	338	44	76	22	—	24	624	—	44	660
100# Gloss Coated	.0046	416	94	97	56	412	56	92	26	—	28	760	—	54	804
COVER STOCK (Toner)					♦ 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 reference the Perfect (PUR) numbers on the front of this sheet.										
CALIPER	PPI	BRIGHT	OPACITY												
65# Opaque Smooth *7	.0088	226	96	98.5											
80# Opaque Smooth	.0110	190	96	98.5											
100# Opaque Smooth	.0113	190	96	98.5											
80# Silk Coated	.0092	222	96	99											
80# Gloss Coated *8	.0073	274	94	98.5											
100# Silk Coated	.0109	182	96	99											
100# Gloss Coated	.0090	216	94	99											
10pt. CIS *7 10pt. C2S	.0100	210	92	—											
12pt. CIS 12pt. C2S	.0120	166	92	—											
14pt. CIS 14pt. C2S	.0140	142	92	—											

COIL COLORS: *6

- 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

*6 Subject to availability

*7 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. Recommend moving page counts that fall above the listed number in the "preferred stitch max" column to a perfect bound book.

*8 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.