

Perfect Binder

November 2016

The information below reflects the standards for this equipment. Please contact department manager for questions on projects that may fall outside of the standard. If you are unsure about any of the information, please check with manager or estimating.

21 pockets total (including 1 cover feeder)

Finished Minimum
4.71875 (face) x 6.25 (spine)

Finished Maximum
12 (face) x 15 (spine)

Covers – MUST score off line if 11pt or above Cover Stock Minimum – 100# Text

Note – Thicknesses = TEXT ONLY

Minimum Thickness: .0800

Maximum Thickness: 2.359375

Head Trim Minimum: .125”
Foot Trim Minimum: .125”
Face Trim Minimum: .125”
Minimum Grind: 0”

Head Trim Maximum: 1.25”
Foot Trim Maximum: 1.25”
Face Trim Maximum: .75”
Maximum Grind: .1875”

Modifiers

Name	MR Time	MR Waste	Run Speed	Run Waste
Additional Helper	N/A	N/A	N/A	N/A
Additional MR Minutes	Enter Additional Minutes	N/A	N/A	N/A
Additional MR Sheets	N/A	Enter Additional Sheets	N/A	N/A
2pg Inside Cover	0	0	Reduce 15%	N/A
Hand Feed ***MUST MANUALLY ADD IN HELPER	0	0	Reduce 75%	0
Pre-Collated Sigs	0	0	Reduce 50%	0
Thin Book	0	0	Reduce 25%	0
Oblong book	90 Minutes	0	Reduce 15%	0

Helpers Included

	1-3 Pocket	4-6 Pocket	7-9 Pocket	10-12 Pocket	13-15 Pocket	16-18 Pocket	19-21 Pocket
Perfect Bind	1	2	3	4	5	6	7

ADD 1 helper if covers are variable.

Grain Requirements

If Text is Grain Wrong – Cover must be Grain Wrong

If Text is Grain Right – Cover must be Grain Right

Equipment Notes

Thin Book Modifier – Use for books up to .125” thickness (entire book)

Anything thinner must get approval by production

Glue Slop – If cover is Matte Stock – MUST allow for glue slop (cannot go tight on head/foot)

Other Info

2 Passes OK – 500/hr on second pass

Indigo Book Blocks – Uses 2 Pockets with additional helper – 2 hr MR – Hand Feed

Sorting In Line

Add 1 helper for Variable Covers NO Slowdown

Use Table Sort (with appropriate sort rate) in Lettershop

Additional - may want to discuss with sales PUR binding – use best judgment

Things to consider :

Life of book

How book will be used

Document owner to approve spec sheet. After approval, deliver to Estimating Manager for final review. Approval by document owner and Estimating Manager is needed for update of controlled form.