

# Stitcher

September 2015

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.

## 10 Positions TOTAL (pockets &/or cover feeders) + 1 Hand Feed Station

Can only combine with the following:

4 Upright Pockets, 4 Lay Flat Pockets, 3 Cover Feeders

Also has:

Stitcher with Punch Production Code

Stitcher with Inkjet Production Code

Stitcher with Plow Fold & Glue Production Code

### Finished Minimum

3.5 (face) x 4.75 (spine)

### Untrimmed Minimum

3.625 (face) x 5.0625 (spine)

### 2up Finished Minimum

3.5 (face) x 3.9375 (spine)

### 2up Untrimmed Minimum

3.625 (face) x 8.25 (spine)

### Finished Maximum

12.1875 (face) x 18.625 (spine)

### Untrimmed Maximum

12.5625 (face) x 18.875 (spine)

### 2up Finished Maximum

12.1875 (face) x 9.8125 (spine)

### 2up Untrimmed Maximum

12.5625 (face) x 18.875 (spine)

### Cover Feeder

Minimum Flat 6.3125 x 5.0625 (spine)

Stock Minimum – 80# Text

– MUST Score Off-Line if 10pt or above

Note – Thicknesses = Finished Piece

Maximum Flat 24 x 18 (spine)

Maximum Thickness stitching: .375

Maximum Thickness 4<sup>th</sup>/5<sup>th</sup> Knife: .109375

Head Trim Minimum: .125

Foot Trim Minimum: .125

Face Trim Minimum: .125

Front Lap Minimum: .25 Sheetfed; .3125 WEB

Head Trim Maximum: 2"

Foot Trim Maximum: 2"

Face Trim Maximum: 1.5"

### 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
Final Fold after Stitch	20 Minutes	0	Reduce 60%	N/A
Hand Feed *MUST MANUALLY ADD IN HELPER	0	0	Reduce 85%	0
Oblong Book	0	0	Reduce 15%	0
Stitch 2up	60 Minutes	0	INCREASES run 40% based on Finished Quantity	0
Sucker Feed	0	0	Reduce 25%	0

### Helpers Included

	1-3 Pocket	4-6 Pockets	7-9 Pockets	10 Pockets
Stitch	2	3	4	5
Stitch w/ Punch	2	3	4	5
Stitch w/ Plow Fold & Glue	2	3	4	5

### Equipment Notes

Cover and Text must have matching head trims

2up format requires .25" gutter between books (Note: Add Helper)

Short Folded 6pg Cover – If inside panel is less than 3" (based on 8.5 x 11 size),

must glue at head (allow for .5" for glue at head)

### Other Info

*Punch: 8.5 x 11 Only; Standard 3 Hole Punch or 1 Hole Calendar Punch Only*

*.25 or .3125 diameters only*

*Maximum book thickness of .125*

### Additional Helper

Add for 2up books

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.