Horizon
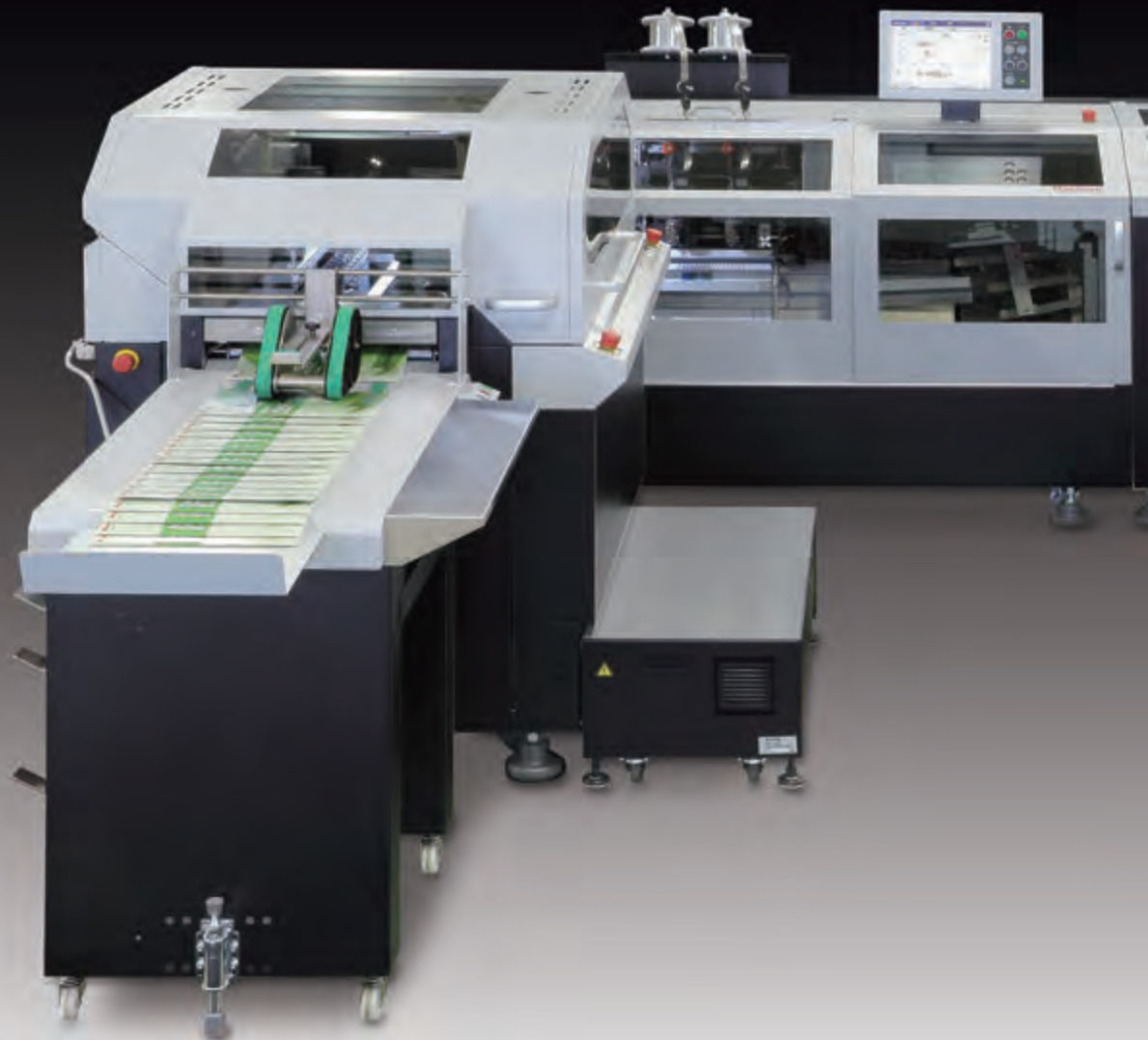
StitchLiner Series

Saddle-Stitching System StitchLiner MarkⅢ / StitchLiner6000 / StitchLiner5500

Revolutionary new concept in saddle-stitching Technology.

Combining the efficiency and ease of operation of flat sheet collating with the productivity, versatility and quality of a saddle-stitiching system.

VAC-600H(12 bins) + ST-CV + ST-40 + StitchLiner MarkⅢ

The saddle-stitching system combines all processes, from flat sheet collating, scoring, folding, and saddle-stitching through three knife trimming into a single operation.

The StitchLiner series provides user-friendly operation, high productivity and versatility for on demand, production print, and trade bindery environments. The StitchLiner MarkⅢ enables you to meet an expanded range of applications, with the highest throughput.

Features of StitchLiner Mark III

Horizon takes saddlestitching technology to the next level! The new StitchLiner Mark III delivers the highest quality booklets with greater efficiency than ever before!

The StitchLiner Mark III features expanded booklet size range and increased productivity up to 6,000 booklets per hour.

The system can produce a wider range of products, such as A4 landscape booklets and pocket booklets adding expanded application flexibility.

The system can be configured as a conventional collating system for offset print production and a high-speed sheet feeder for pre-collated digital production.

The StitchLiner Mark III enables you to meet the ever increasing requirements of the market.

SPF-40 Saddle-Stitcher
Sets are jogged, stitched and transported to three knife trimmer. Stitch length and balance are adjusted automatically according to thickness information.
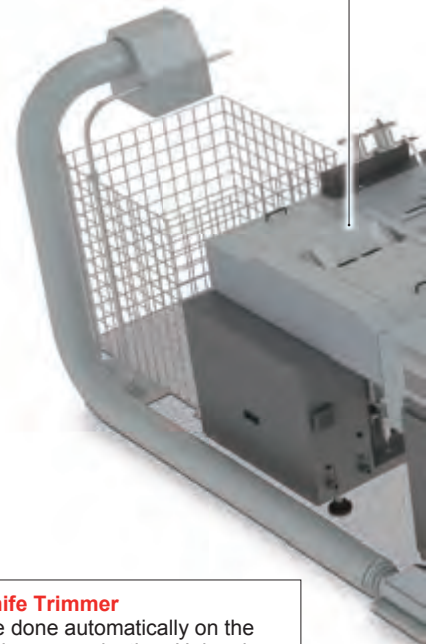
HTS-40 Three-Knife Trimmer
All the settings are done automatically on the fly for variable thickness production. Uniquely designed 4 side jogging achieves accurate trimming quality with 1-up or 2-up production.

Features

1. **Fully-automated Settings** - In addition to booklet format and thickness, all necessary adjustments which includes length and balance are automated.

2. **Higher Quality Booklet** - Professional quality production is achieved with newly designed systems for sheet transport and jogging, scoring and folding, stitch and fold monitoring, and positive jog register at the trimmer.

3. **Variable Thickness Production** - True end to end automation for variable thickness production. Variable stitch length and balance adjustment combined with variable thickness transport adjustment through the trimmer.

4. **A4 Landscape Stitching** - Expanded format size to meet A4 landscape large format calendar production. Higher productivity is achieved on a wider range of formats, including A4 landscape at over 5,000 per hour.

5. **Compatibility** - The StitchLiner Mark III can be integrated with the VAC series collator* and HOF-400 High-speed sheet feeder.
   *System does not have compatibility with VAC-100a and VAC-60Ha towers. Has to be VAC-1000a or VAC-600H. Middle tower and rear tower can be VAC-100m/c and VAC-60Hm/c.

AFC-40 Accumulator and Folder
Uniquely designed accumulating and folding section achieves high quality and high speed production with a wider range of substrates and formats.

ST-40 Bypass Stacker
Straight or offset stacking can be achieved across a wide range of substrates. Serves as a bypass and error reject station for booklet production.

VAC-1000/600H Collator Series
Conventional flat sheet collator which is used for collation of offset printed work.

HIF-400 Hybrid Conveyor
The HIF-400 connects the HOF-400 with the collator to process digital and/or offset applications in one system.

AC-400 Accumulator
The AC-400 accumulates the sheets from the HOF-400 for higher productivity and auto-reject of errored sets.
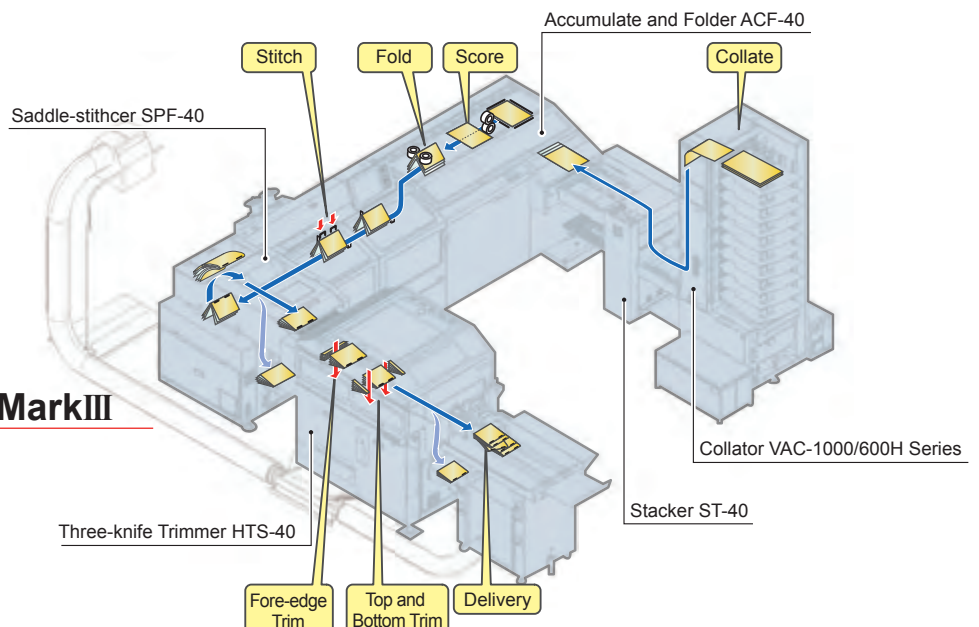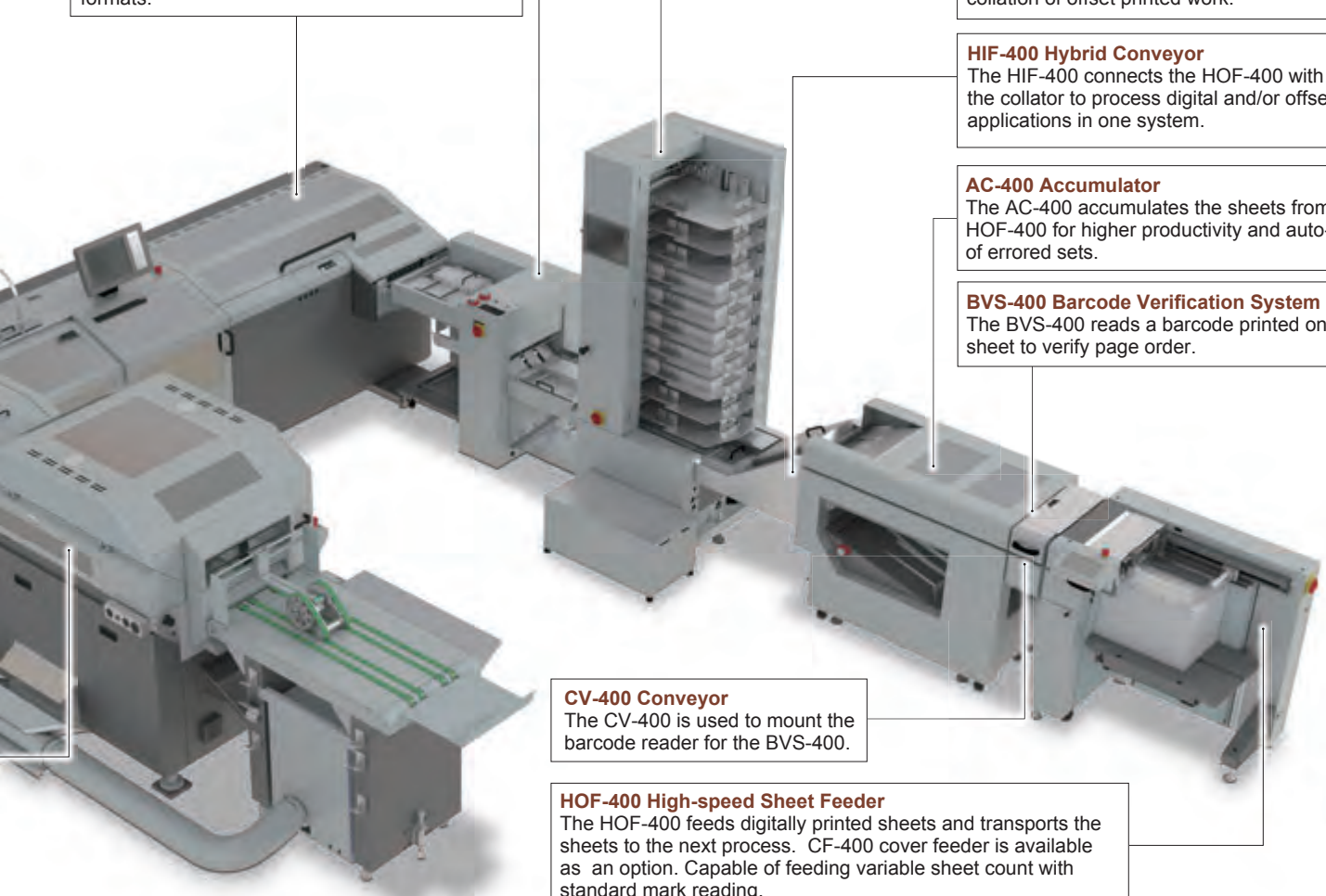
BVS-400 Barcode Verification System
The BVS-400 reads a barcode printed on each sheet to verify page order.

CV-400 Conveyor
The CV-400 is used to mount the barcode reader for the BVS-400.

HOF-400 High-speed Sheet Feeder
The HOF-400 feeds digitally printed sheets and transports the sheets to the next process. CF-400 cover feeder is available as an option. Capable of feeding variable sheet count with standard mark reading.
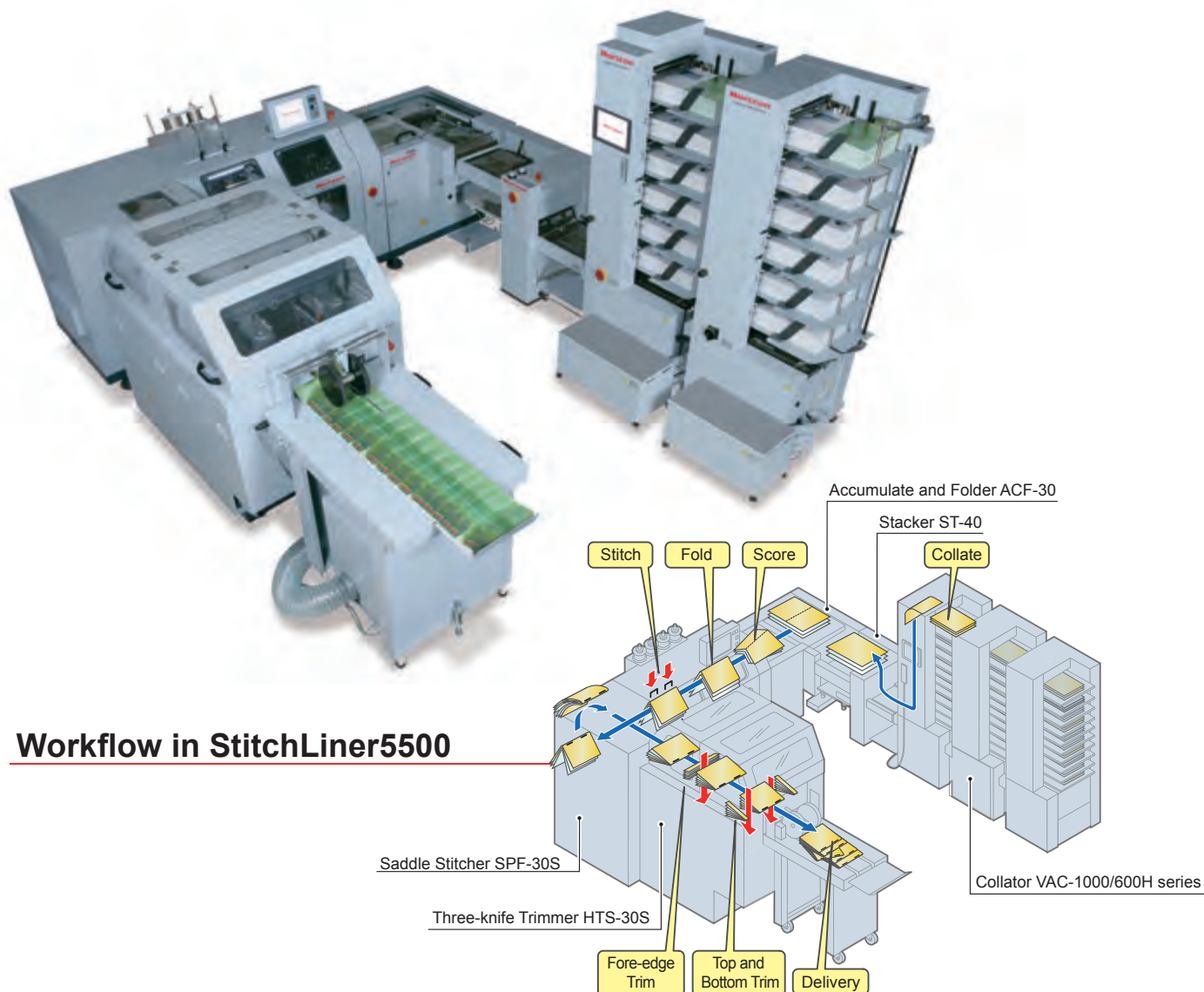
Sheet Flow in StitchLiner MarkⅢ

Stitch Fold Score Accumulate and Folder ACF-40 Collate

Saddle-stithcer SPF-40

Collator VAC-1000/600H Series

Stacker ST-40

Three-knife Trimmer HTS-40

Fore-edge Trim Top and Bottom Trim Delivery

System Features of StitchLiner5500/6000

StitchLiner5500

At up to 5,500 booklets per hour with quick-changeover, the StitchLiner5500 is ideal for short, medium and long production runs.

Workflow in StitchLiner5500

Stitch | Fold | Score | Accumulate and Folder ACF-30 | Stacker ST-40 | Collate

Saddle Stitcher SPF-30S

Three-knife Trimmer HTS-30S

Fore-edge Trim | Top and Bottom Trim | Delivery
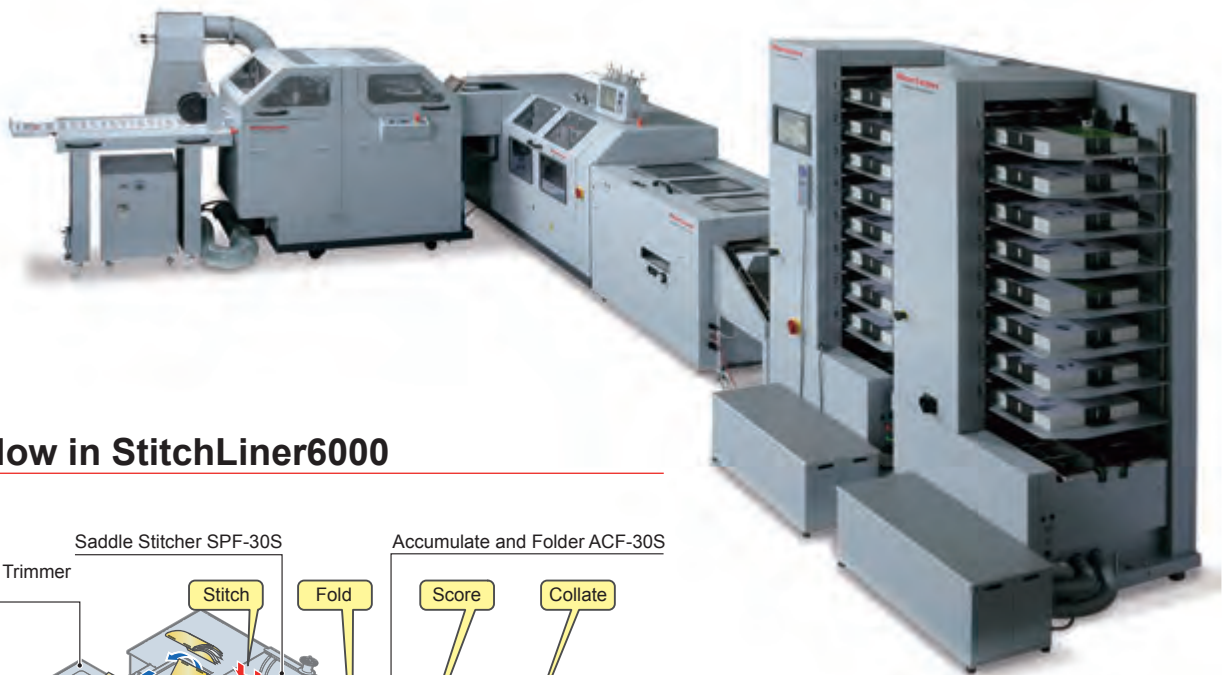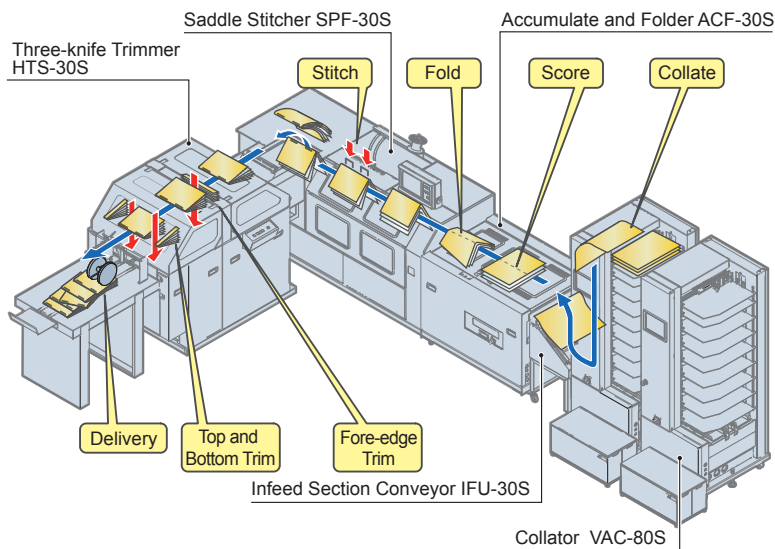
Collator VAC-1000/600H series

Features

1. **User-friendly Operation** - User-friendly operation through the color touch screen and accurate automation achieve short make-ready for quick turnaround.

2. **In-line Folding** - Folding is performed in-line to simplify the saddle-stitching workflow and improve operational efficiency.

3. **Flexible System Configuration** - Various operational devices are available for both offset and digital printing.

4. **Work Efficiency** - The convenient U-shaped layout allows the operator to monitor work in progress.

StitchLiner6000

At up to 6,000 booklets per hour, the StitchLiner6000 is ideally suited for landscape-oriented booklets.

Workflow in StitchLiner6000

Three-knife Trimmer HTS-30S

Saddle Stitcher SPF-30S

Accumulate and Folder ACF-30S

Stitch

Fold

Score

Collate

Delivery

Top and Bottom Trim

Fore-edge Trim

Infeed Section Conveyor IFU-30S

Collator VAC-80S

Features

1. **User-friendly Operation** - User-friendly operation through the color touch screen and accurate automation achieve short make-ready for quick turnaround.

2. **In-line Folding** - Folding is performed in-line to simplify the saddle-stitching workflow and improve operational efficiency.

3. **Meet the Variable Needs** - Newly designed landscape feeding and straight saddle-stitching flow handles thinner paper stock and feeds larger, landscape-oriented sheets.

4. **Efficient Work Space** - Ergonomic L-shaped configuration for efficient operation and space savings.

VAC series

Horizon's unique rotary suction feeding system operates effectively on a wide range of paper stocks.

Rotary Suction Feeding

- Horizon's unique rotary suction feeding system can feed paper weights from very light weight to heavy cover stocks and pre-folded sheets.
- The feed wheel employs a special, highly durable rubber for totally mark-less feeding.
- Feed height sensors and air blowers allow a wide range of sheets to be fed.

What is rotary suction feeding?

Air is blown into the stack to float the sheets. The air rotor then picks-up the top sheet and rotates to advance the sheet.

Air-suction Feeding

3. Rotates to advance the sheets.
2. Picks-up the top sheet.
1. Air is blown into the stack to float the sheets.
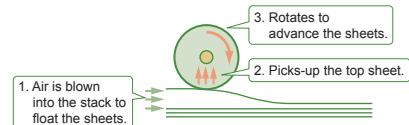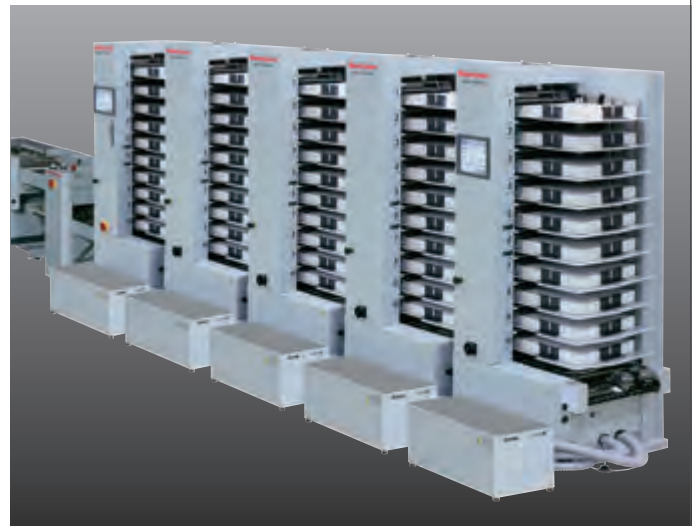

For StitchLiner5500 / StitchLiner MarkIII

VAC-1000

Stable collation for a wide variety of paper stocks. Suitable for multiple page jobs.

- Advanced programming functions are available such as double cycle for non-stop operation and sub-setting for higher sheet count production.
- Capable of accomodating the increased sheet length of StitchLiner MarkIII (610 mm or 24.015")
- The VAC-1000 is expandable up to 6 towers, 60 feed bins.

- Bin Pile Height: Max. 55 mm or 2.16"
- Sheet Size: Max. W350 x L500 mm or W13.77" x L19.68"
  Min. W148 x L148 mm or W5.83" x L5.83"
  * Optional support guides are capable of handling the 120 mm or 4.73" width sheet at minimum and the expanded sheet length of 610 mm or 24.015".
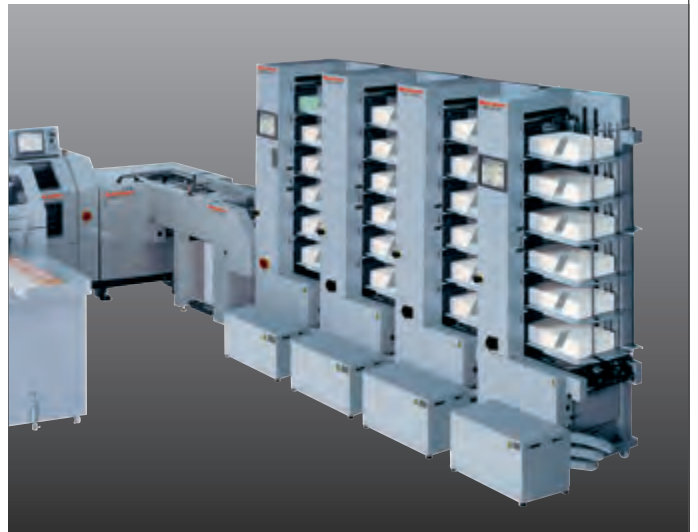
For StitchLiner5500 / StitchLiner MarkⅢ

VAC-600H

Maximum pile height is 130 mm or 5.11".
Suitable for longer run production.

- Each bin has 130 mm or 5.11" pile height capacity. Compared to the VAC-1000, the bin capacity is 2.4 times greater for longer run production.
- Advanced programming functions are available such as double cycle for non-stop operation and sub-setting for higher sheet count production.
- Optional image checking system (IC2-V600) is available for higher quality control.
- The VAC-600H is expandable up to 6 towers, 36 feed bins.

  - Bin Pile Height: Max. 130 mm or 5.11"
  - Sheet Size: Max. W350 x L500 mm or W13.77" x L19.68"
    Min. W120 x L148 mm or W4.73" x L5.83"

For StitchLiner6000

VAC-80S

Equipped with 8 landscape feeding stations.
Maximum production speed is 6,000 booklets per hour.

- The VAC-80S is equipped with a sheet alignment mode to reduce jams in the ACF-30S and down time for uninterrupted operation.
- Advanced programming functions are available such as double cycle for non-stop operation and sub-setting for higher sheet count production.
- Optional image checking system (CCD-VAC80S) is available for higher quality control.
- The VAC-80S is expandable up to 6 towers, 48 feed bins.

  - Bin Pile Height: Max. 80 mm or 3.14"
  - Sheet Size: Max. W500 x L350 mm or W19.68" x L13.77"
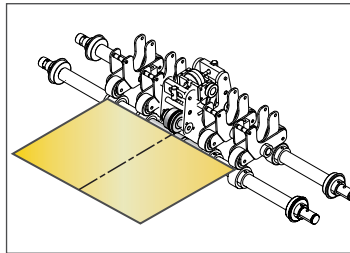   Min. W199 x L140 mm or W7.84" x L5.52"

ACF-40/30/30S

Accurate sheet registration, scoring and folding. In-line plow fold mechanism eliminates unnecessary folding steps.

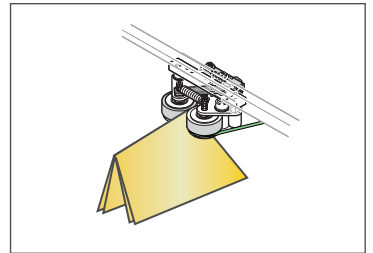## Operation Process and Sheet Flow

1 Jogging
2 Scoring
3 Folding
4 To Stitch Section

* Shown with ACF-30S.
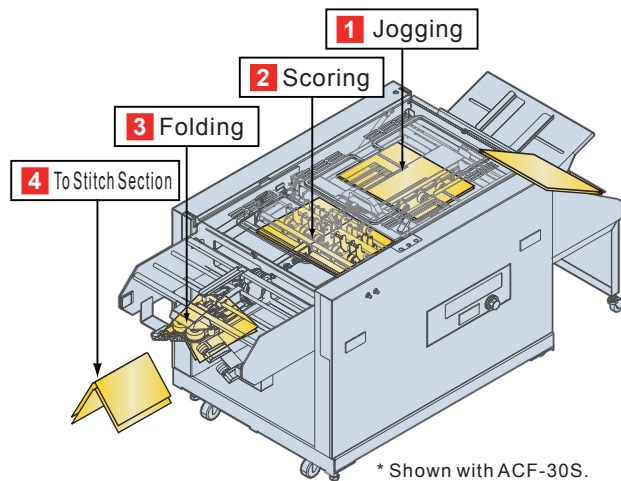
2 Scoring Section

Scoring with the upper and lower rollers.

3 Fold Section

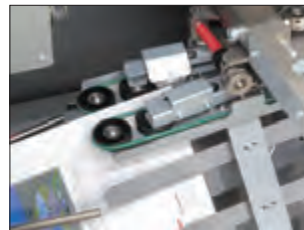Plow-folding with the belt and rollers.

For StitchLiner MarkIII

ACF-40

Jog Section

Uniquely designed transport and jogging mechanism achieves high speed production with a wider range of substrates and formats.

Scoring Section

Scoring function to reduce crack on the spine and tighter folding quality. Adjustable gap and creasing pressure to apply suitable creasing quality depending on substrate.
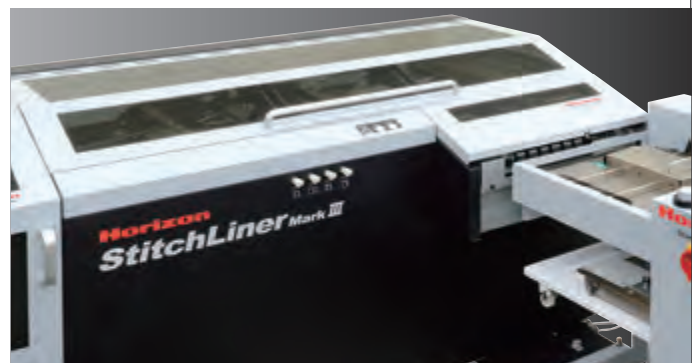
Fold Section

Folding function for high quality fold for a wider range of substrates and formats. Improved folding mechanism for sharper and tighter folding quality with improved accuracy.

For StitchLiner5500

ACF-30

Jog Section

The jog guides are adjusted automatically according to the sheet size input on the SPF-30S. The gathered sheets are accumulated, jogged, registered and transported at a right angle to the scoring section.

Scoring Section

The jogged set is precisely scored on the center of the sheet. The number of sheets per folded section can be divided and then scored to insure a tightly folded booklet.

Fold Section

The scored sheets are folded reliably along the score line by a continuous series of forming rollers. The pressing rollers insure a sharp, tight fold.

For StitchLiner6000

ACF-30S

Jog Section / Scoring Section

Gathered sheets are jogged on all four sides and registered firmly. The jogged set is precisely scored in the scoring section to produce a tight folded booklet.

Other Functions

The ACF-30S is equipped with a hand feed unit for off-line bookletmaking and a misfeed tray for non-stop operation.
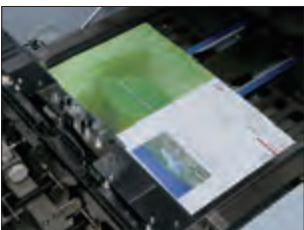
Fold Section

The scored sheets are folded reliably along the score line by a continuous series of forming rollers. The pressing rollers insure a sharp, tight fold.

SPF-40

The SPF-40 handles booklets up to 10 mm thick. Fully automated settings enable a high finishing quality.

For StitchLiner MarkIII

Color Touchscreen

Each finishing station is automatically set in less than 10 seconds (A3 to A4 / 11" x 17" to 8.5" x 11") by simply inputting the sheet size and booklet size on the color touchscreen. Up to 999 different jobs can be saved for instant job recall.

Stitching Section

Stitch position, stitch length and balance, stitch detection sensor position are all automated. (*Note)Extended stitch distance adjustment for a wider range of applications. Various stitching options, including, loop stitching, four stitching and center stitching are available.

* SPF-30S: 66 through 150 mm, SPF-40: 64 through 176 mm

Maintenance and Other Features
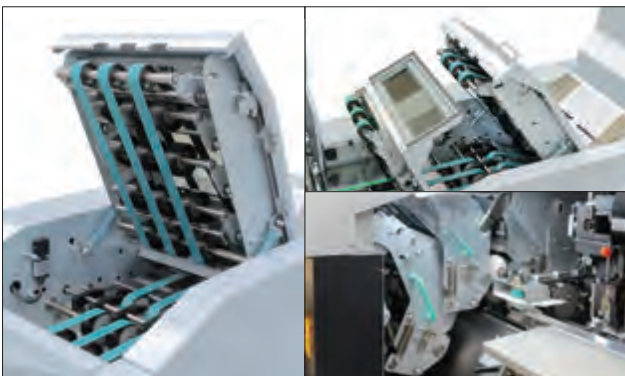
Two reject stations to reject mis-stitched, fold skews, and thickness errors. Only good books arrive on delivery conveyor. In addition, accessibility is greatly improved for maintenance and jam removal.

Reject Tray

SPF-30S

Saddle Stitcher

**Quick changeover and professional quality...
Handles booklets up to 10 mm thick.**

For StitchLiner5500/6000

Color Touchscreen

Each finishing station is automatically set in less than 30 seconds (A4 to A5 / 8.5" x 11" to 5.5" x 8.5") by simply inputting the sheet size and booklet size on the color touchscreen.

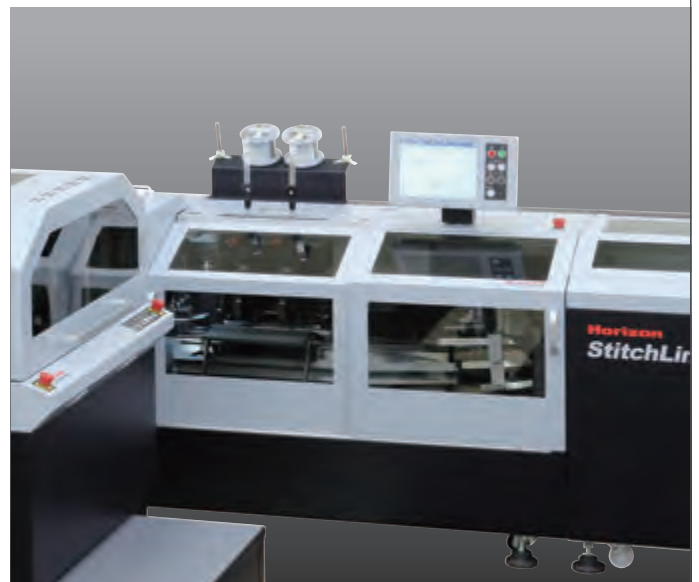Five steps of speed mode and jog delay time can be adjusted depending on the sheet condition or finishing size. Up to 200 different jobs can be saved for instant job recall.

Stitch Section

Booklets up to 10 mm thick (50 sheets of normal 80 gsm /50lb. paper) can be stitched. The folded sets are jogged from the head and foot, then centered on the saddle by the centering mechanism before the heavy-duty stitching

heads produce accurately stitched booklets. The stitch wire length is automatically adjusted according to the book thickness. Optional devices are available for a wide variety of applications such as 4-stitching and loop stitching.

Stitching Process and Sheet Flow in SPF-30S

3 Transfer

2 Stitching

1 Jogging
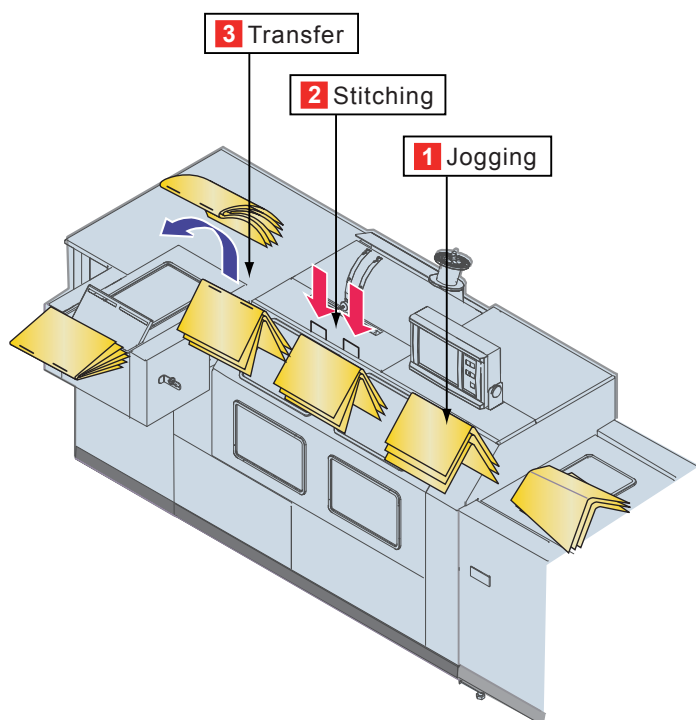
Other Features

The bad booklets are detected and ejected to the misfeed tray before they are transported to the HTS-30. This enables continuous operation.

HTS-40

The newly developed trimmer achieves even higher accuracy of trimming and finish quality on a wider range of formats and variable thickness booklets. The three-knife trimmer enables you to deal with a variety of jobs.

For StitchLiner MarkIII

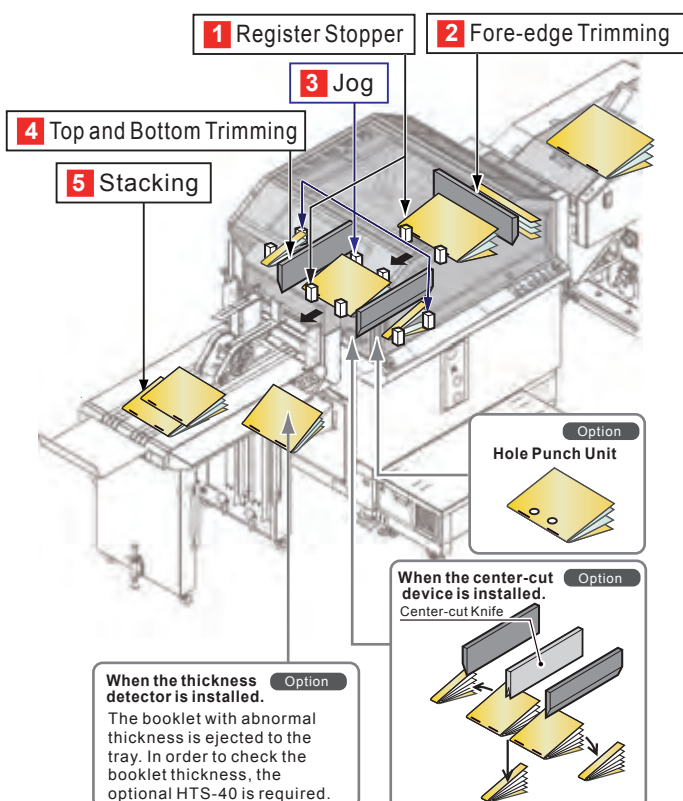### Infeed Section and Fore-edge Trim Section

Newly designed booklet transport system provides controlled transport of booklets into the trimming section at higher speeds, even with lighter substrates and thinner booklets.

Top and Bottom Trim Section

Booklet is jogged on four sides for accurate and consistent trimming quality. Uniquely designed air assisted trim removal to drop the trim waste efficiently. Optional center cut knives are available for 2 up production.

HTS-40 Trimming Process and Sheet Flow

1 Register Stopper   **2** Fore-edge Trimming

3 Jog

4 Top and Bottom Trimming

5 Stacking

Hole Punch Unit Option

When the center-cut device is installed. Option
Center-cut Knife

When the thickness detector is installed. Option
The booklet with abnormal thickness is ejected to the tray. In order to check the booklet thickness, the optional HTS-40 is required.

Conveyor Section
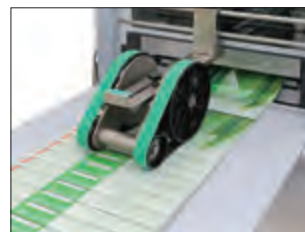
Newly designed delivery conveyor to consistently deliver finished booklets. Automated positioning of delivery roller and expended conveyor are available as an option. The optional PK-30 preset kicker can be used in a conventional manner.

HTS-30S

Three-knife Trimmer

**Professional-quality three-knife trimming applies the final finish.
A center-cut option enables two-up production.**

For StitchLiner5500/6000

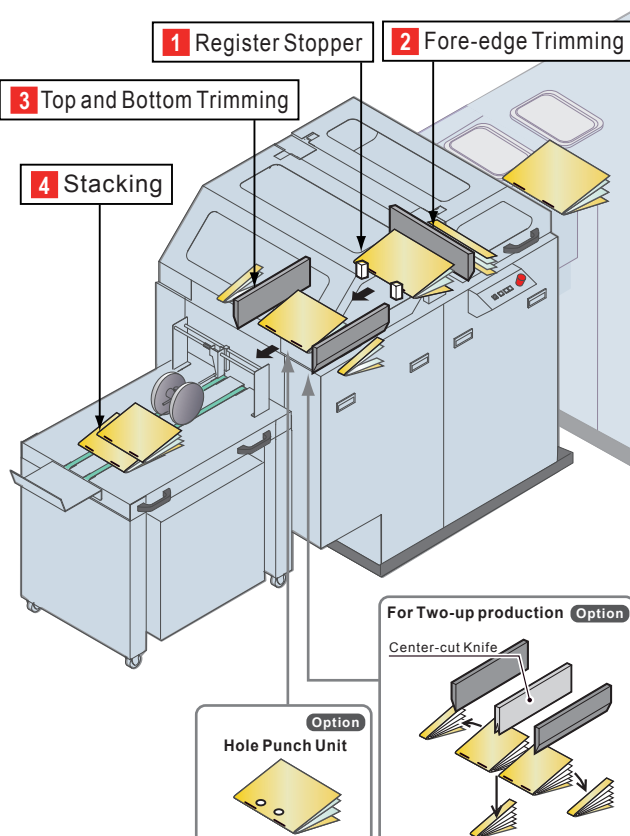### Fore-edge Trim Section

The servo-motor controlled feed mechanism provides for accurate booklet registration and fore-edge trimming. The guide is automatically adjusted according to the sheet size input on the touchscreen on the SPF-30S.

Top and Bottom Trim Section

The top and bottom of the booklet are trimmed accurately, and trimming waste is smoothly extracted from the trim box to a movable chute with a powerful air blower. An optional center knife device can be fitted for two-up booklet production.

Conveyor Section

Finished booklets are neatly delivered to the exit conveyor. An optional preset kicker PK-30 separates a batch of booklets at a predetermined count.
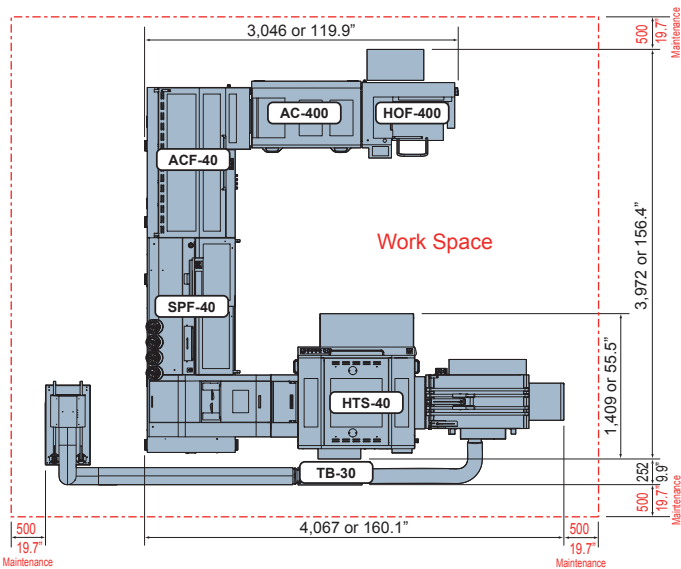
Trimming Process and Sheet Flow in HTS-30S

1 Register Stopper
2 Fore-edge Trimming
3 Top and Bottom Trimming
4 Stacking

For Two-up production Option
Center-cut Knife

Option
Hole Punch Unit

System Configuration

StitchLiner MarkⅢ

Machine Dimensions and Installation Space (Unit : mm or inch)

Height : 1,962 mm or 77.3" (VAC-600H)

- 3,046 or 119.9"
- AC-400
- HOF-400
- ACF-40
- Work Space
- SPF-40
- HTS-40
- TB-30
- 3,972 or 156.4"
- 1,409 or 55.5"
- 500 / 19.7" Maintenance
- 252 / 9.9"
- 500 / 19.7" Maintenance
- 500 / 19.7" Maintenance
- 4,067 or 160.1"
- 500 / 19.7" Maintenance

System Configuration

StitchLiner MarkⅢ
CV-400
CF-400
AC-400
HOF-400

- 5,619 or 221.2"
- 810 or 31.9"
- 500 / 19.7" Maintenance
- 500 / 19.7" Maintenance
- ST-40
- VAC-1000
- VAC-1000
- VAC-1000
- VAC-1000
- ACF-40
- Work Space
- SPF-40
- HTS-40
- TB-30
- 3,671 or 144.5"
- 1,409 or 55.5"
- 252 / 9.9"
- 500 / 19.7" Maintenance
- 4,067 or 160.1"
- 500 / 19.7" Maintenance

StitchLiner MarkⅢ
ST-40
VAC series
ST-CV

16

StitchLiner MarkⅢ Specifications

Finishing Type	Saddle Stitch, Fold and Trim
Sheet Size	**Width x Length** Portrait Max. : 356 x 508 mm or 14.015" x 20.000" Landscape Max. : 267 x 610 mm or 10.510" x 24.015" Min. 140 x 194 mm or 5.515" x 7.640" * Max 356 mm x 610 mm or 14.015" x 24.015" can de processed depending on substrate weight and condition. A3 / B4 / A4 / B5 / A5 11" x 17" / 8.75" x 11.25" / 8.5" x 11" / 9.75" x 10.25" / 5.5" x 8.5"
Untrimmed Booklet Size	**Width x Length** Portrait Max. : 356 x 254 mm or 14.015" x 10.000" Landscape Max. : 267 x 305 mm or 10.510" x 12.005" Min. : 140 x 97 mm or 5.515" x 3.820" [2] * Max 356 mm x 305 mm or 14.015" x 12.005" can be finished depending on substrate weight and condition. A4 / A4E / A5 / B5 / B6 / A6 11" x 8.5" / 8.5" x 11" / 8.5" x 5.5" / 10.25" x 9.75"
Finished Booklet Size	**Width x Length** Portrait Max. : 352 x 252 mm or 13.855" x 9.920" Landscape Max. : 263 x 303 mm or 10.350" x 11.925" Min. : 120 [1] x 85 mm or 4.725" x 3.350" * Max 352 mm x 303 mm or 13.855" x 11.925" can be finished depending on substrate weight and condition.
Sheet Weight Range	Normal Paper : 52.3 to 350 gsm Coated Paper : 73.3 to 350 gsm
Fold Thickness	Max. : 2 mm or 0.075" (Thickness of one block)
Stitch Thickness	Max. : 5 mm or 0.195" (Booklet Thickness 10 mm or 0.390") (About 50 sheets of Normal Paper 81.4 gsm)

Stitch Distance	**Two Stitch**
	With Centering Device: 64 to 176 mm or 2.520" to 6.925"
	Without Centering Device: 53 to 176 mm or 2.090" to 6.925".
	
	Three Stitch (Requires the B-40C kit)
	• When using the standard head blocks and center block:
	  With Centering Device
	  Stitch Distance Right and Left 64 to 88 mm or 2.520" to 3.460"
	        Overall 128 to 176 mm or 5.040" to 6.925"
	  Without Centering Device
	  Stitch Distance Right and Left 53 to 88 mm or 2.090" to 3.460"
	        Overall 106 to 176 mm or 4.175" to 6.925"
	• In case of using the outside head blocks for four stitcher heads and center block:
	  Stitch Distance Right and Left 106 to 120 mm or 4.175" to 4.720"
	        Overall 212 to 240 mm or 8.350" to 9.445"
	        (Independent of centering device)
	Attention
	When doing three stitches, this cannot be done in the range where the overall measurement is 176.1 to 211.9 mm or 6.935" to 8.340".
	
	Four Stitch (Requires the B-40S kit)
	With Centering Device
	Stitch Distance Inside 64 to 112 mm or 2.520" to 4.405"
	    Right and Left 64 to 88 mm or 2.520" to 3.460"
	    Overall 192 to 240 mm or 7.560" to 9.445"
	Without Centering Device
	Stitch Distance Inside 53 to 134 mm or 2.090" to 5.275"
	    Right and Left 53 to 93.5 mm or 2.090" to 3.680"
	    Overall 159 to 240 mm or 6.260" to 9.445"

Stitch Heads	Standard Equipment : Two stitcher heads Option : Additional stitcher heads for three or four stitches (The B-40C kit for three stitches or the B-40S kit for four stitches is required.)
Stitching Wire	Standard: 0.5 mm (No.26) The wire of 0.4 to 0.6 mm diameter can be installed on the standard stitcher head.
Trim Width	Fore Edge : Max. 25.4 mm or 1.000" Min. 2 mm or 0.080" Top and Bottom : Max. 25.4 mm or 1.000" Min. 2 mm or 0.080"
Trim Thickness	Max. 10 mm or 0.390"
Center Cut (Option)	**• Four stitches - gutter width 6 mm or 0.235"** Booklet Size before Top and Bottom Trimming and after Fore-Edge Trimming: Width 214.5 to 356 mm or 8.445" to 14.015" Length 85 to 220 mm or 3.350" 8.660" Finished Booklet Width: 100 to 173 mm or 3.940" to 6.810" **• Four stitches - gutter width 12 mm or 0.475"** Booklet Size before Top and Bottom Trimming and after Fore-Edge Trimming: Width 211.5 to 356 mm or 8.330" to 14.015" Length 85 to 220 mm or 3.350" to 8.660" Finished Booklet Width: 94 to 170 mm or 3.700" to 6.690" **• Two stitches or without stitch - gutter width 6 mm or 0.235"** Booklet Size before Top and Bottom Trimming and after Fore-Edge Trimming: Width 190 to 356 mm or 7.485" to 14.015" Length 85 to 220 mm or 3.350" to 8.660" Finished Booklet Width: 90 to 173 mm or 3.545" to 6.810" **• Two stitches or without stitch - gutter width 12 mm or 0.475"** Corresponding booklet size (Before top and bottom trimming and after fore-edge trimming) Width 196 to 356 mm or 7.720" to 14.015" Length 85 to 220 mm or 3.350" to 8.660" Finished Booklet Width: 90 to 170 mm or 3.545" to 6.690"
Punch (Option)	Hole Diameter : 5 mm or 0.197", 6 mm or 0.236" Hole Position : Two Holes at 5 to 15 mm from spine, 80 mm pitch One Hole at 10 mm from fore edge, Center Booklet Thickness : 3 mm (0.115") or thinner and moreover, half of hole diameter or thinner Booklet Size : Before Top and Bottom Trimming : Width 254 to 356 mm or 10.000" to 14.015" Length 85 to 220 mm or 3.350" to 8.660"
Production Speed	Max. 6,000 booklets per hour (A4 Portrait finished from A3 sheets)[3] Max. 5,300 booklets per hour (A4 Landscape)[3]
Voltage/Frequency	3-phase 200-230 V, 50 / 60 Hz (Step down to 200 V by Transformer for 3-phase 400 V)

[1]   Minimum width in case that the following center guide is installed in the trim section
       Center Guide S: 147 mm or 5.790"
       Center Guide M: 204 mm or 8.035"
       Center Guide L: 279 mm or 10.985"
[2]   Depending on the sheet weight, sheet thickness, booklet thickness or grain direction, the booklet spine may be marked by the transport belts, or the booklet may not be arranged properly on the delivery conveyor. (In this case, the kicker may not be used.)
[3]   The production speed is affected by operation mode and paper condition.
[4]   Air compressor is required. (Need to be arranged locally.)
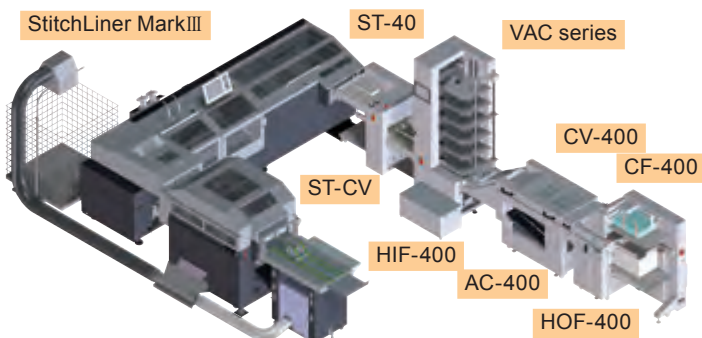
StitchLiner MarkⅢ   ST-40   VAC series   CV-400   CF-400   ST-CV   HIF-400   AC-400   HOF-400
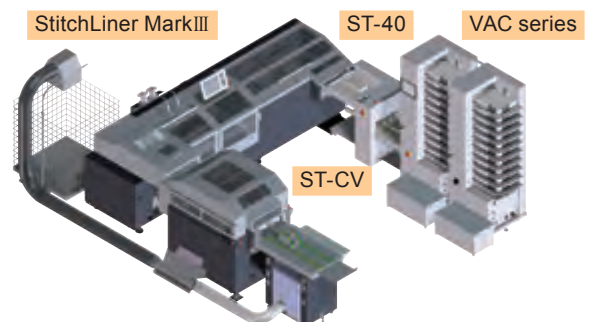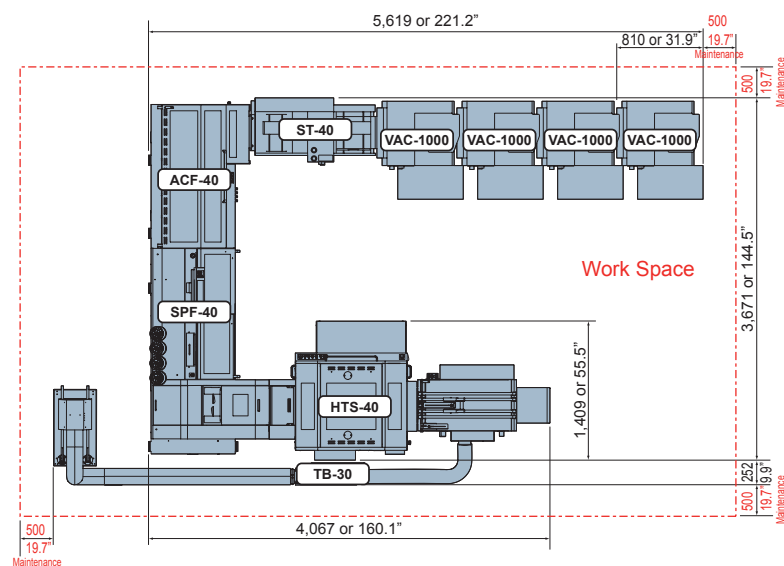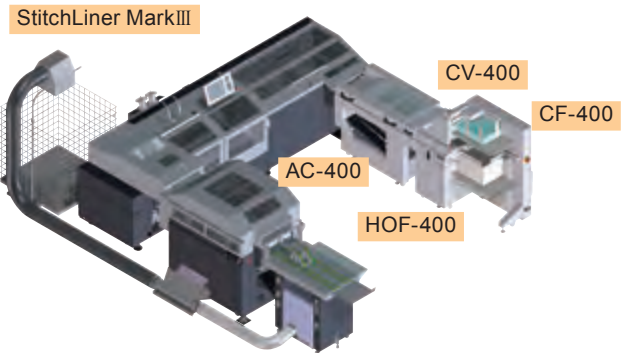
System Configuration

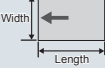## StitchLiner5500

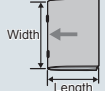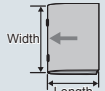### Machine Dimensions and Installation Space (Unit : mm or inch)

Height : 1,962 mm or 77.3"
(VAC-600H)

Diagram labels: 4,240 or 167.0"; 3,240 or 127.6"; 500 / 19.7" Maintenance; 500 / 19.7" Maintenance; 2,180 or 85.9"; 1,060 or 41.8"; 860 or 33.9"; 400 / 15.8"; 1,400 or 55.2"; 1,270 or 50.0"; 3,930 or 154.8"; SPF-30S; ACF-30; HTS-30S; (Conveyor); 1,060 or 41.8"; 1,460 or 57.5"; HOF-30; 3,362 or 132.4"; 842 or 33.2"; VAC-600Ha; 810 or 31.9"; VAC-600Hm; 810 or 31.9"; VAC-600Hm; 810 or 31.9"; VAC-600Hm; 810 or 31.9"; VAC-600Hm; 810 or 31.9"; VAC-600Hm; 500 / 19.7" Maintenance; 7,412 or 291.8"; 8,412 or 331.2"; Work Space

StitchLiner5500 Specifications

Sheet Size	Width → Length	**Width x Length**
		Max. 350 x 500 mm or 13.77" x 19.68"
		Min. 140 x 199 mm or 5.52" x 7.84" (140 mm or 5.52" width sheet is available with the optional support guide.)
Sheet Weight Range		Normal Paper : 64 to 210 gsm
		Coated Paper : 80 to 210 gsm
Stitch Thickness		Max. 5 mm or 0.19" (Booklet Thickness : 10 mm or 0.39") (about 50 sheets of 80 gsm or 22# normal)[1]
Stitch Distance		66 to 150 mm or 2.60" to 5.90", adjusted by +/- 2 mm or 0.08" / Auto
		Min. 55 mm or 2.17", with additional stitcher / Manual
Stitching Wire		#24 to #26 (0.6 mm to 0.5 mm)
		Option : #26 to #28 (0.5 mm to 0.4 mm)[2]
Untrimmed Booklet Size	Width → Length	**Width x Length**
		Max. 350 x 250 mm or 13.77" x 9.84"
		Min. 140 x 102 mm or 5.52" x 3.90"[3]
Finished Booklet Size	Width → Length	**Length**
		95 to 230 mm or 3.74" to 9.05" (Up to 85 mm or 3.35" depending on a condition)
		95 to 220 mm or 3.74" to 8.66" (When center-cut is performed)
		170 to 220 mm or 6.70" to 8.66" (When 2-hole punch is performed)
		Width
		144 to 340 mm or 5.67" to 13.38" (When center base is installed)
		120 to 152 mm or 4.73" to 5.98" (When center base is removed)
		186 to 340 mm or 7.33" to 13.38" (When center base is installed and center-cut is not performed)
		90 to 167mm or 3.55" to 6.57" (A booklet size when center-cut is performed)
		232 to 340 mm or 9.14" to 13.38" (When 2-hole punch is performed)
Trim Width		2 to 25 mm or 0.08" to 1"
Production Speed		Max. 5,500 booklets per hour - Min. 2,900 booklets per hour (Changed in 9 steps)[4]
Voltage / Frequency		3-phase 200-220 V, 50 or 60 Hz
		3-phase 208 V, 60 Hz
		3-phase 400 V, 50 or 60 Hz (Step down to 200 V by Transformer)

*1 Limitation for stitch thickness: If the 6 mm or 0.23" width center cut (option) is performed, Max. 3 mm or 0.11" of booklet thickness. (When using the 8 mm or 0.31" width slitter, Max. 4 mm or 0.15" of booklet thickness.)
If the punch (option) is performed, Max. 3 mm or 0.11" of booklet thickness.
When the sheet block thickness is 3 mm or 0.11" or above, use thick wire (#24 or 25).
*2 Optional stitching head is required.
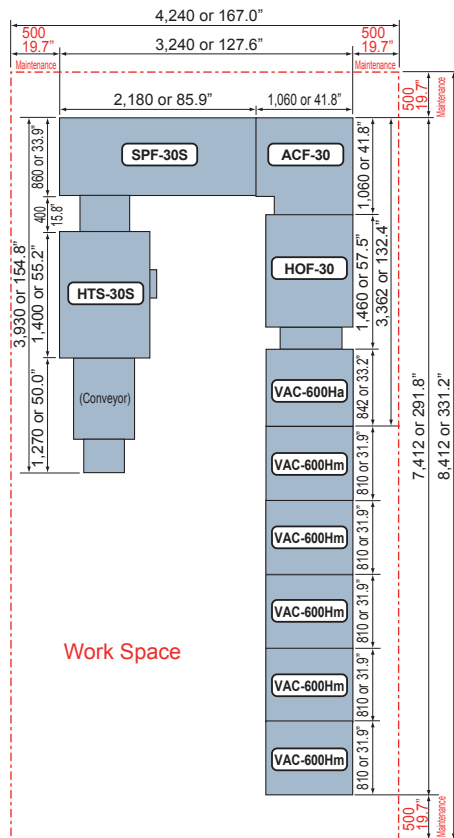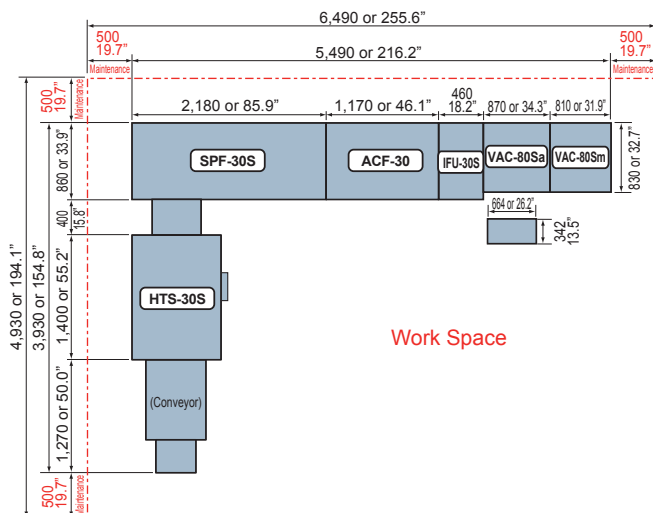*3 Depending on the sheet weight, sheet thickness, booklet thickness or grain direction, the booklet spine may be marked by the transport belts, or the booklet may not be arranged properly on the delivery conveyor. (In this case, the kicker may not be used.)
*4 The production speed is affected by operation mode, system setting, job setting and paper condition.
*5 Air compressor is required. (Need to be arranged locally.)

StitchLiner6000

Machine Dimensions and Installation Space (Unit : mm or inch)

Height : 1,980 mm or 78.0"
(VAC-80S)

Work Space

StitchLiner6000 Specifications

		Width x Length
Sheet Size	Width / Length	Max. 500 x 350 mm or 19.68" x 13.77"
		Min. 199 x 140 mm or 7.84" x 5.52"
Sheet Weight Range		Normal Paper : 53 to 210 gsm
		Coated Paper : 74 to 210 gsm
Stitch Thickness		Max. 5 mm or 0.19" (Booklet Thickness 10 mm or 0.39") (about 50 sheets of 80 gsm or 22# normal)
		Loop Stitch : Max. 3 mm or 0.11" (Booklet Thickness 6 mm or 0.23")[*1]
Stitch Distance		66 to 150 mm or 2.60" to 5.90", adjusted by +/- 2 mm or 0.08" / Auto.
		Min. 55 mm or 2.17", with additional stitcher / Manual.
Stitching Wire		#24 to #26 (0.6 mm to 0.5 mm)
		Option : #26 to #28 (0.5 mm to 0.4 mm)[*2]
Untrimmed Booklet Size	Width / Length	Width x Length
		Max. 350 x 250 mm or 13.77" x 9.84"
		Min. 140 x 99 mm or 5.52" x 3.90"[*3]
Finished Booklet Size	Width / Length	Length
		95 to 230 mm or 3.74" to 9.05" (Up to 85 mm or 3.35" depending on a condition)
		95 to 220 mm or 3.74" to 8.66" (When center-cut is performed)
		170 to 220 mm or 6.70" to 8.66" (When 2-hole punch is performed)
		Width
		144 to 340 mm or 5.67" to 13.38" (When center base is installed)
		120 to 152 mm or 4.73" to 5.98" (When center base is removed)
		186 to 340 mm or 7.33" to 13.38" (When center base is installed and center-cut is not performed)
		90 to 167 mm or 3.55" to 6.57" (A booklet size when center-cut is performed)
		232 to 340 mm or 9.14" to 13.38" (When 2-hole punch is performed)
Trim Width		2 to 25 mm or 0.08" to 1"
Production Speed		Max. 6,000 booklets per hour - Min. 2,900 booklets per hour (Changed in 11 steps)[*4]
Voltage / Frequency		3-phase, 200-220 V, 50 or 60 Hz
		3-phase 208 V, 60 Hz

*1 Limitation for stitch thickness: If the 6 mm or 0.23" width center cut (option) is performed, Max. 3 mm or 0.11" of booklet thickness. (When using the 8 mm or 0.31" width slitter, Max. 4 mm or 0.15" of booklet thickness.)
    If the punch (option) is performed, Max. 3 mm or 0.11" of booklet thickness.
    When the sheet block thickness is 3 mm or 0.11" or above, use thick wire (#24 or 25).
*2 Optional stitching head is required.
*3 Depending on the sheet weight, sheet thickness, booklet thickness or grain direction, the booklet spine may be marked by the transport belts, or the booklet may not be arranged properly on the delivery conveyor. (In this case, the kicker may not be used.)
*4 The production speed is affected by operation mode, system setting, job setting and paper condition.
*5 Air compressor is required. (Need to be arranged locally.)

19

Options

For StitchLiner5500 / StitchLiner MarkIII

High-speed Offline Feeder HOF-400
Near-Line Solution for digital printing

Variable Thickness Production
Digitally collated sheets are loaded at the feed table of the HOF-400 and reliably transported to the stitcher. A standard mark sensor enables variable sheet count documents to be handled with integrity and verification. The VAC series collator can be connected in line, for processing of conventional offset printed work.   * Note: The HOF-400 cannot be connected to the VAC-80S.

High Speed Feeding
The HOF-400 can feed at a speed of 25,000 sheets per hour (A3 or 11" x 17") and 35,000 sheets per hour (A4 SEF or 8.5" x 11"). This high speed feeding is capable of handling the output of multiple printers.

User Friendly Operation
Feature rich newly designed 7" color touch screen display for easy and intuitive operation. The HOF-400 is equipped with a high quality feed detection system for reliable processing. If mis-feeding occurs in the HOF-400, the set is ejected before stitching.

Variable System Configuration
The HOF-400 is compatible with a wide variety of system configurations such as sheet feeding, cover feeding, accumulating, bleed trimming and center creasing depending on your needs.

HOF-400

For StitchLiner5500 / StitchLiner6000 / StitchLiner MarkIII

Inserter IM-30
Inline inserter for expanded booklet processing

The IM-30 can insert(blow-in) single sheets, post cards, envelopes and folded sheets into a booklet stitched on the StitchLiner.

Labor-savings
Sheet insertion can be performed in-line with the StitchLiner with minimal operator involvement.

High Productivity
The IM-30 can insert at a maximum production speed of 4,000 booklets per hour with the StitchLiner connected. Faulty insert eject function is employed for non-stop operation even when a feed error occurs.

User Friendliness
Intuitive touchscreen control and quality checking systems increase production efficiency with minimal errors.
Quality checking system includes: Feed section error sensor, Separation error sensor, Booklet jam sensor.

Wide Variety of Inserting Applications
Increase production capabilities with a wide range of inserting applications. Up to three pieces can be inserted into the middle, front or back of a booklet.

IM-30

Beneath Top Sheet
Post Card

Middle of Booklet

Single Sheet
(Up to 3 sheets)
Folded Sheet
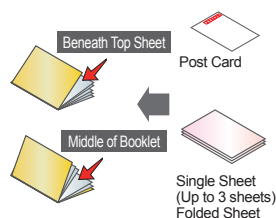
Options for IM-30

Error Insert Detector IM-SD
Using an ultrasonic sensor, the IM-SD detects that the front page is turned.

Conveyor IM-CC Compressor CMP-04

Preset Kicker PK-30

Bypass Convey or IM-BC40: For StitchLiner MarkIII

IM-BC: For StitchLiner5500/6000

StitchLiner5500 / StitchLiner MarkⅢ

Bypass Stacker ST-40
Simple and Quick Changeover

User Friendliness
Bookletmaking, reject function and offset or straight stacking can be selected at the ST-40.

High Speed
Errored sets are delivered to the built-in reject tray for non-stop operation. Collated sets delivered on the pallet are jogged for superior stack quality.

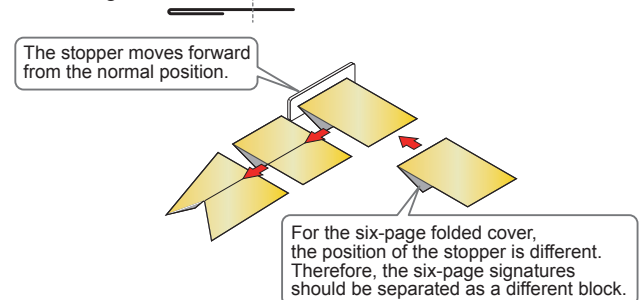*Note: The ST-40 cannot be connected to the VAC-80S.

ST-40

SL6PS-40: StitchLiner MarkⅢ/ SL-6PS: StitchLiner5500

Optional Six-page Cover Kit SL6PS-40/SL-6PS
Software to mix different length of sheet.
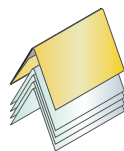
Mix six-page folded or different size cover

Normally, the sheets are folded in half to make a four-page signature.

Stopper in the ACF
This receives and arranges the sheets.

The sheets are fed and folded in blocks.
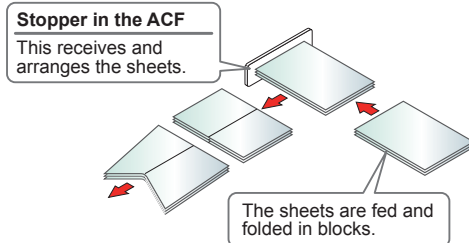
Six page folded or different size cover can be processed as shown below for proper registration and to avoid trimming the folded edge.

The stopper moves forward from the normal position.

For the six-page folded cover, the position of the stopper is different. Therefore, the six-page signatures should be separated as a different block.

Different size sheet can be inserted in any position.
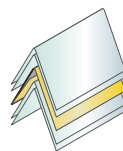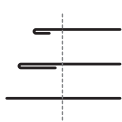
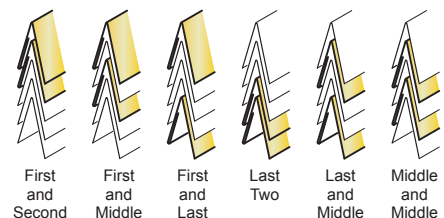Mix different size sheet on top.

Mix different size sheet at the bottom.
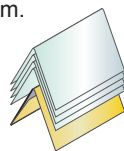
Insert different size sheet in the middle.

Up to two different sheet sizes can be inserted - only if they are fed from the VAC

• Different size sheet can be inserted up to four positions in a booklet: front, Back, and other two inserts. However, the system is limited to insert only two different sizes.
• Multiple sheets can be inserted within the same block.
• If the sheets are fed from the HOF-400(CF-400), only one different size sheet can be inserted.

First and Second

First and Middle

First and Last

Last Two

Last and Middle

Middle and Middle

Option

Other Options

Stitcher Head

The stitcher head is selectable from either of the standard stitcher head (No.25 through No.27, thickness: 0.5 mm through 0.4 mm or 0.020" through 0.016") or the stitcher head for heavy line (No.23 through No.25, thickness: 0.6 mm through 0.5 mm or 0.024" through 0.020"). Four stitching is available by using the four stitching kit. Three stitching is available by using the B-40C which is the option of the SPF-40. *Note: The SPF-30S is only for two stitching and four stitching.

Loop Stitching Kit
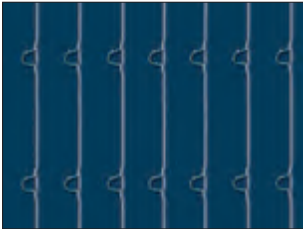
Loop stitching is available by installing the loop stitching kit with the stitch head.

* Note: The stopper for the loop stitching is required for the StitchLiner Mark III.

Hole Punch Unit

High speed two-hole punching can be performed in-line for efficient production.
HP-05K (5 mm hole), HP-06K (6 mm hole) and one-hole punch unit (for fore-edge) are available.

Thickness Detector HTS-TD40 (for HTS-40)

The HTS-TD40 detects the booklets with abnormal thickness and ejects them to the misfeed tray.

Thickness Detector HTS-TD (for HTS-30S)

When the HTS-TD detects a booklet with abnormal thickness, the Booklets that are being processed on the SPF-30S are ejected to the misfeed box on the SPF-30S.

Center-cut Unit

Two-up production is available by installing the center-cut device. For the center-cut unit for the StitchLiner5500/6000, there are two types of unit; cutting width 6 mm or 0.24" and cutting width 8 mm or 0.31". For the center-cut unit for the StitchLiner Mark III, there are four types of unit; cutting width 6 mm or 0.24", cutting width 8 mm or 0.31", cutting width 10 mm or 0.39", and the cutting width 12 mm or 0.47".

Preset Kicker PK-30
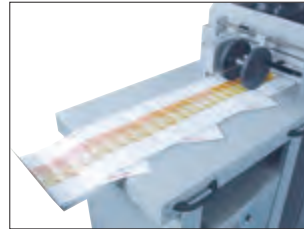
According to a preset number input on the touchscreen, a booklet is skewed to identify and separate the end of a series.
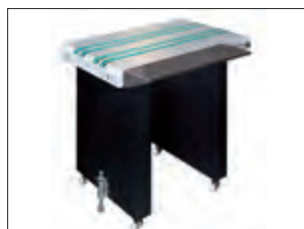
Trimmings Blower TB-30

The TB-30 ejects the trims from HTS by air.

Transport Rollers HTS-AR40

The upper delivery roller is automatically set to match the finished size of the booklet.

Delivery Conveyor (HTS-ECV40)

The HTS-ECV40 has a higher booklet capacity and is suitable for longer production runs.

	Name	Format	Description	StitchLiner5500	StitchLiner6000	StitchLiner Mark III
Stitch Section	Optional Six-page Folder	SL-6PS	Software for the optional six-page folder	Yes	No	No
		SL6PS-40	Software for the optional six-page folder	No	No	Yes
	Stitcher Head Optional Parts	B-40S	Two Stitcher Head Attaching Parts (Stitcher head and clincher are not included.)	No	No	Yes
		B-30S		Yes	Yes	No
	Stitcher Head Optional Parts	B-40C	One Stitcher Head Attaching Parts (Stitcher head and clincher are not included.)	No	No	Yes
		B-30C		Yes	Yes	No
	Centering Device	CD-30S (9964585)	-	Yes	Yes	Yes
	Stitcher Head 52/8S (Thick) No.23 through 27	0522530	For heavy line: Thickness 0.4 through 0.6 mm	No	No	Yes
	Stitcher Head 52/8S (Thin) No.25 though 27	0522532	Domestic Standard For fine line: Thickness 0.35 through 0.5 mm	No	No	Yes
	Clincher	996-3684	-	No	No	Yes
	52/8S Head Parts for Heavy Line	052-2980	Bender and Driver for One Head Thickness 0.4 through 0.6 mm	No	No	Yes
	52/8S Loop Stitching Parts	052-2940	Thickness 0.5 mm through 0.6 mm The stopper for loop stitching is necessary for the HTS-40.	No	No	Yes
	Wire No.23	CO-23	0.60 mm or 0.024"	Yes	Yes	Yes
	Wire No.24	CO-24	0.55 mm or 0.022"	Yes	Yes	Yes
	Wire No.25	CO-25	0.50 mm or 0.022"	Yes	Yes	Yes
	Wire No.27	CO-27	0.40 mm or 0.016"	Yes	Yes	Yes
	Stitcher Head 43/6S No.25 through 27	M792010 (0543542)	For fine line: Thickness 0.5 mm through 0.4 mm	Yes	Yes	Yes
	Stitcher Head 43/6S No.23 through 25	M792019 (0543540)	For heavy line: Thickness 0.6 mm through 0.5 mm	Yes	Yes	Yes
	43/6S Head Parts for Heavy Line	9964324	Bender and Driver for One Head	Yes	Yes	*
	43/6S Loop Stitching Parts	9964400	For One Head No.23 through 25 (0.6 mm through 0.5 mm) The stopper for loop stitching is necessary for the HTS-40.	Yes	Yes	*
Trimming Section	Trimmings Blower	TB-30	The TB-30 ejects the trims from HTS by air.	Yes	Yes	Yes
	Preset Kicker	PK-30	The PK-30 is necessary for separating the booklets by the preset number on the delivery conveyor.	Yes	Yes	Yes
	Additional Stopper for Top-Bottom		Stopper for Loop Stitching	No	No	*
	Thickness Detector	HTS-TD	When the HTS-TD detects the booklets with abnormal thickness, the HTS-30S stops in an emergency and the booklets that are being processed on the SPF-30S are ejected to the misfeed box on the SPF-30S.	Yes	Yes	*
		HTS-TD40	The HTS-TD40 detects the booklets with abnormal thickness and ejects them to the misfeed tray.	No	No	Yes
	Center-Cut Device (6 mm or 0.23" Width)	CC40-06	Cutting Width 6 mm or 0.23" (Maximum booklet thickness: 3 mm or 0.12")	No	No	Yes
		CC-06		Yes	Yes	*
	Center-Cut Device (8mm or 0.23" Width)	CC40-08	Cutting Width 8 mm or 0.31" (Maximum booklet thickness: 4 mm or 0.16")	No	No	Yes
		CC-08		Yes	Yes	*
	Center-Cut Device (10 mm or 0.39")	CC40-10	Cutting Width 10mm or 0.31" (Maximum booklet thickness: 4 mm or 0.16")	No	No	Yes
	Center-Cut Device (12 mm or 0.47")	CC40-12	Cutting Width 12 mm or 0.47" (Maximum booklet thickness: 4 mm or 0.16")	No	No	Yes
	Punch Base Unit	HP-30S	Lower part is common in 5 mm or 6 mm	Yes	Yes	*
		HP-40S	Lower part is common in 5 mm or 6 mm	No	No	Yes
	Punch Unit (5 mm or 0.19")	HP-05K	Upper Part 2 holes and 5 mm or 0.19"	Yes	Yes	Yes
		HP-C05K	Upper Center 1 hole and 5 mm or 0.49"	Yes	Yes	Yes
	Punch Unit (6 mm or 0.24")	HP-06K	Upper Part 2 holes and 6 mm or 0.23"	Yes	Yes	Yes
		HP-C06K	Upper Center 1 hole and 6 mm or 0.23"	Yes	Yes	Yes
	Delivery Conveyor	HTS-AR40	The upper delivery roller is automatically set to match the finished size of the booklet.	No	No	Yes
	Delivery Conveyor	HTS-ECV40	The HTS-ECV40 is suitable for stacking the large number of booklets.	No	No	Yes
Paper Inserter	Paper Inserter	IM-30	Up to three sheets can be inserted into the middle of the booklet and beneath the top sheet. The IM-30 can be connected to the stitcher or can be used as stand alone.	Yes	Yes	Yes
	StitchLiner IM-30 Conveyor	IM-BC	The IM-BC is a conveyor which cross over the IM-30 to transport the booklets to the conveyor of HTS.	Yes	Yes	No
		IM-BC40		No	No	Yes
	Error Insert Detector	IM-SD	The IM-SD is a sensor which detects that a front page is turned when a sheet is inserted.	Yes	Yes	Yes

* Contact your local dealer about availability of connection.

Change the **focus**

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