

Stitchers

An introduction to saddlestitching - the Prosetter 455



Do you want to expand your business by providing a saddlestitching service for the first time?

Easy operation, fast makeready and durability have been built into every aspect of Heidelberg's 455 modular design.

General:

Heidelberg Finishing's Production Management Control (PMC) system speeds up makeready and provides production data. The PMC's displays step-by-step instructions for each position.

In the event of a machine stop, the PMC displays the cause, helping the operator to return to action quickly.

The backbone of any saddlestitching system is it's saddle chain. Our narrow, single chain means that signatures sit well down.



Pockets:

With the maximum pile height a generous 8", the time your operators spend loading feeders is minimized.

Feeders have optional half-speed or neutral operation, the better to tailor the machine to the job at hand.

The large diameter transfer drum minimizes signature distortion and feeds two signatures per rotation to reduce wear.

Signatures are opened via grippers, vacuum or a combination of both.



Coverfeeder:



The proven FF100 cover folder feeder is capable of feeding at twice the maximum speed of the Prosetter 455.

Cover-lifting and spine cracking is avoided with the side caliper.



Trimmer:

The book stops prior to its transfer to the trimmer, which facilitates the right-angled turn into the trimmer infeed.

Trimming the front edge first releases air and allows the book to lie flat for more accurate trimming.

The backstops are adjusted externally, either individually or as a pair, to compensate for folder variation during production.

One set of belts transports the book from infeed to delivery, eliminating the risk of marking associated with over-running belts.

Heidelberg Finishing Systems' method of trimming the front edge of the book first provides better trim accuracy by releasing air and allowing the book to lie flat for the head and tail cut. This method is essential when producing two-up work, because the book is split at the same time as the head and tail are cut.

Summary:

- Wide variety of book sizes can be accommodated
- AC frequency inverter drive for smooth acceleration to running speeds
- PMC system for fast makeready and production data
- Narrow single saddle chain
- Vertical feeders for minimized marking
- Electro-mechanical side caliper
- Stationary stitching
- Book stopped after stitching for accurate transfer into trimmer

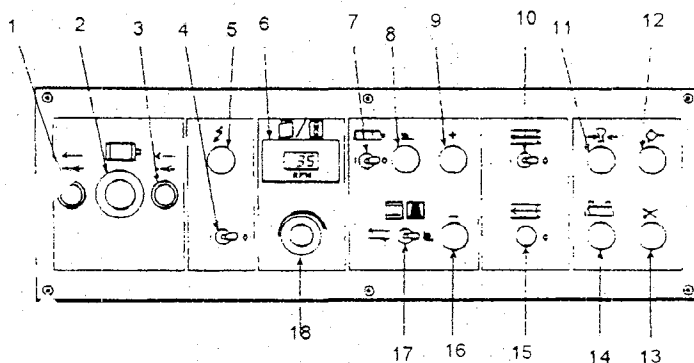


Figure 5. Main Control Panel, Controls and Indicators

□ SPECIFICATIONS

The following table provides design and performance data for the Saddlebinder SP455-S. This information is intended to familiarise the user with the machine as an aid during maintenance.

Table 4. Saddlebinder SP455-S Specifications

CHARACTERISTIC	SPECIFICATION
SIGNATURE SIZE (UNTRIMMED)	
Maximum	321 x 350 mm (12 5/8" x 13 3/4")
Minimum	89 x 146 mm (3 1/2" x 5 3/4")
Lap	5 to 19 mm (3/16" to 3/4")
NOTES:	
1. No lap required for vacuum opening.	
2. Smaller signatures or cards can be run, using small size hopper kit.	
3. Minimum untrimmed spine length is 75 mm.	
BOOK SIZE (TRIMMED)	
Maximum	305 x 324 mm (12" x 12 3/4")
Minimum	78 x 146 mm (3 1/16" x 5 3/4")
NOTE: 78 mm is possible with trimmer backstop extension. Otherwise minimum trimmed width is 89 mm (3 1/2").	
SPEED (CYCLES PER HOUR)	Infinitely variable from 1,500 to 8,000. Production speed depends on size, thickness, number of stations, kind and condition of stock and other operating variables.

CHARACTERISTIC	SPECIFICATION
MAXIMUM TRIM ALLOWANCE	51 mm (2") on all three sides.
CHIP REMOVAL	Mechanical conveyor belt removes chips from under knives into collection bin, to optional Chip Removal System or to in-house disposal system.
DELIVERY	Trimmer delivers onto an indexing flat belt conveyor with batch counter as standard. Delivery into an RS10/2 stacker is optional.
LUBRICATION	
FEEDER	Manual oil and grease fittings on feeder and connection base as required.
STITCHER	Centralised oiling system as standard.
TRIMMER	Greasing system as standard.
FACTORY WIRING	Standard.
CONTROLS	
FEEDER STATION	Jog, run and stop controls.
TRIMMER INFEED STATION	Jog control only.
TRIMMER STATION	Batch counter ON/OFF switch, batch/total run readouts and jog, stop and run controls.
MAIN CONTROL PANEL	Jog, run and stop controls, power ON/OFF switch, speed control, inspector controls, vacuum pump ON/OFF switch, set/run switch and indicator lamps.

❑ OPTIONAL EQUIPMENT AVAILABLE

- ☐ Additional Stitching Heads (Acme, Bostitch or Hohner)
- ☐ Hand Feed Section
- ☐ Additional Set of Knives
- ☐ 4th and 5th Knife Attachment for two-up work Model 645
- ☐ Chip Removal System Model 646
- ☐ Counter/Stacker Model RS-10 or RS-12
- ☐ Inline Cover Folder/Feeder