The Horizon StitchLiner 5500/6000 is an innovative saddle-stitching system which incorporates flat sheet collating, scoring, folding, stitching and three-knife trimming in line.

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

The Horizon StitchLiner 5500/6000 is an innovative saddle-stitching system which incorporates flat sheet collating, scoring, folding, stitching and three-knife trimming in line.

The StitchLiner 5500/6000 provides user-friendly operation, high productivity and versatility for on demand, production print, and trade bindery environments.
**Features**

**StitchLiner5500**

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

- User-friendly operation through the color touchscreen and accurate automation achieve short make-ready for quick turnaround.
- Folding is performed in-line to simplify the saddle-stitching workflow and improve operational efficiency.
- Various optional devices are available for both offset and digital printing.
- 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.

- User-friendly operation through the color touchscreen and accurate automation achieve short make-ready for quick turnaround.
- Folding is performed in-line to simplify the saddle-stitching workflow and improve operational efficiency.
- Newly designed landscape feeding and straight saddle-stitching flow handles thinner paper stock and feeds larger, landscape-oriented sheets.
- Ergonomic L-shaped configuration for efficient operation and space saving.
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 52 gsm tissue paper to 208 gsm cardboard.
- 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.

For StitchLiner5500

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 Block Feed for accurate bookletmaking.
- The VAC-1000 is expandable up to 6 towers, 60 feed bins.

- Bin Pile Height: Max. 55 mm (2.2”)
- Sheet Size: Max. 395(W) x 500(L) mm (15.57” x 19.69”)
- Min. 148(W) x 148(L) mm (5.83” x 5.83”)

For StitchLiner6000

VAC-600H
Maximum pile height is 130 mm (5.11”). Suitable for longer run production.

- Each bin has 130 mm (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 Block Feed for accurate bookletmaking.
- Optional image checking system (CCD-VAC) is available for higher quality control.
- The VAC-600H is expandable up to 6 towers, 36 feed bins.

- Bin Pile Height: Max. 130 mm (5.1”)
- Sheet Size: Max. 395(W) x 500(L) mm (15.57” x 19.69”)
- Min. 120(W) x 148(L) mm (4.72” x 5.83”)

For StitchLiner5500

VAC-60S
Equipped with 8 landscape feeding stations. Maximum production speed is 6,000 booklets per hour.

- The VAC-60S 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 Block Feed for accurate bookletmaking.
- Optional image checking system (CCD-VAC80S) is available for higher quality control.
- The VAC-60S is expandable up to 6 towers, 48 feed bins.

- Bin Pile Height: Max. 83 mm (3.2”)
- Sheet Size: Max. 350(W) x 500(L) mm (13.77” x 19.69”)
- Min. 140(W) x 199(L) mm (5.52” x 7.84”)

Air-suction Feeding

1. Air is blown into the stack to float the sheets.
2. Picks-up the top sheet.
3. Rotates to advance the sheets.
**ACF-30/30S**

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

Operation Process and Sheet Flow in ACF-30/30S

**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 ensure a tight 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.

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

*Shown with ACF-30S.*
**SPF-30S**

**Saddle Stitcher**

Quick changeover and professional quality...

Handles booklets up to 10 mm thick.

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For StitchLiner 5500/6000

**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 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 fire to 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.

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For StitchLiner 5500/6000

**Stitching Process and Sheet Flow in SPF-30S**

1. Feeding
2. Stitching
3. Jogging

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**HTS-30S**

**Three-knife Trimmer**

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

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For StitchLiner 5500/6000

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**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.

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For StitchLiner 5500/6000

**Trimming Process and Sheet Flow in HTS-30S**

1. Register with stopper
2. Fore-edge Trimming
3. Top and bottom Trimming
4. Stacking

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**SPF-30S**

- For StitchLiner 5500/6000
- Saddle Stitcher
- Quick changeover and professional quality...
- Handles booklets up to 10 mm thick.

**HTS-30S**

- For StitchLiner 5500/6000
- Three-knife Trimmer
- Professional-quality three-knife trimming applies the final finish.
- A center-cut option enables two-up production.
### Machine Dimensions and Installation Space

**Unit: mm (inch)**

<table>
<thead>
<tr>
<th>Sheet Size</th>
<th>Stitcher/Conveyor</th>
<th>Booklet Size</th>
<th>Booklet Size with Top-Bottom Flap Width</th>
</tr>
</thead>
<tbody>
<tr>
<td>Max. 190.0x140.0</td>
<td>SPF-35S</td>
<td>Max. 350 x 250</td>
<td>Max. 170 x 230</td>
</tr>
<tr>
<td></td>
<td>ACF-35S</td>
<td>Min. 140 x 103</td>
<td>Min. 95 x 130</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Top-Bottom x Fore-edge</td>
<td>Top-Bottom x Fore-edge</td>
</tr>
<tr>
<td></td>
<td></td>
<td>5.6 x 4.1</td>
<td>2.8 x 0.8</td>
</tr>
</tbody>
</table>

**Looper**

1. Max. 350 x 250
2. Top-Bottom Flap Width
3. Top-Bottom x Fore-edge

**Machine Specifications**

**Sheet Size**
- Max. 190.0 x 140.0
- SPF-35S
- ACF-35S

**Stitching Wire**
- 0.08" to 1"
- #24, #25, or #26

**Voltage**
- 3-Phase 400 V, 50 / 60 Hz
- 3-Phase 208 V, 50 / 60 Hz
- 3-Phase 200 V, 50 / 60 Hz

**Stitching Head**
- Optional

**Optional Accessories**
- SPF-35S
- ACF-35S
- SP-35S
- SP-35U

**Voltage / Frequency**
- 0 Phase 220 V, 50 / 60 Hz
- 0 Phase 220 V, 50 / 60 Hz
- 0 Phase 400 V, 50 / 60 Hz

**Production Speed**
- Max. 6,000 booklets / hr. - Min. 2,900 booklets / hr.

**Optional Accessories**

- SPF-35S
- ACF-35S
- SP-35S
- SP-35U

**Voltage / Frequency**

1. 0 Phase 220 V, 50 / 60 Hz
2. 0 Phase 220 V, 50 / 60 Hz
3. 0 Phase 400 V, 50 / 60 Hz

**Production Speed**

1. Max. 6,000 booklets / hr.
2. Max. 5,000 booklets / hr.
3. Min. 2,900 booklets / hr.

**Limitations**
- For stitching thickness: If the 6 mm 
  stitch thickness is performed, Max. 3 mm 
  (0.12") of booklet thickness is allowed when 
  the sheet block thickness is 5 mm or more.

- Optional stitching head is required.

**Optional Accessories**

- SPF-35S
- ACF-35S
- SP-35S
- SP-35U

**Voltage / Frequency**

1. 0 Phase 220 V, 50 / 60 Hz
2. 0 Phase 220 V, 50 / 60 Hz
3. 0 Phase 400 V, 50 / 60 Hz

**Production Speed**

1. Max. 6,000 booklets / hr.
2. Max. 5,000 booklets / hr.
3. Min. 2,900 booklets / hr.

**Limitations**
- For stitching thickness: If the 3 mm (0.1") of booklet thickness is performed, Max. 2 mm 
  (0.08") of booklet thickness is allowed when the sheet block thickness is 3 mm or more.

- Optional stitching head is required.

**Optional Accessories**

- SPF-35S
- ACF-35S
- SP-35S
- SP-35U

**Voltage / Frequency**

1. 0 Phase 220 V, 50 / 60 Hz
2. 0 Phase 220 V, 50 / 60 Hz
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  (0.08") of booklet thickness is allowed when the sheet block thickness is 3 mm or more.
Options

For StitchLiner5500

High-speed Offline Feeder HOF-20 / HOF-30

Near-Line Solution for digital printing
HOF-20 - Features a built-in deep pile cover feed station
HOF-30 - Can be connected to the VAC-1000/600H collators

High Speed
The system feeds at a speed of 27,000 sheets per hour, using Horizon’s patented rotary feeding system.

High Pile
Maximum pile height is 340 mm (13.4") on the sheet feed tray and 130 mm (5.1") on the cover feed tray (HOF-20 only). For maximum efficiency, 2 sets of trays for sheet feeding are provided as standard equipment, so one set is always available for pre-loading.

Dynamic
The HOF-20/30 has the capability to handle variable data applications. A mark sensor enables the feeder to handle variable sheet count documents with integrity and verification.

*The HOF-20/30 cannot be connected to the VAC-80S.

For StitchLiner5500/6000

Paper Inserter IM-30

Inline sheet inserter for efficient booklet production
The IM-30 can insert single sheets, post cards, 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 a sheet at the maximum production speed of 4,000 booklets per hour with the StitchLiner connected. Faulty set 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 sheets can be inserted into the middle of a booklet or beneath the top sheet.

IM-30 Option

- The ultrasonic sensor detects that only one top sheet turns over consistently.

Bypass Stacker ST-40

Simple and Quick Changeover

User Friendliness
Bookletmaking and stacking can be selected by the switch on 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.

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

Other Options

Stitching Head
Standard stitcher head (#24 to #26)
- Thickness: 0.5 mm to 0.6 mm

Optional stitcher head (#26 to #28)
- Thickness: 0.5 mm to 0.4 mm

Additional stitcher heads are available for up to 4 stitches per booklet with mounting block B-30S.

Loop Stitching Kit
An optional loop stitching kit can be fitted to the standard stitcher heads to meet varying customer needs.

Hole Punch Device HP-05 / HP-06
5 mm (HP-05) or 6 mm (HP-06) hole punch device provides 2 punch holes for A4 booklet. Precise hole punching is performed in-line for efficient production.

6-page Fold Program SLRom6P
An optional 6-page fold program can be inserted to a booklet with simple operation. 6-page fold sheet can be collated wherever in the booklet by the combination of 6-page fold and block feed program.

Center-Cut Device CC-06 / 1/4 / 08 / 10 / 12
Two-up production utilizing the center knives.

- #24 to #26 hole thickness: 2 mm (1/6")
- #26 to #28 hole thickness: 1 mm (1/32")

Special Order
- #24 to #26 hole thickness: 3 mm (1/8")
- #26 to #28 hole thickness: 2 mm (1/32")

HTS-TD
Powerfully extracts trim waste from the three-knife trimmer.

Max. book thickness:
- 6 mm / 0.24" (Max. book thickness: 3 mm / 0.12"
- 5 mm / 0.20" (Max. book thickness: 4 mm / 0.16"
- 3 mm / 0.12" (Max. book thickness: 6 mm / 0.24"
- 2 mm / 0.08" (Max. book thickness: 8 mm / 0.31"

The HTS-TD is installed at fore-edge trimming section and checks the thickness of each booklet. In case of missing section or double sections, system stops for maximum quality control.

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.

6-page Fold Program SLRom6P (StitchLiner5500 only)

Cutting Waste Extractor TB-30
Powerfully extracts trim waste from the three-knife trimmer.

Max. book thickness:
- 6 mm / 0.24" (Max. book thickness: 3 mm / 0.12"
- 5 mm / 0.20" (Max. book thickness: 4 mm / 0.16"
- 3 mm / 0.12" (Max. book thickness: 6 mm / 0.24"
- 2 mm / 0.08" (Max. book thickness: 8 mm / 0.31"

*Max. book thickness varies depending on booklet size and paper condition.* 3 stitches are available as factory option with mounting block B-30C.
think intelligent automation.

*The machine design and specifications are subject to change without any notice.

HORIZON INTERNATIONAL, INC.
510 Kuze Ooyabu-cho, Minami-ku, Kyoto, 601-8206, Japan
Phone: +81-(0)75-934-6700  Fax: +81-(0)75-934-6708
www.horizon.co.jp

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Standard Finishing Systems, 10 Connector Road, Andover, MA 01810
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