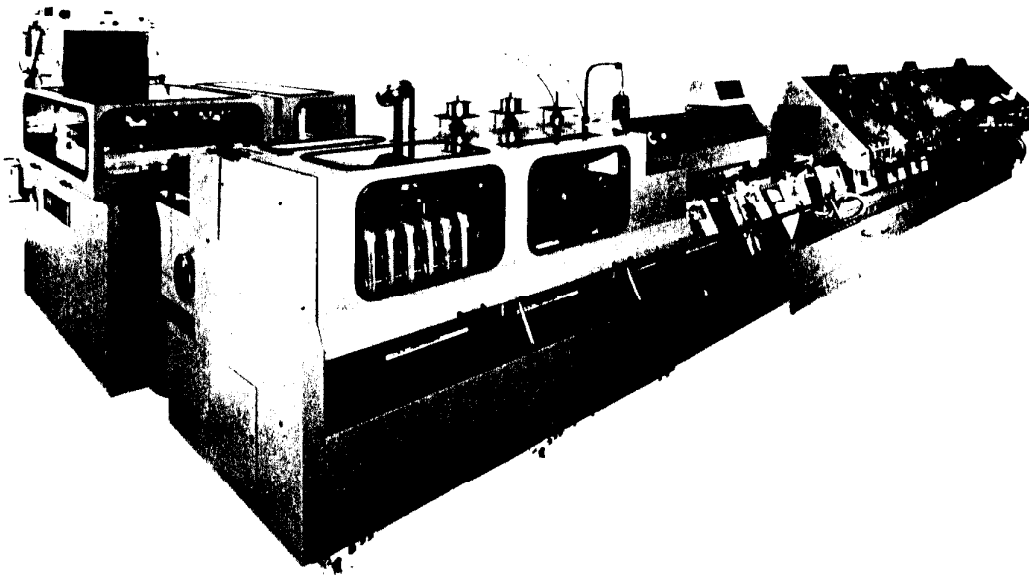


Model SP650 - The SP650 has taken mid range stitching to the same precise control level as the long run publication industry. With the proven P-15 hopper with a durable easy make ready stitcher and trimmer it is now possible for the commercial printer or trade binder to produce cost effectively either medium or long runs on the same machine. This machine can be equipped with cover folder feeder and card feeder as necessary. These feeders are also movable, like the P-15, to allow for greater flexibility in job layout.

Min. Size	3 1/2" x 5 3/4"
Max. Size	12" x 18 3/4"
Bulk Loose	
Hopper Capacity	
Speed	up to 12000/cph

Model SP705 - The SP705 introduced at Print '91 fills the gap between the medium and long run market. With the SP705, medium runs are easy and efficient to set up and with an operating speed of 13,000 cph even long runs can be efficiently run. Modular construction allows the addition of publication type options, such as ink jet.



SECTION I

GENERAL INFORMATION

INTRODUCTION

Section I contains general descriptive information, receiving, installation, specifications and optional data.

DESCRIPTION

The Saddlebinder SP 650 collates, stitches, and trims books at 11,500 cycles per hour. (Refer to specifications). Precise, mark-free signature control from hoppers through delivery provides quality books. The combination of gripper transfer and inner and outer gripper/vacuum opening provides versatility for handling hi or low folio, lip or no lip, open or closed-hand signatures. The trimmer with Register Belt book control, delivers trim accuracy.

The system shown in Figure 1 can be combined with an optional 4th and 5th knife attachment that can be installed or removed in minutes.

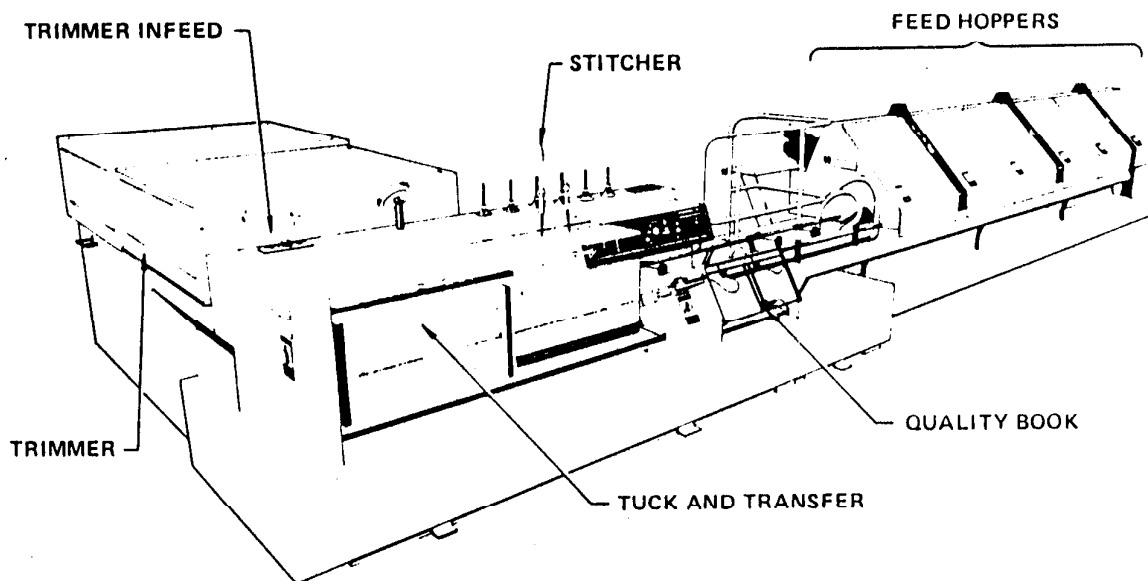


Figure 1. Saddlebinder SP 650

STANDARD SPECIFICATIONS

MACHINE: INSERTER/STITCHER/TRIMMER

MODEL: SP 650 SERIES

	English	Metric
1. Max. Signature Size (Untrimmed)		
(Lap Opening).....	12 5/8" x 19"	(321 mm x 483 mm)
(Vacuum Opening).....	12 5/8" x 19"	(321 mm x 483 mm).
Min Signature Size (Untrimmed)		
(Lap Opening).....	5" x 5 3/4"	(127 mm x 146 mm)
(Vacuum Opening).....	5" x 5 3/4"	(127 mm x 146 mm).
NOTE: Smaller sized signatures can be run utilizing "small signature kit" parts. Refer to specs SP 6579 and SP 6580.		
2. Book Size (Trimmed).....		
Maximum.....	12" x 18 3/4"	(305 mm x 476 mm)
Minimum.....	3 1/2" x 5 3/4"	(89 mm x 146 mm).
NOTE: See also spec SP 6586 (Non-standard) for "small book" trimmer kit.		
NOTE: Thickness of Book..... 1/2" (12 mm) Compressed.		
4. Lap.....		
	1/4" to 5/8"	(6 mm to 16 mm) "High Folio" Lap Format
5. Speed.....		
	Infinitely variable to 11,500 cycles per hour. Production speed depends on size, thickness, number of stations and kind and condition of stock and other operating conditions.	
6. Inserter Bases.....		
	Bases are supplied to mount two feed hoppers (60") or four feed hoppers (120"). Bases contain air and vacuum connections in each hopper.	

NOTE: MACHINE SPECIFICATIONS ARE PERIODICALLY REVISED. IF QUESTIONS ARISE, CONTACT THE MARKETING DEPARTMENT OF HARRIS GRAPHICS OR YOUR LOCAL SALES REPRESENTATIVE.

STANDARD SPECIFICATIONS

For every two feed hopper spaces, bases contain the following electrical functions: (1) run, jog, stop station on operator side; (2) jog, stop station on feeder side; (3) fault light visible from either side, (4) raceway jam switch. Bases contain for each hopper space a one up/two up/neutral gearbox. Maximum number of hopper spaces in standard machine is 10.

NOTE: Harris Graphics does not warrant operating capabilities of equipment. The equipment described herein is powered to cycle mechanically as indicated. However, it must be understood that actual operating capabilities vary under different conditions for which Harris Graphics can assume no responsibility. The warranties contained in Harris Graphics' standard terms and conditions are the only warranties applicable to this equipment. Harris Graphics reserves the right to change the specifications of this equipment without notice.

7. Signature Feed HoppersStandard vertical P 15 type. Continuous feed with signatures on edge. Vacuum separation, double grippers on main drum, single gripper transfer and opener drum assemblies. Removable for interchangeability with cover and card feeders and for location in any frame space.
8. Signature OpeningLap gripper opening on high folio lap is standard. Optional vacuum (no lap) and reverse lap opening kits available.
9. Interconnection BasesModular steel construction. Includes all chain, track, drive connections, and electrics to connect stitcher to first inserter feed hopper off the feeder stand.
10. Master Caliper/InspectorDetects "over" and "under" signature sets. Detection accuracy, plus or minus, is .003" (.076 mm) minimum. Includes electric/electronic logic to activate stop stitch and auto reject devices. Three consecutive faults stop machine if desired.

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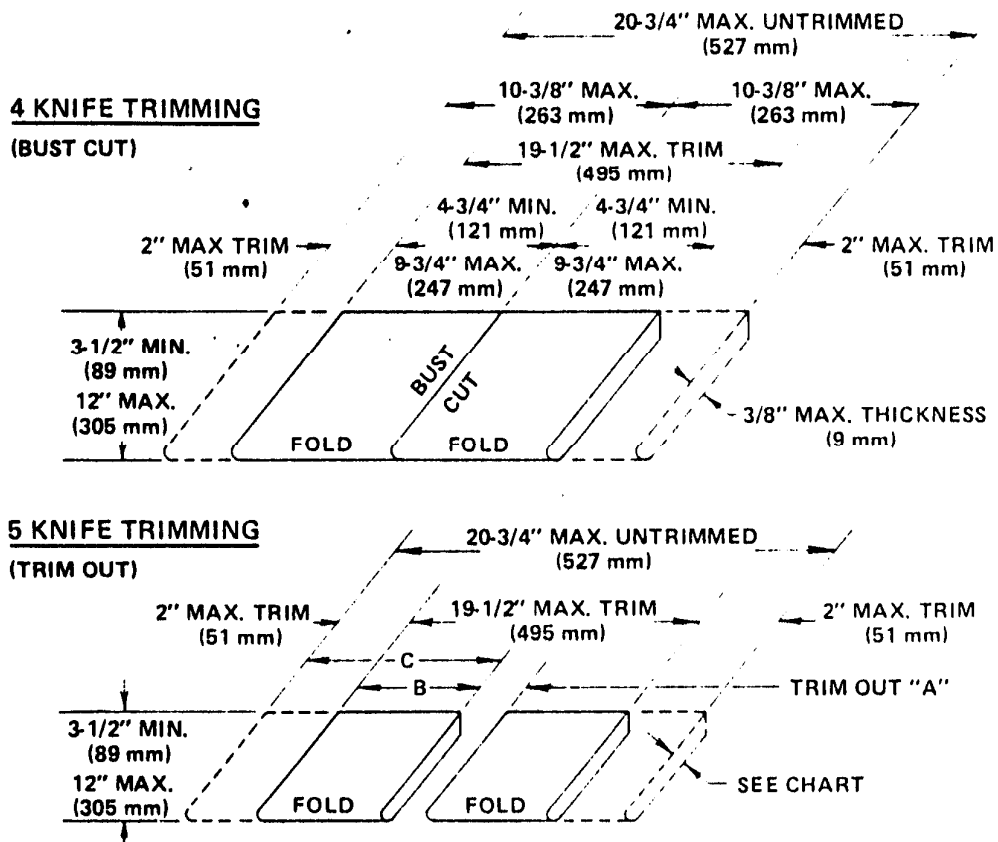
STANDARD SPECIFICATIONS

11. Raceway (Saddle) Chain.....Crowned steel chain with easily removable urethane pusher pins on fixed 21" (533 mm) centers.
12. Main Drive.....Standard 10 HP D.C. main drive motor with programmable system controller.
13. Operator Panel/Main Electrical.....Main enclosure is machine mounted and also supports Primary operator console panel.
Enclosure
14. Long and Skewed Signature.....Standard; activates stitcher stop stitch device
Detector and auto reject.
15. Vacuum Pumps and Blowers.....Standard and included for hopper signature
feed and opening. Low pressure air is for
saddle conveyor chain control of signatures.
16. Compressed Air RequirementsCustomer supplied; not required for basic
inserter, stitcher, trimmer but is required if
RIMA RS 10 or RS 12 is selected. (See RS
10/12 detailed specs).
17. StitcherStitches up to 1/4" (6 mm) thickness through
crown of book utilizing 55/7F (26D) style, 1/2"
crown, #25 round wire heads. Maximum
stitcher capacity is 6 heads which must be
ordered separately. See detailed specs.
Stitcher is of oscillating shuttle design with 90°
tuck/transfer delivery to trimmer infeed table.
Reject book delivery is included as standard.
18. TrimmerStandard is 3 knife reciprocating (non
"flying") type. Book delivery from stitcher is
by tapes to pusher chain infeed trimmer table.
See detailed choices for optional 4/5th and 6/
7th knife attachments.
19. Cutting RegisterBook is register-guided into face cut area
against double adjustable backstops, then
securely transferred to head/foot trim knives
by top/bottom indexing belts.

STANDARD SPECIFICATIONS

20. Knives.....Three cutting and three bed knives; cutting knives are guided by pre-loaded ball bearings (no adjustment necessary). Shear action for cutting.
21. Setting of KnivesSingle hand crank to adjust head to foot cutting and bed knives. Face cut stop fingers are adjusted for face cuts by direct measurement.
22. Maximum Trim Allowance2" (51 mm) on all 3 sides.
23. Chip RemovalMechanical Belt Conveyor removes chips from under knives to empty box, to optional Chip Removal System, or into house disposal system.
24. Delivery.....Choice is one of (a) 60" Belt Conveyor, which indexes and counts only when good books are being delivered; (b) connections to counter stackers.
25. Lubrication.....(1) Manual oil and grease fittings on feeder and connection base as required.
(2) Raceway chain has automatic oiler as standard.
(3) Stitcher equipped with centralized automatic oiling system as standard.
(4) Trimmer equipped with centralized automatic oiling system as standard.
26. Factory Wiring.....Standard.
27. ControlsJog, run and stop controls located every two hopper spaces and on stitcher and trimmer. Main control panel contains on-off for blower and vacuum, main drive speed range control, caliper controls.
28. Power RequiredApproximately 15 KVA.

4TH AND 5TH KNIFE SPECIFICATIONS (optional equipment)



A TRIM OUT SIZE	B TRIMMED BOOK SIZE		C MAX. OF TRIMMED BOOK + WASTE	MAX. BOOK THICKNESS
	MIN.	MAX.-		
1/2" (12.7 mm)	4-1/2" (114 mm)	9-1/2" (241 mm)	10-1/8" (257 mm)	5/16" (7.9 mm)
3/8" (9.5 mm)	4-9/16" (116 mm)	9-9/16" (243 mm)	10-3/16" (259 mm)	1/4" (6.3 mm)
1/4" (6.3 mm)	4-5/8" (117 mm)	9-5/8" (244 mm)	10-1/4" (260 mm)	3/16" (4.7 mm)

NOTE:

FOR ONE UP WORK (THREE KNIFE TRIMMING) 9" (229 mm) IS THE MINIMUM WIDTH TRIMMED BOOK WITH 4TH AND 5TH BED KNIVES IN PLACE.

Figure 3. 4th and 5th Knife Specifications