



DIGITAL FINISHING SOLUTIONS

FormerLine FoldLine

EVERY RUN. EVERY FOLD. EVERY FINISH.

From the printed web to the finished product.

FormerLine and FoldLine are engineered for modern digital printing: fast job changes, variable formats and reliable high-speed finishing.

Built for inline and nearline environments where industrial-scale performance is required.

Built to keep up with your digital press.

Built to never slow you down.

manroland | GOSS

Built for industrial digital finishing

Speed, precision and reliability. Non-stop.

FormerLine and FoldLine are engineered for continuous high-volume digital print production – with the flexibility to handle short and medium runs just as efficiently. Intelligent automation and seamless workflow integration maximize uptime, minimize waste and reduce operator intervention.

PRODUCTION SPEED

up to **305** m/min

SIGNATURES PER HOUR

up to **70,000**

CHANGEOVERS

1–5 min

PRODUCTION PERFORMANCE

24/7



YOUR BENEFITS

No more bottlenecks after the digital press.
Faster job changes. Make-ready on the fly.
Less operator intervention. More output.
Lower costs. Higher margins.

FormerLine

Efficient roll-to-book-block production



FormerLine is built for on-demand book production at industrial scale. Fast job changes, including make-ready on the fly, high output and outstanding folding quality make it the ideal finishing solution for modern digital print environments. Combined with digital printing systems, FormerLine delivers up to 7,000 book blocks per hour with 160 pages per book.*

* Output depends on printing system and cut-off length.



PERFORMANCE

Production speeds up to 305 m/min.
Up to 70,000 signatures per hour.
Fast job changes in 1–5 min,
including make-ready on the fly



FLEXIBILITY

Inline and nearline configurations.
Web widths up to 1,500 mm (59").
Up to 24 pages per copy.



QUALITY & RELIABILITY

Stable folding and stacking quality.
Precise cutting with stable high-speed flow.
Auxiliary gluing for stable book blocks.



Watch efficient roll-to-book block
production in action



flyer & mailings



auxiliary glued
book-blocks



signatures for
books & commercial



zigzag fold



delta fold



gate fold



parallel fold

Specifications	Metric	Imperial
Cut off min.	150 mm	5.9"
Cut off max.	496 mm	16.5"
Paper weight min. to max.	60 – 120 gsm	40.0 – 81.1 lbs
Paper weight "X-range package"	28 – 150 gsm	18.9 – 101.3 lbs
Production speed	3 m/s (180 m/min)	600 ft/min
Production speed with "speed package"	5 m/s (305 m/min)	1000 ft/min
Web width in the cutting module max.	254 mm	10.0"
Web width in the cutting module min.	105 mm	4.1"
Web width in the printer system [Basic 2 formers]	508 – 1016 mm	20.0" – 40.0"
Web width in the printer system [Option 3 formers]	508 – 1500 mm	20.0" – 59.0"
Web width in the printer system [Option 3 formers + SMM*]	508 – 1500 mm	20.0" – 59.0"
Minimum size of glued book-blocks	105 x 150 mm	4.13" x 5.9"
Maximum size of glued book-blocks	254 x 496 mm	10.0" x 19.5"
Pages per copy with 1 former max.	4 pages	
Pages per copy with 2 formers max.	8 pages	
Pages per copy with 3 formers max.	16 pages	
Pages per copy with 3 formers + SMM* max.	24 pages	

* Split and Merge Module

FoldLine

Flexible newspaper, book and commercial finishing



FoldLine combines newspaper production, commercial applications and book finishing in one highly flexible production platform. The multi-purpose system supports applications ranging from classic newspaper formats to stitched products, inserts and book block production. Designed for industrial web speeds up to 305 m/min, FoldLine delivers reliable high-volume performance across every application.



PERFORMANCE

Production speeds up to 305 m/min.
High-volume newspaper, book and commercial production.
Stable web handling at maximum speed.



FLEXIBILITY

Inline and offline configurations.
Chopper and crossfold production.
Up to 96 pages per copy.
Web widths up to 1,500 mm (59").



QUALITY & RELIABILITY

Reliable folding and collecting quality.
Inline stitched booklets and inserts.



Discover flexible high-volume newspaper production



auxiliary glued
book-blocks



signatures for
books & commercial



broadsheet & tabloid
newspapers



inline cylinder stitched
booklets



glued booklets &
inserts

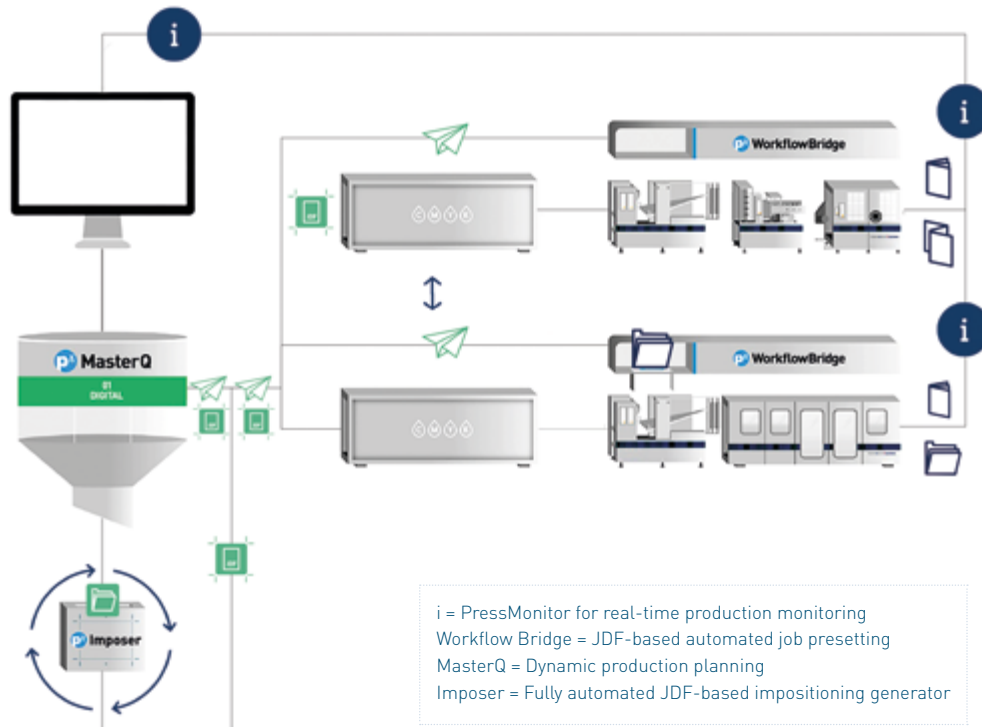
Specifications	Metric	Imperial
Cut off min.	420 mm	16.5"
Cut off max. chopper production	800 mm	31.5"
Cut off max. crossfold production	630 mm	24.8"
Paper weight min. to max.	45 – 120 gsm	30.4 – 81.1 lbs
Paper weight "X-Range paper"	28 – 135 gsm	18.9 – 91.2 lbs
Production speed max.	5 m/s (305 m/min)	16.6 ft/sec.
Web width in the folder max.	580 mm	22.8"
Web width in the folder min.	240 mm	9.4"
Web width in the printer system max.*	580 mm	22.8"
Web width in the printer system max.** [1 former]	1160 mm	45.66"
Web width in the printer system max.** [2 formers]	1500 mm	59.0"
Minimum size of glued book-blocks	120 x 210 mm	4.72" x 8.27"
Maximum size of glued book-blocks	254 x 400 mm	10.0" x 15.75"
Collecting min.	0 (1 sheet)	
Collecting max.	23 (24 sheets)	
Pages per copy crossfold or chopper production max.	96 pages (48 sheets)	

*former not in use **use of former

Folding sequence	Configuration	Capacity
Folding sequence 1	crossfold	4 – 96 pages in a 4-page increment
Folding sequence 2	former + crossfold	8 – 96 pages in an 8-page increment
Folding sequence 3	crossfold + chopper	8 – 96 pages in an 8-page increment
Folding sequence 4	former + crossfold + chopper	16 – 96 pages in a 16-page increment

Smart workflow automation

Automated from job setup
to finished product



CONNECTED PRODUCTION FOR MAXIMUM EFFICIENCY

manroland Goss workflow solutions automate and optimize every stage of the finishing process. From job setup and production planning to real-time monitoring and reporting. The result: faster changeovers, reduced waste and more efficient production workflows.

- Automated job setup via JDF/JMF
- Seamless workflow integration
- Dynamic production planning
- Real-time production monitoring
- Reduced waste
- Fast format and job changes



**FASTER
JOB CHANGES**



**REDUCED OPERATOR
DEPENDENCY**



**HIGHER
PRODUCTIVITY**



**STABLE & REPEATABLE
PRODUCTION PROCESSES**

THE PRESS RUNS. THE FINISHING KEEPS UP. WE MAKE SURE IT DOES.

- Decades of experience in web offset and digital finishing
- Proven industrial production technology
- Global service and support network
- Reliable long-term production performance

Find the right finishing solution for your production.

Talk to our experts:

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manroland | GOSS

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Machine illustrations may show optional equipment and individual configurations. Scope of delivery and machine configuration may vary. Technical specifications are subject to change without notice. Performance data may vary depending on configuration, substrate and production environment.