

Book Binding Explained

SMYTH SEWN

All signatures must have lap on high folio side ¼” minimum. BindTech recommends 3/8-1/2 inch.

- There is no perforation on the spine of signatures that are going to be sewn.
- On page one of signature one and last page of last signature mask back, free of inks and coatings, 3/16” for end sheet tipping.
- Mask back last page of first signature and first page of last signature, as well as first page and last page on final fold on all other signatures (pp1 and pp16) 1/16” free of inks and coatings.
- BindTech recommends minimum head, foot and low folio face trim of 3/16”.
- Any additional tips must be mask backed 3/16” on the tip as well as the signature in which it is being tipped.
- All four and two page signatures must be tipped between regular full signatures.
- BindTech recommends that the grain of the text and the end sheets run parallel to the binding side to minimize wrinkles (waves) in the paper.
- All furnished end sheets must be at least .006 thick (80# uncoated Vellum or 100# smooth).
- Any excess trims need to be divided evenly between the head and foot. Please check with Bind-Tech if there is any additional trim amount in advance.
- On thin books, backbone of spine will rock front to back, minimum spine board is ¼”.
- Headbands: the bulk of book must be 5/16” or greater to have headbands.
- Signatures to sew must be folded 16s or greater. Eight page signatures can be sewn intermittently throughout the 16s.
- If a Smyth sewn book consists of all eight page sigs, they must be nested to form 16 page sigs.

MECHANICAL BINDING

- Allow 3/16” trim off spine of signatures
 - Use light perforation on head and spine (please do not over perforate which could create gathering problems with signatures pulling apart).
 - Allow ¼” head, ¼” face, and ¼” foot trim. Bleed in the appropriate bleeds 3/16” into the trim.
- Note- These trims can be adjusted to accommodate web cut offs and different sheet size. Please advise if different trims are needed.
- Signatures can be folded without a lap.
 - Grain of text should run parallel to binding edge.
 - Copy should be laid out to avoid avoid punching through type. We recommend a ½” clearance area
- It’s your experience, your journey, your guide. Let it be know with our personal labeling.

PREFERRED PACKAGING

- Package all signatures between bundle boards on 40x48 pallets or 42x48 pallets. Two way entry preferred for better strength.
- Maximum height of load including skid should be 50 inches.
- Stretch wrap all skids heavily as well as cross band with matching top board.
- Label each skid on two entry sides with skid tag noting signature number and quantity of forms on that particular skid. Also, please either tape or insert under stretch film one signature per skid that may be removed when load is received.
- Package covers similar to signatures with the maximum height of 50” including pallets. Please send two covers separate, in full size press sheets with signatures.
- Please send separate from skids two sets of actual printed signatures numbered in order as well as any other appropriate packaging and purchase order information.

PERFECT BOUND

Text

- Allow 1/8"-3/16" grind off spine of signatures.
- Use light perforation on head and spine (please do not over perforate which could create gathering problems with signatures pulling apart).
- Allow 1/4" head, 1/4" face, and 1/4" foot trim. Bleed in the appropriate bleeds 3/16" into the trim.
Note- These trims can be adjusted to accommodate web cut offs and different sheet sizes. Please advise if different trims are needed.
- On first page first signature and last page last signature, mask 3/16" area free of links and coatings beyond the 1/8" grind for side glue application.
- Mask back inks and coatings 1/16" on all other pages (excluding the first page and last page) beyond the grind off. This is done so that there can be better glue adhesion to text stock.
- Signature can be folded without a lap.
- Grain of text should run parallel to binding edge.
- Maximum signature size, front to back, cannot exceed 12 1/2 inches.

Cover

- On very thin books (1/8") spine may have a slight rounded effect.
- Grain of cover must run parallel to binding edge.
- Gatefold should be well secured with head and foot tack falling beyond the trim size. Gatefold should be a minimum of 1/8" short of face trim. Note- In some instances the tack is not needed.
Please consult on a job-by-job basis.
- One-up cover to equal untrimmed signature size head to foot plus 1/8" head and 1/8" foot for glue trapping. Please match trims and bleeds with signatures.
- Minimum flat cover size for a perfect bound book must be at least 9-1/2" left to right.
- On inside of cover if printed, please mask back inks and coatings where spine and side glue adheres. This dimension will be the bulk of book plus 3/16" front and 3/16" back for side glue.
- If covers are UV coated, please note that you may experience some enhanced cracking of coating where spine wraps book as well as where cover hinges.
- For any special specifications such as gatefolds, foldouts, special coatings, etc.

PERFECT BOUND SOFT SPECIFICATIONS & GUIDE LINES

Text

- Allow 1-8"-3/16" grind off spine of signatures.
- Use light perforation on head and spine (please do not over perforate which could create gathering problems with signatures pulling apart).
- Allow 1/4" head, 1/4" face, and 1/4" foot trim. Bleed in the appropriate bleeds 3/16" into the trim. Note--These trims can be adjusted to accommodate web cut offs and different sheet sizes, but 1.5 inch trim is our max off any edge. Please advise if different trims are needed.
- On first page first signature and last page last signature, mask 3/16" area free of inks and coatings beyond the 1/8"-3/16" grind for side glue application on hot melt and PUR glue. On PUR lay-flat it needs to be increased from 3/16 to 5/16 beyond the grind for the side glue application.
- Signature can be folded without a lap.
- Grain of text should run parallel to binding edge.
- Maximum signature size cannot exceed 12 1/2 inches front to back.

Cover

- On very thin books (1/16 to 1/8) spine may have a slight rounded effect.
- Grain of cover should run parallel to binding edge for best quality.
- PUR lay-flat covers have 2 scores. The first score is approximately 3/16's from the binding edge and the second score is approximately 3/8 from the binding edge.
- Gatefold covers that fall short of the face trim should be a minimum of 1/8" short of face.
- Gatefold covers that fall flush with the face trim do not have to be tacked closed at the head and foot anymore.
- Best scenario, one-up cover to equal untrimmed signature size head to foot plus 1/8" head and 1/8" foot for glue trapping. Please match trims and bleeds with signatures.
- Minimum flat cover size for a perfect bound book must be at least 9-1/2" left to right.
- On inside of cover if printed, please mask back inks and coatings where spine and side glue adheres. This dimension will be the bulk of book plus 3/16" front and 3/16" back from the spine for regular perfect binding or PUR perfect binding. For PUR lay-flat it will be the bulk of book plus 5/16" front and 5/16" back from the spine.

PREFERRED PACKAGING

- Package all signatures between bundle boards on 40x48 pallets or 42x48 pallets. Two-way entry preferred for better strength.
- Maximum height of load including skid should be 50 inches.
- Stretch wrap all skids heavily as well as cross band with matching top board.
- Label each skid on two entry sides with skid tag noting signature number and quantity of forms on that particular skid. Also, please either tape or insert under stretch film one signature per skid that may be removed when load is received.
- Package covers similar to signatures with the maximum height of 50” including pallets. Please send two covers separate, in full size press sheets with signatures.
- Finally, please send separate from skids two sets of actual printed signatures numbered in order from one through eight as well as any other appropriate packaging and purchase order information.