



Side sewn Hardbound Specifications & Guidelines

Text

- No grind off on spine of signatures.
- Use light perforation on head and spine (please do not over perforate which could create gathering problems with signatures pulling apart).
- Max trims allowed, 1/4" head, 1/4" face, and 1/4" foot trim.
- Minimum trims allowed, 1/8 head, 1/8 face, and 1/8 foot.
- Bleed in the appropriate bleeds 1/8" into the trim.
- Signature must be folded without a lip/lap.
- Folded signatures stack on top of each other. **They Do Not insert like a saddle stitched book.**
- Grain of text should run parallel to binding edge.
- For any special specifications such as gatefolds, foldouts, special coatings, etc. please call for further guidelines
- Side sewn thread will be 3/16 +/- from the binding edge. Any image in this area will not be visible*.
- *Make sure to bleed ink or crossovers into this area so no white will be visible.

Endsheets

- Grain on endsheets **must** run parallel to binding edge.
- Endsheets must have the same head, foot, and face trim as the other untrimmed signatures in the book
- Endsheets do not have a grind off.
- Endsheets should bulk .006 to .01

Printed Covers

- If the cover is printed, please consult BindTech for the size.
- All printed covers must be film laminated for strength and durability.
- The grain must run parallel to the binding edge on all printed cover wraps.
- Do not use aqueous coating when printing the cover wrap.

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.