

Binding Guidelines for Smyth Sewn **Hard** Cover Books

Text

- All signatures must have lap (lip) on high folio side 1/4" 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, 1/8" for **end sheet tipping**.
- Allow a minimum of 1/8" head, 1/8" face, and 1/8" foot trim. Bleed in the appropriate bleeds 1/8" into the trim. Note: These trims can be adjusted to accommodate web cut offs and different sheet sizes, but 1.5" trim is our maximum off any edge. Please advise if there are any different trims.
- All four- and two-page signatures must be tipped between regular full signatures.
- All tips and the signatures they tip to must have the inks and coatings masked backed 3/16" along the binding edge where they meet. On the **opposite** side of the tips and the signatures they tip to, **do not** mask back the ink and coatings.
- **Example:** a book consists of 2-16, 1-4, 2-16 for a total of 5 signatures. Only page 4 of the four pager and page 1 of the 16 pager that follows it needs 3/16" knocked out along the binding edge. Page 1 of the four pager and page 16 of the 16 pager that precedes does not need any knockout.
- BindTech recommends the grain of the text should run parallel to the binding side to minimize wrinkles (waves) in the paper.
- Any excess trims need to be divided evenly between the head and foot. Please check with BindTech if there is any additional trim amount in advance of printing.
- On thin books, backbone of spine will rock front to back slightly, minimum spine board is 1/4".
- Headbands: book bulk must be 3/8" or greater to have headbands.
- Signatures for sewing must be folded 12's or greater. Eight page signatures can be sewn intermittently throughout the larger signatures.
- If a Smyth sewn book consists of all eight page sigs, they must be **nested** to form 16 page sigs.
- When heavy/thick stocks are used as the text, you may see some "bubble gumming". (Glue squeeze up through the sewing holes)
- 12, 8, 4 and 2 page signatures should not fall as the first or last signature in the book.
- Maximum **untrimmed** signature size cannot exceed 12 1/2 inches front to back unless approved by BindTech in advance for oversized books.

End sheets

- **All furnished end sheets must be at least .006 thick (80# uncoated).**
- Grain on the endsheets **must** run parallel to the binding side.
- Mask back ink and coatings 1/8" on page 4 of the front end sheet and page 1 of the back end sheet.
- Endsheets must have the same head, foot and face trim as the other **untrimmed** signatures in the book

Printed Case Wraps (covers)

- If the case wrap is printed, please consult BindTech for the size.
- All printed covers (case wraps) **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 ten, etc. as well as any other appropriate packaging and purchase order information.