Binding Guidelines for Smyth Sewn <mark>Soft</mark> Cover Books

<u>Text</u>

- All signatures must have lap (lip) on high folio side 1/4" minimum. BindTech recommends **<u>3/8-1/2</u>** inch.

- There is **<u>no</u>** 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 the **hinge/side-glue adhesion.**

- 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 <mark>opposite</mark> side of the tips and the signatures they tip to, <mark>do not</mark> mask back the ink and coatings.

- <mark>Example</mark>: 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 that the grain of the text 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.

- Signatures to sew must be folded 12s 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 ½ inches front to back.

<u>COVER</u>

- On very thin books (1/8") spine may have a slight rounded effect.

- Grain of cover must run parallel to 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 smyth sewn soft cover 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. please call for further guidelines.

<u>PREFERRED PACKAGING</u>

- 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. **(2025)**