



express solutions

HARD BINDING GUIDELINES

Following are a few key points to remember when planning for sewn hardbound books.

1. Signatures should all be the same length from head to foot and it is always helpful to have collating marks stripped in at the spine fold.
2. Signatures should have a 1/4" high or low folio lap for pick up on the sewing machines.
3. Non-lap portion of signatures must remain constant from sig. to sig.
4. White space required (no ink) on signatures for sewn, hardbound books.

3/16" white space required at spine on first and last page of book for end sheet adhesion and on any two signatures that require tipping.

1/16" white space on each side of the binding edge, of all folded signatures, to help backbone adhesion. (Remember on inserting which pages end up outside) All inside pages may bleed to gutter.

5. Minimum of two signatures for sewn books and a minimum thickness of .100, which includes end sheets.

6. 3/16" plus trim is recommended. (head, foot, face, and lip)

7. Signatures must have a closed spine (not perforated) to allow for sewing through the gutter of the signature.

8. A 2-page insert must be tipped to the outside of another signature. Tips to first and last signatures should be avoided if possible.

9. End sheets should be on uncoated stocks, 80 lb. text weight equivalent, and grain parallel to spine. Exceptions can affect the quality of the book and should be discussed prior to production.

10. A 4-page signature must be tipped to the outside of a sig. or paged sequentially to insert into the middle of, or wrap around the outside of a signature. A 4-page cannot be sewn by its self.

11. It is preferable to avoid 8 or 12 page signatures when sewing. An 8 page can be inserted into another 8 page to make a 16 page or into a 16 page to make a 24 page. Attempting to make a book using 8's or 12's could result in an inferior book unless where those signatures are on 100# or heavier stock.