

TechLines

Technical Information Sheet

B3

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Changes in RED

Perfect Bind Specifications

HOT GLUE PERFECT BINDERS

KOLBUS I - 32 pockets**MUELLER-MARTINI Bolero - 24 pockets with PUR glue and Layflat capabilities**

Covers

The heavier, stiffer the stock, the more efficiently a job runs. We recommend the following stocks:

8pt, 9pt & 10pt board stocks

65# & above uncoated cover

80# & above coated cover

80# & above coated text weight

If text stock is 30# or less, a 100# text weight is the recommended minimum.

67# Vellum Bristol or 65# uncoated covers are difficult to run since the porous qualities of the stock allow air to bleed through the stock.

UV coating, aqueous or at least varnish on covers is recommended to avoid marking.

A hinge score is standard. With layflat, there is a double score on the front and back covers.

Except for digest-sized projects, we require that trimmed covers have an allowance to catch glue spill.

Covers **must extend** beyond text signatures. For books less than 2" thick, we need 1/16" at the top and another 1/16" at the bottom. For books 2" or thicker, we need 1/8" at the top and another 1/8" at the bottom. Our web press text signatures are 11-5/8" tall.

To ensure a stable backbone, it is critical that all parts be printed with the grain running parallel to the spine. This includes the cover, bind-in cards, inserts and sheet press or web press signatures.

Inserts or signatures printed using the heatset web method, when combined with non-heatset signatures, will grow out past the final trim edges. If printed grain parallel to the spine, the pages will grow out at the face. If printed grain perpendicular to the spine, they will fight to grow at the top and bottom and put undue stress on the spine, weakening the spine and creating puckers in the pages.

Signatures

The heavier the paper stock, the more efficiently a job will run.

Job runs better and faster if signatures are properly jogged and stacked/blocked off the press.

A dummy **MUST** be provided for the correct set-up of the pockets.

Signatures should be the same size without a lap.

Signatures are to be supplied with a 1/8" skive allowance and a minimum of 3/16" trim at the closed head of the signatures.

Any supplied signature, insert card or other part that extends beyond all other signatures must be pre-trimmed prior to binding.



Single sheet inserts positioned next to either cover

Due to binder design, lightweight single sheet inserts placed next to either cover have a tendency to tip away from the spine.

To attain quoted run speeds, we require a .007" minimum caliper for these inserts. The following stocks are recommended:

67# vellum bristol	80# offset cover
65# offset cover	90# index
75# hi-bulk return card	100# coated cover
8pt, 9pt & 10pt covers	110# index

We understand that pre-printed inserts obtained from national manufacturers often do not meet this minimum caliper. These inserts should be placed between text signatures. If you must use such an insert next to either cover, we need to discuss the implications and reduced binder speeds.

Insert cards

Cards are progressively worse to run the smaller they are. We recommend binding on the longest dimension.

Cards will jog to the head of the book

Preferred minimum 4"W x 6"H; bind on 6" side

Absolute minimum 3"W x 5"H; bind on 5" side

Maximum – Same size as press signatures (8-3/4" x 11-5/8")

All cards must be set up with same head/foot trim as other signatures.

Multiple-page stitched inserts

In order to place this type of insert into a perfect bind catalog, the following points need to be considered.

Paper: virtually no special limitations except papers that contain high clay content or other additives, such as Titanium. These stocks will dull trimmer knives more quickly. We need to be informed of this at the estimating stage to allow for additional knife changes.

Preparation of the signatures: The insert(s) should be folded and untrimmed.

4 to 32 pages - should be supplied as one saddle-gathered unit.

36 to 64 pages - should be supplied as one saddle-gathered unit with a single staple.

Over 64 pages are not recommended as one unit. They should be printed as following forms and delivered uncollated. If this can not be done, skive allowance will need to be adjusted to ensure proper glue adhesion.

Skive/Trim allowances: In the binding process, we trim 3/16" at the closed head* of our web press signatures and skive 1/8" off the backbone (bind edge). We also require a minimum 1/8" trim at the face and at the closed end of the text signatures.

If your multi-page insert is the same dimensions or smaller than the book you are ordering, these required trims will result in a poor final product. If the insert is narrower or shorter than the finish size of the bound book, poor trimming results. For example, if the insert is placed at the front of

the book, the front cover has a ragged cut since there is no firm edge to cut against. If the insert is placed in the middle or towards the back, the pages in front of the insert appear ragged and bent. The more pages in these cases, the more pronounced the problem is. *Our recommendation in this case is to change the finished size of the complete piece to reflect the inserts. If you intend to use an insert that is already trimmed to 8-1/4" x 10-3/4", for example, the finish size of your book should be adjusted for trims/skive allowances to 8" x 10-9/16" (deducting 1/4" from width and 5/16" from height).*

**Regarding head/foot trim, our flattening standard is to place the foot of the copy at the closed head of our web text signatures. Pages are positioned foot-to-foot on our 8-page flats. Our standard foot trim is 3/16".*

If the insert is already trimmed with the pages open, keep in mind we will be trimming an additional 3/16" from either the top or bottom depending on flattening configuration.

Copy/Image area:

8-3/8" x 10-7/8" finished size

Preferred copy area: 7-5/8" x 10-1/8"

Maximum insert size: 8-3/4" x 11-5/8"

7" x 10" finished size

Preferred copy area: 6-3/8" x 9-3/8"

Maximum insert size: 7-3/8" x 11-5/8"

Extras: Any supplied insert that requires special handling (folding, collating or pre-trimming) will be subject to extra charges.

Perfect bound inserts

Many of the points noted in **Multiple-page stitched inserts** also apply here – paper, skive/trim allowances, copy/image area and extras apply here.

If this insert is over 1/4" thick it will need to be hand-fed on the binding line. This requires that the insert be placed at the front or the back of the catalog.

Pay special note in skive/trim allowances about trimming and final trim size.

Fold-Out Maps

Books requiring a folded map insert reduce binder speed.

Must be careful to plan so the map will not be cut open when the book is trimmed.

These require a 1/2" bind lap that includes the 1/8" skive allowance.

The maximum width of a map as measured from binding edge to first fold should be 1/4" narrower than the width of the book.

Any perforation must be 5/8" or more from bind edge.

Each consecutive panel should be narrower than the one to its left so it folds into itself.



Book dimensions

Minimum book thickness of 1/8".

Maximum book thickness is 3" on the Kolbus, 2-5/8" on the Bolero.

Minimum book thickness with PUR glue is 2-1/4"

Maximum layflat book thickness is 1-1/8"

Maximum width of a book would be 11-7/8" with a 2" spine. As the spine increases beyond 2" available width decreases the same amount.

Maximum length of a book is 15"

Maximum untrimmed size: 15-1/2" x 12-1/8"

Double Digest size books (5-3/8" x 8-3/8")

The Bolero has a book slitting saw which will cut gathered 2-up book block into two halves for final trim. The two halves must be the same size and the head and foot trims on the two halves must be the same.

If you will be producing a cover or insert for a digest size project, you are **strongly** encouraged to contact your customer service representative for complete details to make use of the slitting saw.

Jobs requiring more than 32 pockets

We can configure a large page count project in two or more "passes." A portion of the book is "pre-bound" taking a minimal skive and applying a thin layer of glue. This pre-bound block(s) is either handfed or run through a pocket (if less than 1/4" thick) with the remaining job parts.

Please contact your customer service representative to discuss binding plans so supplied signatures or inserts can be setup properly.

PUR Glue

PUR provides exceptional strength and quality in extreme temperatures along with a tougher binding for catalogs and books. It offers above standard page pulls, increased layflat quality and additional binding strength for coated and mixed paper stocks.

Layflat Binding

By adding a cloth liner and another score on the front and back covers, your project can have a layflat binding. The book block is suspended away from the backbone so there is some "give" and the book can be pushed down without breaking the backbone.

Layflat scores and cloth liner adhesion reduce available gutter space for inside covers' content by 5/8" at gutters.

Available only on the Bolero at additional cost.