

PUR/EVA

Perfect Binding Guidelines

Information Packet



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COVER

- **COVER MAXIMUM SIZE**
 - 15 3/8" Head to Foot
 - 25" Edge to Edge
- **COVER MINIMUM SIZE**
 - 5" Head to Foot
 - 8" Edge to Edge
- Furnished covers should be set up on uncut press sheets. Covers must allow for a minimum 1/4" glue trap on head and foot.
- Contact 3d for covers heavier than 12pt/120#.
- Provide blueline/mock up with guide & gripper clearly identified
- Grain of cover should run parallel to binding edge, for best results.
- Match trims and bleeds with signatures.
- For BEST RESULTS - Inside cover (if printed) should have spine area and side glue area free of inks and coatings. This will be the bulk of book (spine) plus 3/16" front and 3/16" back for side glue.
- UV coated and dark covers may experience enhanced cracking where spine wraps as well as where the cover hinges.

CALCULATING SPINE THICKNESS

- Measure your block as accurately as possible, using calipers.
- Take your spine measurement PLUS the cover thickness (x2) PLUS an additional 1/32 for glue widening.

Ex: 1/2" BOOK BLOCK

$.50 + .0095 + .0095$ (100# gloss cover) + $.031 = .55''$

*(This will be your **FILE/ART** thickness only)*

** Scores for bindery are still calculated at the 1/2" thickness.*

TEXT/SIGNATURES

- **SIGNATURE MAXIMUM SIZE**
15" Head to Foot, 12.25" Spine to Face
- **SIGNATURE MINIMUM SIZE**
5" Head to Foot, 4.25" Spine to Face
- **Book Block Minimum Thickness:**
5/64" (2mm / .08")
- **Book Block Maximum Thickness:**
2.00"
- Allow 1/8" grind off spine of signatures
- All Folded Signatures must be completely closed on binding edge
- Use light perforation on the head and spine. Over perforating will tear during collating.
- Allow minimum 1/4" head, 1/4" face and 1/4" foot trim.
(Maximum trim 3/4")
- 3/16" bleeds into the trim area appropriate
- Grain should run parallel to binding edge
- For BEST RESULTS - Mask 3/16" of first page of first signature and last page of last signature for side glue application.
- On very thin books (under 1/8"), spine may have a slight rounded effect. Recommend no text on spines less than 1/8" thick.

Continues for EVA

STANDARD EVA GUIDELINES

- **MINIMUM BOOK WIDTH**
4.5" spine to face
(book can trim smaller after bind)
- **MAXIMUM BOOK HEIGHT**
CALL FOR DISCUSSION
- **MINIMUM BOOK THICKNESS**
10 standard sheets
- **MAXIMUM BOOK THICKNESS**
1.75"

COVER:

Sheet size should have glue trap built in. Meaning your cover needs to be **minimum 1/2" taller** than the text block provided, at 1/4" top and 1/4" bottom

If your book block provided is 11.5" tall, cover needs to be at least 12"

* Do not trim Covers

INTERIOR:

Interior does not require grind on spine. EVA machinery only puts notches to allow glue absorption. Text should be provided with **minimum 1/8" trim on top, bottom, and face, binding edge cut on spine crop marks**. If this is not supplied, the book will finish just inside your finish size.

ALL JOBS MUST BE SCHEDULED A MINIMUM OF 3 DAYS IN ADVANCE TO AVOID RUSH CHARGES

Anticipate 5% - 8% Production Waste

We recommend a prudent 12-24 hour waiting time for complete curing. The benefits of PUR require a change of mindset. PUR is a 100% solid moisture-curing adhesive. Depending on the available moisture, 24 hours of curing time is NOT unusual.

ANY QUESTIONS OR CONCERNS SHOULD BE ADDRESSED PRIOR TO PRODUCTION.