

# PUR PERFECT BINDING PRE-PRODUCTION GUIDELINES

Maximum **FINISH** size: 13" Head to Foot & 12" Spine to Face

Minimum **FINISH** size: 4" Head to Foot & 3.5" Spine to Face

TEXT/SIGNATURES	COVER
<ul style="list-style-type: none"><li>• Allow 1/8" to 3/16" grind off spine of sigs</li><li>• Minimum Thickness: 5/64" (2mm)</li><li>• Maximum Thickness: 2"</li><li>• All Folded Signatures must be completely closed on binding edge</li><li>• Use light perforation on the head and spine Over perforating will tear during collating.</li><li>• Allow minimum 1/4" head, 1/4" face and 1/4" foot trim. (Maximum trim 3/4")</li><li>• 3/16" bleeds into the trim area appropriate</li><li>• Grain should run parallel to binding edge</li><li>• For BEST RESULTS - Mask 3/16" of first page of first signature and last page of last signature for side glue application.</li><li>• <b>Maximum signature size:</b> 15" Head to Foot, 12.25" Spine to Face</li><li>• <b>Minimum signature size:</b> 5" Head to Foot, 4.25" Spine to Face</li><li>• On very thin books (under 1/8"), spine may have a slight rounded effect. Recommend no text on spines less than 1/8" thick.</li></ul>	<ul style="list-style-type: none"><li>• Furnished covers should be set up on uncut press sheets. Covers must allow for a minimum 1/4" glue trap on head and foot.</li><li>• Contact 3d for covers heavier than 12pt/120#.</li><li>• Provide blueline/mock up with guide &amp; gripper clearly identified</li><li>• Grain of cover should run parallel to binding edge, for best results.</li><li>• Match trims and bleeds with signatures.</li><li>• 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.</li><li>• UV coated and dark covers may experience enhanced cracking where spine wraps as well as where the cover hinges.</li><li>• <b>Maximum cover size:</b> 15 1/2" Head to Foot, 25" Edge to Edge</li><li>• <b>Minimum cover size:</b> 5" Head to Foot, 8" Edge to Edge</li></ul>

## SETTING UP YOUR SPINE THICKNESS IN FILES

When calculating your spine thickness, measure your block as accurately as possible, using calipers. Take your spine measurement + the cover thickness (x2) + an additional 1/16 for glue widening.

Ex: 1/4" book block + .0095 + .0095 (100# Gloss cover) + 1/16 = .331 (This will be your **FILE/ART** thickness only)

*Scores for bindery are calculated at the 1/4" thickness.*

## 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.

