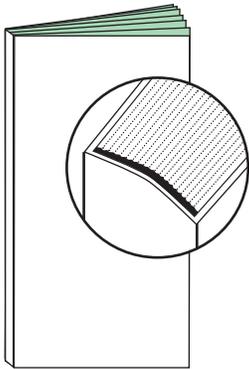


# Binding

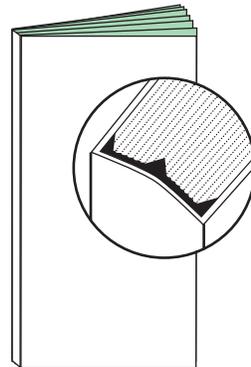
## Perfect and Case Binding

- Ink should not be inside the glue area at the bind.
- For Perfect Bind, edge of each signature will likely have 1.5mm to 3mm of grind off so glue holds better.
- For Burst Bind, each signature will be nicked in short lengths during folding to allow glue to reach each page, forming a tighter bond than Perfect Binding alone.
- For Case Bind; Signatures are stitched together with thread for strength.
- Two main types of glue are PUR (Polyurethane Reactive) and EVA (Ethylene Vinyl Acetate);
  1. PUR is longer lasting and holds better, but is more expensive and harder to work with, as it cures when exposed to air. Usually applied from a nozzle system.
  2. EVA is a hot melt, meaning it can be reactivated if reheated, and can become brittle in cold temps, or over time. Usually applied by a continuous flow tank.



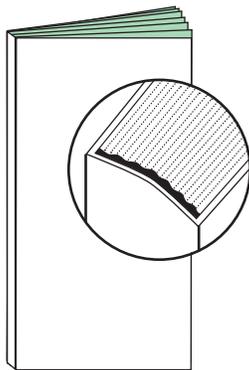
### Perfect Binding

Bind edge ground off to expose paper fibers.  
Signatures are bound to the cover.



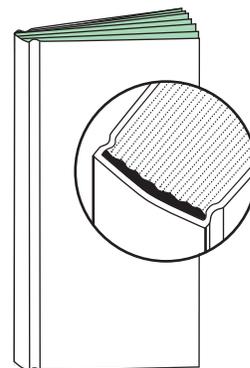
### Lay Flat Perfect Binding

Using a flexible glue on only the edges of the spine,  
allows the book to “lay flat”.  
Signatures are not bond to the cover, only each other.



### Burst Perfect Binding

Each leaf and section is adhered with the glue,  
burst binding is considered to be a more robust  
form of binding than perfect binding

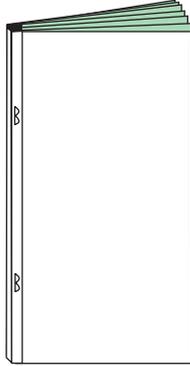


### Case Perfect Binding

Three basic steps to case binding:

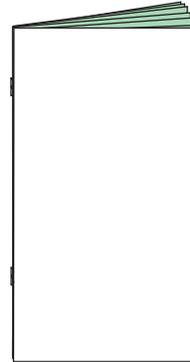
- 1) Thread Sewing - Signatures are stitched together with thread.
- 2) Forwarding - Consists of “rounding” and “backing” for the spine.
- 3) Casing In - Attaching the cloth-covered cardboard case.

# Binding



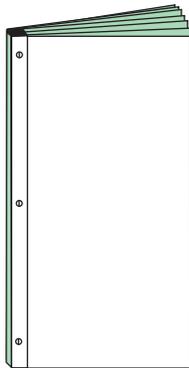
## Side Stitch Binding

Two or more staples placed on face at the bind edge.



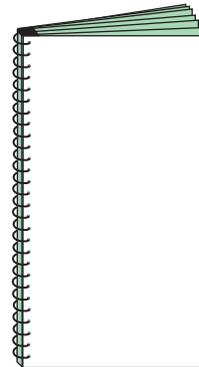
## Saddle Stitch Binding

Two or more staples directly in the center of the bind edge.



## Screw and Post Binding

One or more metal posts drilled into the face of the bind edge. It may or may not be accompanied by a strengthening backer.



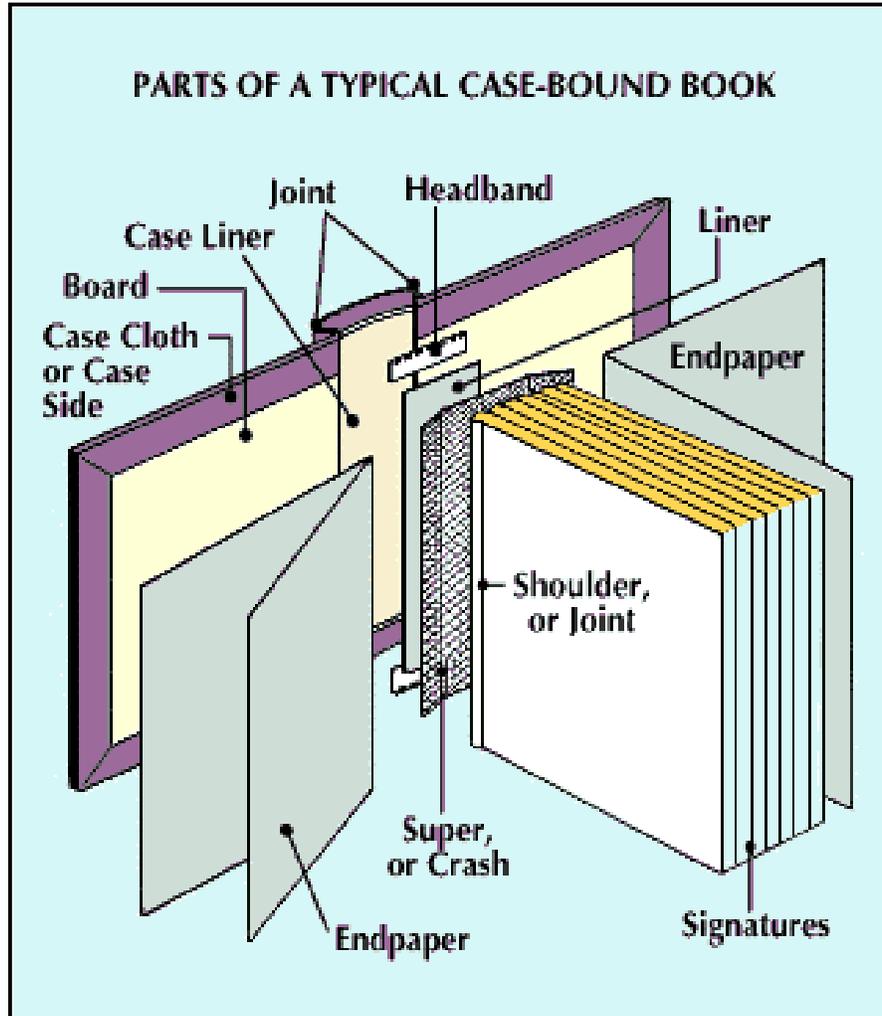
## Spiral Binding

Also known as:

Spiral coil, color coil, colorcoil, ez-coil, plastic coil, plastikoil and coilbind.

Uses a plastic (or metal) spiral coil that is inserted at the bind edge. Different “itches” are used, but the most common is a 4:1 pitch or about 6mm.

# Hard Cover Case Building



## Hard Cover Case Making

Hard Cover Case Making is a bit of an art form, and every Case maker you talk to will have their own formula or calculator to build the cover file to their specifications. With that said, here are some of the components that need to be specified to calculate hard cover file trim size;

- Cover bleed margin
- Printed case wrap amount
- Binder board overhang
- Binder board thickness
- Cover hinge backspace (per side)
- Maximum spine
- Minimum spine
- Spine rounding factor % (rounded or square)
- Book block thickness
- Binder Board Height
- Binder Board Width

### Note:

Different countries use different standards for Hard Cover book rounding, the USA, most of the EU, and Germany all have different degrees of “roundness”.