

Paper stocks for adhesive binding are rated in the following order for holding quality:

- 1.) Uncoated text stocks
- 2.) Matte finish coated stock
- 3.) Coated stock (Calendared)

The "holding" quality of a paper stock refers to the strength of the bond between the adhesive and the paper fiber. Stocks with the highest quantity of long fibers offer the best surface for glue to adhere. For that reason, uncoated text stocks are easiest to bind. Enamel, matte and gloss coated stocks are most difficult because they have fewer fibers and a higher clay content.

For best adhesion and durability, the grain of the paper should run parallel with the binding edge on both covers and signatures. Cross-grain paper may be bound, but it creates a book that can be difficult to open, with reduced strength, less flexibility and possible waviness of the spine.

To maximize strength, coatings should be kept free of the adhesion area.

On the first and last page of an OTABIND book, and inside front and back cover, the distance from the spine to the printed image must be at least 7/16" after spind grind off to allow for the adhesion of the cover.

Covers must be laid out on both OTABIND and Perfect bind with at least 1/16" additional trim on head and foot, longer than the longest folded signature. We prefer to cut your cover press sheets.

SPOILAGE ALLOWANCE TO INSURE FULL COUNT:

- Allow 10% overrun of signatures for orders to 3,000 books.
- Allow 6% overrun of signatures for orders up to 5,000 books.
- Allow 5% overrun of signatures for orders up to 10,000 books.
- Allow 3% overrun of signatures for orders over 10,000 books.

MAXIMUM AND MINIMUM SIZE SPECIFICATIONS:

- Minimum flat cover – 8-1/2" (width) x 5-1/2" (spine)
- Minimum untrimmed signatures – 4" (width) x 5-1/2" (spine)
- Maximum untrimmed signatures – 11-7/8" (width) x 15-3/4" (spine)
- Minimum thickness – 1/8"
- Maximum thickness – 2" (Perfect Bound); 1-1/2" (OTABIND)
- Minimum Spine Grind – 1/8"
- Maximum Spine Grind – 1/4"
- Number of pockets for binding in one pass – 27
- Maximum head and foot trim – 1-5/8" OR Max. face trim – 1-1/2"
- *Not both on one project; call if your project has large trim offs.

Raw signatures must have a minimum of 1/8" trim on all four sides.
ALL FOLDED SIGNATURES MUST HAVE CLOSED SPINE.

PERFECT: Minimum trim size on 3 knife trimmers – 3" x 4"
Maximum trim size on 3 knife trimmers---11-3/4" x 15-1/2"

OTABIND: Minimum trim size on 3 knife trimmers---4" x 5"
Maximum trim size on 3 knife trimmers---11-3/4" x 15"

As spine length increases, width must decrease. Please call when working with large trims sizes or let us help with any questions you may have.