Information

Determining the file format and finished size

Number of pages (incl. cover)	Material interior		
	Paper weight (e.g. 90 gsm silk)	Paper weight (e.g. 135 gsm glossy)	Paper weight (e.g. 170 gsm silk)
	Spine thickness		
30	-	-	3.0 mm
34	-	-	3.0 mm
38	-	3.0 mm	3.0 mm
42	-	3.0 mm	3.5 mm
46	3.0 mm	3.5 mm	3.5 mm
50	3.0 mm	3.5 mm	3.5 mm
54	3.5 mm	4.5 mm	4.0 mm
58	3.5 mm	4.5 mm	4.0 mm
62	4.5 mm	C 5.0 mm	4.0 mm
66	4.5 mm	5.0 mm	4.5 mm
70	5.0 mm	5.5 mm	4.5 mm
74	5.0 mm	5.5 mm	4.5 mm
78	5.5 mm	6.5 mm	5.0 mm
82	5.5 mm	6.5 mm	5.0 mm
...	...	...	...

EXAMPLE:
The **paper weight** 135 gsm glossy and the **total number of 62 pages** result in a **spine thickness** C of **5.0 mm**, as can be seen on the chart.

Calculation: Width file format A
305 mm + 6 mm = **311 mm**

Calculation: Width finished size B
150 mm + **5 mm** + 150 mm = **305 mm**

The exemplary chart and layout use fictitious numerical values!

Finished size + bleed · A
Width U4 + C + width U1 · B
Width U4 · C · Width U1
Height U + bleed · A
Height U · B
U4 · Back · U1

Print files

Cover

U4 · Back · U1

Cover exterior
(document page 1)

Interior

1 · 2 · 3 · 4 · 5...

Interior pages
must be delivered in chronological order (PDF with multiple pages).

Please deliver two print files:
**Cover:** 1 document page
Interior: multiple pages

Finished product
We create your finished product from the two print files (cover and interior) delivered by you.

The **spine thickness** C of this product varies depending on the total number of pages. Therefore, the spine thickness must be used to calculate the print data (file format).
To calculate the **file format and finished size** of your cover pages, consult the chart to determine the necessary dimensions of the **spine thickness** C (see last PDF page).
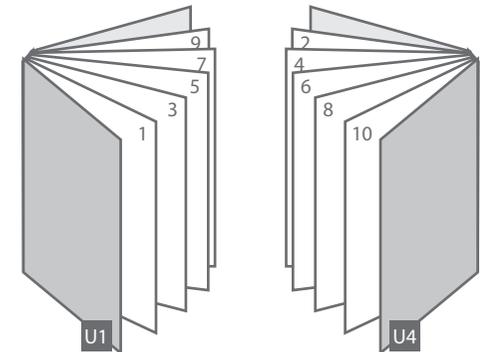
Hard back perfect binding
A4, format portrait, left side binding

Document page 1: **Cover – exterior**

464 mm + C
430 mm + C
215 mm C **215 mm**
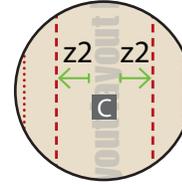
A
B

A
B

336 mm
302 mm

D   D
8

U4   U1

13
2
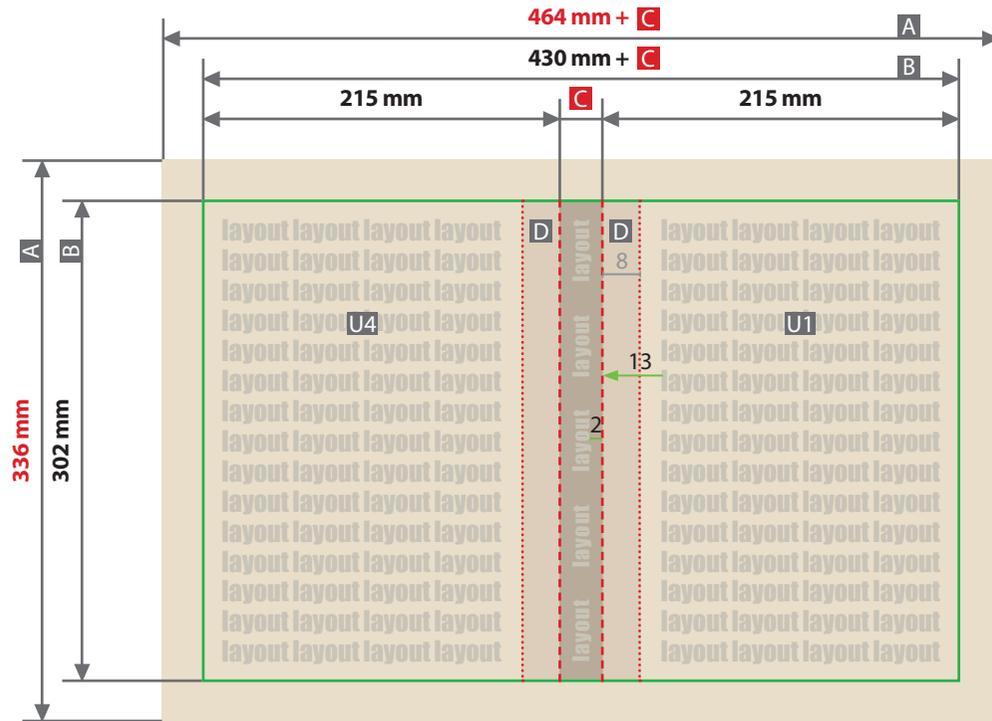
Folded final format
215 x 302 mm
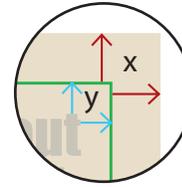
Bleed (x)
17 mm

Safety distance (y)
5 mm

z1
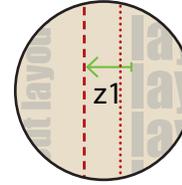
Safety distance spine (z1)
13 mm from back to title

z2   z2
C

Safety distance spine (z2)
2 mm to back and title

A = File format

B = Final format

C = Spine width: the measurement can be found
       the chart below.

D = Crease

U1 = Cover front

U4 = Cover back

Diagrams not to scale

Adhesive binding
A4, format portrait, left side binding

Inner part

216 mm A

210 mm B

303 mm **297 mm** A B

E
layout layout layout
layout layout layout
layout layout layout
layout layout layout
layout layout layout
layout layout layout
layout la**D**ut layout
layout layout layout
layout layout layout
layout layout layout
layout layout layout

216 mm A

210 mm B

E layout layout layout
layout layout layout
10 layout layout layout
layout layout layout
5 layout layout layout
layout la**C**ut layout
layout layout layout
layout layout layout
layout layout layout
layout layout layout
layout layout layout

x

y

Bleed (x)
3 mm

Safety distance (y)
5 mm

z z

D C

Safety distance to the binding edge (z)
10 mm

A = File format

B = Final format

C = Right side

D = Left side

E = Glued, non-visible area
Apply background only!

1 C

2 D

3 C

... D

... C

96 D
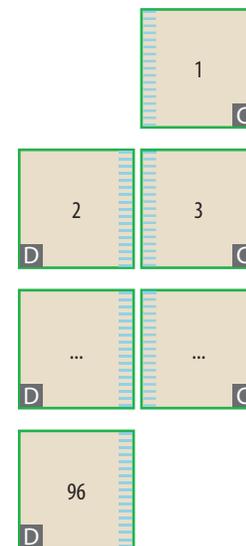
Print file 2
Interior: multiple pages

Number of pages
The selected number of pages (including cover), **excluding the 4 pages for the cover** is the **number of inner pages.** Regardless of whether the cover can be printed in a 4/0 single sided print or 4/4 double sided print the cover always has **4 pages**.
Example:
Number of pages 100 - 4 cover pages = 96 pages.

Interior pages
- Interior begins with a right page (C)
- Interior ends with a left page (D)
- Deliver pages in chronological order
- If there are empty (white) pages, these need to be included in the print file.

Glued area (E)
Due to the perfect binding, 5 mm of the layout space is not visible in the binding.
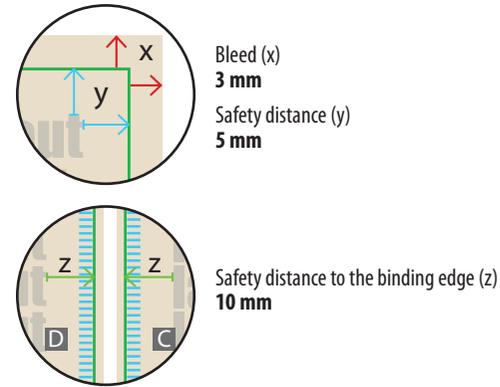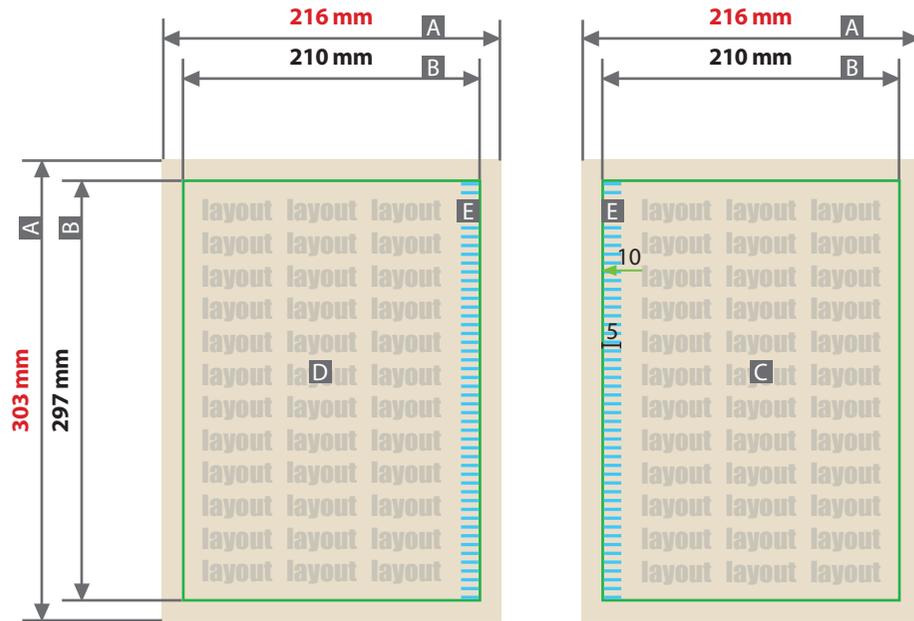
Data delivery
- PDF file, multiple pages
- CMYK colour space, ISO coated v2 300% output profile
- Image resolution: 300 ppi minimum

Please create backgrounds and images with edges up to the edge of the data format in order to avoid white borders.

Diagrams not to scale

Spine widths for books with hardcover (digital print)

Number of pages (incl. cover)	Type of material for the inner part				
	90 g matt	90 g offset	135 g matt/glossy	170 g matt/glossy	190 g photo paper
	Spine width				
28	--------	--------	--------	--------	8 mm
32	--------	--------	--------	--------	8 mm
36	--------	--------	--------	--------	8 mm
40	--------	--------	--------	--------	10 mm
44	--------	--------	--------	--------	10 mm
48	8 mm	8 mm	8 mm	10 mm	10 mm
52	8 mm	8 mm	8 mm	10 mm	10 mm
56	8 mm	8 mm	8 mm	10 mm	10 mm
60	8 mm	10 mm	10 mm	10 mm	12 mm
64	8 mm	10 mm	10 mm	10 mm	12 mm
68	8 mm	10 mm	10 mm	10 mm	12 mm
72	8 mm	10 mm	10 mm	10 mm	12 mm
76	8 mm	10 mm	10 mm	12 mm	12 mm
80	8 mm	10 mm	10 mm	12 mm	14 mm
84	8 mm	10 mm	10 mm	12 mm	14 mm
88	8 mm	10 mm	10 mm	12 mm	14 mm
92	8 mm	10 mm	10 mm	12 mm	14 mm
96	8 mm	12 mm	10 mm	12 mm	14 mm
100	8 mm	12 mm	12 mm	12 mm	14 mm
104	10 mm	12 mm	12 mm	14 mm	16 mm
108	10 mm	12 mm	12 mm	14 mm	16 mm
112	10 mm	12 mm	12 mm	14 mm	16 mm
116	10 mm	12 mm	12 mm	14 mm	16 mm
120	10 mm	12 mm	12 mm	14 mm	16 mm
124	10 mm	12 mm	12 mm	14 mm	18 mm
128	10 mm	12 mm	12 mm	14 mm	18 mm
132	10 mm	14 mm	12 mm	14 mm	18 mm
136	10 mm	14 mm	14 mm	16 mm	18 mm
140	10 mm	14 mm	14 mm	16 mm	18 mm
144	10 mm	14 mm	14 mm	16 mm	18 mm
148	10 mm	14 mm	14 mm	16 mm	20 mm
152	10 mm	14 mm	14 mm	16 mm	20 mm
156	10 mm	14 mm	14 mm	16 mm	--------
160	10 mm	14 mm	14 mm	16 mm	--------
164	10 mm	14 mm	14 mm	18 mm	--------
168	12 mm	16 mm	14 mm	18 mm	--------
172	12 mm	16 mm	16 mm	18 mm	--------
176	12 mm	16 mm	16 mm	18 mm	--------
180	12 mm	16 mm	16 mm	18 mm	--------
184	12 mm	16 mm	16 mm	18 mm	--------
188	12 mm	16 mm	16 mm	18 mm	--------
192	12 mm	16 mm	16 mm	20 mm	--------

Number of pages (incl. cover)	Type of material for the inner part			
	90 g matt	90 g offset	135 g matt/glossy	170 g matt/glossy
	Spine width			
196	12 mm	16 mm	16 mm	20 mm
200	12 mm	16 mm	16 mm	20 mm
204	12 mm	18 mm	16 mm	20 mm
208	12 mm	18 mm	18 mm	20 mm
212	12 mm	18 mm	18 mm	20 mm
216	12 mm	18 mm	18 mm	20 mm
220	12 mm	18 mm	18 mm	22 mm
224	12 mm	18 mm	18 mm	22 mm
228	12 mm	18 mm	18 mm	22 mm
232	14 mm	18 mm	18 mm	22 mm
236	14 mm	18 mm	18 mm	22 mm
240	14 mm	20 mm	18 mm	22 mm
244	14 mm	20 mm	20 mm	22 mm
248	14 mm	20 mm	20 mm	24 mm
252	14 mm	20 mm	20 mm	24 mm
256	14 mm	20 mm	20 mm	24 mm
260	14 mm	20 mm	20 mm	24 mm
264	14 mm	20 mm	20 mm	24 mm
268	14 mm	20 mm	20 mm	24 mm
272	14 mm	20 mm	20 mm	24 mm
276	14 mm	22 mm	20 mm	26 mm
280	14 mm	22 mm	22 mm	26 mm
284	14 mm	22 mm	22 mm	26 mm
288	14 mm	22 mm	22 mm	26 mm
292	16 mm	22 mm	22 mm	26 mm
296	16 mm	22 mm	22 mm	26 mm
300	16 mm	22 mm	22 mm	26 mm
304	16 mm	22 mm	22 mm	28 mm
308	16 mm	24 mm	22 mm	28 mm
312	16 mm	24 mm	22 mm	28 mm
316	16 mm	24 mm	24 mm	28 mm
320	16 mm	24 mm	24 mm	28 mm
324	16 mm	24 mm	24 mm	28 mm
328	16 mm	24 mm	24 mm	28 mm
332	16 mm	24 mm	24 mm	30 mm
336	16 mm	24 mm	24 mm	30 mm
340	16 mm	24 mm	24 mm	30 mm
344	16 mm	26 mm	24 mm	30 mm
348	16 mm	26 mm	24 mm	30 mm
352	16 mm	26 mm	26 mm	30