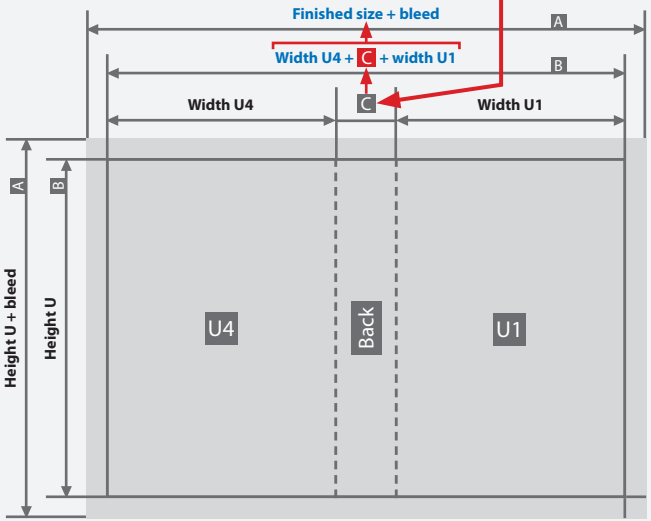
Information

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.

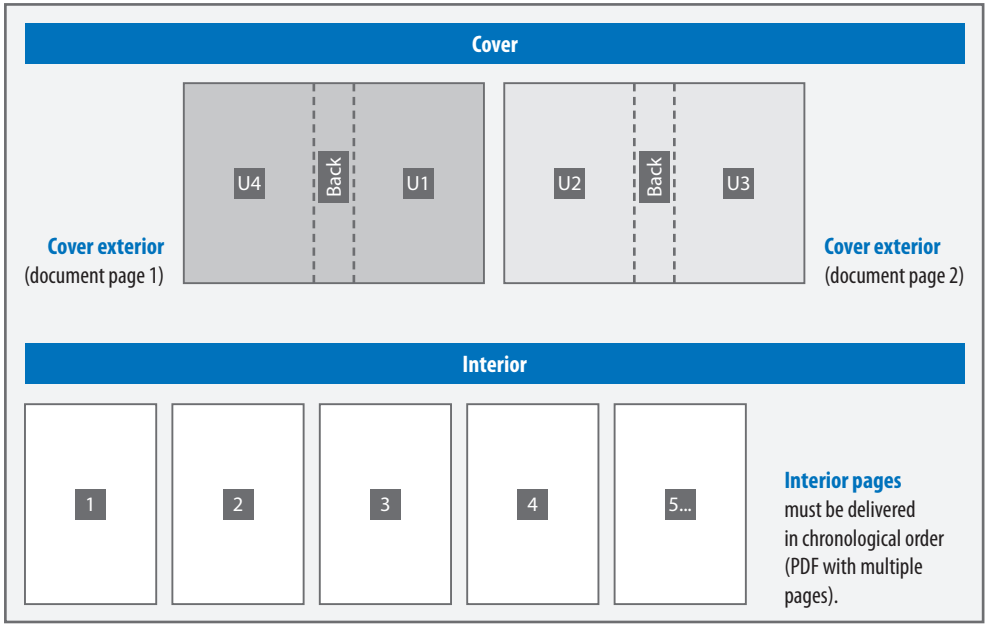
Calculation: Width file format A
305 mm + 6 mm = **311 mm**

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

The exemplary chart and layout use fictitious numerical values!

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).

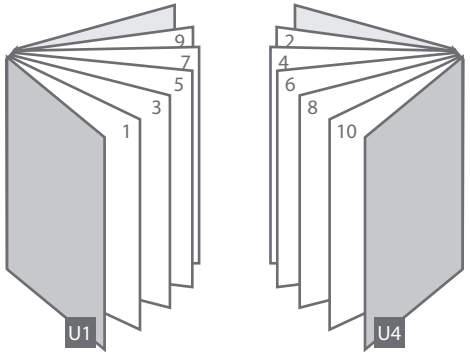
Print files



Please deliver two print files:
Cover: 2 document pages (if there are empty pages, these need to be included in the print file)
Interior: multiple pages

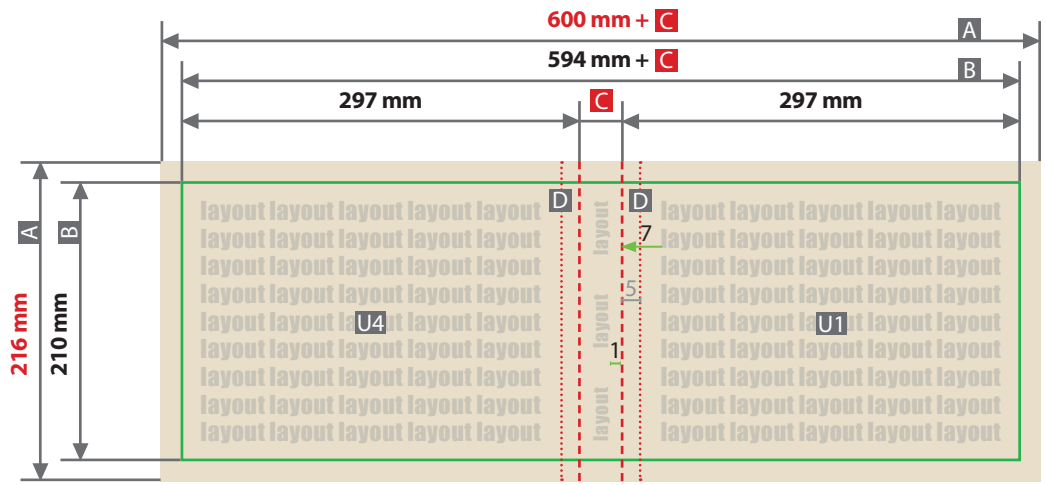
Finished product

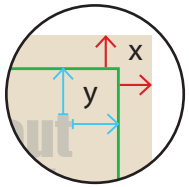
We create your finished product from the two print files (cover and interior) delivered by you.



Soft back perfect binding
A4, format landscape, left side binding

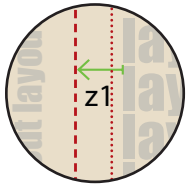
Document page 1: **Cover – exterior**



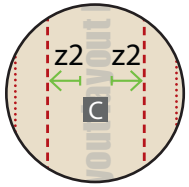


Bleed (x)
3 mm

Safety distance (y)
5 mm

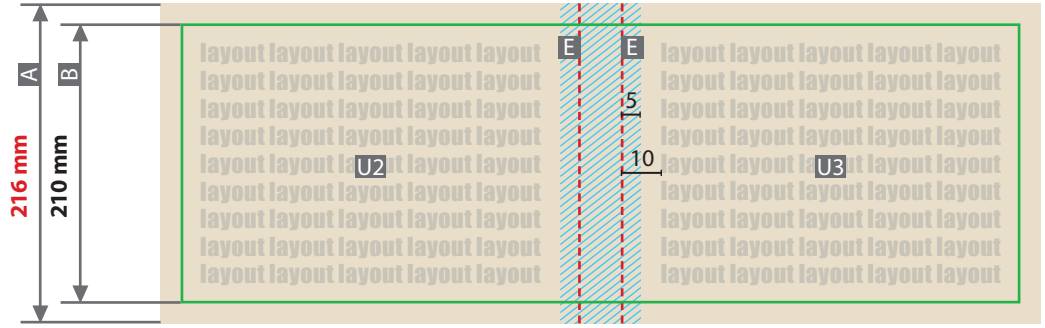


Safety distance spine (z1)
7 mm from back and cover



Safety distance spine (z2)
1 mm from back and cover

Document page 2: **Cover – interior**



A = File format

B = Final format

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

D = Fold line

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

U1 = Cover front

U4 = Cover back

U2 = Cover left interior

U3 = Cover right interior

Folded finished format
297 x 210 mm

Diagrams not to scale

Please deliver two print files

Cover: 2 document pages
If there are empty (white) pages, these need to be included in the print file.

Interior: multiple pages

Materials used

The cover surface is different to the interior surface.
This may affect the print of graphics / images across multiple pages.
We recommend not creating a layout across the binding at **U2 and the first interior page** and at **the last interior page and U3**.

Glued area (E)

The first and last page of the interior will be glued to the cover for maximum durability.
5 mm of the layout space is not visible.

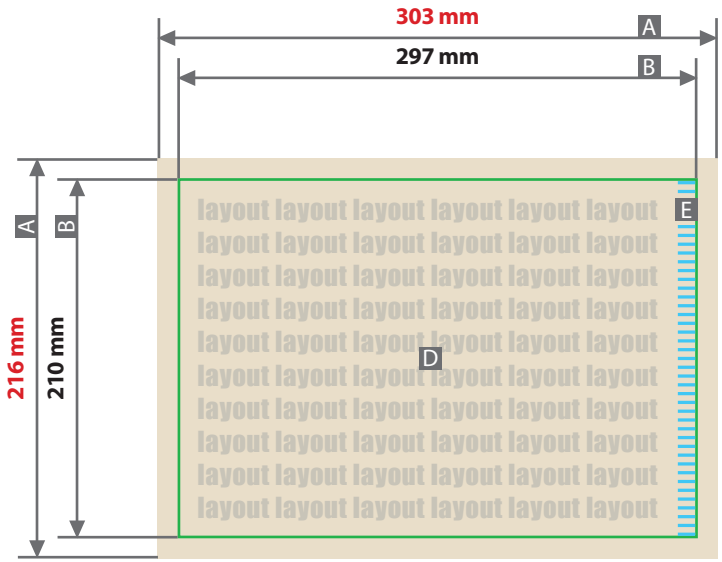
Data delivery

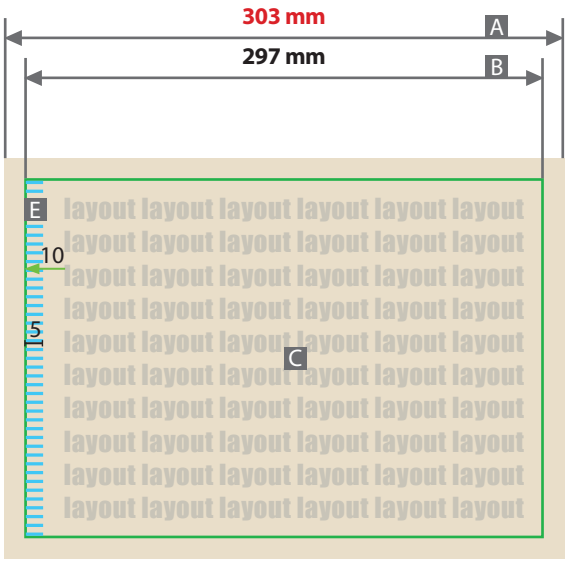
- PDF file, multiple pages
- CMYK colour space, ISO coated v2 300% output profile
- Image resolution: 300 ppi minimum

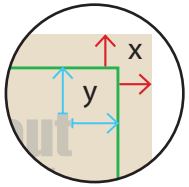
Please create backgrounds and images with edges up to the edge of the data format in order to avoid white borders.

Adhesive binding
A4, format landscape, left side binding

Inner part

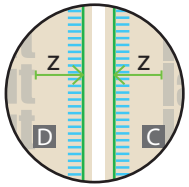






Bleed (x)
3 mm

Safety distance (y)
5 mm



Safety distance to the binding edge (z)
10 mm

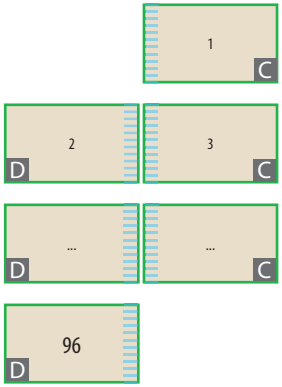
A = File format

B = Final format

C = Right side

D = Left side

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



Diagrams not to scale

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.

Spine thicknesses for softcover books (digital print)

Number of pages (incl. cover)	Inner part material							
	65gsm silk paper	90gsm silk paper	100gsm offset paper	115gsm silk paper	135gsm silk paper	135gsm gloss paper	170gsm silk paper	190gsm photo paper
	Spine thickness							
32	-----	-----	-----	-----	-----	-----	3.5 mm	4.0 mm
36	-----	-----	-----	-----	-----	-----	4.0 mm	4.5 mm
40	-----	-----	-----	-----	3.5 mm	-----	4.5 mm	4.5 mm
44	-----	2.5 mm	3.0 mm	-----	3.5 mm	-----	4.5 mm	5.0 mm
48	-----	2.5 mm	3.5 mm	3.5 mm	3.5 mm	4.0 mm	5.0 mm	5.5 mm
52	2.5 mm	3.0 mm	3.5 mm	3.5 mm	4.0 mm	4.0 mm	5.0 mm	6.0 mm
56	2.5 mm	3.0 mm	3.5 mm	4.0 mm	4.5 mm	4.0 mm	5.5 mm	6.0 mm
60	2.5 mm	3.5 mm	4.0 mm	4.0 mm	4.5 mm	4.5 mm	5.5 mm	6.5 mm
64	2.5 mm	3.5 mm	4.0 mm	4.5 mm	5.0 mm	4.5 mm	6.0 mm	7.0 mm
68	3.0 mm	3.5 mm	4.5 mm	4.5 mm	5.0 mm	5.0 mm	6.5 mm	7.5 mm
72	3.0 mm	3.5 mm	4.5 mm	5.0 mm	5.5 mm	5.0 mm	6.5 mm	7.5 mm
76	3.0 mm	4.0 mm	5.0 mm	5.0 mm	5.5 mm	5.0 mm	7.0 mm	8.0 mm
80	3.5 mm	4.0 mm	5.0 mm	5.5 mm	6.0 mm	5.5 mm	7.0 mm	8.5 mm
84	3.5 mm	4.0 mm	5.5 mm	5.5 mm	6.0 mm	5.5 mm	7.5 mm	9.0 mm
88	3.5 mm	4.5 mm	5.5 mm	6.0 mm	6.5 mm	6.0 mm	7.5 mm	9.5 mm
92	3.5 mm	4.5 mm	6.0 mm	6.0 mm	7.0 mm	6.0 mm	8.0 mm	9.5 mm
96	4.0 mm	5.0 mm	6.0 mm	6.5 mm	7.0 mm	6.0 mm	8.5 mm	10.0 mm
100	4.0 mm	5.0 mm	6.5 mm	6.5 mm	7.5 mm	6.5 mm	8.5 mm	10.5 mm
104	4.0 mm	5.0 mm	6.5 mm	7.0 mm	7.5 mm	6.5 mm	9.0 mm	11.0 mm
108	4.0 mm	5.5 mm	7.0 mm	7.0 mm	8.0 mm	6.5 mm	9.0 mm	11.0 mm
112	4.5 mm	5.5 mm	7.0 mm	7.5 mm	8.0 mm	7.0 mm	9.5 mm	11.5 mm
116	4.5 mm	5.5 mm	7.5 mm	7.5 mm	8.5 mm	7.0 mm	10.0 mm	12.0 mm
120	4.5 mm	6.0 mm	7.5 mm	7.5 mm	8.5 mm	7.5 mm	10.0 mm	12.5 mm
124	5.0 mm	6.0 mm	8.0 mm	8.0 mm	9.0 mm	7.5 mm	10.5 mm	12.5 mm
128	5.0 mm	6.0 mm	8.0 mm	8.0 mm	9.5 mm	7.5 mm	10.5 mm	13.0 mm
132	5.0 mm	6.5 mm	8.5 mm	8.5 mm	9.5 mm	8.0 mm	11.0 mm	13.5 mm
136	5.0 mm	6.5 mm	8.5 mm	8.5 mm	10.0 mm	8.0 mm	11.0 mm	14.0 mm
140	5.5 mm	6.5 mm	9.0 mm	9.0 mm	10.0 mm	8.5 mm	11.5 mm	14.5 mm
144	5.5 mm	7.0 mm	9.0 mm	9.0 mm	10.5 mm	8.5 mm	12.0 mm	14.5 mm
148	5.5 mm	7.0 mm	9.0 mm	9.5 mm	10.5 mm	8.5 mm	12.0 mm	15.0 mm
152	6.0 mm	7.5 mm	9.5 mm	9.5 mm	11.0 mm	9.0 mm	12.5 mm	15.5 mm
156	6.0 mm	7.5 mm	9.5 mm	10.0 mm	11.0 mm	9.0 mm	12.5 mm	16.0 mm
160	6.0 mm	7.5 mm	10.0 mm	10.0 mm	11.5 mm	9.5 mm	13.0 mm	16.5 mm
164	6.0 mm	8.0 mm	10.0 mm	10.5 mm	12.0 mm			
168	6.5 mm	8.0 mm	10.5 mm	10.5 mm	12.0 mm			
172	6.5 mm	8.0 mm	10.5 mm	11.0 mm	12.5 mm			
176	6.5 mm	8.5 mm	11.0 mm	11.0 mm	12.5 mm			
180	6.5 mm	8.5 mm	11.0 mm	11.5 mm	13.0 mm			
184	7.0 mm	8.5 mm	11.5 mm	11.5 mm	13.0 mm			
188	7.0 mm	9.0 mm	11.5 mm	11.5 mm	13.5 mm			
192	7.0 mm	9.0 mm	12.0 mm	12.0 mm	14.0 mm			
196	7.5 mm	9.0 mm	12.0 mm	12.0 mm	14.0 mm			
200	7.5 mm	9.5 mm	12.5 mm	12.5 mm	14.5 mm			
204	7.5 mm	9.5 mm	12.5 mm	12.5 mm	14.5 mm			
208	7.5 mm	10.0 mm	13.0 mm	13.0 mm	15.0 mm			
212	8.0 mm	10.0 mm	13.0 mm	13.0 mm	15.0 mm			
216	8.0 mm	10.0 mm	13.5 mm	13.5 mm	15.5 mm			
220	8.0 mm	10.5 mm	13.5 mm	13.5 mm	15.5 mm			
224	8.0 mm	10.5 mm	14.0 mm	14.0 mm	16.0 mm			
228	8.5 mm	10.5 mm	14.0 mm	14.0 mm	16.5 mm			
232	8.5 mm	11.0 mm	14.5 mm	14.5 mm	16.5 mm			
236	8.5 mm	11.0 mm	14.5 mm	14.5 mm	17.0 mm			
240	9.0 mm	11.0 mm	14.5 mm	14.5 mm	17.0 mm			

Only valid for softcover photo books!

Spine thicknesses for softcover books (digital print)

Page 2

Number of pages (incl. cover)	Inner part material				
	65gsm silk paper	90gsm silk paper	100gsm offset paper	115gsm silk paper	135gsm silk paper
	Spine thickness				
244	9.0 mm	11.5 mm	15.0 mm	15.0 mm	17.5 mm
248	9.0 mm	11.5 mm	15.0 mm	15.5 mm	17.5 mm
252	9.0 mm	12.0 mm	15.5 mm	15.5 mm	18.0 mm
256	9.5 mm	12.0 mm	15.5 mm	15.5 mm	18.0 mm
260	9.5 mm	12.0 mm	16.0 mm	16.0 mm	18.5 mm
264	9.5 mm	12.5 mm	16.0 mm	16.0 mm	19.0 mm
268	9.5 mm	12.5 mm	16.5 mm	16.5 mm	19.0 mm
272	10.0 mm	12.5 mm	16.5 mm	16.5 mm	19.5 mm
276	10.0 mm	13.0 mm	17.0 mm	17.0 mm	19.5 mm
280	10.0 mm	13.0 mm	17.0 mm	17.0 mm	20.0 mm
284	10.5 mm	13.0 mm	17.5 mm	17.5 mm	20.0 mm
288	10.5 mm	13.5 mm	17.5 mm	17.5 mm	20.5 mm
292	10.5 mm	13.5 mm	18.0 mm	18.0 mm	21.0 mm
296	10.5 mm	13.5 mm	18.0 mm	18.0 mm	21.0 mm
300	11.0 mm	14.0 mm	18.5 mm	18.5 mm	21.5 mm
304	11.0 mm	14.0 mm	18.5 mm	18.5 mm	21.5 mm
308	11.0 mm	14.5 mm	19.0 mm	18.5 mm	22.0 mm
312	11.0 mm	14.5 mm	19.0 mm	19.0 mm	22.0 mm
316	11.5 mm	14.5 mm	19.5 mm	19.0 mm	22.5 mm
320	11.5 mm	15.0 mm	19.5 mm	19.5 mm	22.5 mm
324	11.5 mm	15.0 mm	20.0 mm	-----	23.0 mm