Information

Determining the file format and finished size
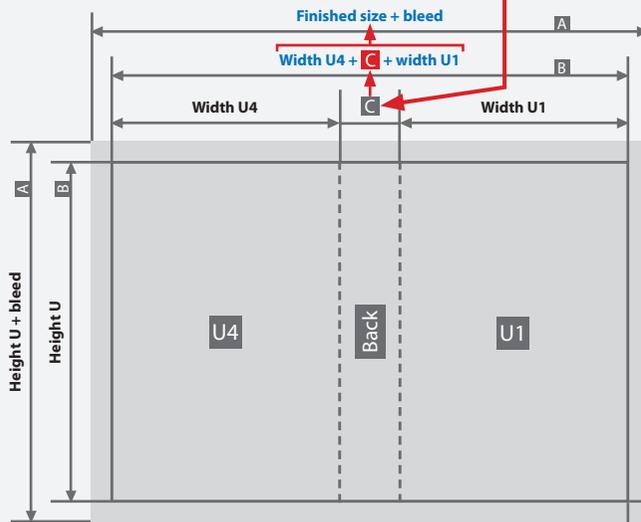
Number of pages (incl. cover)	Material interior		
	Paper weight (e.g. 90 gsm silk)	Paper weight (e.g. 135 gsm glossy)	Paper weight (e.g. 170 gsm silk)
	Spine thickness		
30	-	-	3.0 mm
34	-	-	3.0 mm
38	-	3.0 mm	3.0 mm
42	-	3.0 mm	3.5 mm
46	3.0 mm	3.5 mm	3.5 mm
50	3.0 mm	3.5 mm	3.5 mm
54	3.5 mm	4.5 mm	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.

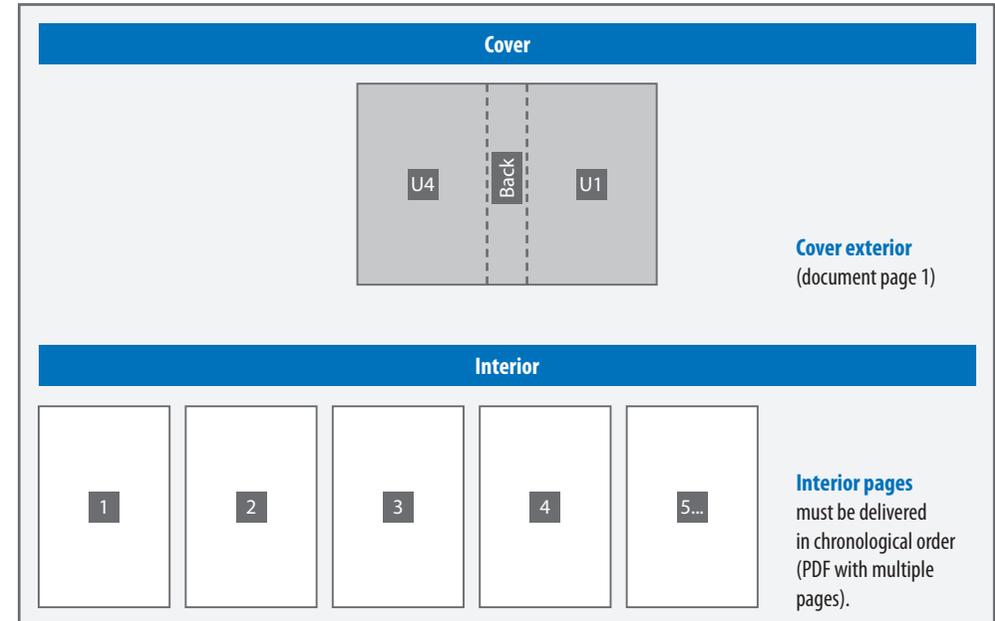**Calculation: Width file format** A

305 mm + 6 mm = **311 mm**

Calculation: Width finished size B

150 mm + **5 mm** + 150 mm = **305 mm**

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

The exemplary chart and layout use fictitious numerical values!

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.

9 | 7 | 5 | 3 | 1 | U1

2 | 4 | 6 | 8 | 10 | U4

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).
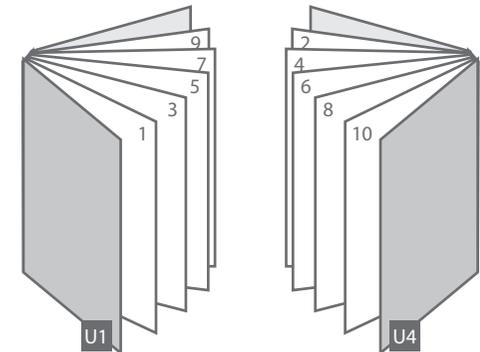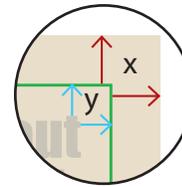
Hard back perfect binding
A4, format portrait, left side binding

Document page 1: **Cover – exterior**

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

336 mm   **302 mm**
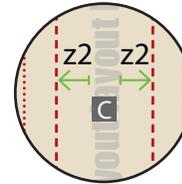A   B

U4   D   D   U1

8
13
2
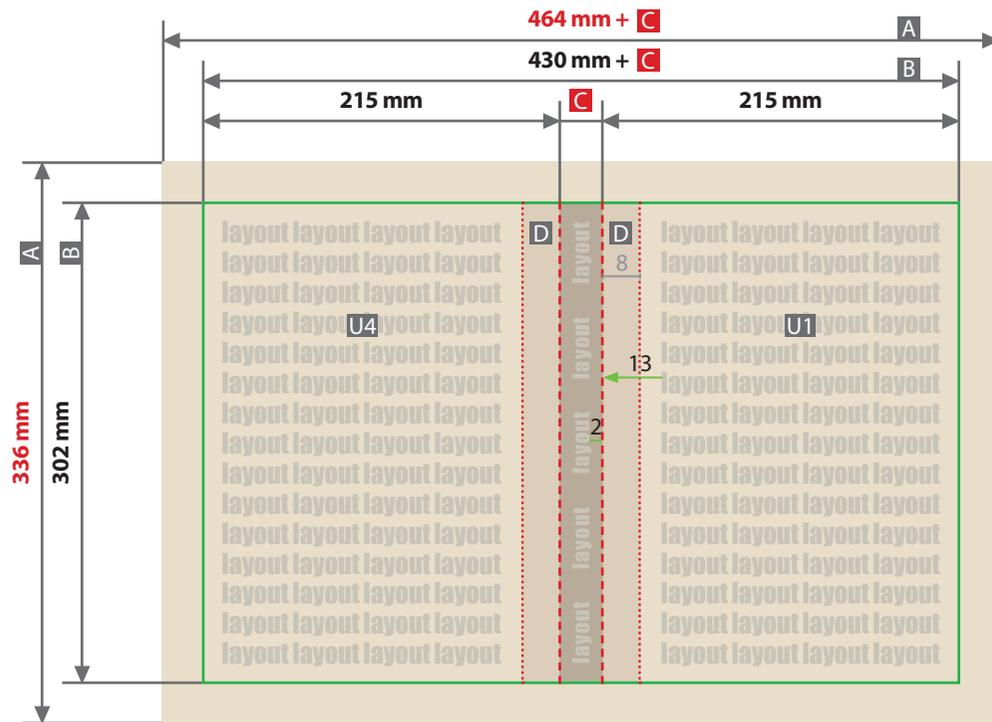
Folded final format
215 x 302 mm

Bleed (x)
17 mm

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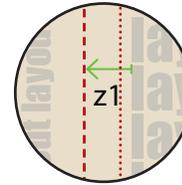
Safety distance spine (z1)
13 mm from back to title

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

Please deliver two print files

Cover: single side
U4 + C + U1 = **one** document page

Inner part: multiple pages

BEWARE
The end pages are part of the cover and cannot be printed (unprinted, white).
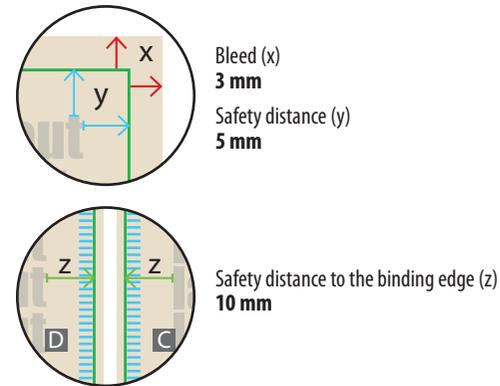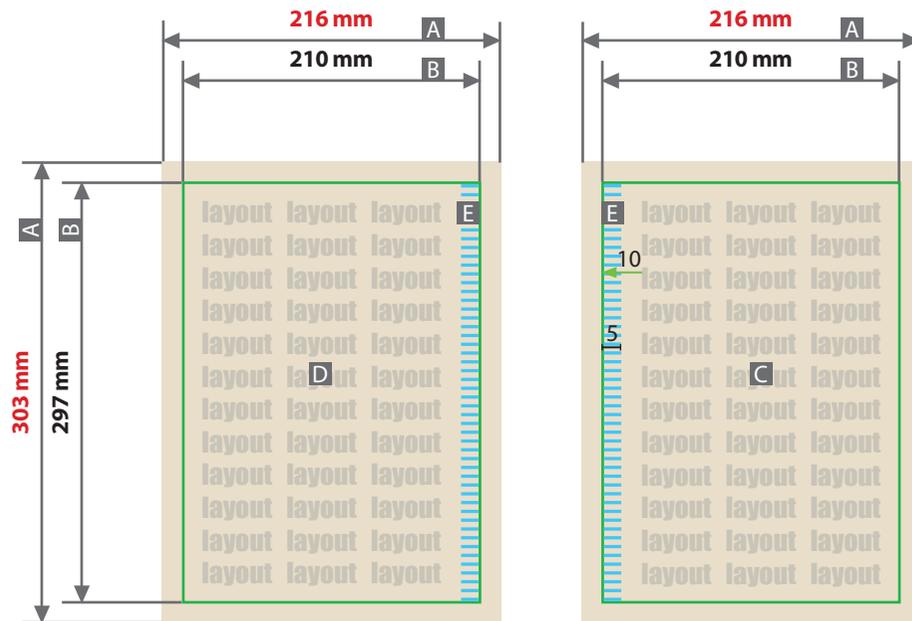Do not create end pages in your print file.

Data delivery
- PDF-file, single side
- 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

Adhesive binding
A4, format portrait, left side binding

Inner part

216 mm

A

210 mm

B

303 mm

297 mm

layout layout layout
layout layout layout E
layout layout layout
layout layout layout
layout layout layout
layout layout layout
layout layout layout D
layout layout layout
layout layout layout
layout layout layout
layout layout layout
layout layout layout

A
B

216 mm

A

210 mm

B

E layout layout layout
layout layout layout
10 layout layout layout
layout layout layout
layout layout layout
5 layout layout layout
layout layout C layout
layout layout layout
layout layout layout
layout layout layout
layout layout layout
layout layout layout

Bleed (x)
3 mm

x

y

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

Diagrams not to scale

Spine width, adhesive binding, hardcover, offset print

Number of pages (incl. cover)	Material off inner part			
	80g natural	90g offset	135g matt	135g glossy
	Spine width			
60	_____	_____	9 mm	8 mm
68	9 mm	8 mm	9 mm	9 mm
76	9 mm	9 mm	10 mm	9 mm
84	10 mm	9 mm	10 mm	10 mm
92	10 mm	10 mm	11 mm	10 mm
100	11 mm	10 mm	11 mm	11 mm
108	11 mm	11 mm	12 mm	11 mm
116	12 mm	11 mm	12 mm	12 mm
124	12 mm	11 mm	13 mm	12 mm
132	13 mm	12 mm	13 mm	12 mm
140	13 mm	12 mm	14 mm	13 mm
148	13 mm	13 mm	14 mm	13 mm
156	14 mm	13 mm	15 mm	14 mm
164	14 mm	13 mm	15 mm	14 mm
172	14 mm	14 mm	16 mm	15 mm
180	15 mm	14 mm	16 mm	15 mm
188	15 mm	15 mm	17 mm	16 mm
196	16 mm	15 mm	17 mm	16 mm
204	16 mm	16 mm	18 mm	16 mm
212	17 mm	16 mm	18 mm	17 mm
220	17 mm	17 mm	19 mm	17 mm
228	17 mm	17 mm	19 mm	18 mm
236	18 mm	18 mm	20 mm	18 mm
244	18 mm	18 mm	20 mm	19 mm
252	19 mm	18 mm	20 mm	19 mm
260	19 mm	19 mm	20 mm	19 mm
268	19 mm	19 mm	20 mm	19 mm
276	20 mm	20 mm	21 mm	20 mm
284	20 mm	20 mm	21 mm	20 mm
292	21 mm	21 mm	21 mm	20 mm
300	21 mm	21 mm	22 mm	21 mm
308	21 mm	22 mm	22 mm	21 mm
316	22 mm	22 mm	23 mm	21 mm
324	22 mm	22 mm	23 mm	21 mm
332	23 mm	23 mm	24 mm	22 mm
340	23 mm	23 mm	24 mm	22 mm
348	24 mm	24 mm	24 mm	23 mm
356	24 mm	24 mm	25 mm	23 mm
364	24 mm	25 mm	25 mm	24 mm
372	25 mm	25 mm	26 mm	24 mm
388	25 mm	26 mm	26 mm	24 mm