

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

Width U4 + C + width U1

Width U4

Width U1

Height U + bleed

Height U

U4

Back

U1

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

Cover

Cover exterior
(document page 1)

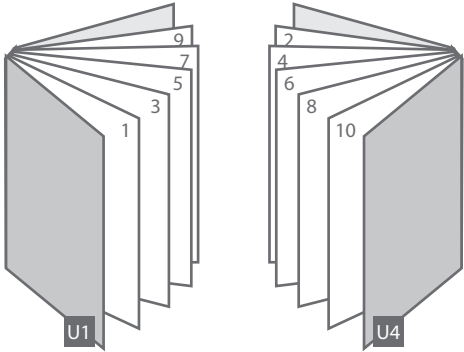
Cover exterior
(document page 2)

Interior

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

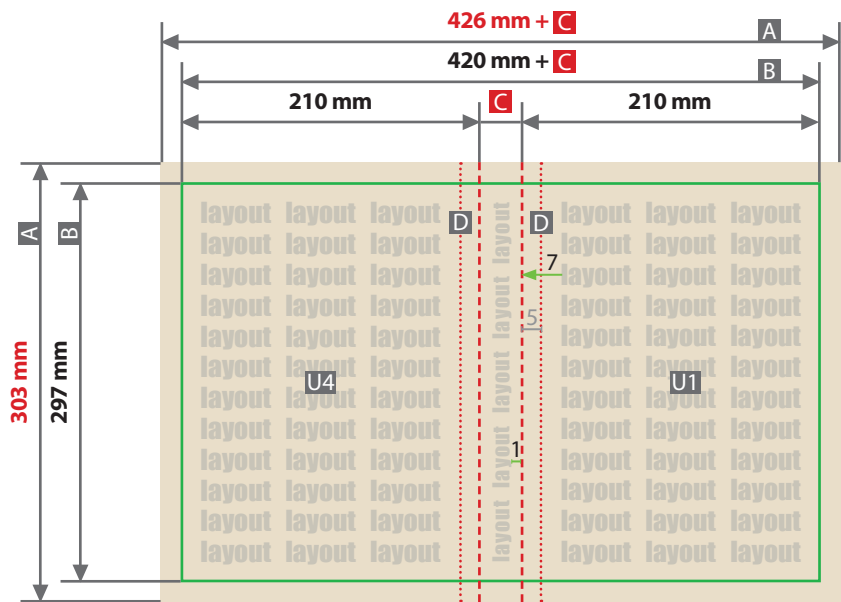
Please deliver two print files:
Cover: 2 document pages (if there are empty pages, these need to be included in the print file)
Interior: multiple pages

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

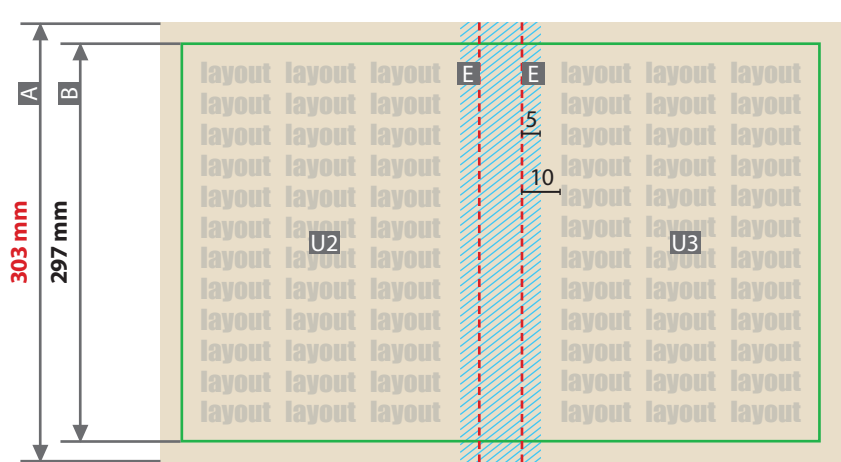
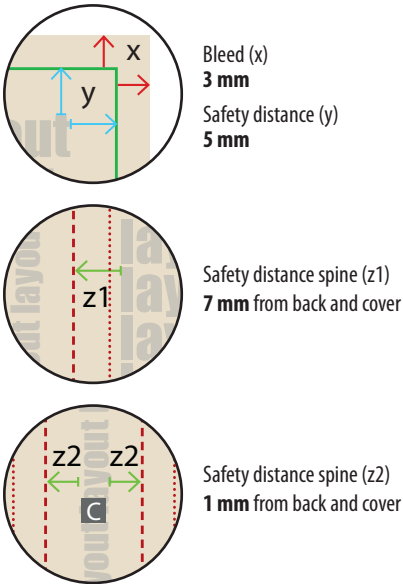


Soft back perfect binding
A4, format portrait, left side binding

Document page 1: Cover – exterior



Document page 2: Cover – interior



- 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

- 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
210 x 297 mm

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.

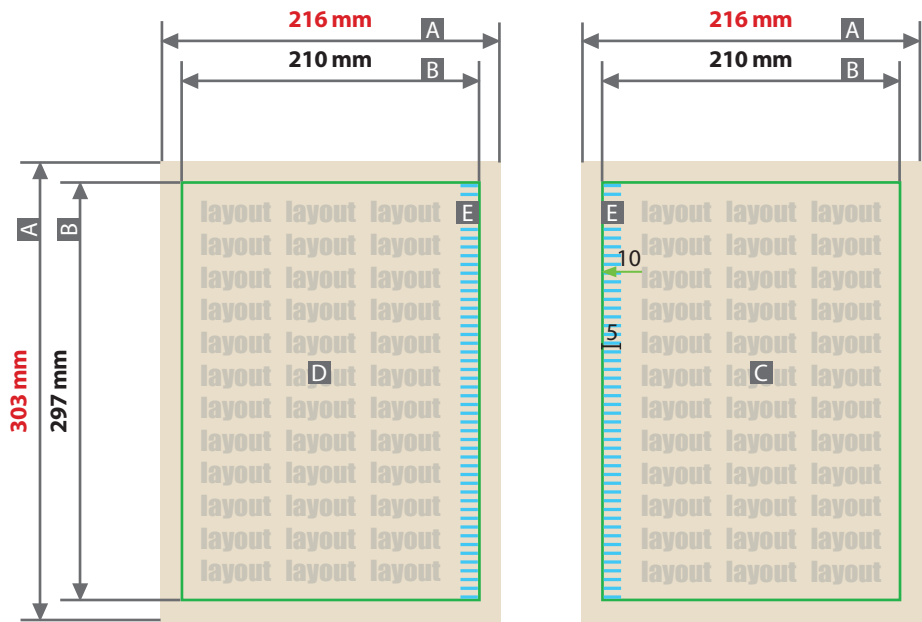
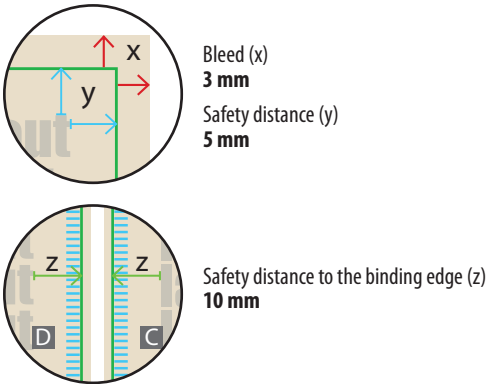
Data delivery

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

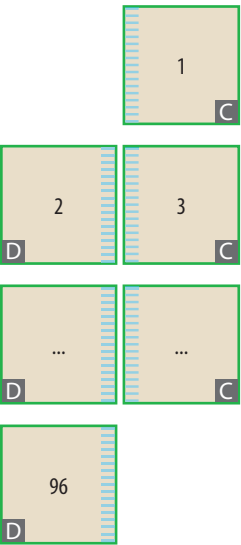
Please create backgrounds and images with edges up to the edge of the data format in order to avoid white borders.

Adhesive binding
A4, format portrait, left side binding

Inner part



- A = File format
- B = Final format
- C = Right side
- D = Left side
- E = Glued, non-visible area
Apply background only!



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 widths, softcover offset print

1

Number of pages (incl. cover)	Type of material for the inner part											
	80g natural	90g matt	90g glossy	90g offset	115g matt	115g glossy	120g offset	135g matt	135g glossy	150g recycled paper	170g matt	170g glossy
	Spine width											
32	-----	-----	-----	-----	-----	-----	-----	2.5 mm	2.5 mm	3.5 mm	3.5 mm	3.0 mm
36	2.0 mm	-----	-----	2.5 mm	-----	-----	3.0 mm	2.5 mm	2.5 mm	3.5 mm	3.5 mm	3.5 mm
40	-----	-----	-----	2.5 mm	-----	-----	3.5 mm	3.0 mm	3.0 mm	4.0 mm	4.0 mm	3.5 mm
44	3.0 mm	-----	-----	3.0 mm	3.0 mm	2.5 mm	3.5 mm	3.0 mm	3.0 mm	4.5 mm	4.0 mm	4.0 mm
48	-----	-----	-----	3.0 mm	3.5 mm	2.5 mm	4.0 mm	3.5 mm	3.5 mm	5.0 mm	4.5 mm	4.0 mm
52	3.0 mm	3.0 mm	2.0 mm	3.0 mm	3.5 mm	3.0 mm	4.0 mm	4.0 mm	3.5 mm	5.0 mm	5.0 mm	4.5 mm
60	4.0 mm	3.0 mm	2.0 mm	3.5 mm	4.0 mm	3.0 mm	4.5 mm	4.0 mm	4.0 mm	6.0 mm	5.5 mm	5.0 mm
64	-----	3.5 mm	2.5 mm	4.0 mm	4.0 mm	3.5 mm	5.0 mm	4.0 mm	4.0 mm	6.0 mm	5.5 mm	5.0 mm
68	4.0 mm	3.5 mm	2.5 mm	4.0 mm	4.0 mm	3.5 mm	5.5 mm	4.5 mm	4.5 mm	6.5 mm	6.0 mm	5.5 mm
76	4.0 mm	4.0 mm	3.0 mm	4.5 mm	4.5 mm	4.0 mm	6.0 mm	5.0 mm	5.0 mm	7.0 mm	6.5 mm	6.0 mm
84	5.0 mm	4.0 mm	3.0 mm	5.0 mm	5.0 mm	4.5 mm	6.5 mm	5.5 mm	5.0 mm	8.0 mm	7.0 mm	6.5 mm
88	-----	4.0 mm	3.0 mm	5.0 mm	5.0 mm	4.5 mm	6.5 mm	6.0 mm	5.0 mm	8.0 mm	7.5 mm	6.5 mm
92	5.0 mm	4.5 mm	3.0 mm	5.5 mm	5.0 mm	5.0 mm	7.0 mm	6.0 mm	5.5 mm	8.5 mm	7.5 mm	7.0 mm
100	6.0 mm	4.5 mm	3.5 mm	6.0 mm	5.5 mm	5.0 mm	7.5 mm	6.5 mm	6.0 mm	9.5 mm	8.0 mm	7.5 mm
108	6.0 mm	5.0 mm	4.0 mm	6.5 mm	6.0 mm	5.5 mm	8.0 mm	7.0 mm	6.5 mm	10.0 mm	9.0 mm	8.0 mm
112	-----	5.0 mm	4.0 mm	6.5 mm	6.0 mm	5.5 mm	8.5 mm	7.0 mm	7.0 mm	10.5 mm	9.0 mm	8.0 mm
116	6.0 mm	5.5 mm	4.0 mm	7.0 mm	6.5 mm	6.0 mm	9.0 mm	7.0 mm	7.0 mm	10.5 mm	9.5 mm	8.0 mm
124	7.0 mm	5.5 mm	4.5 mm	7.5 mm	6.5 mm	6.0 mm	9.5 mm	7.5 mm	7.0 mm	11.5 mm	10.0 mm	9.0 mm
132	7.0 mm	6.0 mm	4.5 mm	8.0 mm	7.0 mm	6.5 mm	10.0 mm	8.0 mm	7.5 mm	12.0 mm	10.5 mm	9.0 mm
136	-----	6.0 mm	5.0 mm	8.0 mm	7.0 mm	6.5 mm	10.0 mm	8.0 mm	8.0 mm	12.5 mm	11.0 mm	9.5 mm
140	8.0 mm	6.5 mm	5.0 mm	8.5 mm	7.5 mm	7.0 mm	10.5 mm	8.5 mm	8.0 mm	12.5 mm	11.0 mm	9.5 mm
148	8.0 mm	6.5 mm	5.0 mm	9.0 mm	8.0 mm	7.0 mm	11.0 mm	9.0 mm	8.5 mm	13.5 mm	11.5 mm	10.0 mm
156	8.0 mm	7.0 mm	5.5 mm	9.5 mm	8.0 mm	7.5 mm	11.5 mm	9.5 mm	9.0 mm	14.5 mm	12.0 mm	10.5 mm
160	-----	7.0 mm	5.5 mm	9.5 mm	8.5 mm	7.5 mm	12.0 mm	10.0 mm	9.0 mm	14.5 mm	12.5 mm	11.0 mm
164	9.0 mm	7.5 mm	5.5 mm	10.0 mm	8.5 mm	8.0 mm	12.5 mm	10.0 mm	9.0 mm	15.0 mm	13.0 mm	11.0 mm
172	9.0 mm	7.5 mm	5.5 mm	10.5 mm	9.0 mm	8.0 mm	13.0 mm	10.5 mm	9.5 mm	15.5 mm	13.5 mm	12.0 mm
180	10.0 mm	8.0 mm	6.0 mm	11.0 mm	9.0 mm	8.5 mm	13.5 mm	11.0 mm	10.0 mm	16.0 mm	14.0 mm	12.0 mm
184	-----	8.0 mm	6.0 mm	11.0 mm	9.5 mm	8.5 mm	14.0 mm	11.0 mm	10.0 mm	16.5 mm	14.0 mm	12.5 mm
188	10.0 mm	8.5 mm	6.5 mm	11.5 mm	9.5 mm	8.5 mm	14.0 mm	11.5 mm	10.5 mm	17.0 mm	14.5 mm	13.0 mm
196	10.0 mm	8.5 mm	6.5 mm	11.5 mm	10.0 mm	9.0 mm	14.5 mm	11.5 mm	11.0 mm	17.5 mm	15.0 mm	13.5 mm
204	11.0 mm	9.0 mm	7.0 mm	12.0 mm	10.0 mm	9.5 mm	15.0 mm	12.0 mm	11.0 mm	18.0 mm	15.5 mm	13.5 mm
208	-----	9.0 mm	7.0 mm	12.0 mm	10.5 mm	9.5 mm	15.5 mm	12.0 mm	11.0 mm	18.5 mm	16.0 mm	14.0 mm
212	11.0 mm	9.5 mm	7.0 mm	12.5 mm	10.5 mm	9.5 mm	16.0 mm	12.5 mm	11.5 mm	19.0 mm	16.0 mm	14.0 mm
220	12.0 mm	9.5 mm	7.5 mm	12.5 mm	11.0 mm	10.0 mm	16.5 mm	13.0 mm	12.0 mm	19.5 mm	17.0 mm	14.5 mm
228	12.0 mm	10.0 mm	7.5 mm	13.0 mm	11.5 mm	10.5 mm	17.0 mm	13.5 mm	12.5 mm	20.5 mm	17.5 mm	15.0 mm
232	-----	10.0 mm	8.0 mm	13.5 mm	11.5 mm	10.5 mm	17.0 mm	14.0 mm	13.0 mm	21.0 mm	17.5 mm	15.5 mm
236	12.0 mm	10.5 mm	8.0 mm	13.5 mm	11.5 mm	10.5 mm	17.5 mm	14.0 mm	13.0 mm	21.0 mm	18.0 mm	15.5 mm
244	13.0 mm	10.5 mm	8.5 mm	14.0 mm	12.0 mm	11.0 mm	18.0 mm	14.5 mm	13.0 mm	22.0 mm	18.5 mm	16.0 mm

Spine widths, softcover offset print

2

Number of pages (incl. cover)	Type of material for the inner part											
	80g natural	90g matt	90g glossy	90g offset	115g matt	115g glossy	120g offset	135g matt	135g glossy	150g recycled paper	170g matt	170g glossy
	Spine width											
252	13.0 mm	11.0 mm	8.5 mm	14.5 mm	12.5 mm	11.5 mm	18.5 mm	15.0 mm	13.5 mm	22.5 mm	19.0 mm	17.0 mm
256	-----	11.0 mm	9.0 mm	14.5 mm	12.5 mm	11.5 mm	19.0 mm	15.0 mm	14.0 mm	23.0 mm	19.5 mm	17.0 mm
260	14.0 mm	11.5 mm	9.0 mm	15.0 mm	13.0 mm	11.5 mm	19.5 mm	15.5 mm	14.0 mm	23.0 mm	19.5 mm	17.5 mm
268	14.0 mm	11.5 mm	9.0 mm	15.5 mm	13.0 mm	12.0 mm	20.0 mm	15.5 mm	14.5 mm	24.0 mm	20.0 mm	18.0 mm
276	14.0 mm	12.0 mm	9.5 mm	16.0 mm	13.5 mm	12.5 mm	20.5 mm	16.0 mm	15.0 mm	24.5 mm	21.0 mm	18.5 mm
280	-----	12.0 mm	9.5 mm	16.0 mm	14.0 mm	12.5 mm	20.5 mm	16.0 mm	15.0 mm	25.0 mm	21.0 mm	18.5 mm
284	15.0 mm	12.5 mm	9.5 mm	16.5 mm	14.0 mm	12.5 mm	21.0 mm	16.5 mm	15.0 mm	25.0 mm	21.5 mm	19.0 mm
292	15.0 mm	12.5 mm	9.5 mm	17.0 mm	14.5 mm	13.0 mm	21.5 mm	17.0 mm	15.5 mm	26.0 mm	22.0 mm	19.5 mm
300	16.0 mm	13.0 mm	10.0 mm	17.0 mm	14.5 mm	13.5 mm	22.0 mm	17.5 mm	16.5 mm	26.5 mm	22.5 mm	20.0 mm
308	16.0 mm	13.0 mm	10.0 mm	17.5 mm	15.0 mm	13.5 mm	22.5 mm	18.0 mm	16.5 mm	27.5 mm	23.0 mm	20.5 mm
316	16.0 mm	13.5 mm	10.5 mm	17.5 mm	15.5 mm	14.0 mm	23.5 mm	18.5 mm	17.0 mm	28.0 mm	23.5 mm	21.0 mm
324	17.0 mm	14.0 mm	11.0 mm	18.0 mm	15.5 mm	14.5 mm	24.0 mm	19.0 mm	17.0 mm	28.5 mm	24.0 mm	21.5 mm
332	17.0 mm	14.5 mm	11.0 mm	18.5 mm	16.0 mm	14.5 mm	24.5 mm	19.5 mm	17.5 mm	-----	25.0 mm	22.0 mm
340	18.0 mm	14.5 mm	11.0 mm	19.0 mm	16.5 mm	15.0 mm	25.0 mm	19.5 mm	18.0 mm	-----	25.5 mm	22.5 mm
348	18.0 mm	15.0 mm	11.5 mm	19.5 mm	17.0 mm	15.5 mm	25.5 mm	20.0 mm	18.5 mm	-----	26.0 mm	23.0 mm
356	18.0 mm	15.0 mm	12.0 mm	20.0 mm	17.0 mm	15.5 mm	26.0 mm	20.5 mm	19.0 mm	-----	26.5 mm	23.5 mm
364	19.0 mm	15.5 mm	12.0 mm	20.5 mm	17.5 mm	16.0 mm	26.5 mm	21.0 mm	19.5 mm	-----	27.0 mm	23.5 mm
372	19.0 mm	16.0 mm	12.5 mm	21.0 mm	18.0 mm	16.5 mm	27.5 mm	21.5 mm	19.5 mm	-----	27.5 mm	24.0 mm
388	20.0 mm	16.0 mm	13.5 mm	22.0 mm	18.5 mm	17.0 mm	28.5 mm	22.0 mm	20.0 mm	-----	29.0 mm	25.5 mm