

Marvel Bookbinding

Hard Cover Cheat Sheet

- **Text Requirements**
 - Section Sewn
 - Minimum 7mm lap that is consistent on all sections.
 - Varnish free area 3mm either side of spine fold on the outer of each section
 - Print and varnish free area 5mm from the spine on the first and last page for endpaper adhesion.
 - Recommended 5mm head and foot trims
 - Head and foot trims must be consistent on every section.
 - PUR (Sections)
 - Lap not critical if not sewn.
 - Varnish free area 3mm either side of spine fold on the outer of each section
 - Print and varnish free area 5mm from the spine on the first and last page for endpaper adhesion.
 - Recommended 5mm head and foot trims
 - Head and foot trims must be consistent on every section.
 - PUR (Digital Book Blocks)
 - Allow at least 5mm all the way around
 - Print and varnish free area 5mm from the spine on the first and last page for endpaper adhesion.
 - Coloured divider sheet in between each collated set (book block)
 - Grain Direction
 - Must run parallel to the spine.
- **Overs Required**
 - PUR (Digital Book Blocks)
 - Minimum 8 books + 4% of job quantity
 - Section Sewn
 - Minimum 30 of each section + 4% of job quantity
 - Covers
 - Minimum 30 overs + 4% of job quantity
- **Endpapers**
 - Head and foot trims must match text sections
 - Stock
 - Must be uncoated paper
 - Between 140gsm and 200gsm is ideal
 - Grain Direction
 - Must run parallel to the spine.
 - Print/Varnish Free area
 - 5mm from spine where it adheres to the first and last pages.
 - Watermark on pasted down area
 - If printing both sides, it can be beneficial to have 'Front' and 'Back' printed as a low opacity watermark on the page that gets pasted down to the inside cover.
 - This helps determine which is front and back, and which way faces up for the bindery staff.

- **Covers**
 - Stock for PLC cover (printed and laminated)
 - Must be on 150gsm to 170gsm stock
 - Board Options
 - 1800um
 - 2400um
 - 3000um
 - Flexi Binding (No Board)
 - Lamination
 - Printed covers must be laminated (outer only) unless printed on a stock approved by Marvel Bookbinding.
 - Marvel recommends an anti-scuff laminate for best results.
 - Strong adhesion of the laminate is critical for hard covers.
 - Please consult with your laminator to ensure no areas delaminate during the case binding process.
 - Bleed
 - 20mm bleed is required for the 'turn in' areas of the cover.
 - Some of this area may be visible to the end user.
 - Spine Dimension
 - The spine dimension can depend on many different elements of the text.
 - Please consult with Marvel Bookbinding to determine the correct measurement.
 - Impositions upon request
 - Marvel is happy to supply a cover imposition based on the text stock and page quantity of the job
 - On rare occasions, a mock up must be created to determine cover dimensions. Marvel are happy to assist with this upon request.
 - Cover Materials
 - Feel free to discuss with our staff the many different options available with cover materials.
 - Linens, embossed papers, faux leathers, bonded leathers and more are available.
 - Digital swatches available upon request
- **Foiling & Debossing**
 - Marvel offers in-house foiling and debossing with a range of foil options
 - Send artwork as a high resolution PDF with trim marks to determine positioning.
- **Head and Tail Bands + Ribbon Marker**
 - Head and Tail bands are the small decorative coloured cord that sit against the spine at the head and tail of the book. They add a design element to the book.
 - Text Thickness is important to consider when choosing the width of the ribbon marker. Marvel recommends the ribbon being at least 4mm thinner than the text thickness.
 - Ribbons are available in 3mm, 6mm, 9mm, 16mm, and 25mm widths.
 - Printed Ribbon markers is available upon request.
 - Digital swatches available upon request for ribbon markers and head and tail bands.

- **Dust Jackets**
 - GSM range
 - Between 120gsm to 170gsm is ideal.
 - Must be laminated.
 - Grain must run parallel to the spine
 - Imposition available upon request.

- **Slip Case**
 - Marvel can organise for a slip case or other custom boxes to be made for your books.
 - This includes boxes with ribbon pulls, magnetic closures etc.