

## Calculating Cover & Jacket Spine Width Allowances

### Calculating Spine Bulk:

In order to calculate the paper spine bulk three pieces of information are required.

- The number of pages (Extent)
- The weight of the paper stock in gsm (Grammes per square metre)
- The volume of the paper (Thickness)

The calculation is Extent x Weight (gsm) x Volume ÷ 20,000 rounded up to the nearest millimetre.

Example:

(Extent) 320pp x (Paper Weight) 80gsm x (Volume) 17.5 ÷ 20,000 = 22.4 rounded up 23mm

Additional allowances are then added to this figure subject to the type of binding and the result of the spine bulk calculation. Typically this extra allowance is to allow for further bulking in the binding process and thickness of the boards used in the manufacture of case bound books.

### Sewn Limp (Litho):

Add additional 1mm to paper bulk calculation - **Maximum spine size 60mm**

### Notch Limp Bound (Litho/Digital):

No further allowances required - **Minimum spine size 3mm - Maximum spine size 60mm**

### Notch Case Bound (Litho):

Paper bulk 4mm-20mm + 3mm

Paper bulk 21mm-40mm + 4mm

Paper bulk 40mm-54mm + 5mm **Maximum cased spine size 60mm**

### Sewn Case Bound (Litho):

Paper bulk 4mm-20mm + 4mm

Paper bulk 21mm-40mm + 5mm

Paper bulk 40mm-54mm + 6mm **Maximum cased spine size 60mm**

### Case Bound (Digital Printing):

Paper bulk 4mm-40mm + 3mm

Paper bulk 40mm-54mm + 4mm **Maximum cased spine size 60mm**

### Flat Back Case Bound :

Spine bulk as Notch Case Bound with a 10mm gutter allowance up to 50mm spine if > 50mm check with CSR (see layout on pp4) **Maximum cased spine size 60mm**



Trimmed book width

Spine width

Trimmed book width

Trimmed book depth

**TJ INTERNATIONAL**  
QUALITY BOOK MANUFACTURERS

*Guidelines for Limp Covers*

*Guidelines  
for  
Limp  
Covers*

(To calculate correct spine width allowance please refer to the first page of this document for instructions)

**Add trim marks**

**3mm bleed  
ALL around**

Flap width minimum size = 50mm

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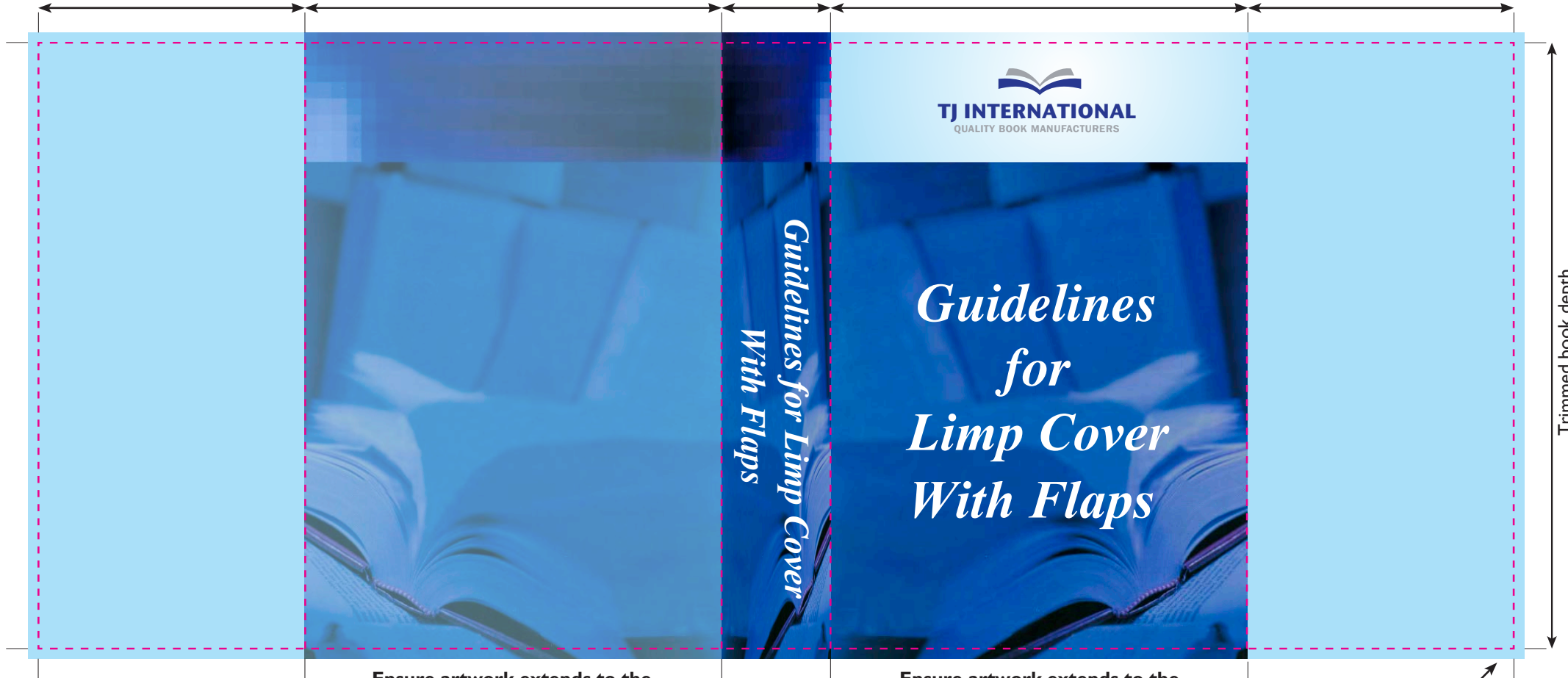
Flap width maximum = trimmed book width less 10mm

Flap width maximum = trimmed book width less 10mm

Trimmed book width +2.5mm for flap fold)

Spine width

Trimmed book width +2.5mm for flap fold)



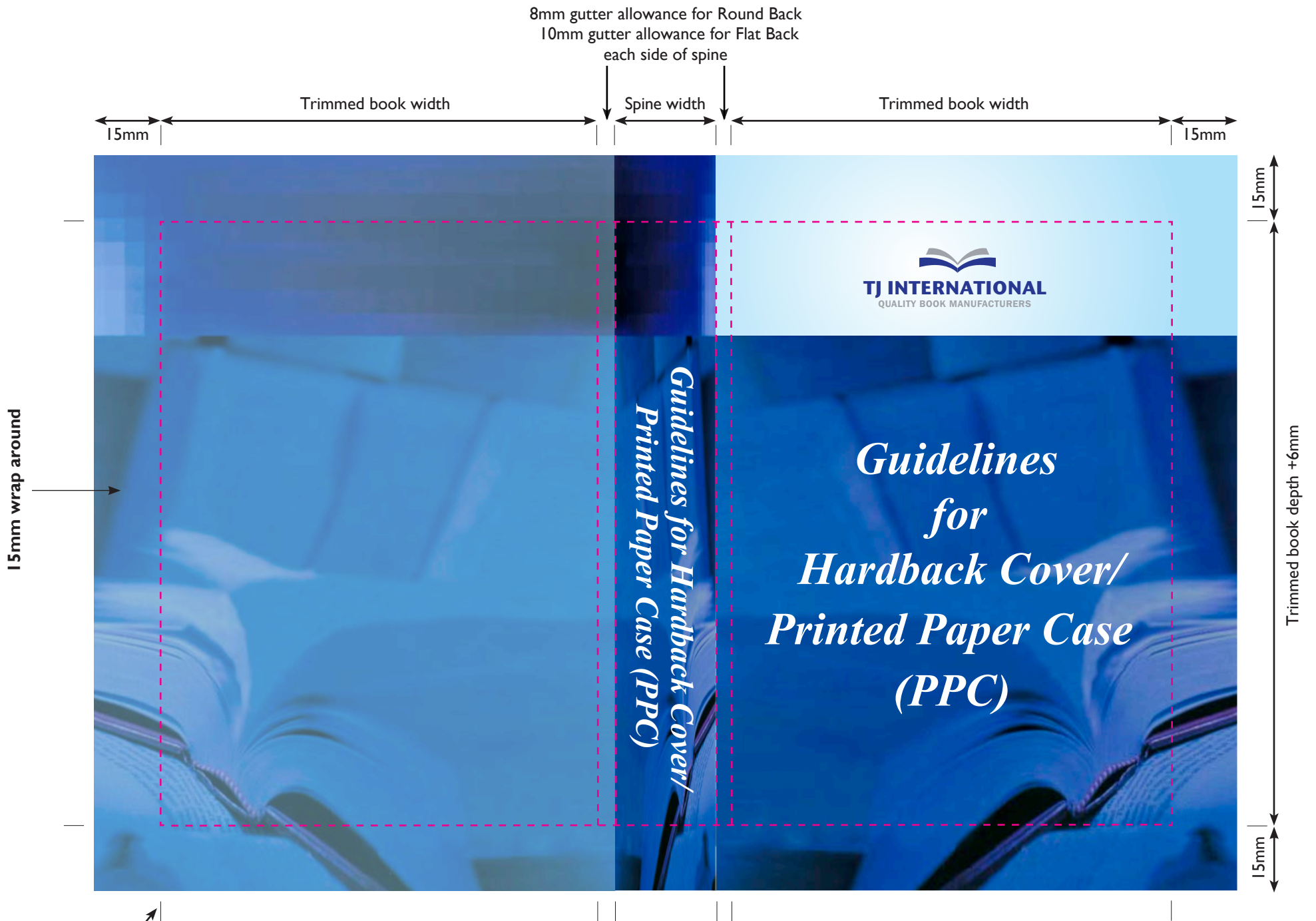
Ensure artwork extends to the edge of the flap fold allowance

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Add trim marks

(To calculate correct spine width allowance please refer to the first page of this document for instructions)

3mm bleed ALL around



Add trim marks

(To calculate correct spine width allowance please refer to the first page of this document for instructions)

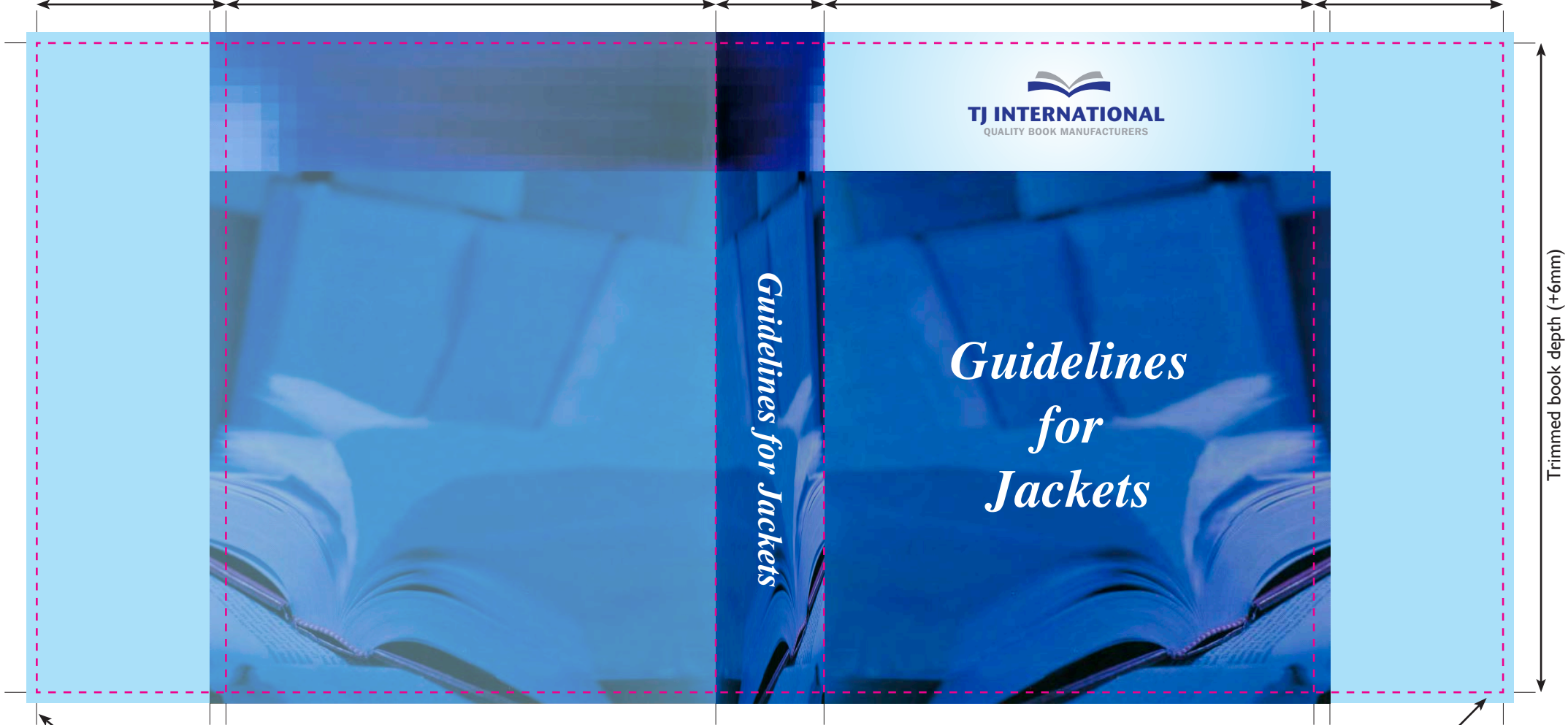
Flap width needs to measure between 75mm and 100mm and should include 10mm turn in for colour/image wrap

Flap width needs to measure between 75mm and 100mm and should include 10mm turn in for colour/image wrap

Trimmed book width (+4mm)

Spine width

Trimmed book width (+4mm)



Add trim marks

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3mm bleed ALL around