

## 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	<b>C 5.0 mm</b>	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

**Cover exterior** (document page 1)

**Cover exterior** (document page 2)

**Interior**

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

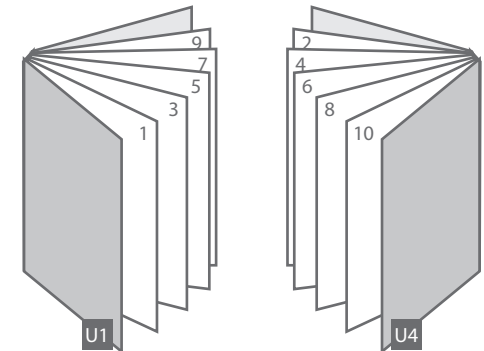
Please deliver two print files:

**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.

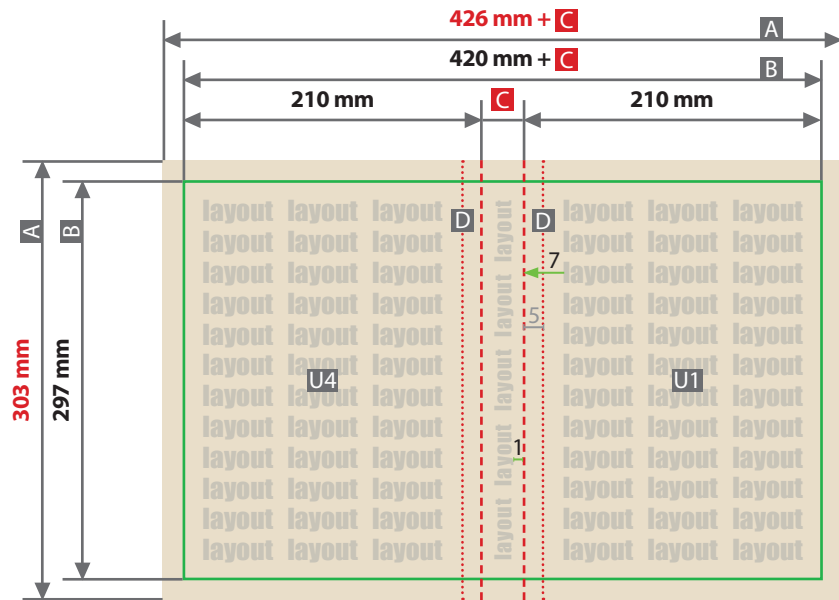


### Questions and help

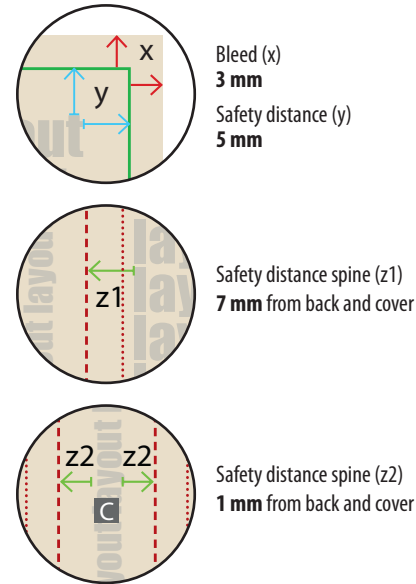
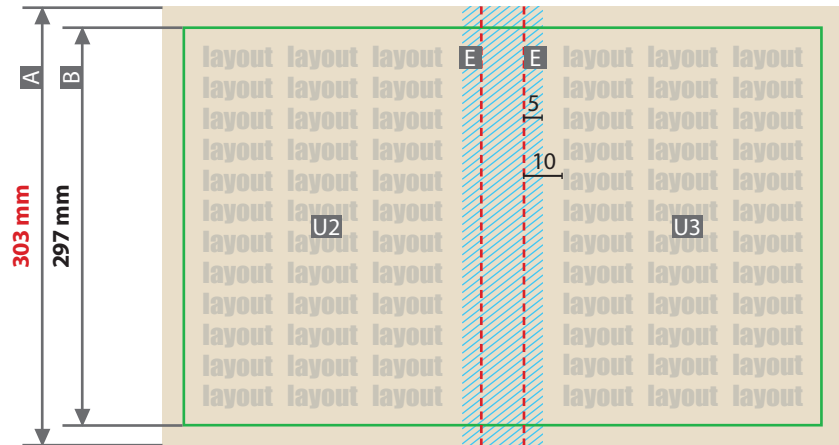
We are here to help: call our customer service centre today.

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

Document page 1: Cover – exterior



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  
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

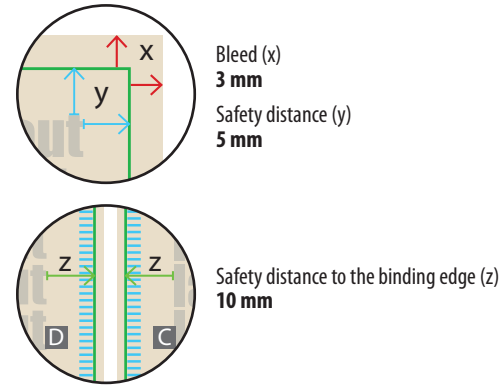
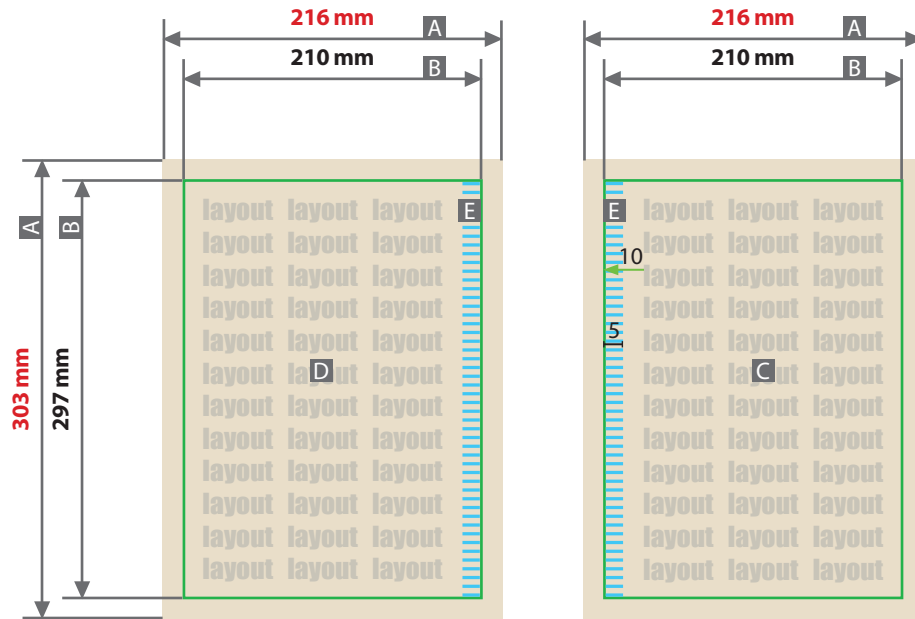
- PDF file, multiple pages
- CMYK colour space, ISO coated v2 300% output profile
- Image resolution: 300 ppi minimum

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

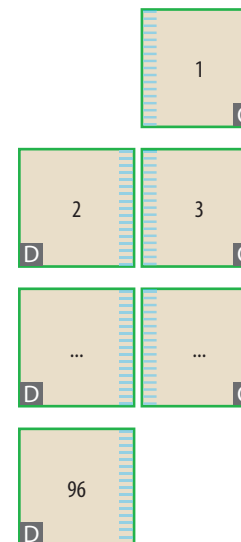
# Adhesive binding

## 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 for brochures with softcover (digital print)

Number of pages (incl. cover)	Type of material for the inner part													
	70g offset	80g natural paper	80g book paper	90g matt	90g offset	100g offset	135g matt	135g glossy	120g offset	150g recycled paper	160g natural paper	170g matt	170g glossy	190g photo paper
	Spine width													
28	-	-	-	-	-	-	-	-	-	-	4.0 mm	-	-	4.0 mm
32	-	-	-	-	-	-	-	-	3.5 mm	4.0 mm	4.5 mm	3.5 mm	-	4.5 mm
36	-	-	-	-	-	-	-	-	4.0 mm	4.0 mm	4.5 mm	4.0 mm	3.5 mm	4.5 mm
40	-	-	-	-	3.5 mm	-	3.5 mm	-	4.0 mm	4.5 mm	5.0 mm	4.5 mm	4.0 mm	5.0 mm
44	-	3.5 mm	3.5 mm	-	3.5 mm	3.0 mm	4.0 mm	-	4.5 mm	5.0 mm	5.5 mm	4.5 mm	4.0 mm	5.5 mm
48	3.5 mm	4.0 mm	4.0 mm	-	3.5 mm	3.5 mm	4.0 mm	4.0 mm	4.5 mm	5.0 mm	6.0 mm	5.0 mm	4.5 mm	6.0 mm
52	3.5 mm	4.5 mm	4.5 mm	-	4.0 mm	3.5 mm	4.5 mm	4.0 mm	5.0 mm	5.5 mm	6.0 mm	5.0 mm	4.5 mm	6.0 mm
56	4.0 mm	4.5 mm	4.5 mm	-	4.5 mm	3.5 mm	4.5 mm	4.0 mm	5.0 mm	6.0 mm	6.5 mm	5.5 mm	5.0 mm	6.5 mm
60	4.0 mm	4.5 mm	4.5 mm	4.0 mm	4.5 mm	4.0 mm	5.0 mm	4.5 mm	5.5 mm	6.0 mm	7.0 mm	5.5 mm	5.0 mm	7.0 mm
64	4.0 mm	5.0 mm	5.0 mm	4.0 mm	5.0 mm	4.0 mm	5.0 mm	4.5 mm	6.0 mm	6.5 mm	7.5 mm	6.0 mm	5.5 mm	7.5 mm
68	4.5 mm	5.0 mm	5.0 mm	4.0 mm	5.0 mm	4.5 mm	5.5 mm	5.0 mm	6.0 mm	6.5 mm	8.0 mm	6.5 mm	5.5 mm	7.5 mm
72	4.5 mm	5.0 mm	5.0 mm	4.0 mm	5.5 mm	4.5 mm	5.5 mm	5.0 mm	6.5 mm	7.0 mm	8.0 mm	6.5 mm	6.0 mm	8.0 mm
76	5.0 mm	5.5 mm	5.5 mm	4.5 mm	5.5 mm	5.0 mm	6.0 mm	5.0 mm	6.5 mm	7.5 mm	8.5 mm	7.0 mm	6.0 mm	8.5 mm
80	5.0 mm	5.5 mm	5.5 mm	4.5 mm	6.0 mm	5.0 mm	6.0 mm	5.5 mm	7.0 mm	8.0 mm	9.0 mm	7.0 mm	6.5 mm	9.0 mm
84	5.0 mm	6.0 mm	6.0 mm	4.5 mm	6.0 mm	5.5 mm	6.5 mm	5.5 mm	7.5 mm	8.5 mm	9.5 mm	7.5 mm	6.5 mm	9.5 mm
88	5.0 mm	6.0 mm	6.0 mm	5.0 mm	6.0 mm	5.5 mm	6.5 mm	6.0 mm	7.5 mm	8.5 mm	10.0 mm	7.5 mm	7.0 mm	9.5 mm
92	5.5 mm	6.0 mm	6.0 mm	5.0 mm	6.5 mm	6.0 mm	6.5 mm	6.0 mm	8.0 mm	9.0 mm	10.0 mm	8.0 mm	7.0 mm	10.0 mm
96	5.5 mm	6.5 mm	6.5 mm	5.0 mm	7.0 mm	6.0 mm	7.0 mm	6.0 mm	8.0 mm	9.5 mm	10.5 mm	8.5 mm	7.5 mm	10.5 mm
100	5.5 mm	6.5 mm	6.5 mm	5.5 mm	7.5 mm	6.5 mm	7.0 mm	6.5 mm	8.5 mm	9.5 mm	11.0 mm	8.5 mm	7.5 mm	11.0 mm
104	6.0 mm	7.0 mm	7.0 mm	5.5 mm	7.5 mm	6.5 mm	7.5 mm	6.5 mm	8.5 mm	10.0 mm	11.5 mm	9.0 mm	8.0 mm	11.0 mm
108	6.0 mm	7.0 mm	7.0 mm	5.5 mm	7.5 mm	7.0 mm	7.5 mm	6.5 mm	9.0 mm	10.5 mm	12.0 mm	9.0 mm	8.0 mm	11.5 mm
112	6.0 mm	7.5 mm	7.5 mm	5.5 mm	8.0 mm	7.0 mm	8.0 mm	7.0 mm	9.0 mm	10.5 mm	12.5 mm	9.5 mm	8.5 mm	12.0 mm
116	6.5 mm	7.5 mm	7.5 mm	6.0 mm	8.0 mm	7.5 mm	8.0 mm	7.0 mm	9.5 mm	11.0 mm	12.5 mm	10.0 mm	8.5 mm	12.5 mm
120	6.5 mm	7.5 mm	7.5 mm	6.0 mm	8.5 mm	7.5 mm	8.5 mm	7.5 mm	9.5 mm	11.0 mm	13.0 mm	10.0 mm	9.0 mm	12.5 mm
124	7.0 mm	8.0 mm	8.0 mm	6.0 mm	8.5 mm	8.0 mm	8.5 mm	7.5 mm	10.0 mm	11.5 mm	13.5 mm	10.5 mm	9.0 mm	13.0 mm
128	7.0 mm	8.0 mm	8.0 mm	6.5 mm	8.5 mm	8.0 mm	9.0 mm	7.5 mm	10.5 mm	12.0 mm	13.5 mm	10.5 mm	9.5 mm	13.5 mm
132	7.0 mm	8.5 mm	8.5 mm	6.5 mm	9.0 mm	8.5 mm	9.0 mm	8.0 mm	10.5 mm	12.5 mm	14.0 mm	11.0 mm	9.5 mm	14.0 mm
136	7.5 mm	8.5 mm	8.5 mm	6.5 mm	9.0 mm	8.5 mm	9.5 mm	8.0 mm	11.0 mm	12.5 mm	14.5 mm	11.0 mm	10.0 mm	14.5 mm
140	7.5 mm	8.5 mm	8.5 mm	7.0 mm	9.5 mm	9.0 mm	9.5 mm	8.5 mm	11.0 mm	13.0 mm	15.0 mm	11.5 mm	10.0 mm	14.5 mm
144	7.5 mm	9.0 mm	9.0 mm	7.0 mm	10.0 mm	9.0 mm	10.0 mm	8.5 mm	11.5 mm	13.5 mm	15.5 mm	12.0 mm	10.5 mm	15.0 mm
148	8.0 mm	9.0 mm	9.0 mm	7.0 mm	10.0 mm	9.0 mm	10.0 mm	8.5 mm	12.0 mm	13.5 mm	15.5 mm	12.0 mm	10.5 mm	15.5 mm
152	8.0 mm	9.5 mm	9.5 mm	7.0 mm	10.0 mm	9.5 mm	10.5 mm	9.0 mm	12.0 mm	14.0 mm	16.0 mm	12.5 mm	11.0 mm	16.0 mm
156	8.5 mm	9.5 mm	9.5 mm	7.5 mm	10.5 mm	9.5 mm	10.5 mm	9.0 mm	12.5 mm	14.5 mm	16.5 mm	12.5 mm	11.0 mm	16.5 mm
160	8.5 mm	10.0 mm	10.0 mm	7.5 mm	10.5 mm	10.0 mm	10.5 mm	9.5 mm	12.5 mm	14.5 mm	17.0 mm	13.0 mm	11.5 mm	16.5 mm
164	8.5 mm	10.0 mm	10.0 mm	8.0 mm	11.0 mm	10.0 mm	10.5 mm	9.5 mm	13.0 mm	15.0 mm	17.5 mm	13.0 mm	11.5 mm	17.0 mm
168	9.0 mm	10.0 mm	10.0 mm	8.0 mm	11.0 mm	10.5 mm	11.0 mm	10.0 mm	13.0 mm	15.5 mm	17.5 mm	13.5 mm	12.0 mm	17.0 mm
172	9.0 mm	10.5 mm	10.5 mm	8.0 mm	11.0 mm	10.5 mm	11.0 mm	10.5 mm	13.5 mm	16.0 mm	18.0 mm	14.0 mm	12.0 mm	17.0 mm
176	9.0 mm	10.5 mm	10.5 mm	8.5 mm	11.5 mm	11.0 mm	11.5 mm	10.5 mm	14.0 mm	16.5 mm	18.5 mm	14.0 mm	12.5 mm	17.5 mm



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Number of pages (incl. cover)	Type of material for the inner part													
	70g offset	80g natural paper	80g book paper	90g matt	90g offset	100g offset	135g matt	135g glossy	120g offset	150g recycled paper	160g natural paper	170g matt	170g glossy	190g photo paper
	Spine width													
180	9.5 mm	11.0 mm	11.0 mm	8.5 mm	11.5 mm	11.0 mm	11.5 mm	11.0 mm	14.0 mm	16.5 mm	19.0 mm	14.5 mm	12.5 mm	17.5 mm
184	9.5 mm	11.0 mm	11.0 mm	8.5 mm	12.0 mm	11.5 mm	12.0 mm	11.0 mm	14.5 mm	17.0 mm	19.5 mm	15.0 mm	13.0 mm	18.0 mm
188	9.5 mm	11.5 mm	11.5 mm	9.0 mm	12.5 mm	11.5 mm	12.0 mm	11.0 mm	14.5 mm	17.0 mm	19.5 mm	15.0 mm	13.0 mm	18.5 mm
192	10.0 mm	11.5 mm	11.5 mm	9.0 mm	12.5 mm	12.0 mm	12.0 mm	11.5 mm	15.0 mm	17.5 mm	20.0 mm	15.5 mm	13.5 mm	18.5 mm
196	10.0 mm	11.5 mm	11.5 mm	9.0 mm	12.5 mm	12.0 mm	12.5 mm	11.5 mm	15.0 mm	18.0 mm	20.5 mm	15.5 mm	14.0 mm	19.0 mm
200	10.0 mm	12.0 mm	12.0 mm	9.5 mm	13.0 mm	12.5 mm	12.5 mm	12.0 mm	15.5 mm	18.0 mm	21.0 mm	16.0 mm	14.0 mm	19.5 mm
204	10.5 mm	12.0 mm	12.0 mm	9.5 mm	13.0 mm	12.5 mm	13.0 mm	12.0 mm	16.0 mm	18.5 mm	21.5 mm	16.5 mm	14.5 mm	20.0 mm
208	10.5 mm	12.5 mm	12.5 mm	10.0 mm	13.5 mm	13.0 mm	13.0 mm	12.0 mm	16.0 mm	19.0 mm	21.5 mm	16.5 mm	14.5 mm	20.5 mm
212	10.5 mm	12.5 mm	12.5 mm	10.0 mm	14.0 mm	13.0 mm	13.5 mm	12.5 mm	16.5 mm	19.0 mm	22.0 mm	17.0 mm	15.0 mm	20.5 mm
216	11.0 mm	12.5 mm	12.5 mm	10.0 mm	14.0 mm	13.5 mm	13.5 mm	12.5 mm	16.5 mm	19.5 mm	22.5 mm	17.0 mm	15.0 mm	21.0 mm
220	11.0 mm	13.0 mm	13.0 mm	10.5 mm	14.5 mm	13.5 mm	14.0 mm	13.0 mm	17.0 mm	20.0 mm	23.0 mm	17.5 mm	15.5 mm	21.5 mm
224	11.0 mm	13.0 mm	13.0 mm	10.5 mm	14.5 mm	14.0 mm	14.0 mm	13.0 mm	17.5 mm	20.0 mm	23.0 mm	18.0 mm	15.5 mm	22.0 mm
228	11.5 mm	13.5 mm	13.5 mm	10.5 mm	15.0 mm	14.0 mm	14.5 mm	13.0 mm	17.5 mm	20.5 mm	23.5 mm	18.5 mm	16.0 mm	22.0 mm
232	11.5 mm	13.5 mm	13.5 mm	11.0 mm	15.0 mm	14.5 mm	14.5 mm	13.5 mm	18.0 mm	21.0 mm	24.0 mm	18.5 mm	16.0 mm	22.5 mm
236	11.5 mm	14.0 mm	14.0 mm	11.0 mm	15.5 mm	14.5 mm	14.5 mm	13.5 mm	18.0 mm	21.0 mm	24.5 mm	19.0 mm	16.0 mm	23.0 mm
240	12.0 mm	14.0 mm	14.0 mm	11.0 mm	15.5 mm	14.5 mm	15.0 mm	14.0 mm	18.0 mm	21.5 mm	25.0 mm	19.0 mm	16.5 mm	23.5 mm
244	12.0 mm	14.0 mm	14.0 mm	11.5 mm	16.0 mm	15.0 mm	15.0 mm	14.0 mm	18.5 mm	22.0 mm	25.5 mm	19.5 mm	17.0 mm	24.0 mm
248	12.5 mm	14.5 mm	14.5 mm	11.5 mm	16.0 mm	15.0 mm	15.5 mm	14.5 mm	19.0 mm	22.5 mm	25.5 mm	20.0 mm	17.0 mm	24.0 mm
252	12.5 mm	14.5 mm	14.5 mm	12.0 mm	16.5 mm	15.5 mm	15.5 mm	14.5 mm	19.0 mm	22.5 mm	26.0 mm	20.0 mm	17.5 mm	24.5 mm
256	12.5 mm	15.0 mm	15.0 mm	12.0 mm	16.5 mm	15.5 mm	16.0 mm	14.5 mm	19.5 mm	23.0 mm	26.5 mm	20.5 mm	17.5 mm	25.0 mm
260	13.0 mm	15.0 mm	15.0 mm	12.0 mm	17.5 mm	16.0 mm	16.0 mm	15.0 mm	20.0 mm	23.0 mm	27.0 mm	20.5 mm	18.0 mm	25.5 mm
264	13.0 mm	15.5 mm	15.5 mm	12.5 mm	17.5 mm	16.0 mm	16.5 mm	15.0 mm	20.0 mm	23.5 mm	27.5 mm	21.0 mm	18.0 mm	25.5 mm
268	13.5 mm	15.5 mm	15.5 mm	12.5 mm	18.0 mm	16.5 mm	16.5 mm	15.5 mm	20.5 mm	24.0 mm	27.5 mm	21.5 mm	18.5 mm	26.0 mm
272	13.5 mm	15.5 mm	15.5 mm	12.5 mm	18.0 mm	16.5 mm	17.0 mm	15.5 mm	20.5 mm	24.5 mm	28.0 mm	21.5 mm	18.5 mm	26.5 mm
276	13.5 mm	16.0 mm	16.0 mm	13.0 mm	18.5 mm	17.0 mm	17.0 mm	15.5 mm	21.0 mm	24.5 mm	28.5 mm	22.0 mm	19.0 mm	26.5 mm
280	14.0 mm	16.0 mm	16.0 mm	13.0 mm	18.5 mm	17.0 mm	17.0 mm	16.0 mm	21.0 mm	25.0 mm	29.0 mm	22.0 mm	19.0 mm	27.0 mm
284	14.0 mm	16.0 mm	16.0 mm	13.0 mm	18.5 mm	17.5 mm	17.5 mm	16.0 mm	21.5 mm	25.0 mm	29.5 mm	22.5 mm	19.5 mm	27.5 mm
288	14.5 mm	16.5 mm	16.5 mm	13.5 mm	18.5 mm	17.5 mm	17.5 mm	16.5 mm	21.5 mm	25.5 mm	29.5 mm	23.0 mm	19.5 mm	27.5 mm
292	14.5 mm	16.5 mm	16.5 mm	13.5 mm	19.0 mm	18.0 mm	18.0 mm	16.5 mm	22.0 mm	26.0 mm	30.0 mm	23.0 mm	20.0 mm	28.0 mm
296	14.5 mm	17.0 mm	17.0 mm	13.5 mm	19.0 mm	18.0 mm	18.0 mm	17.0 mm	22.5 mm	26.0 mm	30.5 mm	23.5 mm	20.0 mm	28.5 mm
300	15.0 mm	17.0 mm	17.0 mm	14.0 mm	19.0 mm	18.5 mm	18.5 mm	17.0 mm	22.5 mm	26.5 mm	31.0 mm	23.5 mm	20.5 mm	29.0 mm
304	15.0 mm	17.5 mm	17.5 mm	14.0 mm	19.0 mm	18.5 mm	18.5 mm	17.5 mm	23.0 mm	27.0 mm	31.5 mm	24.0 mm	20.5 mm	29.0 mm
308	15.5 mm	17.5 mm	17.5 mm	14.5 mm	19.5 mm	19.0 mm	19.0 mm	17.5 mm	23.0 mm	27.5 mm	31.5 mm	24.0 mm	21.0 mm	29.5 mm
312	15.5 mm	17.5 mm	17.5 mm	14.5 mm	19.5 mm	19.0 mm	19.0 mm	17.5 mm	23.5 mm	27.5 mm	32.0 mm	24.5 mm	21.0 mm	30.0 mm
316	15.5 mm	18.0 mm	18.0 mm	14.5 mm	20.5 mm	19.5 mm	19.0 mm	18.0 mm	23.5 mm	28.0 mm	32.5 mm	24.5 mm	21.5 mm	30.5 mm
320	16.0 mm	18.0 mm	18.0 mm	15.0 mm	20.5 mm	19.5 mm	19.5 mm	18.0 mm	24.0 mm	28.5 mm	33.0 mm	25.0 mm	21.5 mm	31.0 mm
324	16.0 mm	18.5 mm	18.5 mm	15.0 mm	20.5 mm	20.0 mm	19.5 mm	18.0 mm	24.5 mm	28.5 mm	33.5 mm	25.0 mm	22.0 mm	31.0 mm