

GENERAL REFERENCE on COVERS

Standard procedures in measuring, folding, and constructing covers which are basic to all covers will be stated only in this section. They should be read prior to constructing a cover for one of the bindings.

PAPER

Paper covers must use stock which is heavy and rigid in order to protect the text block. Unlike most text blocks which require text weight paper, covers must use 80 or 100 pound cover weight paper. Strathmore Grandee is a good paper with a range of colors. Canson is thinner, but appropriate for smaller books.

Grain of the cover paper must be parallel with the hinge-folds. This allows the cover to bend as it is turned, and insures a clean fold. If it tends to crack or crease, the paper will first have to be scored, before it is folded.

COVER MEASURING PROCEDURE

Most non-adhesive bindings have a one piece paper cover which must be measured and cut before sewing begins. This is because the text block and cover are sewn simultaneously with a single thread.

In describing how to measure and cut a cover, the sheet of cover stock is always on the table, with the inside of the potential cover facing up. Dimensions are listed as a progression across the sheet. Widths are listed from the front cover foredge turn-in, if any, to front cover, spine, back cover, and then back cover foredge turn-in, if any. This means measuring proceeds from the right to left on the sheet, since the inside of the cover is marked.

Dimensions for a cover, as well as procedure of folding, will be given simultaneously. Each use of the word *plus* in the stated measurements also denotes the position of a fold on the cover. Mark these positions with your thumbnail, a prick with a pin or if you must, a faint pencil dot along the head or tail of the cover.

REINFORCING PAPER COVERS

Turn-Ins: A paperback tends to become dog-eared at the corners of the foredge.

To help prevent this, the foredge can be reinforced. Flaps at the foredge turn in to the inside of the side-cover. They are usually not glued down. The two layers at the foredge make it twice as strong. The foredge is two-ply. Certain paper covers have turn-ins at the head and tail, as well as the foredge, for rigidity. See: *Flat Back with Borders*, page 240.

Optional Liners: A flat back with borders, or separate side-covers with borders can have a sheet of paper underneath the bordered turn-ins to make a stiffer cover. The liner is also cover weight paper of the same or a different color than the cover. It is cut 1/4" less in height and width than the book block. It is seen on the inside of the side-covers.

The liner is held in place by the turn-ins, but should be tabbed or sewn into position to give structural rigidity, making the side-cover 2-ply. A dotted tab might be laced through the bordered turn-in and liner through slots. A design of tabbing with slits might be anywhere on the side-covers, lacing the liner and side-cover.

Slots: A slot is an opening, constructed by two slits, parallel, and no more than about 1/8" apart. A cut is made at right angles at the ends of the parallel slits to remove the paper or board within the slot.

Slots, rather than slits, are needed to accommodate heavy paper in weaving a strap or flap into a cover. They are also used to insert photographs into album pages. Slots help prevent the sheet from buckling.

Cutting the thickness of a slot creates a very narrow rectangle. If you are not careful and over-cut the corners, the paper is weakened at that point and could rip when photo is inserted (or a strap is woven). Both the single and double slot are more attractive if the extremes are started with a punch. The two resulting holes are connected with exacto knife and straight edge. The opening can be an oblong, or shaped like bar bells:



Punches come in different diameters. A punch is a small cylindrical metal tool with one end hollow and sharpened for cutting. The other end is solid metal, to be struck with a hammer. Book board should be placed under the sheet to be pierced. This will protect the sharpened edge of the tool. Do not punch onto a self-sealing cutting mat.

Reinforced Spine: Often in sewing a paper cover, the spine is reinforced so that the stitches do not rip the paper spine. A strip of cover stock the width and height of the spine can be glued down on the inside of the spine.

If you wish to avoid pastes and glues, you can maintain a totally non-adhesive structure. One means is turn-ins at head and tail, to give a two-ply spine. See: *Flat Back with Borders*, page 240. For a three-ply spine, see: *Flat Back with Fixed Foreedge Turn-ins*, page 237.

The spine can be reinforced by a cover with inside flap. Another means is a double or layered cover:

Cover with Inside Flap: A flat back cover is made, with the side-covers reduced in width to about 1-1/2" to 3" to become flaps. Another flat back cover with foreedge turn-ins is placed over the first, and the two are sewn as a unit. The turn-ins on the outer cover could extend in to the spine, covering the flaps. The structural purpose of the flaps is to reinforce the spine for sewing.

For purposes of design, the flap offers possibilities. The turn-ins might extend to meet the flap. The vertical edge of the flap and turn-in would be tangent. The turn-in and flap would open like swinging doors to reveal text or picture on the inside of the side-cover. Or, they could be stitched together to form a two-ply cover. The inside flap would structurally not only reinforce the spine, but the side-cover as well.

Another variation is to cut an endsheet slightly smaller in height and width than the side-cover *plus* the spine *plus* the other side-cover. This would be sandwiched between the cover and flap. The three would be sewn as a unit.

Layered Covers: Two flat back covers can be used as a double cover. One sitting inside the other. The inner cover does not have foreedge turn-ins. The outer does, and they fold around the inner cover. They are sewn as a single unit. See: *Flat Back cover*, page 236 and *Flat Back with Foreedge Turn-ins*, page 236.

Measure the inside flat back cover to fit the book block. Cut and fold the inside cover. The outer cover will have side-covers and spine about 1/16" greater in width. The height of both covers are the same. Measure and cut outer cover, but do not fold.

Fold one hinge-fold of the outer cover. Place outer cover in position, snug on the back of the inner cover. Mark the position of the second hinge-fold of the outer cover on the inside of the spine. Remove and fold.

Place outer cover snug against the back of the inner cover. Mark the positions of the foredge folds on the inside of the outer cover. Remove and fold the turn-ins.

This procedure for the outer cover of measuring as you go will allow enough extra width in folding, so the inner side-covers are not cramped and buckled.

Hold the two covers together as a unit, and proceed sewing as if with one cover.

If the turn-ins are almost as wide as the side-covers, you will, in effect, have a three-ply, or layered cover.

Layered covers can have a turn-in at the head and tail of either the inner or outer cover. Foredge turn-ins should only be on the outer. I would not recommend making a layered cover by using three flat backs, as this makes a three-ply spine, which could give trouble in the sewing.

Layered covers can be attached other than sewing both flat backs as a unit. See: *Jacket A*, page 117, and *Jacket B*, page 126.

All layered covers offer the possibility of cutting away parts of each layer to reveal composite designs. See examples on page 138 and 265.

OVERHANG COVERS

Hard cover books almost always have the cover boards extended slightly beyond the head, tail and foredge of the text block for protection. The oversize cover is referred to as an overhang cover. The amount of protrusion is called the square, or square of the book. With hard covers, the amount the board extends is usually 1-1/2 times the thickness of the book board.

An overhang paper cover cannot be a one-ply. The square of the book would quickly become crimped with use. Overhang paper covers must have turn-ins on the head, tail, and foredge as reinforcement to protect the square. This is described on page 240 as *Flat Back with Borders*.

Before marking the sewing stations using an overhang cover, center the section inside the cover, for an equal amount of overhang at the head and tail. Mark the stations on the spine, making sure the extreme sewing stations on the cover will catch the section. These stations must be slightly farther in from the head and tail than a cover which is the same height as the section.



VOLUME I

**NON-ADHESIVE
BINDING**

BOOKS WITHOUT PASTE OR GLUE



KEITH A. SMITH