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Perfect-bound brochure with hardcover | A4 | portrait | Cover

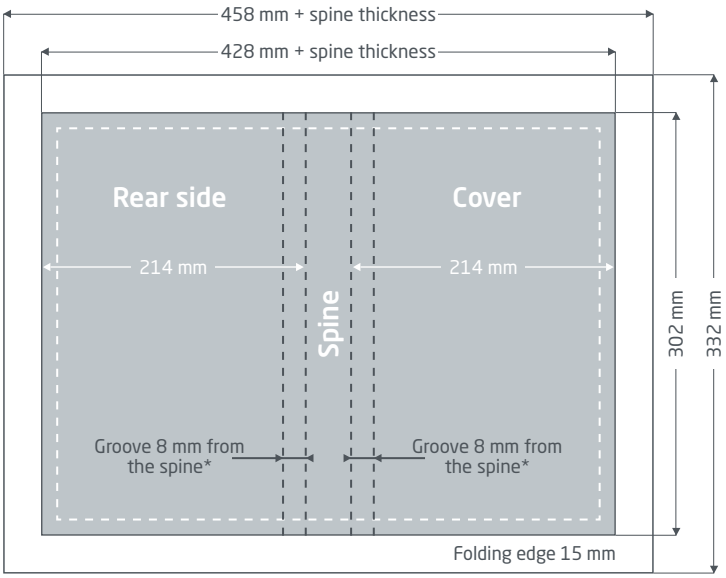
Final Closed Format:
214 × 302 mm

Final Open Format:
428 + spine thickness × 302 mm

Document format to deliver incl. TrimBox:
458 + spine thickness × 332 mm

General information:

- The spine thickness is variable and based on the number of pages and the paper that is used
- Please provide a 1-page PDF in the document format to be delivered incl. spine thickness separately from the interior part



Cover, exterior (PDF page 1)

Bleed: min. 15 mm
Parts of your project that are designed up to the edge of the page need to be extended into bleed. This area is trimmed off during the manufacturing.

Margins: min. 5 mm
It is recommended that no important texts or images are placed outside the inner margins set inside the TrimBox due to manufactoring tolerances.

Groove: 8 mm from the spine

Final Format: Size of the finished product

*See next page for information on the groove.

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Product-specific data preparation » Perfect-bound brochure with hardcover

Information for designing the book cover

Book cover

The cover for wrapping requires a 15-mm folding edge all-around. The book cover is larger than the book block and therefore the book cover protrudes somewhat over the book block.

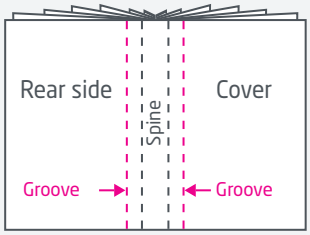


Book spine

The spine thickness varies and depends on the total number of pages and the paper that is used. The exact spine thickness will be shown to you directly on your order on the online website.
However, due to technical production reasons, the spine thickness may differ by up to 20%.
Our recommendation: Do not use graphics that go directly over the spine to prevent visible discrepancies (production-related) in the final product.
Text can be placed on the spine only if the thickness is 8 mm or greater. Please maintain an adequate distance from the edge.

Book cover groove

The groove is located 8 mm apart on both sides of the spine. Please do not place small typography in the folding area. The visual centre is moved by approx. 2 mm by the fold to open the book (see information on visual central axis). For graphics with a distance smaller than approx. 10 mm from the edges, the graphics should be aligned to the centre axis of the cover.



Format adjustment

Please always follow the instructions in the test report. If you provide an incorrect page format, incorrect TrimBox or incorrect page orientation, we will place your data centred and unscaled in the ordered page format and inform you before you authorise the printing.

Hardcover

Brochures with a stable, fixed book cover. During this process, the cover – which is printed on paper and wrapped in cellophane – is stretched onto the cardboard book cover. The book spine and cover are not connected by the same cardboard, creating an empty space between the book block and spine when opening. The hardcover binding is robust and therefore delivers long-lasting durability.

Front/back endpaper

The front and back endpaper are part of the cover and are not printable.

Bookmark and headband

The bookmark (also known as a ribbon marker) is a long, flat, fabric band that is fastened to the book's spine. With a content block thickness of 6 mm or greater, you can optionally choose a bookmark in many different colours.
The headband is placed between the book block and book cover. It covers the space between the book spine and book block, thereby making the book look more visually attractive. With a content block thickness of 5 mm or greater, you can optionally choose a headband in many different colours.



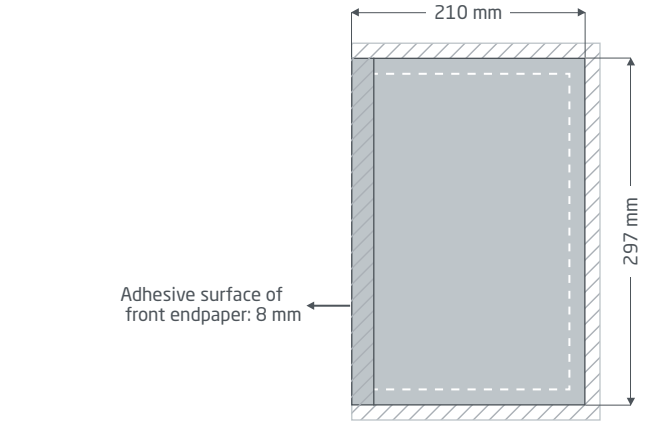
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Perfect-bound brochure with hardcover | A4 | portrait | Content

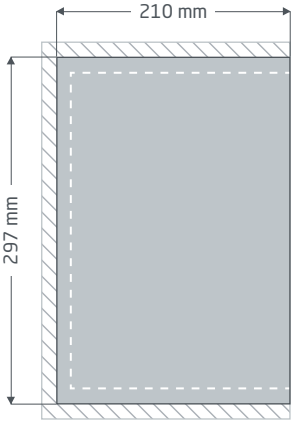
Final Open Format (TrimBox):
210 × 297 mm

General information:

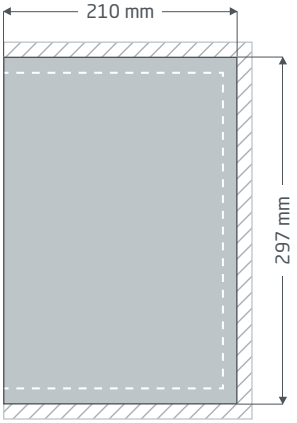
- Number of pages must be divisible by four
- Please provide a PDF with consecutive, individual pages in the right order.



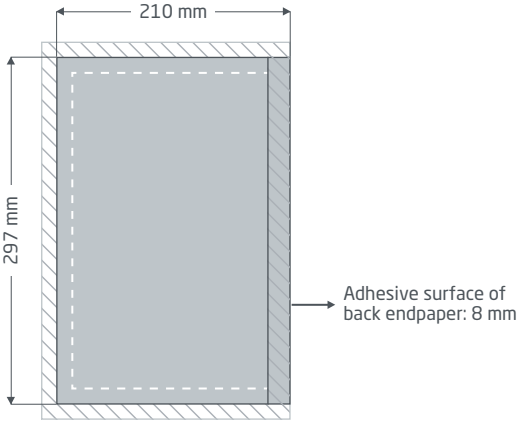
1 Inner page - right (PDF page 1)



Consecutive, even number of pages on the left



Consecutive, odd number of pages on the right



Last inner page, left (last PDF page)

Bleed: min. 3 mm
Parts of your project that are designed up to the edge of the page need to be extended into bleed. This area is trimmed off during the manufacturing.

Final Format:
Size of the finished product (TrimBox)

Margins: min. 5 mm
It is recommended that no important texts or images are placed outside the inner margins set inside the TrimBox due to manufactoring tolerances.

Adhesive surface of front/ back endpaper 8 mm
No text or important content; the area is no longer visible afterwards! Position in the left inner page on the left hand edge and on the right inner page on the right hand edge.

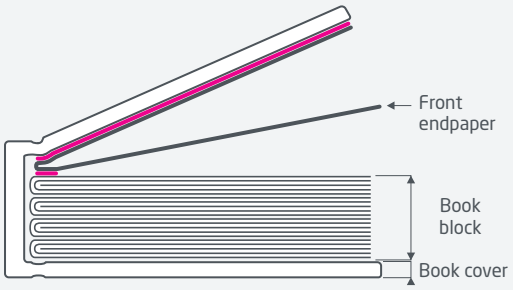
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Product-specific data preparation » Perfect-bound brochure with hardcover

Information for designing the pages of the interior

Joining area for front and back endpaper

The front and back endpaper are the double pages at the beginning and the end. They connect the book cover to the book block.
On the front endpaper, the left side is fully adhered to the interior side of the book cover and the right side to the left edge of the first page of the interior by 8 mm. On the back endpaper, the right side is fully adhered to the interior side of the book cover, and the left side is adhered to the right edge of the last page of the interior by 8 mm.



The adhesive area with the first and last page of the interior is afterwards no longer visible. Nevertheless, adjacent print elements should extend 2–3 mm into the joining area to prevent trapping.

- Adhesive area for front/back endpaper
- Additional margin for elements near the edge: 2–3 mm



Graphics that extend across pages

Graphics or images may be visually offset.

Format adjustment

Please always follow the instructions in the test report. If you provide an incorrect page format, incorrect TrimBox or incorrect page orientation, we will place your data centred and unscaled in the ordered page format and inform you before you authorise the printing.

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Guide on preparing print data

In order to achieve an optimal print result, please consider the following items when creating your print data:

File format
Please send us a PDF or JPG file that is ready to print. We recommend that you create a PDF file according to the PDF/X-1a, PDF/X-3 or, preferably, the PDF/X-4 standard.

Colour space and ink coverage
All elements of the document should be created in CMYK mode. We will automatically convert data created in another colour mode (e.g. RGB, LAB, spot colours) to CMYK. We do not assume any liability for resulting colour deviations or non-display of objects, especially in connection with transparencies or unknown special colours. Furthermore, please provide your print data with the corresponding ICC profiles for standardised offset printing. For coated papers use the colour profile "PSOcoated_v3.icc" and for uncoated papers the profile "PSOuncoated_v3_FOGRA52.icc".
Please create grey areas and black texts exclusively in the black channel. Objects with a total colour application of over 320%, exceeding the limit for printing, will be reduced to this 320% total colour application for production reasons.

Resolution of images and graphics
Generally, we recommend a resolution of at least 250 ppi (dpi), and at least 1,200 ppi (dpi) for line art.

Page format, page alignment, and page bleed
Please make the page format and page orientation equal for all sides and according to your desired print job. Elements that extend to the edge require a bleed margin. Furthermore, we recommend that you maintain a safety clearance at the edge of your document by not placing any text or important elements due to possible manufacturing tolerances. If the page format or page orientation in your print data differs from the requirements listed herein, we will place your template centred and unscaled in the ordered page format and we will notify you thereof before you give the approval for printing. We cannot accept any liability for resulting complaints.

Fonts
Please embed all the fonts that you use in your print file. We will not replace missing fonts. For optimum readability, we recommend a minimum font size of 5 points.

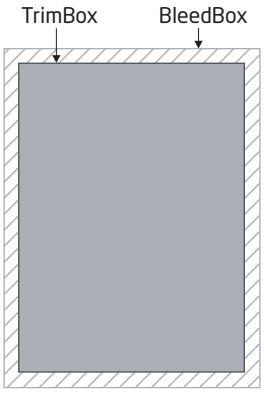
Lines
The line weight of graphics and text outlines should be at least 0.2 pt. We automatically thicken excessively thin lines to this minimum printable size. Please note that this can also cause lines created with 0 pt to become visible or thicken text outlines that are too narrow.

Overprinting, non-printing elements and layers
Please remove all non-printing elements from your document. PDF files should not contain any layers. Check if the overprinting settings are correct.

Format adjustment
During the ordering process and as part of the selected data check, we check your print data to see if the page format of your print data matches that of the ordered product, among other things. Only the "TrimBox" is important in this case. You can freely define the size of the possible BleedBoxes according to your needs.

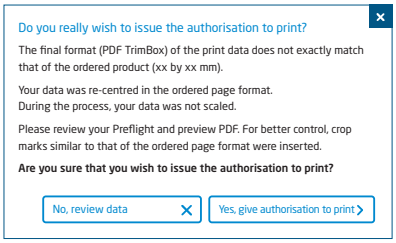
Final Format (TrimBox):
The TrimBox describes the trimmed final format of a page.

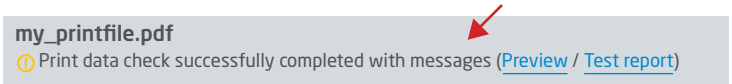
BleedBox:
The BleedBox defines the bleed of a page. With a bleed of 3 mm, the BleedBox will be 3 mm larger all around than the final format.



You can check the TrimBox of your PDF file using the **Adobe Acrobat Reader** and **Adobe Acrobat** programs. Unlike Acrobat, Adobe Reader has very limited functionality. For instance, you cannot alter PDF documents with Adobe Reader. You must use Acrobat to do so.
You can display the TrimBox or final format in both programs as follows: Open the "Presets" in the menu and from there, activate "Page display" » "Page contents and information", activate the "Show art, final format, and BleedBox" menu item. Afterwards, the TrimBox will be displayed with a red border and the BleedBox with a blue border in the corresponding PDF file.

If there are discrepancies between the page formats of the ordered product and their print data, we adjust the format. In other words, we place your data centrally and unscaled in the ordered page format and notify you both in the test report of the data check and in a separate window before the order is completed.





In our prepared, low-resolution preview file, you can check the status of your file. If the format is adjusted, we always add crop marks for you in this preview.

We do not check the contents of your data at all. The print data is checked automatically. Please make sure that you always adhere to the instructions of the data check print area in the online website. We recommend that you use "advanced data check". We assume no responsibility for problems arising due to failure to adhere to this data sheet and the data handling guidelines on our website!