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: 320pp (Extent) x 80gsm (Paper Weight) x 17.5 (Volume) ÷ 20,000 = 22.4 (Spine bulk of 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.

Notch Limp or Perfect Bound:

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

Sewn Limp:

Add additional 1mm to bulk - Maximum spine size 60mm

Notch Case Bound:

Up to 479pp + 4.5mm
480pp - 959pp + 5mm
960pp and above + 6mm Maximum spine size 60mm

Sewn Case Bound:

Up to 479pp + 5.5mm
480pp - 959pp + 6mm
960pp and above + 7mm Maximum spine size 60mm

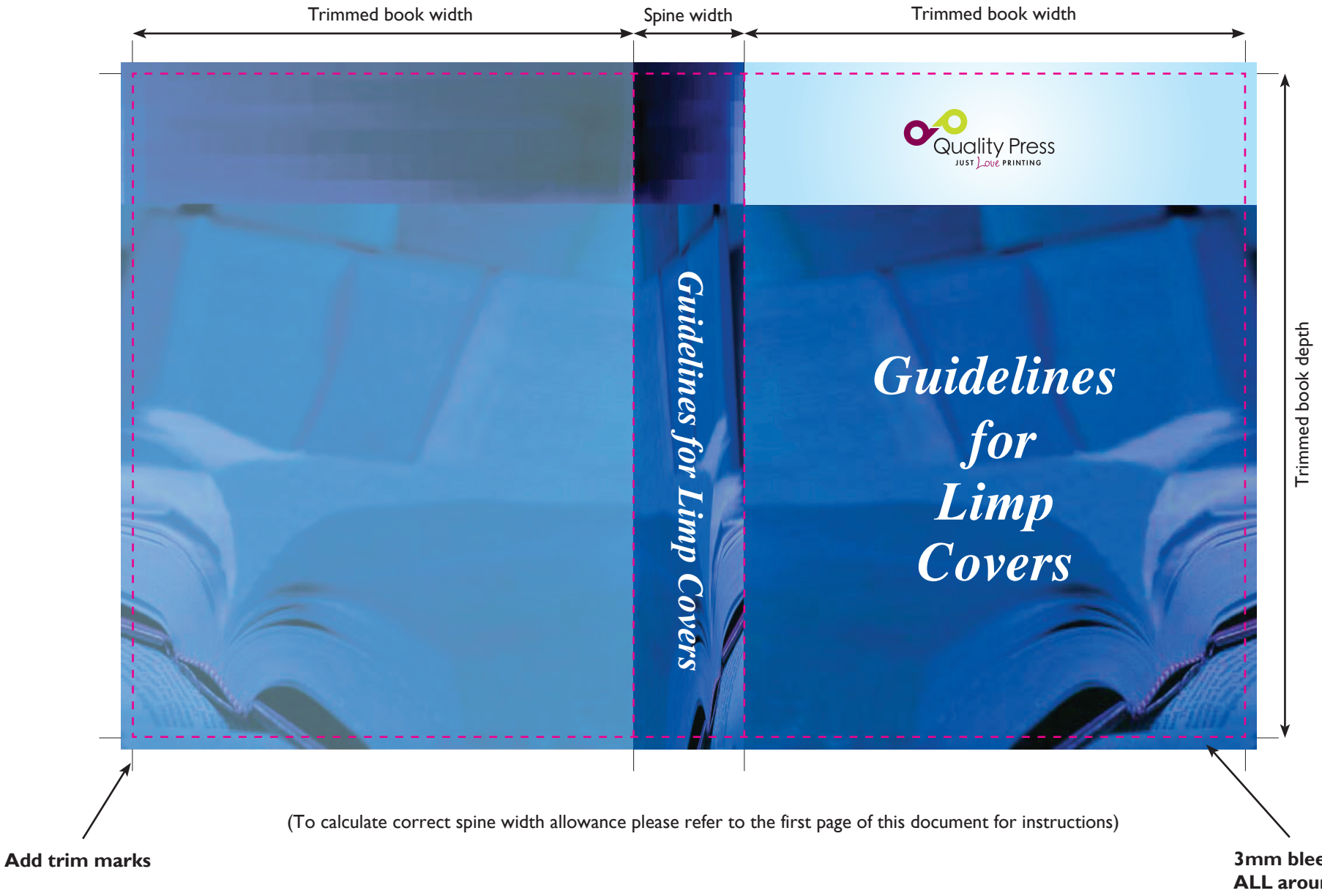
Flat Back Case Bound:

Up to 479pp + 9.5mm.
480pp - 959pp + 10mm.
960pp and above + 11mm Maximum spine size 60mm

Standard Book Sizes

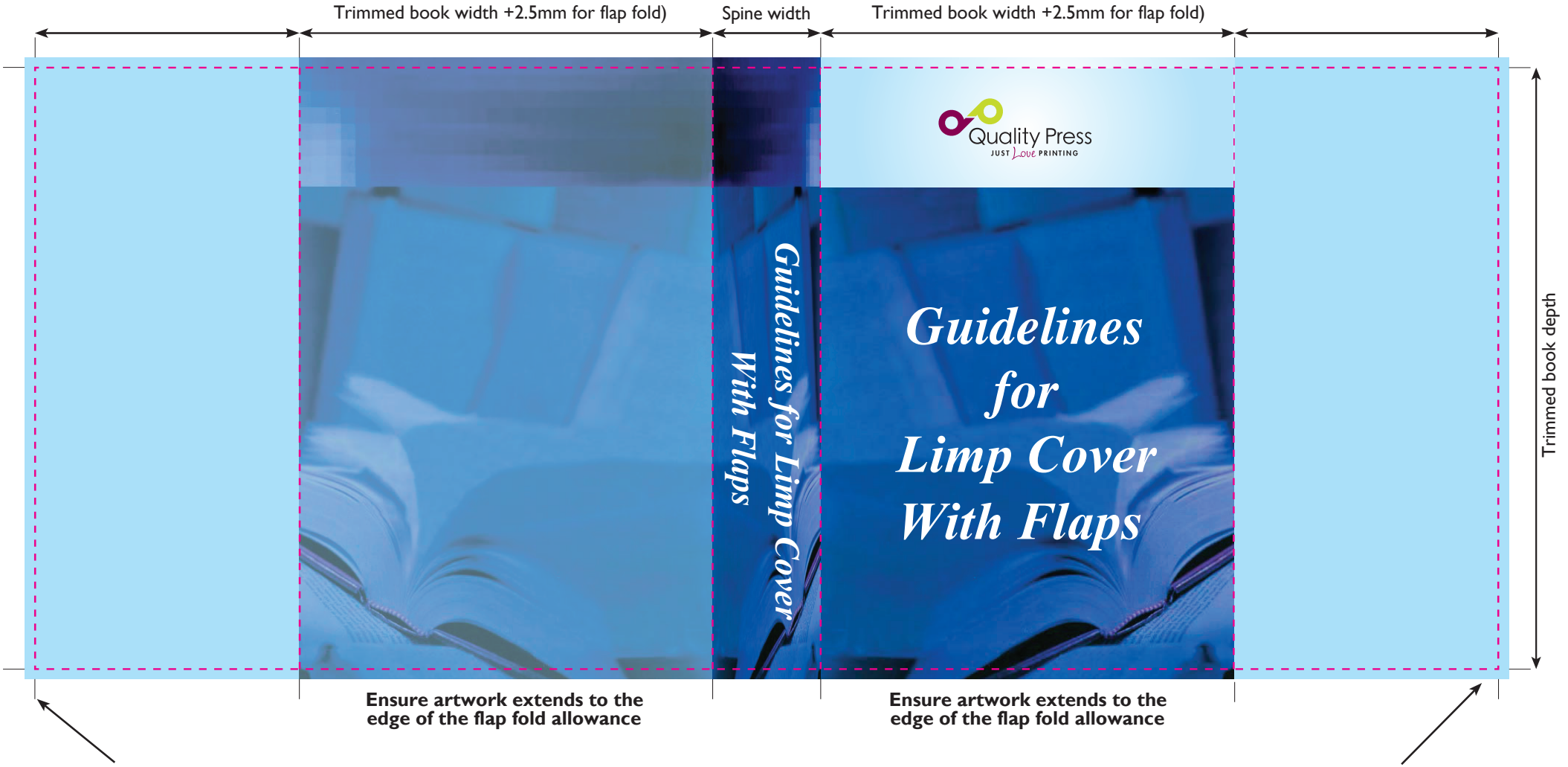
Common Sizes:

198x129	B - Format	297x210	A4
216x138	Demy		
229x152	American Royal		
234x156	Royal Octavo		
246x171	Pinched Crown Quarto (PC4)		
246x174	Pinched Crown Quarto (PC4)		
246x189	Crown Quarto		
276x219	Demy Quarto		


Trimmed book width
Spine width
Trimmed book width
Quality Press
JUST Love PRINTING
Guidelines for Limp Covers
Guidelines for Limp Covers
Trimmed book depth
(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
Flap width maximum = trimmed book width less10mm

Flap width minimum size = 50mm
Flap width maximum = trimmed book width less10mm



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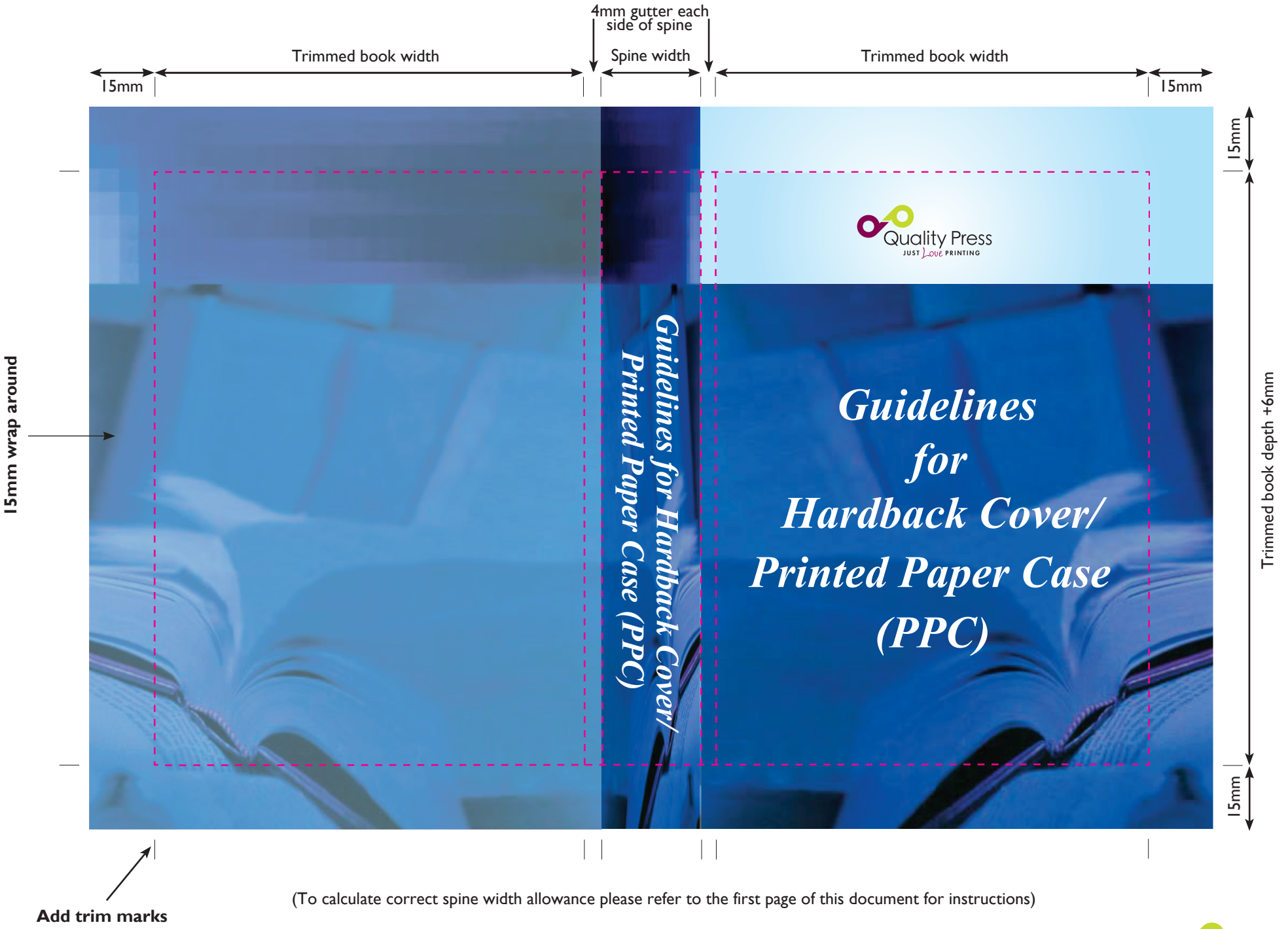

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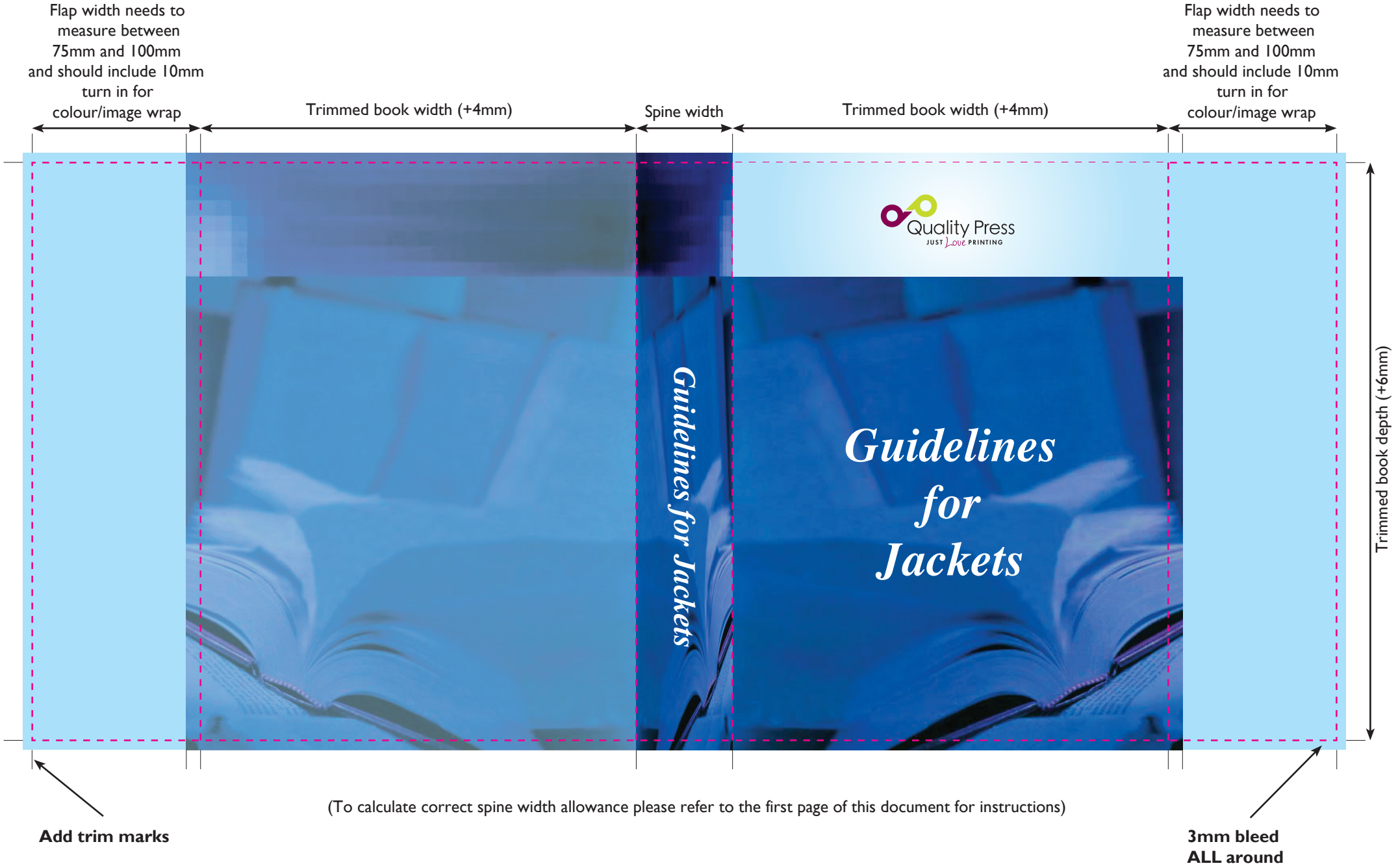

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