

**7th ANNUAL GUILD OF BOOKWORKERS STANDARDS SEMINAR
COLLABORATION OF PRINTER AND BINDER**

*G. Rummolds +
Craig Jensen*

*1987
Austin*

Following is a typical, if not somewhat idealistic, chronology for binding a limited edition at Jensen Bindery.

PRELIMINARY CONTACTS AND NEGOTIATIONS

Initial specifications are set (usually by printer)

Style of binding

- materials to be used, proportions, etc.

- budget expectations

Jensen Bindery responds to initial specifications

Suggested revisions

Binder's suggested specifications

- technical description of proposed binding

- list of materials

- rough cost estimate

Binder and printer agree on trial specification

DUMMY CONSTRUCTION AND FINAL SPECIFICATIONS

Printer will provide the following

Specification of colors and materials to be used in binding

Working set of sheets

Special endpapers, cover papers, etc.

Jensen Bindery constructs dummy

An inventory of steps required to bind dummy is compiled

- any problems with materials or structure are noted

- finished dummy is sent to printer with comments about problems and suggested revisions

Printer reviews the dummy

Dummy is returned to Jensen Bindery with approval or suggested changes (this stage usually includes phone conversations)

Jensen Bindery responds to printer's review

A new dummy can be constructed (only if necessary)

If dummy is approved:

- inventory of steps is reviewed and revised if necessary

- a spreadsheet bid template is created or revised to fit the inventory of steps

- production times for each step are revised or established

- material costs and availability are established

-final bid is prepared and presented to printer with a detailed specification of the binding and each party's responsibilities

The printer responds to the bid

If the bid is accepted:

-printer prepares printed sheets and any other previously agreed upon materials for delivery or shipment (special cover papers, endpapers, etc.)

If the bid is rejected:

-reasons are established and minor adjustments are made

-if bid is rejected and not negotiable, a bill is sent for design and construction of the dummy

PRODUCTION

Before production begins

Printer's responsibility:

-deliver printed sheets and any other agreed upon materials

-deposit is made

Jensen Bindery's responsibility

-order all necessary materials

-assure availability and delivery times

Production begins

Strategy planning

-logical sequence of pre-forwarding steps (cutting and any delivery and pick-up of sub-contract work)

-clear benches and storage areas to accommodate work in progress

-assignment of resources (labor and equipment)

-make quality control assignments

Production sequence for JOURNEYS IN SUNLIGHT

1. Make endpaper jig
2. Cut and make up endpapers
3. Make piercing jig
4. Pierce sections
5. Sew books
6. Glue spines
7. Round and back
8. Make-up endband cores
9. Sew endbands
10. Cut balloon cloth *light-wood muslin*
11. Cut paper spine liners

12. Line spines *1 cloth, 1+ paper (1 step)*
13. Cut hollows *10pt nup stock - 2 pcs. laminated - shoulder + shoulder width*
14. Shape hollows *Cons. into rounds over form*
15. Trim balloon cloth to accommodate turn-ins *larger than book 38" - at shoulder slit down for leather turn-ins*
16. Cut polyester mask strips
17. Insert polyester masks *under cloth*
18. Cut spine carrier *AW archival paper*
19. Attach hollows *glue hollows onto paper glue to cloth turn-ins*
20. Nip in laying press *on polyester*
21. Cut boards
22. Attach boards *Pull away excess spine carrier at corners*
23. Trim hollows *cover polyester + paper carriers cut off at square*
24. Cut leather
25. Pare leather
26. Make paste *to spine*
27. Attach leather and set hinges *with bone folder*
28. Press books and allow leather to dry
29. Repaste turn-ins and turn in and set caps
30. Make jig for trimming out leather
31. Score leather for trimming
32. Trim leather
33. Cut outside fills *redesign built to fill in level c leather - sand edges*
34. Attach outside fills
35. Sand/trim outside fills
36. Make jig for cutting cover paper
37. Mark cover paper for cutting
38. Cut cover paper
39. Attach cover paper
40. Cut inside fills
41. Cut polyester mask to protect textblock
42. Trim out and attach inside fills and insert masks
43. Paste down endpapers and reinsert masks
44. Press book
45. Open and set joints
46. Allow books to completely dry
47. Remove masks
48. Put books in boxes (box production was conducted simultaneously with binding production)
49. Pack boxed books for shipping
50. Return books by registered and insured mail.