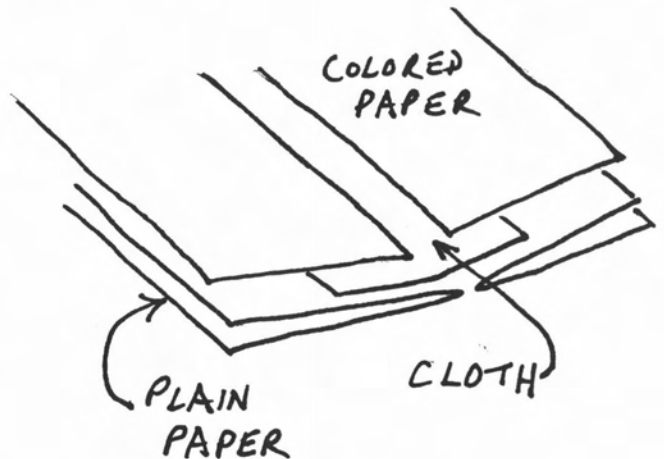


Spring Back Ledger Binding

1. Make endsheets. (See illustration.) Place two folded sheets fold-to-fold on bench. Glue cloth strip and place on folds. Glue marbled paper and place on top, lining up with outer edge of folded sheet. Nip in press.
2. Sew on 4 tapes. **Knots on outside!** Sew on endsheets using colored thread to match cloth joint by tying on to regular thread by the last tape of the last signature so only a short section of colored thread shows in the first and last signatures.
3. Glue flyleaf to first page (and last) of book and nip.
4. Glue up spine.
5. Trim edges in guillotine.
6. Round book before glue sets hard, but **DO NOT BACK.**
7. Glue stiff card (20 pt., Height of book x $\frac{1}{4}$ the book width) to waste sheet lining up edge of card to spine of book.
8. Glue down tapes.
9. Glue waste sheet, then fold over to the back edge. Rub well and cut off excess, $\frac{1}{4}$ inch from edge of stiff card.
10. Paste scrap leather strips to spine as a lining. Use same color as covering leather. Rub until well stuck, using paste as lubricant on folder. Let dry.
11. Cut off leather flush with ends of book and cut flaps on an angle at ends and pare the three flap edges with knife.



12. Make semi-circular cut with knife through leather and card at each end of flap. (Be careful not to cut through sewing.) Angle the blade so that the cut allows the end of the flap to move toward the book and the center of the flap moves away. See illustration.

13. Make split boards, 2/3 glued, 1/3 open.

14. Make spring back. Cut heavy card (20 pt.) the length of the book plus 2 inches x the width of the spine at the tape plus $\frac{3}{8}$ – $\frac{1}{2}$ inches. Cut good paper the same length x twice the width of the card plus $\frac{1}{2}$ inch. Glue paper with PVA, place card in center, glue again, wipe out glue from edges with bone folder, fold paper around and nip in press.

15. While still damp, roll the spring back on a piece of pipe or dowel the same diameter as the thickness of the book at the fore-edge using a piece of Kraft paper to hold it in shape. Leave for about 15-20 minutes. Bend the edges into a "C" shape to "grip" the spine of the book.

16. Hold in shape with bricks until dry.

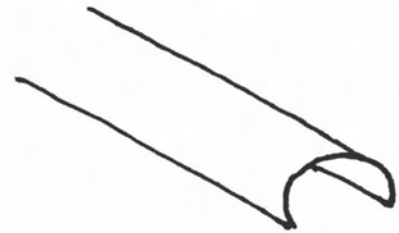
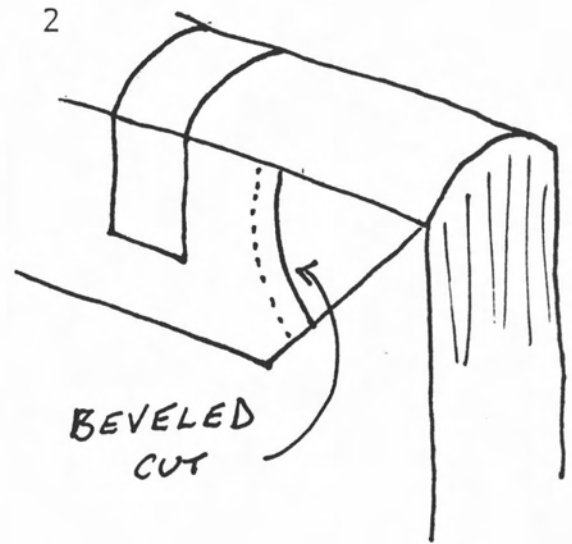
17. Glue "C" cloth strips to inside of spring back and glue them to flaps to hold spring back on spine. Add leather strips to create false raised bands, if desired.

18. Cut boards to size on guillotine and round corners.

19. Nick boards, glue splits, set on book with only the center part of the flap glued into the split (leave groove at least as wide as the boards are thick; extra for banded work) and nip.

20. Cut the ends of the spring back in a crescent moon, pare back slightly, and hammer over to form headcaps.

21. Cut and edge pare leather spine and corners.



22. Put on corners.

23. Dampen ends of spring back. Paste leather. Paste up spine and rub paste in groove. Put on leather spine and turn in head and tail. Press with brass rods or wood dowels in groove for 10-15 minutes. Remove from press and tie up. Set head cap by hammering over and set as in quarter leather library style. Let dry between boards and under a weight.

Bibliography

Modern Bookbinding, Alex. Vaughan, Skilton, London 1929
(reprint 1960).

