

General FlexBind® Printing Guidelines

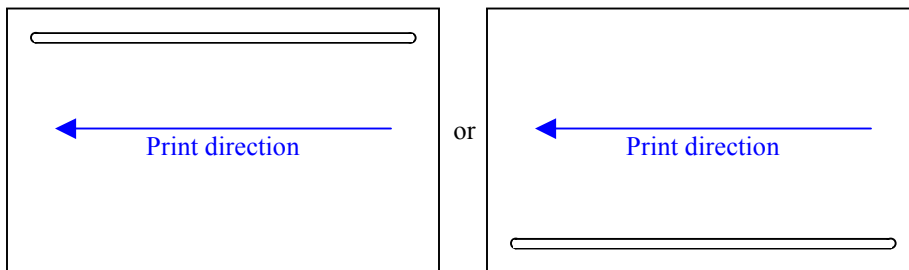
General Info:

Printing Issues

- Duplexing is recommended
- UV coating can be used normally without modification to standard processes

Paper orientation while printing

- The hinge should be along either the back or the front of the press while printing to improve toner/ink transfer into the recessed gap. See Illustration.



Feed drawer stacking

- Fan stack before loading into the feed drawer. If excessive blocking occurs, verify storage conditions are in compliance with guidelines.
- If possible, assign a drawer to FlexBind® sheets to prevent excessive handling during repetitive loading and unloading between jobs.
- Wedges and stack tilt devices are unnecessary since FlexBind® sheets are perfectly flat and produce no stack bias.

Ream handling

- Do not flex the hinge before printing
- Do not straighten stacks of FlexBind® sheets by resting the stack on the hinge side of the sheet.

Trimming

- Trimming can be done individually with an in-line trimmer or by stacking multiple books and guillotine cutting the stack.
- The indented laminated hinge allows for stacks of FlexBind® sheets to be cut simultaneously without stack bias.
- Be sure to use a sharp knife to cut the film cleanly without tearing.
- Trim 4 sides of the sheet. Be sure to cut the spine of the FlexBind® page to the proper width for the intended binding method

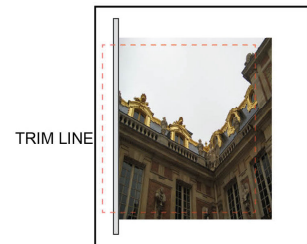
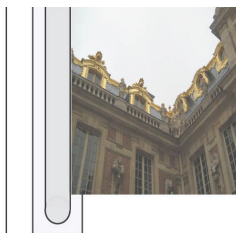
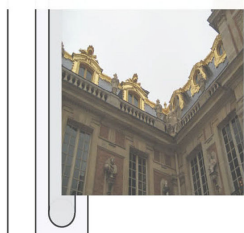


Image position

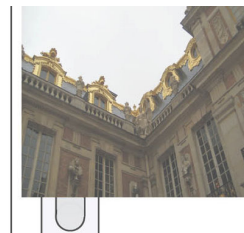
- Image placement on the FlexBind® sheet should be centered in the hinge gap, or printed over the gap. See illustration.
- If there is difficulty getting toner transfer into the recessed gap, it is recommended to print only to the edge of the gap. (See #1 below)
- Images extending across the binding will need to be individually verified for registration.
- Setup on different paper so as to not waste FlexBind® sheets
- The image should be printed on the laminate as necessary. The laminate is coated to be toner receptive.



1. Image placed up to the gap



2. Centered in the hinge gap



3. Printed over the gap

General FlexBind® Binding Guidelines

Below is a partial list of binding methods and hardware with recommendations about binding FlexBind® pages. This is not a guarantee or endorsement of any particular product or method.

Binding Method	Spine Dimension (mm)	Spine Dimension (in)	Covers available	Cover Making equipment and materials available	Comments
Unibind	9.525	0.375	X		No modifications necessary. Side stitching improves sheet security in the adhesive.
ChannelBind	15.875	0.625	X		No modifications necessary. Side stitching improves sheet security in the binding channel.
Powis Parker	6.35	0.25	X		The spine of the book block should be stitched to ensure that the pages turn at the FlexBind™ hinge rather than at the binding edge.
ExactBind	6.35	0.25	X	X	Reduce grind depth to prevent damage to the FlexBind® hinge.
FastBind	6.35	0.25		X	Reduce grind depth to prevent damage to the FlexBind® hinge.
FastBind BooXter	6.35	0.25		X	No modifications necessary. Side stitching improves sheet security in the binding channel.
ODM-Super Sewer	9.525	0.375		X	Center sewing on the FlexBind™ spine, being careful not to tear the laminate in the gap.
Side-sewn	9.525	0.375			Center sewing on the FlexBind™ spine, being careful not to tear the laminate in the gap.
Side-stitched	6.35	0.25			Stitch 1/8" from edge, alternate sides when stitching to keep spine from curling.
Perfect Binding	4.7625	0.1875			Reduce grinding depth, follow recommendations from supplier for perfect binding FlexBind sheets
Smyth Sewn	not compatible				The pages are intentionally separated at the binding edge.
Library Binding	not compatible				The pages are intentionally separated at the binding edge.

Storage and Conditioning

Handling

Treat cartons with care. You may not even notice the damage until you have paper jams or other feeding problems. Avoid touching the toner/ink receptive hinged laminate area.

Climate Control

Store your cartons on shelves or pallets rather than right on the floor to avoid moisture absorption. Choose an area that's protected from extreme temperatures and humidity. Temperature and humidity are critical factors in how this product will perform in your printer. Most environments with air conditioning systems provide the proper mix of temperature and humidity. If you are in an environment that is not air conditioned, follow these guidelines:

- Ideal temperatures range 60°F/20°C – 76°F/24.4°C
- Ideal relative humidity range 35-55%

Do Not Open Until...

To achieve best results, leave sheets sealed in their original boxes, in the shipping carton. Do not open them until you are ready to load into your copier or printer. Why? The box has a protective wrap that guards against moisture absorption. Once you open it, the protective barrier is gone and moisture can seep in and cause excessive curl and other problems. Once you do open the package, store unused loose sheets in a resealable plastic bag. Do not store in your machine's paper trays.

Paper Conditioning

Make sure conditions are right for best results. Like any other high-performance, high-quality paper product, a little conditioning goes a long way. It can make the difference between adequate and excellent results. Digital printing is very sensitive to moisture in paper. Moisture can ruin your job in a hurry. High humidity causes damp edges and wavy paper. Low humidity dries paper edges and makes it contract and become tight. Poor performance is the result. As a rule, condition sheets for a minimum of 24 hours. Three to seven days is even better.

FlexBind® Products are not designed to be imaged on Ink-jet equipment. Test on printing and binding equipment before production runs.

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Get more information at www.FlexBind.com