



The Seaboard Advantage

At Seaboard Bindery, we have the knowledge, experience and production capabilities to help you turn great ideas into attractive pieces. Even the “simple” projects need advance planning to turn out properly. Involve us early in your project to be sure the final product meets both your demands and those of your clients.

Services offered:

Perfect Binding
Mechanical Binding
Saddle Stitching
Die Cutting
Folding
Film Laminating
Index Tabbing
Design & Planning
And More!

Paper Grain: So Small, But So Important

Managing paper grain direction in the bindery is very important to the overall appearance and quality of many printed projects. Common issues include cracking on the fold, folding registration, spine waviness (adhesive bound books) and tearing. The best way to overcome grain direction problems is to layout jobs so the major folds don't occur across the grain in the first place. When this isn't possible, scoring helps – especially if you're battling other factors like heavy coverage of dark ink.

Folding success depends on bindery expertise. In general, the heavier the paper, the more likely some kind of scoring will be needed. If you identify a job where cracking or other grain related production problems may be an issue, ask your bindery services partner for advice before applying ink to paper.

Common Scoring Options:

- *Press scores.* Helps on lighter weight sheets.
- *Folder scores.* Roto-crease and wet scoring are available as needs arise.
- *Die scores.* Die scoring (channel scoring) is the Cadillac of scoring. For difficult jobs, nothing less than die scoring should be accepted.

Put Scores The Right Way:



Cross Grain Adhesive Binding Issues:

Text: Perfect bound books with cross grain text can suffer from spine waviness and reduced page pull strength. Why? The combination of heat and added moisture during glue application expands the paper, but in bound books, pages have no room for expansion. 8-1/2" x 11" 16-pg forms on grain long stock have cross grain text. If the layout or grain direction can't be changed, then PUR glue may be necessary to bolster page pull strength.

Cover: Perfect bound covers with cross grain layouts are subject to unsightly cracking on the spine problems, especially if a lot of dark ink is used. Die scoring will greatly reduce this problem. Another step to consider is asking your ink supplier about adding elasticizers to your ink for flexibility.