



MEDIA GROUP

INSERT REQUIREMENTS – PERFECT BOUND - A4

| | | | |
|--|---|---|-----|
| Trim allowances (mm) | 210mm – 235mm | | |
| Head: | 310mm maximum section length. Trim equals (310-trim size-foot trim)=head trim. E.g. trim size is 297mm, (310-297-4)=9mm. | | |
| Foot: | 4mm | Foredge | 3mm |
| If head and foot allowance vary depending on knock direction, please clarify with as much detail possible: | | Knock direction can be determined by inserts, tip-ons | |

* Please confirm knocking direction with Bauer Production Services

| LOOSE INSERTS | | | | | | |
|--|---------|---------|---------|---------|--|---------|
| Trim width (mm): | 210 | 215 | 220 | 225 | 230 | 235 |
| Minimum size (mm): | 148x105 | 148x105 | 148x105 | 148x105 | 148x105 | 148x105 |
| Maximum size (mm): | 255x200 | 255x205 | 255x210 | 255x215 | 255x220 | 255x225 |
| | 2pp | 4pp | 8pp | 16pp | ITEMS (such as sachets, seed packs etc in grams) | |
| Min. weight at min size (gsm): | 115 | 80 | 60 | 45 | Testing Required | |
| Min. weight at max. size (gsm): | 115 | 80 | 60 | 45 | Testing Required | |
| Max. weight at min size (gsm): | 300 | 250 | 150 | 115 | Testing Required | |
| Max. weight at max size (gsm): | 300 | 250 | 150 | 115 | Testing Required | |
| Lead-time on booking a cover wrap: | 2 weeks | | | | | |
| CONSIDERATIONS: Folded inserts must have a closed edge to allow automatic feeding on the collator. Concertina of "Z" folds cannot be mechanically inserted. 20mm smaller on all 4 sides than trim size of product. Sachets and packets may require hand inserting. A sample MUST be supplied to Bauer Production prior to booking for confirmation if inserting. | | | | | | |

| BOUND INSERTS | | | | | | |
|---|----------------------|---------|---------|---------|--|---------|
| Spine Grind (mm - perfect bound titles only): | 3mm | | | | | |
| Trim width (mm): | 210 | 215 | 220 | 225 | 230 | 235 |
| Mini untrimmed size (mm): | 120x105 | 120x105 | 120x105 | 120x105 | 120x105 | 120x105 |
| Max untrimmed size (mm): | 310x215 | 310x220 | 310x225 | 310x230 | 310x235 | 310x240 |
| Min untrimmed card size (mm): | 120x105mm | | | | | |
| Min lap width for 4pp (mm) (2pp max width): | 18mm – Reverse Bound | | | | | |
| | 2pp | 4pp | 8pp | 16pp | ITEMS (such as sachets, seed packs etc in grams) | |

**WE THINK
POPULAR.**



MEDIA GROUP

2/2

| | | | | | |
|--|---------|-----|-----|-----|------------------|
| Min. weight at min size (gsm): | 115 | 80 | 60 | 45 | Testing Required |
| Min. weight at max. size (gsm): | 115 | 80 | 60 | 45 | Testing Required |
| Max. weight at min size (gsm): | 300 | 250 | 150 | 115 | Testing Required |
| Max. weight at max size (gsm): | 300 | 250 | 150 | 115 | Testing Required |
| Lead-time on booking a bound insert: | 2 weeks | | | | |
| CONSIDERATIONS: | | | | | |
| Roll fold and reverse bound inserts require an 18mm lap (includes 3mm spine grind) – Minimum stock weight is 100gsm. | | | | | |
| A sample MUST be supplied to Bauer Production prior to booking for confirmation if inserting. | | | | | |

| MECHANICAL TIP-ON | | | | | |
|--|--|-----|--|------|--|
| Minimum size (mm): | 65 x 45mm | | | | |
| Maximum size (mm): | 300 x 220mm – dependent on host product, Tip ons must be 30mm from all sides of the book and 30mm from the spine. | | | | |
| | 2pp | 4pp | 8pp | 16pp | ITEMS (such as sachets, seed packs etc in grams) |
| Min. weight at min size (gsm): | 115 | 100 | 60 | 60 | Testing Required |
| Min. weight at max. size (gsm): | 115 | 100 | 60 | 60 | Testing Required |
| Max. weight at min size (gsm): | 250 | 250 | 150 | 115 | Testing Required |
| Max. weight at max size (gsm): | 250 | 250 | 150 | 115 | Testing Required |
| If knocks to HEAD, (left or right page): | Right | | If knocks to FOOT, (left or right page): | | Left |
| Wet sachet testing requirements: | 2,200psi pressure test for 5 seconds and suitability to handle and feed mechanically followed by 5 hours under 1500psi | | | | |
| Lead-time on booking a mechanical wrap: | 4 weeks | | | | |
| CONSIDERATIONS: | | | | | |
| All tip ons must have a closed edge to allow for mechanical application. | | | | | |
| It is not possible to mechanically tip on a concertina fold or Z fold as these do not have a closed edge. | | | | | |
| Tip ons must be 30mm from all sides of the book and 30 mm from the spine. | | | | | |
| Maximum product thickness for a tip-on is 2.5mm. | | | | | |
| A sample MUST be supplied to Bauer Production prior to booking for confirmation | | | | | |
| These specifications are <u>generic guidelines</u> which were deemed correct at the time of publishing and may be subject to change and variation depending on magazine title. | | | | | |
| It may be possible to go outside the specifications for some titles. Please check if this is possible. | | | | | |
| Please refer to the Production Insert Delivery Requirements for further detail | | | | | |