



MEDIA GROUP

INSERT REQUIREMENTS – SADDLESTITCH - Quarto

| | | | |
|--|--|---|-----|
| Trim allowances (mm) | 195 x 235mm | | |
| Head: | 289mm maximum section length. Trim equals (289-trim size-foot trim)=head trim. E.g. trim size is 275mm, (289-275-4)=10mm. | | |
| Foot: | 4mm | Foreedge | 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): | 195 | 200 | 205 | 210 | 215 | 220 | 225 | 230 |
| Min size (mm): | 148x105 | 148x105 | 148x105 | 148x105 | 148x105 | 148x105 | 148x105 | 148x105 |
| Max size (mm): | 245x180 | 245x185 | 245x190 | 245x195 | 245x200 | 245x205 | 245x210 | 245x215 |
| | | 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): | | 100 | 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 standard, if 64pp sections please use 4mm | | | | | | | |
| Trim width (mm): | 195 | 200 | 205 | 210 | 215 | 220 | 225 | 230 |
| Mini untrimmed size (mm): | 150x105 | 150x105 | 150x105 | 150x105 | 150x105 | 150x105 | 150x105 | 150x105 |
| Max untrimmed size (mm): | 289x200 | 289x205 | 289x210 | 289x215 | 289x220 | 289x225 | 289x230 | 289x235 |
| Min untrimmed card size (mm): | 105x145mm – must float | | | | | | | |
| Min lap width for 4pp (mm) (2pp max width): | 10mm pick up lap – 2pp must have 125mm min lap | | | | | | | |

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| | 4pp | 8pp | 16pp | ITEMS (such as sachets, seed packs etc in grams) |
|--|---------|-----|------|--|
| Min. weight at min size (gsm): | 80 | 60 | 45 | Testing Required |
| Min. weight at max. size (gsm): | 80 | 60 | 45 | Testing Required |
| Max. weight at min size (gsm): | 250 | 200 | 115 | Testing Required |
| Max. weight at max size (gsm): | 250 | 200 | 115 | Testing Required |
| Lead-time on booking a bound insert: | 4 weeks | | | |
| CONSIDERATIONS: | | | | |
| Minimum sizes include 4mm head or foot allowance (head or foot trim depending upon whether the product knocks to the head or the foot). | | | | |
| Maximum sizes include 4mm head trim allowance and 10mm foot trim allowance and 5mm fore edge trim allowance. If knocking to the foot, the foot trim will be 4mm, and head trim will be 10mm. | | | | |
| Bound inserts require a closed head or foot relative to knocking direction and a 10mm binding lap. | | | | |

| MECHANICAL TIP-ON | | | | | |
|--|--|-----|--|------|--|
| Minimum size (mm): | 85 x 55mm | | | | |
| Maximum size (mm): | 210mmx140mm – must be smaller overall in width & 60mm smaller in height. | | | | |
| | 2pp | 4pp | 8pp | 16pp | ITEMS (such as sachets, seed packs etc in grams) |
| Min. weight at min size (gsm): | 115 | 100 | 65 | 55 | Testing Required |
| Min. weight at max. size (gsm): | 115 | 100 | 65 | 55 | 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 |
| 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 | | | | | |

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