

# The World of Bookbinding.



## Sheeting and slitting service

Your cloth should be precut in strips of the desired height or the roll should be slit in half?

You would like to receive grey board or paper in ready-cut sheets?

No problem - we may cut cloth, paper and board according to your requirements at low costs!

Just let us know the format required stating the grain direction (long or short grain), and we will get in done!

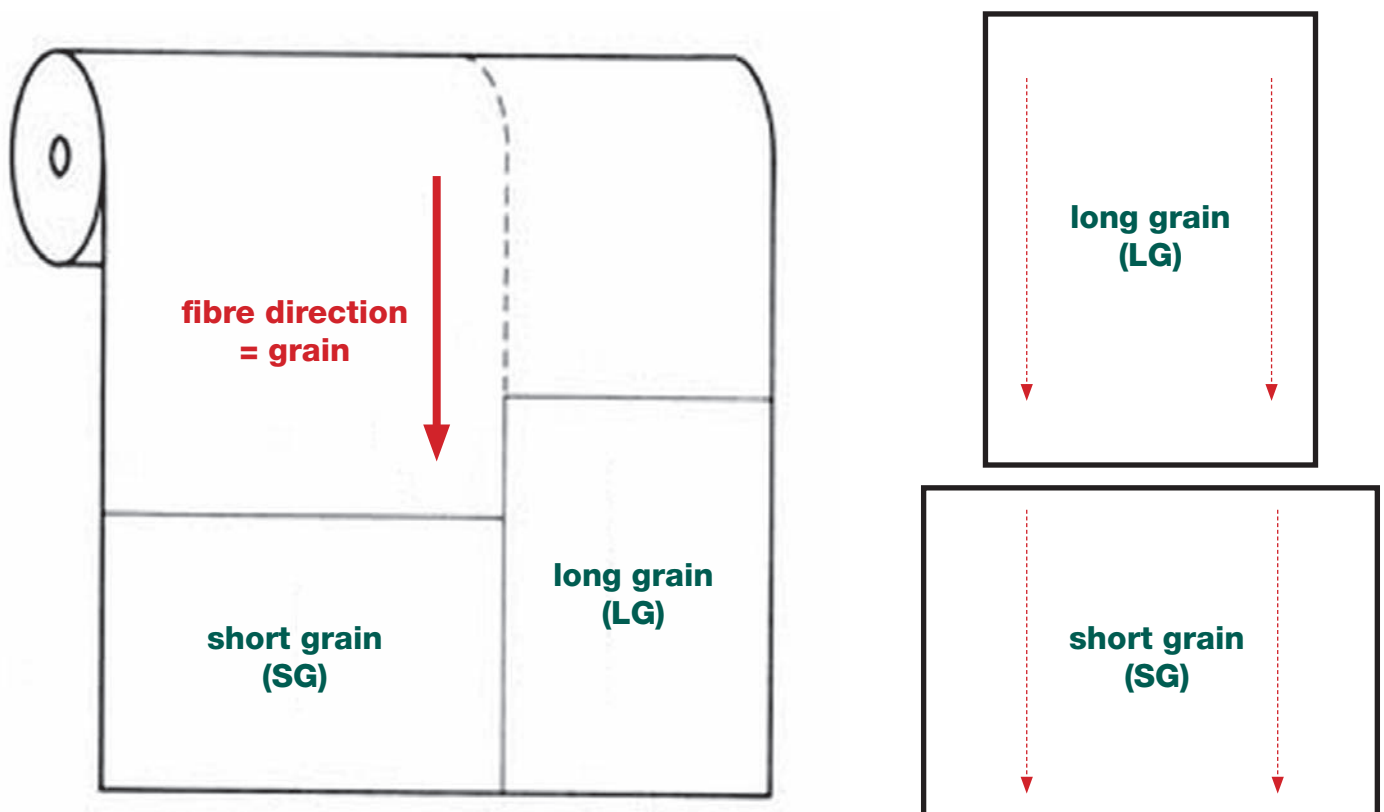
### What does grain direction mean and why is it so important?

During the industrial production of papers and/or cloth with paper backing, the fibres orient towards the direction of production, the so-called grain direction. Papers manufactured that way expand less in the grain direction than across the grain direction. Moreover, they may be bent more easily in grain direction.

When producing books, the fibres, i.e. the grain direction, should always be parallel to the book spine to avoid fluting and to improve the opening of the book. It is also important in the processing e. g. when folding. The grain direction should always be parallel to the foldout.

There are two different grain directions: long grain (LG) and short grain (SG).

In case of long grain, the fibres run parallel to the longer side, in case of short grain parallel to the shorter side.

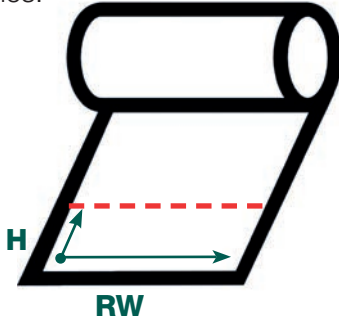


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## Sheeting and slitting service

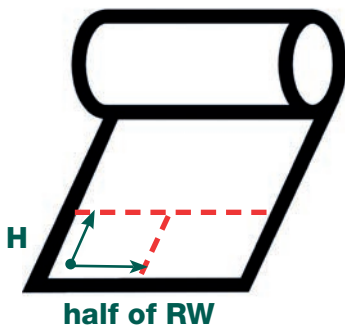
### Cutting rolls or sheets

Cloth, paper, grey board (up to 2.5 mm thickness) etc. in rolls or sheets may be cut as per the following examples:



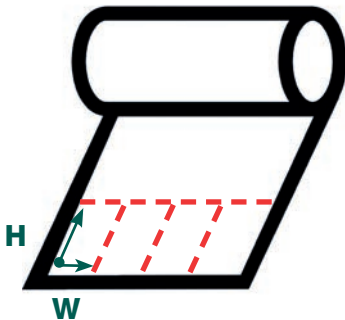
Cut rolls into strips

$H = \text{height required} \times RW = \text{roll width}$



Cut rolls into strips and cut the strips in half

$H = \text{height required} \times \text{half of RW} = \text{roll width}$

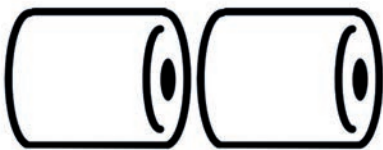


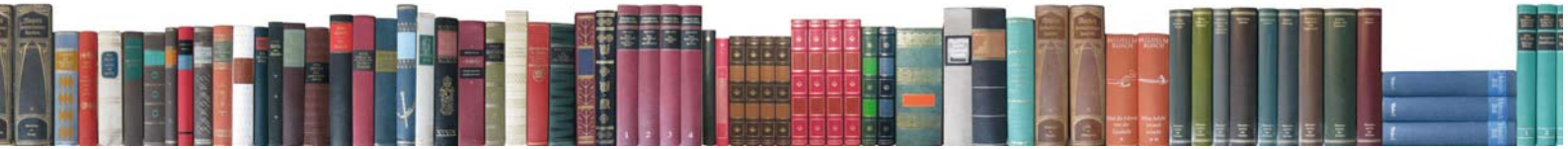
Cut rolls into precut sheets

$H = \text{height required} \times W = \text{width required}$   
(+ state grain direction, see previous page)

### Slitting rolls

Cloth or paper rolls may be slit into two, three, four etc. narrow rolls, either of the same width or according to your specifications.





## Sheeting costs for rolls into strips or precut sheets

|  |  |
|--|--|
| Cut rolls into strips (height required x roll width)<br>Machine setup charge for quantities < 1 complete roll  | EUR 0,20 / lin. metre<br>EUR 5,00 lump sum   |
| Cut rolls into strips + cut strips in half<br>height required x half of roll width<br>Machine setup charge for quantities < 1 complete roll                                    | EUR 0,23 / lin. metre<br>EUR 5,00 lump sum   |
| Cut rolls into strips + cut strips in 3 parts<br>height required x roll width divided into three<br>Machine setup charge for quantities < 1 complete roll                      | EUR 0,25 / Meter<br>EUR 5,00 lump sum  |
| Cut rolls into precut sheets (1 grain direction)<br>for quantities 1 - 9 m per colour<br>for quantities 10 – 49 m per colour<br>as per 50 m per colour<br>Machine setup charge | as per expenditure of time: EUR 5,95 / 5 min.<br>EUR 20,00 lump sum<br>EUR 0,30 / per lin. metre<br>included |
| <i>The prices stated are valid for a <u>minimum sheet size of DIN A4</u>. Smaller sizes are invoiced based on expenditure of time.</i>   |  |
| <i>When ordering precut sheets, please always state the grain direction (short grain or long grain) required!</i>  |  |

## Slitting costs for rolls

|  |  |
|--|--|
| Roll slit 1x (halved)<br>Machine setup charge for quantities < 1 complete roll     | EUR 0,10 / lin. metre<br>EUR 5,00 lump sum |
| Roll slit 2x (cut into 3)<br>Machine setup charge for quantities < 1 complete roll | EUR 0,12 / lin. metre<br>EUR 5,00 lump sum |
| Roll slit 3x (cut into 4)<br>Machine setup charge for quantities < 1 complete roll | EUR 0,14 / lin. metre<br>EUR 5,00 lump sum |
| Roll slit 4x (cut into 5)<br>Machine setup charge for quantities < 1 complete roll | EUR 0,16 / lin. metre<br>EUR 5,00 lump sum |
| plus 2 Cents / lin. metre for each further cut                                     |  |

## Miscellaneous

|   |                   |
|---|-------------------|
| Rewinding a master roll<br>(e. g. one 50 m roll into 2 rolls of 25 m) | EUR 4,00 lump sum |
|---|-------------------|

Pricing: The prices stated are net prices, without taxes.

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