

## **Case Binding Flatback**

### Textblock Prep + Sewing

1. Fold and cut 4-6 sections of text weight paper
2. Fold and cut 2 single folio endsheets
  - a. Cut to the EXACT height of the textblock
  - b. Cut to the EXACT width of the textblock
3. Make a template cut the the EXACT height of the textblock and prepped for the link stitch sewing
  - a. Make sure your first and last stations are between 1/2" and 5/8" from the head and tail
4. Punch holes in your sections but NOT in your endsheets
5. Sew your textblock using the link stitch but WITHOUT the endsheets
  - a. Start on the OUTSIDE of the textblock at the FIRST sewing station
  - b. To end, kettle and then kettle again between the two sections down from your first kettle
6. Tip your first and last sections to your second and second to last sections with a 2mm strip of PVA
7. Tip your endsheets to your first and last sections with a 2mm strip of PVA

### Consolidation

1. Place textblock between boards wrapped in wax paper
2. Jog to the head and spine of your textblock
3. Place under weight and check alignment with your L-square
4. Paste up with PVA/methyl mix (paste instead of PVA makes this step reversible)
5. Leave under weight until the spine has dried completely

### First Spine Lining

1. Prep a spine lining of Japanese paper by scoring with your awl and straight edge and peeling
  - a.  $H = H \text{ of spine} - 1\text{mm}$
  - b.  $W = W \text{ of spine} + 4\text{-}6\text{mm}$
2. Place textblock and boards into the finishing press or between two C-clamps
3. Glue out the paper with PVA/methyl mix (paste instead of PVA makes this step reversible)
4. Place paper on spine and stipple into place with a dry brush
5. Leave in press until dry

## **Case Binding Flatback (continued)**

### Endbands

1. Stiffen a piece of sewing cord
2. Wrap with cloth, grain parallel to the cord
3. When completely dry, cut two pieces to the EXACT width of the spine, from shoulder to shoulder
4. Cut endband height as follows
  - a. Allow the endbands to sit snugly on the head and tail of the textblock
  - b. Remaining cloth should be cut to rest against (but NOT on top of) the kettle stitches
3. Adhere endbands to the textblock using PVA applied directly to the spine

### Flange

1. 1. Prep a flange of Japanese paper by scoring with your awl and straight edge and peeling
  - a. H = H of spine from kettle to kettle
  - b. W = W of spine + 2"
2. Place textblock and boards into the finishing press or between two C-clamps
3. Glue out spine with PVA/methyl mix
4. Center flange onto spine and stipple into place with a dry brush
5. Leave in press until dry

### Final Spine Lining

1. Prep a final lining of 70 lb western paper by cutting to the following dimensions
  - a. H = H of spine from middle of endband to middle of endband
  - b. W = W of spine from shoulder to shoulder
2. Place textblock and boards into the finishing press or between two C-clamps
3. Glue out spine with PVA/methyl mix
4. Center final lining onto spine and bone down vigorously using a layer of wax paper to protect spine
5. Leave in press until dry
6. Check restraint and adjust if needed by adding one more lining (Japanese or lighter-weight western paper)