

The sequence of operations

Preliminary work

- 1** Open a day-book for the job 15
- 2** Measure the text-block 16
- 3** Make up new book boards (oversize) 17
- 4** Collate the book 23
- 5** Pull the book (if necessary) 24
- 6** Make a card template of the positions of the old sewing holes (for later use: **15–16**) 29
- 7** Guard the backs of the sections and do paper repair as necessary (wheat starch paste) 30
- 8** Measure the page spread (to establish how much paper you will need for endpapers) 32
- 9** Make paper templates for the size of the cover, the doublures and the leather joints in order to select skin(s) of the correct size 33
- 10** Select the materials 35
- 11** Cut out the piece of leather that you need for the leather joints in the endpapers 37

Making the leather-jointed endpapers

- 12** Make the leather-jointed endpapers (oversize) 39
- 13** Trim the endpapers to the same size as the text-block 43

Edge treatment

- 14** Rough-edge gilding 47

*If you are using a loose guard (see **18**) around the first and last sections, you should include a sheet of the appropriate paper, cut to the same length as the text-block, with the text-block during the gilding process. You will cut the guards from that sheet once its edges have been gilded.*

*If solid edge gilding or gilding in the rough is being done, this should be executed at **28**. See the rationale for different types of gilding and the different stages at which each is done to check what is appropriate in your case.*

Preparing for sewing and sewing the text-block

- 15** Using the template that you made at **6** as a reference, decide on the position of the sewing stations, the type of sewing and number and type of sewing supports. Mark up the template accordingly 59

- 16 Mark up the text-block for the sewing stations 61
- 17 Using the template, pierce holes at the sewing stations (ensure you have the endpapers the correct way around) 62
- 18 Put in place the loose guards around the first and last sections of the text-block 64
- 19 Set up the sewing frame 65
- 20 Sew the text-block: the first and last sections and the endpapers should be sewn 'all along'. Remove the text-block from the sewing frame 67
- 21 Tip the endpapers to the loose guards 71

Rounding and backing

- 22 EVA the spine: *do not* apply it over the sewing supports 73
- 23 *Backed books only*: mark the depth of the joint along the shoulder of the text-block 75
- 24 Round the text-block 75
- 25 Back the text-block (if appropriate) 77
- 26 EVA the spine again, this time going over the tapes 81
- 27 Trim the fore-edge of the waste and compensation sheets of the endpapers to the same width as the text-block 81
- 28 Solid edge treatments such as gilding or colouring, or gilding in the rough, should be done now (see 14) 83

Preparing the book boards

- 29 *Rounded only books*: bevel the spine edge of the inside face of each board at a steep angle to fit the round of the text-block 85
- 30 Cut the book boards to size 86
- 31 Tip joint-spacers along the joints of the text-block 89
- 32 Mark up the outside of the book boards for lacing on to the text-block 91
- 33 Mark up the outside of the boards for chamfering 92
- 34 Chamfer the three outside edges of the boards – fore-edge, tail, head, in that order 93

Lacing on the book boards

- 35 Lace on the book boards; insert barrier sheets and leave to dry between lightly weighted pressing boards 97

Sewing the endbands (headband and tailband)

- 36 Sew the endbands 101
- 37 Cap-up the text-block 110

Spine linings

- 38 Line the spine, but do not put on the hollow back yet (if one is appropriate) 113
- 39 Trim the core of the endbands to the exact width 117
- 40 Make and put on the hollow-back (if one is appropriate) 119
- 41 Trim the hollow-back to the exact length 122

- 42** Make an exact size paper template for the covering leather and near-exact templates (5mm all round) for the doublures 123
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Setting the slips (tapes)

- 43** Prepare the book boards for setting the slips (tapes) 127
44 Set the slips (tapes); remove the cap, leave between weighted pressing boards for approximately one hour 129
45 Cut out and mark up the leather for the cover 131
46 Remove the book from the weighted pressing boards, cap-up the text-block 133
47 Line the outside of the boards, remove cap and put in press or between weighted pressing boards 133
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Paring the cover

- 48** Pare the covering leather for the book 137
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Preparation for covering

- 49** Cap-up the text-block (if not done already) 151
50 Sand the book boards 151
51 Back-corner the spine edge corners at the head and tail of the boards 152
52 Slit the hollow-back (if appropriate) 154
53 Cut away the 'on' layer of that part of the hollow-back which protrudes beyond the end of the endbands 155
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Covering

- 54** Cover the book. Leave to dry under weight, ideally overnight (cap off, 0.5mm pressing sheets in) 159
55 Controlled opening of the book (and the hollow-back, if appropriate) 167
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Putting down leather-jointed endpapers

- 56** Put down the leather joints 171
57 Apply onlays or inlays that turn over the board edge 180
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Preparing the ground for doublures

- 58** Fill-in on the inside of the book boards 183
59 Cut out and pare the leather for the doublures and pare onlay leather 186
60 Cap-up the text-block 188
61 Put in the overall lining on the inside of the boards 188
62 Cut out and pare the leather for the doublures and pare onlay leather (if not done at **59**) 190
63 Tooling/onlay/inlay work 190
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Preparing and putting in leather doublures

- 64** Cut to exact size and prepare the edges of the doublures 193
65 Put in the doublures 197