

Guidelines For Normal Spoilage Allowances



Inserters/Stitcher/Trimmer

(normal job on paper stock of 45# coated up to 100# coated)

NUMBER OF POCKETS	PERCENT OF FINISHED COUNT	SIGNATURES FOR MAKE READY
1	2%	500
2	2.5%	500
3	2.75%	500
4	3%	500

Additional percentages required:

- 1.5% for one-up oblong book
- .5% for all two-up jobs
- 2% for 4 page signatures 50# book weight or less
- 2% for jobs on uncoated of stock less than 45#
- .5% for each 8 page signature
- 1% per vacuum fed sheet

On A Flat Cutter

.5% per 1000 finished pieces

Additional percentage required: .25% additional allowance for stock with remoistenable gum strip

For Buckle Folders

Make ready/set up:

- 1" of stock for each folder,
- + 1% of the finished pieces

Additional percentage required:

.5% of the folded finished pieces for each additional folding machine section used whether used in parallel or right angle

The following will increase basic spoilage:

(please consult your finisher)

- Curly stock • Lightweight stock (less than 45# uncoated)
- Gluing or pasting • Small or close to fold perforations
- Postage stamp-type perforations • gatefolds

Counter Cards (Mount paper to chipboard or foamcore)

QUANTITY	CARD ONLY (NO EASEL)	CARD WITH EASEL ON BACK	CARD WITH EASEL AND TAKE-ONE BOX
under 1M	20%	25%	35%
1M-5M	15%	20%	25%
5M-25M	12%	15%	20%
25M-100M	10%	12%	15%
over 100M	8%	10%	12%

Notes: Please print on 80# coated text with varnish. If UV Coated, Film Laminated, please use 100# coated text.

For Perfect Binding

QUANTITY	SET UP	SPOILAGE	6-16's:
under 1M	10%	10%	
1M-5M	100 pieces	5%	.25% per additional form
5M-10M	100 pieces	4%	
over 10M	100 per set up	3%	

The following will affect spoilage: (please consult your finisher)

- Lightweight stock (less than 45# uncoated) • 6- and 8-page covers • Uncoated 2-, 4-, & 8-page signatures
- Short forms • Fold-out forms

Mechanical Binding

Same spoilage as Perfect Binding plus 2%

Case Binding

Same spoilage as Perfect Binding plus 100 copies of the first and last signatures.

Smyth Sewing

Same spoilage as Perfect Binding if heads are closed and or signatures have consistent high folio lip. Increase spoilage rate 25% for lightweight stock or signatures with no lip.

For Book Blocks

QUANTITY	PERCENT SPOILAGE
1M	13%
2M	9%
3M	7%
4M	7%
5M	6%
10M	5%
15M	5%
20M	4%
25M	3%

Pocket Folders (Please leave all glue areas free of ink and coatings)

	UNDER 5M	5M-25M	25M-100M	OVER 100M
1 OR 2 REG. FLAT POCKETS	15%	12%	10%	6%
1 FLAT & 1 CAPACITY POCKET	20%	12-15%	10%	8%
1 OR 2 CAPACITY POCKETS	15%	10%	8%	6%
1 VERTICAL FLAT POCKET	15%	10-12%	8-10%	6%
2 VERTICAL FLAT POCKETS	20%	12-15%	10%	8%
1 FLAT VERTICAL & 1 FLAT HORIZONTAL POCKET	20%	12-15%	10-12%	8-10%

These guidelines were assembled by the Binderies and Finishers of The Printing Industry of the Maryland to assist customers in planning their printing production – allowing sufficient overruns to enable the finisher to deliver full counts. These guidelines do not represent every job so please consult your finisher in unusual circumstances.

The following factors could adversely affect the guidelines:

- Condition of material as it is packed on pallets or skids going to finishing operations.
- Stock curl • Kind and weight of paper • Numerous lots or codes

Helpful Hints:

- Planning between the Binder and the Printer from the original concept, delivers the best price, quality, and on time delivery.
- Print the first and last signatures first. Keep them on a separate skid, mark them clearly, because nothing happens to a case bound book until the end sheets are attached to the first and last signature.