

Bookbinding - Pamphlets & Variations

Single Section Bradel Binding

A more sophisticated take on the Rigid Board Pamphlet Binding. This case binding results in a hardback cover with a square spine, providing rigidity and protection to the contents with an elegant finish that opens flat.

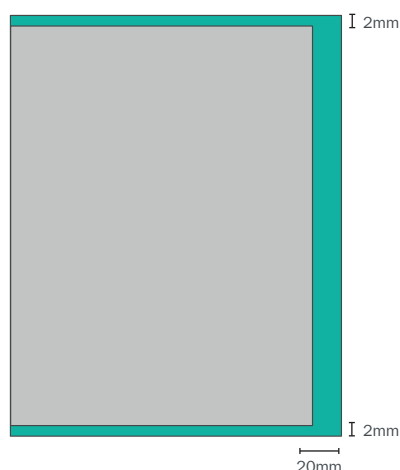
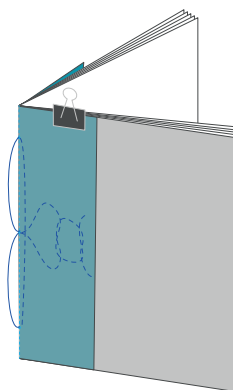
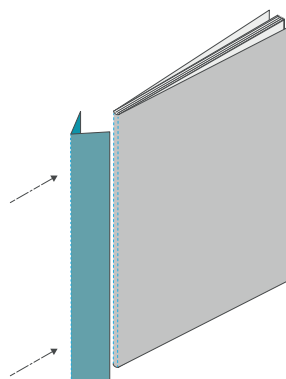
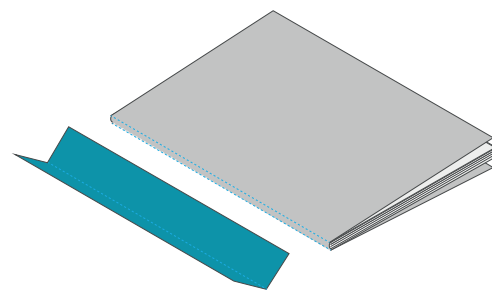
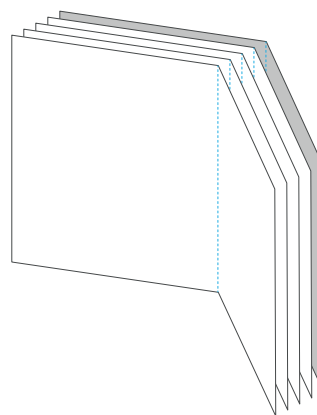
The Bradel is a paper hinge typically used to attach the cover boards and spine in German bindings. It provides a stronger joint at the spine and makes the case easier to assemble and attach. The book-block consists of a single section (signature) of folded pages and a coloured end paper (folded) which is then sewn together with a strip of book cloth using the pamphlet stitch.

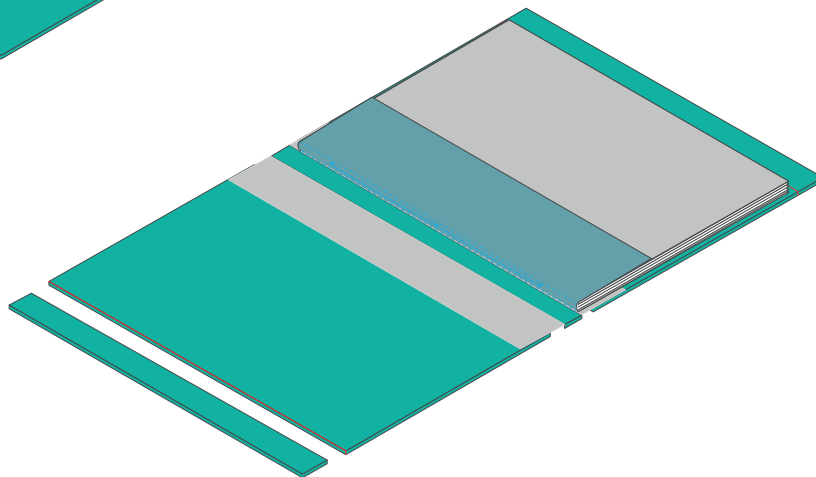
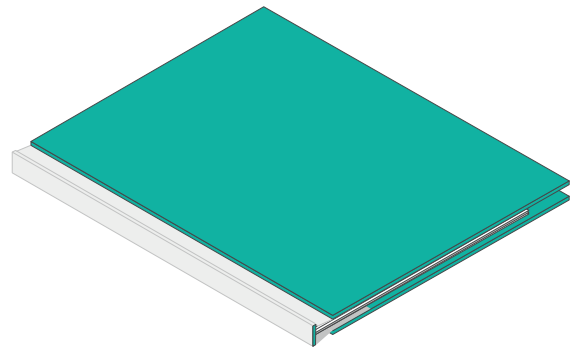
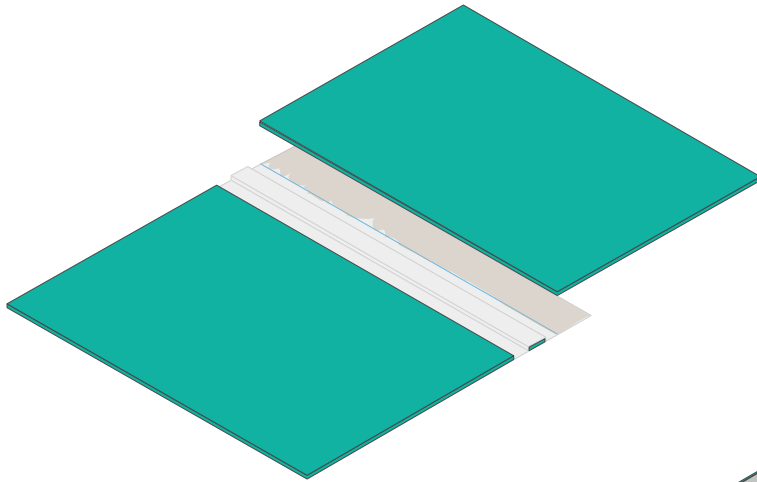
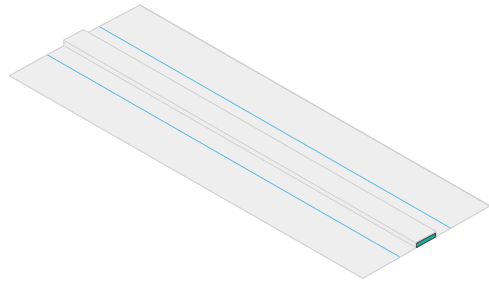
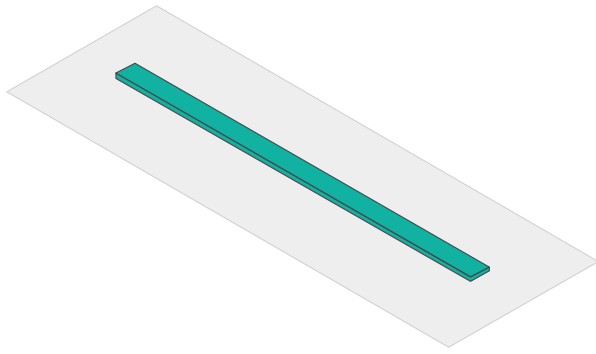
This binding is suitable for books up to 20cm in height and consisting of up to approx. 64 pages.

01. Fold the pages and gather them together ensuring they are in the correct sequence. Add the folded colour endpaper as the outer most sheet.
Ensure the paper grain is running parallel to the spine on all the paper.
02. Cut a strip of bookcloth to the height of the folded pages and approx. 8cm wide for the cloth hinge. Fold it in half so the good side faces in.
03. Nest the folded pages into the cloth hinge and punch five holes through the spine fold. Five holes is suitable for books up to A5 in size, for taller books use 7, 9 or 11 holes.
04. Sew your pages as you would a Five-hole Pamphlet, starting the stitch on the inside of the pamphlet then press the section under light weight to ease the folds.
05. Trim the section on the fore-edge, then head and tail to the desired size.

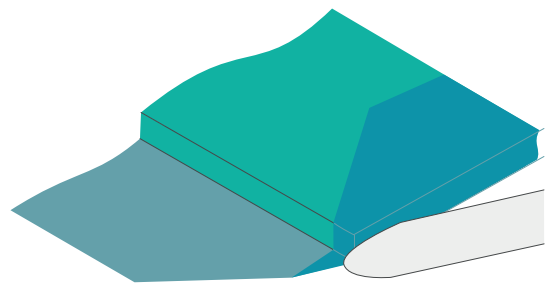
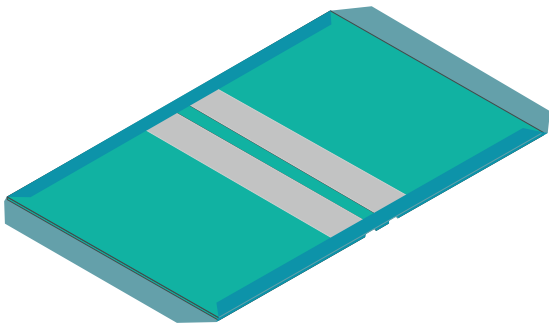
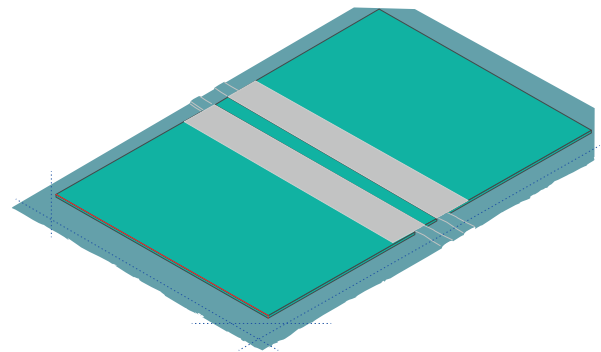
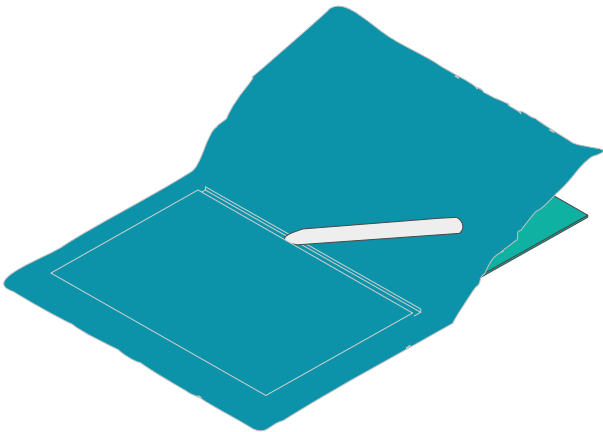
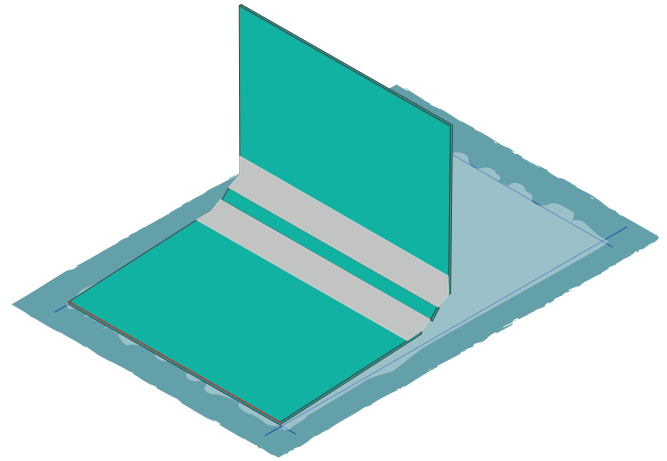
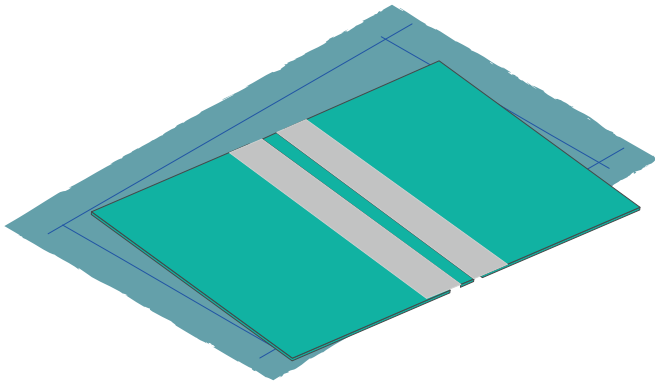
The case is comprised of a set of boards attached by a paper hinge, then covered by a sheet of book cloth. When preparing the boards it is essential the grain direction runs parallel to the spine in all the materials used and that they are cut accurately and to the necessary size.

06. Measure and cut your covers, from greyboard, to size allowing an extra 2mm at the head and tail and, at the fore-edge adding an extra 20mm (this excess is trimmed to size later).
07. Cut a piece of greyboard for the spine the same height as the cover boards. Calculate the width of the spine by adding the thickness of the two cover boards to the thickness of the book-blocks spine minus 1mm and cut accordingly.

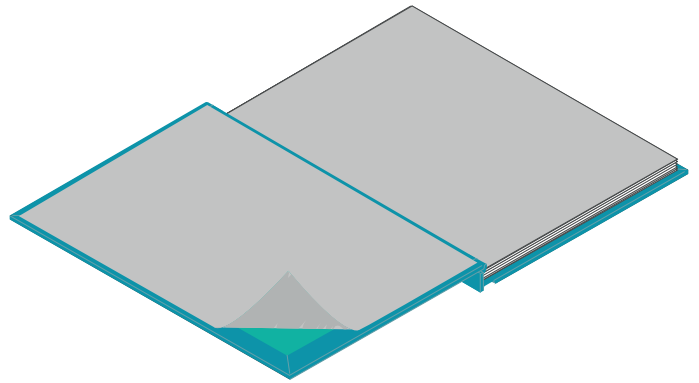
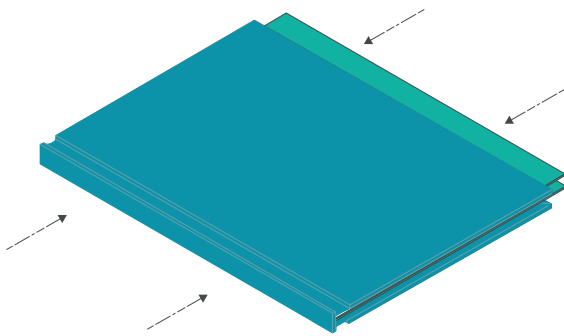
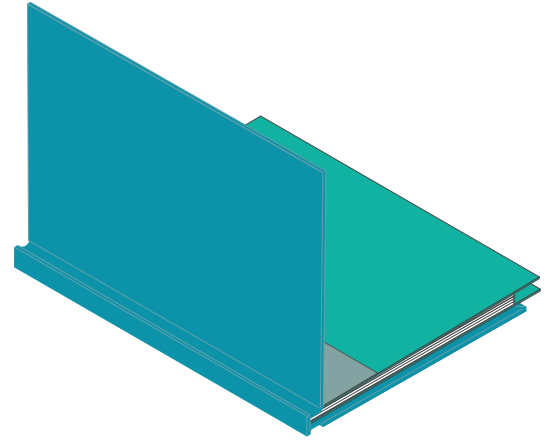
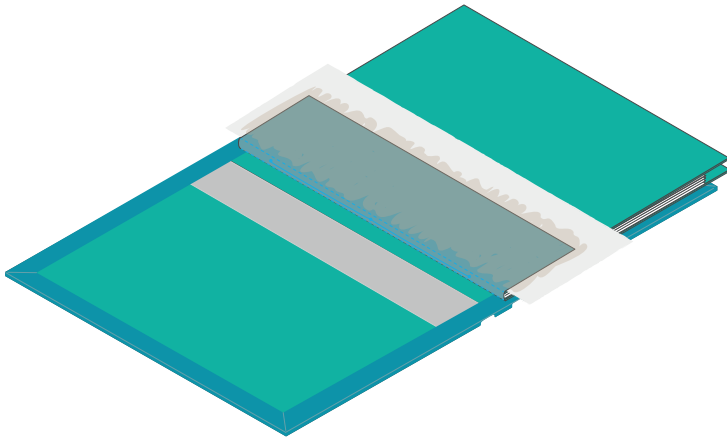




08. Cut a piece of strong paper 10cm wide and approx. 3cm taller than the spine piece, ensure the grain is running parallel to the spine. Glue the spine piece down into the centre of the paper and rub down with a bone folder.
09. Trim the excess from the head and tail. Flip the spine over and form the paper hinge around the sides of the spine to create a tight fold.
10. Measure out 7mm from the spine on each side drawing a line parallel to the spine. Use the width of a ruler to trim the excess paper parallel to the spine to form a tab.
11. Glue out the side edge of each board and attach to the paper tab leaving the 7mm gap for the joint. Place the cover under light weight and leave to dry.
12. Once dry, place the book-block in the cover boards pushing it tight against the spine and aligning the squares at the head and tail.
13. Carefully open the front cover and while holding the book-block in place measure and mark the 3mm square on the fore-edge.
14. Close the cover again, and flip over. Open the other cover and measure and mark the square on that fore-edge in the same manner.
15. Remove the book-block and trim the fore-edge of the cover boards to the square, ensuring the cut is perpendicular to the head and tail.



16. Cut a piece of bookcloth allowing 30mm turn-ins around the board assembly. With the bookcloth face down, position the cover boards so there is a 30mm margin on all sides and lightly draw around the boards.
17. Apply glue evenly to the outlined area, tip one of the boards into place on the bookcloth, carefully flip the bookcloth and boards over while keeping the spine and other board clear.
18. Ensure the board is adhered to the bookcloth all around the edges before working it down into the joint, rubbing down firmly with a bone folder.
19. Rub down the bookcloth over the spine and work it into the next joint before rubbing it down over the final board.
20. Trim the bookcloth to leave 20mm of turn-in on all sides. Cut the corners of the bookcloth at 45° leaving a 3mm gap from the corner of the boards.
21. Glue the turn-in at the head and tail wrapping them around the boards ensuring you achieve tight creases where it folds over the boards, rub down the cloth into the joint again forming the bookcloth around the boards.
22. Pinch the bookcloth around the board at the corners, then glue the turn-ins at the fore edge and rub down well.
23. Leave the case to dry under a weight before the next stage of 'casing-in' the book-block. This will help to keep the case flat.



In the final steps, casing-in boards are used to push the book-block back into the case and force the cloth hinge up against the inside of the case so that it fully adheres without leaving a hollow in the spine.

24. Cut a pair of casing-in boards from 1mm greyboard. These should be the same height as the section and about 20mm wider. Place these either side of the book-block inside the cloth hinge.
25. Position the book-block inside the case ensuring the squares are correct. Slide a piece of waste paper between the casing-in board and cloth hinge. Glue out the cloth hinge.
26. Remove the waste and then carefully close the case, pushing the spine of the case up vertical before dropping the cover down into place..
27. Flip it over, open the case on the other side and glue the cloth hinge on this side as well as applying glue to the spine of the book-block.

28. Close the case push against the casing-in boards to make sure the cloth hinge is well adhered to the inside of the case, open the case slightly, remove the casing-in boards and use a bone folder to rub down the cloth hinge in the joints.
29. Place wax paper between the book-block and case on both side and nip the case for an hour between a set of boards with knitting needles to help form the joints.
30. Cut 2 paste downs from the same paper as used for the endpaper. These should be the same height as the book-block and go from the inside edge of the boards and be the same width as the book-block.
31. Glue out of the paste downs and place in position on the inside of the boards, using a bone folder to smooth them out. Replace the wax paper between the paste downs and book-block and leave to dry for at least an hour but, preferably overnight.