



STAMPING DIE SPECIFICATIONS FOR HARDCOVERS AND PAPERCOVERS

- Manufacture the die to have a base thickness of 1/4 inch and a minimum stamping depth of 3/64 inch. Proper die depth is essential for clear, non-plugged stamped images.
- Cut the metal as close as possible to the stamping portion of the die so that the excess border or dead metal does not exceed 1/8 inch. On very small dies, such as for ISBNs and logos, a minimum 3/16-inch shoulder above and below the image is required, however.
- Rout large areas of dead metal an additional 1/16 inch.
- Make all edges of any lettering, rules or design straight, not beveled.
- Provide one die per color for each section of the book (spine, front cover, and back cover) to allow for proper alignment in case of paper bulk variances as well as for reuse for multiple set stamping.
- Select the proper metal for die on the basis of expected use. Use copper or brass dies for all panel dies, titles which are expected to reprint, and all bind quantities over 2500. Magnesium is appropriate for type-only dies with short run lengths.
- Include a layout with your stamping order which carefully defines color and placement.
- Design panel dies that will have the borders overstamped by a rule to be slightly smaller than the overall stamped area. Reduce the panel size by one-half the thickness of the overstamping rule on each dimension. For example, if the overall area is to be a 4-inch square which includes a 1/8-inch rule, the actual panel die would be a 3-7/8-inch square.
- Reference the component layout sheet for hardcover books to determine the maximum width for hardcover spine dies. For papercover books, the die width for the spine must be at least 1/8 inch less than the bulk of the book block. For example, a stamped papercover for a 1-inch book block may have a die that is no larger than 7/8 inches in width.
- If supplying an electronic file for the die image, please use a recent version of Adobe Acrobat or Adobe Illustrator software.
- Contact your Customer Service Representative to determine when dies are needed at the manufacturing plant to maintain your binding schedule or for additional information.