

# tipping specs



Royle Printing has the versatility to tip three signatures together, or two signatures and a card, or cards can be applied to both sides of a signature.

Please contact your CSR for testing if the tip-ons and/or host do not fit in these specifications.

## Main/Host

Minimum size: 6" - Backbone to Face  
7" - Head to Foot  
Maximum size: 12" - Backbone to Face  
16" - Head to Foot  
Minimum thickness: single sheet card stock .007  
single sheet 80# book wt.  
Maximum thickness: 1/2"

## Tip

Minimum size: 6" - Backbone to Face  
4" - Head to Foot  
Maximum size: 12" - Backbone to Face  
16" - Head to Foot  
Minimum thickness caliper: 0.0035 - 80# book wt.

## Glue Options

Fugitive glue – This glue is peelable glue, which will allow the insert or card to be removed from the main (or host) piece.

Standard glue – This glue is a permanent bond between the tipped sections.

## Tipping Process Specs

Live matter must be 1/2" less than the final trim size of a book.

6 page inserts must be supplied as a closed gatefold or requires the single sheet be glued into the center spread of the insert.

Perforations must not exceed 50% of the linear dimension and should be at least 1/2" from the gutter edge in order to insure the ability to run.

Minimum and maximum stock weights for tips:

4pg tips – Minimum 40# book wt.  
Maximum 80# book wt.

Up to 8pg tips – Minimum 40# book wt.  
Maximum 80# book wt.

Up to 16pg tips – Minimum 40# book wt.  
Maximum 70# book wt.

Above 16pg tips – Minimum 40# book wt.  
Maximum 70# book wt.

Note: Tips must be smaller than the host piece.

## Spoilage

The quantity of tips (inserts) supplied for each issue should be no less than 5% above the print order.

## Gimmicks

Inserts with special effects (die cuts, rough surfaces, etc.) can be tipped to the front of the signature only. Any variations are subject to prior approval.

Note: Gimmicks may incur an additional charge.

Please contact your CSR for final approval before production.