

Stand 02.2026

Quality Guideline - Printed Edges

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Printed Edges

- Data delivery is carried out using ICC profile Fogra 30 for yellowish printing paper without optical brighteners (if using other papers, see data delivery guidelines).
- Since the cut edges of the book are printed, it cannot be ruled out that dust particles may be present on the surface due to the nature of the process, which may cause disturbances in the print image.
- Due to medium print resolution (600 dpi), there may be design-related deviations and limitations in font reproduction.
Our recommendation: font size at least 10 pt.
- The minimum line thickness should be 0.5 mm, otherwise lines will be barely visible. (See example on p. 15)
- The minimum element size should not be less than 0.5 mm, as otherwise it may blur with other objects. (See example on p. 16)

Paperbacks / Paperback w/ flaps

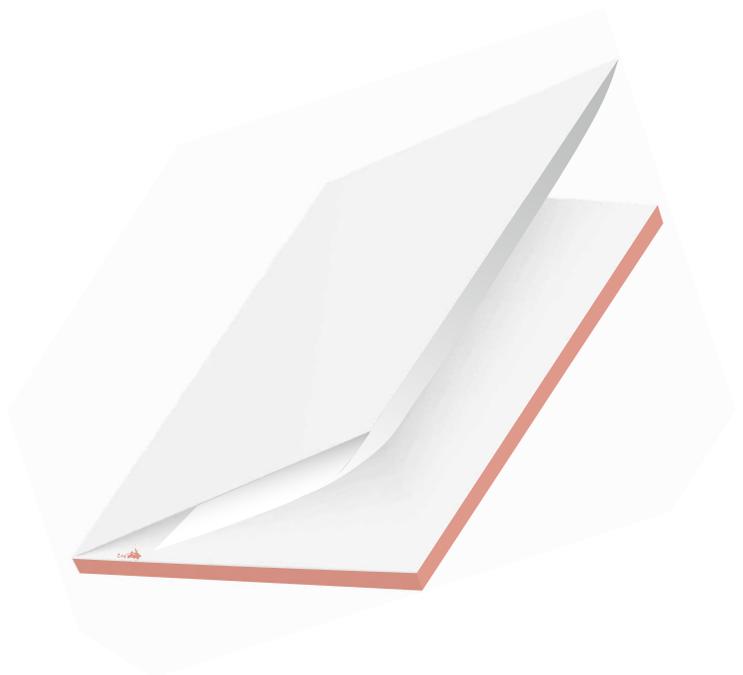
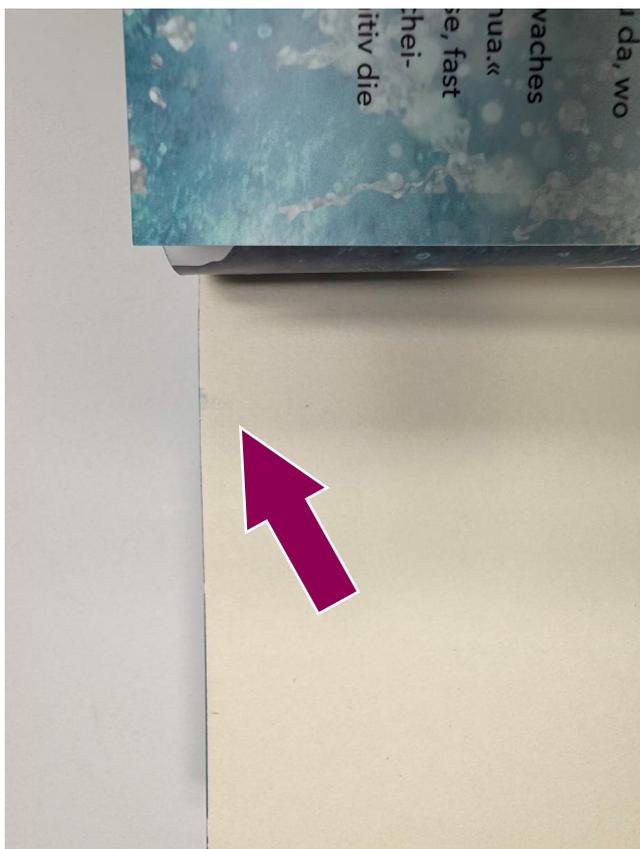
- Flaps must be flush.
- The flaps protrude slightly beyond the content block. This can cause ink residue to appear on the flap protrusions on the inside of the BU.
(See example on p. 8)
Our recommendation: Color design of the inside covers in the edge color (background printing) and no important text elements in the flap area.
- It is not possible to remove color residues on uncoated paper after printing. (See example on p. 6)
- Light color and dirt deposits may be visible on light-colored covers, unlike colored covers. (See example on p. 7)
- On paperbacks w/ flaps, the trimmed edge of the cover and the flap are not printed. The trimmed edges of the book block are fully printed.
(See example on p. 9)
- Ink deposits may appear on the first and last pages of the contents, as ink can get onto these pages through the small gap between the flap edge and the cover. (See example on p. 5)

General:

- Paperback covers/ paperback covers w/ flaps that are not coated with a matte or glossy film or finished with a soft-touch film may show ink residue on the covers.
- Color mist may cause smudges on the covers as well as on the first and last pages of the text.
- With both single-sided or double-sided printed edges, the ink mist sprays onto the unprinted sides. The darker the design, the more visible small dots appear on the unprinted sides.
(See example on p. 17)
- Yellowing of the text paper may lead to deviations in color fastness
- Image sections produced with paper that differs from the text paper can have a negative effect on the color edge, as the papers have different color acceptance properties. (e.g., 115 gsm image printing paper)
(See example on p. 10)
- The following points be noted when designs spill over across several books:
 - All print data must be identical and created in accordance with prepress specifications, as otherwise there may be misalignments at the transitions between the different designs.
 - The same text paper must be used, otherwise visual color deviations may occur. (See example on p. 11)
- Cropped images in the content may affect the color edge, as they may be visible in the color edge (especially with light-colored designs).
(See example on p. 12)
- For designs that run across corners, there may be fitting inaccuracies of up to 0.5 mm at the transitions. (See example on p. 13)
- Frames located at the edge of the final format of the print file should have a minimum width of 3 mm. (See example on p. 14)
- Due to the different materials used, it is not possible to achieve a 100% color match between the cover and the color edge.

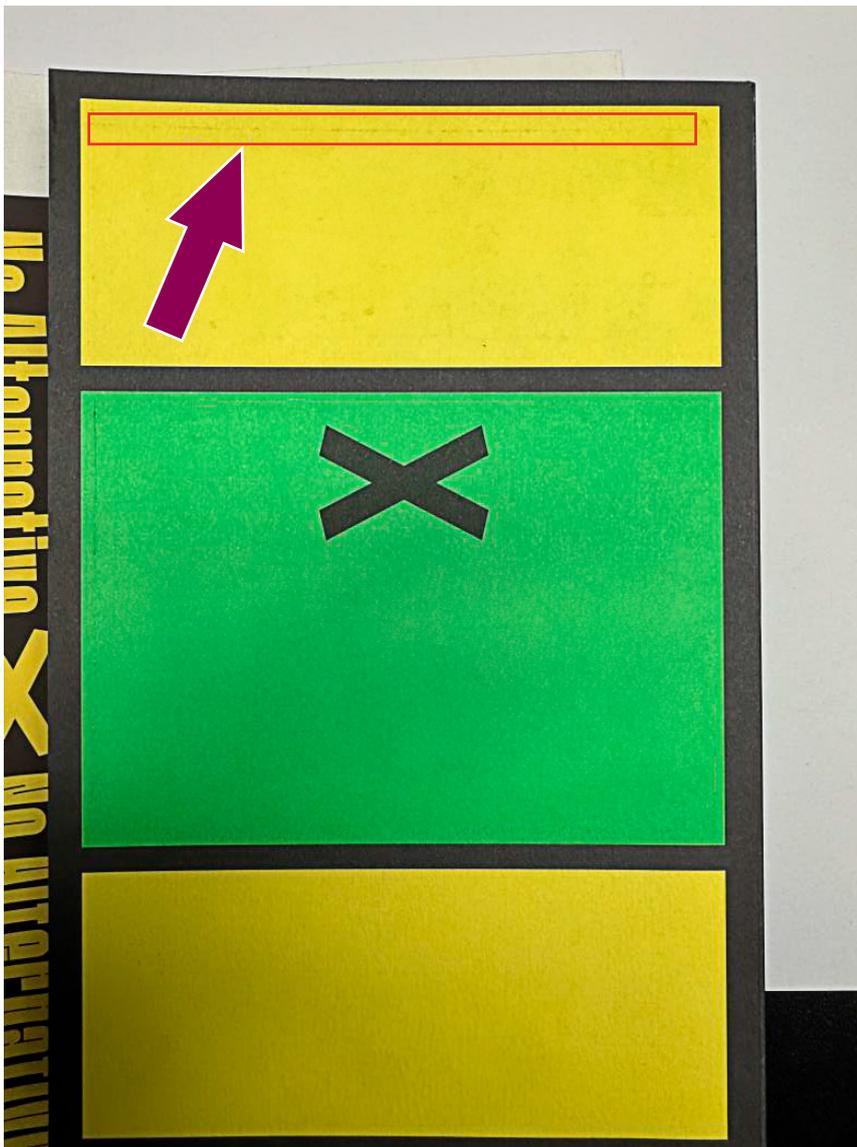
Paperback covers and paperback covers w/ flaps

Ink can get onto the first and last pages of the content through the small gap between the flap edge and the cover.



Paperback covers and paperback covers w/flaps

Ink residues on uncoated paper can **not** be removed afterwards.



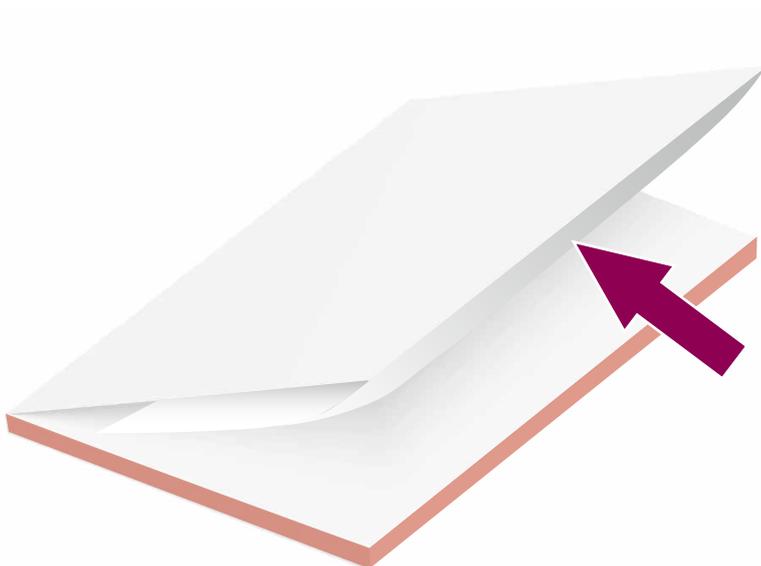
Paperback covers and paperback covers w/ flaps

Light color and dirt deposits may be visible on light-colored covers, unlike full coverage colored covers.



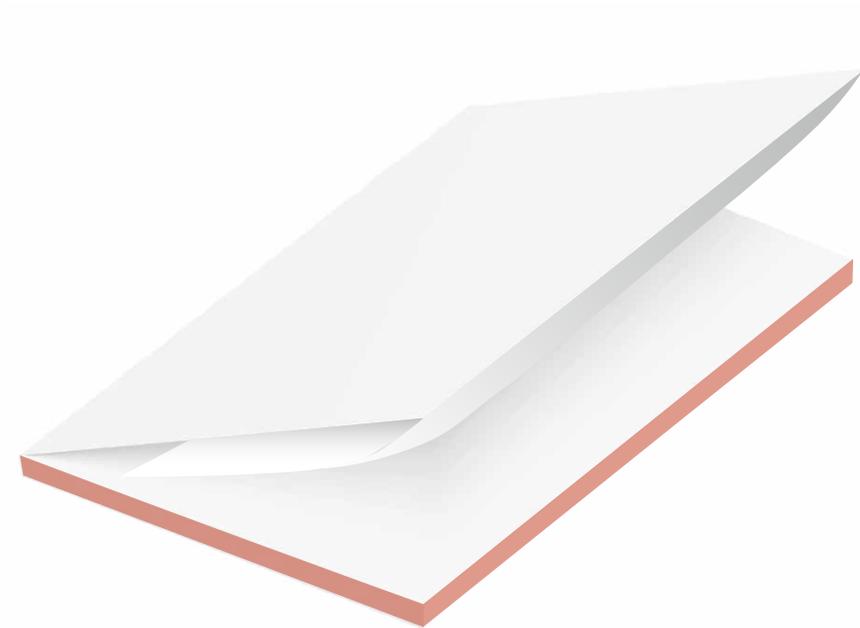
Paperback covers and paperback covers w/ flaps

The protruding flaps may cause ink residue on the flap protrusions on the inside of the BU.



Paperback covers and paperback covers w/ flaps

On paperbacks w/ flaps, the trimmed edge of the cover and the flap are not printed. The trimmed edges of the book block are fully printed.



Design Elements

Image sections produced using paper that differs from the content paper can have a negative effect on the color edge, as the papers have different color acceptance properties. (e.g., 135 gsm image printing paper)



Design Elements

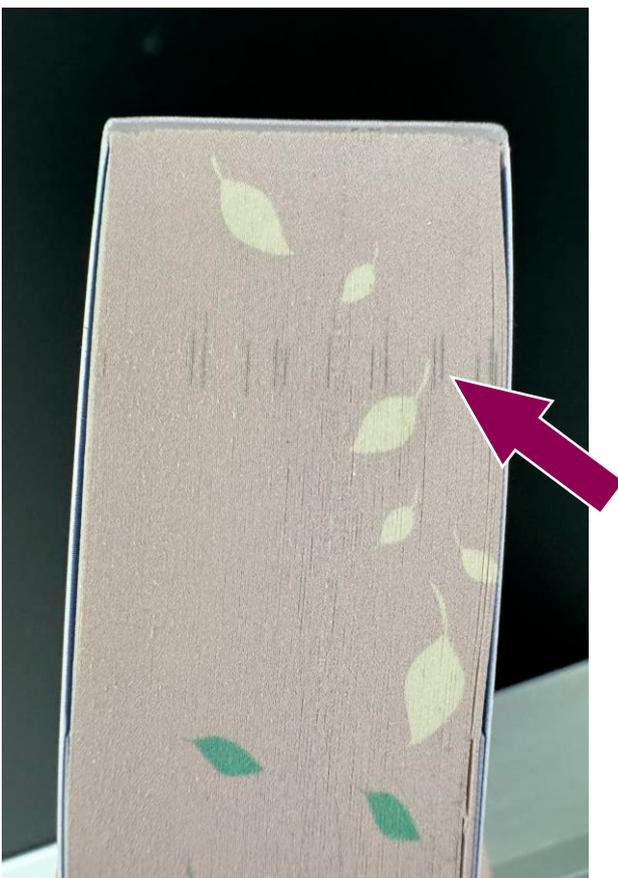
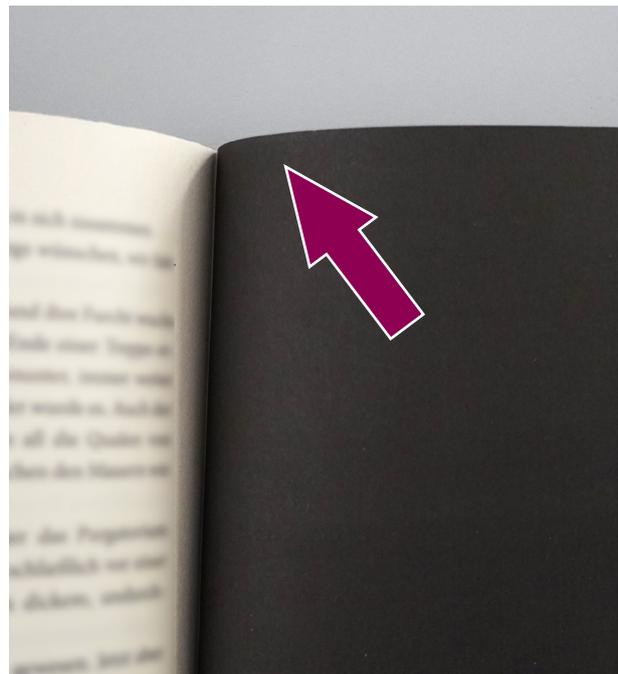
The following points should be noted when designs spill over across several books:

- All print data must be identical and created in accordance with prepress specifications, as otherwise there may be misalignments at the transitions between the different designs.
- The same text paper must be used, otherwise visual color deviations may occur.



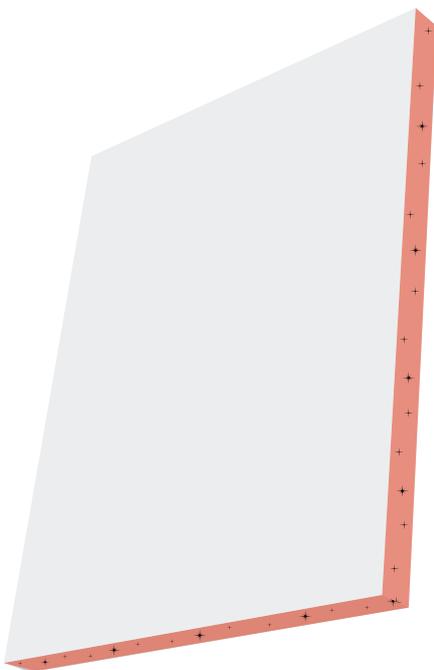
Design Elements

Cropped bleeding images in the content may affect the printed edges, as they may be visible in the printed edges (especially with light-colored designs).



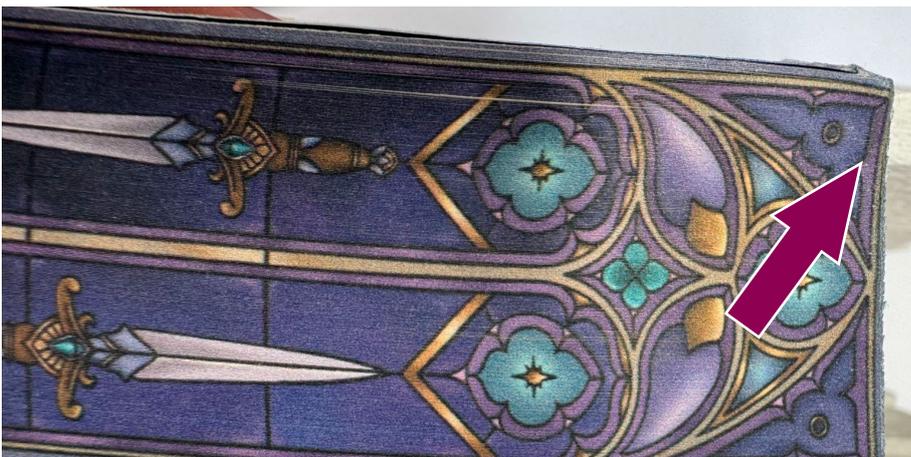
Design Elements

For designs that run across corners, there may be fitting inaccuracies of up to 0.5 mm at the transitions.



Design Elements

Borders located at the edge of the final format of the print file around the cut edge should have a minimum width of 3 mm.



Minimum sizes of lines and elements

The minimum line thickness should be 0.5 mm, otherwise the lines will be difficult to see.



Minimum sizes of lines and elements

The minimum element size should not be less than 0.5 mm, as otherwise they may blur with other objects.



1-sided / 2-sided printed edges

Spray overspray may occur on the unprinted edges of the book

