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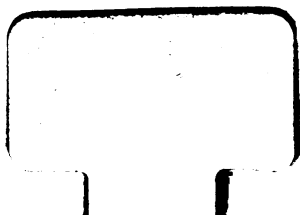
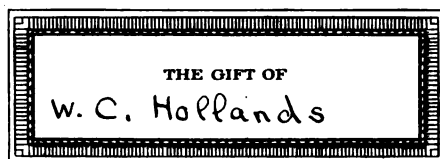
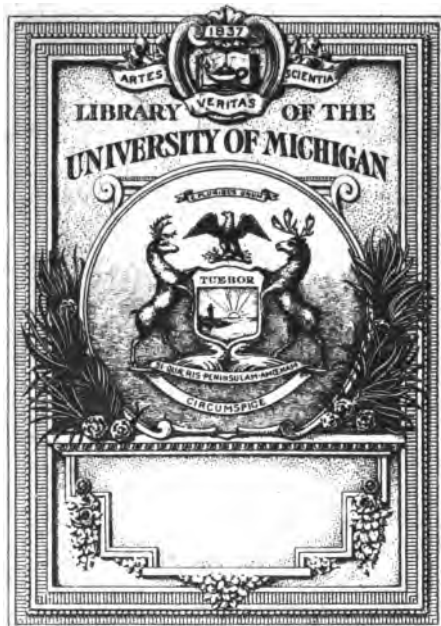
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A Syllabus of a Course

ON

Elementary Bookmaking and Bookbinding

BY

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ELEMENTARY BOOKMAKING AND BOOKBINDING

PART I

ELEMENTARY BOOKMAKING

This course as outlined in the following pages is given at Teachers College of Columbia University. It affords instruction in the underlying principles and processes of bookmaking, which include the construction of boxes, portfolios, desk-pads, note-scraps and guest books, rebinding of old books and magazines and a full course of library mending. Students who have had elementary training in applied design will find in bookmaking the foundation for the application of wood-block and stencil decoration, leather modeling, lettering by hand and illustration. This course is of special value to teachers of art, librarians and students of hand work.

The lessons as presented illustrate all the principles and processes of bookbinding which may be successfully completed without special equipment.* Such work is necessarily limited, not in variety of models, but in accuracy of technique. One aim of such a course is to show the grade of work possible within these limitations. The problems as stated give the points to be illustrated, materials and measurements, and in each case a desirable method of procedure. No attempt has been made to describe the technique necessary for obtaining good results. This is dependent upon either the skill of the individual who wishes to use these outlines without further instruction; or upon the instruction received in class, individually or through demonstration.

The course has four divisions, i. e.:—Box-making, Portfolio work, Bookmaking, Leather modeling and paring, the latter branch of the work being a very necessary feature in the make-up of leather articles. It has been found advisable to teach leather paring early in the year so that odd moments may be utilized by the students.

Bookmaking includes nine problems developed both from the history of the book and from its technique. Owing to the limited equipment these two points cannot be fully met.

* See Processes and Equipment under General Information.

Beginning with primitive ring-bound clay tiles (V), the book progresses steadily through the Japanese or stabbed binding (V, XIII) and Monastic thong-bound parchments (VIII, IX), to the modern book of commerce practically produced by machinery (XIV).

Class instruction is also given in the selection of materials and equipment. This is done so that the student organizing pioneer work in this line may have the necessary knowledge at his command. A list of such equipment may be found under General Information.

It is recommended that the student utilize the diagram at the back of this manual as a nucleus for the collection of desirable samples of material.

These problems as presented in the classes of Teachers College cannot be applied in their entirety to the work of the grades. Consequently a graded set of models suited to grammar school work will be studied.

It will be found advisable to read as many as possible of the various books mentioned in the Bibliography as a help to a richer appreciation of the subject. To further this appreciation, an illustrated lecture on the hand-made book will be given, supplemented by visits to commercial binderies.

A love and broader appreciation of the book will be greatly furthered by an advanced course in bookbinding which is also given in the Industrial Arts Department and adequately outlined in these pages.

I. HANDKERCHIEF BOX

This problem illustrates cutting, folding, pasting, edge and corner turning and hinging. The box is covered and then lined. (See Fig. 1.)

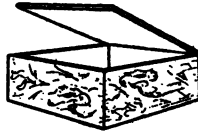


Fig. 1. Sketch. Handkerchief Box partly open.

Materials and Measurements.

Boards: Wood-pulp; 2 pieces, 7" x 7"; 2 pieces, $2\frac{1}{2}$ " x 7"; 2 pieces, $2\frac{1}{2}$ " x 7"—(twice the thickness of board).

Covering material: Chintz; 1 piece, $8\frac{1}{2}$ " x $8\frac{1}{2}$ "; 1 piece, 4" x 22"; 1 piece, $6\frac{1}{2}$ " x $6\frac{1}{2}$ ".

Paper: Anti-rust; 3 pieces, $6\frac{1}{2}$ " x $6\frac{1}{2}$ "; 1 piece, $2\frac{1}{4}$ " x 27".

Lining: Cotton poplin; 2 pieces, 8" x 8"; 1 piece, 4" x 27"; 1 piece, $2\frac{1}{2}$ " x $7\frac{1}{2}$ ".

Interlining: Super; 1 piece, 2 piece, $2\frac{1}{2}$ " x $6\frac{1}{2}$ ".

Cotton wadding: 3 pieces, $6\frac{1}{2}$ " x $6\frac{1}{2}$ ".

Method of Procedure.

(1) Glue the short edges of board strips together, placing long strips at front and back. (2) Fortify corners with thin muslin. (3) Glue bottom of strips and place on 7" x 7" board. (4) Press and stand until dry. (5) Cover top, (7" x 7"), with cotton wadding and chintz, ($8\frac{1}{2}$ " x $8\frac{1}{2}$ "). (6) Stretch cloth strips, (4" x 22"), around sides of box and attach at back with paste. Turn and paste on inside of box and on bottom. (7) Paste cloth strips, ($6\frac{1}{2}$ " x $6\frac{1}{2}$ "), on back of box, at sides and on bottom, allowing top of cloth to stand free. (8) Place lining, ($2\frac{1}{2}$ " x $7\frac{1}{2}$ "), over super interlining, ($2\frac{1}{2}$ " x $6\frac{1}{2}$ "), turning and pasting down sides over back of super. Attach this to inside of back of box. (9) Attach lining strip, (4" x 27"), to paper strip, ($2\frac{1}{4}$ " x 27"). (10) Fit this in box $\frac{1}{4}$ " from top. (11) Fit and cover paper, ($6\frac{1}{2}$ " x $6\frac{1}{2}$ "), to inside bottom and top with

cotton wadding and lining, (8" x 8"). (12) Drop one into bottom of box. (13) Attach hinge to inside of cover. (14) Fasten the other to inside of cover.

II. POST CARD BOX

This problem illustrates cutting, folding, all-over pasting, edge and corner turning. The box is scored, lined and then covered. (See Fig. 2.)

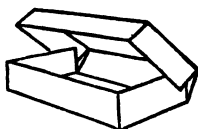


Fig. 2. Sketch. Post Card Box partly open.

Materials and Measurements.

Finished box, $1\frac{1}{2}$ " x $3\frac{13}{16}$ " x $6\frac{3}{8}$ ". (See Fig. 3.)

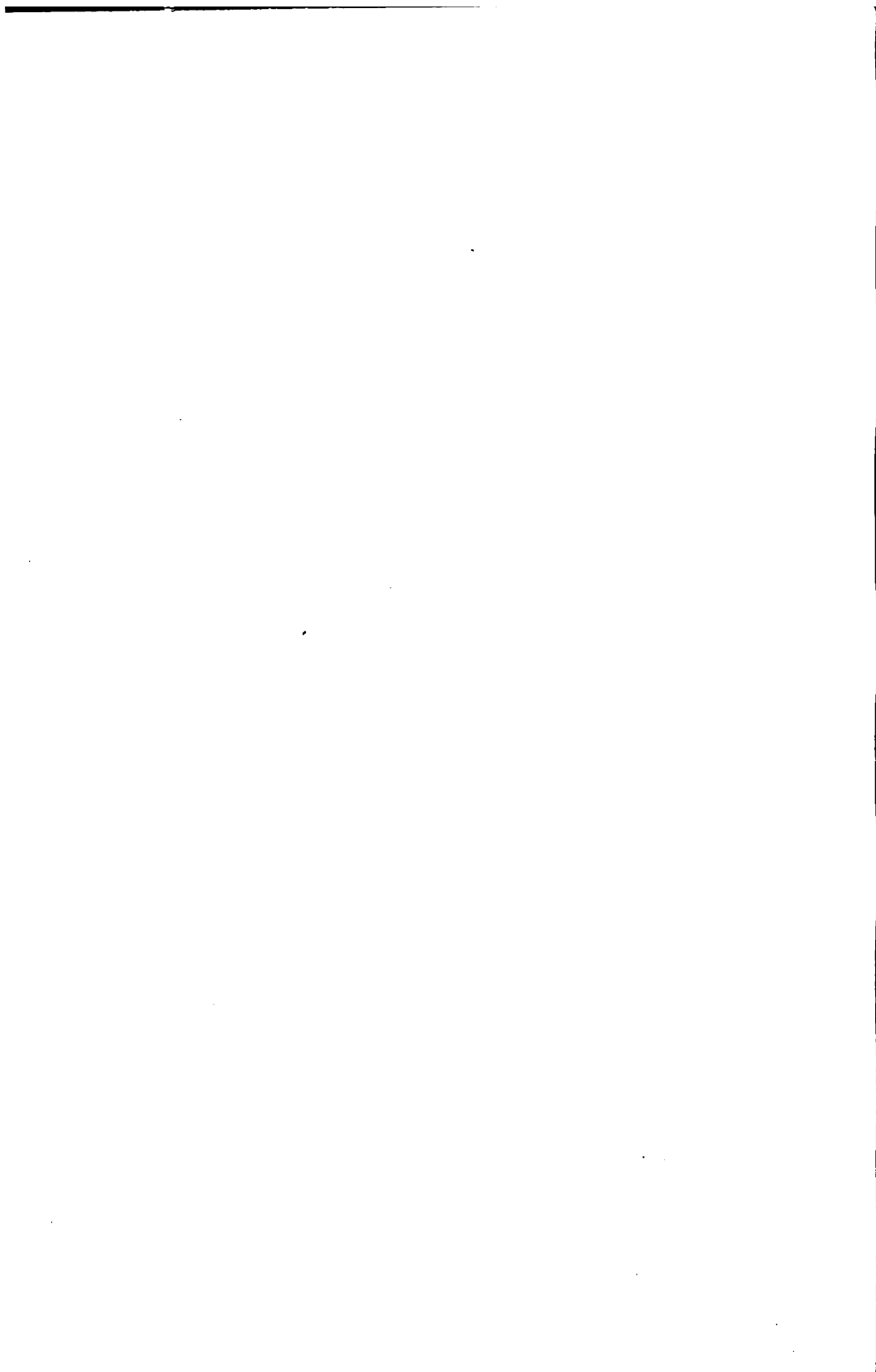
Board: Blue tint; 1 piece, $9\frac{1}{4}$ " x 12".

Paper: Anti-rust; 1 piece, 10" x 13". Fancy; 1 piece, 11" x 14".

Cloth: Super or thin muslin; 2 pieces, 1" x $6\frac{1}{4}$ "; 4 pieces, 1" x $1\frac{1}{2}$ ".

Method of Procedure.

(1) Mark and score lightly with knife the straight lines indicated in Fig 3 (dotted lines represent fancy covering paper). (2) Cut out squares at corners. (3) Paste board ($9\frac{1}{4}$ " x 12") and lay on paper (10" x 13".) (4) Dry under light pressure. (5) Score on the other side and turn up sides of box. (6) Fortify the four corners with thin muslin. (7) Fortify the two back edges with thin muslin. (8) Dry. (9) Paste bottom, back and top of box, lay on fancy paper, and close box to dry. (10) Cut and fit sides, turn over and trim. (11) Paste and fit into place in turn, lower front, lower sides, upper front, upper sides. (12) Close box and dry under light pressure.



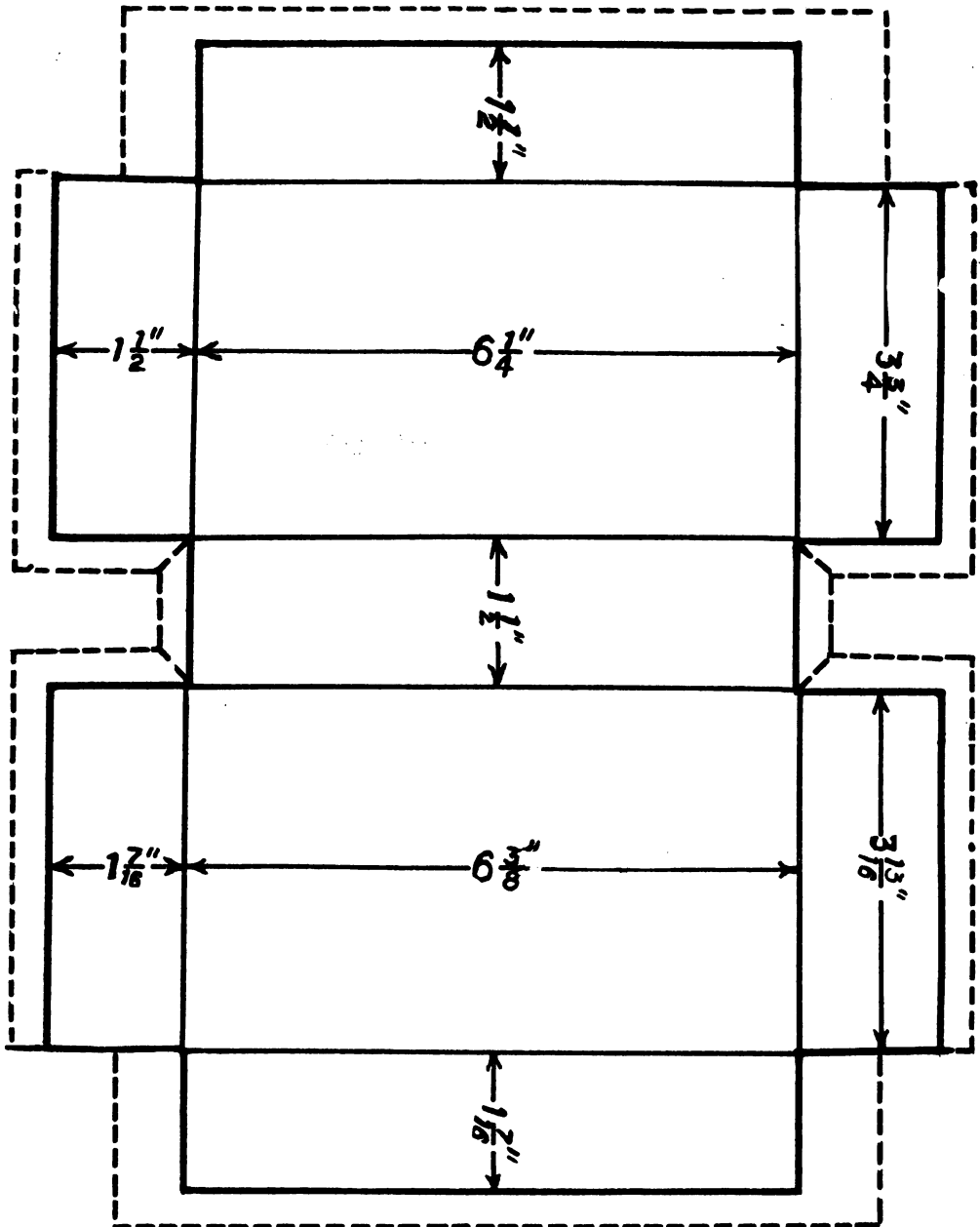


Fig. 3. Chart of Post Card Box.

III. PORTFOLIO WITH THREE FLAPS

This problem illustrates cutting, folding, all-over pasting, corner turning, hinging, mitreing, shrinkage and warping and inserting of tapes.

Materials and Measurements. (See Fig. 4.)

Boards: Gray or cloth board; 2 pieces, 12" x 14". Blue tint board; 1 piece, $2\frac{1}{2}$ " x $13\frac{1}{2}$ "; 2 pieces, $2\frac{1}{2}$ " x $11\frac{1}{2}$ ".

Cloth: Cotton poplin: 2 pieces, $13\frac{1}{2}$ " x $15\frac{1}{2}$ "; 2 pieces, 5" x 13"; 2 pieces, $2\frac{1}{2}$ " x $11\frac{3}{8}$ "; 1 piece, 5" x 15" 1 piece $2\frac{1}{2}$ " x $13\frac{1}{4}$ "; 1 piece, 3" x 15"; 1 piece, 3" x $13\frac{3}{4}$ ".

Paper: Anti-rust; 2 pieces $11\frac{7}{8}$ " x $13\frac{3}{4}$ "; 2 pieces, $2\frac{3}{8}$ " x $11\frac{3}{8}$ "; 1 piece, $2\frac{3}{8}$ " x $13\frac{1}{4}$ ".

Tape: 6 pieces, 8".

Method of Procedure.

(1) Mitre 1" corners on one side of flaps. (2) Cover three flaps (blue tint board) with cloth (5" x 13" and 5" x 15"). Line with cloth hinges ($2\frac{1}{2}$ " x $11\frac{3}{8}$ " and $2\frac{1}{2}$ " x $13\frac{1}{4}$ ") and paper ($2\frac{3}{8}$ " x $11\frac{3}{8}$ " and $2\frac{3}{8}$ " x $13\frac{1}{4}$ "). (3) Cover sides (12" x 14") with cloth ($13\frac{1}{2}$ " x $15\frac{1}{2}$ "). (4) Dry under pressure. (5) Insert tapes in two short sides and front, $\frac{1}{2}$ " from edge. (6) Make and attach hinge at back (3" x 15" and 3" x $13\frac{3}{4}$ "). (7) Attach and mitre flaps. (8) Line boards with paper ($11\frac{7}{8}$ " x $13\frac{3}{4}$ "). (9) Press with flaps out.

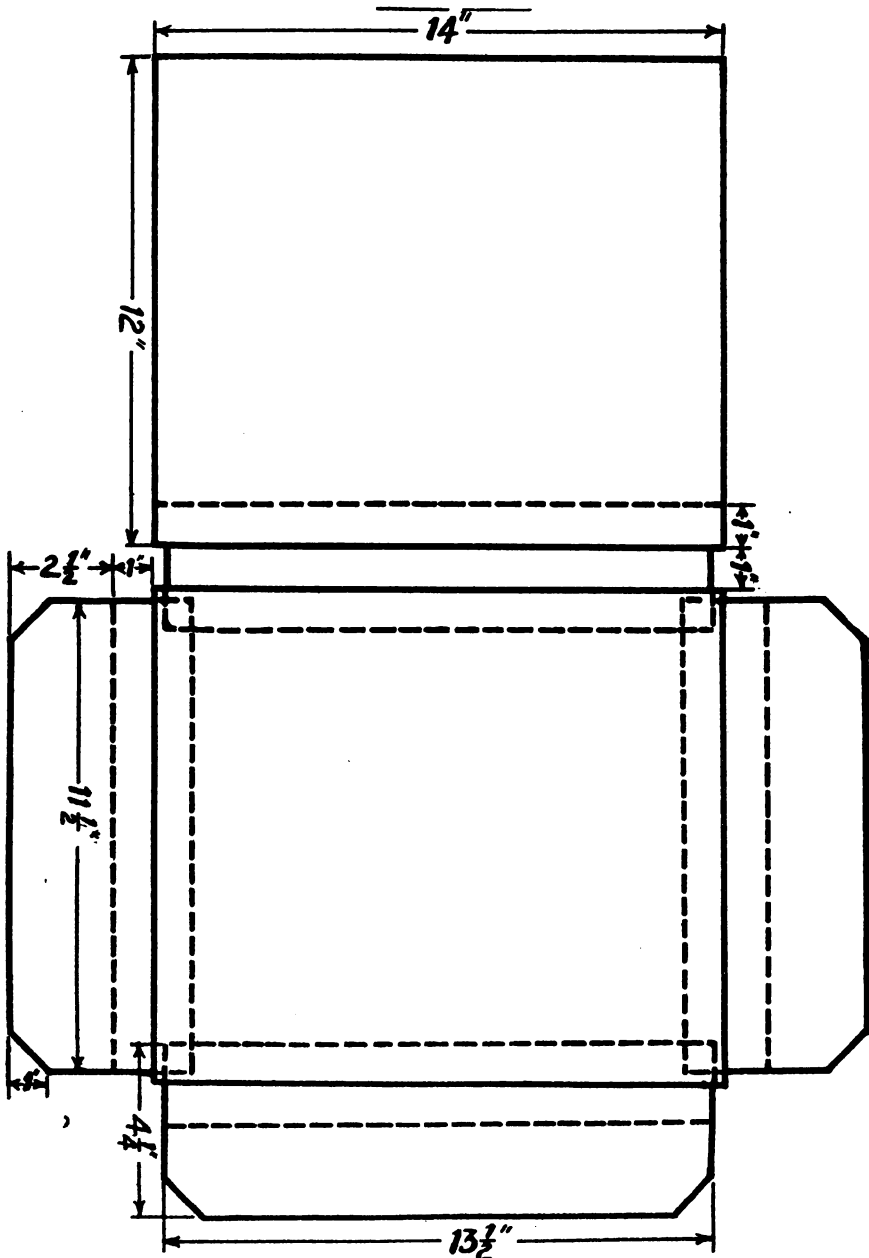


Fig. 4. Chart of Portfolio.

IV. DESK PAD

This problem illustrates all-over pasting, shrinkage and warping, corner-turning, the making and setting of loose corners, and stencil decoration. (See Fig. 5.)



Fig. 5. Sketch of Desk Pad.

Materials and Measurements.

Board: Foundation board—cloth board, $9\frac{1}{2}" \times 12"$. Corner board—blue tint, $9\frac{3}{8}" \times 11\frac{7}{8}"$. Filling-in board, $9\frac{1}{4}" \times 11\frac{3}{4}"$.

Cloth: Royal buckram; 1 piece, $11" \times 13\frac{1}{2}"$; 1 piece, $4\frac{1}{2}" \times 9"$ (See Fig. 6 A.)

Paper: Anti-rust; $2\frac{1}{2}" \times 2\frac{1}{2}"$. (See Fig. 6 B.) Unprinted newspaper; $2" \times 2"$. (See Fig. 6 C.)

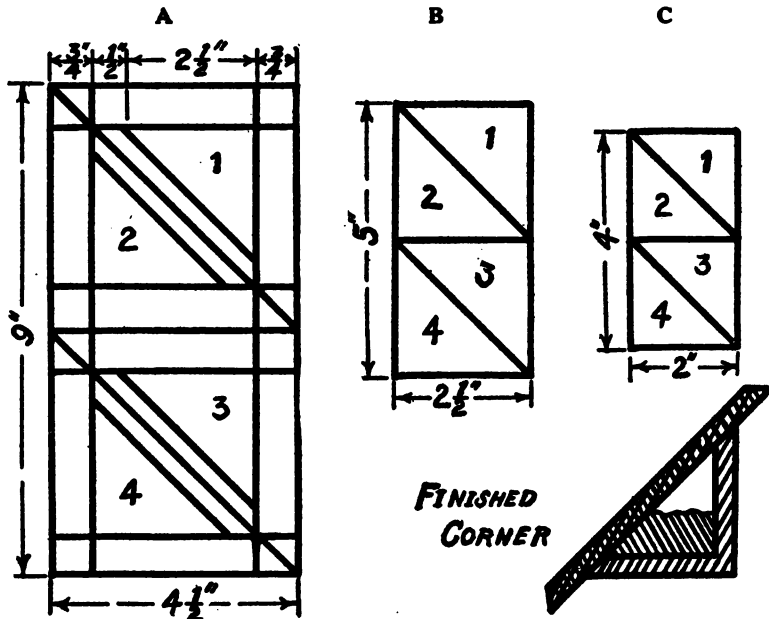


Fig. 6. Chart of Corners for Desk Pad.

Finished Corner D.

Method of Procedure.

Mark off buckram ($4\frac{1}{2}" \times 9"$) into four corners ($2\frac{1}{2}" \times 2\frac{1}{2}"$), allowing $\frac{3}{4}"$ for straight turn over and $\frac{1}{2}"$ for diagonal turn over. (2) Cut across diagonals making four corners—A 1, 2, 3 and 4. (3) Cut B and C on diagonals. (4) Paste B 1, 2, 3 and 4 and place on A 1, 2, 3 and 4. (5) Paste and turn over $\frac{1}{2}"$ diagonal left on A 1, 2, 3 and 4. (6) Paste C 1, 2, 3 and 4 and place on the uncovered portions of B 1, 2, 3 and 4. (See Fig. 6 D.) (7) Cut off corners diagonally leaving $\frac{1}{4}"$. (See Fig. 7 A.) From filling-in board cut off four $3\frac{1}{2}"$ corners. (8) With these as filling-in boards, mount corners on corner board. (9) Cover foundation board ($9\frac{1}{2}" \times 12"$) with buckram. (10) Paste back of corner board in center, glue on edge and bring this and foundation board together. (11) Put filling-in board in place and dry under pressure.

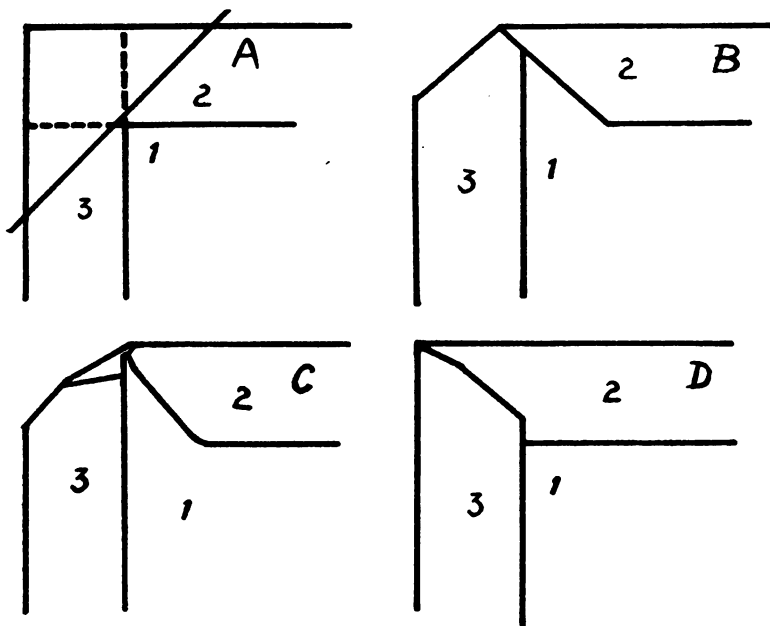


Fig. 7. Corner Turning.

V. SCRAP BOOK WITH OPEN BACK

This problem illustrates the earliest form of bookbinding—single sheets pierced with holes and joined by rings or thongs. A simplified method of eyelet inserting is used. (See Fig 8.)

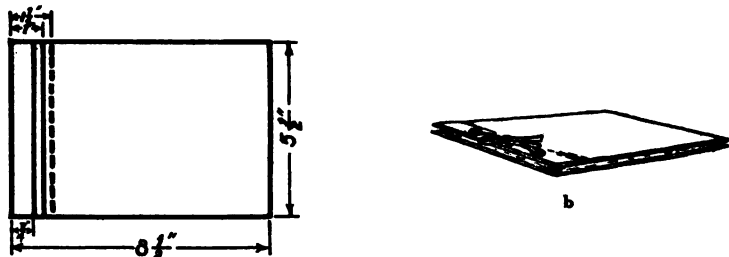


Fig. 8. Scrap Book with open back.

Materials and Measurements.

Boards: Cloth board; 2 pieces, $5\frac{1}{2}" \times 8\frac{1}{2}"$.

Cloth: Royal buckram; 2 pieces, $7" \times 10"$; 1 piece, $1\frac{1}{4}" \times 5\frac{1}{4}"$.

Paper: Cover: 16 pieces, $5\frac{1}{4}" \times 8\frac{1}{4}"$; 1 piece, $5\frac{1}{4}" \times 7\frac{1}{4}"$.

Eyelets: 4.

Method of Procedure.

(1) From one cloth board cut off a strip $\frac{3}{4}" \times 5\frac{1}{2}"$ and another $\frac{1}{4}" \times 5\frac{1}{2}"$ leaving a piece $5\frac{1}{2}" \times 7\frac{1}{2}"$. (2) On buckram ($7" \times 10"$) mark off two oblongs by drawing around ($5\frac{1}{2}" \times 8\frac{1}{2}"$) board. (3) Cover one board (for corner turning see Fig. 7) and line with cover paper. (4) Paste board ($5\frac{1}{2}" \times 7\frac{1}{2}"$) and place on right end of second piece of cloth. (5) Paste strip ($\frac{3}{4}" \times 5\frac{1}{2}"$) and place on left end of cloth. This leaves $\frac{1}{4}"$ for hinge.. Cover as first board. (6) Place strip of buckram ($1\frac{1}{4}" \times 5\frac{1}{4}"$) over hinge. (7) Line the oblong ($5\frac{1}{2}" \times 7\frac{1}{2}"$) with cover paper ($5\frac{1}{4}" \times 7\frac{3}{8}"$). (8) Trim off strip ($\frac{1}{4}" \times 5\frac{1}{2}"$) to fit hinge and push in hinge on inside of board. (9) Dry under pressure. (10) Insert eyelets $1\frac{1}{2}"$ from head and tail in strip ($\frac{3}{4}" \times 5\frac{1}{2}"$) and back cover. (11) Punch holes in sheets and tie with leather thong.

VI. JAPANESE BOOK WITH CLOSED BACK

This illustrates the earliest form of bookbinding, stabbed sewing, and is one form of binding pamphlets of one section, or single sheets. (See Fig. 9.)



Fig. 9. Japanese Book.

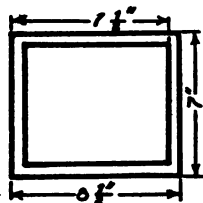


Fig. 10. Flinder.

Materials and Measurements.

Boards: Blue tint; 2 boards, $4\frac{1}{4}" \times 6\frac{1}{2}"$.

Paper: Anti-rust; 6 sheets, $6\frac{1}{2}" \times 9\frac{1}{4}"$.

Leather: Ooze; $2" \times 6\frac{1}{2}"$.

Cloth: Royal buckram; 2 pieces, $4\frac{1}{4}" \times 6\frac{1}{2}"$.

Silk: Twisted silk to match leather.

Method of Procedure.

(1) Cover boards with buckram. (2) Fold sheets into $6\frac{1}{2}" \times 4\frac{5}{8}"$. (3) Paste board on end sheets. (4) Paste leather along back edge of boards. (5) Punch $\frac{1}{4}"$ from back of leather one hole in middle, three on each side, and sew through shoemaker's stitch. (6) Tie in middle.

VII. PAMPHLET PROBLEM

This illustrates the one-section book with a case cover. All the common problems of book mending are worked out on a blank sheet dummy.

Materials and Measurements.

Boards: 2 pieces, $3\frac{5}{8}" \times 6"$.

Cloth: Crepe cloth or chintz; 1 piece, 7" x 8½"; 1 piece, 6" x 7½".

Paper: Anti-rust; 1 piece, 7" x 8½". (See Fig. 10.) White paper; 8 sheets, 5⅝" x 6¾".

Method of Procedure.

- (1) Fold sheets into 3⅜" x 5⅝".
- (2) Make into one section.
- (3) Mark pages 1 to 28, leaving out first and last sheets.
- (4) Mark as follows:



Fig. 11. Sketch. Florentine Note Book.

Front End Sheet.

Page 1. Mending a straight torn corner. Inside of outside sheet.

Page 3. Mending a roughly torn corner.

Page 5. Patching. Edge and page tear.

Page 7. Hinging I. Books taken apart. 7-8; 21-22. Joining the corresponding sheets of a section.

Page 9. Hinging II. Books taken apart. 9-10; 19-20. Stub left. Magazine problem.

Page 11. Hinging III. Bound books with loose leaves when the leaf is full size. 11-12; 17-18.

Page 13. Outside of inside sheet.

Page 17. Hinging IV. Bound books with loose leaves when the leaf is not full size.

Page 19. Back of hinging II.

Page 21. Back of hinging I.

Back end sheet.

- (5) Sew cloth (6" x 7½") with seven stitches through folded section at back.
- (6) Cover boards (3⅝" x 6") with cloth (7" x 8½") leaving ¼" hinge.
- (7) Paste cloth (6" x 7½") on case.
- (8) Dry under light pressure.

VIII. FLORENTINE NOTE BOOK

This illustrates cutting, folding and sewing on tapes, including the processes of bookbinding noted below. See General Information—processes. (See Fig. 11.)

Materials and Measurements.

Paper: Anti-rust; 4 flat sheets, $17\frac{1}{4}" \times 24\frac{1}{2}"$; 1 piece, $8\frac{3}{8}" \times 21"$. Cover paper; 1 piece, $6\frac{1}{4}" \times 17\frac{3}{4}"$. Silk fibre paper; 1 piece, $8\frac{3}{8}" \times 21"$.

Tape: 4 pieces, 5"; 2 pieces, 25".

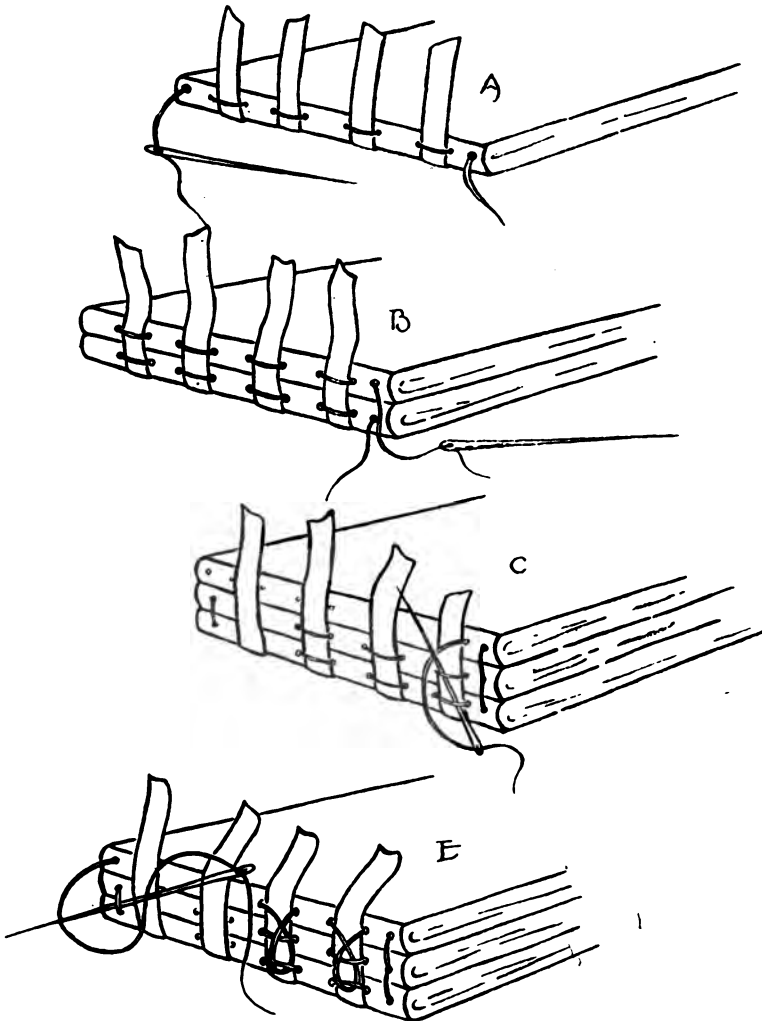


Fig. 12. Sewing.

Method of Procedure.

(1) Fold flat sheets into four sections of 16 pages. (2) Page and mark signatures. (3) Mark on page 1, Head, Tail, Fore-edge, Back. (4), Knock up head and back and mark for four tapes. (See Fig. 12.) (5) Saw or cut in kettle stitch. (6) Place in position for sewing and sew with linen thread. (7)

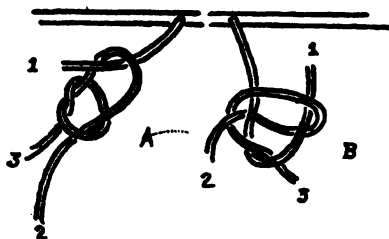


Fig. 13. Knots.

Join new thread by knot (Fig. 13.) (8) Tighten tapes and glue up back. (9) Cut pattern (anti-rust $8\frac{3}{8}" \times 21"$). (See Fig. 14) and mark off as on chart. (10) Cut through slits for tapes. (11) Cut lining ($6\frac{1}{4}" \times 17\frac{3}{4}"$). (12) Cut cover (silk fibre $8\frac{3}{8}" \times 21"$). (13) Fold and cut cover and lining by pattern. (14) Place folded cover on book. (15) Draw short tapes through slits and tip down on lining with glue. (16) Cut first and last pages, turn back for end sheets. (17) Cut the remaining slits through end sheets and lace long tapes through cover and end sheets.

IX. LIMP LEATHER BOOK

This illustrates sewing on tapes, mending, paper and silk end sheets, and soft leather cover.

Materials and Measurements.

Paper: Keppel booklet of several sections, $3\frac{3}{8}" \times 5\frac{5}{8}"$. White end paper; 2 folded sheets, $3\frac{3}{8}" \times 5\frac{5}{8}"$.

Silk: 2 pieces, $4\frac{1}{2}" \times 6\frac{1}{2}"$.

Leather: Ooze calf or goat, 1 piece, $6\frac{1}{2}" \times 8"$.

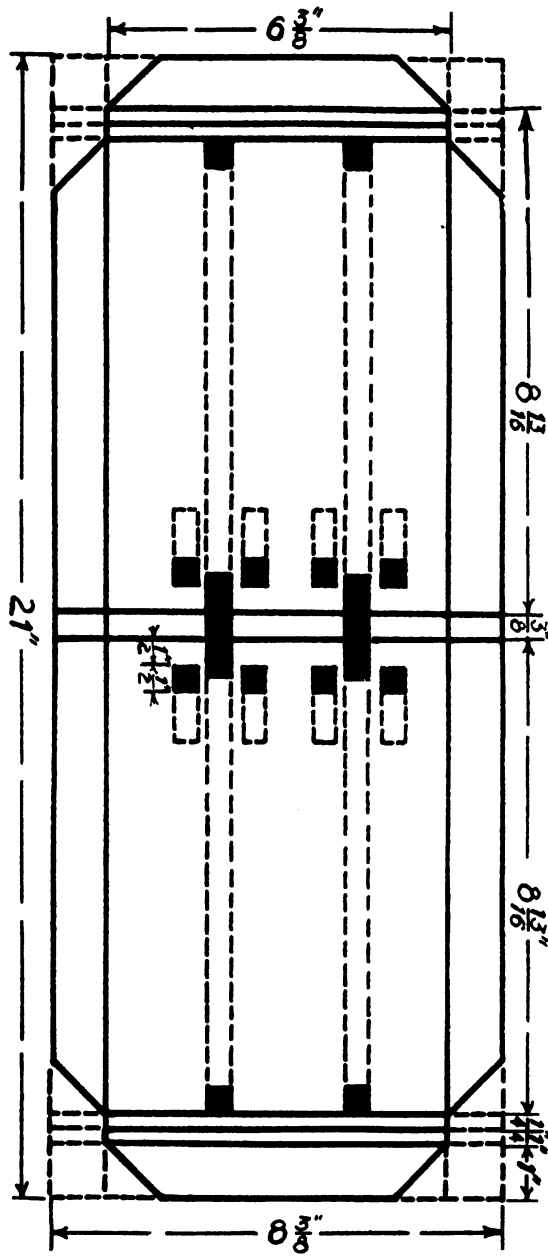


Fig. 14. Chart. Florentine Note Book Pattern.

Method of Procedure.

(1) Take book apart, mend. (2) Make new end sheets. (3) Mark up for two tapes and sew. (4) Knock up head and back, glue and dry. (5) Between first and second sheets lay silk, right side toward p. 3. (7) Turn over edges $\frac{1}{2}$ " and paste over head, tail and foreedge of sheet. (8) Repeat for the end of book. (9) Paste border on book and attach to smooth side of leather. (10) Dry under light pressure. (11) Trim down margin or square. Width is optional.

X. KODAK BOOK

This illustrates sewing on tapes, waste sheets, insertion of stubs, the double board and French joint book with hollow back.

Materials and Measurements.

Boards: Cloth board; 2 pieces, $4\frac{1}{2}$ " x $4\frac{3}{4}$ " (length). Blue tint; 2 pieces, $4\frac{1}{2}$ " x $4\frac{3}{4}$ ".

Paper: Cover; $1\frac{1}{2}$ sheets, $22\frac{1}{2}$ " x 27"; 12 stubs, 1" x $4\frac{1}{2}$ ". Mending; 2 pieces, $4\frac{1}{2}$ " x 5". Stiff, 1 piece, $\frac{1}{2}$ " x $4\frac{3}{4}$ ". Silk fibre; 1 piece, $5\frac{3}{4}$ " x $11\frac{1}{2}$ ".

Tape: 2 pieces, 3".

Method of Procedure.

(1) Tear paper ($22\frac{1}{2}$ " x 27") into 16 sheets $4\frac{1}{2}$ " x 9"; fold into 16 double sheets $4\frac{1}{2}$ " x $4\frac{1}{2}$ ". (2) Make into 8 sections, 2 sheets in each. (3) Fold 12 stubs lengthwise 1" x $4\frac{1}{2}$ ". (4) Insert stub outside of each sheet except in first and last section; fasten in place with a little paste. (5) Paste waste sheet $4\frac{1}{2}$ " x 5" around first and last sections. (6) Knock up book head and back and mark for two tapes. (7) Saw or cut in kettlestitch. (8) Place in position for sewing. (9) Sew. (10) Glue up back. (11) Where there are two stubs, paste them together. (12) Cut off waste sheet 2" wide from back. (13) Cut off tape a little less than 1" long and paste down. (14) Paste waste

sheet, fold over tapes, mitre 1" at corners. (See Fig. 15 A and B.) (15) Glue boards, a thick and a thin board together, 2-3 of the way, leaving 1-3 open the length of board $4\frac{3}{4}$ ". (16) Dry under pressure. (17) Mark on waste sheets lines the length of book $\frac{1}{4}$ " from back. (18) Insert glue between boards at unglued side, slip the folded waste sheet between them, thick board

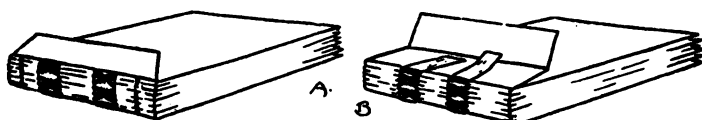


Fig. 15. Sketch French Joint.

outside. (19) Dry under pressure. (20) Make pattern for cover ($5\frac{3}{4}$ " x $11\frac{1}{2}$ "). (21) Paste covering paper. (22) Cover. (23) Paste back end sheets. (24) Dry under pressure.

XI. DUMMY FOR CHAUTAUQUA HINGE

This illustrates a method of replacing a case cover on a book, or of hinging large books and of strengthening first and last sections of books.

Materials and Measurements.

Boards: Blue tint; 2 pieces, 3" x $4\frac{1}{4}$ ".

Paper: Cover; 6 pieces, 12" x 16"; 2 pieces, $2\frac{7}{8}$ " x 4". Stiff; 1 piece, $\frac{5}{8}$ " x $4\frac{1}{4}$ ".

Tape, 2 pieces, 3".

Cloth: Chintz; 1 piece, $5\frac{1}{2}$ " x $8\frac{1}{2}$ ". Label vellum; 2 pieces, 1" x 4". Book muslin; 2 pieces, 1" x 4".

Method of Procedure.

(1) Fold the six flat sheets (12" x 16") into six sections, pages 3" x 4". (2) Sew on two tapes and glue up back. (3) Fold book muslin and label vellum, one of each together lengthwise $\frac{1}{4}$ " from edge and sew on machine, large stitches. (See Fig. 16.) (4) On one end of book paste label vellum on last sheet $\frac{1}{4}$ " and over back. (5) Attach end sheets to upper side of book

muslin. (6) On the other end of book sew $\frac{1}{8}$ " from back lengthwise of book shoemaker's stitch five stitches, through first section to middle of second. (7) Pastel label vellum $\frac{1}{4}$ " on sheet against back. (8) Make and dry case cover of boards and cloth. (9) Attach to end having end sheets, by tapes and one

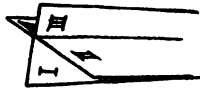


Fig. 16. Chautauqua Hinge.

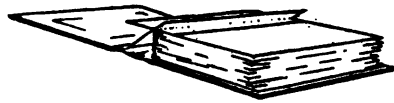


Fig. 17. Chautauqua Hinge on Book.

end sheet. (10) Leave the other end open for inspection. (See Fig. 17).

XII. MAGAZINE

This illustrates the problems of mending and hinging worked out in Pamphlet Problem (VIII) and Dummy for Chautauqua Hinge (XI) and refers to books partly or wholly in single sheets.

Materials and Measurements.

Boards: Cloth—vary in size.

Paper: Anti-rust—varies in size. White end sheet—varies in size. The Book: Articles from magazines 25-75 pages. Margins should be kept intact.

Cloth: Royal Buckram—varies in size.

Tape: 3 pieces, 4".

Chautauqua hinges—vary in size.

Stiffening: Heavy paper—varies in size.

Method of Procedure.

(1) Collate magazine articles. (2) Make into 16-page sections by hinging. See VIII. (3) Fold extra end sheet around first and last sections. (4) Sew on three tapes, glue up, attach Chautauqua Hinge and endsheets (anti-rust). (5) Make case cover. (6) Dry under pressure. (7) Attach cover to book. (8) Tie string around hinges and dry under pressure.

XIII. SINGLE SHEET PROBLEM

This illustrates a method of casing single sheets united with stabbed sewing.

Materials and Measurements.

Boards: Blue tint; 2 pieces, 5 5-16" x 7".

Paper: Silk fibre-cream; 2 pieces, 1½" x 5 1-16"; 1 piece, 3" x 6¾". Fancy; 4 pieces, 5 1-16" x 6¾"; 2 pieces, 6½" x 6½". Pad; ½ Junior Size U. S. Mail Tablet; measures 5 1-16" x 7" x 5-16".

Method of Procedure.

(1) Fold silk fibre strips (1½" x 5 1-16") lengthwise. (2) Paste fold toward back on first and last sheets. (3) Stab 7 holes ¼" from back and sew shoemaker's stitch. (4) Make case cover allowing 5-16" for back, using boards and silk fibre paper (3" x 6¾") for back. (5) Cover sides with fancy paper (6½" x 6½") allowing ⅛" lap on silk fibre paper. (6) Dry cover under pressure. (7) Attach cover to book by silk fibre hinge. (8) Paste in the four end sheets. (9) Dry under pressure.

XIV. HALF LEATHER BINDING

This illustrates the paring of leather for books and the half bound, hollow-back book of commerce.

Materials and Measurements.

Boards: Cloth board—varies in size.

Paper: Anti-rust—varies in size.

The book: Requirements—Not more than 1½" thick nor less than ½" thick; good joint, sewing in perfect condition. Preferably a new book.

Cloth: Royal Buckram—red; 2 pieces—vary in size.

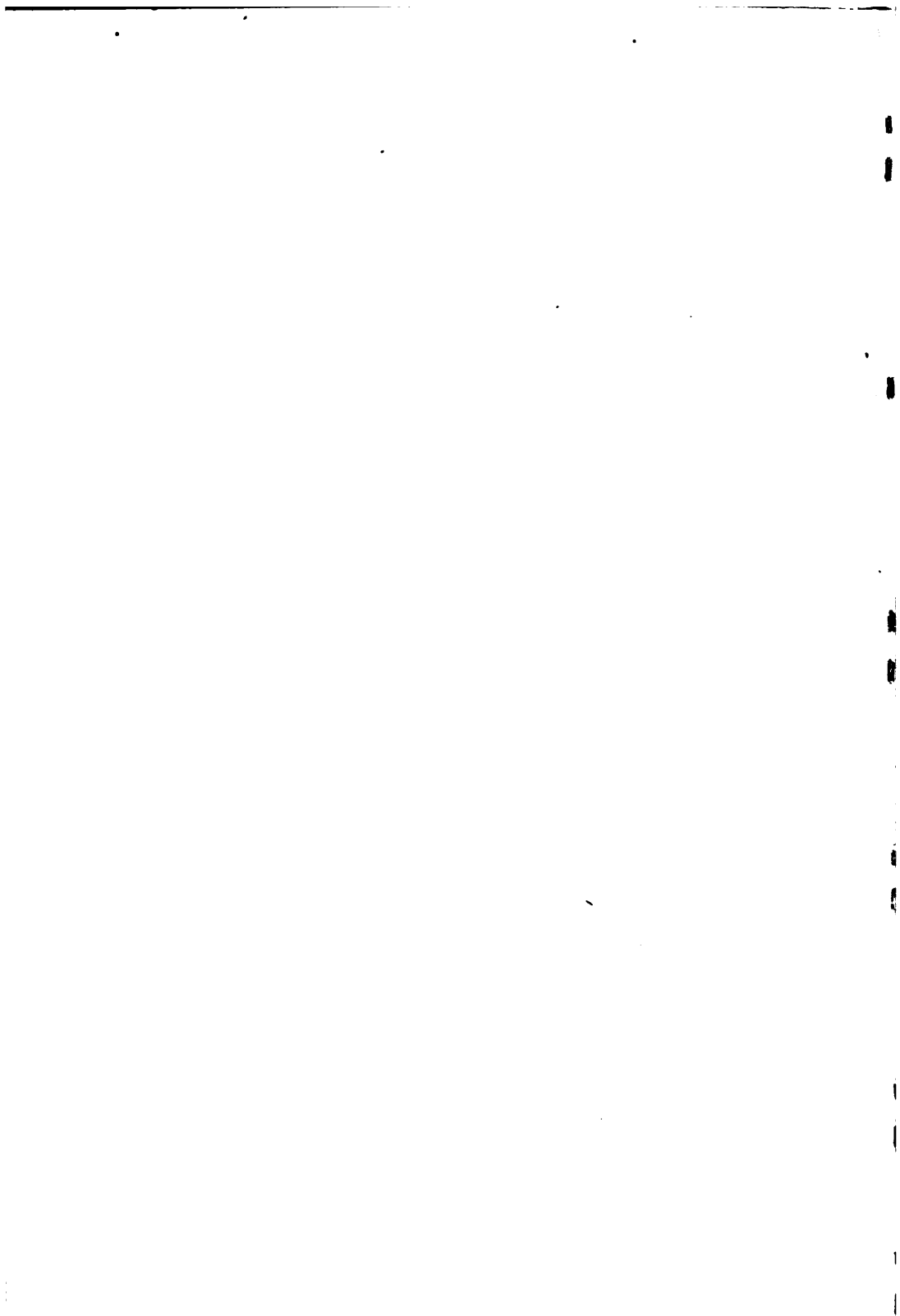
Leather: American morocco—red. Back—varies in size.

Four corners—1 piece, 3" x 6".

Super: Varies in size.

Method of Procedure.

(1) Remove old cover of book. (2) Remove paper, super and glue from back. (3) Replace super and paper with new materials. (4) Make and attach end sheets. Dry. (5) Make paper pattern of case cover; of back; of corners. (6) Cut leather by patterns. (7) Pare back and corners. (8) Paste these on boards. (9) Make paper pattern of sides. (10) Cut cloth by pattern. (11) Paste cloth on sides. (12) Dry under pressure. (13) Attach cover to book by end sheets. (14) Tie string over hinge. (15) Make head cap. (16) Dry under pressure.





PART II

BOOKBINDING

The work as laid down in Elementary Bookmaking is accomplished without special equipment; this course which is a step in advance requires a full bookbinding plant, and is particularly adapted to high schools where rooms can be equipped for this purpose. As a result of this plant, greater accuracy and skill in technique is demanded of the student.

Beginning at the point where we left the work in the previous year, the first problem of the five included in this course is a whip-stitched cloth-covered magazine sewed on sunken cords, with a hollow back. This is followed by the whip-stitched sunken-cord book, with hollow back and false cords, half-bound in American morocco. The third is the flexible library binding, sewed on tapes, adherent back, half-bound in leather, finished with blind tooled title and lines. The last two books are sewed on raised cords, one of which is half-bound in crushed levant, the other, full-bound, both finished in gold title and lines.

Finer points such as leather onlays, doublures, and geometrical or intricate designs in gold and blind tooling are the work of experts and cannot be reached in the one hundred and twenty hours assigned to this course.

Instruction is given in judging and purchasing leather, paper and textiles suited to the needs of bookbinding, and assistance is offered in estimating the plant and materials necessary for equipping classes of varying sizes.

Familiarity with the subject matter of the following texts is insisted upon. For technique, Cockerell and Zaehnsdorf; for history and general information, Davenport "The Book and its Construction."

It is needless to state to the worker in books that two years of the most faithful work is but a beginning; it can at best but serve as a foundation for the furtherance of skill which can only be gained by continuous and persistent effort. These two years of binding, however, open a wide vista in the world of books, bringing to the student an appreciation of the book as it has stood, from the beginning of time, an expression of thought from within and without.

I. PRESSING BOARDS

This illustrates the French pressing board which will not crack and will warp less than the wooden board in common use.

Materials and Measurements.

Boards: W. O. Davey No. 10; 4 pieces, 9" x 12"; 4 pieces, 6" x 8". Red press board; 4 pieces 9" x 12"; 4 pieces, 6" x 8".

Glue: Ground white—hot.

Paste.

Method of Procedure.

(1) Place together two pieces of Davey board (9" x 12"), one board pasted, the other glued. (2) On either side of this double board, which should be pasted, place a glued press board. (3) Make the other board (9" x 12") and two boards (6" x 8") in the same manner. (4) Mark with name of student on Dennison label in corner. (5) Place with waxed paper between, under a weight to set glue. (6) Place in standing press to dry.

II. MENDING DUMMY

(See Elementary Bookmaking: VII Pamphlet Problem.)

III. MAGAZINE

This illustrates the ordinary magazine binding, whip-stitched, sewed on sunken cords, bound in cloth, hollow back, with the added strength of laced-in slips.

Materials and Measurements.

Boards: W. O. Davey; 2 pieces—vary in size according to magazine used.

Paper: Anti-rust; 2 pieces—vary in size. White end sheets; 4 pieces—vary in size. Stiff; 1 piece—varies in size. The Book: Magazines or selections from magazines, not more than 1½" or less than 1" thick.



Cloth: Royal Buckram; 1 piece—varies in size.

Cord: Two-ply soft sewing; 3 pieces 12".

Head banding: Two pieces—vary in size.

Method of Procedure.

(1) Collate, mark pages and signatures. (2) Add blank sheet at beginning and end of book. (3) Knock up head and back. (4) Press between boards in standing press over night. (5) Cut off back in lying press. (6) Glue up back. (7) Mark up and saw in for three cords and kettle-stitch. (8) Separate into sections. (9) Mark and prick for whip-stitching. (10) Whip-stitch. (11) Flatten thread. (12) Press in standing press. (13) Collate. (14) Place on frame for sewing. (15) String up frame. (16) Sew. (17) Make end sheets. (18) Attach end sheets. (19) Line up boards. (20) Fray out slips. (21) Glue up back. (22) Round and back. (23) Square boards. (24) File boards to joints. (25) Mark boards for holing. (26) Hole and draw in slips. (27) Cut edges. (28) Color edges. (29) Attach headbands. (30) Line up back with paper. (31) Cut pattern. (32) Clean edges of boards. (33) Set squares. (34) Press in tins. (35) Make envelope. (36) Cover with cloth. (37) Dry under light pressure. (38) Paste back end sheets. (39) Stand open to dry. (40) Close and press.

IV. WHIPPED-STITCHED BOOK

This illustrates a method of rebinding old books with backs too worn for mending—the hollow-back, false cord, half bound leather binding with paper or cloth sides, cord head band, and laced-in slips.

Materials and Measurements.

Board, paper, cloth, cord as in III.

Leather: American morocco—red; 1 piece—varies in size; 1 piece, 3" x 6".

Method of Procedure.

(1) As in III through "Cut and color edges." (2) Line up back with paper. (3) Glue five cords on paper. (4) Make pattern for leather back and corners. (5) Pare leather. (6) File boards to joint. (7) Nick corners. (8) Smooth edges of boards. (9) Make envelope. (10) Cover back with leather, inserting cord head bands. (11) Nip up over cords. (12) Dry in flannel under light pressure. (13) Place corners. (14) Make pattern for sides. (15) Cover sides. (16) Paste back end sheets. (17) Stand open to dry. (18) Close. (19) Set head caps. (20) Press. (21) Finish.

V. FLEXIBLE LIBRARY BINDING

This illustrates a method of binding books of reference, or large books, on tapes, raised bands, French joint, double boards, adherent back, half-bound leather and paper or cloth sides.

Materials and Measurements.

Board: W. O. Davey; 2 pieces—size varies. Blue tint; 2 pieces—size varies.

Paper and cloth, as in III.

Leather: Levant morocco; 1 piece—size varies; 1 piece. 3" x 6".

Silk: Twisted embroidery to match leather.

The Book: "Bookbinding and the Care of Books" by Douglas Cockerell is a suitable book for flexible library binding.

Method of Procedure.

(1) Collate. (2) Take apart. (3) Knock out joint. (4) Clean. (5) Mend. (6) Refold and cut. (7) Press. (8) Make end papers. (9) Mark for five tapes and kettle-stitch. (10) Saw in kettle-stitch. (11) Collate. (12) Place on frame for sewing. (13) String up frame with five tapes. (14) Sew. (See Fig. 12). (15) Attach end sheets. (16) Glue up. (17) Round and back. (18) Get out boards—square back edge. (19) Glue one Davey board and one blue-tint board, $\frac{3}{4}$ width of

board, leaving back open. (20) Press boards. (21) Square boards. (22) File boards to joint. (23) Cut off waste sheet 2" wide from back. (24) Cut off tape a little less than 1" long and paste down. (25) Paste waste sheet, fold over tapes, mitre 1" at corners. (See Fig 15 A and B.) (26) Mark on waste sheet lines the length of book $\frac{1}{8}$ " from back. (27) Remove glue. (28) Cut and color edges of book. (29) Make head bands. (30) Set head bands. (31) Attach boards. (32) Press. (33) Build up bands. (34) Cut pattern of back and corners. (35) Pare leather. (36) Clean edges of boards. (37) Press in tins. (38) Make envelope. (39) Cover back. (40) Set head cap. (41) Tie string over hinge. (42) Fold in flannel under light pressure. (43) Place corners. (44) Make pattern for sides. (45) Place sides. (46) Paste end papers. (47) Close book, tie string, set head cap. (48) Insert waxed paper between end sheets. (49) Fold in flannel under heavy pressure. (50) Finish.

VI. EXTRA BINDING—HALF BOUND

This illustrates the method of binding fine books on raised cords, with half leather, cloth or paper sides, blind tooled title and lines.

Materials and Measurements.

Boards: W. O. Davey; 2 pieces—vary in size.

Paper and leather as in V.

Cord: English—Two-ply—heavy; 5 pieces, 12".

The Book: The Mosher Books; 2 from the Vest Pocket Series.

Method of Procedure.

(1) Collate. (2) Take apart. (3) Knock out joints. (4) Clean. (5) Mend. (6) Refold and cut. (7) Press between boards in standing press. (8) Make end papers. (9) Mark up for five cords and kettle stitch. (10) Saw in kettle stitch. (11) Collate. (12) Place on frame for sewing. (13) String

up frame. (14) Sew. (15) Attach end sheets. (16) Press. (17) Line boards. (18) Fray out slips. (19) Glue up. (20) Round and back. (21) Square boards. (22) File boards to joints. (23) Mark boards for holing. (24) Hole and draw in slips. (25) Press between tins in standing press. (26) Remove glue. (27) Cut edges. (28) Gild edges. (29) Re-cut boards. (30) Nick corners. (31) Work headbands. (32) Set head bands. (33) Nip up and straighten cords. (34) Cut pattern for back and corners. (35) Pare leather. (36) Clean edges of boards. (37) Pare down cords to joint. (38) Set square. (39) Press in tins. (40) Make envelope. (41) Cover back. (42) Set head caps. (43) Fold in flannel to dry. (44) Open up. (45) Place corners. (46) Make pattern for sides. (47) Cover sides. (48) Dry in flannel. (49) Finish with blind tooled title and lines. (50) Paste down end papers. (51) Stand open to dry. (52) Close and press.

VII. EXTRA BINDING—FULL BOUND

This illustrates the extra bound crushed levant book which is the foundation for elaborate applied designs in gold and blind tooling and mosaics. The book in this course is finished with a gold title and straight lines.

Materials and Measurements as in VI.

Method of Procedure.

(1) As in VI through "Nip up and straighten bands." (2) Cut pattern for full leather. (3) Pare leather. (4) Clean edges of boards. (5) Pare down cords to joint. (6) Set square. (7) Press in tins. (8) Make envelope. (9) Cover. (10) Dry in flannel under light pressure. (11) Finish with gold title and lines. (12) Paste down end papers. (13) Stand to dry. (14) Close and press.

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*This is reprinted from the Year Book of the Guild of Book Workers.

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Coy, Hunt & Co. 4th Street and Lafayette.

Cushion, gold. See G.

Dejonge, Louis. 71 Duane Street.

Delacy, George W. 119 East 89th Street.

Dennison Mfg. Co. 15 John Street.

Dividers.

No. 1119—2½"..... .49

7" Compasses. *Hammacher. Austin.*..... .14

Edison Electric Co. 10 Fifth Avenue.

EQUIPMENT.

ELEMENTARY BOOKMAKING

Boards and weights	Snips
German paring knife	Scissors
Bone folder	Rule
Modeling tool	Brushes
Matting tool	Paste and glue
Awl	Oil stone
Knife	Sand and emery paper

BOOKBINDING

Oil stone	Bone point
Plow and press	Wooden scraper
Gas or electric stove	Knife
Lithographer's stone	Rule
Finishing press	Folder
Letter press	Brushes
Standing press	Paring knife
Cutting boards	Glue
Backing boards	Flexible
Sewing frame and keys	Common
English cord	Paste
Soft sewing cord	Burnisher
Linen thread	Polishing iron
English mill board	Steel hammer, large and small
Davey mill board	Alphabets and numbers
Blue tint board	Roulette
Pressing boards	Gold knife
Pressing tins	Violin string
Large and small tri-square	Oil can
Large and small dividers	Sand and emery paper
Shears	Waxed paper
Band nippers	Mending paper
Band stick	Filling in paper
File	Unprinted newspaper
Gold-cushion	Awl
	Saw

Eyelets. <i>United Fast Color Eyelet Co.</i> 205 Lincoln Street, Boston.	
<i>J. K. Krieg</i> , 39 Warren Street, New York.	
Fast Color Eyelet 00-11-100, per 1000.....	\$1.00
Fasteners. <i>U. S. Fastener Co.</i>	
3½ Gilt Plain, per gross.....	\$1.50
Hand machine.....	1.11
File. <i>Hammacher.</i>	
Folder or bone paper cutter. <i>Tower Bros.</i>10
per doz.....	1.00
Gessewin, Fred W. 26 John Street.	
Gilding. <i>Geronimo.</i> 140-142 West 27th Street.	
Glue.	
Dennison's ¼ pt.....	.15
Flexible. 15 lbs.....	3.75
<i>J. F. Tapley Co.</i> 531 West 37th Street.	
<i>Nat. Gum and Mica. Co.</i>	
Ground white. 436 C. 12½c per lb.	
<i>Nat. Gum and Mica. Co.</i>	
Gold cushion. Can be made at home.....	3.00
Gold rubber "dog." <i>Lewis' Car—Mu—Cha.</i>50
<i>Dejonge. Austin.</i>	
Gold lifter. <i>Austin.</i>30
Hall, W. H. 119 Beach Street, Boston, Mass.	
Hamilton Mfg. Co. Rahway, New Jersey.	
Hammacher Schlemmer & Co. Fourth Avenue & 12th Street.	
Hammers. Backing.	
Large	\$1.00
Small	1.25
<i>Austin. Hickok.</i>	
Head banding— <i>Dejonge.</i>	
Hickok, W. O. Mfg. Co. Harrisburg, Pa.	
Hull Grippen & Co. 310 Third Avenue (23-24th St.)	
Iron—See Polishing Iron.	
Japan Paper Co. 34 Union Sq. Represented by	
Albert D. Smith. 35 Thomas Street, N. Y.	
The Paper Mills Co. 319 Fifth Ave., Chicago.	
Stone and Andrews. 310 John Hancock Bldg, Boston.	
Johnson, Faulkner & Co. 35 East 17th Street.	
Kellogg, Alice. 114 East 23rd Street.	
Kemp, W. H. 165 Spring Street.	
Keppel, Fred. 4 East 39th Street.	
Knives.	
German paring knife. <i>Langbein.</i>50
No. 2 Sloyd knife. <i>Hammacher.</i>20
Gold Knife, Common Kitchen Knife or <i>Hickok's.</i>75

Label vellum—See V.

Langein, Chas. 61 Center St.

Leather.

Calf Russia. *Robertson. Willcox.* .40 pr sq. ft. by skin.

By sq. ft. *Palette Art Co.*

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Levant morocco. By skin. *Dejonge. Leclercq.*

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Lifter, gold. See G.

Lindenmeyr, Henry. Bleecker & Mott St.

MATERIALS—ELEMENTARY BOOKMAKING:

Covering

Royal buckram

Book muslin

Leather

Russia calf

Ooze

Am. morocco

Papers

Mending

Japan 117

Japan vellum

Thin Japan

Hurd's bond

Waxed

Unprinted newspaper

Smooth end paper

Rough end paper

Anti rust

Fancy

Silk fibre

Cover paper

Boards

Cloth

S. Wood

Blue Tint

Textiles

Crepe

Chintz

Poplin

Super

Label vellum

Tape, thread and cord

Eyelets

Fasteners

Glue and paste

Mayer, (Robert) & Co. 19 East 21st St.

McGibbon. Broadway & 19th St.

Mending paper—see P.

Metropolitan Hardware Co. 32 Vesey St. Cor. Church.

Miller & Wright. 65 Duane St.

Mosher, Thos. B. Publisher. Portland, Maine.

Muslin book. Book muslin—see B.

National Glue & Mica Co. 502 West 45th St.

National Wax and Paper Co. 199 Franklin St.

Oil can—any Hardware Company.

Oil stone—see S.

Paper.

Y	Anti-rust, 30 x 40—80½ rm. Coy Hunt. Lindenmeyr.....	\$2.75
	Cover.	
	Lincoln Green and Army Brown—22 x 28—50 per sheet.....	.02
	Conrow Bros.	
	Beacon Paper Co. St. Louis, Mo.	
	Carter, Rice & Co. Devonshire St. Boston.	
	Central Ohio Paper Co., Columbus, O.	
	The Paper Mills Co. 319-327 Fifth Ave. Chicago.	
	J. L. Shoemaker & Co. 15 S. 6th St. Philadelphia, Pa.	
	O. F. H. Warner & Co. 156 Congress St. Boston, Mass.	
	Lindenmeyr.	
	Emery paper. Hammacher or Metropolitan Hardware Co.	
	Fancy end and covering. Dejonge. Leclercq. Austin and Kellogg.	
	Filling in. Austin.	
	Cartridge (22 x 31) per sheet.....	.07
	Card middling (22 x 28).....	.06
	Tag board (24 x 36).....	.10
	Hand made.	
	Dejonge. Seymour—Japan Paper Co.	
	Miller & Wright.	
	Austin.	
	The O. W. Paper & Arts Co. 100 Great Russell Street,	
	W. C. London.	
	Mending. Hurd's 7002 Correspondence Typewriting Bond Crown	
	water mark. Any stationers, per box.....	1.70
	Japan mending vellum No. 2, per doz.....	.50
	Japanese Thin, No. 4, per doz.....	.30
	Japanese Heavy, No. 117, per doz.....	.20
	Austin.—Japan Paper Co.	
	Sand paper. Hammacher or Met. Hardware Co.	
	Silk fibre "Eltonbury" per yd.....	.15
	Austin. Kellogg.	
	Unprinted newspaper. Austin. per 100 sheets.....	.65
	½ Ream. Lindenmeyr.....	.75
	Waxed.	
	B. K. White, per ream.....	4.25
	per quire.....	.50
	Nat. Wax and Paper Co.	
	White End sheets, per sheet.....	.02
	Smooth—White Antique Japan vellum, 25 x 30—80.	
	Rough—White Japan Plate, 21 x 38—80.	
	Seymour Co.	
	Palette Art Co. 56 East 23rd Street.	

Paste. <i>Arabol Mfg. Co.</i> also by gal. at <i>McGibbons</i>75
Plow Eng. Knife.....	6.00

Polishing Iron.

Round	3.50
Flat	2.00

Austin. Hickok.

Presses.

Laying—Special size.....	9.00
Stand for press. <i>Hickok</i>	11.00
Finishing—14" bet. screws.....	2.25
Standing, No. 00. <i>Hickok</i>	27.00
Letter— <i>Macy</i>	4.00
Sewing—see S.	

Processes.

Those marked * belong to Elementary Bookmaking.

*Collate	Hole and draw in slips
*Take apart	Press
Knock out joint	Remove glue
Clean	Cut edges
*Mend	Gild or color edges
*Refold and cut	Re-cut boards
Press	Nick corners
*Mark up for sewing	Work head bands
Saw in kettle stitch	Set headbands
*Make end papers	Nip up and straighten bands
Whip-stitch	*Cut pattern
Flatten thread	*Pare leather
*Collate	*Clean edges of boards
Place on frame for sewing	Pare down cords to joint
String up frame	Set squares
*Sew	Press in tins
*Attach end sheets	Make envelope
Press	*Cover
*Line boards	Fold in flannel
Fray out slips	Press lightly
*Glue up	Open up
Round and back	*Finish
*Square boards	*Paste down end papers
File boards to joints	*Stand open to dry
Mark boards for holing	*Close and press

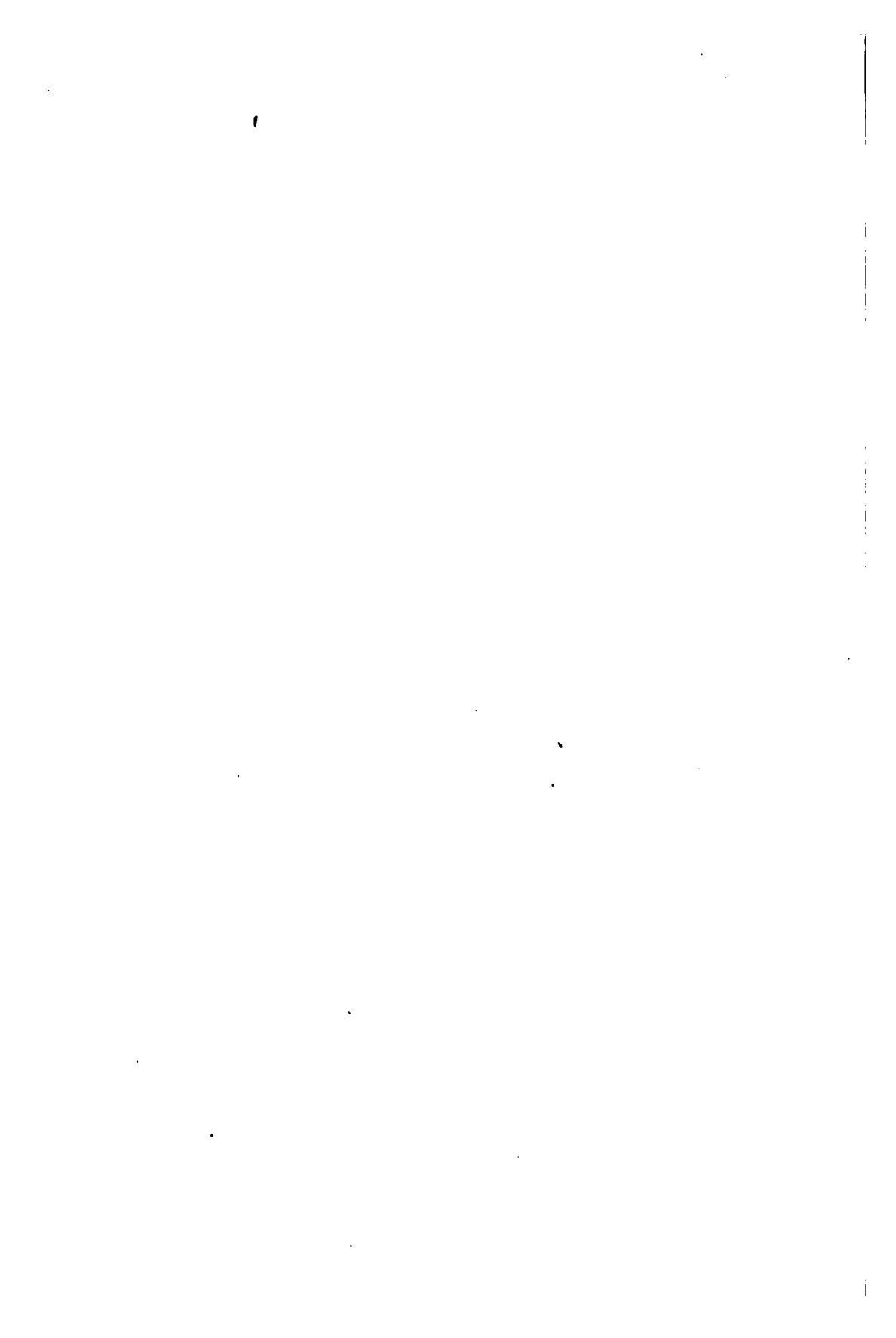
Punches—steel.

Hollow No. 7.....	.16
Solid No. 7.....	.16

Hammacher.

Robertson, L. F. & Sons. 37 Spruce St.

Roulette. Single line. *Austin. DeLacy*..... 2.75



Rubber, gold—see G.	
Rule. Chesterman steel 12". <i>Hammacher</i>50
Saw. <i>Austin. Hammacher</i>60
Schirmer, C. 35 Union Square.	
Scraper, wooden. <i>Austin</i>50
Sewing frame or press and keys. <i>Hickok or Austin</i>	2.00
small size 18 in. bet. screws. <i>Hamilton</i> .	
Seymour Co. 76 Duane.	
Shears. <i>Hammacher</i> .	
Metal No. 11 Compton snips.....	.72
Cloth & paper—8½" straight trimmers. Jap handles.....	.54
Silk-fibre paper—see P.	
Snips or metal shears. <i>Hammacher</i> . No. 11 Compton snips.....	.72
Squares. <i>Hammacher. Austin</i> .	
Large tri sq. No. 20-9".....	.33
Small tri sq. No. 20-3".....	.15
Stand for laying press. <i>Hickok</i>	11.00
Stones, lithographer's. <i>Mayer</i>75
Stone, oil. Carborundum stone. <i>Best</i>60
Stoves. Gas—one burner. Electric—6 in. plate. <i>Edison</i>	7.00
String, violin—see V.	
Super. <i>Dejonge</i> . No. 134, per bolt.....	1.40
Tape. <i>Kellogg</i> . Tying—unbleached—1000 yds.....	3.50
Sewing—linen. <i>Austin</i> . Any dry goods store.	
Textiles.	
Rep or cotton poplin, per yd. <i>R. H. Macy. Wanamaker</i>19
Cotton crepe. <i>Vantine's. Kellog</i>35
Chintzes, etc. <i>Kellog. Johnson. Faulkner</i> .	
Thread.	
Imported Irish linen—4 sizes, per skein. <i>Austin</i>08
Barbour's spool No. 30-40.	
<i>Leclercq</i> . by pkg. of 33 skeins, No 40.....	1.00
Tins. <i>Austin. Hull Grippen</i> .	
Tools. <i>Palette Art Co</i> .	
Modeling35-.60
Matting50
Tower Bros. 23 West 23rd Street.	
Trimmers, straight—see S.	
United Fast Color Eyelet Co. 205 Lincoln Street, Boston.	
United States Fastener Co. 95 Milk Street, Boston.	
Varnish, French, <i>Zinsser, Wm</i> . 197 William St.	
Vellum label, per yd. <i>Dejonge</i>23
Violin String. <i>Schirmer</i> .	
A.25
D.30
Wemple, Jay C. 35 East 20th Street.	
Willcox, M. B. 28 Spruce Street.	

