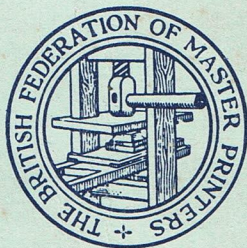


# BOOK IMPOSITIONS

1962

*This edition supersedes all previous editions*



THE BRITISH FEDERATION OF  
MASTER PRINTERS

11 BEDFORD ROW, LONDON, W.C.1



# BOOK IMPOSITIONS

1962

## FOREWORD

This booklet, which supersedes all previous editions, specifies the custom of the trade in the matter of impositions in book printing, marks to be incorporated by the printer, the slitting of sheets on the printing machine and the method of packing and labelling. It is produced for the benefit of book printers, bookbinders and their customers.

The changes as compared with the 1956 edition are that the instructions have been clarified and brought into line with current practice both on pages 2 and 3 and on the imposition diagrams themselves. No additional impositions have been introduced,

L. E. KENYON, Director,  
British Federation of Master Printers,  
11 Bedford Row, London, W.C.1

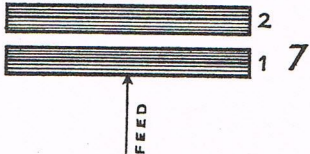
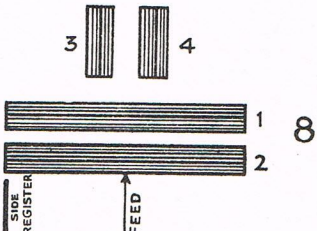
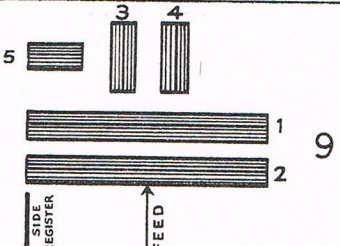
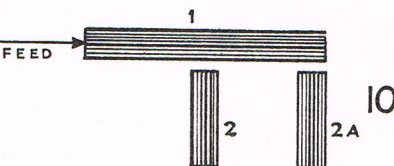
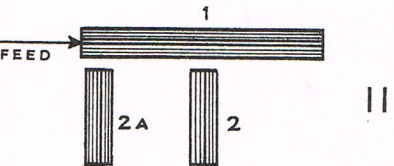
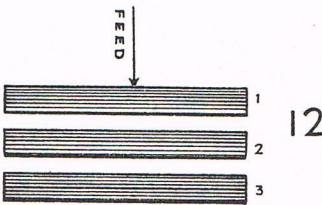
## FOOTNOTE

The first edition of Book Impositions was produced in 1927 by the Master Bookbinders Association and it was welcomed by publishers, printers and binders. In 1936 the Association, in co-operation with the British Federation of Master Printers, compiled a new edition which was a considerable extension of the original book. This, too, proved of immense value to all engaged in the production of books. In 1946 a reprint of the 1936 edition was produced by the British Federation of Master Printers and, subsequently, following careful work by a sub-committee of the Book Printers and Publishers Binders Sections of the Federation a new edition, incorporating revisions and extensions, was produced in 1956.

# PLAN INDEX

## IMPOSITIONS

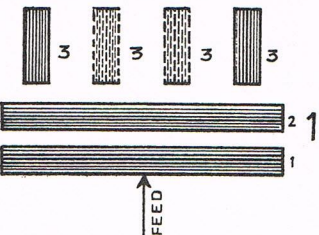
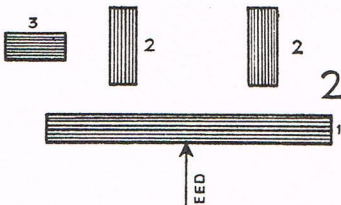
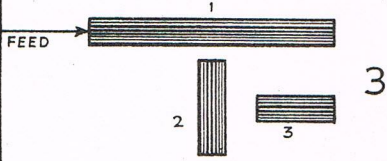
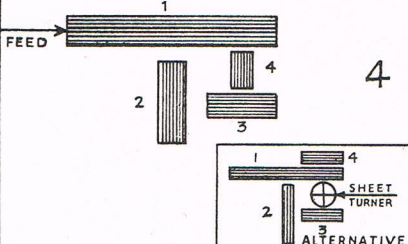
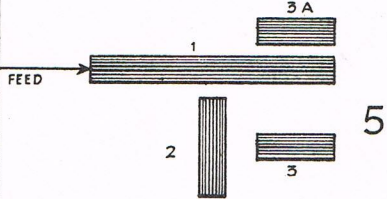

DIAGRAMS OF  
FOLDING MACHINE ROLLS

<p>8 PP. TWO PARALLEL FOLDS FOLDS USED: 1, 2 IMPOSITION LETTERS:— R, R1</p>	 <p>7</p>
<p>32 PP. TWO PARALLEL, TWO CROSS FOLDS FOLDS USED: 1, 2, 3, 4 1, 2 &amp; 4 BUCKLE FOLDS, 3 KNIFE FOLD IMPOSITION LETTER:— S</p>	 <p>8</p>
<p>64 PP. TWO PARALLEL, TWO CROSS, ONE RIGHT ANGLE FOLDS USED: 1, 2, 3, 4, 5 1, 2 &amp; 4 BUCKLE FOLDS, 3 &amp; 5 KNIFE FOLDS IMPOSITION LETTER:— T</p>	 <p>9</p>
<p>16 PP. TWO UP TWO RIGHT ANGLE, ONE PARALLEL FOLDS USED: 1, 2, 2A IMPOSITION LETTERS:— U, U1</p>	 <p>10</p>
<p>16 PP. TWO UP TWO RIGHT ANGLE, ONE PARALLEL FOLDS USED: 1, 2, 2A IMPOSITION LETTERS:— W, W1</p>	 <p>11</p>
<p>16 PP. EIGHT UP THREE PARALLEL FOLDS USED: 1, 2, 3 IMPOSITION LETTER:— X</p>	 <p>12</p>



# IMPOSITIONS

## DIAGRAMS OF FOLDING MACHINE ROLLS

<p>TWO 32 PP. (16 PP. INSERTED 16 PP.) IMPOSITION LETTERS:— A, Ai, C* OR FOUR 16 PP. SECTIONS (CONTINUOUS) IMPOSITION LETTERS:— B, Bi, C QUAD MACHINE FOLDS USED: 1, 2, 3</p>	
<p>ONE 32 PP. (16 PP. INSERTED 16 PP.) IMPOSITION LETTERS:— D, Di, F OR TWO 16 PP. SECTIONS (CONTINUOUS) IMPOSITION LETTERS:— E, Ei, G DOUBLE SIXTEEN MACHINE FOLDS USED: 1 2 3</p>	
<p>16 PP. THREE RIGHT ANGLE FOLDS FOLDS USED: 1, 2, 3 IMPOSITION LETTERS:— H, Hi, J, Ji, K, Ki, Z</p>	
<p>32 PP. FOUR RIGHT ANGLE FOLDS FOLDS USED: 1, 2, 3, 4 IMPOSITION LETTERS:— L, Li, M</p>	
<p>32 PP. TWO UP THREE RIGHT ANGLE, ONE PARALLEL FOLDS USED: 1, 2, 3, 3A IMPOSITION LETTERS:— N, Ni, O</p>	
<p>16 PP. THREE PARALLEL FOLDS FOLDS USED: 1, 2, 3 IMPOSITION LETTERS:— P, Q</p>	

## IMPOSITIONS

### DIAGRAMS OF FOLDING MACHINE ROLLS

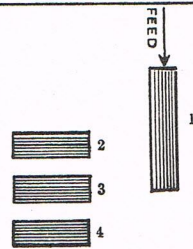
32 PP. FOUR UP

ONE RIGHT ANGLE, THREE PARALLEL

FOLDS USED : 1, 2, 3, 4

IMPOSITION LETTER :—

Y



13

IT SHOULD BE UNDERSTOOD THAT THE DIAGRAMS OF FOLDING ROLLS GIVEN ARE ESSENTIAL FOR FOLDING THE IMPOSITION NUMBERS QUOTED, BUT IN MANY CASES THE FOLDING MACHINES MAY ALSO BE FITTED WITH ADDITIONAL FOLDING ROLLS WHICH COMBINE SEVERAL OF THESE DIAGRAMS, E.G. A FOUR RIGHT ANGLE MACHINE MAY ALSO INCLUDE DOUBLE THIRTY-TWO FOLDING ROLLS COMBINING DIAGRAMS Nos. 4 & 5, AND IN OTHER MACHINES STILL MORE.



IMPOSITION Q

PLAN 6

Slit on printing machine to fold as Imposition P.  
64 pp. forme work and turn.  
Four 16 pp. sections continuous.

PRINTING MACHINE SIDE LAY

Diagram showing the layout of Imposition Q, a 4x16 grid of pages. The grid is divided into four sections (A, B, C, D) by vertical lines labeled 'FOLDING MACHINE PITCH EDGE'. The pages are numbered 1 through 64. The layout is as follows:

Section	Row 1	Row 2	Row 3	Row 4
A	1	16	9	8
B	17	32	25	24
C	33	48	41	40
D	49	64	57	56
A	5	21	28	29
B	20	36	45	44
C	53	60	61	62
D	59	68	65	63
A	11	12	13	14
B	26	27	28	29
C	37	38	39	40
D	50	51	52	53
A	6	7	10	15
B	22	23	26	31
C	34	35	38	43
D	47	48	51	56
A	2	3	4	1
B	18	19	20	17
C	30	31	32	29
D	42	43	44	41

Labels: SLIT ON PRINTING MACHINE THROUGH SLITTER MARKS, SLITTER MARK, FOLDING MACHINE PITCH EDGE, PRINTING MACHINE SIDE LAY, FOLDING MACHINE PITCH EDGE, SLITTER MARK.

SUBJECT TO INSTRUCTIONS GIVEN ON PAGES 2 AND 3

IMPOSITION O

Diagram showing the layout of Imposition O, a 4x16 grid of pages. The pages are numbered 1 through 64. The layout is as follows:

1	16	31	46	61
2	17	32	47	62
3	18	33	48	63
4	19	34	49	64
5	20	35	50	65
6	21	36	51	66
7	22	37	52	67
8	23	38	53	68
9	24	39	54	69
10	25	40	55	70
11	26	41	56	71
12	27	42	57	72
13	28	43	58	73
14	29	44	59	74
15	30	45	60	75
16	31	46	61	76

IMPOSITION P

Diagram showing the layout of Imposition P, a 4x16 grid of pages. The pages are numbered 1 through 64. The layout is as follows:

1	16	31	46	61
2	17	32	47	62
3	18	33	48	63
4	19	34	49	64
5	20	35	50	65
6	21	36	51	66
7	22	37	52	67
8	23	38	53	68
9	24	39	54	69
10	25	40	55	70
11	26	41	56	71
12	27	42	57	72
13	28	43	58	73
14	29	44	59	74
15	30	45	60	75
16	31	46	61	76