The Terms and Tools used in Bookbinding.

As apprentices and others are constantly writing us, concerning the meaning of various technical terms used in the trade, we this month give for their information a roughly compiled glossary.

All-along.—When the thread passes from end to end in each sheet, the volume is said to be sewed “all-along.”

Arming Press.—A blocking press used by hand.

Backing-boards.—These boards are of hard wood, and they are wedge-shaped, so that when used in the lying press, the whole power of the press is conveyed to the back of the book.

Bands.—The cord wherein the sheets of a volume are sewn. When a book is sewn “flexible,” the bands appear upon the back. Band nippers are used for nipping up the back in covering.

Beading.—The small twist formed by the twisting of the silk or cotton in head-banding.

Bevelled-boards.—Heavy boards with bevelled edges, used in antique work.

Bleeding.—Cutting into the print of a book.

Blind-tooling.—Tooling without gold.

Blocks.—Blocks or plates are the engraved stamps used on the blocking press.

Bodkin.—A steel point used for making the slip or lace holes through the boards.

Bole.—A red mineral used in the preparation for gilding edges.

Bosses.—Ornaments fixed on the covers of books for decoration and preservation.

Burnishers.—Pieces of agate or blood-stone affixed to stout handles.

Cancels.—Leaves containing errors which are to be cut out and replaced by corrected pages.

Cap.—The paper used to protect the edges, while the volume is being covered and finished.

Case-work.—This is the binding of books in covers specially made in quantities, mostly cloth-work.

Centre-tools.—Tools cut for finishing the centre of panels and sides.

Clearing-out.—Removing the superfluous leather and paper before pasting down the end papers.

Combs.—Instruments with wire teeth used in marbling.

Cropped.—Cutting a book down too much.

Divinity Calf.—A dark brown calf used mostly for religious books.

Dentelle.—Finishing with very fine tools in a manner resembling lace-work.

Edge Rolled.—When the edges of the boards are rolled either in blind or in gold.

Fillet.—A wheel-tool used in finishing, the edge being engraved with lines or pattern.

Finishing.—The ornamentation of the cover of a volume.

Finishing Press.—A small lying press that can be conveniently handled.

Flexible.—When a book is sewn on raised bands, and the thread is passed entirely round each band.

Foredge.—The front edge of a book.

Forwarding.—The binding of sewn books up to the stage of placing them in leather.
**Full-bound.**—When the sides and back of a book are covered with leather.

**Glair.**—The white of eggs beaten up.

**Gouge.**—A finisher’s tool that forms the segment of a circle.

**Graining boards and plates.**—Engraved boards used for producing a grain on calf and Russia leather.

**Guides.**—The groove in which the plough moves upon the face of the cutting press.

**Guinea-edge.**—A roll with a pattern similar to the edge of an old guinea.

**Half-bound.**—When a volume is covered with leather upon the back and corners, and the sides with paper or cloth.

**Head band.**—The silk or cotton ornament worked at the head and tail of a volume as a finish.

**Kettle-stitch.**—The chain-stitch which the sewer makes at the head and tail of a book.

**Laced or drawn in.**—When the millboards have been attached by means of the slip.

**Law Calf.**—The uncoloured calf used for law books.

**Marbling.**—The art of floating various colours on a size, from which it is transferred to paper or book edges.

**Mitered.**—The meeting of finisher’s lines at right angles without overrunning.

**Out of boards.**—Cutting a book before the boards are affixed.

**Out of truth.**—A book that is not cut square.

**Paring.**—Reducing the edges of leather.

**Paste wash.**—Paste diluted with water.

**Piece.**—Any space that has another leather upon it, as a lettering piece.

**Polisher.**—A steel instrument for glossing leather.

**Press-pin.**—An iron lever-bar for presses.

**Pressing-boards.**—Boards used for pressing books between.

**Pressing-blocks.**—Blocks of wood used for filling up a standing press when there are not enough books.

**Rasper.**—Taking the edge off millboards.

**Run-up.**—When the back has a fillet run from head to tail without being mitered at each band.

**Runner.**—The front board used in cutting edges.

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**The New York Grolier Club.**

A recent number of the *Century Illustrated Monthly Magazine* gives an interesting account of the New York Grolier Club. The Grolier Club is a gathering of those who love books for their external beauty, especially for the decorative skill displayed on the binding. The club is named after Jean Grolier de Servier, Viscount d’Aquisy, Treasurer-General of France, who was not, as many imagine, a bookbinder by trade, but a book-lover, choosing the best impressions of the best books, and having them bound by the best binders under his own supervision. The article continues: "Of the founders of the club, some were merely book-lovers from taste and some were book-makers by trade; and thus the club began with a novel and fertile alliance of the dilettante and the professional—an alliance likely to be of lasting benefit to both. The object of the club was in reality
The Terms and Tools used in Bookbinding.

(Continued from p. 101).

Sawing-in.—When the back is sawn for the reception of the cord in sewing.

Setting the Head-band.—Adjusting the leather in covering so as to form a cap to the head-band.

Sewing-machine.—A recent invention for the sewing of books with wire instead of thread.

Shaving-tub.—The paper cut from the edges of a volume are called shavings. The receptacle into which they fall while the forwarder is cutting is termed the shaving-tub.

Signature.—The letter or figure under the footline of the first page of each sheet to indicate the order of arrangement in the volume.

Size.—A preparation used in finishing and gilding; formerly made with vellum, but can now be bought ready for use.

Slips.—The pieces of twine that project beyond the back of the volume after it is sewn.

Squares.—The portions of the boards that project beyond the edges after the book is cut.

Stabbing.—The term used formerly for piercing the boards with a bodkin for the slips to pass through; more generally known now as "holeing." The operation of piercing pamphlets for the purpose of stitching.

Stabbing-Machine.—A small machine used for making the holes through the backs of pamphlets.

Standing-press.—A fixed heavy press, with a perpendicular screw over the centre.

Start.—When any of the leaves are not properly secured in the back, and they project beyond the others, they are said to have started. When the back has been broken by forcing the leaves, they start.

Stiffener.—A thin mill-board used for various purposes.

Stitching.—The operation of passing the thread through a pamphlet for the purpose of securing the sheets together.

Straight-edge.—A small board having an edge perfectly straight.

Steps.—Small circular tools, adapted to "stop" a fillet when it intersects at right angles; used to save the time mitreing would occupy.

Tenon Saw.—A small saw used by bookbinders for sawing the books for sewing. More strictly speaking, a carpenter's tool.

Title.—The spaces between the bands upon which the lettering is placed. The leaf in the beginning of a book describing the subject.

Tools.—Applied particularly to the hand-stamps and tools used in finishing.

Trimming.—Shaving the rough edge of the leaves of a book that is not to be cut.

Trindle.—A thin strip of wood or iron.

Turning-up.—The process of cutting the foredge in such a manner as to throw the round out of the back until the edge is cut. All books that are cut in boards have a pair of trindles thrust between the boards and across the back to assist the operation.
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Tying-up.—The tying of a volume after the cover has been drawn on, so as to make the leather adhere to the sides of the bands; also for setting the head-band.

Type.—Metal letters used in printing and lettering.

Type-holder.—An instrument for holding the type when used for lettering.

Varnish.—Used as a protection to the glaire when polished on the covers of books.

Whipping.—Another term for overcasting, but when longer stitches are made.

Witness.—When a volume is cut so as to show that it has not been so cut down but that some of the leaves have still rough edges, these uncut leaves are called “witness.”

Wrinkle.—The uneven surface in a volume, caused by not being properly pressed, or by dampness; also caused by improper backing.

[For much of the above information we are indebted to the works of Mr. Zaehnsdorf.]

**New Method of Book Sewing.**

Our New York contemporary gives detailed particulars of an improved method of bookbinding. The improvement is more particularly adapted to that class of books in which the binding cords are inserted lengthwise of and lie within and continuously along the folds of the signatures in lieu of being threaded in and out, as in hand bookbinding. Its object is to produce a neat binding—one stronger than the ordinary hand binding, and, furthermore, so applied and arranged that it approximates somewhat to the hand sewing, and can be produced automatically by mechanism. Fig. 1 is a perspective view of a series of signatures united by this method of binding. Fig. 2 is a section through the fold of a signature and transversely of the holding cords or bands. Fig. 3 is a plan of a part of a signature. Fig. 4 is a perspective view of a series of signatures laid in position and showing the bandways or slots formed by the holes punched in each signature separately.

The purpose is to secure each signature firmly for its entire length to the adjoining and contiguous signatures in lieu of at intervals, as now practised in the ordinary method of hand sewing; furthermore, to obviate the use of a single binding thread, which is to be passed in and out about the holding cords and signatures and made to pass from one signature to the