



BINDWEL MASTERCLASS BOOKS OF MISTAKES WEBINAR

Your Guide to a Zero-Rejection Workflow

OCTOBER 9, 2025

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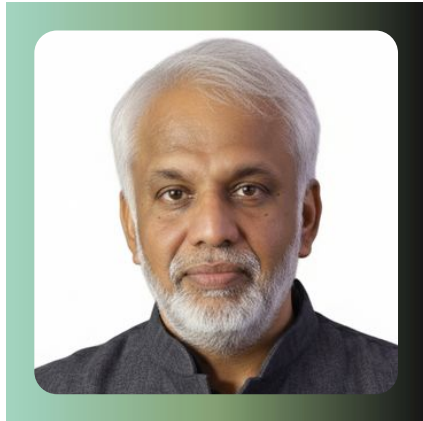
SESSION GUIDELINES



- **Audio & Video Status:** To ensure a smooth experience for all participants, all attendees have been **muted** and their **videos are off** by default.
- **Participation is Encouraged:** Please answer our quick **Poll Questions** to help us tailor the discussion.
- **Submit Questions:** Post your questions anytime in the **Q&A box ONLY**.
- All questions and messages are confidential and seen only by the organizers.
- **Q&A Timing:** We will address all questions during the dedicated segment at the **end** of the presentation.
- **Technical Issues:** If you have trouble posting a question, you may use the **Raise Hand** feature *during the Q&A segment* to be unmuted.



SPEAKERS



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AGENDA

01 Context

02 Why this session matters?

03 Planning & Substrate Selection

Mistakes
04 Lamination Failures

05 Process & Handling Errors

06 Paper & Environment Issues

07 Machine & Maintenance Problems

08 BindRight Program

09 Q&A

Poll 1

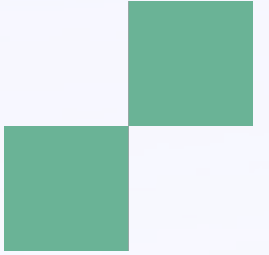


What do you think is the biggest cost in book printing?

Options: Paper | Adhesives | GST | Rejections



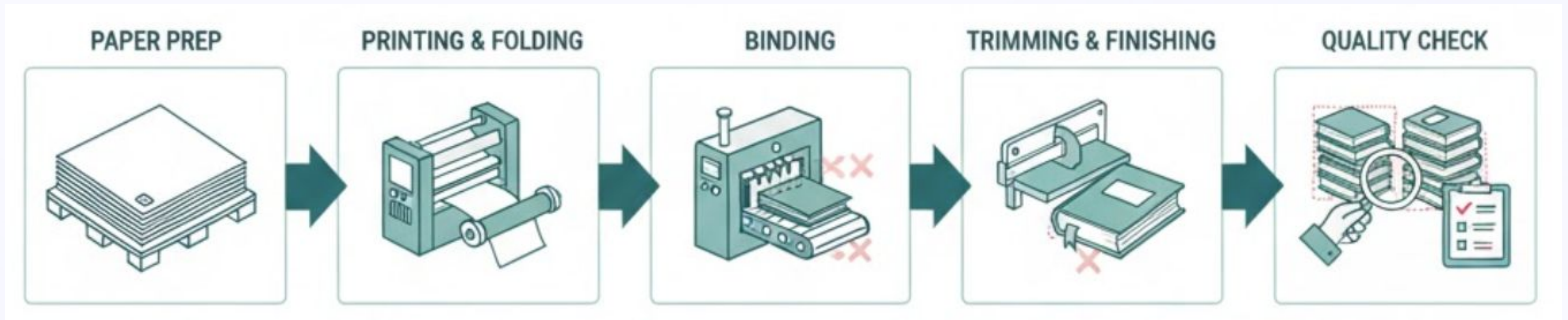
THE BIGGEST COST NOBODY TALKS ABOUT



- Printers debate paper, adhesives, GST... but rejections bleed the most.
- Every 1 % rejection = thousands of books wasted + loss of margin + lost customer

Story: *One of the book printers imported adhesive from South-East Asia for years without issues. But one winter batch turned brittle. Books bound in cool December conditions failed months later under summer heat. Thousands of school books were rejected—proof that even trusted materials need testing across temperature zones before large-scale production.*





Why This Session Matters



Stages

Printers face rejections across all stages: planning, paper, adhesives, machines, processes.



Root Causes

Each rejection has a **root cause** — often small, but costly.



Today's Focus

Today: we'll exhibit some failures and share preventive actions.



CATEGORY 1 – PLANNING & SUBSTRATE SELECTION MISTAKES

It All Starts With Planning

- Wrong choices at the substrate/planning stage
= cascading failures
- Two common disasters: Multiple cover issues
+ FPLP (First Page Last Page opening).



Poll #2

Do you face frequent cover creasing issues in your press?

Yes | No



COVER CRACKING FAILURE

Problem

Cover cracking or creasing fails to open smoothly.

Impact

Damages usability & aesthetics → customer complaints.

Root Causes:

- Selection of cover material
- Improper creasing depth

Solutions:

- Select correct board & grain direction
- Proper creasing channel depth setup



FPLP (Front/Back/Side Lifting Problem)



Problem

Covers lift from spine or edges.

Impact

Rejections in export shipments, higher complaints.

Root Causes:

- Cross grain or mixed grain signatures/ wrong grain direction of covers, signatures
- Wrong adhesive grade / roller setting

Solutions:

- Use grain direction that is parallel to the spine for both cover & signatures.
- Adjust rollers & adhesive settings



CATEGORY 2 – LAMINATION FAILURES

When Films Fail

- Adhesives in lamination are invisible but critical.
- In both Thermal and Wet laminations the surface energy of the film and paper are important



Poll #3

Which lamination failure is most common in your press?

Silvering | Delamination | Wrinkling | All the above



SILVERING

Problem

Visible silver line on the crease area of the cover.

Impact

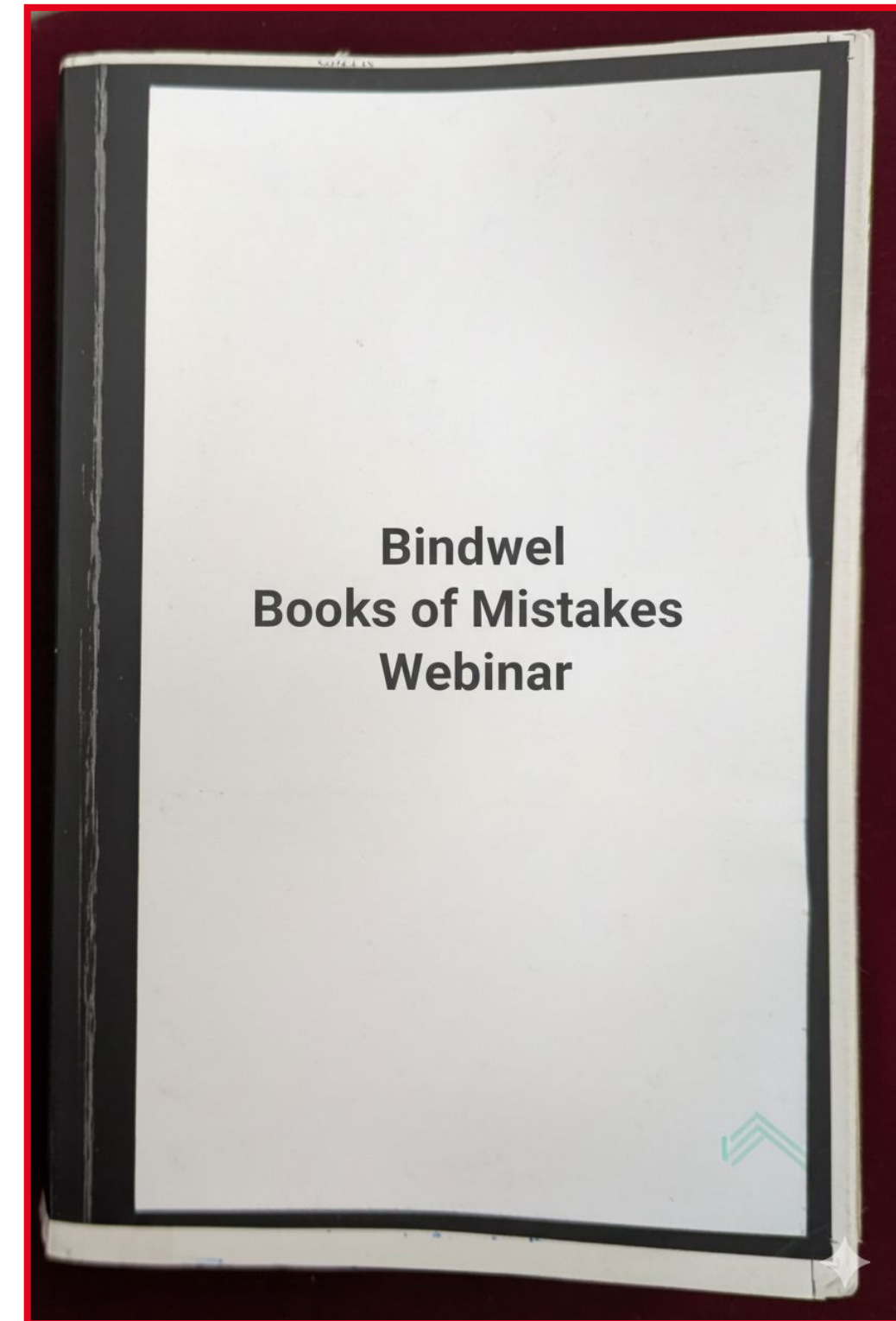
Looks cheap, rejected by publishers.

Root Causes:

- Wet lamination: poor adhesive bonding
- Thermal lamination: improper heat/film

Solutions:

- Use corona-treated films
- Monitor temperature & roller pressure with respect to machine's speed.



DELAMINATION

Problem

Cover film peels off completely.

Impact

Shipment rejected at QC.

Root Causes:

- Wrong/ Inadequate adhesive - Wet Lamination
- Improper machine temperature/pressure - Thermal lamination
- Non-corona treated film
- Improper moisture content

Solutions:

- Correct adhesive grade
- Ensure proper curing time
- Calibrate lamination machine with respect to temperature, pressure and speed settings.



CATEGORY 3 – PROCESS & HANDLING ERRORS

Handling Matters as Much as Machines

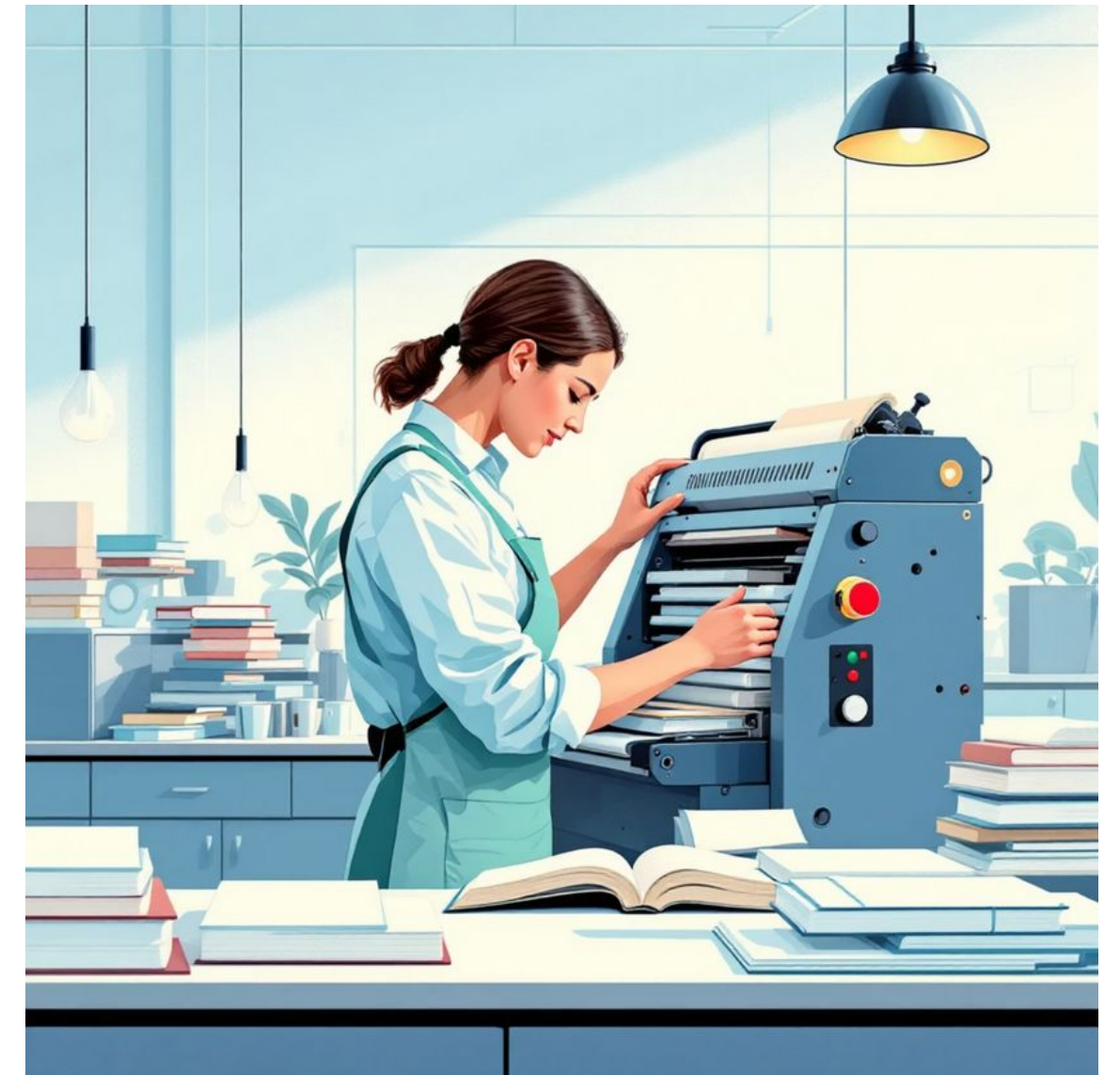
- Signature mismatch is one of the most reasons for rejections.
- Handling and movement of signatures in the workflow are critical.



Poll #4

Do you gather signatures of your books manually ?

Yes | No



BLOWHOLES ON SPINE



Problem

Gaps/holes on spine after binding.

Impact

Poor look lead to rejected shipments.

Root Causes:

- Poor pressing & bundling of signatures
- Bounce-back at head-side

Solutions:

- Press & bundle properly
- Correct signature alignment
- Perforation while folding



CROW's FEET



Problem

Extra lines/folds at spine edge.

Impact

Weakens book structure, reduces shelf life.

Root Causes:

- Folding without perforation
- Poor folding alignment

Solutions:

- Head-side perforation
- Train folding operators



CATEGORY 4 – PAPER & ENVIRONMENT

ISSUES

Paper & Environment: Silent Killers

- Paper reacts to the environment more than we realize.
- Grain direction, humidity, trimming errors = top rejection causes.



Poll #5

What's your biggest challenge when it comes to paper?

Moisture | Grain Direction | Others



GROWTH OF PAPER AFTER TRIMMING



Problem

Uneven edges of the books - developed much after trimming.

Impact

Unacceptable.

Root Causes:

- Web growth due to mixed grain
- Paper not acclimatized

Solutions:

- Store paper in controlled environment
- Acclimatize before use
- Avoid mixed grain lots



MOUSE TRAP



Problem

Inability to keep the book open for reading.

Impact

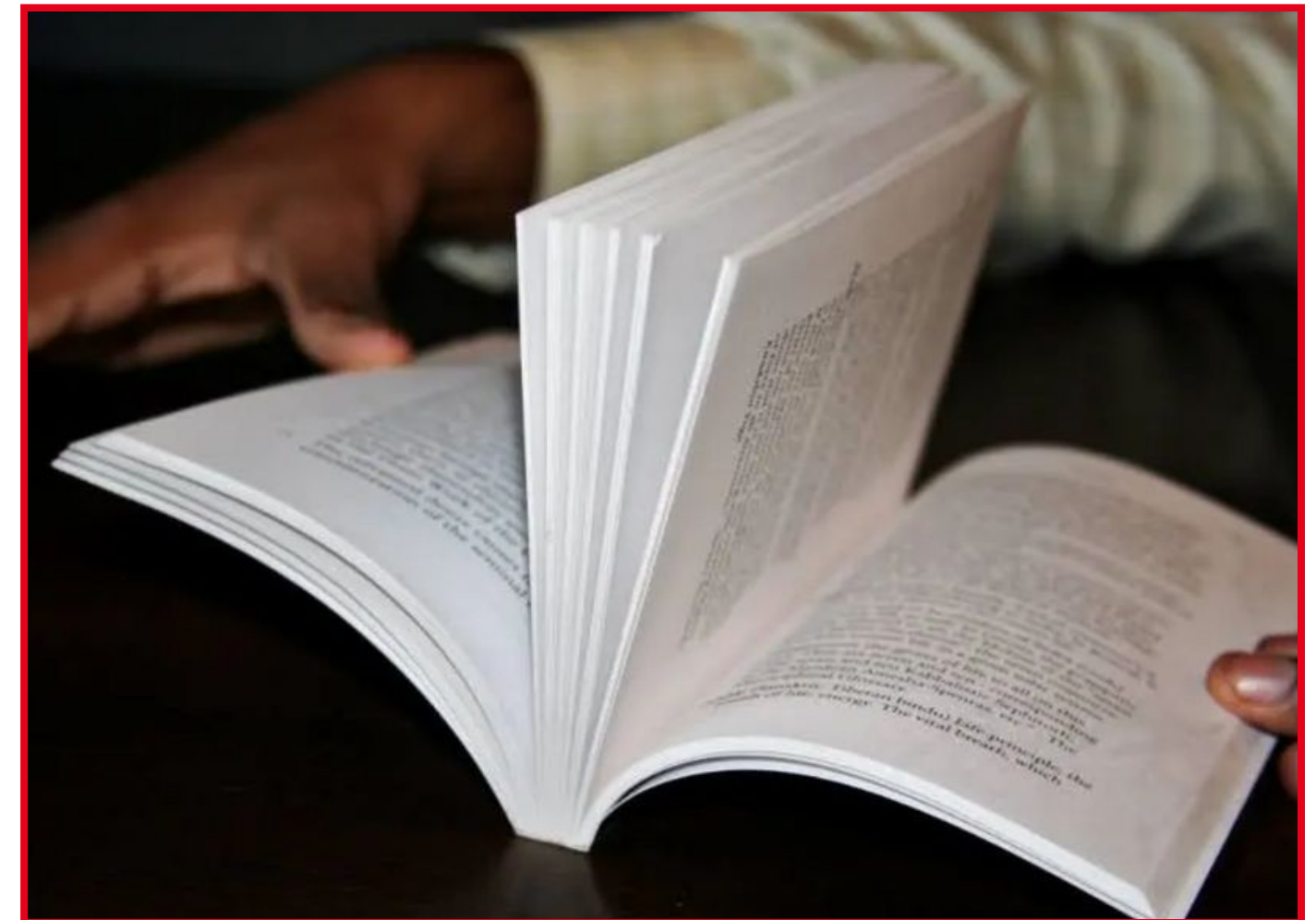
Severe usability rejection.

Root Causes:

- Cross grain paper selection

Solutions:

- Always align grain parallel to spine
- Control substrate sourcing



CATEGORY 5 – MACHINE & MAINTENANCE PROBLEMS

A Machine Is Only as Good as Its Maintenance

- Blunt knives, wrong settings, unclean glue pot = instant rejections.
- Prevention is cheaper than reprints.



Poll #6

Do you follow preventive machine maintenance schedules?

Always | Sometimes | Rarely



POOR SPINE PREP

Problem

Adhesive doesn't penetrate properly → loose pages.

Impact

Weak spine → mass rejection.

Root Causes:

- Blunt milling cutter / improper notching

Solutions:

- Periodic replacement of blunt milling cutter
- Correct depth and interval calibration



GLUE STRING / EXCESS SPINE GLUE



Problem

Thin glue strings spoiling the cover spine appearance.

Impact

Pages fall off → biggest rejection reason.

Root Causes:

- Low temperature
- Wrong reverse roller settings
- Excess adhesives

Solutions:

- Maintain adhesive at right temp
- Use inline string removers



KEY TAKEAWAYS



- **Rejection is the Silent Profit Killer**

Every rejected book drains time, money, and trust. The biggest cost in book printing isn't materials — it's rework and rejection.

- **Binding Failures Begin Long Before Binding**

Most bookbinding problems trace back to earlier stages — paper selection, grain direction, or improper planning — not the final stitch or glue line.

- **Plan Like a Pro — Process and Materials Together**

Successful binding starts on the drawing board. Match the process, paper, and adhesive to the job — precision in planning prevents costly surprises.

- **Never Cut Corners with Grains**

Grain direction isn't a small detail — it's the backbone of a well-bound book. Always respect the grain.

- **Moisture is the Invisible Enemy**

Paper and adhesives are alive to humidity. Acclimatize materials before production — or risk chaos in quality.

- **Train. Retrain. Repeat.**

Machines can't fix what people don't know. Skill and awareness make the biggest difference — invest in your team continuously.



BINDRIGHT PROGRAM

From Rejections to Process Excellence

- BindRight = Diagnostic + Preventive + Deep Learning program.
- Offers: Adhesive audits, machine calibration, operator training.
- Got a rejected or failed book? Send it to us — our experts will identify the issue and guide you toward a fix.



Bind
Right



Poll #7

Would you like a BindRight audit for your press?

Yes | No





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