

Using the Perfect Binder with Xerox[®] FreeFlow[®] Print Server

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Table of Contents

- Xerox® FreeFlow® Print Server 1
 - 1.0 Introduction.....1
 - 1.1 Perfect Binder Terminology1
 - 1.2 Workflow Options.....1
 - 1.3 Tips for Size and Paper Selection2
 - 2.0 Perfect Binder Operations.....4
 - 2.1 Manual Mode Procedure.....4
 - 2.2 Print Book Block and Bind with Pre-Printed Covers.....7
 - 2.3 Print & Bind from Single File that Contains both Cover and Book Block10
 - 2.4 Print & Bind from a Single File with all Book Block Pages.....12
 - 3.0 Additional Information..... 16
 - 3.1 Caveats16

1.0 Introduction

1.1 Perfect Binder Terminology

- **Definition of terms**

Cover Stock: Media used to cover the book.

Book Block: Media used for pages contained within the book, untrimmed size. The Cover Stock wraps around the Book Block.

Trim Size (or Finished Size): The size of the finished bound book.

- For the Perfect Binder User Guide, refer to chapter 13:
(<http://xwww.docushare.world.xerox.com/dsweb/View/Collection-1062895>)

1.2 Workflow Options

You have several options for printing and binding documents using FreeFlow Print Server with the Xerox Perfect Binder. These options differ according to the layout of the job files and whether you want to manually feed book blocks or use the binder in normal online mode with the press. Your workflow options include:

- **Operate the binder in Manual Mode**

To use Manual Mode, both covers and book blocks are preprinted. The Perfect Binder is placed in Manual Mode and covers are fed from a tray to the binder while book blocks are manually placed in the binder, one at a time, for finishing.

- **Print book block and bind with pre-printed covers**

Covers are preprinted on large stock, at least 2x the book block size, and loaded into a tray. A single file containing the book block is then printed at the press and sent to the binder where the covers are automatically fed and bound to the book block.

- **Print and bind from a single file that contains the cover and the book block**

A single file is created in pre-press that contains a large first sheet to serve as a wrap-around cover. The remainder of the pages in the file is book block size. The file is submitted to the server, set to be finished at the Perfect Binder and then released for processing.

- **Print and Bind from a Single File that Contains all Book Block Pages**

One file contains all images the same size. Create a bound document with the first page image printed on the front cover and no image on the back cover. Page 2 can be printed on the inside of the front cover or the inside of the front cover can be left blank. Achieved by using page range, submitting the cover page(s) with booklet imposition, and then placing them in the Perfect Binder interposer tray. Then submit the remainder of the job, the book block specifying the page range using pre-printed covers.

1.3 Tips for Size and Paper Selection

For each job, you'll need to select a cover stock and a body stock. To minimize trimming and avoid wasting paper, consider these tips:

- If you want the final booklet to be 8.5 x 11" in size, use 9 x 12" paper for the body stock and 12 x 18" paper for the cover stock. After trimming, the finished booklet will be 8.5 x 11". To save on paper cost, you can purchase 12 x 18" stock and cut this size in half for the 9 x 12" body paper.
- If you don't mind trimming to a smaller finished size than 8.5 x 11", simply use 8.5 x 11" for the body stock and 11 x 17" paper for the cover stock. The finished booklets will be about 8.2 x 10.7" after minimum trimming.
- Table of Applicable weight and number of sheets:

| Weight of Stock (gsm) | Number of Sheets | Reference |
|-----------------------|--------------------------|------------|
| 64 to 80 | 10 to 200 | *1, *5, *6 |
| 81 to 105 | 10 to 150 | *2, *5, *6 |
| (J paper) 82 | 10 to 200 | *3, *5, *6 |
| 106 to 163 | Up to 10 sheets per book | *4, *7 |

Reference:

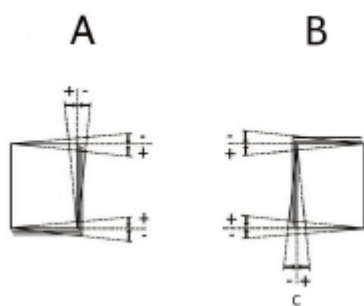
- *1: If book block is of less than 10 sheets, bond strength between cover and the book block cannot be secured.
- *2: With more than 150 sheets, book block thickness exceeds 23mm.
- *3: Up to 200 sheets is allowed as the thickness is 20.7mm even with duplex print.
- *4: If sheets of this type are positioned in a row or unevenly in a book, the spine may split and sheet(s) may be detached.
- *5: Maximum book block size can be extended to 255 sheets on NVM. However, the maximum thickness of 23mm cannot be exceeded.
- *6: When the cover with high stiffness is used and the book block size is 10 sheets, jam may occur as the square-holding operation cannot function properly. In this case, the stiffness of book block sheets or the book block size should be increased. When the stiffness of cover stock, whose weight is within the specified range, is high, binding may fail and jams can occur even if the book block is of 10 sheets or more. (E.g. Jam may occur with the following combination: 10 sheets of 67gsm recycled stock in book block & 209gsm cover.)
- *7: The upper limit can be changed up to 30 sheets on NVM.

- Some examples of other common combinations for body and cover stock options for a Left Bound Book:

| Finished/Trim Size | Body Stock | Cover Stock | Image Shift |
|--------------------------------|--|---------------|---|
| 6"x9" | B5 (6.9"x9.8") | 14"x10" | For 50 sheets of 24lb/90 gsm x: -0.15 y: -0.045 |
| 6"x9" | B5 (6.9"x9.8") | 14"x10" | For 150 sheets of 24lb/90 gsm x: -0.25 y: +0.25 |
| Undersize Letter, 8.22"x10.42" | 8.5"x11" | 11"x17" | For 50 sheets of 24lb/105gsm x: 0.0 ** y: 0.0** |
| 8.22"x9.95" | 8.5"x11" | 12"x18" | For 10 sheets of 120 gsm x: 0.0 ** y: 0.0** |
| Letter/8.5"x11" | 9"x12" | 12"x18" | |
| A4 | 225mm x 320mm | SRA3 | |
| 5.5"x8.5" | Finished Size is Beyond Perfect Binder Capabilities: Too Small | | |
| 8"x8" | 8.28"x10.13" | 10.13"x16.91" | |

**may not be necessary.

- For custom sizes, notice the trim ranges for Height and Width on the print server UI. FreeFlow Print Server automatically calculates the minimum and maximum trim for the cover stock and the body stock that you've selected. You must select trim values within this range.
- You will generally not have to adjust trim angles. However, if you do need to make these adjustments, use this diagram to help you understand whether to set + or – values for the Top, Front and Bottom settings:



A is a left-bound book and **B** is a right-bound book.

2.0 Perfect Binder Operations

2.1 Manual Mode Procedure

Both covers and book blocks are preprinted. The Perfect binder is placed in Manual Mode and covers are fed from a tray to the binder while book blocks are manually placed in the binder, one at a time, for finishing.

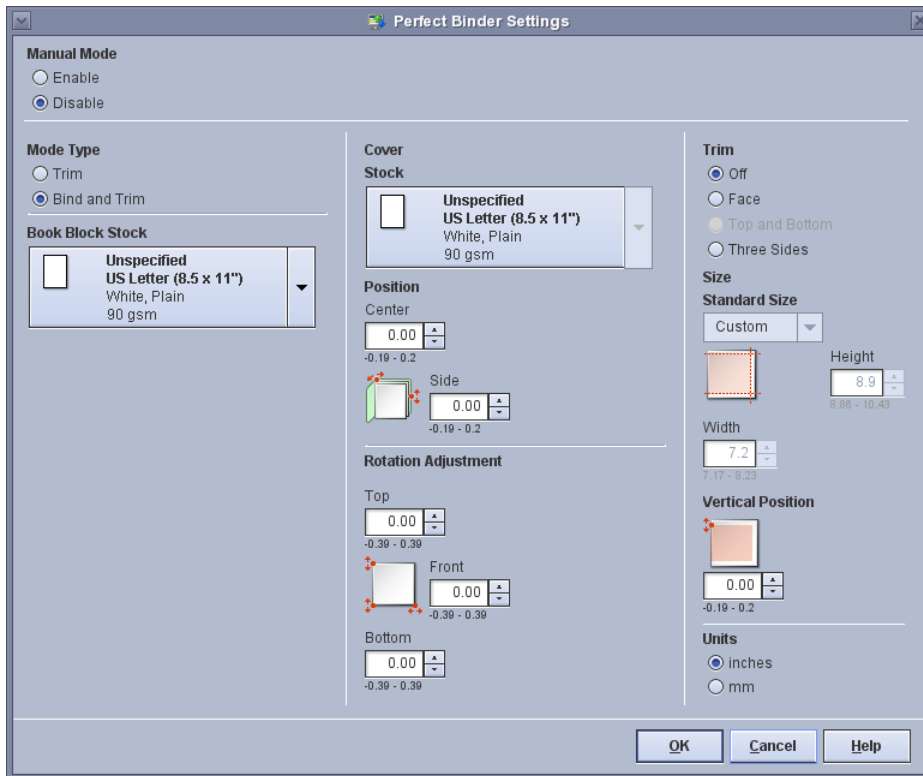
General procedure:

1. Pre-print both covers and book bodies
2. At the print server, set the binder in Manual Mode and make settings for book block stock, cover stock, cover positioning and trim.
3. At the binder, load covers into the Inserter Tray and manually feed the preprinted book bodies into the unit.
4. Press Start after loading each book body to bind and trim the book.
5. Remove finished books when the Book Stacker Tray becomes full.

Specific steps:

1. Preprint covers and book blocks separately and place them within reach of the Perfect Binder.
2. Load the preprinted covers into the Perfect Binder Inserter Tray or another tray on the press.
The press trays can hold more pre-printed cover sheets than the Perfect Binder Inserter. So if the print run is large, you can avoid having to replenish covers in the Inserter Tray by using a press tray. When you feed preprinted covers to the Perfect Binder from a press tray, the paper does not touch the fuser in the press.
3. At the PCUI, program the tray into which you loaded the covers. If you loaded the Perfect Binder tray, it is labeled "T1" at the PCUI.
4. At the Print Server, from the Printer drop-down menu, select **Finishing**.
The Finishing window opens showing the finishers available.
5. From the Internal Finishers area of the window, double-click **Perfect Binder**.

The Perfect Binder Settings window opens:



6. For Manual Mode, select the **Enable** radio button. This setting takes the Perfect Binder offline from the press. Any stackers or binders configured inline before the binder will be available to the press, but finishing devices located inline after the binder cannot be used while in Manual Mode.
7. Under **Units** in the lower right of the window, select either **inches** or **mm** for the measurement unit. All image and trim adjustments will display in the unit that you select.
8. For Mode Type, select **Bind and Trim** for normal binding operation. The **Trim** option can be used to only trim pages without binding them.
9. From the Book Block Stock menu, select the **specific stock** on which the book blocks are pre-printed. You can select it from Loaded Stocks, Stock List or use the Custom option to set the stock attributes. Note that the stock you set here does not have to be loaded in the press. You are setting this value so that the print server can inform the Perfect Binder what you will later be manually loading.
10. In the Cover area of the window, select the **stock** on which the covers are pre-printed. You can select the stock from Loaded Stocks since you already loaded it into a tray.
11. For cover **Position**, accept the default values of **0.00** for Center and Side, unless you have already bound some books and know that the book block needs to be adjusted up/down, or left/right in inside the cover.
12. **Rotation Adjustment** is used when the corners of a bound book are not 90° and therefore the book is not square. For Rotation Adjustment, accept the default values of **0.00** for Top, Front and Bottom, unless you have already bound some books and know that one of the sides of the bound book is not being trimmed straight and needs adjustment.

13. In the Trim area of the window, select **Three Sides**. This trims the three sides of the bound book that are not bound. This selection provides the best quality output. For special cases, there are also options for **Face** only (this trims one side—the side opposite the bind) and **Top and Bottom** (this trims two sides—the top and bottom sides of the bound book).
14. From the Standard Size drop down menu, select the size you want the finished book to be: **US Letter**, **A4** or **Custom**. US Letter and A4 are fixed sizes, but Custom allows you to set the Height and Width of the finished book to specific values.
15. If you select **Custom** from the Standard Size menu, enter a specific Height and Width value now. Only enter values that are within the ranges specified below the entry fields.
16. For Vertical Position, leave the default value of **0.00** unless you have already bound some books and know that the top and bottom trim need adjustment. Normally, equal amounts are trimmed from the top and bottom of the bound book. If you want more trimmed from the bottom and less trimmed at the top, decrease the setting from 0 (- number). If you want more trimmed from the top and less trimmed at the bottom, increase the setting from 0 (+number). The total trim amount remains the same, but the bound book is shifted up or down during the cutting process.
17. Click **OK**. The Perfect Binder is now ready for manual operation and is offline from the printer for print line jobs. The parameters that you entered have been sent to the binder for the manual operation. Other jobs can be run on the press, as long as they output to a stacker before the Perfect Binder, and not a finishing device after it in the configuration.
18. Insert cover stock into the top tray of the binder. Adjust the paper guides to gently touch the edges of the paper.
19. Lift the **top left cover** of the binder.
20. Lift **Lever 1** and then **Lever 2** to open gain access to the paper block area.
21. Insert the paper block into the area LEF and face down. Then push the green lever in to adjust the paper guides to the edge of the paper.
22. Close Lever 2, Lever 1 and then the top cover.
23. Press the green **Start** button.
As the book is bound and/or trimmed, the lock icons will light up on the covers to indicate that you cannot open them during the operation.
24. When the lock icons turn off, the book retrieval area can be opened. Push the green button to open the door to retrieve the book. You can continue to manually load book blocks for binding/trimming, and collect several finished books at once, instead of retrieving each one when it completes. The collection area will hold xxx.
25. When you are finished with manual binding operations, take the Perfect Binder out of Manual Mode. From the Printer drop-down menu, select **Finishing**, and then double-click **Perfect Binder** and click **Disable**.

2.2 Print Book Block and Bind with Pre-Printed Covers

Covers are preprinted on large stock, at least 2x the book block size, and loaded into a tray. A single file containing the book block is then printed at the press and sent to the binder where the covers are automatically fed and bound to the book block.

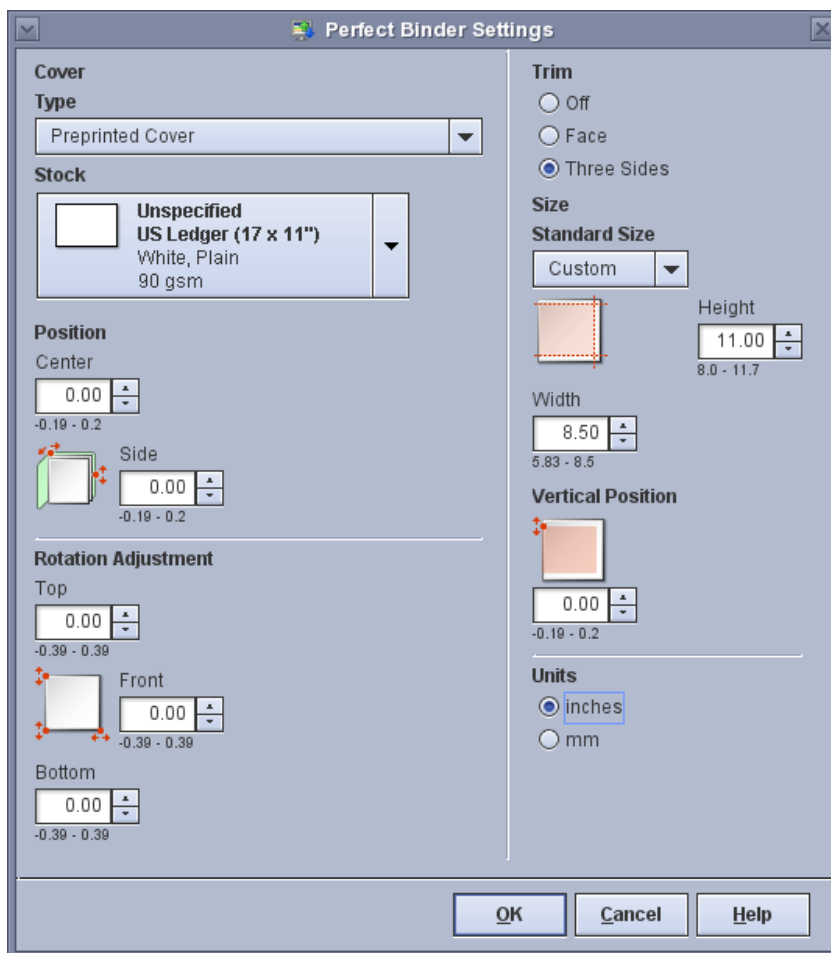
General procedure:

1. Pre-print covers and load prints into the Inserter Tray at the Perfect Binder or another press tray.
2. At the PCUI, program the tray into which the covers were placed.
3. At the print server, submit the file using Print From File or submit from a client to a Hold queue and open Job Properties.
4. Under Finishing, open the Perfect Binder Settings window and set parameters for cover stock, body stock, positioning and trimming.
5. Print the job and collect bound and trimmed books at the binder.

Specific Procedures

1. Load the preprinted covers into the Perfect Binder Inserter Tray or another tray on the press. Press trays can hold more pre-printed cover sheets than the Perfect Binder Inserter. So if the print run is large, you can avoid having to replenish covers in the Inserter Tray by using a press tray. When you feed preprinted covers to the Perfect Binder from a press tray, the paper does not touch the fuser in the press.
2. At the PCUI, program the tray into which you loaded the covers. If you loaded the Perfect Binder tray, it is labeled "T1" at the PCUI.
3. Load the stock you want to use for the book block into one of the printer trays.
4. At the PCUI, program the tray for the stock that you loaded. You can select from the Stock Library if the media is listed there, or use the Recommended Media List. For custom paper that is not listed in the Stock Library or the Recommended Media List, click Create New Stock and enter the stock attributes.
5. Click the **Print From File** shortcut icon or select **Print From File** from the Services menu.
6. Click **Browse**.
7. In the **Look in** area, navigate to the location of the book block file to be printed. For example, CD-ROM, USB Flash Drive, or a file system location.
8. Once you've located the folder containing the file, double-click the **file name** in the area on the right of the window.
9. From the Queue drop down menu at the top right of the window, select the **queue** you want to use for printing.
10. For Quantity, at the top left of the window, set the **number of books** that you want to print and bind.
11. Click to select the **Basic** tab.
12. For Paper Stock, click the Loaded Stocks button and select the **specific stock** that you loaded.
13. For Sides Imaged, select **2 Sided** to print the book duplex or **1 Sided** to print simplex.

14. Click the Stapling / Finishing menu and select **Perfect Bind > Portrait Left**. This setting places the spine on the left side of the book as it faces you. Other options are **Portrait Right** (for Asian and Middle-Eastern languages) and **Landscape Top** or **Landscape Bottom** (for “calendar” type layouts).
15. Click **Finishing Settings**.
The Perfect Binder Settings screen opens:



16. Under **Units** in the lower right of the window, select either **inches** or **mm** for the measurement unit. All image and trim adjustments will now display in the unit that you select.
17. From the **Type** drop-down menu, select **Pre-printed Cover**.
18. For **Stock**, select the **cover stock** that you loaded into the Perfect Binder Inserter Tray or another press tray. You can select it from **Loaded Stocks** because you loaded it earlier.
19. For cover **Position**, accept the default values of **0.00** for Center and Side, unless you have already bound some books and know that the book block needs to be adjusted up/down, or left/right in inside the cover.
20. **Rotation Adjustment** is used when the corners of a bound book are not 90° and therefore the book is not square. For **Rotation Adjustment**, accept the default values of **0.00** for Top, Front and Bottom, unless you have already bound some books and know that one of the sides of the bound book is not being trimmed straight and needs adjustment.
21. For **Trim**, select **Three Sides**. This trims the three sides of the bound book that are not bound. This selection provides the best quality output. For special cases, there is also the option for **Face** trim which trims one side—the side opposite the bind.

22. From the Standard Size drop down menu, select the size you want the finished book to be: **US Letter**, **A4** or **Custom**. US Letter and A4 are fixed sizes, but Custom allows you to set the Height and Width of the finished book to specific values.
23. If you select **Custom** from the Standard Size menu, enter a specific Height and Width value now. Only enter values that are within the ranges specified below the entry fields.
24. For Vertical Position, leave the default value of **0.00** unless you have already bound some books and know that the top and bottom trim need adjustment. Normally, equal amounts are trimmed from the top and bottom of the bound book. If you want more trimmed from the bottom and less trimmed at the top, decrease the setting from 0 (- number). If you want more trimmed from the top and less trimmed at the bottom, increase the setting from 0 (+number). The total trim amount remains the same, but the bound book is shifted up or down during the cutting process.
25. Click **OK to save and close**
26. Click **Print** to send the job to the press and binder.

2.3 Print & Bind from Single File that Contains both Cover and Book Block

A single file is created in pre-press that contains a large first sheet to serve as a wrap-around cover. The remainder of the pages in the file is book block size. The file is submitted to the server, set to be finished at the Perfect Binder and then released for processing.

General procedure:

1. Verify that the cover page is correctly laid out for either 1 Sided or 2 Sided printing.
2. Load both cover stock and book block stock into trays at the press.
3. At the PCUI, program the trays for the stock that you loaded.
4. At the print server, submit the file using Print From File or submit from a client to a Hold queue and open Job Properties.
5. Under Finishing, open the Perfect Binder Settings window and set parameters for cover stock, body stock, positioning and trimming.
6. Print the job and collect bound and trimmed books at the binder.

Specific Procedures:

1. Open the file to verify that the first page of the book is set to print on large cover stock. One of the following layouts should be used:

2. Sheet 1 for 1 Sided Printing

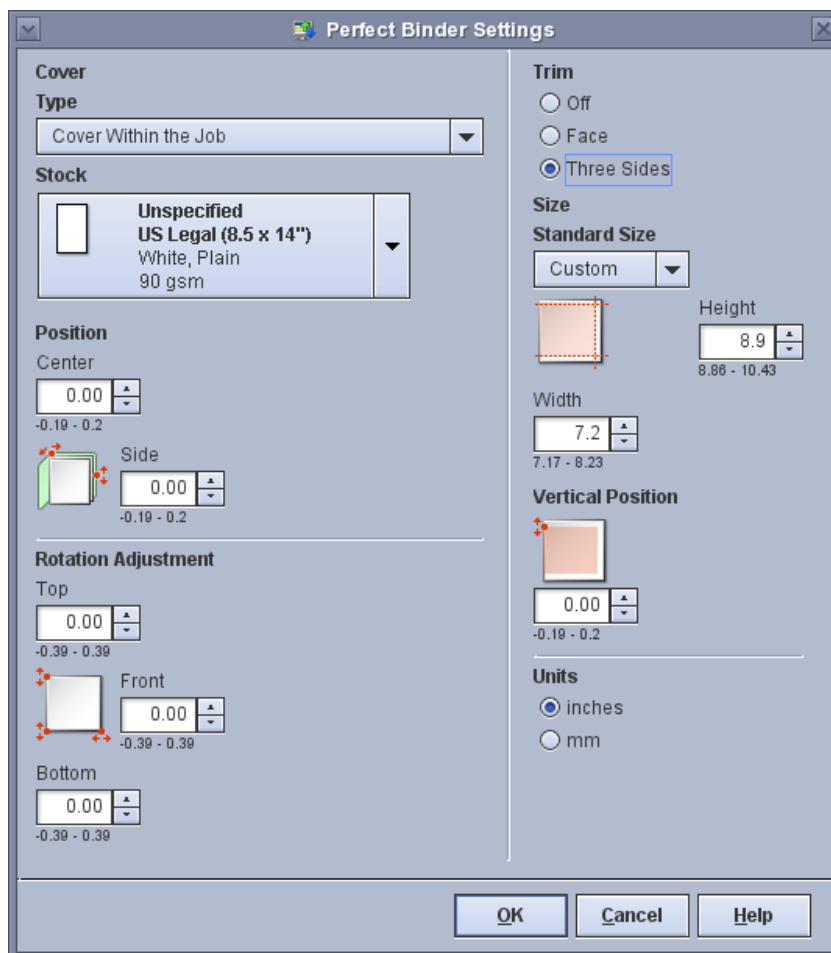
| | |
|-------|-------------|
| Blank | Front Cover |
|-------|-------------|

- Sheet 1 for 2 Sided Printing

| | | |
|--------|--------|-------------|
| Side 1 | Blank | Front Cover |
| Side 2 | Page 2 | Blank |

3. Load the cover stock into one of the printer trays. At the PCUI, program the tray for the stock that you loaded.
4. Load the book block stock into one of the printer trays. At the PCUI, program the tray for the stock that you loaded.
5. Click the **Print From File** shortcut icon or select **Print From File** from the Services menu.
6. Click **Browse**.
7. In the **Look in** area, navigate to the location of the book block file to be printed. For example, CD-ROM, USB Flash Drive, or a file system location.
8. Once you've located the folder containing the file, double-click the **file name** in the area on the right of the window.

9. From the Queue drop down menu at the top right of the window, select the **queue** you want to use for printing.
10. For Quantity, at the top left of the window, set the **number of books** that you want to print and bind.
11. Click to select the **Basic** tab.
12. For Paper Stock, click the Loaded Stocks button and select the **specific stock** that you loaded for the book block.
13. For Sides Imaged, select **2 Sided** to print the book duplex or **1 Sided** to print simplex.
14. Click the Stapling / Finishing menu and select **Perfect Bind > Portrait Left**. This setting places the spine on the left side of the book as it faces you. Other options are **Portrait Right** (for Asian and Middle-Eastern languages) and **Landscape Top** or **Landscape Bottom** (for “calendar” type layouts).
15. Click **Finishing Settings**.
The Perfect Binder Settings screen opens:



16. Under **Units** in the lower right of the window, select either **inches** or **mm** for the measurement unit. All image and trim adjustments will now display in the unit that you select.
17. From the **Type** drop-down menu, select **Cover Within Job**.
18. For Stock, select the **cover stock** that you loaded into the Perfect Binder Inserter Tray or another press tray. You can select it from Loaded Stocks because you loaded it earlier.

19. For cover Position, accept the default values of **0.00** for Center and Side, unless you have already bound some books and know that the book block needs to be adjusted up/down, or left/right in inside the cover.
20. Rotation Adjustment is used when the corners of a bound book are not 90° and therefore the book is not square. For Rotation Adjustment, accept the default values of **0.00** for Top, Front and Bottom, unless you have already bound some books and know that one of the sides of the bound book is not being trimmed straight and needs adjustment.
21. For Trim, select **Three Sides**. This trims the three sides of the bound book that are not bound. This selection provides the best quality output. For special cases, there is also the option for **Face** trim. This trims one side—the side opposite the bind.
22. From the Standard Size drop down menu, select the size you want the finished book to be: **US Letter**, **A4** or **Custom**. US Letter and A4 are fixed sizes, but Custom allows you to set the Height and Width of the finished book to specific values.
23. If you select **Custom** from the Standard Size menu, enter a specific Height and Width value now. Only enter values that are within the ranges specified below the entry fields.
24. For Vertical Position, leave the default value of **0.00** unless you have already bound some books and know that the top and bottom trim need adjustment. Normally, equal amounts are trimmed from the top and bottom of the bound book. If you want more trimmed from the bottom and less trimmed at the top, decrease the setting from 0 (- number). If you want more trimmed from the top and less trimmed at the bottom, increase the setting from 0 (+number). The total trim amount remains the same, but the bound book is shifted up or down during the cutting process.
25. Click **OK to save and close**
26. Click **Print** to send the job to the printer and binder.

2.4 Print & Bind from a Single File with all Book Block Pages

One file contains all images the same size. Create a bound document with the first page image printed on the front cover and no image on the back cover. Page 2 can be printed on the inside of the front cover or the inside of the front cover can be left blank.

General procedure:

1. At the print server, submit the file using Print From File or submit from a client to a Hold queue and open Job Properties.
2. Set Pages to Print for just the cover and set the job for Booklet layout.
3. Print the covers and place in a tray to feed the binder.
4. Resubmit the file and set Pages to Print for the remainder of the pages—the book block.
5. Under Finishing, open the Perfect Binder Settings window and set parameters for cover stock, body stock, positioning and trimming.
6. Print the job and collect bound and trimmed books at the binder.

Specific Procedures

1. Load the cover stock into one of the printer trays. This stock should be at least 2 times the page images in the file.
2. At the PCUI, program the tray for the stock that you loaded.
3. Click the **Print From File** shortcut icon or select **Print From File** from the Services menu.
4. Click **Browse**.
5. In the **Look in** area, navigate to the location of the book block file to be printed. For example, CD-ROM, USB Flash Drive, or a file system location.
6. Once you've located the folder containing the file, double-click the **file name** in the area on the right of the window.
7. From the Queue drop down menu at the top right of the window, select the **queue** you want to use for printing.
8. For Quantity, at the top left of the window, set the **number of covers** that you want to print and bind.
9. On the Files tab, for **Pages to Print**:
 - Enter **From 1 to 1** for printing the front cover with no image on the inside of the cover
 - Enter **From 1 to 2** for printing the 2nd page image on the inside of the front cover.
10. Click to select the **Basic** tab.
11. For Paper Stock, click the Loaded Stocks button and select the **specific stock** that you loaded for the cover.
12. From the Output tab, select **Layout**.
13. Click **Booklet**. Select Portrait Left (or Right, depending on job).
14. Click **Print**.
15. Collect the cover prints and place them in the Print Binder Inserter Tray (T1).
16. At the PCUI, program the Perfect Binder tray (T1) to the media that you're using for the covers.
17. Load the book block stock into one of the printer trays.
18. At the PCUI, program the tray for the stock that you loaded.
19. Click the **Print From File** shortcut icon or select **Print From File** from the Services menu.
20. Click **Browse**.
21. In the **Look in** area, navigate to the location of the book block file to be printed. For example, CD-ROM, USB Flash Drive, or a file system location.
22. Once you've located the folder containing the file, double-click the **file name** in the area on the right of the window.
23. From the Queue drop down menu at the top right of the window, select the **queue** you want to use for printing.
24. For Quantity, at the top left of the window, set the **number of books** that you want to print and bind.
25. On the Files tab, for **Pages to Print**:

- Enter **From 2 to N** (where N=last page in document) for printing when the front cover has no image on the inside of the cover
- Enter **From 3 to N** (where N=last page in document) for printing when the 2nd page was printed on the inside of the front cover.

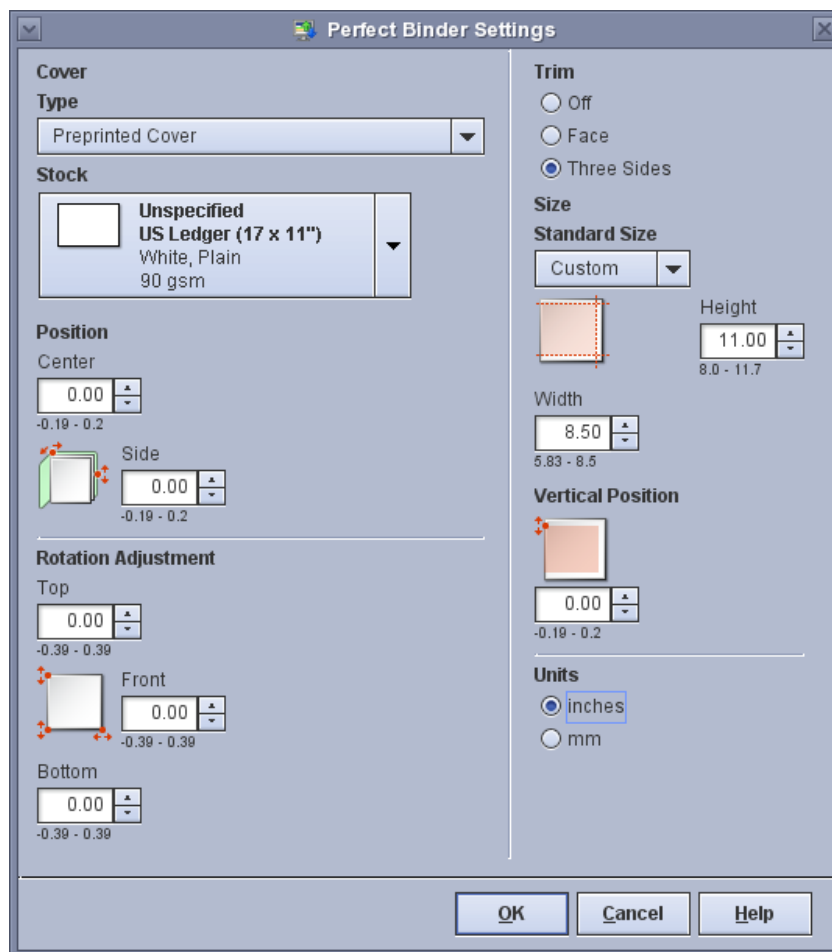
26. Click to select the **Basic** tab.

27. For Paper Stock, click the Loaded Stocks button and select the **specific stock** that you loaded for the book block.

28. Click the Stapling / Finishing menu and select **Perfect Bind > Portrait Left**. This setting places the spine on the left side of the book as it faces you. Other options are **Portrait Right** (for Asian and Middle-Eastern languages) and **Landscape Top** or **Landscape Bottom** (for “calendar” type layouts).

29. Click **Finishing Settings**.

The Perfect Binder Settings screen opens.



30. Under **Units** in the lower right of the window, select either **inches** or **mm** for the measurement unit. All image and trim adjustments will now display in the unit that you select.

31. From the **Type** drop-down menu, select **Pre-printed Cover**.

32. From the Stock drop-down menu, select Loaded Stocks and the specific **cover stock** that you loaded into the Perfect Binder tray (T1) or another tray.

33. For cover Position, accept the default values of **0.00** for Center and Side, unless you have already bound some books and know that the book block needs to be adjusted up/down, or left/right in inside the cover.
34. Rotation Adjustment is used when the corners of a bound book are not 90° and therefore the book is not square. For Rotation Adjustment, accept the default values of **0.00** for Top, Front and Bottom, unless you have already bound some books and know that one of the sides of the bound book is not being trimmed straight and needs adjustment.
35. For Trim, select **Three Sides**. This trims the three sides of the bound book that are not bound. This selection provides the best quality output. For special cases, there is also the option for **Face** trim this trims one side—the side opposite the bind.
36. From the Standard Size drop down menu, select the size you want the finished book to be: **US Letter**, **A4** or **Custom**. US Letter and A4 are fixed sizes, but Custom allows you to set the Height and Width of the finished book to specific values.
37. If you select **Custom** from the Standard Size menu, enter a specific Height and Width value now. Only enter values that are within the ranges specified below the entry fields.
38. For Vertical Position, leave the default value of **0.00** unless you have already bound some books and know that the top and bottom trim need adjustment. Normally, equal amounts are trimmed from the top and bottom of the bound book. If you want more trimmed from the bottom and less trimmed at the top, decrease the setting from 0 (- number). If you want more trimmed from the top and less trimmed at the bottom, increase the setting from 0 (+number). The total trim amount remains the same, but the bound book is shifted up or down during the cutting process.
39. Click **OK to save and close**
40. Click **Print** to send the job to the printer and binder.

3.0 Additional Information

3.1 Caveats

- setpage device calls in PostScript takes precedence over programming on the FFPS GUI.
- Cover/Book Body invalid combinations are displayed when the programming is completed and submitted to the RIP.
- When selecting “Cover within the Job / Automatically Pick Media” it may allow invalid trim sizes entered.