

mencing to make-up. A simple and expeditious mode is to drive two nails in the wall distant from each other one-half the desired length, wind the cord around them, and cut it all at once by a single clip of the shears.

Instead of *wrapping* the cord, after taking from pages in the form, hang it over your shoulders; after you have finished your work at the stone hang it over a nail—it will not become tangled if a little care is observed, and will save both time and patience expended in untaangling cord that has been wrapped.

**Making-up.**

To secure a perfect imposition, it is absolutely necessary that the make-up of the pages should be uniform to the degree of exactness. This requisite can be accomplished readily by proper care and as expeditiously as inferior work executed in a slovenly or neglectful manner.

The first essential is to have a well-protected, thick brass-rimmed galley, not more than five-eighths of an inch high, firmly fastened to the make-up stand, which should be set perfectly level on its legs. The galley may be immovably fixed by driving a staple at the head, and at the foot a broad-headed tack near each side, allowing them to come well down, clinching the brass, to prevent slipping.

All matter should be transferred to this galley as the make-up progresses—thus the make-up will not be affected by variations in other galleys, while the staple at the head will prevent the galley from slipping over the case when the matter is forced to the head for the purpose of bringing it up clear and square.

The gauge should be exactly the length of the page exclusive of foot-line or slug. (Always use a slug—it is cheaper in the end and tends to prevent bowing in a hurried lock-up).

In order to determine the exactness of the make-up, press the matter closely, slide the make-up rule to the right, and if it barely clears the gauge (which can be ascertained by touching it with the middle finger of the right hand) the page is accurate.

In side-noted matter the lead separating them from the text should be the length of the page exclusive of foot-slug—this will permit the slug to clinch both text and notes.

In tying up the pages always commence at the lower right-hand corner. Never permit the cord to lap until it is about to be secured, which should be at the lower left-hand corner. A

page tied up in this manner will stand rough handling without detriment.

**Imposition.**

A great deal has been written concerning this important branch of the "art preservative," and it is somewhat astonishing to those conversant with the fact, that the knowledge of nine of every ten book hands is confined to laying a 16mo. in *one* position. I have heard intelligent tenth men assert that there are but *two* positions in which an 8vo. can be laid; others, that there are *three*.

Experiments have taught me that imposition of book forms is of *two* kinds (*long* and *broad*); that each kind has *three* classes (*regular*, *centre*, and *bastard*); and that each class has *two* divisions (*outside* and *inside*); in all, *twelve* distinct impositions, each making a perfect fold. They are here illustrated:—

**FIRST KIND — LONG.**

1. Outside regular.	2. Inside regular.	3. Outside centre.
3 2	7 2	9 2
3 6	9 8	3 2
4 9	5 4	4 1
1 8	8 1	5 8
4. Inside centre.	5. Outside bastard.	6. Inside bastard.
7 6	2 8	3 2
2 8	7 6	9 2
1 4	8 9	5 8
8 9	1 4	4 1

**SECOND KIND — BROAD.**

1. Outside regular.	2. Inside regular.
4 9 9 8	3 6 5 4
1 8 7 2	6 2 8 1
3. Outside centre.	4. Inside centre.
9 4 8 0	6 3 4 5
8 1 2 7	2 6 1 8