

in the cover, the inside of which consists of boards more or less strong. Of the kinds on the market the bookbinder uses grey-board, which is made from waste paper and rags. It is grey, very tough, and flexible, but dearer than other raw materials.

Straw-boards made from straw and waste paper are cheaper, but less flexible, and are easily broken. They take a very high polish under the calendering machine and become very hard, and are therefore very suitable for some work if flexibility is not essential. They are generally used in all cloth binding.

So-called leather-boards are unsuitable, for, in spite of great toughness and pliancy, they are certain to cockle and always remain spongy. Wooden-boards are unsuitable for bookbinding on account of their small resistance, but are indispensable for fancy goods and portfolios, as they can be so nicely cut and are less liable to subsequent cockling than any other kind.

Besides these, yellow and blue boards are made. These are coloured to suit and serve quite special purposes, mostly fancy goods; but they also are not used in bookbinding, on account of their high price.

The thinnest boards are known as middles. This is a strong whitish material made entirely from waste-paper. It is used for lining backs, limp bindings, and in all cases where flexibility, together with durability, is required.

In finished work—books, fancy goods, maps—the boards are never left exposed to view, but are covered with paper, cloth, or leather. For the inner side of the cover of the book white or coloured paper is frequently used, note-paper of the smallest size being more rarely used.

All marbled or pressed papers are made in one standard size. Besides the end papers for inside of books, a figured paper has of late been made known as "litho printed" for