



FIG. 48. "HARRILD" BLOCKING PRESS, NO. 6.

impression on the cases before the actual printing, and on many materials two impressions with ink are often required to obtain good solid results. Specially built heavy platen presses are also used to print and emboss publishers' covers. A good imitation of gold blocking for cheap work is obtained with a gold ink paste printed in a platen or small rotary

press. Here, however, the blocks must be heated to dry the ink and give a solid impression. The covers require no sizing or cleaning-off, and the results obtained by this gold printing method compare favourably with imitation-gold blocking.

*Blocking Presses.* There are many makes and sizes of blocking presses for both power and hand operation, the nature of the work and the length of the run being the deciding factors. The "Harrild" Blocking Press No. 6 (Fig. 48) is a hand lever press particularly suitable for miscellaneous work. Because it has open sides, larger jobs can be blocked on the corners and edges than are possible on many other small machines.

The Standard Fully Automatic Press is an American blocking and embossing press that has an automatic case feed, and is capable of speeds of from twenty-five to thirty cases a minute. It can be used for ink stamping or for gold and imitation-gold blocking from the roll. Over a hundred cases can be placed in the hopper from which they are automatically fed into the centre of the press, where they are stamped in blind or with ink or in gold and then automatically delivered and piled uniformly on a lowering table. A water-cooling device enables this machine to change over quickly from gold-blocking to inking.

Some of the more important machines, which are made in a wide range of sizes to suit all classes of work, are the Seybold, Krause, Chandler and Price, Marshall, Sheridan, Friedheim, Beatrice, and Harrild presses, some of which are illustrated on pp. 215-222.

Air-brush *superfinishing* of cases is now general practice in most large binderies.