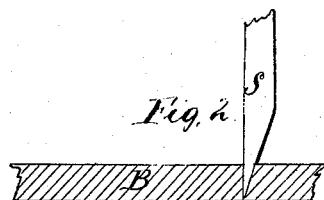
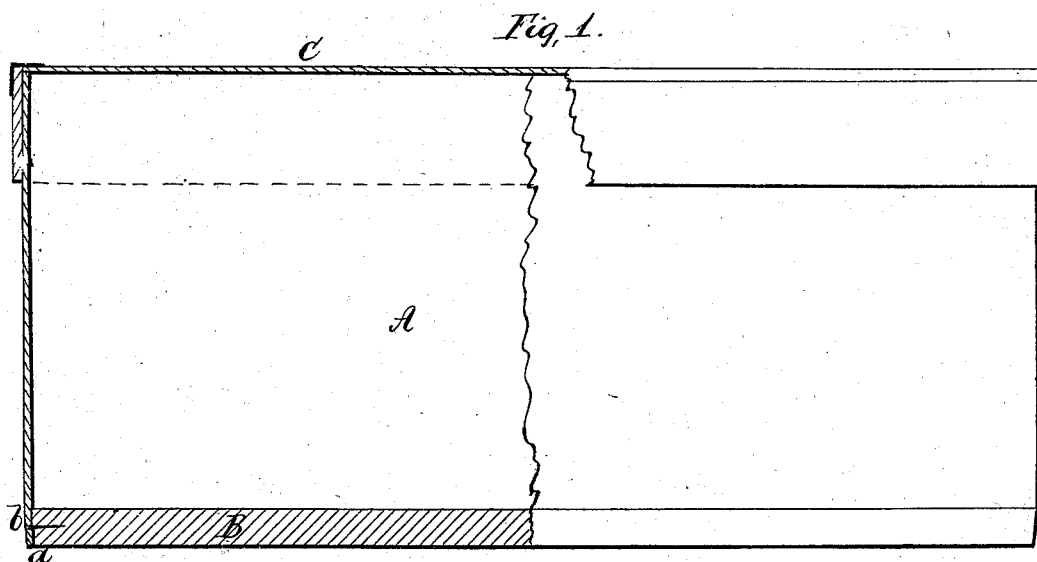


O. Mallory,
Fruit Box,
N^o 48,192, Patented June 13, 1865



Witnesses,
Wm. H. Loughborough
W. H. Rogers

Inventor,
O. Mallory

UNITED STATES PATENT OFFICE.

O. MALLORY, OF ROCHESTER, NEW YORK.

IMPROVED GRAPE-BOX.

Specification forming part of Letters Patent No. 48,192, dated June 13, 1865.

To all whom it may concern:

Be it known that I, O. MALLORY, of Rochester, in the county of Monroe and State of New York, have invented certain new and useful Improvements in Grape-Boxes; and I do hereby declare that the following is a full, clear, and exact description thereof, reference being had to the accompanying drawings, making part of this specification, in which—

Figure 1 is an elevation of my invention, a portion being shown in vertical section. Fig. 2 shows the shape of the knife *s*, for cutting the bottoms.

Similar letters of reference indicate corresponding parts in both figures.

This invention consists in the employment of ordinary straw-board hoops and wooden bottoms, the latter being made with a beveled edge and placed in the hoop with the face having the smaller diameter down, which, when the hoop is nailed to the edge, renders this joint much more perfect and substantial than when the parts are made and combined in the usual way.

To enable others to work my invention, I will describe it in detail.

I use the ordinary straw-board for the sides or hoops *A*, cut and formed in the ordinary way and of any desired size. The bottoms *B*, I cut from boards prepared for the purpose, one-fourth of an inch (more or less) in thickness, by means of a revolving cutter, the knife or spur *s* of which is beveled on the side opposite the bottom *B*, as shown in Fig. 2. This causes the point to cut under by springing toward the center as it is pressed into the board from which the bottom is being cut, which thereby bevels the edge of the bottom *B*, as seen at *a* in Fig. 1.

The knife *s* should be perfectly straight on the inside, and the outside somewhat hawk's-bill shaped at the point, as seen in Fig. 2. This tendency of the knife to run under makes the face edge of the bottom *B* perfectly smooth by the friction from the knife.

The bottoms are put in the hoops from the top and pressed down to their place, where they are secured by several tacks, *b*, driven through the hoops, as seen in Fig. 1. This manner of cutting and connecting the bottoms renders them stronger and more perfect than as heretofore practiced, forming as it does a sort of lock or dovetail joint between the parts.

The hoops are all made upon a former or

cylinder, which renders them of uniform size, so that the bottoms will fit in any hoop of a given size, and by using straw or paste board hoops instead of wood, and they being dampened by the paste on the covering or outside paper when it is applied, permits the lower edge of the hoops to conform to the beveled edge of the bottoms, as seen at *a*, Fig. 1, where it is held in close contact by the covering-paper, which is pasted to the bottom. The shrinkage of the hoop and of the covering-paper when they dry draws the parts into close contact and holds them there. Wooden hoops could not be made to conform to this beveled edge, because they would split off on the line of the upper side of the bottom.

It is a source of great annoyance to the workmen trying to keep the bottoms in their place until they are nailed when the bottoms are cut with a square edge, as heretofore practiced; but when made after this plan the bottoms may be applied to any number or quantity of the hoops, and afterward nailed, &c., avoiding entirely the inconvenience of their displacement by handling, and saving the time and trouble attending the same.

Another advantage afforded by means of the bevel is that the slivers or rough edge produced by the point of the cutter on the back side of the bottom cannot interfere with the hoop *A* to force it away from the bottom, so as to leave the joint between the parts open at various points on the inside. This roughness is unavoidable, owing to the wear of the face-plate, which is of wood, upon which the bottoms are cut by the point of the knife or spur.

I use the ordinary covers. Straw-board hoops are better than wood, because they are less brittle.

What I claim as my invention, and desire to secure by Letters Patent, is—

As an improved article of manufacture, a grape-box composed of an inflexible or wooden bottom, *B*, having a beveled edge cut under from the face or inside of the bottom, for the purposes set forth, and being arranged and combined with the straw-board hoop or side *A*, in the manner shown and described.

O. MALLORY.

Witnesses:

WM. S. LOUGHBOROUGH,
W. H. ROGERS.