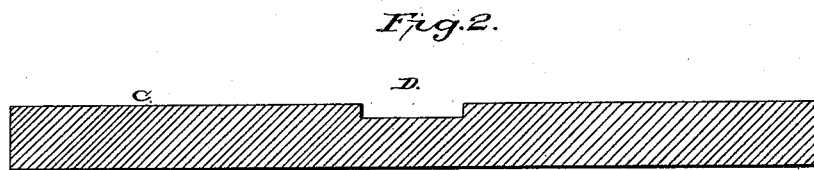
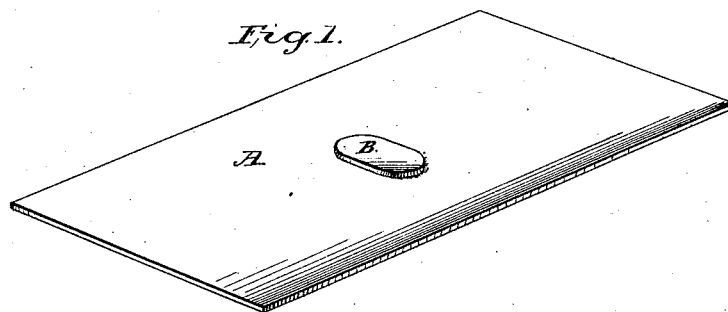


H. W. HUNT.
Process of Labeling Plugs of Tobacco.

No. 200,062.

Patented Feb. 5, 1878.



Attest:

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IMPROVEMENT IN PROCESSES OF LABELING PLUGS OF TOBACCO.

Specification forming part of Letters Patent No. **200,062**, dated February 5, 1878; application filed December 10, 1877.

To all whom it may concern:

Be it known that I, HIRAM WILLIS HUNT, of the city of Brooklyn, in the county of Kings and State of New York, have invented a certain Improved Process of Labeling Plugs of Tobacco, of which the following is a correct description:

During the process of manufacturing plugs of tobacco the tobacco leaves or slivers are, after suitable preparation, made by hand into round rolls or lumps, and afterward covered by hand with the ultimate wrapper of tobacco-leaf; or they are made by a lump-machine into flat lumps, and afterward covered by hand with the ultimate wrapper of tobacco-leaf.

The lumps of tobacco made by either of the methods above described are afterward placed in molds, shapes, or forms, and there pressed, and, as soon as so pressed and formed, are called "plugs."

After these plugs are removed from the molds, shapes, or forms, they are placed in layers between smooth sheets of metal in a finisher or polishing-pot, where they receive their final pressure.

When the plugs are removed from the finisher or polishing-pot they are ready to be packed in boxes, "prized," and the packing-boxes should be of sufficient strength to prevent the swelling of the plugs after prizing, which swelling would otherwise take place by reason of the elastic spongy character and condition of freshly-made plugs of tobacco.

Before my invention plugs of tobacco have been labeled in various ways, mostly by the use of labels made of hard substances and applied by pressure during the process of manufacture. But by my improved process the label is not attached to any part of the plug until after the plug is ready to be put into the packing-boxes. I am thus enabled to dispense with pressing the label into any part of the plug, and can therefore use a label made of suitable soft substance.

My improved process of labeling plugs of tobacco is as follows: I attach to the metal sheets, between which the plugs of tobacco are packed in layers and pressed in the finisher or polishing-pot, dies of suitable size and suitably located, so that when the final pres-

sure is applied in the polishing-pot a die is forced into and makes a depression in the face or broad side of each plug of tobacco of the proper size, shape, and depth to receive the desired label. The plugs are then removed from the finisher or polishing-pot, and a label, which may be of hard or soft metal or any other suitable material, is then placed in each of the depressions formed by the dies, which can be done either before or after the plugs are placed in layers in the packing-boxes.

When filled, the packing-boxes should be closed in the usual way. The result will be that, after the labels are placed in the depressions and the packing-boxes filled and closed, the tobacco will sufficiently swell and close in and upon the sides and edges of the labels, and thus partially fill up the depressions made by the dies, so that when the boxes are opened and the plugs are removed the labels will be found to be securely attached to the plugs.

The dies should be made of a shape corresponding with the labels, and the depressions should be made somewhat deeper than the thickness of the labels, so as to give a better opportunity for the labels to be held fast by the swelling of the tobacco and the partial closing of the depressions.

The labels may be made with certain projections or teeth, by which they can be more securely retained by reason of the swelling of the tobacco.

In my drawing, hereto annexed, A in Figure 1 is a plane view of one of the metal plates used in the polishing-pot, having upon it one oval-shaped die, marked B. It is evident that there might be other dies on the same plate, or that this die might be of different shape. C in Fig. 2 is a lengthwise sectional view of a plug of tobacco through its center after it has received its final pressure in the polishing-pot between plates like that shown in Fig. 1. The depression produced by the die in the plug is shown at D, Fig. 2.

I prefer to produce the necessary depressions in the plugs substantially as hereinbefore described; but it is evident that such depressions may be produced in numerous other ways by means of dies or suitable devices suitably applied to the lumps or plugs during

the process of manufacture, or after the plugs are made.

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

1. The process of labeling a plug of tobacco by first producing a depression therein, and afterward placing a label in such depression, substantially as described.

2. A labeled plug of tobacco having the label held in an independently-formed depression, substantially as described.

HIRAM WILLIS HUNT,

Witnesses:

GEORGE STIMPSON,
STEPHEN PETTUS.