

UNITED STATES PATENT OFFICE.

GILBERT W. BRADLEY, OF SUNDERLAND, VERMONT.

IMPROVEMENT IN MAKING WOODEN BOXES.

Specification forming part of Letters Patent No. **211,130**, dated January 7, 1879; application filed September 3, 1878.

To all whom it may concern:

Be it known that I, GILBERT W. BRADLEY, of Sunderland, in the county of Bennington and State of Vermont, have invented a new and Improved Mode of Making Wooden Boxes, of which the following is a specification:

The invention relates to a new process of forming wooden boxes, which will first be described in connection with all that is necessary to a full understanding thereof, and then pointed out in the claim.

In making the boxes, strips of veneer are cut of the required length and breadth, which are then passed through a series of sets of rolls of three to a set. These rolls are similar to the rolls of a tin-pipe former, except in the second set the back roll is placed higher. Each succeeding set of rolls is arranged to give an increased pressure, the third or last set giving a heavy pressure, and forming the cylinder very neatly. By this operation the wood is compressed and smoothed, so that the use of sand-wheels or sand-paper is unnecessary. The ends of the veneer bands are then dampened, overlapped, and sewed, and the bodies thus formed are placed upon the drying apparatus.

The tops and bottoms of the boxes are exactly alike, and are each formed as follows:

The material is first cut into a circle of the proper size by a cylinder-saw, and is then cut with a smaller cylinder-saw to the proper depth to form the flanges or rims. The molding is then cut upon the edge of the circle, and the portion within the inner saw-cut is taken out, and the bottom and top are ready to receive the body. The inner surface of the flange and a narrow ring of the bottom are coated with glue, and the lower edge and the lower part of the outer surface of the body are also coated with glue. The lower edge of the body is then pressed into place in the cavity of the bottom, the cover is put on, and the box is made.

Having thus fully described my invention, I claim as new and desire to secure by Letters Patent—

The herein-described process of forming wooden boxes, that consists in bending wooden veneers into tubular shape under successively decreasing arcs and increasing pressures, and sewing together the lapped edges, as specified.

GILBERT W. BRADLEY.

Witnesses:

JAMES K. BATCHELDER,
DAVID CROFOOT.