

W. Gilbert,
 Wooden Box.
 N^o 108,700. Patented Oct. 25, 1870.

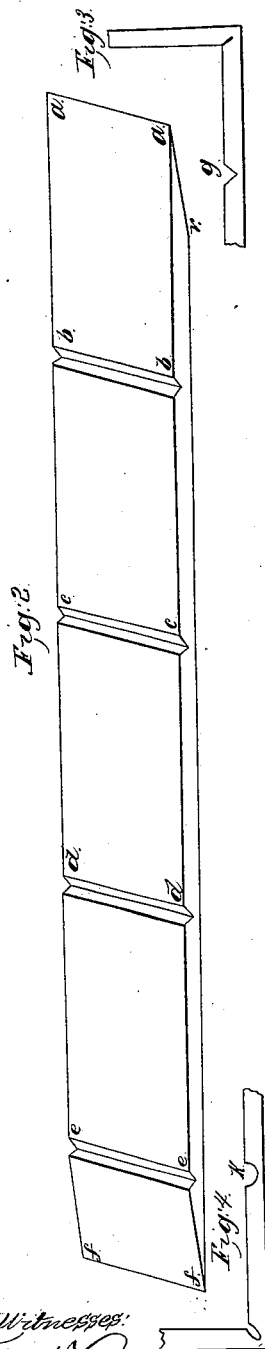


Fig. 6.

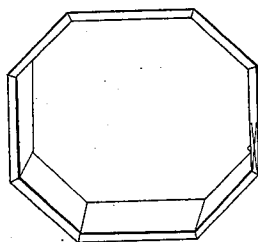


Fig. 1.

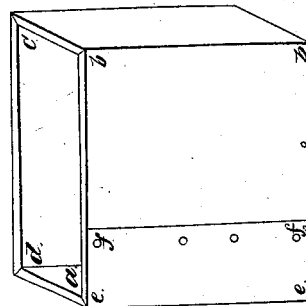
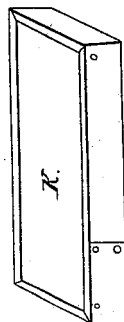
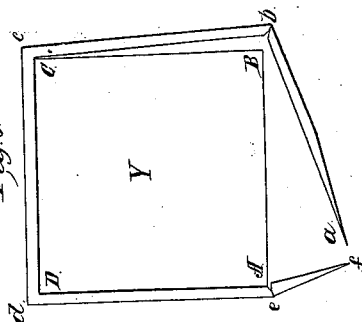


Fig. 5.



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Letters Patent No. 108,700, dated October 25, 1870.

IMPROVEMENT IN WOODEN BOXES.

The Schedule referred to in these Letters Patent and making part of the same

Be it known that I, WILLIAM GILBERT, of Catskill, Greene county, State of New York, have invented a new and useful Improvement in the Construction of Wooden Boxes, for service as fruit-boxes, salt-boxes, spice-boxes, housekeepers' boxes, ladies' work-boxes, or for any use where light strong boxes are needed.

My present object is to save the expense of construction-labor in forming the angular joints at corners, and making them without a break, in the cheapest and promptest manner.

The following specification, with the drawings hereto attached as part thereof, gives a full and perfect description of my invention.

Similar letters in the different figures denote the same parts of the apparatus.

Figure 1 represents in perspective a box and its cover, made by my process or method.

Figures 2, 3, 4, 5, and 6, illustrations of the method of construction.

The box, fig. 1, is intended as a measure to hold grapes, berries, or fruit, for market purposes. When for other purposes, the cover K is added.

The bottom and top pieces are thin squares, about one-eighth of an inch thick.

The sides are prepared by getting out and properly dressing strips, fig. 2, of the material, which may be of any kind of wood having toughness enough of fiber for that purpose.

These strips are made of the proper width for the sides of the box. Thus, if for quart measures, three and one-half inches; if for pint measures, two and three-fourths inches, reference being had to the square of the bottom, and so on in proportion to the measure, by the box required.

The thickness is from two-sixteenths to three-sixteenths of an inch.

These strips are cut into lengths equal to the combined measure of the bottom or top piece, and a lap-piece beside, of convenient size for the finishing of the box.

Fig. 5, Y represents the bottom or top of a square box of which fig. 2 is to form the sides.

The strip is next marked into sections, rectangularly, equal to the edges of the bottom to which they are to apply, *a b* to A B, *b c* to B C, *c d* to C D, *d e* to D A, with enough more to allow for the grooves required to form a joint at each angle of the box.

After being marked off, a rectangular groove, as shown on an enlarged scale at *g*, fig. 3, or a curvilinear one, *h*, fig. 4, is made, forming a miter-joint through about two-thirds of the substance of the wood.

A scarp is also cut upon and along the lap-piece from *e* to *f*, from the top of the joint cut at *e*, to a feather-edge at *f*, and a counterscarp to match it from the upper edge of the opposite end of the strip, at and from *a* to *r*, on its under side.

The strip thus prepared is next subjected to a soaking in hot water, or a steaming, in order to insure the bending of the wood without breaking its fiber. When in that state it is bent around the bottom or top piece, as shown in fig. 5, the cut of the joints inside forming a tight miter-joint, unbroken on the outside, and requiring neither binding-slips nor glue to hold the angles together. The sides are then nailed to the bottom and top pieces, the laps brought upon each other and nailed together. The box is now completed.

The box may be made of any polygonal form. Fig. 6 represents the constructional form and arrangement of one in an octagonal shape.

The above-described method of construction, it must be manifest, is one which will introduce a better and cheaper article of its class into use and sale, than has been or is now in the market; in other words, a new, better and cheaper article of manufacture.

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

As a new article of manufacture, a wooden box with a bottom of sufficient thickness to secure and hold nails, in combination with a veneer partially cut crosswise and bent around and secured to said bottom-piece, substantially as described.

Witnesses:

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RICH. VARICK DE WITT,
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