

or wash drawings. There is another process exactly the same, except that no screen is used by the photographer. It is called "Line work," the impression being re-produced in lines instead of the tiny dots of the half-tone process. In line work the work of the acids in giving the required depth of the plate, which is greater than in half-tone work, is supplemented by the "Routing machine," operated by steam and guided by a skilled workman. The illustrations in this article are "line work," being reproduced from pen and ink. A photograph could not be reproduced as a line cut without re-drawing. The illustrations which appear

this department, as in all the others are always confronted with an amount of orders that necessitates hard work and frequently working over time.

It is not necessary to speak at length of the work of publishing the *Dominion Illustrated*. It has its own editorial staff, composing room, steam press, mailing department and other necessary adjuncts of all newspapers. Its distinctive feature is the photogravure work, which we have just described, and which produces the fine illustrations that enrich its pages from week to week. Whoever has the bound volumes of this journal from its first issue has a Canadian picture gallery of rare value, as well as a collection of charming literary contributions by foremost Canadian writers of prose and poetry.

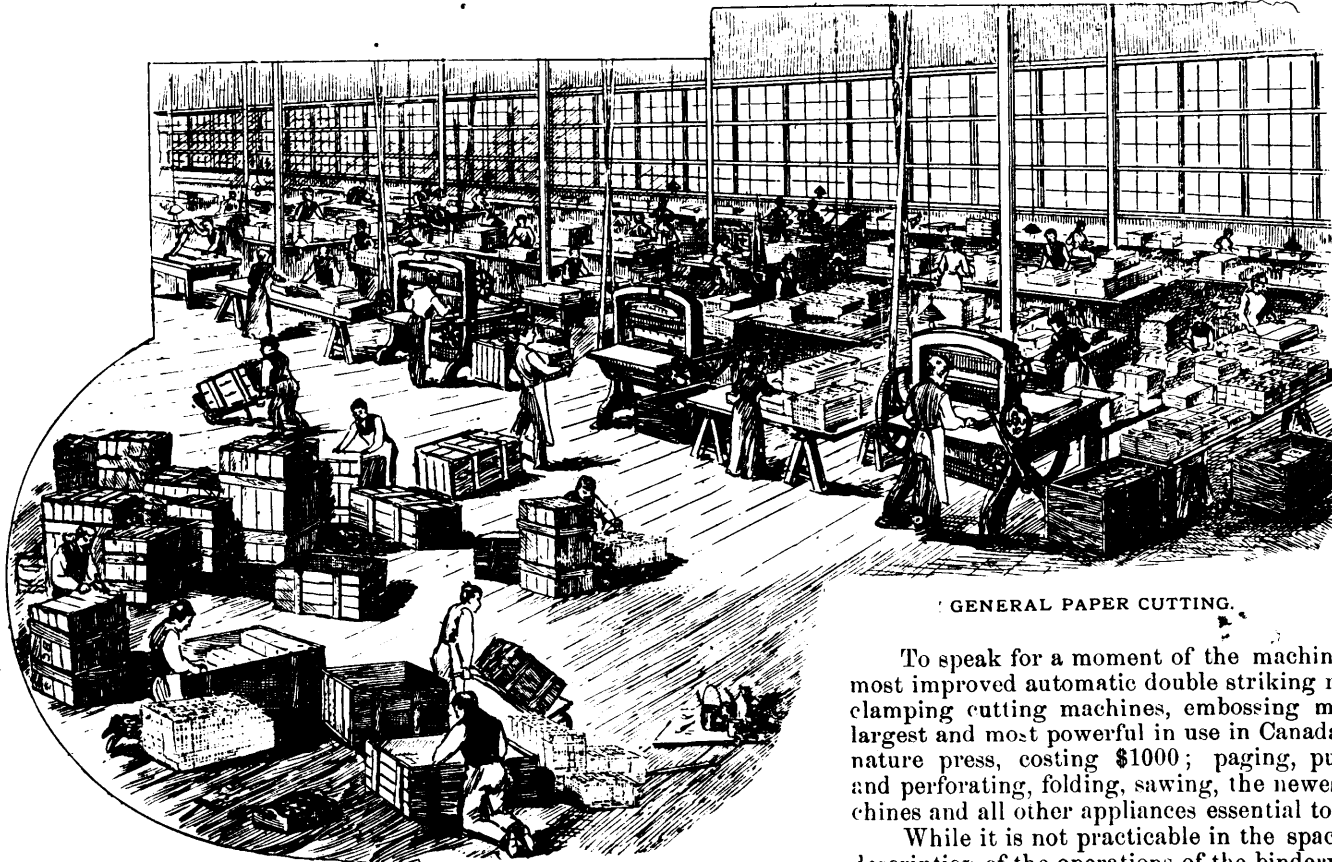
THE BINDERY.

Busy as all the other departments are constantly kept, the bindery of this establishment is the not a whit behind in this respect. The amount of work turned out is enormous, giving employment to no less than eighty-three skilled operatives. When it is stated that every kind of binding, from that of the cheapest small pamphlet to the most expensive blank book or presentation albums done, the variety of work turned out will be apparent.

To speak for a moment of the machinery, there are found here the most improved automatic double striking ruling machines, powerful self-clamping cutting machines, embossing machines, one of which is the largest and most powerful in use in Canada; a new patent hydraulic signature press, costing \$1000; paging, punching and isleting, stabbing and perforating, folding, sawing, the newest improved wire stitching machines and all other appliances essential to the most complete equipment.

While it is not practicable in the space allotted to give a technical description of the operations of the bindery we may briefly refer to some of the work. In the case of an ordinary pamphlet, when it comes from the printer, it is sent at once to the folding department, where by a simple and yet exceedingly intricate machine the folding is done with great rapidity. Next it passes to the wire stitching department, where three machines are in constant operation. After being stitched it passes to the covering department, and thence to the hydraulic press, into which a large number are placed and subjected for about a minute to a tremendous pressure, coming out as solid as a board. One step yet remains—they must go to the cutting machine to be trimmed—after which they are ready to be placed in the hands of the shipper.

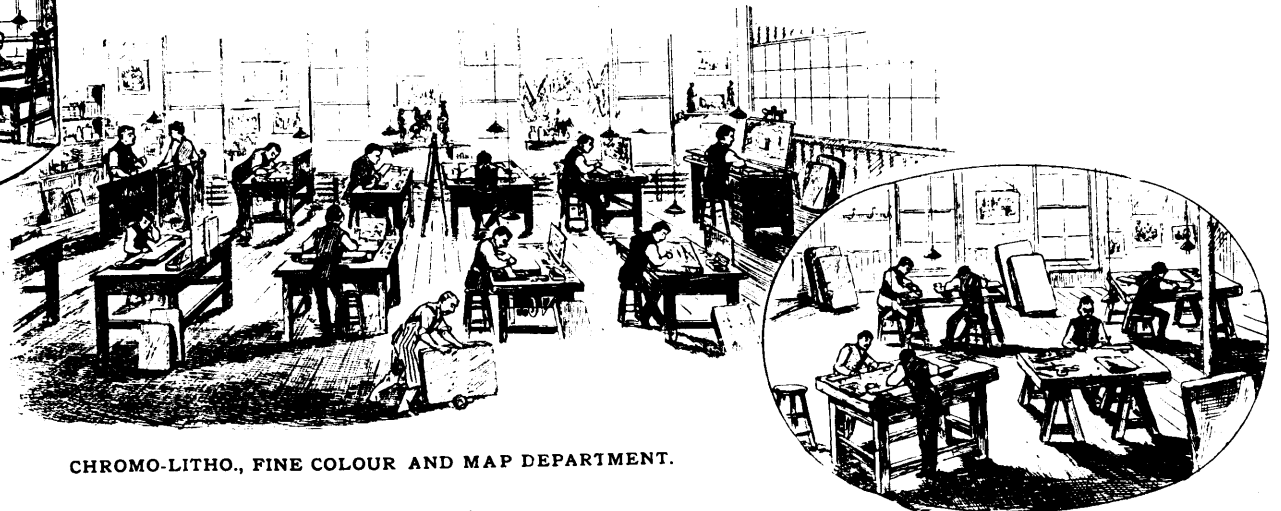
Let us now follow a blank book through the various stages of binding. This department is fitted with the best machinery obtainable, under the care of skilled operatives. The sheets of paper must first go to the ruling machine, through which they pass as rapidly as the machine can be fed, and come out ruled and dry, the mechanism being so perfect and varied



GENERAL PAPER CUTTING.

PACKING DEPARTMENT.

from time to time in the stories, the ornamental initial letters and scrolls or designs of that character are line work, reproduced in the manner described from sketches by the artists of the *Dominion Illustrated* staff. Those who see them will now understand with what care and intricate labour even the production of an initial letter by this process is accomplished. When the paper has been printed the different plates are dismounted from the blocks, numbered and stored away, so that if one is required, it may be years afterwards, for reproduction, or to rent to another publisher or to sell outright, there is no difficulty in at once laying hands



CHROMO-LITHO., FINE COLOUR AND MAP DEPARTMENT.

upon it. In addition to the cuts made for use in the pages of the *Dominion Illustrated*, the photogravure department is constantly rushed with orders for commercial work of that class, such as cuts of buildings or portraits to appear on plain white cards or letter heads or envelopes, or as advertisements in newspapers; besides filling orders for other journals that require cuts of this kind for special issues or any other purpose. The artists in

in adjustableness that the most intricate order in the matter of ruling can be filled. The sheets next pass to the folding and sewing departments and thence to the blank book forwarding department, where the book is marbled and bound up. This marbling of the edges of a book is a most