

the joint and turning the edges, so as to allow them to again overlap, returning to the shape of a coil. The outer cylinder having thus been made larger and the inner one smaller, they can readily be taken away, and the concrete pipe is then left until thoroughly hardened.

Just such a number of pipe as are actually required for the season's work need be manufactured; the implements required are inexpensive, and the pipe may be made by the municipality for actual cost, which, after a little experience, can be reduced to a very small amount.

If cement concrete pipe are employed, they must be of first-class quality. They must be well shaped, as with sewer pipe, and all the rules for making a good concrete must be observed—that is, the material composing the concrete (cement, sand and stone) must be of good quality, and properly mixed. The making of good concrete is not a difficult matter, but it is sometimes difficult to find men who will follow directions. Dirty sand or gravel, too much water, careless and insufficient mixing, neglect to see that the materials are used in the right proportions, are the defects most commonly found. Concrete cannot be mixed like common mortar, and an attempt to do so is far too often made. It is affirmed by cement manufacturers that masons are the greatest offenders in this respect; that it is almost impossible to get them to follow any system other than that to which they have been accustomed in the use of common lime, and that therefore an entirely inexperienced but practical man, who will follow directions, will often make the best concrete.

To meet with success in the use of tile culverts they must be put in place properly. They should be laid with a good fall on a regular grade to a free outlet, in such a way that water will not stand in them. The tile should be laid with the spigot end down grade, and the joints made tight with cement mortar. If the joints are open water will work its way along the outside of the culvert, and finally make a considerable channel which will allow the culvert to get out of line and finally result in a "cave-in." To prevent the water finding its way along the outside of the pipe, it is advisable to protect the ends with concrete, stone or brick head walls. Care should be taken to excavate a concave bed for the pipe, with depressions for the bell of the pipe to rest in, thus securing an even bearing, without which a heavy load passing over before the culvert has properly settled into place, may burst the tile. Tile cannot be used in very shallow culverts, but must have a sufficient depth of earth over them to protect them from the direct pressure of heavy loads. The depth of covering necessary increases with the size of the pipe. At least a foot of earth over the top is advisable in every case, but for culverts of two feet in diameter, or over, this should be increased to at least eighteen inches.

The earth should be well packed and rammed around the tile to secure a firm bearing, and light soils should not be used immediately over or around the culvert. A heavy clay, a firm gravel or a compact sand or gravel will answer, but vegetable mould, water sand, and light loams are subject to wash-outs. At the outlet the culvert should be set nearly flush with the surface of the ground. If set higher than the surface, the fall of water will wash out a depression, and in time will undermine the end of the culvert. A too rapid grade will have the same effect, and it is well to cobble-pave an outlet where this undermining action is liable to occur.

Culverts, in many townships, are very numerous, and necessarily so. Water should be disposed of in small quantities, along natural watercourses, otherwise if gathered in large bodies along the roadside, it gathers force and headway, resulting in extensive washouts, and in every way more costly to handle. Water should be taken away from the roads as quickly as possible, for it is excess water that is the great destroyer of roads.

Culverts, in addition to being a matter of considerable expense to municipalities, are too often in a bad state of repair, sometimes dangerous, and when not level with the roadway, are an annoyance and interruption to traffic. Good road making is largely a matter of good drainage, and culverts are a detail of drainage upon which municipal councils should bestow a good deal of attention, with a view to a greater permanency, increased efficiency, and a reduction of cost.

The concrete arch culvert is, in a number of municipalities, replacing the old

form of timber structure. Greater in first cost, the concrete culvert, if rightly constructed, is a permanent saving in road expenditure. The greater portion of the annual road appropriation is, in many townships, spent in repairing and rebuilding wooden culverts and sluiceways. The life of timber in this work is very short. Wooden culverts are quickly upheaved by frost, warped by sun, and decayed by penetration of moisture. Wherever concrete culverts have been fairly tested they give satisfaction, and their general use by a township will mean, in the course of a few years, a marked reduction in this branch of roadwork.

(To be Continued.)

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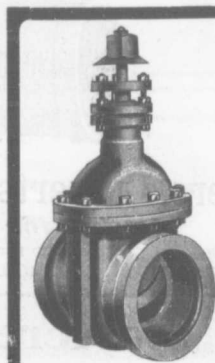
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