

machine by a windlass or crab on a swinging crane, and the chucks are driven into the ends of the block by a friction dogging attachment handled by the operator of the machine. The block revolves, and the knife and back roller approach the block by means of a right and left-hand screw, which regulates the thickness of the cut. This thickness is obtained by gears very similar to an iron lathe. In the back roller is inserted knives laying lengthwise of roller, which extend outside the diameter of the roller the thickness the stave is to be cut. As the block turns around these knives cut into the surface of the block, cutting the staves to random widths before they are cut to thickness. Above the knives, and at a distance apart to cut the desired length of the stave, are placed at both ends a spur knife that enters the block and cuts the stave to length by trimming off all surplus stock outside length of the stave. The timber passes through the space between the edge of the knife and the pressure bar, and drops into the conveyor and is carried to stackers. The pressure bar is a very im-

portant part of the machine, as the amount of pressure regulates the solidity of the staves, and indifference to its importance has caused some people to fall down on the veneer stave, which must be cut solid to maintain the circle and keep the stave from cupping in. This could not be shown except by a sketch showing the proper angle to knife and the height above the edge of knife. This information is furnished by the makers of the machines, which an operator must observe, as the bars wear fast; and this point must be maintained at all times by grinding the bar as often as the knife is ground.

By this process staves can be cut to any length and thickness. In the shorter lengths, such as keg staves, two lengths can be cut at one time. I have cut 100,000 17 1/2-inch staves in ten hours. The fact must be considered in this process; small timber is not practical, but for timber 24 inches and up in diameter, more staves can be cut in same time and from less timber than by the old method.

From the veneer machine the staves are

piled, and their handling is the same in every way as by the old process, except that there are no staves to split nor is there any narrow staves, which is a feature appreciated by the cooper, as it enables him to make a much nicer package at no extra labor. The jointing is easier, as the edges are all square, and one clipping always insures a good joint. The whole process is simple. The expense of splitting into bolts is avoided, you get all No. 1 staves from clear timber, and more staves are obtained from same amount of timber.

There was a meeting of the Michigan maple lumber manufacturers in Grand Rapids, Mich., on October 17th, for the purpose of considering ways and means for putting their business on a better basis than it has been for some time past. The result of the meeting was a decision to organize a company with a capital of \$250,000, which will contract for or buy outright the product of the mills. Over 50 per cent. of the necessary capital was subscribed at this meeting. The output of maple lumber represented at this meeting was 107,000,000 feet annually.

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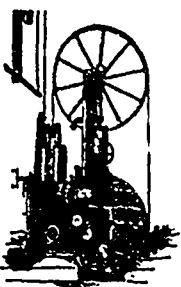
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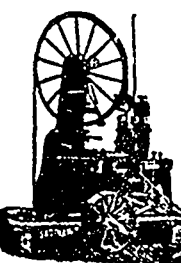
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