

the mixture as it passes from between big polished steel cylinders or rolls, each of them weighing approximately twenty-six tons. As they receive this "mix" they press it firmly against the burlap base which has also been introduced between the big rolls and the two are so securely pressed together as to make them practically inseparable. It is possible to regulate the rolls so that linoleum of any desired thickness may be manufactured, adjustment being possible to a hair's breadth.

CURING THE LINOLEUM

The linoleum has now started on its long journey through processes of curing which require many days,—sometimes weeks. Batteries of cells, or huge stoves made of concrete, brick and stone, are ready to receive the goods as they pass along and are delivered into them. Operators guide the linoleum and it is arranged in festoons extending from the top of these cells to near the floor, a distance of over 50 feet. Sometimes miles of linoleum will be delivered into a single cell. The cell is closed and sealed, and the steam heat turned on through the extensive piping systems used, to be thus maintained for days or weeks, as required.

These big cells are 100 feet in length and specially ventilated. The heating temperature is maintained at approximately 150 degrees Fahrenheit, the linoleum being carefully tested to determine when curing has been completed. When this is accomplished the goods are removed and are then ready for printing.

PRINTING BLOCKS

One of the most important and most interesting operations connected with the manufacture of linoleum is that of the printing. It involves a great many important and costly undertakings, a detailed description of which will, we hope, afford the reader a new viewpoint when making linoleum sales.

Before any printing of the pattern is possible the designers have to evolve designs, first in pencil, and then develop them in all their wonderful detail. After many of these designs have been submitted, the desired ones are chosen and all details of coloring, etc., just as they will appear in the finished pattern, are transferred to blocks of specially prepared wood. Expert Block Cutters then cut this special wood

—a combination of white pine and cottonwood, for the base, faced with hard maple, all made in layers and placed at a different angle to prevent warping.

The face of the Printing Block is creased by sawing fine, parallel lines in one direction, or both, thus facilitating the tracing of the design and eventual cutting away of unneeded or superfluous wood. Sometimes parts of the design may be cut or punched in metal and tacked to the Block in desired places. For printing solid masses of color the wood is used, and for outlines, metal. A separate block has, of course, to be used for printing each color, so that it will be readily seen how extensive are the required operations in producing any printed linoleum. In the making of the metal part of Pattern Block a section of Scotch Line Wood is employed. On the face of this that part of the design to be metallized is first drawn and then burnt in to a depth of about one third of an inch. Molten type metal is now poured into this, cooled and removed. After buffing the casting is attached to the Block.

PRINTING THE PATTERN

Before printing, great quantities of the required paint have to be prepared. These are made in many shades. The colors are first tested carefully and in the mixing of required ingredients huge paint mills are employed. The colors with necessary oils, are ground between rollers until they are of impalpable fineness, and each and every shade must conform with tests and shades previously determined by expert chemists. In addition, all the oil used is carefully selected, boiled and treated, so that every yard of goods will be of uniformly high standard.

Huge Printing Presses, forty to eighty feet in length, and of the required width to produce given widths of linoleum, are employed. The Printing Blocks already described are attached face down, and automatically coated with the shade of paint. As the machine is operated the action of the printing is automatic, first one block prints, then another, this being regulated by cams operated by means of an eccentric. As the linoleum or oilcloth is automatically pulled forward colors are printed one after another, and when the printed goods reach the cell they have been completed with the exception of necessary drying and curing. This is accomplished by leaving the goods in cell the required length of time.

Passed by the Censor

"A Chiel's amang ye takin' notes,
An' faith he'll print them!" —Burns.

Have you heard the explanation of the origin of the slow-motion "Movie" picture? Two Scotsmen offering to pay for the lunch! —(From a Vancouver Scottish Kiwanian)

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TRY "THE OLD COMPLAINT" QUESTION:

This One May be Worth a "Place" to a Politician

On a Vancouver street theother day, a British Columbia Judge, who had just parted with a prominent member of the Bar, turned to the editor of this Magazine in great glee, and said: "What do you think? I just tried him with Palmerstone's prescription, and I got a full history of his complaint. You know Palmerstone said that when he went round his constituency and met the farmers he usually saluted the old men, individually, with the query—'And how is the old complaint?' and he found that the question seldom failed to bring out a story of some personal trouble such as rheumatism, etc. And, of course the farmers thought he was a remarkable man, with a peculiar personal interest in them, in that he remembered their affliction!"

Why are Scottish people usually so happy and hearty as they grow old? Because they are then beginning to see the points of the jokes told them in their youth!

—(From one of Mac's Grocery Salesmen)

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