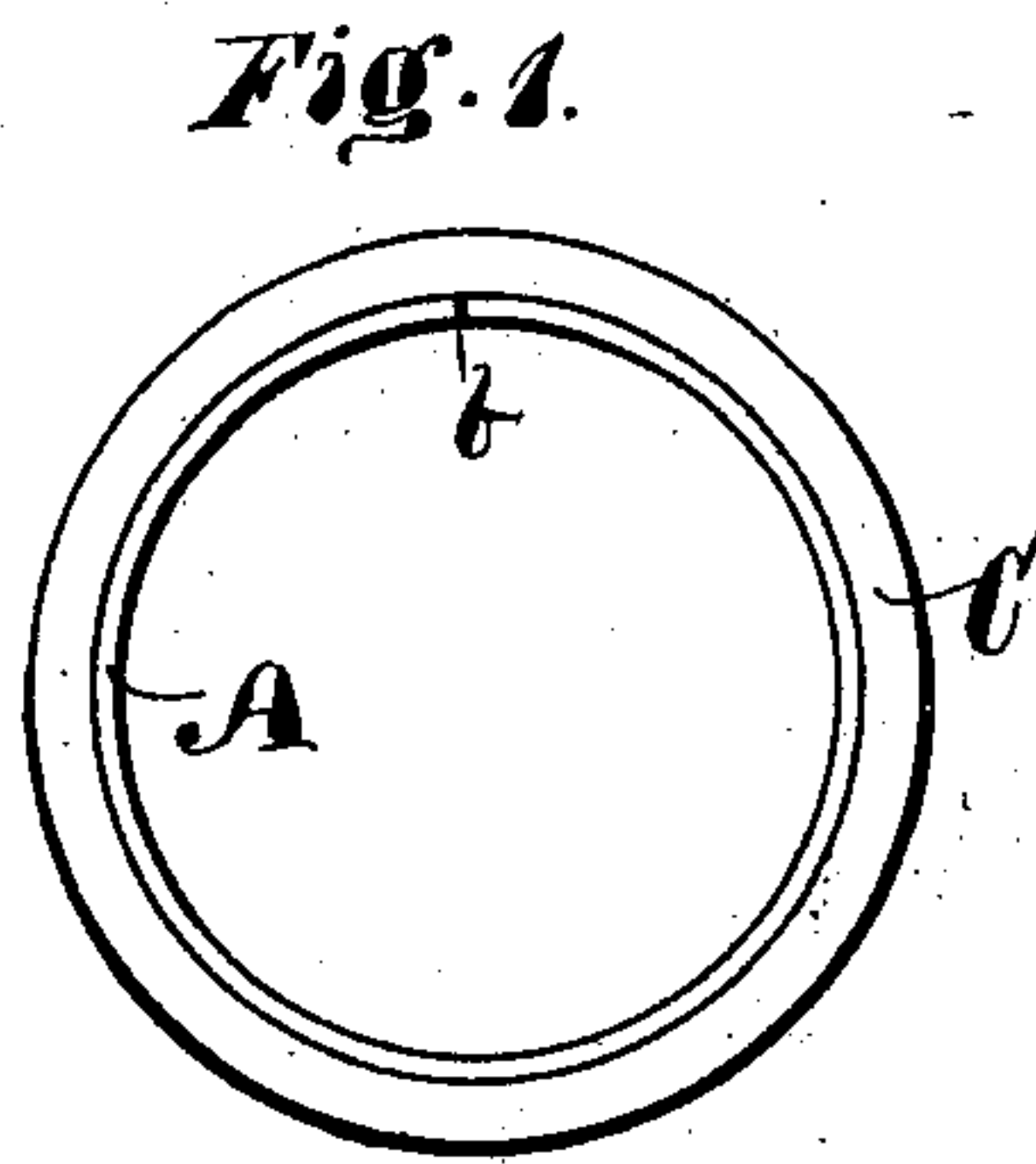
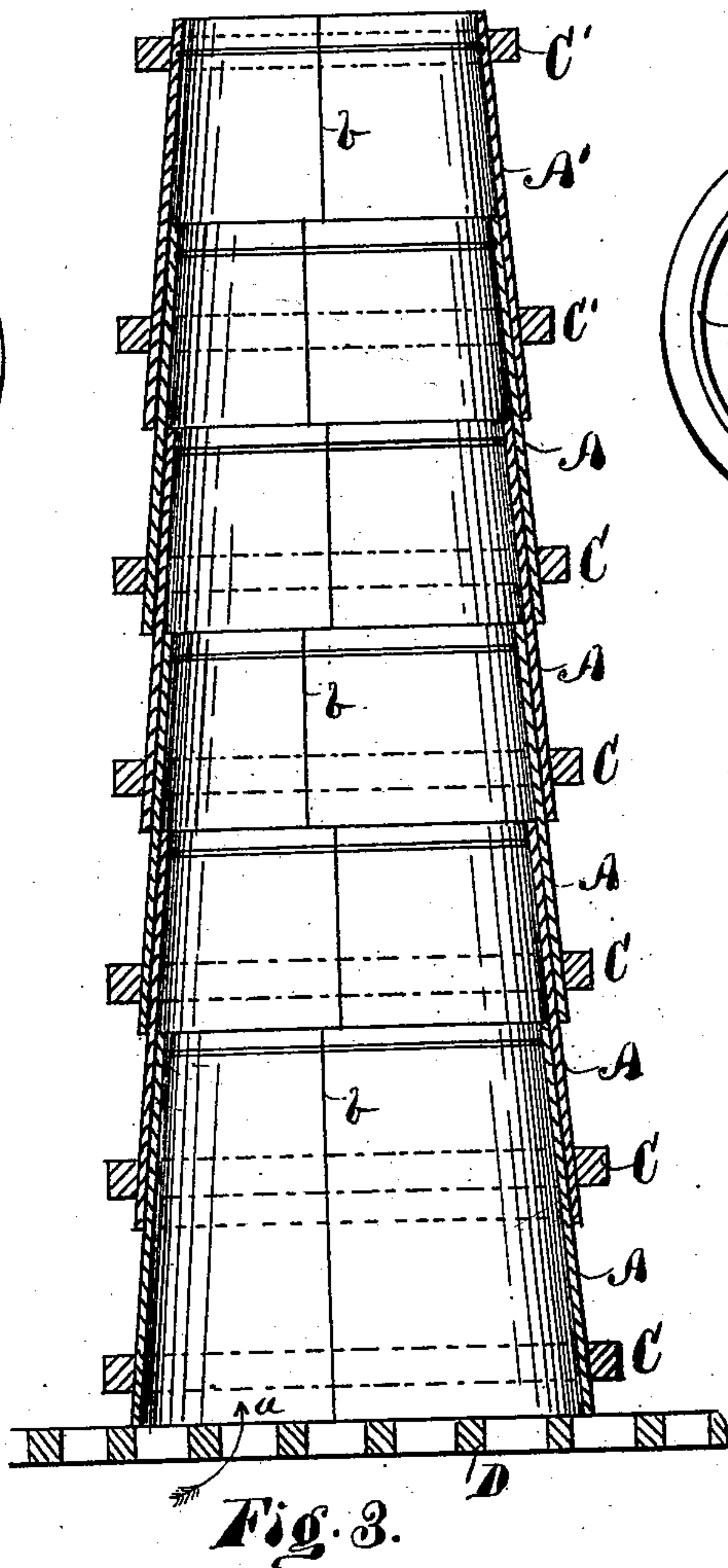
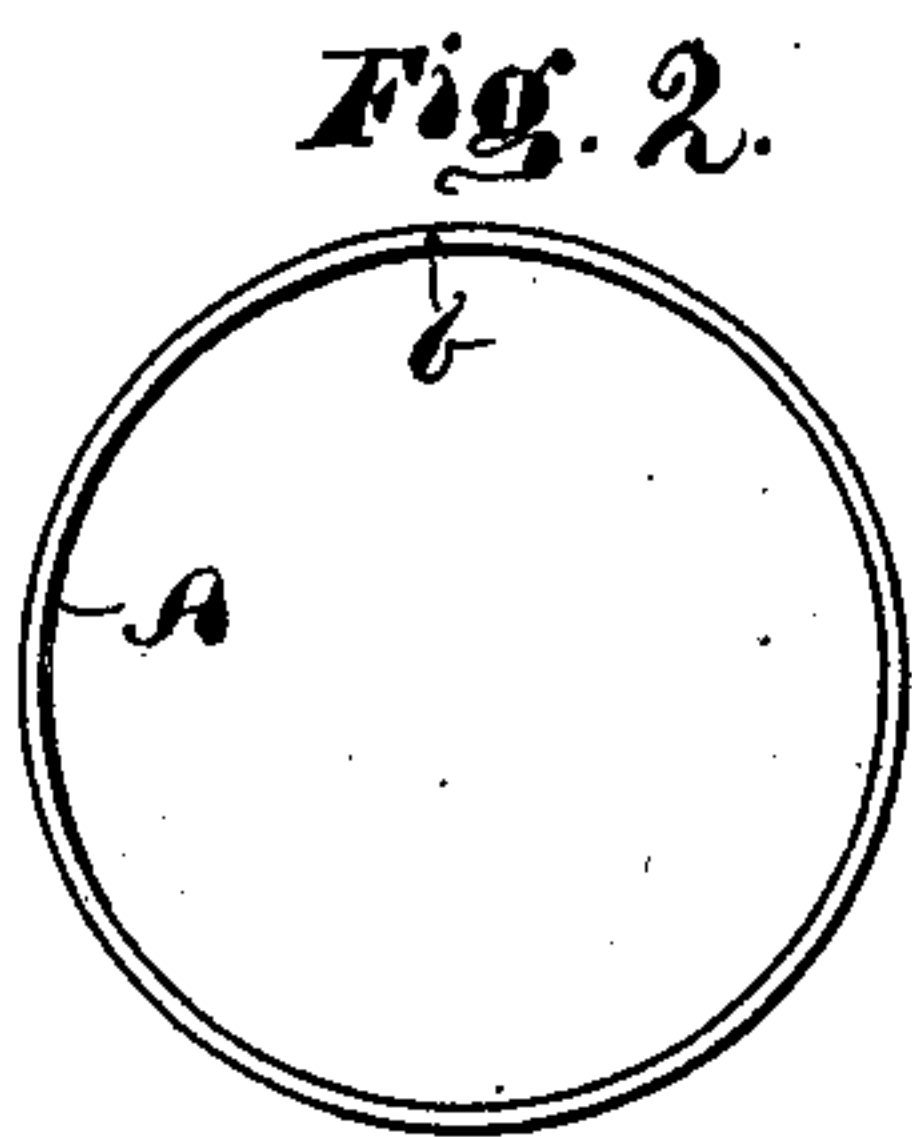


(No Model.)

I. HOGELAND.  
Method of Seasoning Cylinders of One-Stave Vessels.

No. 230,481.

Patented July 27, 1880.



WITNESSES;  
Zelora Phillips  
G. H. Remmett.

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# UNITED STATES PATENT OFFICE.

ISRAEL HOGELAND, OF INDIANAPOLIS, INDIANA, ASSIGNOR TO HIMSELF  
AND GEORGE P. ANDERSON, OF SAME PLACE.

## METHOD OF SEASONING CYLINDERS OF ONE-STAVE VESSELS.

SPECIFICATION forming part of Letters Patent No. 230,481, dated July 27, 1880.

Application filed March 2, 1880. (No model.)

*To all whom it may concern:*

Be it known that I, ISRAEL HOGELAND, a citizen of the United States, residing at Indianapolis, in the county of Marion and State of Indiana, have invented certain new and useful Improvements in Seasoning the Cylinders of One-Stave Buckets, Tubs, Kits, Kegs, &c.; and I do hereby declare that the following is a full, clear, and exact description of the invention, which will enable others skilled in the art to which it appertains to make and use the same.

Heretofore the seasoning of a single sheet or ribbon of veneer of sufficient size to form a bucket, tub, kit, or keg of one stave has been difficult to accomplish without checking or crimping the veneer so as to spoil it for forming a perfect article of manufacture suitable for the market.

The object of my invention is to thoroughly season the cylinders of one-stave buckets, tubs, kegs, kits, &c., which are formed from sheets of veneer, cut to the proper shape and bent into cylinders while hot and steaming, to prevent the cylinders while seasoning from checking or becoming crimped, and to retain the cylinders in their proper shape during the process of seasoning; and to this end my invention consists in re-steaming the blanks of veneer after they have been cut to the proper pattern, then bending each of them into a cylinder, forming the cylinder of the article to be seasoned, then hooping them with a single truss-hoop on the large end of each cylinder, then nesting them together, so that the small end of one cylinder will be inside of the large end of the next cylinder, the last or outside cylinder having two truss-hoops on it, one at the large end, the other at the small end. These cylinders, when nested, are first laid horizontally to permit cold air to circulate through them for from twenty-four to forty-eight hours, after which they are placed in the dry-house, standing on their large ends, so as to permit the hot air to circulate up through them as well as on the outside. As they dry and season they naturally shrink and settle together until perfectly seasoned, ready for the final hooping.

To carry my invention into effect, I first cut the veneer in ribbons from the steamed log, and then cut the veneer to a pattern of the proper shape to form the cylinder of the article to be manufactured. These blanks are then re-steamed and bent into cylinders for seasoning.

In order to illustrate my process more fully, I have prepared the accompanying drawings, which form part of this specification, and in which—

Figure 1 is a top view of a single cylinder bent and provided with a truss-hoop. Fig. 2 is an end view of the cylinder before the truss-hoop is placed thereon. It also shows the form of the cylinder when seasoned. Fig. 3 is a vertical section of a nest of cylinders standing on its large end in a dry-house.

Like letters refer to like parts in the various views.

The re-steamed blanks are bent while hot with the checked side of the blank inside and the joint at *b*, as shown in Fig. 2, after which a truss-hoop, *C*, which is constructed of sufficient rigidity to retain its shape during the process of seasoning, is placed over the small end of the cylinder and forced down near the large end, thus bringing the two edges of the cylinder together, forming the joint *b*, and giving to the blank the shape of the inside of the truss-hoop. The first cylinder, *A'*, thus prepared is furnished with two truss-hoops, *C' C'*, one near the large end, the other near the small end, as shown at the top of Fig. 3. This cylinder, when hooped, is set on the floor with its small end down—*i. e.*, reversed from that shown in Fig. 3.

Each of the other cylinders, *A*, of the nest is provided with only one hoop, *C*, which is near the large end, the small end being inserted in the large end of the cylinder *A'*, and the large end of this cylinder *A'*, which has the hoop *C'* around it, also forms a compound hoop to incase the small end of the cylinder *A*. Thus several cylinders *A* are placed and forced together, as shown in Fig. 3. The nest of cylinders is then laid down, so as to permit cold air to pass through all of them, while in a horizontal position, for a period of from twenty-



four to forty-eight hours, more or less. The nests are then set up on the large end and the cylinders pressed together again, after which they are removed to the dry-house and set on the floor, as shown in Fig. 3, thus permitting the hot air to circulate freely through them, as well as all around them.

If necessary, a weight may be placed on top of the two-hooped cylinder at the top, to assist the settling of the cylinders into each other as they season and shrink.

It will be observed that the hoop C at the large end of the bottom cylinder will gradually settle down as the cylinder shrinks, and that the other hoops on the other cylinders above also settle; also that the cylinders settle one outside of the other until the whole nest is perfectly dry and seasoned.

It will also be observed that the cylinders, while seasoning, also retain their shape, and do not get any chance to check, buckle, or warp, and that when the cylinders are removed from each other they will retain their form, and may be hooped ready for the market. Thus I am enabled to rapidly produce thoroughly-seasoned and perfectly-formed one-stave buckets, tubs, kits, kegs, &c., that are merchantable, cheap, and durable, which heretofore has been difficult to accomplish by any of the old processes, owing to the nature and

condition of the thin veneer employed and its liability to check and crimp during the process of seasoning.

Having fully described my invention, what I desire to claim, and secure by Letters Patent, is—

The process of seasoning the cylinders of one-stave buckets, tubs, kits, kegs, &c., which consists in resteamming the blanks of veneer, bending and hooping each cylinder with a single truss-hoop on the large end of each cylinder, nesting the cylinders thus prepared, so that the small end of one cylinder will extend inside of the large end of the next cylinder, an outside cylinder having two hoops on it, one near the large end, the other near the small end thereof, the nest of cylinders thus formed being first laid horizontally for several hours where cold air can pass through them, and then placed in a dry-house, standing on the large end of the lower cylinder, so that the hot air can circulate up through the nest as well as on its outside, as described.

In testimony whereof I have signed my name to this specification in the presence of two subscribing witnesses.

ISRAEL HOGELAND.

Witnesses:

E. O. FRINK,  
GEORGE H. RENNETT.