

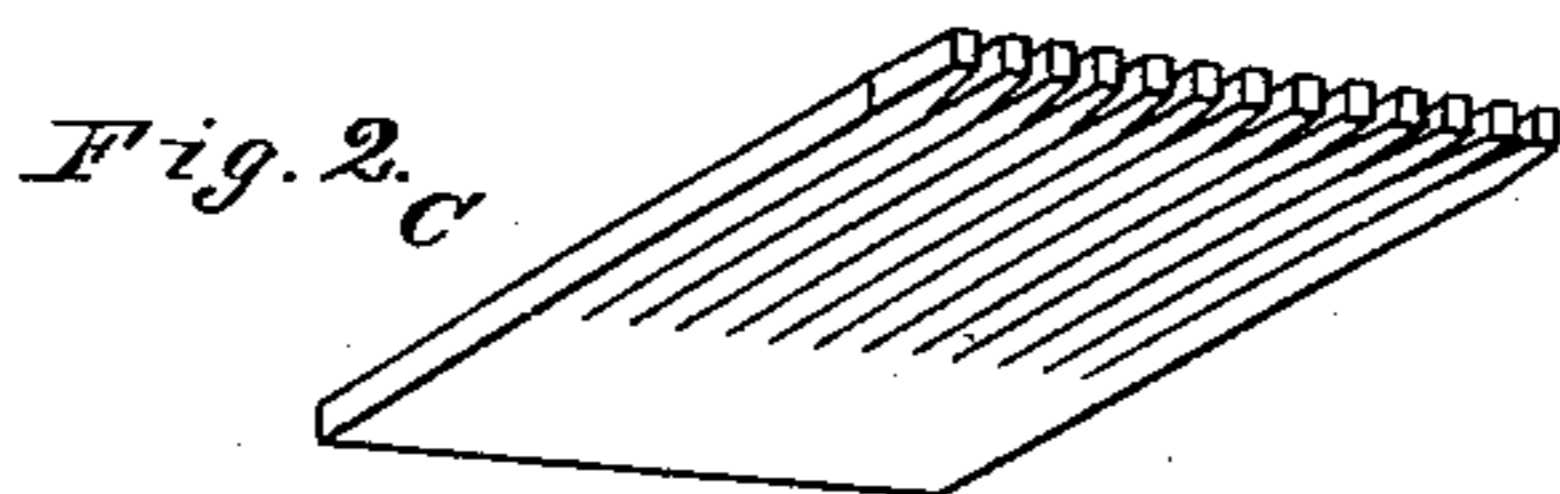
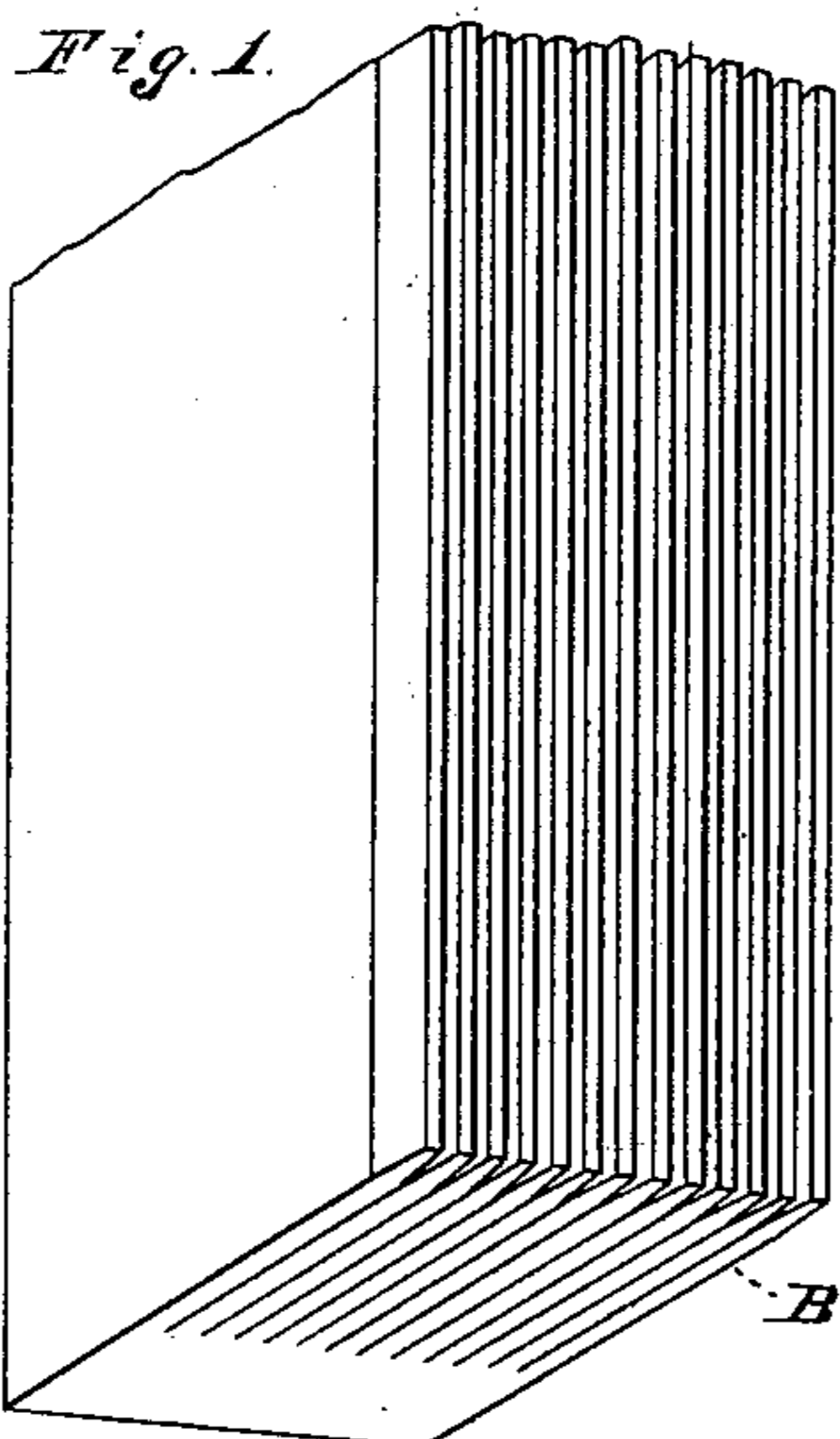
(No Model.)

G. FLEWWELLING & G. J. HARRIS.

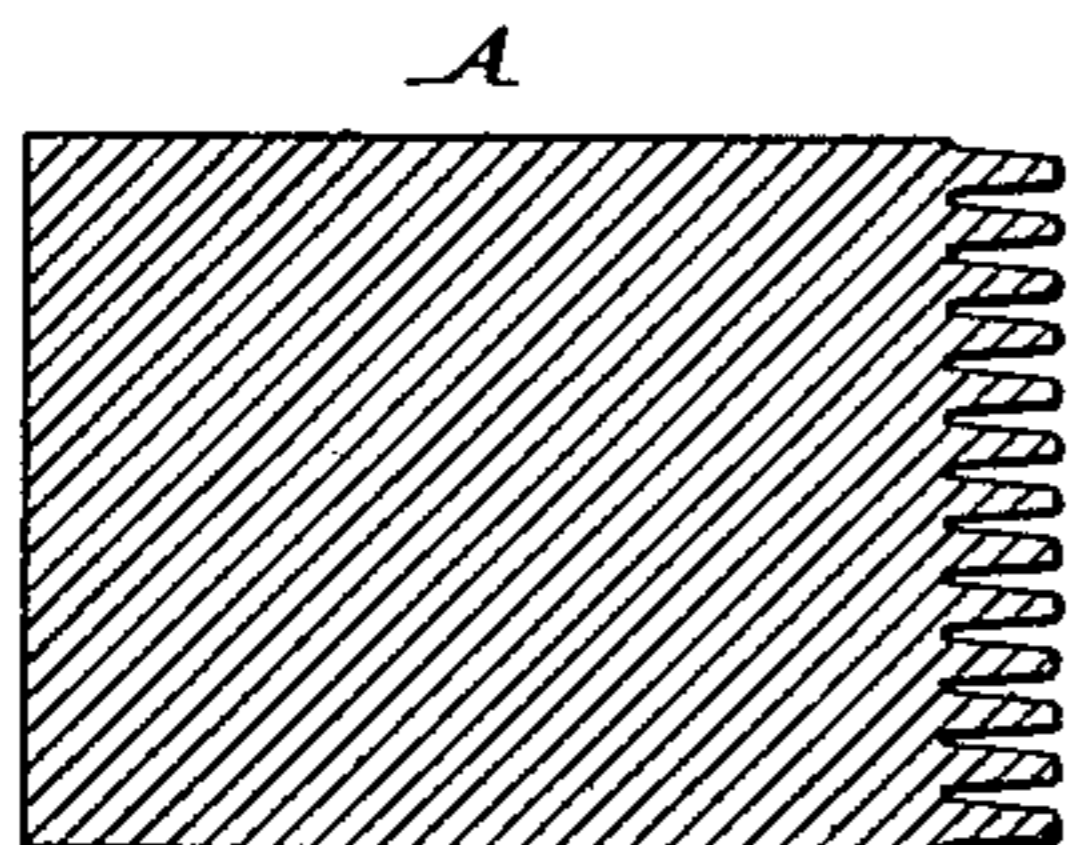
PROCESS OF MAKING MATCHES.

No. 335,516.

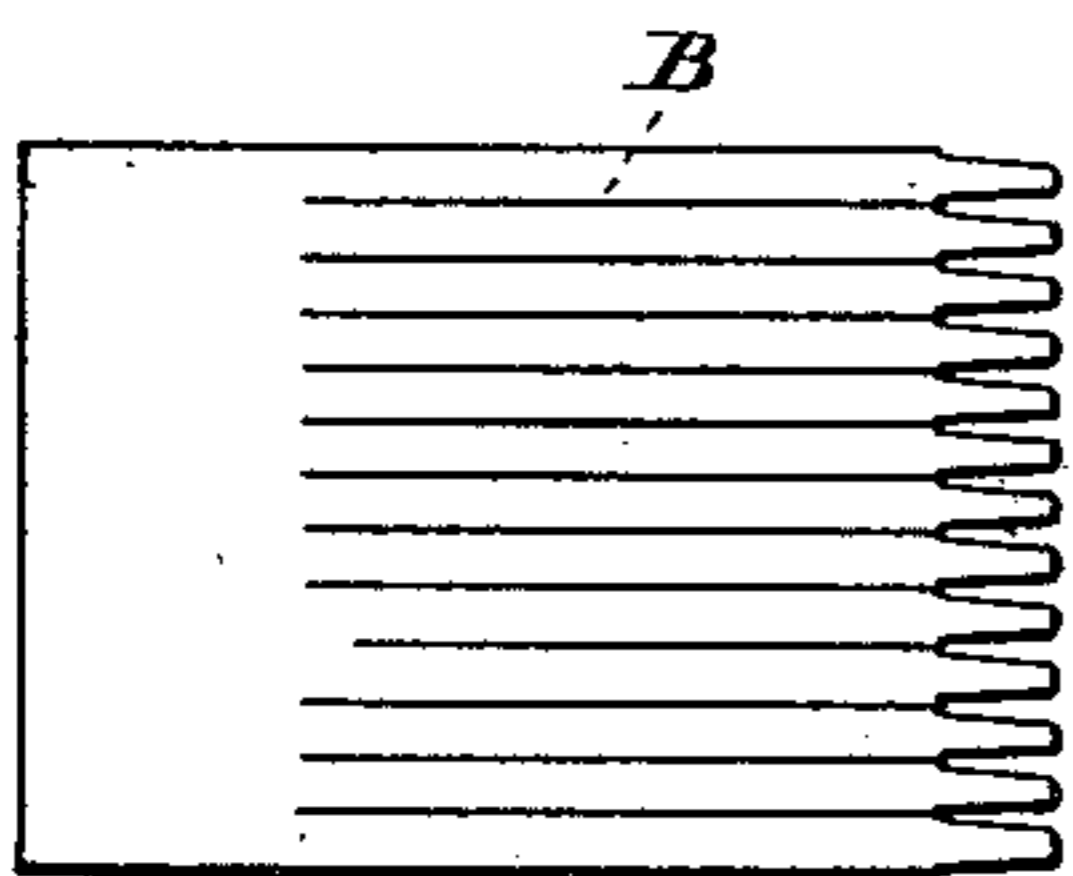
Patented Feb. 2, 1886.



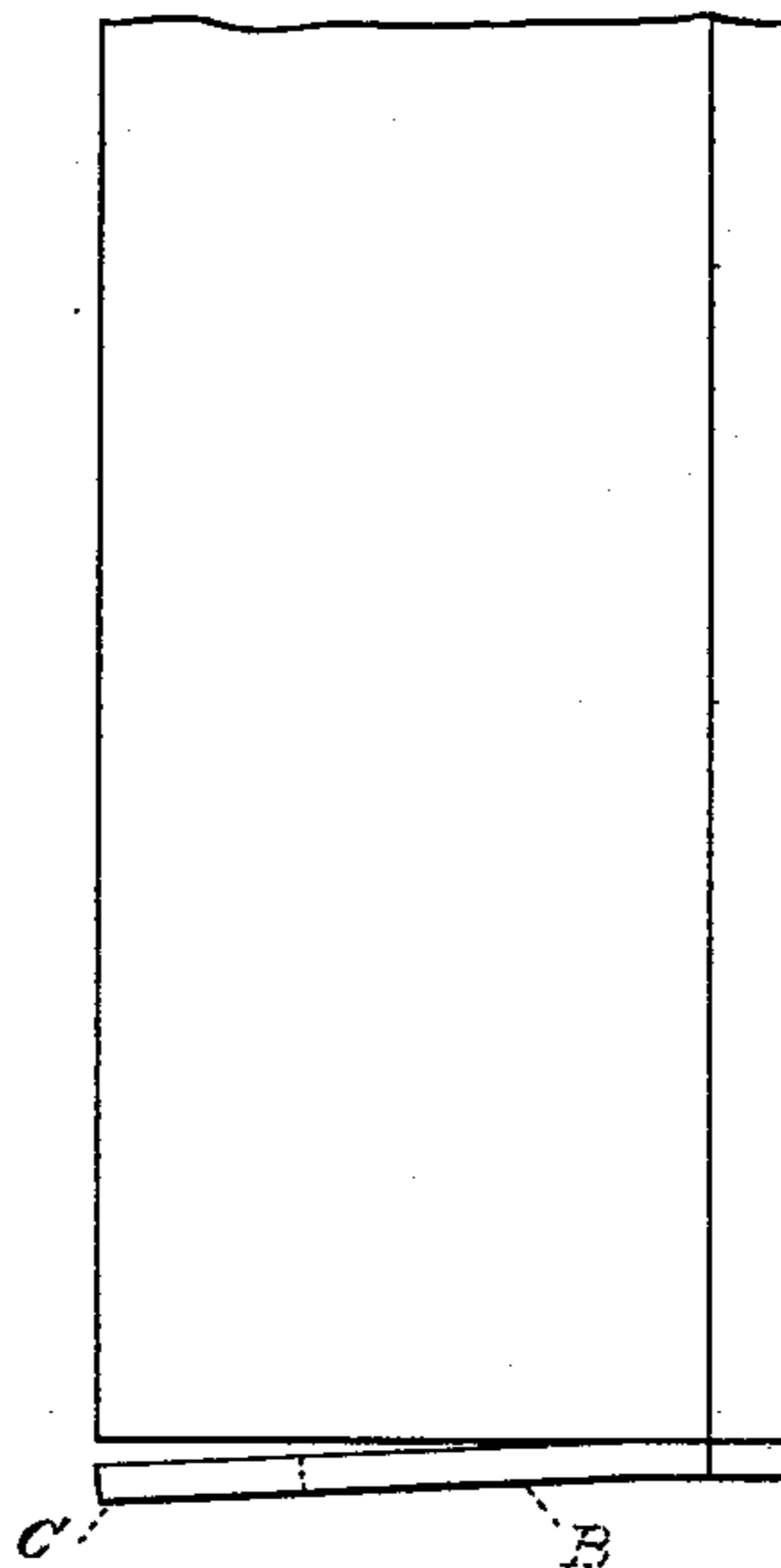
*Fig. 3.*



*Fig. 4.*



*Fig. 5.*



WITNESSES

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# UNITED STATES PATENT OFFICE.

GILFORD FLEWWELLING AND GILBERT JUDSON HARRIS, OF HAMPTON,  
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## PROCESS OF MAKING MATCHES.

SPECIFICATION forming part of Letters Patent No. 335,516, dated February 2, 1886.

Application filed August 3, 1885. Serial No. 173,456. (No model.)

*To all whom it may concern:*

Be it known that we, GILFORD FLEWWELLING and GILBERT J. HARRIS, both subjects of the Queen of Great Britain, residing at Hampton, Province of New Brunswick, Canada, have invented certain new and useful Improvements in Processes of Match-Making; and we do declare the following to be a full, clear, and exact description of the invention, such as will enable others skilled in the art to which it appertains to make and use the same, reference being had to the accompanying drawings, and to letters or figures of reference marked thereon, which form a part of this specification.

Figure 1 of the drawings is a representation of this invention, and is a perspective view of the block, it being broken away at the top. Fig. 2 is a perspective view of the match-card split up. Fig. 3 is a cross-section through the block after being grooved. Fig. 4 is an end or bottom view of the block after being slit. Fig. 5 is a side view, and shows the match-card split off of the block.

This invention has relation to the manufacture of match-cards; and it consists in the process of partially slitting the end of the block in parallel lines as it is fed, and then splitting off the slit portion forming a card of match-splints connected by the unslit portion, all as hereinafter set forth.

In carrying out this process we provide rollers between which the wood block or stock A is fed in guides to gang-saws, which groove the side of the block at the end of the grain. The feed carries the grooved block to gang-cutters, which slit the end of the block in par-

allel lines, as at B, these slits or cuts being made with the grain of the wood. The cutters by which these slits are made project in the opposite direction to that of the feed. Then by means of a cutter operating at right angles to the direction of feeding the slitted end portion or layer of the block is split or sliced off and forms a match-card, C, in which the splints are separated by cuts and are left connected at the unslit portion.

By this process superior match-cards are made directly from the wood in its natural state without previous artificial preparation to soften it, as is usual in the methods now commonly employed.

Having thus described this invention, what we claim, and desire to secure by Letters Patent, is—

The process of making match-cards, which consists in first forming the sides of the splints by grooving the sides of an elongated block of stock and partially slitting the end of the same in parallel lines by cutters projecting at right angles to the line of feed and operating in the direction of the grain, and, secondly, completing the match-card by splitting off the end portion or layer, which forms as it is thus split off a card of match-splints connected by the unslit portion, substantially as specified.

In testimony whereof we affix our signatures in presence of two witnesses.

GILFORD FLEWWELLING.  
GILBERT JUDSON HARRIS.

Witnesses:

JOHN GALEY,  
E. A. FLEWWELLING.