

No. 737,692.

PATENTED SEPT. 1, 1903.

J. ALGER.
METHOD OF MAKING PAPER BOXES.
APPLICATION FILED APR. 7, 1903.

NO MODEL.

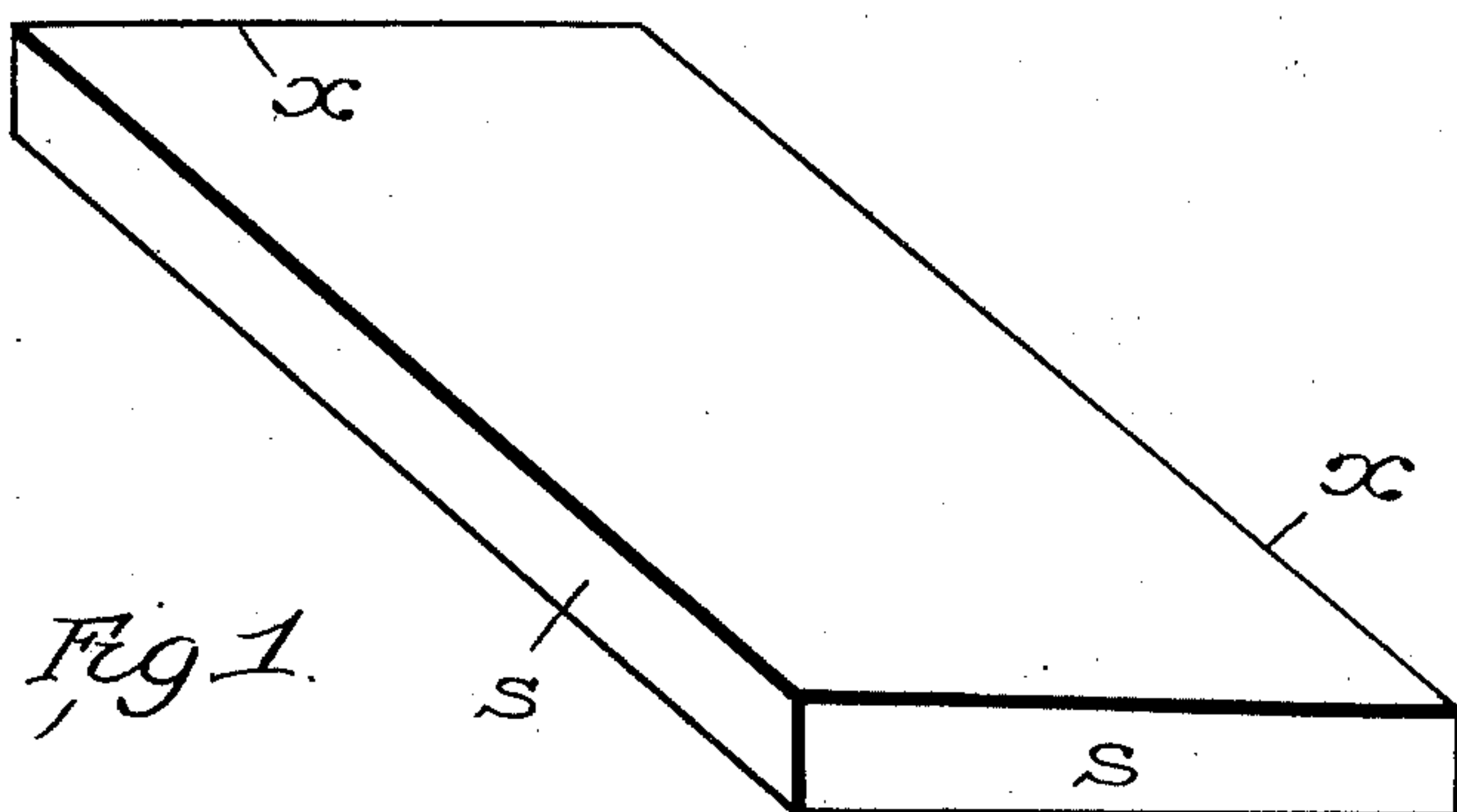


Fig. 1.

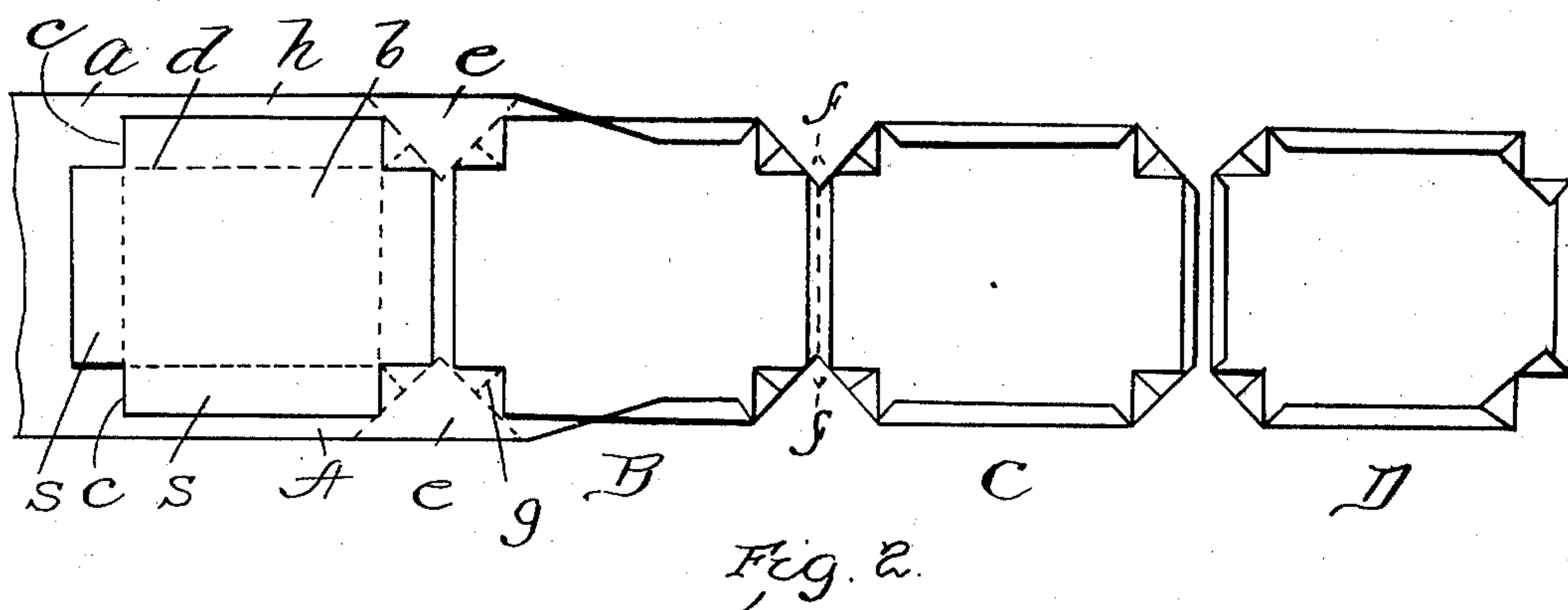


Fig. 2.

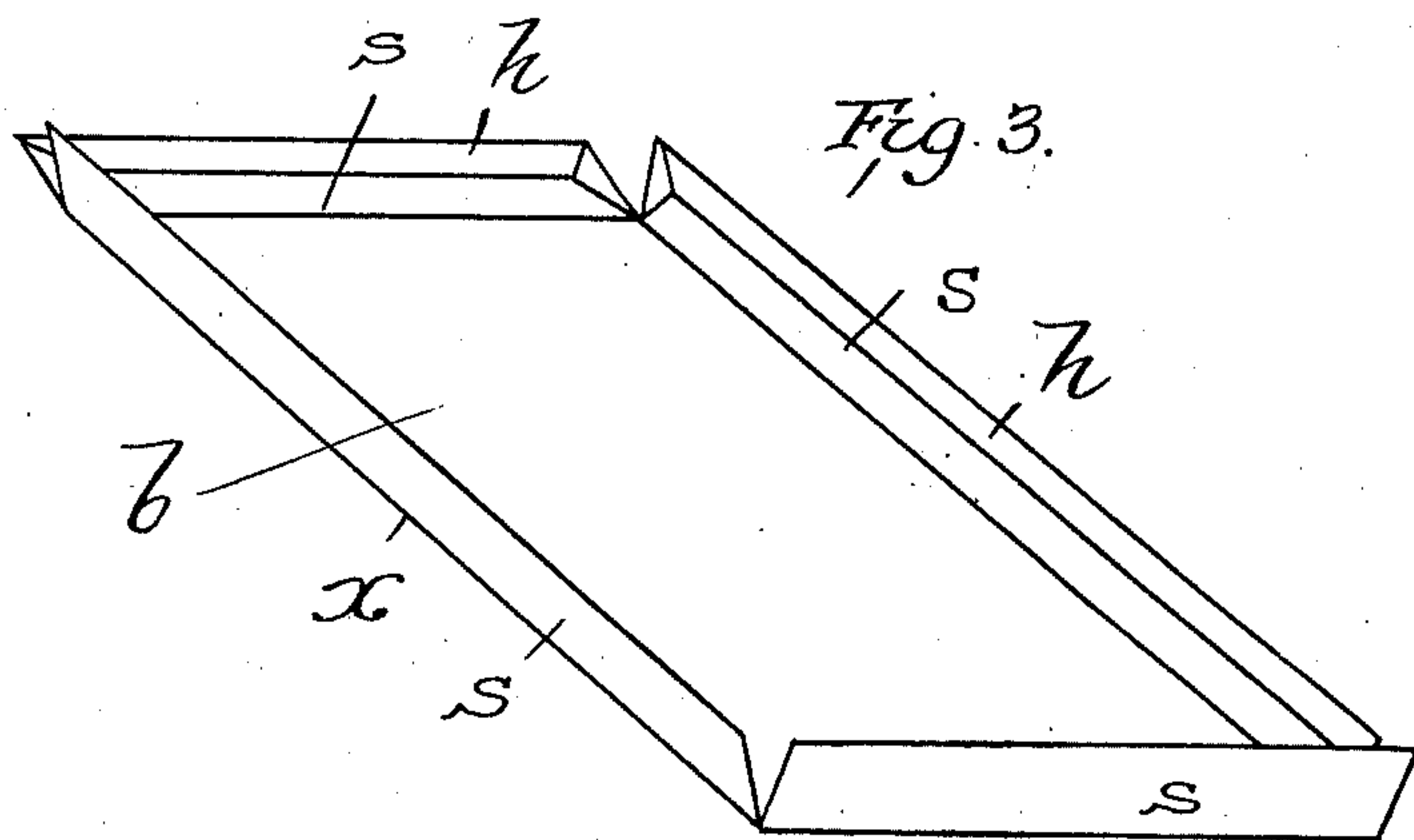


Fig. 3.

WITNESSES:

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JOSEPH ALGER, OF WEST BRIDGEWATER, MASSACHUSETTS.

METHOD OF MAKING PAPER BOXES.

SPECIFICATION forming part of Letters Patent No. 737,692, dated September 1, 1903.

Application filed April 7, 1903. Serial No. 151,496. (No model.)

To all whom it may concern:

Be it known that I, JOSEPH ALGER, a citizen of the United States, residing at West Bridgewater, county of Plymouth, and State of Massachusetts, have invented certain new and useful Improvements in Methods of Making Paper Boxes, of which the following is a specification.

This invention relates to the manufacture of paper boxes or box-covers, and particularly to that class in which the strawboard of the box or cover is covered by a smooth-surfaced paper, the object being to produce a box which will be finished on all sides and all of whose long edges will be neatly overlaid by the surfaced paper.

It has been customary heretofore to apply paper to the ready-formed box by running a strip around the sides and ends and to cover the top or the bottom of the cover of the box, as the case may be, by a sheet which comes to the edges and covers the overlapping portions of the side strip. This method is unsatisfactory, as it does not give a smooth-finished box and involves an additional step and handling.

It has also been attempted to cover a blank which is to form the ends and sides of a box by applying to it a covering-sheet; but as this type of box necessitates the separate application of an additional blank for the bottom or top of the box it is an unsatisfactory method of structure and has also the undesirable seams on its edges.

To this end the present invention involves the application of covering-paper to a flat cornered blank, overturning its edges thereon, and forming the margins of the blank into the sides and ends of the box or top.

In the accompanying drawings, in which like letters indicate corresponding parts throughout, Figure 1 is a view of a box-cover. Fig. 2 is a diagrammatic plan of the blank and paper in the various steps through which they pass. Fig. 3 is a view of the covered blank with its sides and ends partially bent into position.

a is a covering-sheet which is drawn as a continuous web from a roll of finished covering-paper and to which paste has been applied.

b is a strawboard blank cornered out at *c*

to leave marginal flaps *s*, which are to form the sides and ends of the box or cover, and along the lines of the fold *d* (indicated in dotted lines) the board is scored to facilitate bending.

The blanks are united at intervals to the covering-web, which is slightly broader than the blank, as may be seen at *A*. From the spaces between the blanks V-shaped sections *e* are cut, and the paper, if necessary, is slit to the corner of the box, as at *g*. The edges of the sheet *h* are then overturned and firmly pasted down on the margin of the blank, as at *B*. The covering-web, which has united the blanks, is now severed, as at *ff*, and the edges of the paper formed by this cut are in like manner overturned on the end margins of the blank and pasted down, and the corner-pieces formed by the cut *g* are, if necessary, also turned over the margins of the side and end flaps of the blank, as at *C D*. The covered blank is now bent along the scored lines *d* to form the box or top. The stock is worked moist, and the bend of the board at the edges is just sufficient to draw the covering-paper smooth and even and prevent any tendency to wrinkle. The box thus produced will be uniformly covered and will present even-finished edges, as at *x*.

The corners of the box or top may be stayed in any suitable manner.

The edges of the covering-sheet may be overturned in any well-known manner, as by stationary folders or rotary turners, and the steps of the method may be altered without departing from the spirit of my invention.

Having described my invention, what I claim is—

1. The method of making paper boxes consisting in first applying to a flat, cornered, box-blank a finishing-paper, folding the edges of the paper over the margins of the blank, and then bending the margins of the blank to form the ends and sides of the box.

2. The method of making paper boxes consisting in first applying to a flat, cornered, box-blank a finishing-paper in a continuous web, folding the edges of the paper over the longitudinal margins of the blank, severing the partially-covered blank from the web, folding the end margins of the covering-paper

over the end of the blank, and bending the margins of the blank to form the ends and sides of the box.

3. The method of making paper boxes consisting in first applying to a flat, cornered, box-blank, a finishing-paper in a continuous web, severing the web, folding the edges of the paper over the margins of the blank, and

then bending the margins of the blank to form the ends and sides of the box. 10

In testimony whereof I affix my signature in presence of two witnesses.

JOSEPH ALGER.

Witnesses:

FLORENCE N. HOUSTON,
ARTHUR H. ALGER.