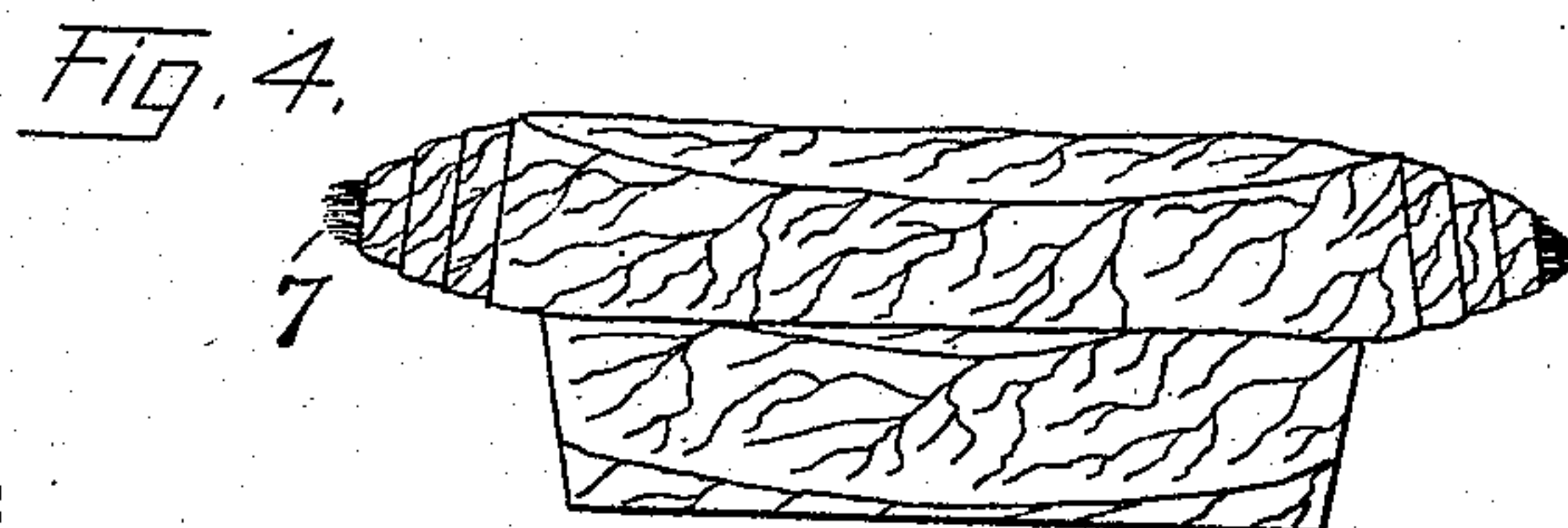
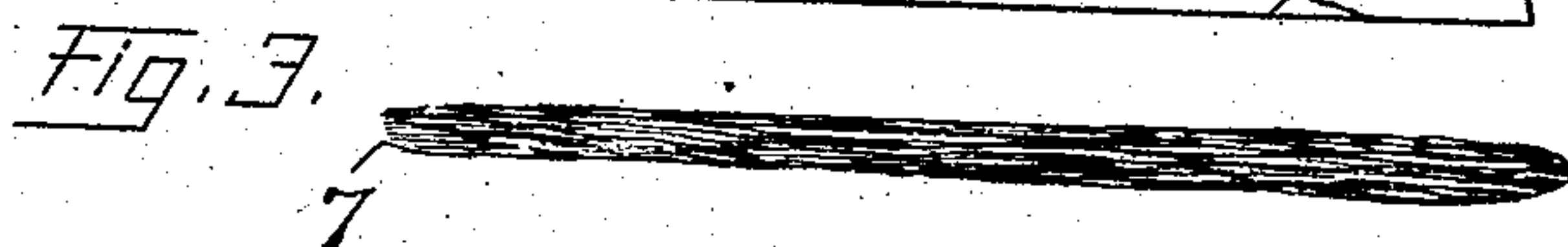
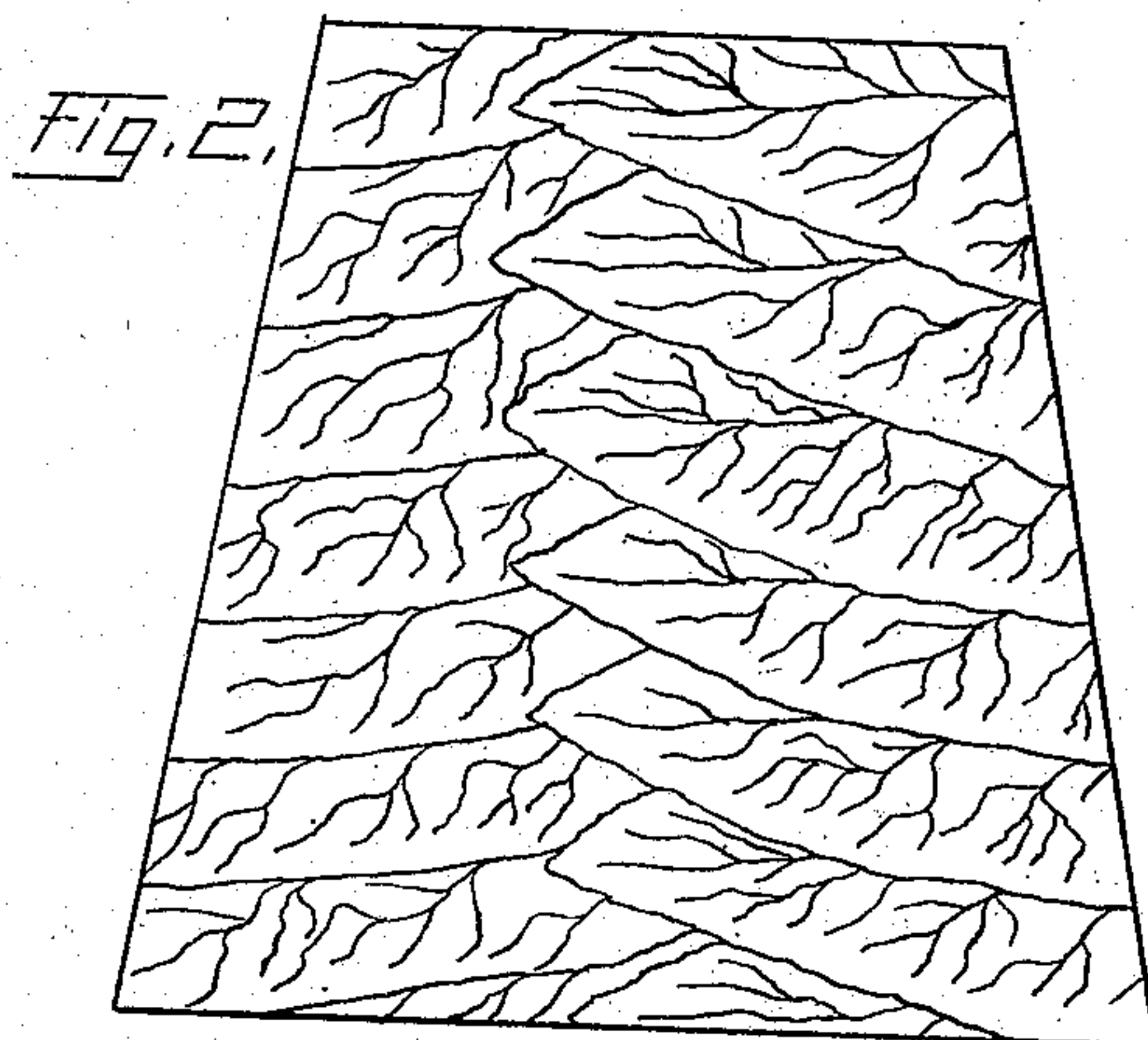
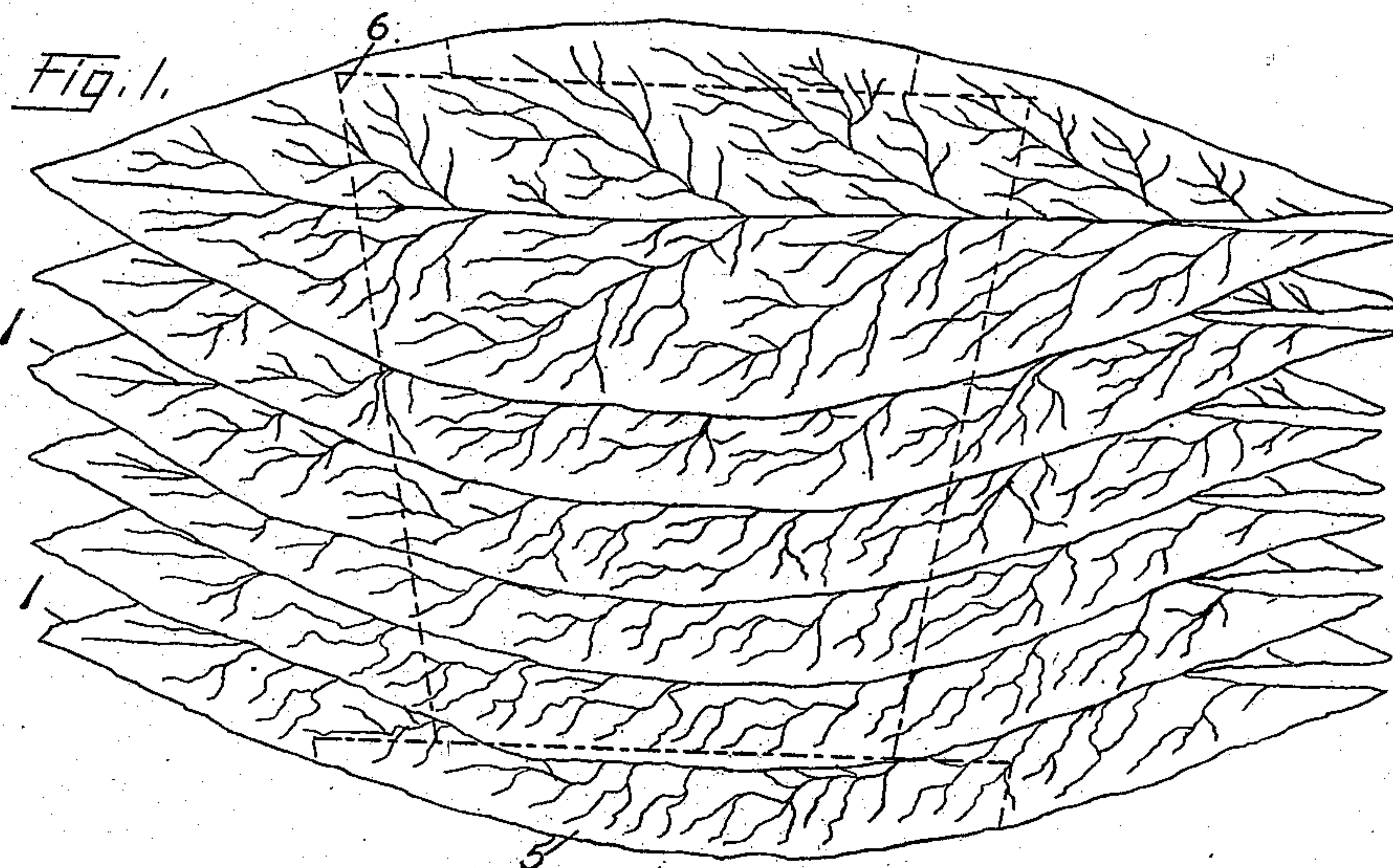


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METHOD OF MAKING CIGAR BUNCHES.
APPLICATION FILED AUG. 11, 1906.

911,756.

Patented Feb. 9, 1909.



WITNESSES:

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UNITED STATES PATENT OFFICE.

SYDNEY I. PRESCOTT, OF NEW YORK, N. Y., ASSIGNOR TO INTERNATIONAL CIGAR MACHINERY COMPANY, OF NEW YORK, N. Y., A CORPORATION OF NEW JERSEY.

METHOD OF MAKING CIGAR-BUNCHES.

No. 911,756.

Specification of Letters Patent.

Patented Feb. 9, 1909.

Application filed August 11, 1905. Serial No. 273,725.

To all whom it may concern:

Be it known that I, SYDNEY I. PRESCOTT, a citizen of the United States, residing at New York, county of Kings, and State of New York, have invented certain new and useful Improvements in Methods of Making Cigar-Bunches, fully described and represented in the following specification and the accompanying drawings, forming a part of the same.

This invention relates to an improved method of making cigar bunches.

Cigars are now ordinarily made by applying a wrapper to either what is known as a "German" bunch or a "Spanish" bunch. The so-called "German" bunch consists of a filler inclosed in a binder, the filler, in high grade cigars consisting of a number of pieces of tobacco crushed together and arranged parallel to the longitudinal axis of the cigar and extending substantially the whole length thereof. In the cheaper cigars, the filler consists of short pieces of tobacco, scrap being used in the cheapest. A "Spanish" bunch is customarily made by spreading out a series of filler-leaves in flat super-imposed form; that is, one leaf, usually a large one, is placed upon a rolling table and upon this leaf as a base, others are placed one over the other and so on until a book is formed containing sufficient tobacco to form a bunch. Where it is desired to make a bunch of the well-known "perfecto" shape, which is tapered at both ends, the upper leaves in the book are smaller than the others and all of the leaves in the book are broken by hand in irregular shape. When the book has thus been formed, the bunch-maker begins at one edge and rolls the leaves into a bunch. In the bunch thus made, the shorter and smaller leaves lie in the center and a recess or opening is left at each end, this recess or opening being formed by the longer leaves on the outside of the bunch. In order to produce the desired shape, another operation is necessary which consists in compressing or squeezing the ends of the longer leaves. This results in the contraction of the air and smoke passages of the bunch to a greater or less extent. Further, in applying the wrapper, the bunch is liable to be twisted at the ends. This interferes with the draft of the cigar when

completed, and is frequently the cause of uneven burning.

It is one of the objects of this invention to provide a new method of making a cigar of the "Spanish" type, in which the air and smoke passages will be substantially parallel and not contracted.

Another object is to so shape the filler-leaves that a bunch of the desired shape and density may be made without employment of the skilled labor heretofore necessary in positioning the broken filler material of which the bunch is composed, so that when a bunch is rolled up it will require no further operation in order to secure the desired shape.

The invention consists in a new and useful method of making cigar bunches of the "Spanish" type, whereby an improved cigar may be produced.

In the accompanying drawings—Figure 1 represents in plan view a book of tobacco leaves arranged in accordance with the improved method. Fig. 2 represents in plan view a way of assembling leaves to form a core, which may be used. Fig. 3 illustrates a formed core, and Fig. 4 illustrates a bunch substantially completed.

In carrying out the invention, a filler-leaf, which may be a whole leaf from which the stem has been taken in the usual manner, or part of the leaf large enough for the purpose, is spread out flat. Upon this leaf another similar filler-leaf is placed, upon that another, and so on, until a book of superimposed leaves is formed containing enough tobacco to form a bunch. When the invention is carried out in what is regarded as the best way, the leaves are spread out in overlapped form, as is clearly shown in Fig. 1, the leaves being marked 5.

While the leaves forming the book might be shaped before they are assembled, it is considered more advantageous to shape the book of leaves after they have been assembled, as described, the specific shape depending upon the form of the bunch which is to be made. While the book of leaves may be shaped by any suitable method, as, for instance, by tearing or breaking the leaves; preferably, and as shown, the book is cut to shape it in predetermined contour, as indi-

cated by the dotted lines, marked 6, in Fig. 1. When the bunch is to be of the well-known "Perfecto" shape, and as shown, the book will be cut in the shape of a trapezoid.

5 After the book of leaves has been formed and shaped, it is rolled up to form the bunch, and it will readily be seen that if the rolling is begun at the long side of the trapezoid, the bunch, when finished, will be tapered at both
10 ends, and that the air and smoke passages will be substantially parallel throughout the bunch, and not contracted.

The tobacco leaves used in the manufacture of cigars are usually longer than cigar
15 bunches. It is well-known that the flavor of the tip-end of the leaf is superior to that of the butt-end of the leaf. While books might be shaped entirely from the tip ends of the tobacco leaves, and other books from the
20 butt-ends of the tobacco leaves, thereby producing two grades of cigars from the same leaf, as shown, the book is cut from the middle portion of the filler-leaves, the tip and butt-ends of the leaf being cut away.

25 While that portion of the filler material cut away from the book might be used for other purposes, when the method is carried out in what is regarded as the best way, the tip and butt ends, where the book is cut from
30 the middle portion of the filler-leaves, is used to form a core of tobacco and the book is then rolled around the core. This core may be made by compressing the tobacco contained therein in cylindrical form, or by rolling the
35 tobacco contained in the said core in convolute form.

As shown, the tips and the butts of the leaves are assembled, as shown in Fig. 2, and then compressed into a cylindrical core
40 represented in Fig. 3. The core is placed upon the filler-book on the longer side of the trapezoid and the book then rolled around the core, as is clearly shown in Fig. 4.

It is well known that tobacco leaves when
45 formed into cigar bunches burn more evenly if the end lighted is the end which was the tip-end of the leaves than when the butt is lighted. It is desirable, therefore, that in making high grade cigars the filler-leaves be
50 assembled with the tips all lying in the same direction, and at that end of the bunch which is to be the "tuck" end, or that which is lighted when the cigar is completed. The main veins of the tobacco are inclined to-
55 ward the tip. In carrying out this invention, therefore, the leaves are spread out in flat superimposed form with the veins of the tobacco all inclined in the same direction, and, when a core of tobacco is formed, the
60 veins of the tobacco contained in the core will lie in the same direction as those of the book. By inspection of Figs. 1 and 2, it will readily be seen how this is accomplished.

It will be readily understood that no com-
65 pression is necessary to shape a bunch made

in accordance with the method described and therefore that the smoke passages are not contracted or choked. Further, it will be seen that there is no liability of twisting the ends of such bunches when the wrappers
70 are applied.

What is claimed is:

1. The method of making cigar bunches which consists in first making a book by spreading a series of filler-leaves in flat over-
75 lapped form and then rolling the book.

2. The method of making cigar bunches which consists in first making a book by spreading a series of filler leaves in flat over-
80 lapped form, then shaping the book, and then rolling the shaped book.

3. The method of making cigar bunches which consists in first making a book by spreading a series of filler-leaves in flat over-
85 lapped form, then cutting the book so formed to shape it, and then rolling the shaped book.

4. The method of making cigar bunches which consists in first making a book by spreading a series of filler-leaves in flat over-
90 lapped form, then positioning a core of tobacco on one side of the book, and then rolling the book around the core.

5. The method of making cigar bunches which consists in first making a book by
95 spreading a series of filler-leaves in flat over-lapped form, then shaping the book, then positioning a core of tobacco on one side of the book, and then rolling the book around the core.

6. The method of making cigar bunches which consists in first making a book by spreading a series of filler-leaves in flat over-
100 lapped form, then cutting the book so formed to shape it, then positioning a core of tobacco on one side of the book, and then rolling the book around the core.

7. The method of making cigar bunches which consists in first making a book by spreading a series of filler leaves in flat over-
110 lapped form, then positioning a core of tobacco on one side of the book with the veins of the tobacco contained therein lying in the same direction as those of the book, and then rolling the book around the core.

8. The method of making cigar bunches which consists in first making a book by spreading a series of filler-leaves in flat over-
115 lapped form, then shaping the book, then positioning a core of tobacco on one side of the book with the veins of the tobacco contained therein lying in the same direction as those of the book, and then rolling the book
120 around the core.

9. The method of making cigar bunches
125 which consists in first making a book by spreading a series of filler leaves in flat superimposed form, then positioning a core of tobacco on one side of the book, and then rolling the book around the core.
130

10. The method of making cigar bunches
which consists in first making a book by
spreading a series of filler leaves in flat super-
imposed form, then positioning a core of
5 tobacco on one side of the book with the
veins of the tobacco contained therein lying
in the same direction as those of the book,
and then rolling the book around the core.

In testimony whereof, I have hereunto
set my hand, in the presence of two sub- 10
scribing witnesses.

SYDNEY I. PRESCOTT.

Witnesses:

AUGUSTA WHITE,
J. A. GRAVES.