

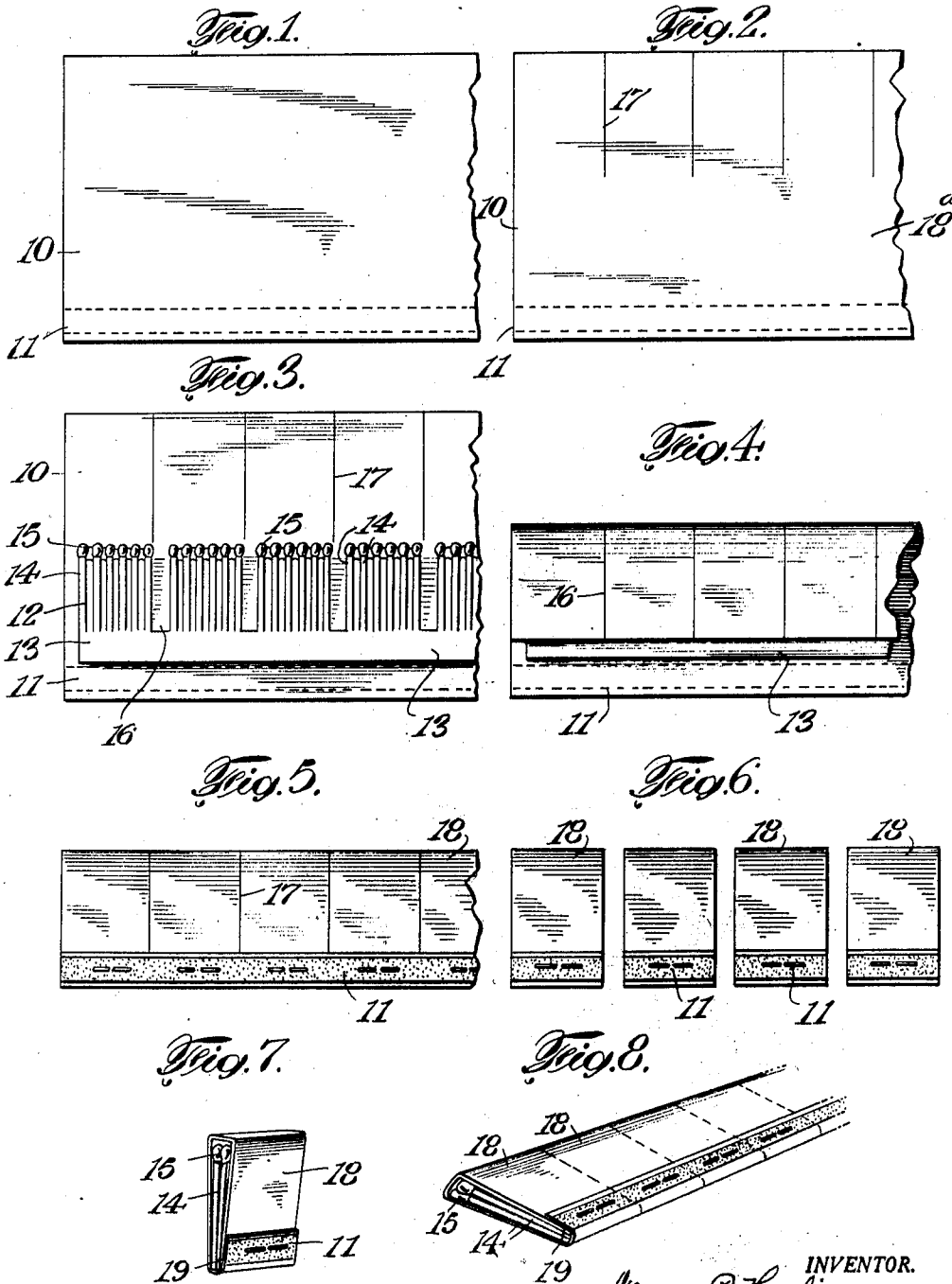
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W. B. HUTCHINSON

ART OF MAKING MATCH BOOKS

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INVENTOR.
Warren B. Hutchinson.
BY
Abner T. Neary,
ATTORNEYS.

UNITED STATES PATENT OFFICE.

WARREN B. HUTCHINSON, OF BOONTON, NEW JERSEY.

ART OF MAKING MATCH BOOKS.

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This application is a division of application Serial No. 35,218, filed June 5th, 1925.

My invention relates to improvements in the art of making match books so called, in which a card of matches is contained in a folding cover. These match books are used largely for advertising purposes and are well known in the trade. The general practice of making such match books is substantially as follows. The individual covers are cut and placed one by one in a holder or carrier, the individual cards are cut from prepared match strips each having a base, and a series of headed splints projecting from the base, and the individual cards are assembled one by one on the individual covers, after which the covers are folded and stitched to the cards. This necessitates handling the stock in small units, and while machines have been perfected to do the work rapidly, still it is a great disadvantage to be compelled to handle the individual cards and covers as stated.

I have found that the work can be greatly facilitated and the match books more rapidly and economically made by handling the stock in larger units, whereby some of the operations are eliminated. For example, if the cover strips from which the individual covers are cut, have the match strips which are of a length corresponding to the width of a plurality of match cards placed in the right position to them, after this the individual cards and covers can be simultaneously cut, and if the match and cover stock are held in this position until the work is finished, then the re-assembling of the severed parts is dispensed with. It is easier to fold a comparatively long cover strip over a long piece of match strip, than it is to fold a single cover over a single card, and also it is easier to attach the cards and covers in multiple than it is when they are separated. Therefore, by doing the cutting, folding, and fastening while the main stock pieces, to wit, the cover strip and the match strip, are held in correct position and without being disarranged, the books can be very economically, nicely, and rapidly produced. This will appear more clearly from the description which follows.

Reference is to be had to the accompanying drawings forming a part of this speci-

fication, in which similar reference characters indicate corresponding parts in all the views.

Figure 1 is a broken plan of a conventional cover strip.

Figure 2 is a similar view showing the strip slitted at spaced intervals and for a part of its width to form the long flaps of the covers.

Figure 3 is a broken plan view of a match strip or strips properly disposed upon the cover strip preparatory to cutting and folding.

Figure 4 is a broken plan view showing the first fold and long flap of the cover strip after being folded over upon a part of the match strip.

Figure 5 is a view similar to Figure 4 showing the final or short fold bent in over the long flaps and fastened to the base of the match strip.

Figure 6 is a plan view of the complete match books as cut from the strip shown in Figure 5.

Figure 7 is a perspective view of the conventional match book, and

Figure 8 is a broken perspective view of a pair of match strips with the cover strip folded over and attached thereto preparatory to cutting into match books.

In practice cover strips 10 are formed which are of a width corresponding to the length of an individual cover, and of a length equal to that of a plurality of covers. It is customary to have a striking surface applied near one edge of the blank or cover strip, as shown by dotted lines at 11 in Figure 1 and in full lines in Figure 5. The matches are cut from the strip 12, the length of which corresponds to the width of a plurality of cards, these strips comprising a base uncut portion 13, splints 14 projecting therefrom, and the usual heads 15. It is customary also to leave gaps 16 between the groups of match splints at points where the strips are to be cut, so that they can be cut to better advantage, but so far as my invention is concerned these gaps may or may not be left in the match strip.

As above stated, the usual practice is to complete the individual covers for the match books, then cut the match strips off through the gap 16 or at corresponding points, and

deposit the cut cards upon the individual blanks or covers and fold the latter and also fasten them.

In my practice, however, I lay a strip of match stock, usually two strips superposed, to correspond with the general practice of two-strip cards, upon a cover strip 10, and while these two strips are held in the correct relative position, both are cut off simultaneously, thus obviating the need of separately cutting the covers and match strips and afterwards assembling them. This cutting operation can be done before folding or when the cover strips are partially folded, or when the folds are complete. The sequence of operation is not important, but I prefer to complete the fold and fasten the parts together before cutting off the match books. To facilitate this cutting, and obviate the necessity of cutting through two thicknesses of stock, the cover strips 10 may be slit transversely at spaced intervals as shown at 17 in Figures 2 and 3, so that the slit part will correspond to the long flaps 18 of the match books. After the first fold has been made as in Figure 4, the short fold 19 is made in which the part of the cover strip provided with a striking surface 11 is folded over upon the base 13 so as to overlap the flap 18, and hold these flaps closed in the customary way, after which the short flap 19 is stitched or otherwise fastened to the base 13; then the parts are in the position shown in Figure 8, and the individual book matches are cut off and are complete when cut, the match books being severed along the parts shown by dotted lines in Figure 8, and as above stated the cuts may coincide with the parts 17 which have been already slitted so as to make the cutting operation easier.

It will be noted that when the cover strip is folded over and fastened upon the match strip, the match books may be cut off one by one, but it is just as easy to simultaneously cut the whole series of them from the prepared stock. This greatly facilitates the work, and by any suitable machinery the parts are held in position and the match books carried away for packing.

I have not shown the means for folding or cutting the stock, because this has nothing to do with my invention, and there are many

folders and cutters known to the art which can be used for carrying out these operations.

From the foregoing description it will be seen that the match strips, either one, two, or more as desired, can be assembled in the position shown in Figure 3, with relation to the cover strip 10, and that when the parts are held in this position, both strips can be cut through simultaneously, and that the folding may be done subsequently, or the cover strip can be folded over as shown in Figure 5, either with or without slitting the cover strips, and the match books cut off individually or collectively; or the stock could be cut in like manner, when the parts are in the position shown in Figure 4; and while it is better to have the folding and fastening complete before cutting the match books, the most essential thing is the simultaneous cutting of the match strips and cover strips while they are held in the right relative positions, and in completing the books without disturbing these positions.

It will be clear from the foregoing description that the sequence of operations, that is cutting, folding, and fastening, may be varied without affecting the invention, and while in the claims to properly define the invention it is necessary to state one step or operation before another, I do not imply by such statements that such sequence of operations is essential.

I claim:—

1. The improvement in the art of making match books, which comprises simultaneously cutting off a match strip and cover strip to form a card and cover for a match book while the two said strips are in position for folding the cover strip upon the match strip.

2. The improvement in the art of making match books, which comprises assembling the cover strip and match strip in folding relation to form cards and covers for a plurality of individual match books, and cutting through both of said strips, folding and fastening the covers upon and to the cards without disturbing the relation of the cards and covers.

In testimony whereof, I have signed my name to this specification this 2 day of March, 1928.

WARREN B. HUTCHINSON.