

No. 865,012.

PATENTED SEPT. 3, 1907.

W. H. BUTLER.  
MANUFACTURE OF CIGARS.  
APPLICATION FILED DEC. 17, 1906.

Fig. 1.

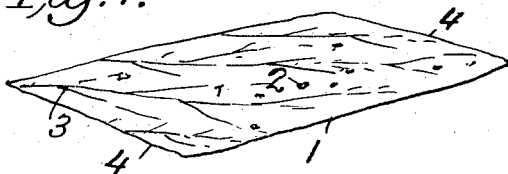


Fig. 2.

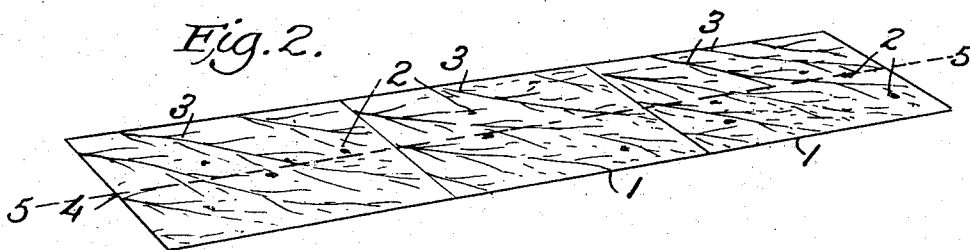


Fig. 3.

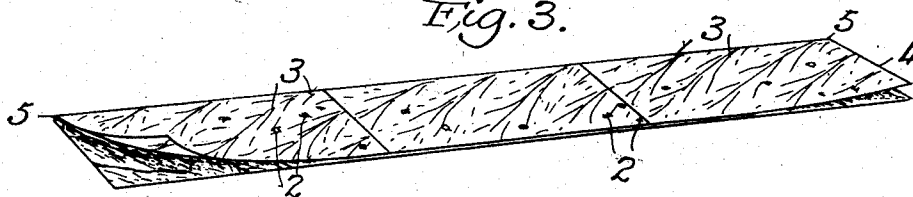


Fig. 4.

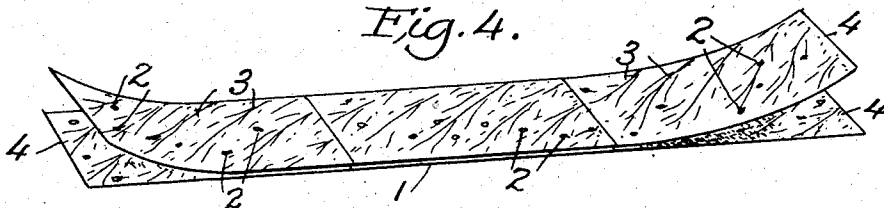
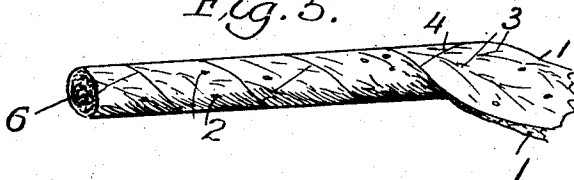


Fig. 5.



WITNESSES:

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# UNITED STATES PATENT OFFICE.

WILLIAM H. BUTLER, OF NEW YORK, N. Y.

## MANUFACTURE OF CIGARS.

No. 865,012.

Specification of Letters Patent.

Patented Sept. 3, 1907.

Application filed December 17, 1906. Serial No. 348,249.

*To all whom it may concern:*

Be it known that I, WILLIAM H. BUTLER, a citizen of the United States, residing at the borough of Manhattan, New York city, State of New York, have invented certain new and useful Improvements in the Manufacture of Cigars, of which the following is a specification.

My invention relates to the manufacture of cigars, and has especial reference to the form of wrapper employed and the manner in which the same is applied about the filler.

One object of the invention is to enable cigars to be manufactured by a method whereby a long filler is enveloped by a long continuous wrapper, and the resulting rod or long cigar cut into desired lengths, as contrasted from the methods at present in vogue in which individual tobacco wrappers are first cut from a leaf and are then wrapped about suitable quantities of filler thus forming the cigars singly.

Another object of my invention is to dispense with the making of a bunch, thereby saving time, labor and expense.

A further object of the invention is to obviate the use of a binder. By omitting the binder I not only save the cost thereof, but also improve the quality of the cigar, inasmuch as the material generally employed for binders is of inferior grade and tends to detrimentally affect the quality of the completed article.

The principal features of the invention consist in preparing a long wrapper made from strips of tobacco leaves, manipulating this wrapper as by folding or in other suitable manner so that it presents a plurality of layers, and winding the wrapper about the filler, preferably in a spiral form, either by hand or by machine.

As an aid to a clear understanding of my invention I append the accompanying drawing, wherein

Figure 1 is a perspective view of a strip cut from a tobacco leaf; Fig. 2 is a view illustrating several of these strips joined end to end to form a long wrapper; Fig. 3 is a view illustrating the wrapper shown in Fig. 2 as folded upon itself, the veins in the two layers being arranged to cross each other. Fig. 4 is a view similar to Fig. 3 but showing the wrapper cut at its median line and the two layers so arranged that the veins therein will run parallel or substantially so; and Fig. 5 is a view illustrating a filler partially enwrapped by a spirally wound wrapper.

The present invention does not contemplate the production of any particular form of machine upon which the herein described method of manufacture may be performed, nor is my invention applicable only in the manufacture of cigars by the continuous method, the invention being equally useful whether the cigars are made singly or are cut from a preformed rod.

In the drawing 1 represents a tobacco strip in which are usually found imperfections or perforations 2 and

in which veins 3 run in substantially the same direction. To form the improved wrapper I join several such strips 1, preferably at their ends 4, and then fold the wrapper upon itself, preferably at the median line 5, whereby I obtain a wrapper of double thickness in which the perforations or imperfections 2 in one layer are covered by the material of the adjacent layer, and the veins 3 of one layer cross similar veins of the other layer. I may also form the wrapper as illustrated in Fig. 4, where the strips of tobacco are shown as having been cut along their median line 5 and the two layers superposed with the veins in each layer running in the same general direction. If desired I may apply a suitable adhesive substance between the layers to hold them closely together.

The form of wrapper illustrated in Fig. 3 is the preferred one, as I have found in practice that a cigar enveloped in a wrapper wherein the veins of the double layers cross each other draws freely and presents a smooth and finished appearance.

It is of course understood that, if desired, the wrapper may consist of more than two superposed layers, either formed by folding or laying one upon the other and with or without adhesive material between the layers.

When the wrapper is completed it is wound, preferably spirally, about the filler 6 and the wrapper ends secured in any suitable manner. It will be noted that no binder is needed, the wrapper when passing about the filler exerts sufficient compressive force to prevent disintegration of the latter. If the continuous method of manufacture be employed the long cigar is cut into suitable lengths after being wrapped, while of course, if the cigars have had the wrappers placed thereon individually such cutting into lengths is unnecessary.

Numerous advantages over present methods of manufacture result from the use of my invention. Firstly, I am enabled to make cigars by the continuous method owing to the fact that the wrapper when of greater thickness than one layer of leaf has sufficient tensile strength to be drawn taut without breaking and may thus be wound upon a reel and suitably fed to the wrapping mechanism. The output of cigars within a given period is consequently increased several fold. Secondly, in dispensing with a bunch I decrease the cost of manufacture by effecting a decided saving in time and labor. Thirdly, owing to the relative arrangement of the veins in the two wrapper layers I produce a cigar which smokes freely and has a smooth, finished appearance. Fourthly, in preparing my wrapper by cutting strips from tobacco leaf, I employ, for wrapper purposes, practically all the available portions of the leaf and no waste results, as is the case when individual rectangular wrappers are cut from a tobacco leaf.

By my improved method of forming a wrapper I obtain from one side of a leaf sufficient wrapper material to cover probably twice as many cigars as could be obtained from the same portion of the leaf were the wrappers to be cut therefrom singly by a die. Moreover a further saving in wrapper material results from the fact that I employ just the quantity of wrapper necessary and have no waste in cutting off projecting ends or edges of wrapper.

10 Having thus described my invention, what I claim as new and desire to secure by Letters Patent is:—

1. An improvement in the art of manufacturing cigars, consisting in preparing a wrapper from strips of tobacco leaf joined end to end, forming said wrapper into a plurality of layers and winding the same spirally about a filler, substantially as described.

2. An improvement in the art of manufacturing cigars, consisting in joining strips of tobacco leaf end to end, and forming the same into a wrapper comprising a plurality of layers having the veins in adjacent layers cross each other, and winding the wrapper spirally about a filler, substantially as described.

3. An improvement in the art of manufacturing cigars consisting in joining strips of tobacco leaf end to end to form a wrapper, cutting said wrapper into sections, superposing the resulting sections of the wrapper so that the

veins thereof will run in the same general direction, and winding the wrapper spirally about a filler, substantially as described.

4. An improvement in the art of manufacturing cigars consisting in joining strips of tobacco leaf end to end as a step in the formation of a wrapper, forming the partially completed wrapper into a plurality of superposed layers and winding the wrapper spirally about a filler, substantially as described.

5. An improvement in the art of manufacturing cigars consisting in joining strips of tobacco leaf end to end as a step in the formation of a wrapper, forming the partially completed wrapper into a plurality of superposed layers, applying adhesive substance between the layers, and winding the wrapper spirally about a filler, substantially as described.

6. An improvement in the art of manufacturing cigars consisting in joining strips of tobacco leaf end to end as a step in the formation of a wrapper, cutting the partially formed wrapper into sections, superposing said sections and applying adhesive substance between the sections which form layers of the completed wrapper, substantially as described.

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

WILLIAM H. BUTLER.

Witnesses:

OTTO MUNK,  
CLARISSA FRANCK.