

the pulpwood cut in Canada was exported in the raw or unmanufactured form. In 1923, with an increase of almost 300 p.c. in total production, the proportion exported has fallen to less than one-third.

The manufacture of pulp forms the second stage in this industry. This is carried on by mills producing pulp alone and also by paper manufacturers operating pulp-mills in conjunction with paper-mills for the purpose of providing their own raw material. Such mills usually manufacture a surplus of pulp for sale in Canada or for export.

The supply of rags for paper-making is distinctly limited and the material too expensive for the manufacture of cheap paper. Early paper makers experimented with fibres from the stems, leaves and other parts of numerous annual plants, but the small proportion of paper-making material recoverable from such sources led to experiments in the use of wood. Different species were tried, and finally spruce and balsam fir were found to be the most suitable for the production of all but the best classes of paper.

The wood is delivered to the pulp-mill in different ways. Logs eight feet and upwards are either floated in booms or rafts or delivered in railway cars. Wood cut in two foot or four foot lengths is seldom driven but is delivered by railway car or vessel. This material may be either peeled or barked or delivered with the bark on. Generally speaking, wood sold by farmers is cut to short lengths and peeled by hand in the woods. Material cut in log lengths must pass first through a "cut-up" mill where it is cut into two or four foot lengths. The next stage in its preparation is the removal of the bark in a "rossing" mill. This is accomplished by the rubbing together of the logs in a revolving drum or by the removal of the bark by revolving knives. This last method produces the cleanest pulpwood but results in the loss of a considerable proportion of the wood itself. This preliminary preparation of pulpwood is frequently carried on at the pulp-mill, but there are in Canada a number of "cutting up" and "rossing" mills operating on an independent basis, chiefly for the purpose of saving freight on material cut at a distance from the mill or on material intended for exportation. Logs are measured in board feet but the shorter material is measured by the cord (4' by 4' by 8' of piled material), which is approximately equivalent to 500 feet board measure or to 90 cubic feet of solid wood. Generally speaking, it takes about one cord of wood to make a ton of groundwood and two cords to make a ton of chemical pulp.

There are in Canada four methods of preparing wood pulp, one of which is mechanical and three chemical. In the mechanical method, green coniferous woods are preferred; spruce forms over 80 p.c. of the total, with balsam fir, hemlock and jack pine. Soft "hardwoods", such as paper birch, white birch and poplar, are occasionally used. The barked and cleaned wood is held by hydraulic pressure against the surface of a revolving grindstone, the sticks lying with their length parallel to the width of the stone. The stone is constantly washed by water, which carries away the pulp in suspension. Mechanically prepared pulp or "groundwood" is used only for the cheaper grades of paper and board which are required only for a comparatively short time. It contains all the wood substance, a large proportion of which is not durable. Mixed with chemical pulp, it is used for news, wall, cheap book, manila, tissue, wrapping, bag and building papers, and for box boards, container boards and wall boards.

There are three methods of producing chemical fibre in use in Canada—the sulphite, sulphate (or kraft) and the soda process, so-called because of the chemicals used in each case to dissolve out the non-fibrous or non-cellulose components