

# AN INVESTIGATION OF THE NEW PROCESS OF BREADMAKING

## The Most Modern Baking Plant in the World.

### CORBY BROS.' BIG ESTABLISHMENT

#### CORBY BROS.' INVENTIONS ARE REVOLUTIONIZING THE BAKING BUSINESS.

#### Thirty-Six Plants Already Installed—Thirty-Five in the United States and a \$100,000 One in England.

#### HOW BREAD IS MADE—A SCIENTIFIC PROCESS.

#### The flour, yeast, milk, &c., microscopically and chemically analyzed—Their marvelous sieve—The great mixer—The enormous ovens—Eighteen elegant new wagons—The cleanliness of everything.

#### GREAT SUCCESS OF TWO YOUNG MEN

##### The Best Bread in the World.

I have been investigating the new bread-making process that is revolutionizing the bread-making of the world.

It has spread rapidly over the United States, and is now being taken up in England. The process and the machinery are patented by Corby Brothers, the inventors. Ten years ago they started a bakery in Washington. Their bakery was a good one, but not specially better than many other bakeries, except that it was better organized.

It did an ordinary business for seven years.

##### The Firm's Members.

The two Corby brothers who constitute the firm, Charles L. Corby and W. S. Corby, two and a half years ago introduced their new process, and since then their business has grown from 2,500 loaves a day to 16,000; from four wagons to eighteen wagons.

The investigator took a 7th street car and went out to the Corby bakery, 2255 Brightwood ave.

He found the Corby Brothers in the office. One of them, W. S. Corby, had just returned from England.

"I went over to install one of our new process plants for making bread," he said, "in buildings erected especially to receive the plant, at Manchester. The buildings and machinery cost some where in the vicinity of \$100,000, and the plant starts making 5,000 loaves a day, which they expect to increase to 50,000 loaves a day in the fall, and they should be able to do it, judging from the way this new bread takes in England.

##### Making Bread in England.

"There has been no progress in England in the making of bread in 150 years. The utensils are the same as they were 150 years ago, and the bread is no better than it was 150 years ago. Everybody who ate our bread went wild over it. Women and children came to buy it at the bakery instead of waiting to get it out of the vans. We had no expectation of making such a success with the bread in England. A man has to go over there and study England for himself to understand how set in its ways it is; but we had a process that could demonstrate its own merits.

##### "Will Go Into All Civilized Countries."

"We have secured facilities in London for manufacturing the machinery of our process. It will go into all civilized countries. It has been patented in all, and we have men who speak the language and are acquainted with the trade traveling in all these countries.

"In this country we have a factory at Cincinnati, and another at Montreal, Canada, to turn out the machinery."

"What does it cost to establish a plant?" "That would depend upon conditions. Ordinarily \$2,500 will do it. The plant at Manchester, England, as I have said, cost about \$100,000, which included the machinery, motive power, and so forth."

"What do you give for \$2,500?" "The machine for developing the gluten in the dough, a molding machine for molding the loaves into shape, and an electric motor."

"Is this molding machinery special?" "Yes. It gives us a loaf of the same size, does away with the handling, with sticking fingers into the dough, and so forth, making a more cleanly operation, and it gives each loaf the same amount of manipulation, insuring a uniform grain or texture to the baked loaf."

"Is your electric motor special?" "Any good electric motor will do."

"How many plants have been established in this country?" "Over thirty. Several have been completed within the last few weeks, while I have been gone, bringing the total number up to about thirty-five. You see, the bakers are coming here to Washington to see our plant in operation, and then they go home immediately to establish similar plants. All bakers are quick to realize the benefits of our invention, and adopt it as soon as they can put in a plant. But the people who eat the bread appreciate the bread, but do not know why. The improvement in the bread is all due to this new process, and is very largely due to our mixer, as it is termed in baking parlance.

##### What the Process Does.

"Bakers in England visiting the plant there would ask, 'What are you doing with this new process of yours?'" "Putting 22 per cent more gluten in the bread."

"Then you must use a substitute for flour?" "No; we are using only flour—but the best."

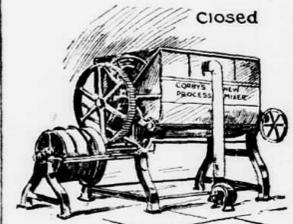
"How?" "Chemists have found that flour does not contain gluten in the flour state, but there are two proteins called 'glutenin' and 'gliadin,' which, when hydrated into the dough mass, form gluten in the dough, and by the ordinary method in use and the hand manipulation it has been impossible

to develop all the gluten, until we brought out our new patented dough-making machine and process."

##### How the Dough is Developed.

"How do you do it?" "To start with, we have manufactured for ourselves a large machine capable of mixing five barrels of flour at one mixing. This machine requires 25 horse-power to operate it. It is equipped with immense arms or an agitator on the inside, which absolutely brings every particle of the gluten and the gluten into contact with each other, forming the gluten in the dough, which is the only possible way of forming the gluten, that is to say, bringing the gluten and gliadin together.

"It is the work of this agitator which is the great factor in producing the perfect dough. A woman making bread can only develop a certain percentage of the nutrition in the flour. A very strong man, with his greater power to knead, can only develop a slightly larger percentage, but our patent dough-mixer and process absolutely develops every particle of the gluten in the dough, and it is largely the gluten which affords the body and nourishment. The whole mass of dough is spun and wound round and round the arms of the agitator on the inside of the machine, which runs at a very rapid rate, and thus the entire mass is shredded out into sheets and membranes. It is so thoroughly made that the dough stretched between the hands is semi-transparent. There is no dry or raw flour left to cause indigestion.



CORBY'S NEW PROCESS MIXER, ART OF MAKING DOUGH

##### Pure Air Blown In.

"Now, while the flour is being made into dough, it is subjected to a blast of fresh air, brought into the building through pipes, and blown into the machine and into the dough. This is a very important feature of the process."

"Why?" "For the reason that as the pure air is brought from the outside of the building, it has never been heated or heated by people working in the bakery as it would be if we were to take air from the factory where the dough is being made, as it is in all other places used for bread making; and we find that our dough works and ferments stronger, and has a better flavor where it is supplied with pure air, containing the oxygen which it could not contain in anything like the same measure if it had been taken from a room where a number of people are working. Air that has been breathed is necessarily vitiated and impure."

"You spoke also of heating; does that hurt the air?" "Yes, for the heat is liable to be foul. Of course, the best air in the world with which to mix the dough is the air from out of doors, the pure air of heaven, and we consider that good air is just as necessary an ingredient of good bread as good flour, good yeast, good milk, good water, good sifting, good sugar, good butter, good mixing, good molding and good baking are. All these things are absolutely essential, and you will have to go through our bakery to see how we have perfected each one of these details."

"This I did later. Meanwhile, I continued to cross-examine Mr. Corby upon the essential points of his mixing process. Continuing, he said:

"Dough made by the ordinary process is rough and granular. It is impossible to spread it out thin and transparent as you can the dough that comes from our mixer. Bread made this way keeps fresh much longer, about forty-eight hours longer, than any other bread, and it will also be noticed that our bread, when it is three or four days old, does not have the old smell so common in other breads."

"How long will it keep?"

##### How Long Bread Will Keep.

"A week, and retain its nutrition and remain moist."

"What is the best way to keep bread?" "That depends upon surrounding conditions."

"In a tin box?" "No; if I were going to keep bread, it would be best for the first two or three days to keep it where good, fresh air could get at it, with possibly a blanket or piece of porous cloth around it, but put it in a place where the wind or a draught

could not blow over it to dry it out or make the crust hard."

"You do not believe in tin bread boxes?" "No."

"Why not?" "They keep the air away from the bread and allow it to become foul and stale. A very important point to remember all through the process of making bread, and keeping bread after it is made—it should always be kept where there is plenty of fresh air. A matter of fact, however, it is not necessary to keep our bread long, unless some one is going to take it with them on a journey or yachting trip, or something of that sort. Here in Washington we make three deliveries a day. This means practically hot bread for the entire population at any hour. We do not want our bread to remain on sale anywhere over twelve hours.

"There is not over twelve hours from the bakery to the consumers—sometimes not over twelve minutes. Any home can have our bread fresh three times a day."

##### Stale Bread Taken Back.

"To start with, we have manufactured for ourselves a large machine capable of mixing five barrels of flour at one mixing. This machine requires 25 horse-power to operate it. It is equipped with immense arms or an agitator on the inside, which absolutely brings every particle of the gluten and the gluten into contact with each other, forming the gluten in the dough, which is the only possible way of forming the gluten, that is to say, bringing the gluten and gliadin together.

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"We sell the stale bread to them at half price. It is practically as good as new. It has usually been made less than twenty-four hours, but we do not want people that buy our bread for fresh bread to get a stale loaf, and we bring it back here to the bakery each day to dispose of it in charity or at half price, and we entered the building."

##### Inmaculate Neatness.

"The first question, thought I, about a bakery is 'Is it clean?'" "Corby Brothers' Bakery is absolutely clean. The floors are of hardwood, planed smooth, scrubbed as clean and white as the deck of a man-of-war. Being of hardwood, they allow no chance for dust to accumulate or dirt to stick; that is, if there were any dirt. The investigator did not see how any dirt could get in. It certainly could not come in with the employes, for Mr. Corby said:

"We compel all our employes to wear a special suit of white duck clothing here when in the bakery, and we supply them with three fresh suits a week. We will discharge a man if he does not keep his hands scrubbed clean all the time. We have discharged men for the slightest infringement of this rule."

"Dust might blow in," I thought to myself, as I looked at the big ventilators in the top of the building, through which the heat escapes from over the furnace. But there is no dust in the part of the city where the Corby Bakery is. It is pretty nearly in the rural part of Washington, a site selected on that account.

But the cleanliness of the bakery establishes itself in each of the departments. It begins where the flour goes through the sieve.

The first room visited was the flour storage room, where hundreds of sacks of the finest grades are kept on hand in a temperature that is preserved at a certain point Fahrenheit.

##### Sifting the Flour.

Mr. Corby took me to the sieve. He reached down and drew out a drawer or something that looked like a drawer and dumped its contents onto the floor. It made a little pile about as large as a peck measure.

"This shows what you get out of flour," he said. "What is all that stuff?" "He took a handful of it to the light and examined it. It was pretty largely fiber, a very few particles of dust, and a very little of the coarser grain of the flour.

"That is lint and stuff out of the bags," he said. "Your flour is really purified!" I remarked. "Yes, but you could not get this out of flour by any other sieve than this. You observe, it takes out every particle of dust and lint. In England the sieves would pretty nearly let a stick of wood pass through.

"This flour-purifying machine of ours is the finest known to the trade, and is the very latest known. We already had a fine sieve after us there in this section of the country, but found we could improve upon it; so we put in this machine, at an expense of \$1,000. In this sieve the flour passes through silk cloth and a series of revolving rollers, which absolutely purify the flour. It is quite as essential to prepare the flour for the mixer as it is to mix it well. From the sieve it goes to the mixer through a conveyor, not being exposed to the air at all; and he led me around the other side of a dividing wall to the machine that is the vital point of the whole proposition, and said:

##### Danger in Home-Baked Bread.

"That is one of the reasons why it is not a good plan for families to do their own baking," spoke up Mr. Charles L. Corby. "The family that does its own baking has no protection against the fungi and bacteria that are apt to be found in flour, or against the bran that is apt to be found in it, or against the dangers that are apt to be found lurking in yeast and milk, and so forth."

"When a firm recommends a certain brand of flour to you," continued the chemical Corby, "if you knew all about flour and could examine it through a microscope, you would be pretty apt to find that the flour recommended was a 'straight.'" "A 'straight,' that is, not good, patent process flour."

"What flour do you use?" "The best from the best mills, that must be analyzed upon the very highest of gluten-forming proteins."

"Is bran the only foreign ingredient you look for in flour?" "If there is any suspicion of adulteration we examine the flour for the signs of different starches than wheat starch. They may put in a corn starch to make the flour look white."

"What does corn starch do?" "It decreases the quality and nutriment. It has not the same absorptive quality. It does not make sweet, nutritious bread."

"Do you examine the yeast?" "Yes."

##### Bacteria in the Yeast.

"What do you expect to find in the yeast?" "Our examination is really a precaution against souring agents which can only be discovered by scientific examination. We make the examination to ascertain the number and size of the yeast cells and their growth, and also for the purity and strength of the yeast."

##### In the Chemical Laboratory.

"Do you also test flour in the laboratory?" "Yes, we test it for the percentage of gluten and

quality of the same, for loaf volume, fermenting period and color."

"What do you mean by loaf volume?" "The loaf volume proves the quality of the gluten, insuring a nice, light loaf."

"And the fermenting period?" "To ferment just long enough, not too long, is necessary to making perfect bread. The fermenting period of any flour is the time it takes it to mature with a given amount of yeast. By a knowledge of the fermenting period we prevent the development of acids which peptonize the gluten and make an inferior loaf of bread through over-fermentation. A knowledge of fermentation is one of the most essential things in good baking, because we seldom find two flours with the same fermenting period. By a close study of this intricate process of fermentation we are able always to produce perfect, sweet bread."

"Do you test the milk?" "Of course."

"Where do you get your milk?" "From the Long Mead Dairy Farm, in Montgomery county, Maryland. We are probably the largest consumers of milk in the District. We use about 250 gallons a day, and we test all the milk we use. It must contain 3 1/2 per cent of fat."

"Does your milk come from special cows?" "Yes, a great majority of them are Jerseys, and in the summertime our milk is also pasteurized, so as to kill any germs that might be in it." And then he led the way to the bakery, a big brick building.

It was between 6 and 7 in the evening, and around the doorway were a number of colored women and boys with baskets.

"They are waiting for the stale bread," said Mr. Corby.

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any other method heretofore known. (This machine has already been described.) You will notice that we have a very large hopper suspended from a scale, where the flour for each batch of dough is accurately weighed. On the left you will notice another scale and tank, where the milk and water are accurately weighed for each batch of dough. After the mixer has got in its work and created the perfect dough the dough is carried into the dough room."

##### The Dough Room.

This dough room is a unique institution. The dough is kept in troughs of polished steel, to which no foreign matter can adhere, and which, Mr. Corby says, "we find much more cleanly than the ordinary wooden troughs."

"This room is kept at an even temperature of 65 degrees. You will notice that overhead there are two kinds of pipes—one for refrigeration and the other for steam heat. We use the steam heating pipes in the winter to keep the temperature up and the cold storage pipes in the summer to keep the temperature down. This room is insulated, similarly to a refrigerator. You will notice that the floor is of hard wood, so no foreign substance can cling to it, and the paint on the walls is the best white enamel. We keep this room as sweet and clean as it is possible for human ingenuity to devise, for there is nothing more important in the process of baking than to keep the dough absolutely sweet, an object which can only be accomplished by means such as these. If dough is subject to the mutations of temperature incidental to the changes of summer and winter, and exposed to the conditions ordinarily prevalent in a bakery, it cannot be by any means an ideal dough. This dough room is an idea of our own, and the only one of the kind in the world."

"After the dough has laid in the troughs for a certain given length of time it is brought out and put on this large bench, and here divided up into loaves, and each one accurately weighed."

##### Making the Loaves.

He showed me a big table, where the cleanliness of the establishment seemed to have reached its acme. It is as white as the Corby bread itself, which resembles angel cake in its immaculateness. "Snow white" is hardly a strong enough expression for it.

"After the loaves are weighed they are run through this molding machine, which forms the dough into the required shape for the different kinds of bread," he continued, as we stood beside the loaf-making machine.

##### 24 Different Kinds of Bread.

"How many different kinds of bread do you make?" "About twenty-four different styles."

"What are they?" "I can tell you better when we get back to the office."

And later he gave me the following list: "Mother's Bread, which is our biggest seller. 'Vienna Bread. 'Home-made Bread. 'Quaker Bread. 'Milk Bread. 'Pullman Bread. 'Cream Bread. 'Cottage Bread. 'Butter Bread. 'Crimped Bread. 'Twist Bread. 'Table Queen. 'Graham Bread. 'Health Bread. 'Rye Bread. 'Pan Rolls. 'Vienna Rolls. 'Finger Rolls. 'Kaiser Rolls. 'Sandwich Rolls. 'French Rolls. 'Sult Rolls. 'Buttercup Rolls. 'Buns."

"What is the difference between these different kinds of bread?" "The difference is in shape and flavor and so forth. It is rather hard to describe; but each loaf and each roll speaks for itself. But Mother's Bread is our specialty, and is the richest of them all."

"We take a good care of our horses as you know how. We feed them on the best of food, and we give them special food periodically to keep them in excellent condition. You will notice we have equine bath tubs to soak their feet when sore and kindred ailments, and in addition to our large staff of stable men we have the services of a veterinary surgeon within easy call. We do not overwork our horses, but keep a large number of them, in order that they may be able to do their work easily. We like our teams to get out promptly and pass swiftly through the streets."

"With the large amount of bread that we have to deliver daily in Washington, and additionally in Alexandria, where in less than two months we have secured a larger trade than any other bakery commands. It is necessary for us to have speed and system, especially in our deliveries. Our drivers are run on the same principle that the employes of the bakery are: they are required to be immaculate in their personal habits and attire, and to keep themselves in good physical health. We do not want any sick people around this bakery. We insist that our employes shall keep perfectly well, and when they are not perfectly well we do not let them work. We would rather pay a man off for a week or a month and let him get well than to have him out of bread for even an hour about this establishment. We believe that healthy, pure bread is the result of healthy ingredients, combined advantageously in a healthy, pure atmosphere, and there is no point that we would spare to attain that result."

"I want you to note, before we return to the office, for instance, our engines and boilers." And he took me to another part of the building where the big boilers are. There is a double plant, two engines and two boilers, so that if anything happens to one, the other can do the work. There is an ironmaking plant and a dynamo for the electric lights. The boilers are fitted with all safety appliances, such as low and high-water alarms, damper regulators, smoke consumers, boiler cleaners, and so forth, and there are devices for filtering the oil and condensing the water. Indeed, everything is the most modern and up-to-date possible."

As we passed back between the great ovens I asked:

"When do you bake?" "Every day."

"Are visitors welcome?" "Always."

"How many employes have you?" "We divide them into three shifts of eight hours each a day. It is the only bakery in the world where the men work only eight hours. This is the first and only bakery that has adopted the eight-hour day. We pay them good wages and employ strictly union men, expert and experienced. Good results cannot be produced in the baking business without good workmen."

And in the office again we fell to discussing the qualities of the bread, and they called my attention to the fact that Corby's Bread is the only bread made that, when you press down with your hand upon a loaf of it, will resume its former shape upon removal of the pressure.

"Its merits are summed up in these words: It is sweeter, keeps moist longer, is whiter, contains 22 per cent more nutriment than any other bread, and has certain health-giving qualities which make bread eating a delight."

"Is bread healthy?" I asked.

##### Bread is Healthy.

"Good bread and good butter are the healthiest food in the world," replied Mr. Corby. "Those who suffer the pangs of indigestion will find themselves helped wonderfully on the road to recovery by consuming their diet largely to Corby's Bread, and our bread is so delicious that it creates a craving for it, an appetite that leads to large consumption of it, and as it is so easily digested it brings into the system a very large amount of nutriment at a very small outlay of digestive energy. It is so pure that it will purify the diges-

tion of the acids which are the distressing feature of impaired digestion. On the other hand, it soothes and stimulates the gastric nerves and functions, and when medicine fails and other food is found impossible, Corby's Bread takes the place of both."

"Which bread is more healthful, new bread or bread that is not so new?"

"How much capacity have your ovens?" "These five ovens have a capacity of 30,000 loaves a day."

"Over the ovens there are huge ventilators, which carry off all steam and gases."

##### Baking the Bread.

Mr. Corby explained how the bread, after being put in these ovens, is most carefully watched, not being merely put in a certain length of time without regard to the temperature of the ovens, but the length of time it is exposed to the heat being regulated by the temperature, and the temperature being most carefully regulated for each particular kind and size of bread or roll. There is a certain nicety about this which is one of the important points in the Corby process. That is, the perfection in their baking, like perfection in any other line of business, is composed largely of attention to details. That comes out of the Corby bakery. As when it is baked just right is characteristic of every loaf that comes out of the Corby bakery. So many bakers turn out bread that is unwholesome, some loaves being underdone and white and doughy, and other loaves cooked too much, and hard and charred on the surface.

It is a pretty sight to see thousands of loaves of bread being baked after it is baked.

It is then placed on wood and iron racks, made for the purpose, and drawn into the bread room to cool, and then placed in the wagons for delivery. The wagons back right up to the doors, the racks are run out so that the bread is loaded into the wagons with the least amount of handling, and while it is yet warm it is passing through the streets of Washington to the thousand grocers who sell it in every section of the city.

The investigator looked into the inside of the wagons, noting how immaculately clean they are. There is no opportunity for dust or dirt to get in, for they are closed, top, bottom and sides, and the bread is put in and taken out, which is practically air-tight when it is closed. These wagons are beautiful vehicles.

##### Elegant Delivery Wagons.

They are made specially for Corby Brothers, and the coach builders' art reaches its perfection in their design and finish. They are decorated elegantly and polished to the highest degree. No small department store in the land and no private stable turns out a vehicle that is more elegant. I asked Mr. Corby what they cost.

"Three hundred and fifty dollars apiece," he replied.

The wagons are kept as clean as the outside as they are on the inside. They are kept in a great rectangular court, with a cement floor, and they are washed daily. The harnesses, also, especially made for Corby Brothers, are carefully washed and polished each day also.

The horses that draw the eighteen wagons of the Corby establishment have a hotel of their own. I call it a hotel because it is so far above the level of the ordinary stable; in fact, above the level of almost any stable.

First, to begin with, it is large and airy, and the stalls are commodious. Each horse has a patent feed box,