MORE WORD CHESS

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It was shown in the November 1968 Word Ways that 110 words of five or more letters (no letters repeated) can be traced out in the word square to the right using only the King's Move in chess: up and down, right and left, or diagonally. In the August 1969 issue, Donald Drury pointed out eleven more such words. The following list gives 163 words of four or fewer letters obtainable from the same square:

ail, air, airy, an, and, ant, ante, art, arty, at, ate, aten, be, bead, bean, bear, beat, beck, ben, bend, bent, best, bet, beta, cent, chop, coma, come, cop, copy, cost, cosy, dank, dart, date, ear, eat, en, end, eta, liar, flat, fig, fir, fra, frit, fry, gad, gait, gali, gat, gate, gild, girl, glad, glia, ho, hock, home, hop, hops, hose, host, if, irate, is, it, its, ivy, kea, kemp, ken, kmet, knag, knar, lad, lag, lair, land, lane, lank, late, liar, lira, lirc, lilt, me, meal, mean, meat, men, mend, met, mock, mop, mopy, most, nag, nail, nary, near, nest, neb, neck, nest, oh, ohm, omen, os, pock, pome, pose, post, posy, rag, rail, rad, ran, rat, rate, ria, rial, rig, rite, sea, seal, seam, sear, seat, sec, send, sent, set, seta, so, sock, some, sop, spy, stag, star, stem, sten, stir, sty, tad, tag, tail, tan, tank, tar, tea, teal, tear, ten, tend, trig, try, via, vial, writ, wry

Can any reader find a word square yielding more than 284 words with no repeated letters?

If the rules are relaxed to permit re-use of letters, at least 63 more words can be found, for example arsenal, fragility, homestead, vitiate, statement, etc. What is the longest such word?