

B 116

57

Millars, Sugar Refiners etc.

June 24th

Note of Interview with Mr S. S. Schwartz
of Pelham St., E.:

Mr Schwartz wrote asking someone to
call. When I did so I found that he had little
to say. The appearance of the building where
I found him was a good indication of the
condition of his trade. It is a large warehouse
of five or six floors, and at first sight
appears to be totally dismantled and unoccupied.
However with great difficulty I succeeded in finding
an entrance, and at the top of the building in
a small office I found Mr Schwartz with one
clerk.

He told me that the depression in the
trade, caused by the imposition of county
duty came to a head in 1886. Up to that
time his father had employed 500 men, who
earned on an average 25/ a week. There were
in the immediate neighborhood four other
works employing a large number of men.
They are now all closed. Schwartz's do a
small trade in fruit cases, but have long

45. d
33

pick up defining.

W-d
23

There are only two business in London which make any profit, Tate's and Lyle's. Tate has made his money out of his patent for cake sugar; Lyle manages to make about 4 p.c. on his capital by doing a large trade in Fruit Sugar. Martensen, formerly the largest business in London, has a revenue in.

June 24th

3

Extract from article in The Times of March 15th 1886 on "Out of work London".

"The condition of the East End has for many years been indissolubly connected with the sugar trade; and the collapse of this industry has produced far-reaching consequences."

40 The manufacturers of animal charcoal, of filter bags, of casks,Expicers and copper workers, jute and canvas bag makers, carriers and porters are all thrown out of employment by the closing of sugar refineries. The firm of Paineloup, cartons and carriers who almost monopolized the work for the sugar trade, would have had to discharge nearly all their men and sell their horses had they not succeeded in securing a totally different outlet for their business, and thus saved 200 cartons from losing their employment. Next door at the sugar refinery of Mr Geo. Martineau I found 56 sugar refiners working as builders labourers, doing tasks given them out of kindness so as to postpone if not altogether avoid the necessity of discharging them.

33

In England the consumption of sugar per head has increased threefold during the last 40 years, but the amount of sugar refined in this country has not increased in proportion. Indeed for some years it has rapidly decreased. The cause is not far to seek, for it is unanimously attributed to foreign countries. For instance, putting aside the fluctuations of the market, and taking a mean price, raw or unrefined beetroot sugar is sold at Hamburg for £13 the ton. Refined sugar in London is worth about £17 the ton. We have therefore a margin of £4 for the process of refining, profits of trade etc. The Americans take the Hamburg sugar to the States where it is refined and sent back to Europe. The sum paid for duty on the imported raw material is returned by the American government when the sugar is exported in a manufactured condition, and £2 extra per ton allowed as bounty money. It is further generally believed in the trade that through various machinations practiced at the American custom house the exporters from the United States secure further

5

advantages equal to about 10% in ton. Thus while the English refiner has only a margin represented by the difference in value between raw and refined sugar of £5 per ton to work upon, the American by the addition of the above mentioned bounty has a margin of £7.10.

A mutual agreement has been made by the five remaining and principal sugar refiners of London. The five firms can produce crystal and fine sugar to the extent of 4000 tons per week. They have entered on an agreement so to limit their collective output that in no instance shall it exceed 2850 tons. On the other hand each workman refines about two tons per week and the weekly output being thus reduced to the extent of 1250 tons this means the discharge of 625 men. But this is only the direct effect. To refine 1000 tons of sugar per week implies an annual outlay for working expenses, and without counting profits of some £80000, of which at most only £28600 goes to the wages of the 500 sugar refiners

6
engaged to produce the 1000 tons. The remaining
£57,400 is spent in a manner that benefits other
traders not so directly connected with sugar refining.
The work has not yet been told. The cut-
loaf and granulated sugar, which does not
come under the agreement has also pretty fallen
off, while the actual output of the other sorts
of sugar does not come up to the limit
established by the restrictions voluntarily ~~accepted~~
accepted. This very week Mr H. Duncan will
close his refinery. This firm has produced
1800 tons of sugar in a week and in prosperous
times employed 800 men. By the agreement
it undertook not to produce more than 700
tons, and therefore reduced its staff to 350
hands. Now the works are totally stopped and
these remaining hands discharged. Again the output
of Mr Schwartz was reduced by the agreement from
1000 tons to 600: but the necessities of the case
have brought about a further weekly decrease of
200 tons. Mr Schwartz tells us that during
the last two years he has been gradually
discharging men. One among them had called

7
regularly at his work every morning for
three months in hope of being discharged: at the
end of that time he disappeared: on enquiry it was
found he had been sent to jail for looting
making. He had always been a sober, steady,
contented workman, and bore an excellent character.
Yet it cannot be said that at the best the
lot of the sugar refiner is particularly enviable,
for they generally work 10 1/2 hours a day, Saturday
included, and only earn 22/ a week.

The total imports of sugar for Jamaica
1886 stand at 27044 tons as compared to
15562 tons in Jamaica 1885. Such figures
readily account for the discharge of so many men,
the closing of some of the works and the bitter
outcry raised against foreign countries. Looking
upon it in another light it may be reckoned that
as our imports of sugar rose from 139179 tons
in 1881 to 266503 tons in ~~1884~~ 1885, there is
here a difference of 128724 tons, which if refined
in England would have necessitated at the rate
of £8000 per ann. for 1000 tons per week
an outlay of some £20000 and would have kept
at work 1550 sugar refiners.

July 1st

Note of Interview with Mr David Martineau:-

Mr Martineau is the Managing Director of David Martineau and Son, Limited. In spite of the fact that the firm is now in liquidation he takes a cheerful view of the situation, and is trying to get capital for reconstruction. He is convinced that there is still money to be made out of sugar refining in London. The countries are not & now anything like so damaging to the trade as they were. Twenty years ago numbers of countries, and Brazil especially, gave large bounties on refined sugar, with the result that the trade was gradually almost killed; now there are no bounties except on raw sugar, which is much more advantageous to the refiner, as when raw sugar is cheap, they can do well with all the bye products and manufactures, i.e. treacle and fruit syrups. Mr Martineau thinks that Tate and Lyle still make very large profits.

Mr Martineau gave me some figures as to wages, hours etc, but for details refer to the

9
to his manager to whom he gave me a
card of introduction.

July 4th.

Note of Interview with Mr H. Loupou:-

Mr Loupou is Manager to Messrs. David Martineau.

In the first place he asked me to dismiss from my head any figures given me by Mr Martineau as utterly worthless. Mr Martineau he says has done nothing in the business for some years and knows nothing about it.

Mr Loupou was very reluctant and at first refused entirely to give me any information. It appears that there is a deadly feud between Martineau's and Lyle's, their neighbours. Ever since Mr Loupou became Manager of Martineau's he has been fighting Lyle's vigorously, and they are exceedingly curious as to how Martineau's have carried their business on. Any publication of the facts in detail would be most detrimental to Martineau's, as they and Lyle are, with the exception of Tate, the only two specimens left in London, and Lyle's would know at once where the information must come from.

After some talk Mr Loupore told me that he had completely ~~not~~ reorganized the wage list of the business, and I gather that he toward wage, as he said that he had to fight the men, who struck without success.

Though he would not give me details he gave me the following maximum and minimum wages, for but only on condition that nothing should be published on his information without being first submitted to him:

Wages:- Melting Men and Wash House Men 22/ to 30/ a week; Liquor Men 30/; Charcoal House Men 27/ to 32/; Parkman 40/ to 50/; Warehouseman 24/ to 27/; Centrifugal Machine Men paid by the piece at the rate of 10^d to 1/ per ton.

The hours were 12 with two hours for meals.

Mr Loupore takes a less cheerful view of the position of affairs than Mr Martineau who he says has been justly deceived as

"a sarjuni aro". It appears that some years ago Martineau's had a great fire, and with the insurance money they were able to launch out. Among other things they secured a valuable patent which would enable them to produce paper from raw sugar at a much lower rate than has ever been done before. With the aid of this patent, and with luck Mr Longdon thinks that they might struggle against bounties if they get sufficient money for reconstruction. But in any case it will be impossible to carry on unless labour is prepared to take a lower rate of wages.

As to describing the process of sugar refining Mr Longdon says that if he attempted to do so he should file volumes.

Mr Longdon thinks we are not likely to get anything out of Tate's who are sure to find good reasons for refusing any information.

July 5th.

Extract from Encyclopaedia Britannica on
Sugar Refining.

Sugar Refining is dealt with differently with raw
cane sugar and beetroot sugar which come into
the market, and by precisely the same series of
operations. The sugar is first melted in charges
of 5 or 6 tons in "blow-ups", i.e. cast-iron tanks
fitted with mechanical and stove pipes for
heating the water. The solution called "liquor"
is brought to a certain degree of gravity from
25 to 30 Baumé, and formerly it was the
practice to treat it, especially when low qualities
of sugar were operated on, with blood albumen.
The hot liquor is next passed through tilled
cotton bags encased in a meshing of hemp, through
which the mixture is mechanically strained. From
50 to 200 of these filters are suspended in
close chambers, in which they are kept hot, from
the bottom of a perforated tank, each perforation
having under it a bag. These bags have from
time to time to be taken off for cleaning out
and washing. From the bag filter the liquor

14
is passed for decolorizing through beds of animal
charcoal enclosed in a system to a depth of from
30 to 50 feet, the sugar being received in the
into tanks for concentration in the vacuum pan.
In that apparatus it is boiled to grain, and
the treatment is varied according to the nature
of the finished sugar to be made. To make
small crystals only are ~~formed~~ formed
in the pan, and the granular magma is run
into steel jacketed open pans and raised to a
temperature of about 180 to 190 Fahrenheit
which liquefies the grains. The hot solution
is then cast into conical moulds, the form of
the loaf, in which the sugar as it cools crystallizes
into a solid mass, still surrounded and mixed
with a syrup containing colored and other
impurities. After thorough setting and crystallization
a plug at the bottom of the mould is opened
and the syrup allowed to drain away. To
whiten the loaves they are treated with successive
doses of saturated syrup, ending with a syrup
of pure colorless sugar. These doses are poured
on the upper side of the cone, and percolating

down through the porous mass, carry into
 them the impure pure syrup which may still
 adhere to the crystals. The liquor which obstinately
 remains in the interstices is drawn out by suction
 or centrifugal action; the loaf is rounded off,
 papered, and placed in a store for drying. The
 syrup which drains from the loaves is sold
 as golden syrup. When refined crystals are
 to be made the contents of the vacuum pan
 are passed into the centrifugal machine; the
 syrup is then drawn off by rotation, and the
 crystals purified either by adding pure syrup
 to the revolving basket or by blowing steam
 through it.

July 6th.

Note of Interview with Mr John Lyle of
Albion Lyle and Son:-

Messrs. Lyle will fill in our papers
return and send it on, but they cannot classify
the men according to the Census. With the exception
of Parkmen, who are the only men whose work can
be called skilled, they employ few except-labors.

Messrs. Lyle keep their work going at one
level throughout the year, though they often have
to sell their sugar at a heavy loss.

The work is not unhealthy though the
men suffer to some extent from the heat, and in
summer they are liable to ~~die~~ ^{die} diarrhoea from
drinking too much oatmeal water.

In 1805 when the crisis in the trade
came Messrs. Lyle reduced the wages on an average
2/3 a week all round, but four years later they
raised the wages to the old level. They do not
think that a reduction in wages would make it

17
possible to carry on the industry successfully in
England: labour though a large, is not the most
important item in the expense. Nothing could raise
the trade except a ~~direct~~ countervailing duty on
refined sugar. Such a duty Mr. Dyer thinks would
only raise the price of sugar to an almost
inappreciable degree, and would scarcely interfere with
its consumption. Even some of the largest consumers
of refined sugar (e.g. Keiller) raise no
objection to such a duty.

Mr. Dyer wishes it to be understood
that we are not to make use of their waste
returns unless we have returns from other
refiners, as they do not wish to be identified.

July 11th.

18
Note of Interview with Mr. Quiddington:-

Mr. Quiddington entered the Sugar Refining trade about 30 years ago, in the employ of Messrs. Schwartz. Since Messrs. Schwartz closed their Refinery in 1886 he and about six other men have remained on doing a little fruit work, and track work.

Wages paid by Messrs. Schwartz, - which Mr. Quiddington thinks correspond to those now paid in the few remaining Refineries - were for Foremen of Melting men about 32/ a week; of Washhouse men 28/ a week; of Ligners men 40/ a week; the ordinary men under these foremen got from 20/ to 24/ a week. In the Charcoal House the men were paid 4/ a day, and stokers 30/ a week. The Centrifugal Machine men were paid 23/ or 24/ a week. Two Passmen were employed, three of whom had two pans to attend to, two one to attend to: the former got 40/ and the latter 30/ a week. The average weekly earnings of men throughout the Refinery amounted to about 24/ a week.

19

Hours were 12 with two hours off. Overtime was sometimes worked and paid for in proportion to the wages.

Regularity. Nearly all sugar Refiners used to and still do turn out a fixed number of tons each week throughout the year.

Method of learning. With the exception of the Passmen the work is unskilled; but it was usual for those who wished to become Passmen to pay a certain sum to the head Passman for a sort of three years' apprenticeship.

In the Pan the liquor has to be boiled to a certain degree of thickness, and it requires a good deal of experience to know when it has reached the requisite point. A passman who was not experienced might spoil tons of sugar.

Neither at Schwertz's nor elsewhere in London was any loaf sugar made.

Health. The work was very hot, but not otherwise unhealthy.

I asked Mr. Quiddington if he could tell me at all what had become of his old fellow lookers, but he was unable to do so. All he could say was that when the crisis came they passed through a time of terrible suffering. The men have long ceased to hope that the trade can be ~~the same~~ revived.

July 18th.

21

Note on visit to Silchester.

I visited Silchester to-day in the hope of picking up some information as to Super Requin. I did not return quite empty handed but the result on the whole was very poor.

I went into a small and very dirty eating house just opposite Mentzer's gate, and found that the only man having a meal there was employed at the site. I was just beginning to get something out of him when his wife appeared from the kitchen and forbade him to tell me anything more. She said that not only did John know nothing about it but that he did not always tell the truth being subject to fits. The real motive for her action was evidently the usual suspicion as to the object of the enquiries. John when interrupted had told me that few men with the exception of parsons ever earned more than 24/- a week, and that it took many years to rise to that sum. John having failed me another lady in the house volunteered to send out for a man who was playing an organ in the immediate neighbourhood.

His name was Alfred Wilson; he has been working in sugar refineries all his life: first for Messrs. Duncan, and after they failed for Mortimer's till last Christmas, when he met with an accident which crippled him, and was he says turned out at once without any compensation. He was not an easy man to get much out of, and from his appearance I should imagine that he is addicted to drink, so that I should not be disposed to place too much reliance on such little information as I obtained from him.

As to wages he says that Parson gets from 40/- to 50/- a week. Others get wages from 20/- to 35/-

Hours are usually ten at actual work though some men only work nine hours. Work goes on night and day.

Regularity: Both at Lyle's and Tates the work is regular throughout the year. Hands are never dismissed for idleness.

Health. The work is unhealthy owing to the fearful heat, and from the same cause there is great temptation to drink.

Lyle's pay, their men better than Tate, and treat them altogether better. Tate's men are usually known as "Tate's shoots"

Pross. Lyle here to-day sent in their wages return. From what Mr Lyle said to me I gather that they have closed as had all who earn less than 20/ whatever their age.

July 22nd

Note of Interview with Mr J. J. Rogers:-

Mr Rogers whom I saw previously with reference to former year has some information as to Sugar Refineries.

He says that the main of the Refineries was by no means entirely due to Domestic indeed that they were not the chief cause. The main reason was that the Refineries sold had sugar, and tried to bolster up their trade by protection. Up to 1874 when Gladstone took off the sugar duties the trade was protected. The Refineries had ~~not~~ hardly anything but West India cane sugar, which was much inferior to the best sugar of the Continent. Their plants and machinery too was far behind that of the Continental refineries; as soon as the European foreign sugar came in free the English sugar was at once driven out of the market, and the refineries tumbled down like a pack of cards. If they had moved into the times and spent capital on new machinery etc. they could easily have kept going. The countries

of course had something to do with their failure,
but in spite of the banker Tate has managed to
pile up the biggest fortune ever made in the
sugar trade. Martineau's has been ruined not
by banker, but by misfortune.

Second Series (116)
Vol. 3. Part II.

July 26th

Note on Japan Question:-

I have read a number of Blue Books and Parliamentary papers on the Japan Question. Of these I have marked the following:-
1864 Report of the Committee on the Japan Question
1864 Report of the Committee on the Japan Question

TF497
Railways for the Moggyara Railway
Feb. 21. 1936
p. 374. figs
Railway Gazette
Scepter

try and
told that
Honour
ordered a
figure
year
the public
till this report is out, as with the very scanty information which I have been able to glean it is impossible to say what is really the condition of the trade

Second Series (116)
Part II
Second Series, Vol III Part II
(Food and Drink).
Chap. I: Millers, Sugar
Refineries, etc.
Interviews

July 26th

Note on Sugar Production

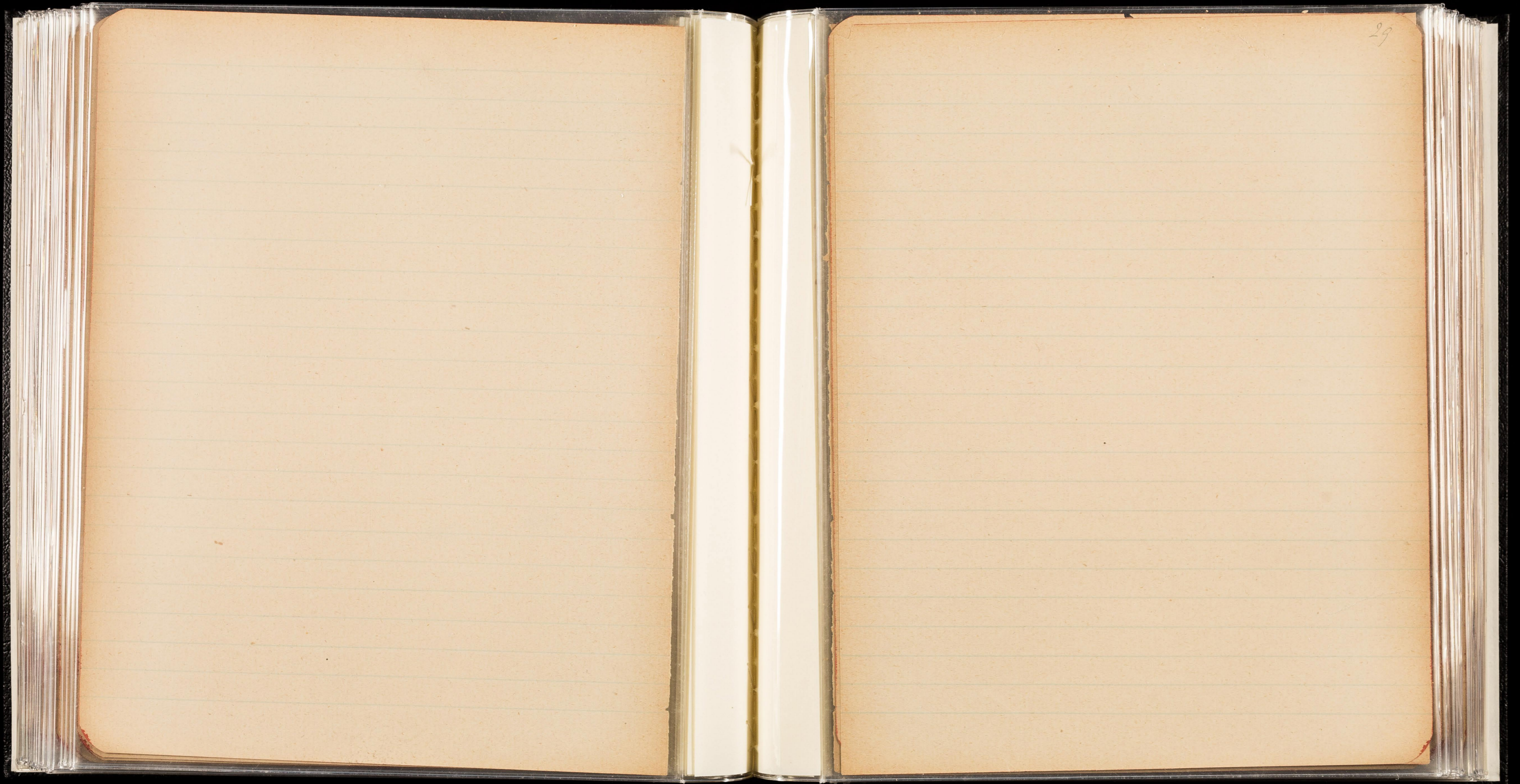
I have read a number of Blue Books and Parliamentary papers on the Sugar Question. Of them it is only necessary to read three:— (1) The Report of the Select Committee, marked A. (2) Sir Robert Siffen's Report in 1864 marked B. (3) Sir Robert Siffen's Report in 1889 marked C.

I called at the Board of Trade to try and get some later information, but was told that at present they could give none. However during last session the House of Commons ordered a further Report, which Sir Robert Siffen will probably write before the end of the year. If possible I should be inclined to defer the publication of the section on Sugar Refineries till this Report is out, as with the very scanty information which I have been able to glean it is impossible to say what is really the condition of the trade.

To bring the history of the attempts to deal with the question up to a later date it may be noted, that a further Conference was held in London in 1807 at which Germany, Austria, Prussia, Denmark, Spain, France, Great Britain, Italy, Holland, Russia, and Sweden were represented. On the 20th the representatives unanimously signed a Protocol condemning bounties, and reporting that a system of manufacturing and refining in bond was the only way in which bounties could be avoided. The Conference met again in 1808 and finally on Aug. 20th a Convention was signed by the representatives of all the countries except France, Denmark, and Sweden, the Convention to come into force from Sept. 1st 1808. The important clause of the Convention is as follows:— "Any contracting power shall in order to exclude from its territory raw sugar refined sugar, molasses, or glucose that has benefited by open or disguised bounties take the measures necessary therefor, either by prohibiting them altogether or by levying thereon a duty which must necessarily exceed the amount

of the bounty, and which shall not be levied on sugar not bounty free coming from the contracting countries.

On April 11th 1869 a Bill to enable her Majesty to carry into effect a Convention made on Aug. 30th 1861, in relation to bounties on the exportation of sugar was read for the first time in the House of Commons. However the bill met with obstacles when supported for the Convention, and such hostility from the Liberals that it never went to a second reading, and was withdrawn on Aug. 22nd. Since then the question has slept.



29

July 11th.Millers.

Note of Interview with Mr Peter Mansford:-

Mr Mansford is one of the largest millers in London. I was not able to detain him long enough to get much detail from him, especially as he had a tendency to wander from the subject, and to discuss labour questions generally.

Wages in Mr Mansford's Mill vary from 21/ to 50/ a week.

Hours are 5-9 a week with overtime paid in proportion to the rate of wage. Mr Mansford greatly dislikes overtime, and does all he can to discourage it, but the men like it. A certain amount of overtime in the trade is inevitable. Work goes on night and day, the men taking it in turns to do night-work.

Regularity. The trade falls off to some extent in hot-weather, but not to such ~~an~~

a desire to re-assess the dismissal of any man.

The trade is healthy, and men go on to a considerable age.

Method of learning. There is no apprenticeship. There is little now to learn, much less skill being required than with the old system of making. The chief requisites for a man now are attention and interest in his work.

The trade has for some years been in a depressed condition owing to the enormous importation of foreign flour. Sir Taylor the largest man in the trade has closed one of his mills and Mansford has at times been obliged to work short hours or even to work off the whole of one shift.

Prof

July 11th.

38
Note of Interview with Mr. Seth Taylor:-

Mr. Taylor is the largest miller in London, and has the reputation of being the ablest man in the trade. He was however too busy this morning to enable me to get much out of him. He appears to live in a constant whirl of telephones, and I found it impossible to fix him to any details.

Hours are 59 throughout the trade.

Regularity. No extra labour is ever required, but it is often necessary to work overtime.

There has been no displacement of labour by machinery of late years; the great displacement took place about 20 years ago, when roller milling first came in.

Mr. Taylor does not think that the number of hands employed in milling in the country or in London has decreased of late years.

but owing to the large importation of foreign flour the number has not increased. Though personally indifferent in the matter, as he is quite able to stand against foreign competition, Mr Taylor thinks that a duty on imported flour would not affect the price, and would of course enormously stimulate the milling industry in England. The raw material would still come in at low prices, and the competition among English millers would keep down the price of flour to its present level.

July 13th

40

Note of Interview with Mr H. Robinson, of
Deptford Bridge Mill:-

Mr Robinson is a man of about 70 in a
large way of business. He began as a working
millen, and has been right through the trade.

The chief grades of labour in a modern
mill are the Roller, the Purifier, the
Siftman, and the Smutman.

The Roller and the Purifier attend
respectively to the rolling and the purifying
the Siftman dresses the flour, and the Smutman
cleans the wheat.

Wages. Mr Robinson could not give me
exact details as to wages, as he pays no
fixed rate of wages, but endeavours as far as
possible to pay each man according to his
capacity. Roller men generally get about
30/- a week, and other men from 20/- to 27/-
a week.

41

Hours. The Mill is worked in two shifts from 6 to 6, with intervals for meals amounting to about an hour and forty minutes. There is a certain amount of overtime, but not much, paid in proportion to wages.

Regularity. Mr Robinson never has occasion to throw off any regular hands, but if work is very heavy he takes on some extra men, who however are not millers, but merely common labourers.

41 The sale of bread always falls off to some extent in the summer, and also when fruit and vegetables are unusually cheap, and probably some masters find it necessary to discharge some of their staff in the summer. Mills too are always liable to be stopped in their working by a glut of foreign flour.

Method of working. There is now no labour in milling which can be called skilled. The modern mill is automatic, and the men other than those engaged in loading and cart-work have only

to attend to machinery. There is nothing to be done in a mill which cannot be learnt in a fortnight. In the old process of milling stone dressing was an exceedingly difficult operation, which required great skill and experience; no man could hope to learn it under three years. In London at all events there is now no apprenticeship, though millers like weavers, take pupils of a superior class.

103

Health. The trade is generally healthy and much more so than it used to be. In the modern process there is no dust in a mill; under the old milling the mill was full of dust, and men suffered much from lung diseases. Mr Robinson thinks the modern process has added ten years to the lives of the men.

Men now whom who are exposed in wheat chaff are an unhealthy, sickly lot, the dust being off by wheat being peculiarly wholesome.

There is no excessive amount of dust among the men, and certainly a good deal less than there used to be.

The vast majority of Millers are countrymen
by birth. Mr Robinson will not leave London
if he can help it. Not only are they inferior
workmen, but they are full of tricks, and
thoroughly unreliable.

Mr Robinson has heard that there is a
Millers' Union, but has never been troubled by
it. He does not know what are the Union
wages and hours. If the Union were ever to
call on his men out he has no doubt that
he could fill their places at once

Mr Robinson thinks that there are probably
as many men employed in milling in London
as ever there were, but if the old methods
were still used the number of men required
to produce the present output of flour would
be four times as great as it is.

July 16th.

44
Account of the process of Milling, from
Dodd's Dictionary of Manufactures (1884):-

"A Flour Mill is at the present
day an example of machine operations on a
very complete scale, presenting a striking
contrast to the corn mills of old times. The
successive operations are ~~about~~ almost entirely
automatic. The order of process which varies
a little in different establishments is substantially
as it follows:—

Smut-Cleaning. A self-acting elevator
raises the corn to the top of the building,
where it passes through the smut-machine.
A vibrating apparatus keeps the grain in agitation
in a wire cage, while a blast of air is blown
through it by a fan. This removes chaff, dirt,
dust, and smut particles, which would otherwise
impair the whiteness and excellence of the flour;
the refuse is carried away through channels
to the outside of the building.

The Hopper. Another elevator transfers
the cleaned grain to the hopper or funnel

shaped runners which surround the small
pairs of grindstones. Here a jiggling or vibratory
motion causes the grain to fall equally between
the stones. In some mills a little bell keeps
tinkling so long as the supply of grain
continues, but stops when the grindstones want
more food.

Grinding. The grindstones after very
ponderous are so chiselled and grooved on the
contact surfaces as to cut and grind the
corn very effectively; the grooves act
indeed like the meeting blades of numerous
pairs of scissors. They require swiftness of
rotation may be given to the stones: they
are boxed in, alike to prevent waste, and
to obviate accidents; and a blast of air
comes at once to blow out the meal or flour,
and to keep the stones free from that degree of
heating, which the friction would otherwise
give them.

Dressing. The flour is taken up by
a series of cups attached to an endless band,
and conveyed to the dressing machine. This

consists essentially of a long, low hollow cylinder of fine wire gauge, or (for some kinds of flour) of fine silk gauze; the cylinder is thickened a little lower at one end than the other, and is made to rotate about 650 times per minute. The gauge varies in fineness at different parts of the length of the cylinder. Entering at the highest ~~end~~ end, which has the finest gauge, the finest flour passes through the meshes; then comes down flour of the next degree, and so to the end, when nothing is left but husk or bran. It is a question of choice with the miller how many kinds he will have of firsts, seconds, pollard etc. according to the number of variations in the fineness of the gauge.

The Sacks. The dusting machines are so placed that the flour falls from them into sacks, and thus is completed the series of operations, in which from first to last the hand scarcely ever touches the grain, the flour, or the machines which contain them.

July 26th

47
Note on Intention with Mr. J. Brazier.

Mr. Brazier was for three years secretary of the Millers' Union; he gave up the position three years ago, and is now Deputy Manager of Seth Taylor's mill at Dockhead.

He tells me that the description of Milling, from Dodd's Dictionary is out of date; no mills of any standing now use grind stones: all mills are on the roller system: it would be impossible to give an adequate description of the process by word of mouth which ~~an~~ an outsider could grasp. The process is entirely automatic: the grain is shot into a machine at one end of the mill and after travelling two or three miles without being touched by hand is shot as flour into the bags. The sole duty of the men who would be described as millers is to attend to the mechanics.

Bags. Roller men earn from 30/ to 36/a

40
back. I'm would get so much as the higher
sum.

Pacific men and Lithuanian men from 29/ to
29/.

Smattermen from 25/ to 26/.
There is no Union rate of wages, and they differ
very much in various mills.

Hours in London Mills are usually 5-9.
Overtime is worked at the rate of time and
a quarter.

Replenish. The work is quite regular
throughout the year for mills. At most
mills it is necessary at times to take on
extra men for unloading bays etc.
At Dockhead at present they have about 40
such men at work. These men are mostly
ordinary labourers; they are paid 5/6 a day,
and few of them either get or want a full
day's work. Several of them have been
offered a permanent job, but have refused it.
Among actual millers in London there is seldom

any difficulty in getting work. Work in the
The output of mills has been smaller for some
years owing to American flour, but few if
any men have been discharged.

Health. Men still to a considerable extent
suffer from lung disease.

Learning. Mr. Brown was appointed
for some years in the country, but apparently
in London is now quite unknown. The man
of great intelligence can learn to mend the
machines in a week or two.

The Millers' Union was started soon after
the Dock strike, and was for a time very
active, without any strikes they succeeded in
getting the standard lower reduced from 61 to
59, and overtime paid at time and a quarter
instead of at the ordinary rate. Almost
without exception they wished the masters to
raise wages from 5 to 20 p.c. The
position of the men is in every way much

better than it was some years ago.
Considering that their duties are quite unskilled
the men have now no reason to complain.
Mr. Drayton does not seem to know anything of
the present position of the Union.

The trade at present is generally
improving, as the impositions of flour are
less than they were.

Aug. 9th.

57
Note of Interview with Mr Arthur Barker:-

Mr Barker is Editor of 'The Miller'.
He tells me that London Millers are a very
reticent and secretive lot, and that he feels
sure that they will look on me as a "proletarian
fellow". So far from the work being easy,
and unskilled he considers it most difficult
and responsible, and wonders that men are
prepared to do it for such small wages. The
masters systematically undermine the position of
the men, and in many cases do all they can
to prevent them from learning their work
thoroughly; a man is kept to one job, and
it is as much as a pumpman's place is
worth for him to attempt to learn the duties
of a rollerman.

Mr Barker has promised to let me
have an account of the process of Roller
Milling.

Aug. 12th.

52
Note of Interview with Mr Mark Mayhem.

Mr Mayhem is a young man of about 25 - with a mill in Dutton. He stood as the Radical candidate for Wandsworth, and alone among London millers seems to view matters to some extent from the men's point of view.

Wages. Mr Mayhem pays Rollermen 34/6, Purifiermen 30/6, and Silkmen 28/6; Smuttermen from 26/6 to 30/6.

He says that he pays higher wages than are usual in the trade. The Union have several times published a statement of his wages, and the Master Millers' Association have expostulated with him for paying too much.

Mr Mayhem agrees with Mr Parker as to the difficulty of the work, and would be sorry to employ a man as a Rollerman with less than twelve years experience. He says it is all nonsense to talk about making a man a miller in a fortnight.

59

Hours in all London mills are now 59.

Replanty. Mr. Mayhem's best customers are best and Baker, and work is very slack from the end of July to end of September, but he never discharges any men. During slack season they are employed in cleaning, repairing machinery, etc. He thinks it is most unusual throughout the trade to discharge any permanent hands.

Health. The trade as a whole is healthy, though men undoubtedly suffer to some extent from lung diseases. Though there is nothing like so much dust now as with stone milling, there is still an invisible dust called in the trade "stare" always floating in the air. This is not flour but part of the husk of the grain.

Compared with many trades, millers look on to a good eye. Mr. Mayhem has one man of 90 at work.

Mr. Hayden much prefers to get
countrymen in his mill; they know their
business better, and will work much harder
than Londoners.

The Millers' Union is very badly
managed and is in a very poor condition.
At times it has consisted of scarcely anyone
except the Executive. In 1850 they showed
some activity, and it was owing to their
representations that the hours were reduced
from 61 to 59. They also did something
towards getting mills generally better
ventilated.

20 The competition is now so great that
the small mills are being driven out, and
the tendency is for the trade of the small
mills round London to gravitate to the
big London mills.

For about a year the English mills
have been underselling the American mills,
+ in England

55
and have got back a large part of the trade which is not likely to leave them again. Many of the American mills have had to be closed. But though the English mills are selling a great deal more flour they are actually making smaller profits, and for this reason: the American mills have sent their 'offal' over here, the result was that the impositions of America flour by reducing the output of English mills sent up the price of offal. The decline in American impositions has sent down the price of offal by 50 p.c. owing to the competition among English mills the price of flour has not risen and the profits of the miller are smaller than they were when he had to fight the Americans.

Aug. 16th.

5-6
Note of visit to Mr Mark Mayher's Mill
at Battersea:-

I to-day visited Mr Mayher's mill and was shown all over it, but I fear too quickly, to give anything like an accurate description of the process. How complicated that process is may be judged from the fact that not a sack of flour leaves the mill, some portion of which has not been through 100 machines. The difficulty of grasping the process was enhanced by the noise of the machines which made it almost impossible to carry on any conversation. Roughly however the order of the various processes was washing, cleaning, milling, purifying; each of these operations seemed to require an endless number of machines.

With regard to the rollers and Purifiers Mr Mayher explained to me where the necessity for knowledge comes in; the flour ought to leave the rollers or the purifiers in a certain state of fineness.

57
and the workman must know when it is
in the right condition, and be able to adjust
his machine so as to produce the required result.
By altering the adjustment of the machine
Mr. Mayhew should be an immediate charge in
the character of the products.

It appears that the number of men
attending to the machines form quite a
small proportion of the labour in a mill.
For the largest proportion are engaged in the
absolutely unskilled work of ^{lifting} ~~lifting~~ the
sacks of wheat or flour.

Sept. 13th.

Note on Interview with Mr W. Salmon. 58

Mr. Salmon is the delegate to the London Trades Council of a branch of the Millers' Union.

Wages. Mr Salmon says that the wages of men throughout the mills do not average more than 21/6. The wages paid vary greatly from mill to mill; the best paid men are those at Marriage's at Dattersea where no man is paid less than 26/6, the rate being 26/6 for silkmen, 29/6 for finishers, and 32/6 for rollers. In some mills some of the men do not get more than 18/6. Peter Mumford has the worst reputation among masters. Magher pays his rollers as much as 40/6 but men in the lower grades some of them get 24/6.

The Union are endeavouring to get 26/6 fixed as a minimum wage, and some months ago brought the matter before the Masters' Association, which replied that the masters

preferred to deal with them one man individually.
In nearly all mills there is a good deal of overtime worked and men make from 2/ to 5/ a week in this way.

The Union was formed in 1885, and in 1890 asked for a general rise in wages which was conceded by all masters though not by all alike. Perhaps gave a rise of 2/ all round. Seth Taylor gave a rise of from 1/ to 4/ in proportion to each man's pay. The rise has not been by any means generally maintained as new men have honestly been taken on at the old rates.

At the same time there was a general rise in the rate of pay for overtime, which previously had been in most mills at less than the ordinary rate. The higher rate for overtime has been generally maintained.

Hours. 5 1/2 are the recognized hours, though as a matter of fact the majority of men do ~~do~~ 5 1/8 hours, as the majority of mills allow 40 minutes for breakfast, which is the

By Low Mills only 30 minutes are allowed. Men who are not on the mechanics are allowed an hour for dinner. Those on the mechanics have to remain in their department the whole of their 12 hours and their meals are brought to them to take in the room; as a matter of fact they seldom have any difficulty in taking them in comfort. Their meal hours are counted as overtime.

The Union in 1890 got hours reduced from 61 to 59, and induced ~~all~~ all masters to stop work at 1 on Saturday instead of at 4.

Mills as a rule now run from 6^{a.m.} Monday to 1 p.m. on Saturday, though some when they are busy start at 12 on Sunday night. Mr Salmon who is not too friendly to masters gives them credit for doing their best always to shut down at 1 on Saturday.

Reputation. The dismissal of men for slackness is very rare, but work is slack and there is less overtime in hot weather, and when

74 | people are out of town in the summer.
 Mr Salmon thinks that trade is generally
 broken when trade generally is depressed as
 so many people can then afford little else but
 bread to eat.

Method of learning. Mr Salmon thinks
 that an intelligent man would learn the
 business of milling as now carried on in about
 six months. It is most important that the
 tender of each machine should know the
 exact condition in which the grain ought to
 leave it.

Health. Mr Salmon admits that the
 trade is much healthier than it was, but
 still thinks that it is unhealthy. He says that
 few men work after 45 and that in his
 experience few millers live over 50. He only
 knows six men still trying to work over that
 age, and of these 4 are out of work.
 All the old millers he knows still living are in
 the workhouse. The work though not so hard

as it used to be and fewer from dust
is more continuous; while a man in the
milk he has no rest, whereas in old days he
might do a hard job and then rest for half
an hour.

In some milks the wives of men
very commonly mend sacks, but with the
exception of the wives of very young men it
is most unusual for wives to do any work.

The Union is at present in a poor
way: there are about 150 members in London.
In 1850 there were about 500. Mr Salmon
thinks that a strong Union might very
probably get better terms out of the masters,
as they are not well organized, and are
now doing well.

Sept. 16th.

Note on Intoxicants with Mr. J. Harris:-

Mr. Harris is Secretary of the Battered Branch of the Millers' Union. He is I should think a more intelligent, and certainly a better educated man than Mr. Salmon. He is a purveyor in Mr. Messer's mill.

The bulk of the information which Mr. Harris gave me is contained in the various papers ~~of~~ of which he gave me copies.

Wages. Mr. Salmon's average of 2/ a bush is too low.

With regard to the wages paid at fair and unfair hours probably the majority of mills approximate more nearly to the unfair scale. There is as a rule a good deal more overtime at the unfair hours, and the actual weekly earnings of men in the two classes of hours would not differ greatly.

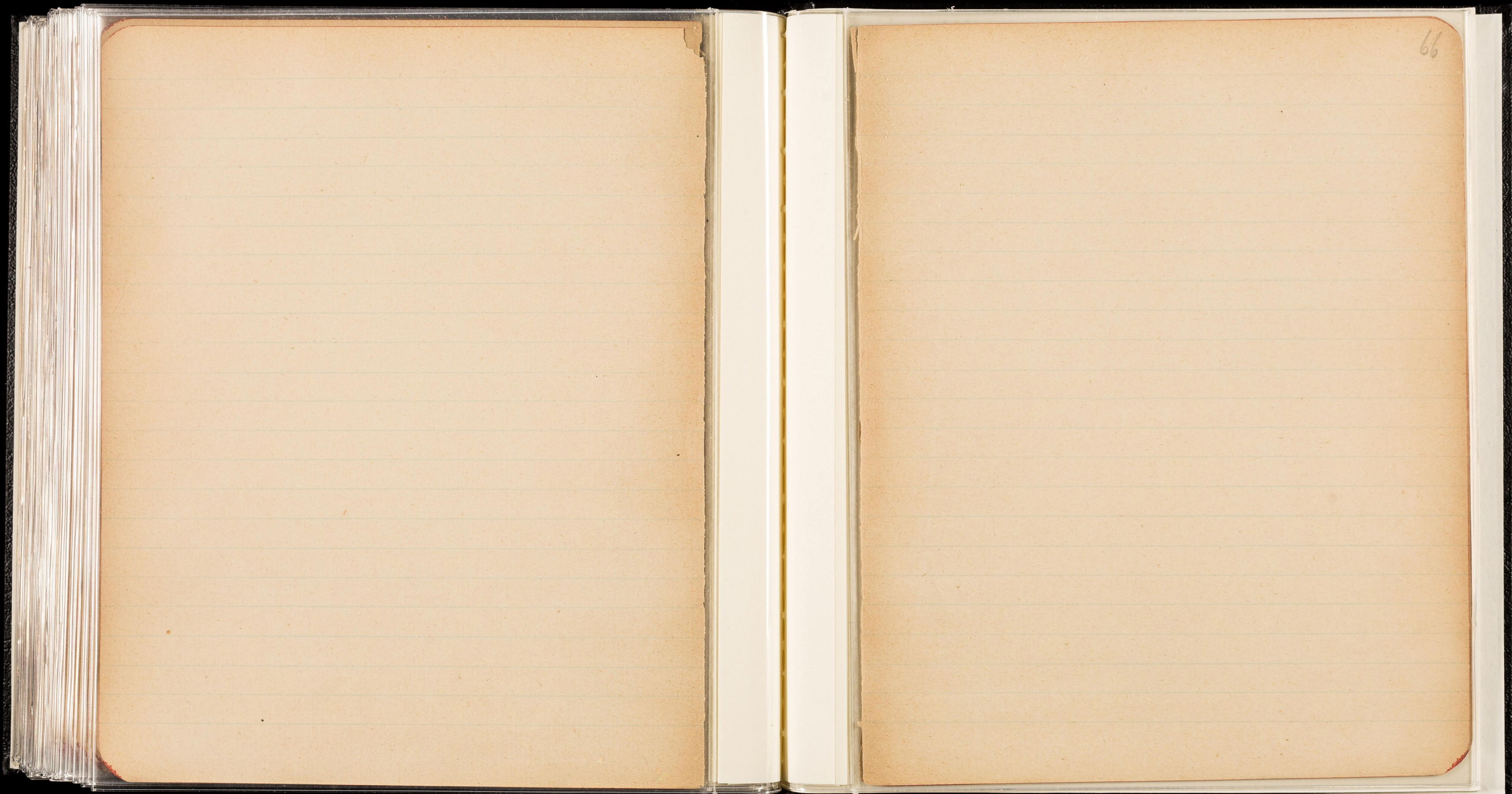
Hours. Mr. Harris denies Mr. Salmon's statement

64
that there are mills in which the hours
are 58. As far as he knows Maniap's is
the only mill where 60 minutes are allowed
for breakfast and here they work till 2 on
Saturday, thus making up the 59 hours.

Holidays. With the exception of Maniap
who gives a week to each man no master
gives regular holidays other than statutory, but
Magher's men can often get a day or two off
by asking for it.

The Union has steadily decreased in numbers
since 1869 and the numbers given in the
Debate Sheet for 1874 are now excessive. Mr
Salmon is convinced that a strong Union could
get better conditions from the most of the masters
with very little trouble; but the men are terribly
apathetic and will not pay 3^d a week.
Masters are as a rule very ignorant, and lead
the purely animal life of eat, sleep, work.
Some of the masters are strongly against the
Union, but the best are quite in favour of it.

65
and even Seth Taylor, the General-man of
Innkeepers among them has recommended his men
to belong to the Union.



66

Index.

- Page 1. Note of interview with Mr. S. Schwartz.
- " 2. Extract from 'Times' of March 13th 1886.
- " 5. Note of Interview with Mr D. Martineau.
- " 10. " " Mr H. Lothrop.
- " 13. Extract from Encyclopaedia Britannica.
- " 16. Note of Interview with Mr J. Lyle.
- " 18. " " Mr Chiddington.
- " 21. Visit to Liberton.
- " 24. Note of interview with Mr. J. J. Rogers.
- " 26. Note on Sugar Bounties.

- " 36. Interview with Mr Peter Mansford.
- " 38. " " Mr Seth Taylor.
- " 40. " " Mr H. Robinson.
- " 44. Extract from Dods Dictionary.
- " 47. Interview with Mr. J. Brazier.
- " 51. " " Mr H. Parker.
- " 52. " " Mr. Mark Mayhew.
- " 56. Visit to Mr Mayhew's Mill.

Page 58. Note on Interview with Mr. W. Salmon.
" 63 " " " Mr. J. Harris.

