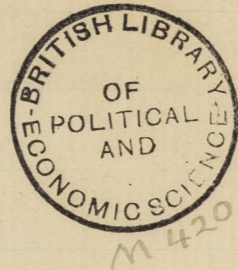


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Extracts from rule book of Coppersmiths Soc. p. 99

Mr Fross Brass founders.

Wages of men employed.

The 'set' system.

March. 14. 1894.

G.H.D.

Mr Frost. Allen Street. Clarendonwell. &c.
Brass founders.

They gave the following as being the average weekly wages earned by their men for two weeks ending March 17th & 20th

	Respectively 17th	20th
Moulders	48/6.	45/.
Firamen.	35/6.	33/.
Trimmes.	30/.	28/.
Coremakers (boy)	18/6.	16/.
Clearing boy.	8/-	8/-

They work on the 'set' system and this is a set given above.

The 'set' system is dying in London they said
It consist of

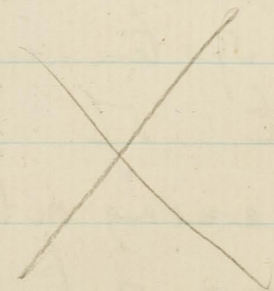
a clearing out boy paid by the week who cleans out the cores from the castings which have been made generally

The set system with average wages.

Hours of work.

No overtime

Hot + dirty work



cleans away the sand.

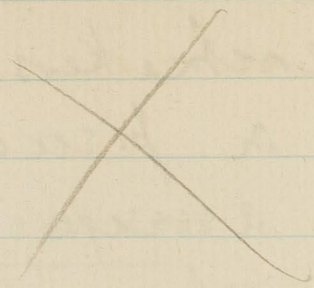
1. one or two combmakers also paid by the ^{week}
2. a trimmer on piecework whose ^{average wage would be 26/-} week.
3. a firman who gets 10/- per cast and 2/- per day for keeping the furnace in order.
4. a moulder who gets 1/- 3 1/2 for 4 moulds. four moulds constitute a cast. The average money of a moulder would be 38/- per week. In a full week 34 casts would be done & his earnings would be £2.3.11.

54 hours is the full working week though the factory is open for 56 hrs. but the men need not work > 54 hours though they generally like to work 56.

8-7 and 8-2 on Saturdays.

They have no overtime because Mr. Allen finds that it does not pay, what you gain one day you lose the next. It is hard hot & dirty work and the men like to be kept moist but the men

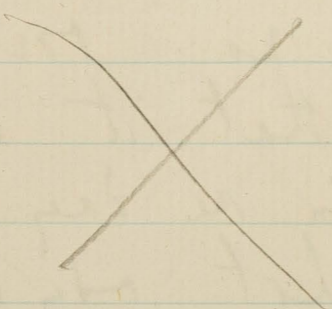
Drink



Training

Finishers out of doors.

Small men.



Course of Trade

Keep good time because they discharged at me of
they don't. They have noticed a great improve-
ment in drink. Men even send out for coffee
now instead of beer. Think it is owing to their
method of training their own men.

Boys are taken on at 7/- per week to do
clearing out, then they make crosses
then they trim or become firemen.

If they become trimmers they remain so for
the rest of their lives. On the other hand

a fireman may eventually become a moulder.

There is not much shifting here but w^t say
there was a good deal in the trade generally.

The Brass & gun metal which they found is used
chiefly in the Gas, electric, gas engineers &
water work.

For finishing they employ out of door men
or other small masters who return it.

These small men start whenever the times are
prosperous, but as soon as things are bad they
are swallowed up & work as journeymen for
the larger firms.

1891 a fairly good year. 1892 a better one

Seasons gas fittings winter }
water .. Jan to May }

Shop club (sick)

Men always stay out one day
longer than nominal holidays

1893 better than 1891 but not so good as 1892.
All the work is more regular than it used to be,
demand was for gas fittings in winter, for repairs
to water fittings January to May, when the frost
used to find out all deficiencies. No one thing
balances another and there cannot be said to
be a marked ^{busy} or slack season.

There is a sick club here but it is not the
general rule in the trade. Every man is allowed
4/- per week above his wages which is paid into
this fund and to which the man himself has to
add 3^d. Only 8 foundrymen subscribe in this way
and only fully competent workmen are allowed to
be subscribers. 10/- is given for sickness without
any time limit and the whole fund is shared
out equally at Xmas. Last year there was a
surplus of 50/- for each man. ~~the~~

The men have a peculiar habit of always staying
out one day longer than their nominal holiday
is if the four day they may stay out till
Easter Tuesday they don't come in till Thursday
apparently just to show their independence.
In some other trade consists of something of

No overtime rate.

London trade is now a jobbing trade.

System of taskwork.

Fumes.

Shopfronts come from Birmingham.

of working

They have no overtime rate and never work very much, and never at any time more than an hour a day.

Besides being manufacturers they are also dealers. They employ 14 men, 4 lads, 7 boys.

London used to be the seat of the wholesale trade but now the London trade is a jobbing trade & wholesale work has gone to Birmingham.

The men are pieceworkers but although on piece they count a certain quantity as being a fair day's work. They are good workmen up to 60 years of age.

The Trades Union is not strong, and have given no notice of their requirements to the firm.

The fumes from molten brass do not improve the health of any one whose chest is already affected, but they are not really unhealthy if a man is sound.

Manganese an amalgam which they do not touch is undoubtedly the worst for men. All shopfronts come from Birmingham & nearly all kettles and lamps also.

Tea & coffee urns now come
from Bram

Pewterers

Tea & coffee urns which used to be skilled
branch of London manufacture now come entirely
from Birmingham, though the handles & caps
may be cast in London. Pewterers do bar fitting
work, beer machines &c

Alex. Craven London United Brass Finishers Society

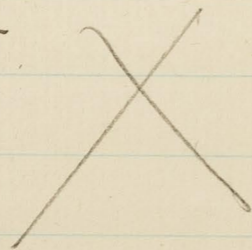
Duties of Brass finishers, Turners, fitters

Brass workers

Both time & piece workers, but P is the rule

Hours

Out of 400 in Soc only 30% are T.



7
March 15th 1894.

Alexander Craven 18 Staugate St
Lambeth. Secretary London United
Brass Finishers Society.

Brass finishers are Turners & fitters & must be able to undertake all kinds of steam sanitary & hydraulic work.

Brass workers do 6 handeler work, stamping & fine work and admit polishes to their Society. They originally belonged to Mr Davis's Society in Birmingham but seceded and formed a separate Society of their own.

Finishers and Brass workers work both on time & piece. Piece is the rule in most shops.

Coverage 9 hours per day. 6-8.30 + from 9 to 1. ^{3.15} from 2-5 work 52 hours per week as a rule. From 6-1 on Saturdays allowing half an hour for breakfast.

out of the 400 who belong to the Society only 30% are day workers.

Brass workers admit moulders, but these do not-

Chief houses employing Finishers.

Masters will not let men earn > 1/- per hr.

In case of a reduction of wages.

Are a branch of the Nat. Soc of Brass Founders.

Bouldings
Tylers Boulding, Jennings, Warner, Maudslay
Dewrance are the houses which employ
the greatest number of brass finishers, and
in every Engineers shop there are always
a number of Brass finishers. Dewrance have
many Society and non Society men working
together

Masters will not let men earn more than 1/-
per hour, the Society will not have any
who earn less than 8^d, but supposing a
man who has been earning 8^d goes into a
shop where the rule is 9^d & 10^d then this man
must insist on a higher rate also

Supposing a shop tries to reduce the rate of a
Society man to the same level of that of a
non Society man, even though that non Society
man may be earning above 8^d per hour then
they block the shop and support both Society
& non Society men out of the funds until the
strike is ended.

The Brass finishers form a branch of the
National Association of Brass Founders to which
each member contributes 1^d which may only

The National Association

Electrical Instrument makers

Finishers employed on sanitary work

9

be touched in the event of disputes.

The National Association is purely a fighting Society, and is made up of 16 different Societies all over the country. They have a conference every 3 years to which each Society sends 2 or 3 members. The Conference is generally held at Liverpool because Liverpool is strictly a day work town. (The Liverpool Society has 450 members)

Brass Finishers will turn Copper Brass or Iron.

Electric Instrument makers sometimes come into this line, but they are only good for very fine work. Their Society is federated with that of the Brass workers

Sanitary work eg Boulton, Jennings & Fuchs is a London specialty, and all cuptry Brass finishers all the very highest class work may be said to be done in London, but none of the very small work

Stones at Deptford do a great deal of Export work.

In the East end Brass finishers are chiefly

East & West End work for
Brass finishers

No seasons.

Training

Each shop settles its own prices.

Not much prospect of Day work being introduced

employed on ships works i.e. Land rails, lamps, scuttle lights (i.e. Porthole doors which are all of brass) In the West End they work on fancy electric and Chaudier work for private orders rather than for large hotels which are generally supplied by Birmingham
No seasons

Apprenticeship for 7 years is the normal way of learning the trade, but it is not used now. Usual way for a boy to come in as an errand boy and pick it up.

The Society has no price list, each shop settles its own prices because machines are so different and so is the class of work, and the patterns worked by different houses.

Screws are generally turned by hand excepting electric work. In Birmingham screws are actually stamped up.

In the trade there is a great tendency to introduce small machinery, but there does not seem to be much prospect of day work becoming the rule, for the men will always ask for Piece work by preference.

Men classed at Daywork rate & draw sack during a
Piece job.

Piece masters.

Arranging new prices is a
continual source of annoyance.

Not much O.T.

All firms allow you to draw on account.

11
at the Westinghouse Brake Co & in most shops
men are classed at daywork rate, & allowed
on piece work to earn time and half or time &
quarter. During a job the men draw at their
stated time work rate and are paid any
surplus due to them in a lump sum on
the completion of the job.

There is a certain amount of piece mastering in
the trade. Sometimes he has had to keep the
shop while his master was away and small
men have come round and asked for jobs to take
home and he knows a case at Floods in old
fravel Lane at the present moment.

There are a great many new pricings for the
new work which is continually cropping up &
these are generally arranged between master
& several men meeting together. These new
arrangements take up a lot of time and are
a source of continual annoyance.

There is not much overtime now worked
all firms allow you to draw on account; they
even like you to be a little in their debt
Masters like men to have seen different classes

Masters like men to have seen
different classes of work but not in too many shops.

The Pewsters.

Earnings.

Men always take a day more
than they are allowed.

Great many small garret masters.

Some masters allow men to take
work home.

of work, but you should not have been in too many shops. Mr Craven has only worked in 5 shops all his life. He works now at a Pewsters of whom there are not 100 journeymen in London he would say. They have a Society of 30 members and their funds are so prosperous that they are worth about £30 per man.

A good man will earn 52/- in a week and could take 60/- if he were allowed to. 44/- would be a good weekly average for a fair workman.

Mr Craven is to use 1 month in the year compulsorily owing to holidays i.e. Easter 1 week or 9 days Whit Sunday 3 days Beau feast or Wasjose Saturday to Wednesday Xmas. His firm also close for a week stock taking and the men will always take a day more than they are nominally allowed to. This is their regular habit.

There are a great many small garret masters e.g. Pickersill whose ^{do} small screw down cock work make cameras or generally with boys to help. have been journeymen themselves.

Some masters allow men to take work home & these set a lathe at home & work at night.

Regular transition from clockmakers
to Brass finishers

All Gas fitters are day workers
without exception.

Drink.

There seems to be a regular transition from clockmakers to dial and index makers to mathematical instrument makers to small brass finishers and so to men who do large work. There is no very marked distinction between each branch ~~beyond~~ ^{broadly} except between those who do large and those who do small work. A man on large work never likes to do small work and is generally incapable of doing it; but a man who does small work is ^{loosely} finishing a worker for large work and unable to make good money.

Garnett & Fowler of Walworth use only boy labour. Shroobred he would say did some of the best sanitary work in London though they employed rather more brass workers than finishers. All gas fitters are day workers without exception, and earn 7½ to 8' per hour. Contribution 1/- per week to the finishers society.

Drink he would say was neither better nor worse than it used to be. When they loose their work the majority lose it through drunken habits but he would not say they drank more than any

Course of trade

other mechanics.

1891 was a very good year, 1892 falling 1893
very bad. In 1893 there were 80 different
men out of work

E. Karat, Tin & Iron plate worker.

Jews in the Trade.

All on piece.

Christians drink.

Foreigners will work more
cheaply than X trans.

21 March 1894.

E. Karat. Tin & Iron plate worker
Vine Court Mile End Road. E.

would say about 50 Jews were in trade now,
(Journeyman). Come over and are glad to be
given work

all pieceworkers

used once to employ Christians, has now 10
foreigners. they are better than Christians, don't
drink. Christians would slave for 4 days and
draw 40/- and then off drinking. Christians would
shift. foreigners only too glad to stay where he is
makes kettles, cans, oil cans, saucepans fenders
Has 2 apprentices for 5 years from Jewish
Board of Guardians. Boy gradually pay off
the premium out of wages

must do things more cheaply else get no trade
Christian refuses to do anything for less price
but a foreigner is not so obstinate

Trade spoilt by small men who have been
journeymen who work at home and then hawk
round to the shops

Knows several who work at home.

More foreigners every year.

Has had men leave and then under sell him
Trade has prospered with him
Knows of several families who work at home
They buy raw material from him, often on credit,
cant pay back, and must then sell him their
goods until they are paid off.

More trade in London every year, and more
foreigners come into it.

Very glad to give further information.

Ossosky, Tin plate worker.

Home worker & hawker.

Machinery is taking the
place of men.

Opinion as to pay at Kavets.

21 March 1894.

Ossosky.

Tin Plate Worker 29. Mulberry St-
6 ^{Commercial} Coleridge Road.

Has worked for Williams in Euston Road.
Has wife + 5 children. is now out of work.
Does work at home and then hawks round to
oil shops and in the "Lane"

Wages depend upon what shops you work for
in the best you get 35/- to 40/-, in others 15/-
is a good wage.

He has worked from 8-10 every day for 2/6 at
piecework.

Machinery does most small work like match
boxes, cigarette boxes, now more quickly than
men.

Small men make for small shops.
at Kavets men would be too thankful to earn
15/- to 20/- on piece, many only make 10/- or 12/-

R. L. Sentinella 172 workmen
Brassfounders Soc.

Composition of the Soc.

Duties of the members

Daywork shops prevail.

10 March 1894

R. L. Sentinella and 12 workmen
at Crown Tavern Blackfriars Road.

Sentinella Secretary pro tem 2 North Street
Kennington Road S E ~~London Society of Br.~~
London United Brass Founders Society

Their members are

Coremakers

Moulders

Trimmers

Firemen

Moulders are the most skilled and make the
outside from a pattern

Coremaker makes a block of sand to form a
hole between the mould and the core round
which the metal can be poured

Trimmers take the burrs off from the casting

Firemen melt the metal for the moulder

These men often work in sets of one each who
take out the work at a price

Daywork shops he would say were the rule the
proportion being 7 daywork to 1 piece work

Earnings

Hours vary. 54 hrs. is rule where Engineers are employed.

Earnings in East End.

Number of shops in London
with rates of pay.

The Improver's System.

where piece work ^{apprentice} obtains the men take out the work at so much per cwt or so much per cast. The prices both for piece work + per cast differ

Moulders average between 38/- + 40/-

Improvers in Moulding (boys) get 4.10.6 per hour the hours vary. In shops where Engineers are employed 54 hours is the rule, but the smaller the shop the longer the hours.

In the East-End of London. Society used to have a branch. There the average is 8½ per hour + time + a quarter for overtime

altogether there are 115 shops in London of which 50 are small ones. At Broad's 9½ per hour is the rule at Wilkinsons 8/- at Verity's at so much per cast at Bentham + Froude piece work coming to 9½ per hour

There are a great many boys now in the trade but they don't suffer so much as other trades. Very few are apprenticed. The system is practically dead only 1 in 3 he could say were regularly indentured. The improver's system has taken its place. personally he thinks the present

system the best for the boy learns one to depend upon himself

Devrauce is one of the few shops where you can learn everything in one place

The more usual thing is for smart core boys to run away to get a place as improver and finally to become moulders

London is a huge jobbing shop, in every place work is different, not 3 shops are alike in the whole town. You must make everything from propellers + cylinders down to bedsteads

Devrauce employs 20 or 30 moulders

Maudslays - 25

Bowens - 26

There are perhaps 500 journeymen in the trade altogether. Small work is done on the bench + large work on the ground

There are no seasons. November is about the worst month but he does not know the reason why

The Society was originally connected with the City Guild of Brass Founders in St. Swithin Lane

There is much shifting especially among firemen. The foundries as a rule are much neglected

London a huge jobbing shop

About 500 journeymen moulders in the trade.

No seasons

Much shifting esp: among firemen

Lowest rates of pay.

Unhealthy fumes.

Trimness.

Small shops rarely make
for large.

2 of the men present, have only seen one
Inspector in their lives.

6¹/₂ per hour is the Society minimum price
and not many get less who belong to the Society,
outside men get as little as 5³/₄ perhaps even
less.

The fumes from molten brass & copper
are unhealthy and may produce blood
poisoning. Antimony is more poisonous and
often makes a man sick. Phosphor Bronze
on the other hand is less unhealthy.

The men sometimes get metal Hague from
the phosphate of zinc given off by the brass
Manganese is a mixture of metals, its
fumes act like Tartar emetic and cause
pressure on the bladder.

Trimners get the same money as firemen
They have had several men out of work for
6 or 7 months while others were making over
time.

It is very rare indeed that small shops
make for large.

The majority of founders are founders only

Brass foundry consists of
Moulders

Fitters

Cornmakers

Trimmers are handy men with a file
only a few are legit brass founders. says you can
make a trimmer in 3 mths. often shift to be
smiths hammermen or dockers

about 500 moulders fitters in London

200 fitters

100 Cornmakers men & a lot of boys who
drop in & out.

R. d. Latouche

Kingston Engineering Co.

Southco Rd. Kingston Thames

W. Substa. Station

will show some works any afternoon or dropping in
tune the night before.

eg of the 38 shops on this (ie) the South Side
of the Thames 22 are working but foundries
but the demand for electric light has brought
in a lot of work lately especially artistic
electrolier work.

Brass founders are said to be born
thirsty ^{they have unproved 100%} several even are avowed teetotallers
Sautella himself was blocked in his
youth for being a teetotaller

26. v. 94.

Loam moulding is really iron moulders work & iron moulders
do it here: tho' in the north brass moulders do loam moulding
Loam moulding is only done in the largest shops for the largest
work

Taskwork is still the rule of the trade,
London is only pitting in the general foundry trade

Manganese Brass & Bronze Co.

Moulders earnings

Lads in rolling mill

Firmen

Patternmakers

Odd side moulding in Clerkenwell
is the poorest part of the trade

March 12th 1894

The Manganese Bronze & Brass Co.
St Georges Wharf Deptford

They employ from 110 to 150 men at present they have in the foundry. 56 men
In the Rolling mill 32.
" Forge 5
" Pattern shop 10
Dugout shop 20

In the foundry the moulders earn from a man of 38/- to 42/-

In the Rolling Mill they are mostly lads no two of whom earn alike varying from 10/- + 12/- to 15/- + 16/-

In the Dugout shop firmen get 32/- fitters & machine men get 38/- to 42/-

Pattern makers 38/- + the leading hands 45/-
Oddside moulding as done in Clerkenwell would be the poorest part of the trade he would think. It is a dry trade owing to the fumes but the men don't drink where there is

Drink.

Other losses in the trade.

Labourers wages.

No seasons.

sufficient ventilation. In any case has been a great improvement in the last 10 years. The men are certainly getting on in sense now than they used to have.

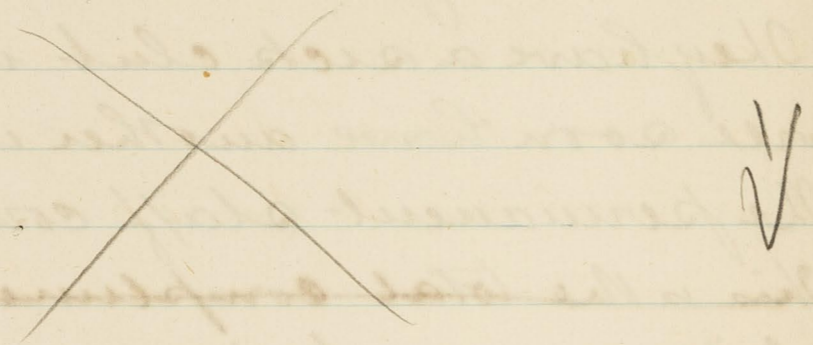
They have a sick club in the mill shop & will soon have another in the foundry. The permanent staff consists of ~~40~~¹¹⁰ men here. This is the total complement; all the rest may shift 40 may be termed the tidal complement and are the uncertain quantity.

Maudslay - Peuss, Humphrys - Tennant & all big Engineers do Brass founding also. He would say loam moulding and brass founding required more skill than any other branches of the trade.

Labourers get 22/- per week here which is 1/- more than the usual rate in the neighbourhood because he wishes to get the pick of the men. 1891 was a good year. 1892 good but only fair to the others. 1893 was fair here, but bad for most others.

They have no seasons and depend upon the Ship building world for their orders. Just a

Hours.



Pay the Union rate.

Union always succeeds in getting the best men.

present they are medium busy
54 hours is a full working week
6-5 for 3 days 6-530 for 2 days 6-12
Saturdays The men make a special
request that they should get away at 12
instead of 1 on Saturdays in order to see
football matches etc. They said they would
prefer to work half an hour longer on Tuesday
& Thursdays, and this was granted them
Copper and zinc makes brass. Copper +
tin ^{makes} gun metal + bronze. Bell metal has
a greater proportion of tin.

Each man in the place is paid separately
They have no apprentices when they want a
new man. The foreman get them from the
Clubs.

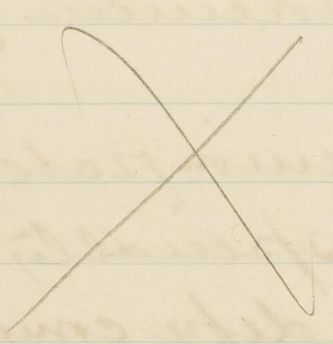
They pay the Union rate because they are
the makers of a specialty and can only keep
their place and defy competition by employing
the best men and there is no doubt that the
Union in every trade always succeeds in
getting the cream of the men.

Brass fumes are supposed to be unhealthy

Fumes.

Men on large do not shift to
small work.

Prob:
Effect of Employers Liability Bill.



and they may affect a man who is otherwise unwell. They have a special medicine prescribed by their doctor which they always keep ready for such cases: It generally happens with a new man coming into the work after having been some time out of work

He would take on a man past 50 supposing that he were a capable workman

As to shifting from branch to branch the general thing is that men on large work do not care to shift to small

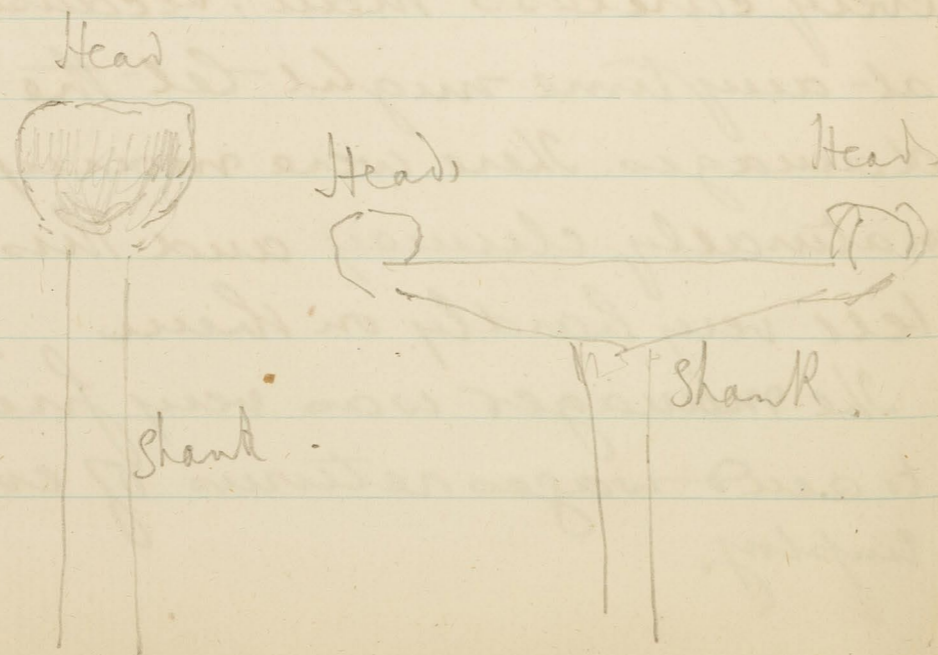
Speaking of the effect of the Employers Liability Bill if passed he said that it would at once add to the number of unemployed because the masters would at once sack every careless man, because such a one at any time might let the master in for £50 damages. There were many men who were naturally clumsy and this Bill would tell very hardly on them

The manager was very friendly and promised to send wages returns of every man in their employ

Browning: small master copper smith & Brazier.

Articles manufactured

Method of work



20 March 1894.

Browning a small master Copper smith
Sowell Road R6

He employs 3 men said that very little beating work was now done in London because the neighbours objected so much to the noise

Coppersmiths & Braziers were to be found all over London they are a highly skilled body of men and a fully trained man must be able to beat up a piece of copper to any required shape Tea Kettles Kitchen ware such as saucepans bowls for sugar melters & for fruit preserving fish kettles and the long cauldrons used for feather dyeing are among the various things manufactured by them. as with brass & silver a good deal is spun, but spun work is neither so hard nor durable as that which has been beaten. a copper smith starts with a thin sheet of copper which has been cut to a given pattern, this he first of all beats to shape with a wooden mallet against a wooden head & then hammers and polishes by beating

Brazing

Scalemakers are the poorest.

Rates of pay for Braziers.

Usually P.

Hours.

with a bright steel edged hammer. These beads are of different sizes & shapes and are fixed upon the ends of iron supports or chanks which are themselves let into a stout block of wood in the floor. All articles which cannot be made in one piece and repairs are brazed or soldered in & then hammered; this requires skill & practice so that while every brazier can do coppersmith work it is not every coppersmith who can braze. He said it was very difficult to find good all round men now. i.e. men who could make their own patterns & then beat their work up.

The poorest part of the trade he would think was to be found among the scale makers at least so he would judge from the very low price at which their work were sold.

The rate of pay for Braziers is 9^s & 9^d per hour. In most places it is piece work, but here as he works on time & finds he gets the best results from time work.

56 hours full working week 7 a.m. - 7 P.M. and 2 on Saturdays. Nothing extra is allowed as an overtime rate.

Seasons.

7 years Apprenticeship usual.

Drink

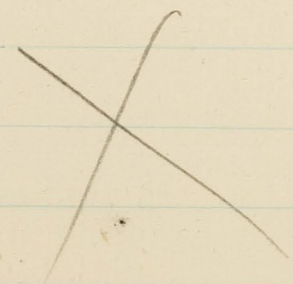
4 months before & 4 months after Xmas are the busiest seasons Spring and Summer are slack until the fruit season begins. Most houses have a few day work men as a regular staff & the rest they employ are pieceworkers

To become braziers boys serve the regular 7 years apprenticeship with indentures. all the best men drink and this is the great complaint in the trade

R. Dudge. Pewterers Society.

Divisions of Trade.

Easterware has supplanted
pewter plates.



March 31st

S.A.D.

R. Dudge. President of the Pewterers. Society.
17. Nally Street. Birmingham.

Pewterers. have some what degenerated

Lead ware (Does it know why) is teapots
ice moulds, ice mixing machines, hot water
dishes. (little done in London). cake moulds.

Bas fitting. The main branch. } this is mostly
Pewter Pot making. } done in London.

The last 2 men together: both made at the same
firms.

One man should be able to do all 3 but men really
stick to one branch.

Easterware has now taken the place of pewter tho'
at first it was much objected to: it took
the edge off the knives, as it does.

Pewter consists of tin, lead (a little) hardened with
copper or zinc, is called also Britannia
metal, common metal, hard metal etc.
a pewterer shd be able to execute any order

London is the centre for Pewter & bar fitting

One price all through trade.

How to make a Pewter pot.

in these metals but it is very rare that he does so.

He must be able to ^{turn} ~~up~~ for pots.

Plates are cast & then turned.

Boon pewter pots are ^{always} ~~generally~~ cast & then turned up.

German silver pots are spun, but they do some of the work.

London is the centre of the industry for Pewter & Bar fitting but Bram & Sheffield for Sadware.

Sadware & potmaking is P. but bar fitting is all without exception Day work.

Are scattered all over London as far as Greenway & in N London.

One price for pot making all through the trade; strictly kept to few exceptions, none he has ever heard of.

First mix & melt your metal to the required quality, then you take your moulds which are all of gun metal & belong to the firm.

Moulds are heavy eg one for a quart pot but weigh nearly 40 lbs for the body only pot is made in 3 parts, body, bottom & handle. The difficulty of casting is to

Moulds of copper.

32
get both your metal & your mould to the requisite heat if one or other is too cold ~~or~~ too hot you cannot cast. It is in the Skill.

This is nearly all P. & it is maddening finding your metal run badly or shrinking wrong.

At the beginning of the cast you are very fortunate if the first 3 or 4 come right it is generally luck that makes it so.

Handle mould, body mould, Bottom mould. Spout ^{stra}.
Then you take your castings to the lathe & turn the inside of the pot

(Baer engines ^{spouts} are cast in gun metal with sand cores, other ^{is} no sand is used)

Then solder together; then turn the outside; then you garnish it solder handles & spouts on. you must solder so finely that it cannot be seen. The solder used is peculiar & secret to the trade.

^{Baer filters}
Baer engines are all made of cut sheet ^{metal} ~~work~~ which are cast & then rolled through steam rollers & then worked up to suit the particular order. Basins in which the glasses are washed are spun or hammered up.

Baer engines made of sheet metal.

Society founded.

Election.

Subscription.

Benefits.

Numbers in London.

very little diff between the two because the metal is
alt-rady hard after having been flatted.

Society founded. 1842. (?) will send word.

$\frac{2}{3}$ of the Rown patterners in London are
members. (w! rather not give exact numbers
so that master may not know how weak
or how strong they are.)

Not all new offers are accepted.

Has to be prop & seconded.

Stand over for 6 or 7 wks pending enquiries
then elected by ballot by the members present
at the meeting by a bare majority.

6^d per wk.

15/6. out of work. 14/ in cash 2^d a day in
refreshment when you sign out of work book
& your contribution is paid for you.

for 3 wks & is the amt for another 3 wks.

No sick.

Dispute pay is decided by funds & according to
numbers who are going to strike. Have five
a week or 30f (excl) a week.

Probably not > 80 journey men in London.

5 big shops employing from 18. to 6. men
(largest) smallest
among these 5.

Chief Losses in the Trade.

Each paid separately.

U & W men work together.

Relations pretty comfortable.

others are little shops employing 1, 2, or sometimes 3 or four.

Heath. Raker St. Goswell Rd. keep their own brass finishers, & carpenters.

Even small ones generally keep a brass finisher but not a carpenter.

Warne. Blackfriars Rd. when he works

Sanders & Co. High Holborn

Helms. & Co. St. St.

No work is put out: all work done by themselves. Each man is paid separately: several men never take a job for a lump sum.

$\frac{7}{10}$ of the work at these shops is day work.

Society men do work together: has had a lot of controversy on this subject: but in-soc finds much diff in getting into a soc. shop tho' not vice versa: the best men decidedly belong to the soc: the quality of workmanship it is that makes a man eligible.

Relations are pretty comfortable between employer & employed there is nothing disagreeable.

No reg. board of conciliation. Before a strike

Disputes.

Earnings.

Payment in Non Soc shops.

Hours of work.

Not unhealthy work.

they require an unanimous vote of the whole of the society. Every man prob he worked with the other & knows them personally.

42/- a week (they are paid weekly). In piece they draw at about the same rate or a little more. Piece workers w^d be bad workmen who did not care if an hour w^d soon want to get out of it.

38/- 40/- an av. man. w^d say it w^d be quite w^t. The great majority in the Soc. get 42/- for a full weeks work.

Most of the non society shops pay 9/- he knows he paying 8/- this would be quite the lowest in the trade which is kept very dark.

He works 54 hrs for 42/-

Some work 58 - - -

All travelling money for fares & time are paid for to & from jobs.

No shops less than 54.

Non Soc. houses w^d prob work more, he knows none working < 54.

They have no regulations as to hours of a full week. There is so little lead that is not unhealthy.

Busy or slack seasons.

Hours of work.

Capacity.

Drink & temptations to

Local Veto Bill & Trade.

the pure tin pipes in mineral water works
& for pumping spirit up in pubs are all
pure tin.

Blackest time is Jan & Feb. men discharged &
short time also. The work depending chiefly
on publicans who wait for a week or 2
before every public holiday. Then esp in
Dec the pubters are in December. Used to
make a lot of O.T. Trade is the rule after
8 P.M.

8-7 as the usual hours. 1 hr dinner. & some
give 1/2 hr for tea.

8-1. Saturdays.

About 60. a man w^d have some difficulty in
obtaining employment. Some c^d work well
at this age but others c^d not.

They have this propotion of drink among the pubters.
great temptation, you have the inn of public
cellar & can take what you like just
like a cellar man. More often than not the
whole cellar is given in charge of pubters
when they are putting in new work.

Trade is going down in London. Veto Bill has frightened

Work slack when slack.

The General holidays are a
dead loss to mechanics.

No shifting.

Always 7 yrs. Apprenticeship.

A man who has not been apprenticed & who wishes to become a member must be known to be a good workman & must have been earning work of wages 5 yrs previous to his election.

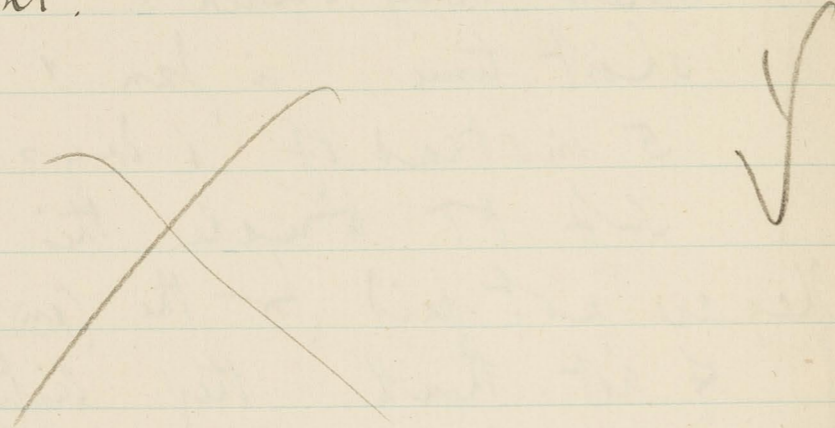
publicans. They don't know what is going to happen & by sitting in their uncertainty work is tolerably well shared & hands not discharged unless very slack. As a rule all work is on short time. in Jan & Feb work probably make 5 instead of 6 days. work never have suff OT to make this up.

They are not paid for the general holidays. Does it not think they suit mechanics at all who can always lose a week or two at just the same cost & then when you go out you don't have to pay twice the ordinary prices and you get pushed about. Think they are fair waste of time.

Men don't shift much from branch to branch & most are employed for many years & I remember a score who have worked for 1 firm for 16 to 20 years.

Men are not pick clubs as a rule in the tiff shops. Always 7 yrs Apprenticeship. has not died at all. can't get into soc. without serving an indenture tho exceptions are sometimes made if a man is a very good man. work think that

Painters can do gas-fitters &
Plumbers work but don't.



Rents in Maltby Street.

nearly every painter in London has been approached.
not 27 not approached. he w. think
a Painter could become a gas fitter or plumber
with very little tuition but never do so.
The out door work in Painting & gas fitting
is much alike. only Painter uses putty
instead of lead.
Gas fitter & plumber never touch this trade &
these never touch theirs.

in Maltby St. 6 rooms incl. small kitchen.
front & back : down : 3 rooms upstairs.
15 ft. frontage. railways cut them on the
slant. he has soft garden. & a wash house.

Messrs Braham, Brass finishers & workers.

London is the centre for the
best work.

Wages.

19 March 1894

Messrs Braham

Brass finishers & Brass workers.

Clerkenwell St

He employs 35 men

He started twice for himself. The first time he had a little money, the second time he had none. He does brass finishing spinning wood turning metal polishing

Brass finishers are to be found all over London London is the centre for the best work and all the special orders are given here when you give a very big order it goes to big firms and generally to Birmingham but the small orders are executed in London. The Birmingham merchants are at a disadvantage because they are not on the spot ~~and so~~ In London there are many little people who do special work and some medium sized houses who will take orders for quantities

Finishers get 8^s per hour as the lowest pay here. The average is 9^s.

Turners earn between 8½ to 10½ per hour

Earnings of the best men.

Sawpiers.

* but he says there are actually more men in the trade than women

Lacquering process.

All day work.

There is so much demand for the very best work and so few who are able to do it that the best men are easily worth $\frac{1}{2}$ per hour and a few even more than that

Sawpiers are mostly women. It used to be a man's business but has now been given over to women, and is very suitable work for them. The women here earn 24/- per week.

Lacquers who put on the varnish to preserve the colour after the brass has been polished are also women. They work at an iron table which is heated and has a bunsen burner at the right hand of each. The articles to be lacquered are placed on the iron table to be warmed, then painted with the lacquer and then moved backwards & forwards through the flame of the burner so that the lacquer may run evenly.

The full week consists of 53½ hours from 8-1, 2-5 & 5.30-7 and until 2 on Saturdays. All work is day work and are given time & quarter for overtime.

They have no season and all here have

regular work. There is not much shifting as far as he is concerned, for during the 5 years he has had a business no man has left of his own accord

1891 was a brisk year + 1893 was all right here

Learning the trade throughout is a thing of the past. The apprenticeship system is dead a lad picks it up as best he can.

Boys start at about 6/- per week and then make themselves affable to the men and are allowed to try their hands on odd jobs

now the work is more divided than used to be. Now you have a turner and a vice man whereas formerly one man did both

Properly a brass finisher should turn his work, file it up burnish, and lacquer it

He will not touch piece work. all his men are day workers and he gets much the best results from day work. He has the advantage of being a practical man himself but he would not say that 1 in 50 of the masters in the trade were themselves practical workmen

Apprenticeship system is dead.

Greater subdivision now.

Day v Piecework.

Advantages of being a
practical man.

Electrics is supplanting gas work.

Electric Tools making is a sep branch.

The man who can give credit
will always get the trade

When there is new work to be done he gives it to the workmen and tells him to do it as best he can. When the man sends in his bill for the time during which he was on this particular job, he compares it with the time at which he estimates he could do the job himself, and suggests ways by which the work could be done more quickly. The men know that he is himself practical and do not try to spend longer than they need over any bit of work, if they do they know they will be found out and lose a good place.

Electric work has taken the place of Chandelier & the gas trade is getting a thing of the past.

Electric instrument making is a branch of the trade by itself.

Trade is just as good now as ever it was but there are so many more to do it. One house is often busy while another house is slack. The man who can give credit will always get the trade it is therefore very difficult for small journeymen to survive a trade.

Best men always drink

Cabinet brass work is the worst branch.

Payment in small shops.

Foreign competition

Does not believe in the Technical Training now being offered.

depression

The best men always drink the worst men dare not do so because they know they would not be employed if they did

Cabinet brass work is the worst branch of the trade to judge by the price at which you can buy the stuff.

only little out of the way shops give 7° less he himself has only 1 turner as low as 8° the rest range 8½ upwards

There are a great many piece work shops in the trade

He would say that the class was growing who liked work to be slightly different from that of their neighbours

The competition with Germany is keen. Their labour is cheaper but in good work he thinks he can certainly hold his own

He is not a believer in technical training it is only educated duffers that you get to teach you a man came round to him the other day whom he knew to be an inferior workman who said that he had got a post as

His own life.

Rates of pay for fair
workmen.

Men take advantage of there being
much work & take a day off.

Technical Instructor, and would he send some of his own men to the class

He himself is one of 6 Brothers. 5 of them were turned out at 10 years of age to earn their own living and have become independent. He had to work from 8 to 8 for 6 days for 10/- per week

He would say that 8½ q³ + 9½ per hour were the average rates for fair workmen. 1 or 2 may earn as much as 60/- per week but these are exceptions

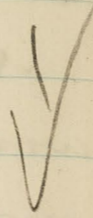
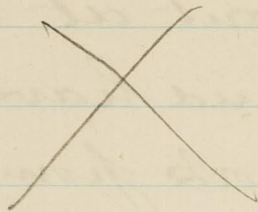
He does not think that men in full work actually do more than 48 hours work per week

If there is much work about the men take advantage of it - to have a day off. In the big shops the rule is to begin at 6 or 7 a.m. but here they start at 8

The Trades Union is not strong nor is 12 of his men belong. He is not much of a believer in it himself for working men are like sheep and will vote for whoever chooses to get up and speak

His chief customers are wholesale houses

Found out the value of middlemen
by personal experience.



and Electric Engineers. He used to think that middle men were unnecessary & swallowed up your profits and tried to supply consumers directly, but it took such an enormous time finding your consumers and going about to get their orders, and so he has come to the conclusion that it is useless trying to get on without them.

London Soc of Amalgamated Brassworkers

London membership.

Wages.
mostly day work.

Seasons.

Plumbers Brassworkers.

London Society of Amalgamated Brassworkers
Seceded from Nail Society 1886

About 4 non Unionists to one union man.

The London membership of the 5 Brassworkers

Societies about 1600 to 1800 men

Unionists & non Unionist work together.

most employers work well together.

men work at lowest rate 8^s per hour 54 hours
per week mostly day work. 8 27 36/

Men at 55 years of age can do the work but the
employers don't like them. There is a prejudice
against old men begins to manifest itself at
about 45

Busy Season September to March

Slack " Summer.

Many firms make stock work during the
slack season & put the men on short time
Plumbers Brassworkers are busy in the summer
when work (Building) is proceeding.

Overtime only in urgent cases. The Society
discourages systematic overtime

In slack times some firms work short time

Very little shifting.

Lads pick up the work.

Others discharge the new
men working as ordinary Brass workers
can do Plumbers Brass work but the men
engaged on the latter cannot as a rule turn to
the general work as they only do lathe work &
not foundry work. Men do not frequently
shift from one employer to another in the
same branch of the trade

Lads go to work in the shops & are put to work
at the vice. If a lad shows aptitude he may
be articulated for 5 or 6 years but it is not
usual to apprentice lads. Employers are
good & help them to learn the trade

London United Brassfounders Society.

Wages.

London United Brassfounders Society
Established 1890

Between the Societies about 25% of the Moulders are organised of the other sections of the Trade the percentage of Unions is smaller. The general Labourers Union is the only organization that takes the Unions & Non Unions work together. The men are practically in the Masters hands.

Moulders 38/- for 54 hours

Core Makers }
Turners } 6 per hour
Fitters }

These are the rates the Union seeks to enforce. There are moulders for 60 hours at 8/- per hr. other men are taken at a weekly wage. Have a case being investigated now. a man working 59 1/2 hours for 26/-

There are very few elderly men in the trade the work is injurious & men are taxed very heavily. The Master knows the capacity of the man &

No seasons.

Not much OT

Trimmer, firmer & coremaker
may in slack times go as gen. labourers.

No shifting as a rule.

Trade precarious in small shops.

Training

exact a certain amount of work It is practically "task work"

No seasons Sometimes appears worst about Xmas

Overtime not often worked Don't get any extra rate as a rule

The practice as to employment during slack times varies in different shops

The Trimmers, firmers, & coremakers may in slack times go as general Labourers. The moulders do not.

As a rule the men do not shift from one branch of the trade to another as work offers.

Firmers & trimmers will exchange. Moulders never. Coremakers seldom change they are not used to heavy work

Trade is very precarious men are often in & out especially in foundries that do outdoor jobbing work men do not change willingly

Very little articling a lad starts at the core bench as a boy in a year or so he is put to the trough. This is his usual method of learning.

O.F. Burnett & Green: Tin plate workers.

History of the 'West End' Society.

X

12 March 1894

Mr. O. F. Burnett & Mr. Green
Working Men. Tin Plate Workers

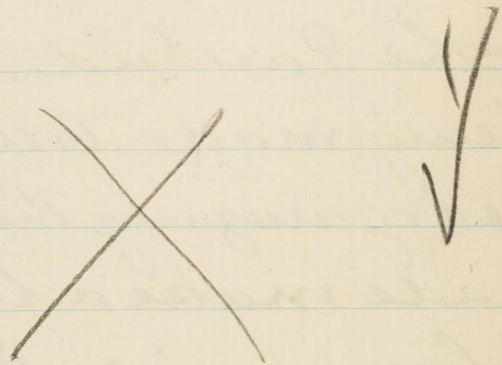
Mr Burnett represents the 3rd generation in the Trade. He belongs to the Amalgamated or West End Trade Society which had a price list as early as 1805. They used to meet in the Bell in the old Bailey, and there was also another Society meeting at the 'Black Jack' in Long Lane. These 2 amalgamated in 1873 and gave the name to the present Society - There are now 2 Societies in the Trade. The Amalgamated or West End & the East End, and an attempt is now being made to amalgamate the two by reorganizing their price lists. The East End had made a lighter class of goods 'Commons' is the name for the lightest kind of plate up to six "cross" after 6 cross Tin plate runs to gauges of iron & is called 'tinned iron' and passes 6 20 gauge iron down to 12 gauge than which

All Piecework.

Earnings on good work

System of working up from Poor
to better paid work.

Reason for men leaving work at
Union prices



no shinger stuff is used. 14 gauge is the
thicket plate used by tin plate workers
all work is piece work

They have no day work rate as yet but
they were going to decide on one next week
on good work a quick man working 50
hours can make 50/- to 60/- per week

He said we must have different
prices for work otherwise men would
only insist on doing only the easy things

In shops you begin by working at poor
work and hope to work up to better paid
work. The Union price list is the reason
for this. A man on rough work at
Union prices may earn as little as 18/-
a week. If such a man sees no prospect
of getting on to good work he leaves the
Society to which he has to subscribe 8/- per week
and takes lower than Union price to do good
work at a non Society shop knowing that
he can thus earn more money than when
he is on poor work at Union prices

Boys are now apprenticed, but not taught

Work pretty regular all the year.

Staple trade winter & summer.

Men do not shift.

He does not know of any shop working more than 52 hours. As a rule they make the stock when slack.

Work is pretty regular all the year round

In 1893 a slack year. Not more than 13 out of the 800 in the Society were out of work. Competition with Birmingham & Wolverhampton or Keele. The staple trade water pots in summer, Coal scoops in winter, &.

Scabrough Trunks for travel in the Autumn. Baths are made throughout the year.

The Army & Navy is a fair firm and pays union rate.

The men do not shift at all they keep to one shop. One has been 12 & the other 14 years in the A & N Stores.

Mr Barnett & his father have never been out of work in their lives. A good workman need never be out of work. They can turn to fur meta making if their own trade fails them.

The power of earning good money begins

Capacity

Overtime is unusual but
short time is proverbial.

Shipping is nearly all day work

Minimum rate.

Cheap homemade work.

to decrease between 48 & 50 - 60 years of age is perhaps the limit of capacity though Burnett's grandfather worked at it till he was 84.

Overtime is usual in the trade but short-time proverbial

Burnett earns between 40/- + 55/- per week a medium man would expect to make between 35/- + 40/-

Burnett has 4 sons + three out-apprentices any sphere to the trade

Shipping work is nearly all day work + men have to work night + day in this branch. Trimming up cauls + doing all the tin work required

The minimum rate is 9/- per hour. The men have a club house at the oriental Tavern East India Dock Road.

Common stuff is made by small men one he knows in Lambeth works with his wife + daughters. There is a demand for a cheap article - cheap tin toys are a great deal made in this way

Small masters in Whitechapel.

In whitechapel & Shoreditch there are
a few suace masters. 1 man Isaacs
in whitechapel gets a great many
deaf & dumb apprenticed to him

Numbers in a small foundry.

The nature of the moulding boxes.

Numbers on task work.

Average amount per week.

May 30th

G.H.D.

R. L. Lentinella at the Kingston Brass foundry
Larkspur Road. Lubbock.

One man can and sometimes does run a small foundry in London. R.L. knows about 12 men working thus singlehanded. It requires about \$50 to start a small foundry. He has been a small master himself & has worked both alone & also with others under him.

The metal moulding boxes are only iron frames & a wooden board is put over ^{each of the} open sides & clamped together so as to keep the sand in during the 'pouring'. Moulders on task work are very careful not to do more than their minimum number of casts in a day. The number of ^{molds} ~~casts~~ depends to a cast depends on the size of the frames or boxes. Ordinarily 29 casts make up a full week & 5 per day & 4 on Mondays when

Trimmen.

Brass workers.

Wages.

Not a season trade.

Healthiness.

the sides of the furnaces are plastered up by the firmen. Moulders are generally not expected in a Monday morning.

Trimmen are both piece & time workers.

'Brass workers' includes the whole of the foundry & finishing trade. Their trade society however includes Brass finishers and moulders also.

Trimmen are the poorest section of the Trade. They get 6^d an hour. How? Not say there were any under this price.

Firmen get 6½^d

Moulders. 8^d or 9^d

It is not a season trade. When in regular work a moulder makes 37/- or 38/- regular work depends on the general trade of the country.

The worst shops are those in the crowded parts of London and especially the smaller ones. About 11.30 AM. in a small shop with ten or 11 men you may have 6 casts being poured and the fumes given off by the brass are very

X

heavy so that there will be a thick white cloud in the air for 2 or 3 hours or more. The men say that this affects the urinary passages besides being hot work. Therefore they drink.

R.S. thinks the fumes which are chiefly zinc fumes do not do much harm: none if the shops are well ventilated.

There are 3 shot makers in London. Two just across the Blackfriars Waterloo Bridge.

The one on the right hand uses a good deal of arsenic which makes the shop much rounder & hotter but we probably not to show this part of the work.

We will say there were about 60 malders in the Brass workers society. Ask Nash the secretary. Crown Tavern. Clerkenwell Green.

- London United Brass founders
- Amalgamated Brass workers.
- London United Brass finishers.
- Mathematical Institute makers

Shot makers.

Malders in the Brass workers soc.

The Societies in London.

Trade Societies.

Electrical Operators Soc.
Birmingham United Brass workers }
Who all send representatives to the
London Federal Council of Brass workers.
Besides these there are
The Nat. Society of Amalgamated Brass workers.
Lond & Prov Soc of Coppersmiths.

Coppersmiths & Braziers are a completely separate
trade to Brass workers.

Men F.W. Potter wire workers & weavers

Divisions of Business.

Wire workers.

Competition of small men.

June 1. 1894.

G.H.W.

A.B. Bond Men F.W. Potter & Co. Wireworkers
& wire weavers. Phipp Street. Great Eastern
Street. &c.

Has been 27 years in the Trade.

Wire workers }
Wire weavers } are the two distinct divisions.

Wireworkers make window guards, fire guards, screens
and all work by hand. Guards for engine
window guards, the backgrounds for colored
glasses to be fixed in for music halls &
theaters, sieves were being made while
I was there.

Nearly all work &c. sieves is done by order.
The wire used is rather thick: it is put
through a machine to be crimped which
gives the size to the meshes of the work
& then the wires are worked in by
hand. With sieve work the wire is
sent up ready woven by the weaver.
With a man can set up as a small worker

and this is the reason of the severe competition among wire workers. All that is necessary is a few yards of wire and pincers. All light good such as gas guards and common fire guards are made by these men who are homeworkers with their wives & families & then hawk round.

There are a great many of them. In factories this class of work is not touched & only wire work done for special orders.

A good wire worker would make an average of about 38/- (in the shop) throughout the year on piecework.

They have a few day workers who would put the wire up on a ship for instance.

Wire working & drawing } are the branches of the sieve making & wire work trade.

Wire weavers are those who with looms weave the wire just as a piece of silk or stuff is woven. The looms are all hand looms & the system is just the same as that in the

Earnings of good wire workers.

Gen. P. but a few day workers also

Wire weavers.

Wire weavers at work.

Earnings of weavers.

Spitalfields Silk trade. A wire weaver does his own 'warping' with the help of a boy which in the silk industry forms a different branch altogether.

At work weavers stand on one leg while with the other they press a first on one treadle, then on another which raises the 'harness' through which the wire has been threaded. The harness is composed of two bits which alternate wires have been threaded, as one is raised the shuttle is shot through with one hand & the wire pressed home with the 'hammer' (i.e.), then the other is raised the shuttle thrown back with the other hand & the wire pressed home with the 'hammer' & so on.

Wire weavers are always on piece, & earn an av of 35/- throughout the year. When only a short length of wire ~~is~~ ^{is} woven a man will make very poor money as so much of his time is taken up in

'Fat jobs'

Character of the weaving trade.

Some foreign competition.

in 'warping' but once warped it is much more paying to do a large than a small quantity. When a price is settled so much is paid for a minimum quantity of yards & if an order comes for more the same price is paid for the rest so that a man on a small job make very poor money but 'fat jobs' sometimes come when a man is on the same stuff for 2 or 3 months & he makes £2 or £3 regularly if he likes.

In weaving a sufficient quantity must always be made to cover the initial loss of time taken up in 'warping', the consequence is that there are always enormous stocks on hand of work gauge waiting to be sold. Weaving is a small trade & the demand is small but the stocks held by manufacturers are large.

There is no competition with carpet makers as they cannot afford to set up looms but there is some foreign competition in this branch. Hand looms are the rule out of a total of

Number of looms in London.

Nearly all hand looms.

London work

Hours of work.

Hard drinkers.

100 looms in London altogether only 2000 at
Men Bedford's are power looms.
Here they have 30 looms at work and at
Bedford 25 so that more than half the
numbers are confined to two houses in the
trade.

In the North of England where coal is cheaper and
where heavy wireweaving is done they do
have power looms esp at Warrington.

London work has no specialty or special lo-
cality. Weavers & workers are to be found
in every part. He wd not say the trade
was increasing or decreasing it just about
holds its own.

55 hours here are the full working week.

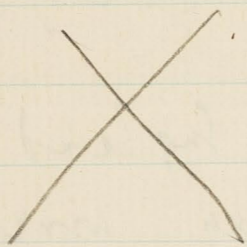
8-1 2-4.30 5-7.30. and

until 2 on Saturdays.

It is the general rule in the trade to
begin at 8 in the morning and not
earlier.

On Mondays the men are very irregular
as broken they come in. They are hard drink
but have certainly improved in the last

Never really work > 40 hrs per wk.



Not much boy labour in London.

Shifting.

Training. Apprenticeship the rule.

Settling prices for new work.

Still this is one of the great evils of the trade. There is more short time than over time but not very much of either.

It would say that no wire worker really did more than 40 hours work in the week even when there was plenty of work on hand. They generally take the opportunity of there being much work to stay away & when there is little they come in punctually.

In Birmingham there is much boy work but in London the Trade Society which is powerful will not allow it.

There is not much shifting. Workers shift more than weavers but not to any great extent.

Apprenticeship for 7 years is strictly kept to among weavers but among workers owing to their being less strict so many outside workers they are much less strict. In the better shops Apprenticeship is the rule for both classes.

Prices for new work are settled by calling a shop meeting: master & man generally

Number of shops in London.

We not employ a man who can't
earn 30/- per wk.

Special season demands.

Wire drawing.

agreed after a good deal of discussion & an hour will often be wasted in this way but the men much prefer piecework & he does not see any prospect of their ever asking for daywork wages.

There are no fair sized shops in London altg. - (others employing he wd say 100 weavers and 200 300 wireworkers.

There is no trade price list. Each shop has its own methods and different prices for work.

Here he wd not employ a man a man who could not make 30/- per week. but there must be many in the trade making less than this amount.

It is not a season trade but there are special demands in special seasons eg. horticultural work in spring & figuards in winter
Wire drawing. They draw their own fine wire buying coarse wire. This is a branch of the workers trade as is stove making.

Wire when drawn is oiled & spring. It is bound up in iron plate & put over a charcoal

All busy & slack together.

fire where all the life is taken out of it.
Then it is washed in dilute acid & beaten
against a stone when it becomes quite
soft & is fit for use in the loom.

Not much wire is drawn in London.

One house is not often busy while another is
slack the rule is for all to be busy &
slack together.

Overtime is only necessary on such a job as when a
ship is being wired & wanting to catch a tide.
Very seldom have any night jobs.

J.P.M. small master wire worker.

His history

Piecework trade

Price list

Earnings.

June 4th.

S.H.W.

J.K. Pitt. 204 Kingsland Road. N. Small master wire worker.

He been a small master for 20 years or so. before that he was foreman to one of the largest firms. Is now 54 years old & just as capable of work as ever he was. Thinks it is a trade at which a man can get a very fair living. Most men are on piecework at so much the square foot.

Says there is a recognized piece price for most kinds of work which the men know well enough though the master may not.

A good man on piece work would average 40/- per week on a fat job he wd make a little more some times a good deal more.

The worst men in the trade make as little as 25/- Spratts (the dog biscuit makers) who also

make her rattle pens get men as low as 24/-
but nobody would think of going to them
unless they had failed to get a job in
every other shop.

An average man would make about 30/- to 35/-.

Now they are the best making seed
guards and garden wire work. In the
Autumn (Aug & Sep) they are slackest.
In winter he makes skylight & window
guards.

It is a skilled trade for you must use your head
a good deal in working out your pattern
& setting your work to them.

He employs one boy sometimes when very busy
an odd man or two. You cannot make
for stock as nearly all orders are for
something special.

Wearers are only in big shops: small men
are only wireworkers: it requires so much
capital to set up a loom that a small
man cannot do it. There are a great many who
make so called wire baskets but he does
not count them as real wire workers.

Prices.

Skilled work.

Small men.

No shifting

Respectable lot of men.

Training

1891. was a poor year 92.93 not so bad at least he had very few men round to him looking for work. This was rather the way in which he could judge of the business generally. Himself he was pretty regular.

Men do not shift much. In a firm such as Potter which the tip top firm of the trade a man regarded a situation there as one for life. advised me to go there & mention his name to the foreman who knew him & could tell me more about the habits of the men.

As far as he knew they were a pretty respectable lot & never had been addicted to drink when he was a journeyman. Since he had become a master he knew very little about the men.

Would not say there were more than 8 others whom he would recognize as small masters with workers.

Apprenticeship for 7 yrs is the proper way of learning the trade but among workmen boys pick it up & become good workers and are often not apprenticed at all.

Messrs Farniloe. Lead Manufacturers.

What they make.

Home of lead.

The Desilverizer.

London visits with Newcastle.

June 5th

S. H. W.

George Farniloe. 34 St John St Smithfield. &c.
of the firm of G Farniloe & Sons.
Works. Limehouse. &c.

Manufacturers of Chemical lead, sheet lead, lead
pipe, pot pipe, barrelling, Composition Gas pipe
lead lined block tin pipe, Tin pipe, lead
pipe waxed with tin, window lead, laminated
lead. Incurdible Tea lead. Pumps, solder.
Lead waders, lead shot.

Lead comes principally from the Broken Hill mine
in Australia & Spain. Spain used to
be the chief seat for pig lead but now
Australia has taken the lead.

Lead comes in the form of pigs. It is generally
mixed with silver & is therefore sent to
the desilverizer (see a sep branch) to have
this taken out.

London is nearly the largest lead (ie blue lead) centre
in England. Newcastle on Tyne used to be

an industry of large factories.

Other Houses.

Branches of business.

Boys on Tin lead.

but the center still is for white lead but for blue lead London is running her lead.

Farniloe employs over 100 men at Limehouse he is the second largest house in London.

It is an industry of large factories - there are no small men or home workers.

F. A. Clark & Co. Marlboro Wharf, St. James's Park, City, London, City Lead Works, Southwark Bridge, Walker, Parker & Co. Belvedere Rd. St. are among the larger firms.

The lead arrives in pipes.

The branches of the business are.

Lead rolling.

Lead pipe making by hydraulic pressure.

Tin lead making.

Tin lead is much made by boys as it is light work.

It is really machine work. The men stay in one department & do not shift.

It cannot be called skilled.

The men are well paid but he could not give any particulars as in the business at Limehouse his relations to Farniloe were

No seasons.

Course of Trade.

concerned.

There are no regular seasons. The two chief things they make are sheet lead for roofing and lead pipes.

1889 was a very good year. Since then lead manufactures profits have been cut & cut & now the workman gets more than his fair share he wd say.

1893 & 94. very bad years.

Wd prefer I did not mention my having seen him if I go down to the other works.

Mr Chatterton. Lead pipe maker.

Chief branches of the London
Trade.

Tea lead rolling.

June 6th

C.H.D.

Messrs Chatterton & Co. Lead pipe makers.
Bridge Wharf. Caladonian Road. N.

Mr Chatterton is on the London County Council
he is the smallest lead pipe maker in
London & employs 20 men.

Lead Pipe making }
Sheet lead rolling } as the three most im-
portant branches of the trade
Shot & Bullet mfg } in London.

There are one or two desilverizers and smelters
Tea lead rolling is a branch of sheet lead rolling
since Indian tea has become such a
large branch of the Tea trade, lead has
been rolled in England & sent out to
India & also to China. In China the old
way was to make sheet lead by castings
between two heavy stones in some very
ingenious way.

Australia & Spain are the chief sources of lead

Lead brought over as ships ballast.

No seasons.

Second class labourers employed.

Hours of work.

which come chiefly as ships ballast. In Spain a great deal is shipped in the boats which bring over the oranges. Lead at the bottom & oranges at the top. Some ships even pay to have the lead given them as ballast. Hence the price of lead has fallen very rapidly in late years.

Australia sends from the Broken Hill mines about 1000 tons a week.

In the trade as a whole there are no seasons for lead pipes ^{work} they are busiest in the Autumn when the builders are ready for them & sleekest in the winter unless it be a very hard frost & pipes burst in every direction as in 1891. Then they were very busy indeed.

The men employed are second class labourers, for a full week of 52 hours beginning at 8 in the morning.

The men work from 8 until 6.30 on Monday, Tu. Wed. Th. & until 6 on Fridays. Those who are not in the mills work on Sat until 2.

Piece versus Time work

Effect of a reduction of hours.

Cases in which shorter hours
produce same quantity of work.

Some are on time. others on Piece work.
he is going to have them all on P. soon,
'There is always a certain reserve of force
in every working man which can only
be tapped by piece work'. This he found
when business was slack when he reduced
the hours of both classes of his men.
He found the pieceworkers turned out very
nearly the same amount of work in less
hours than ^{as} in the longer ones — They
used to work 57 hrs & 59 hrs —
Therefore he called his men together & told
them they need not come in until they
after their breakfast i.e. at 8 instead
of 6.30. That he wd pay them the same rates
as before.

The mill men do not come in at all on Saturdays
because it is not worth while to light the
fires for them

The output of work ~~is~~ is almost the same in the
shorter as in the longer week because
he uses 'intermittent machines' i.e. these
machines are not in use producing new

T & P.

Earnings.

only one 1 on one occasion only.
ordinarily run for 18/ to 23/-

Overtime rate.

No dinner hour.

Drink.

work the whole time. His men therefore managed to save a minute or two by being careful to heat the lead to the proper heat at once & not wasting any time in letting it cool or carrying it to the pipe ^{mills} presses. Hence the output remained at the same level. The quality is almost the same, perhaps not quite so good as under time work but the machines leave very little opening for difference in quality.

He showed the wage book with men earning from ~~35/-~~ 35/- to 28/- for a full weeks work. a great many did not ever make a full week & 18/- & 19/- & less were of common occurrence. He said he paid overtime rates of 5^d & 6^d an hour for over 52 hours.

They have no dinner hour. two men are on each machine & when one man eats the other manages the machine. A great many eat in the workshop. He allows beer in at stated hours. Says men will always spend all their savings

Effect of Trade Unions.

L. County Council.

or beer. No working man looks beyond pay day. He can almost tell the day of the week by the size of the cans which come in. Does not believe in a living wage, it sounds very well but business must be regulated by supply & demand: who looks after the master if he does not make a living profit? men can quite well look after himself. Heed as to Trade Unions in the branch. What these Societies do is to look after the young men & let the old go to the wall. Therefore pension question is now coming to the fore. A young man or strong one is quite worth 6^s but an older one past 40 is not. Trade Unionism has its head on the neck of the London County Council but even the Council is not such a fool as to pay higher prices without seeing that they get a great amount of work out of those whom they employ so that a man at a certain price must do a given amount of foot pounds of work otherwise the LCC will have nothing to say to him.

Unhealthiness.

Small men less liable to the poison.

Course of trade.

There is no training necessary for the men
the foreman shows a new man what to do
He picks it up in a few days.

Blue lead is not so poisonous as white lead,
though the men do sometimes have colic
& a 'dropped hand'.

He has two men who have been with him
18 & 20 yrs respectively.

He will never take on a big tall man: does not
know if big men have bigger entrails but
they are certainly more liable to colic.

It varies among shot men: some men are more
disposed than others to the poison. Those dis-
posed to be ill are given a sovereign & told
to be off. The men don't take oil of vitriol to
extract the lead from the system & let it
pass out again etc in very hot summer
time. They seem to be pretty careful about
washing their hands before eating.

He takes off the old lead which flies about
is the most dangerous part. The men are
all pale but he wd not say unhealthy.

1891 was a good year. 1893. bad & not much better now.

Lead burning.

Lead roasting.

A lead burner is really part of the plumbers trade. is skilled work. Very few in London. Is only necessary when a lead cistern say for sulphuric acid must be soldered on with pure lead & with no admixture of alloy. Then a thin ribbon of lead is taken and is melted on to the joint with a blow pipe. This is called lead burning.

Lead roasting & fume roasting is not done in London. Bristol is the great place both for this & smelting.

In slack times the work is shared; the whole staff work shorter hours.

He showed the lead pipes being made by hydraulic pressure. Molten lead poured into press allowed to set & then shoved up all round a core: comes out pipe the other end.

He offered any further information in his power & gave introduction to a lead smelter & to Walker, Parker & Co.

Alfred Hughes art metal worker.

Brass casting = moulding.

Door plate engraving.

Tubes wire from Bram.

Burnisher's work.

June 7th

S.H.W.

Alfred Hughes metal worker. 4 Brewery Street
Wandsworth road. S.W.

Art metal workers. London & Bram are the two
chief centres.

Brass casting = Brass moulding in Bram it is
generally said that iron is moulded while
brass is cast. In London the terms are used
indifferently.

Door plate engraving - a good many of the large
shop plates are cast in London.
Door plate & monumental plates are
a good deal in London. The medieval metal
workers all do the monumental brass &
it is better paid than the door & shop
plate.

Drawn wire, rolled metal, tubes, come nearly
all from Birmingham.

Burnishing in brass is done with a steel stool both
on the lathe & in the vice. Some big
men in London & Bram.

Medieval metal workers.

Burnishing, Bronzing & Dipping.

Polishing.

Medieval metal workers. a number of these shops in London. means work that is usually made for churches. This work is not burnished but polished.

- v. Burnishing
 - vi. Bronzing
 - vii. Dipping
- go together, is the work of one man. it is a finishing process instead of polishing. Bronzing means taking brass & altering the colour of the surface by means of ^{acids} chemicals. After the metal has been ~~partly~~ smooth filed or turned is finished or dressed it is ^{further} finished either by being finished polished or burnished or bronzed.

Polishing is done with leather polishing pads & sand & then with felt & polishing lime then cleansed ~~with~~ from all grease by benzoline & then finished on Swan's down mops with a little lime.

Bronzing. steel bruing. florentine or red bronze produced by diff. chemicals.

Dipping is merely cleansing the surface of the metal by immersion in aqua fortis. it is one of the processes of bruing.

Metal Annealing

Metal platers.

Spinner.

Seasons.

The metal rollers are really metal annealers which means merely heating the metal to a dull red & then letting it cool when it is quite soft

Metal chasers.

Engravers.
Purifiers } are both silver & brass
Piercer }
Plater } are usually done by one man.

Suggs plate both white metal & brass: most chalices & altar plate, candlesticks & crosses are plated in this way.

Metal Rubber. a Rubber is a large square file means a man who prepares memorial plates for the engraver.

Metal spinner. Still in Station Garden.

Metal is spun up for lamps by Suggs. Chandeliers & brackets are mostly Brown work.

Busy season begins toward end of Oct.

Nov. Dec. Jan & Feb. in the ordinary chandeliers & open fittings.

Medieval work & church work come in just Ecclesiastical brasswork before Easter

Difference between Brass workers
and brass finishers

Apprenticeship dying

Some T to some P.

Suggs like much of the brass trade
is on a daywork piecework system.

Piecemasters v daywork.

v before Xmas. for church feasts.
Brass workers treat wrought brass, i.e. a
worker in sheet & drawn metal.
Brass finishers, ~~process~~ things to which the
form has already been given by casting.
where workers give the form.

Apprenticeship is dying out, where there are so
called Apps they are not indentured
and picks it up as it can.

Diff shops have diff system: some time &
some piece.

Suggs (where he works) is on a daywork
piecework system. i.e. each is rated at
so much per hr. & works on job at piece
price. At Suggs there is often a deficit
at the end of the job. When there is a
plus Sugg says he must cut it down
& cuts it down according to his daywork
rate.

Sometimes there are piecemasters who take the work
from the firm & employ men at daywork rates
as you see at Atterley, Benham & Frowd,
(who have two shops, one a daywork one &
one a piecemaster and)

Shifting from shop to shop.

Lacquering.

Hours.

Earnings.

Regularity.

Wide area makes it hard
for men to find work.

Drink.

A piecemaster is not always but should be a practical
man himself.

Men shift a good deal from shop to shop - but not
to different branches of the trade.

Lacquering is better done by women, must have a
light touch.

Hours vary from 50 to 54. not more. taking
the trade in London & throughout England.

Metal workers good man 10/- 11/- but exceptional
fair average skilled man gets 9/- 10/- the leading
gen speaking the price in London for the
majority of men is 8/- & 8 1/2/-.

6 months work is very uncertain when possibly you
won't earn more than 1/2 a week. as in
the summer months. There are 1000⁰ walking
about London now.

Shops are scattered over such a wide area that
a man has to travel very far if he gets
a new job.

Work begins about 8 AM the time
stops gen at 1 on Saturdays.

Gen speaking brass workers are steadier than they
used to be: he is a total abstainer, it was

Polishes.

Burnishes.

Employment of boys.

Have been very awkward to be a total abstain some
2 yrs ago. Now some makes a remark.
Polishes, dirty work, decent men won't do it
if they can help.

\$1.80 for best brass polishes

Burnishes 8¢ 9¢ 10¢ depending.

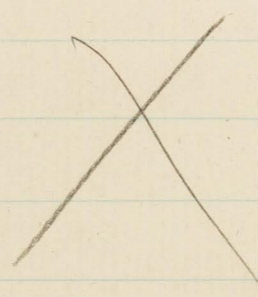
In brass work not many boys, but it is a
standard complaint in the electric brass.
fittings in switches, bells, telephones.

C. H. Quinta. London Prov Soc of Coppersmiths

Piecework in Breweries

But otherwise all time work.

Numbers in London.



June 7th

C. H. Quinta 5-Lockhall Lane, Clapham.
London & Provincial Soc. of Coppersmiths.

In Breweries & Distilleries the a portion of the work
such as coppers, stills, hop back,
piece work prevails.
are now trying to abol. P altogether.

Railway shops all T (tho' the others in the
shop.
said
will engineering firm such as Mandlows, Humphreys
Pears.

East End shops such as Blundells, Brockleys,
Cassid & Rogers are all time.

They consider P is detrimental to the public eq.
Explosion in 'Elba' killed 10 men. defect in
pipe made on P.

Numbers both in rat Soc are not > 450.
Coppersmiths all over London. Shops rather
hang round the river.
Ramsden, Bennett & Shears ^{highly} Warsom City rd.

Dirty work at breweries.

Hours.

Systematic OT.

Greatest Employer.

Braziers work.

Piece masters in Brewery line.

Is nothing else but brewery & distillery which is the best paid part: it is very dirty work. & on a dirty job you get 1/6 a day extra are trying to change the name from 'bit' money to travelling money.

54 full hours.

Much OT in Brewery. Marine repairing, & distiller. Always & seldom OT.

Copper pipes on engines are all attended to by the Maudslays & Shropshire often you work 2 hours.

OT as the regular they paying T & 1/4.

T & 1/2 is pd after 2 hrs.

Marine employ the greatest no. of Coppersmiths.

Then the Breweries.

Braziers is entirely P. have a distinct Soc.

called the Braziers Soc. they do jelly moulds stew pans.

Coppersmiths do a little of it.

Braziers is a ^{higher} finer class of work - Braziers & Coppersmiths compare something like watchmakers & clockmakers.

In Brewery line few piece masters who take job at a price ^{some pay} of daywork piecework in. but there are a few of them. preceding interview

Apprentices

3 to one man.

is this possible?

Seasons

Marine & Brewery is irregular work.

Very few small men.

in one shop
Apprentices must serve 5 yrs. (need not be in-
-vented)

3 allowed to 1 man.

where shops have only 1 man 1 boy allowed.

Rlug is the poorest part of the trade ∴ they
have the most holidays

No season Rlug work.

Brewers busy in winter time ∴ then they can
span the coppers for repairs.

When they are mostly out of work is in the marine
repairing shops & at the Brewery ∴ it is
such a season trade & men shift much fr
shop to shop.

Marine & Brewery are the worst for irregularity and
drink ∴ otherwise the men are steady &
not put it down as a drinking trade.

Very few small men among coppersmiths but more
among braziers.

Only know 2 small men coppersmiths who
make life boat cases for Forrest's life
boats & the other helmets & diving app.

Ships copper bottoms are always put on by shipwrights.
now done chiefly with Muntz's metal.

Out of work money paid by the Soc.

Wages.

Notice of leaving

Point of contact between
Coppersmiths & Braziers.

1890.			
1891.	£303	out of work paid for total no of	365 mth
1892.	£261		360
1893.	203.9.6		365

Braziers soc. is under the hundred.

Average wages 6/- per day. wont work less than the
Rly & Marine 38/- per wk.

As a rule a weeks notice of leaving is required: in small
shops it is only 1 hrs notice.

Copper rails at Patney in Shoe lane (Farrington works
Copper plate makers. is a special branch but not
much in London.

Copper rollers ^{makers} are machine makers work in Leeds
& Manchester.

Pan smith = Braziers.

Sugar pans, coolers, point of contact between
coppersmiths & braziers.

Worm maker: distillery work.

Most of pipes ordered from Brun: annealed in
the fire then filled with iron or lead & then bent to shape.

The At Copper workers, as you called metal workers
+ ~~are~~^{are} braziers rather than coppersmiths.

Bullivant & Co wire rope &

Numbers employed

Australian custom

Skill required

June 7th

G.H.D.

Palham Bullivant, of the firm Bullivant & Co. City office 72 Greenhead Mark Lane. Works. West Ferry Road Middlesbrough. Wire rope & retting makers.

Employs from 250 to 300 men.

In very busy years he has worked double shifts night & day. For 3 years he turned out 200 miles a week. Australia was his chief customer for wire retting to keep out the rabbits. He used to get an order for 1000 miles at a time. The colonial governments would give squatters credit and all orders used to come to England. Now the industry has practically died with the decline in Australian credit.

There is not much skill in the work. It can be learnt in 2 or 3 months. They employ a great many boys. The difficulty is to get rid of them when they begin

No regular training

Wire rope making.

Wire rope makers T.O.

Drink.

to ask for mens wages. It does not pay to keep them on as men when boys can do the work equally well.

There is no regular system of training men & boys work under a foreman & then soon pick it up.

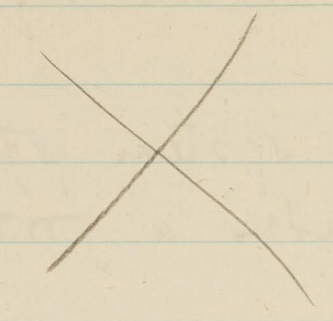
Wire rope making requires rather more skill than wire net making. The man who receives the rope from the machine has to tuck in the ends of wire and braze them on to fresh bits.

This is by far the largest shop in London.

There is another small one named Binks but he is very small & will probably soon be bought up by themselves.

The men have formed a trades union composed of men employed in their shops. A deputation came to him once & he asked how many years the seven who came had been with him. They had all been more than 20 years.

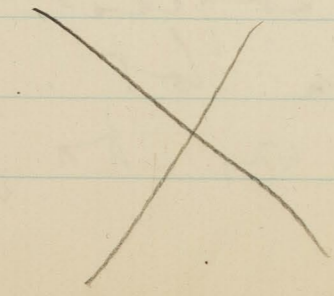
They are a drunken lot. Not one could be trusted to send a way to a job with money.



Shifting.

Riggers.

Earnings.



in his pocket, he wd be sure to go on the
spree before going to his work. When
they are very busy the men will stay out
drinking knowing that they are certain
of a job when ever they like to turn up
again.

They gen go to sea on leaving the factory. Then
come back & get work as lockers or riggers.

Wire rope has entirely taken the place of
hempen & the hempen riggers though they
are willing to & try to get wire rope
rigging to do yet they are not so
good at it a wire rope makers & don't
understand the tucking in & braiding
of broken strands.

They have no seasons. Summer is rather busier
for garden netting: wire rope goes on all
through the year.

All work is piecework.

Fitters 35/-

Good men 30/- to 35/-

Ordinary 24/- to 28/- does not pay to have a
man who makes < 24/-

Hours.

full hours. 60 per week.
 A great deal of wire netting esp for garden
 work is made a Lincoln & Norwich(?)
 The men had started a Trade Society composed
 of members working for him. He told
 them he should now treat them strictly
 on business terms & that no allowance
 would be made for individual men

Mess Walker Parker & Co. Lead.

Numbers employed.

Earnings.

Season.

Manufacture of shot.

June 8th

S.H.W.

Mess Walker Parker & Co. Belvedere Road Lambeth. SE. Lead pipes. Shot & sheet lead for roofing & flooring on an introduction to the Secretary of the Company (Mr. Stracey) from Mr. Chatterton

They employ 90 men 3 women bag making for the shot bags, & 5 boys making a total of 98 persons.

All work is piecework. Leading hand earn from 36/- to 43/- when they are very busy ordinary men between 28/- & 30/- & labourers 24/-.

Autumn is the busiest season for spotting shot in 1893. In the autumn month they made 2000 tons.

Shot is made by melting lead into ingots with arsenic. The arsenic makes the drops of lead fly apart instead of falling in one blob. The ingots are then taken to the top of the shot tower & there

Manufacture of shot.

Sheet lead.

96.

melted & then allowed to drop into tubs of water below, they are then put in a long sifter of wire gauze & fall through at different places according to their sizes. Some times the shot do not fall clean but are joined together. These are separated by being ^{falling} ~~being~~ fed from the sift along an inclined scoop over a tub divided into two portions. The round shot gets up space over the scoop & take a good leap into the further partition while the inferior shot rolls quickly off into the nearer one.

Large shot & bullets are cast & then put in a revolving barrel to take of the burrs & cover them with black lead. The small shot also goes into revolving barrels to be polished & coated with black lead.

Sheet lead is first of all cast in a large thick sheet & then gradually rolled out to the desired thickness.

The lead comes from Australia & Spain in the

Fumes.

Men's health.

Regular employment.

No regular training

largest quantities. England now produces very little.

A great deal of old lead piping & tea lead is melted. The fumes are poisonous & as the lead was thrown in were certainly very insufficiently carried off by the chimney over the melting pot.

Some men he said were predisposed to lead poisoning & these he at once turned off, others seemed entirely unaffected. He had not noticed that any tall men were more particularly liable but now that he came to think of it they had no tall men in their employ.

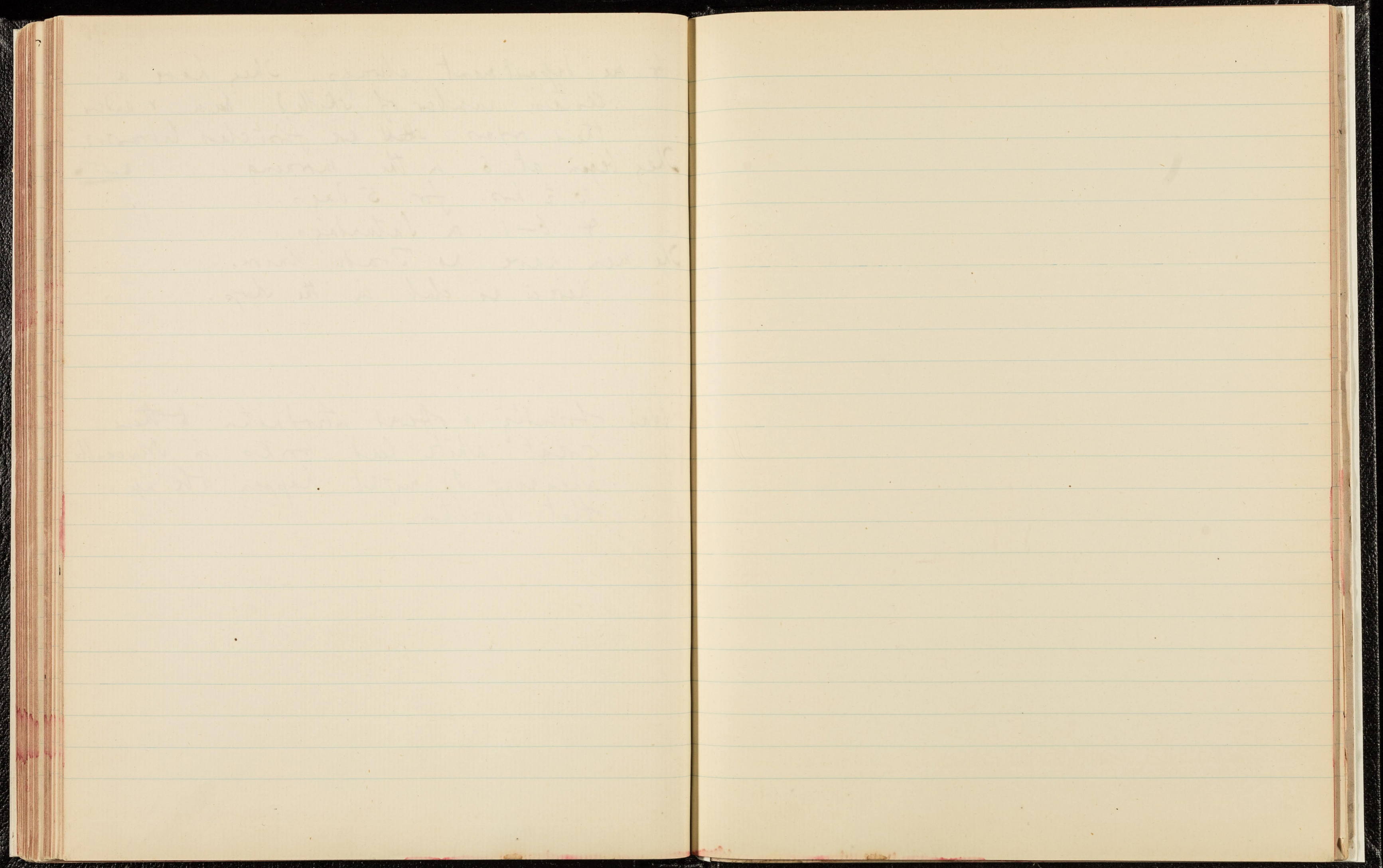
Employment is very regular they only vary 5 or 6 men throughout the year. There are seasons for the dealers but these do not affect them. The middlemen act as equalisers, they must hold a stock so that any sudden demand on the manufacturer is very improbable.

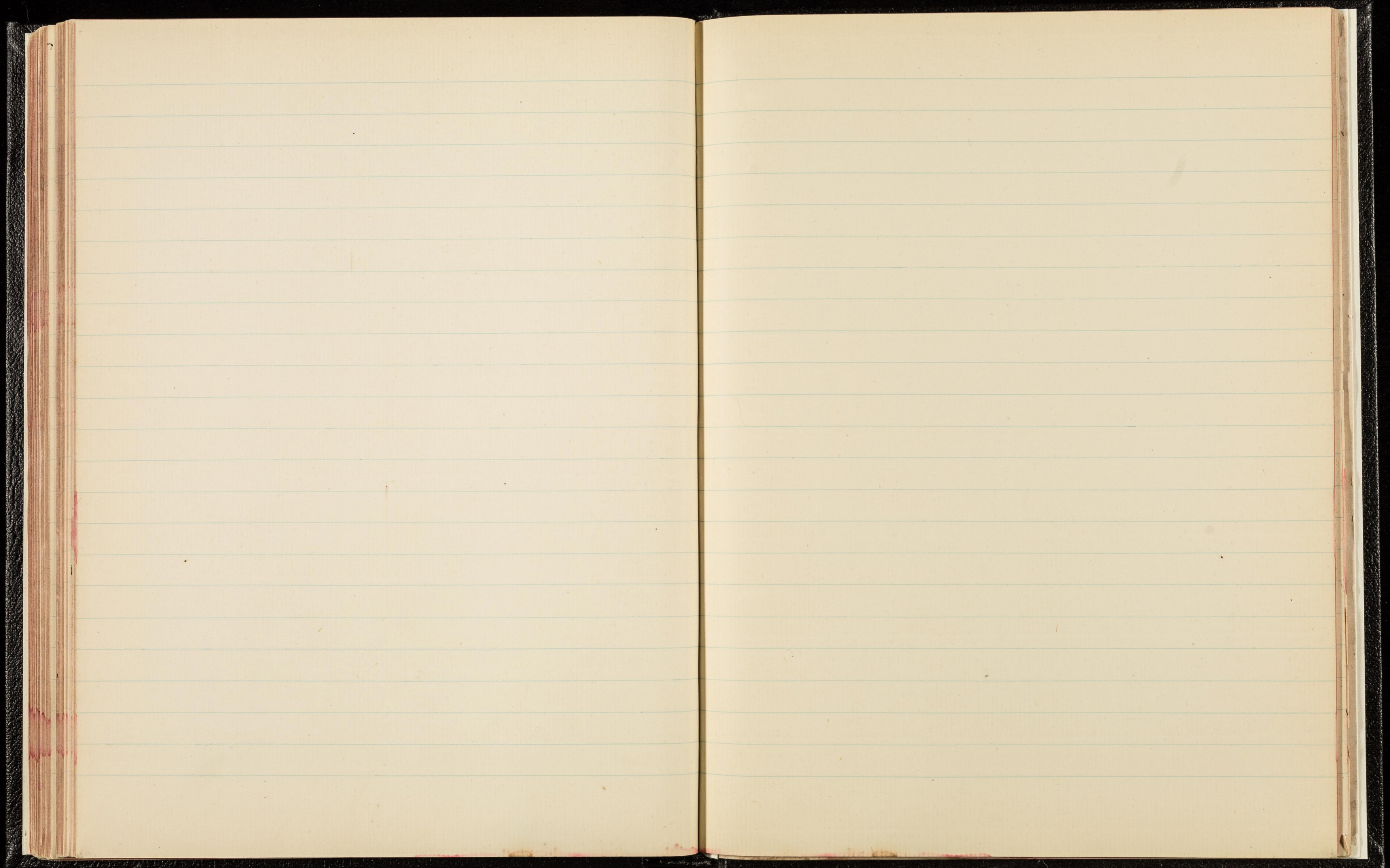
There is no regular training. Men come in and learn in 3 or four weeks & are kept

Hours.

to one department always. They have a certain number of skilled men & under their orders ~~still~~ are first class labourers. They begin at 6 in the morning. 10 1/2 hrs. for 5 days. & 6-1 on Saturdays. The men have no Trade Union. There is no club in the shops.

Was friendly & offers introduction to their great white lead works in Newcastle whenever I might happen to be up in that direction.





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Is there an ^{beer} off license at the end of Heston Rd
_____ a ^{pub} on S side of Wick Rd bet Heston & Brookfield Rds
_____ off beer next to pub in Churchill Rd.

54. Look up exact position of changes. ✓
15
17. _____ Cottage St ✓
203 _____ Jark H. St bet Stockmar & Chalgreen ✓

