Brewers, ...

Sec. 56.

Brewers.

2nd Series. Vol. III

Part II. Chap. II.

R COLL U.
B122

Brewers etc.

Old section 56.

Census Numeration.	Females all ages	Males -19	Males 20-54	Males 55-	Total
Brewer, Maltster	21	207	2841	258	3,327.

Those employed by Brewers are mostly in the prime of life.

Distribution.

East	North	West	South	Total
1046	716	993	1641	4.396 *

Enumeration by Families

Sex	Male	2779	Heads of families 2,803 (Includes widows & unmarried women)
	Female	24	
Birth place	In London	397 / 1093	
	Out of London	617 / 1710	
Industrial status	Employers	77 / 215	
	Employed	91 / 2540	
	Neither	27 / 48	

Total Population Concerned.

In family	Heads	Other occupied	Unoccupied	Servants	Total
Total	2803	2458	7600	505	13,366
Average	1	.88	2.71	.18	4.77

*. This includes 1.069 Ginger beer & Soda water makers.

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Name of Brewer.	Address.	Page.
Persons included by Census under Brewer.		1-3.
Concerning the manufacture of Beer		5-15.
Mr. Charrington & Co.	Mile End Rd. Whitechapel	17-25
Mr. Barclay & Perkins	Park St. Southwark.	27-35
Mr. Combe & Co.	Castle St. Long Acre.	37-41
Mr. Reid & Co.	Brewhouse Clerkenwell Rd.	43-49
Mr. Mann, Crossman & Paulin	Mile End Road.	51-63
Mr. Charrington	Mile End.	65-67.
Mr. Taylor Walker & Co.	Limehouse.	69-79.
Mr. Smith Garrett & Co.	Bow Brewery Bow Bridge.	81-85.
Truman Hanbury & Buxton.	Eagle Brewery Spitalfields.	87-91
Barclay & Perkins.	Park St. Southwark.	93-103.
Extracts from Inland Revenue Report		105.
A.W. Freeborn.	200 Globe Rd. E.	107-
J. Pike	Brewers Engineer	129.
Mr. Henry & Co.	Dott St. Rd.	137

[ii]

Persons included in Census Dictionary under —

Maltster.

Brewer.

Sep. 2nd 1895.

Included under Maltster & Brewer in the Census Dictionary are — (vid. Order. 16. sub. order 2).

Maltster. Malting:
Barley Room man.
Malt crusher
Malt roaster.
Malt maker.
Malt loader.
Malt man.
Malt miller.
Malt mill man.
Kiln man.
Tun man.

Brewer.
Herb beer maker.
Botanic Brewer.
Glucose Brewer.
Stockland beer mfr.
Barm, Yeast, Maker Dealer Importer.

Brewing.

Brewing.

Fermenter.
Dunner
Barm Presser.
Hop Presser.
Union Room Stand.
Hop Room Stand.
Racker
Grinder (malt)
Maltsman.
Grainer.
Grainman.
Vatman.
Marker.
Brasher-out.
Runner-in.
Sideman.
Stower.
Treater.
Loader.
Number taker.
Vatter.
Ale Tester.
Labourer.
Cask Smeller.

The original makers of Beer.

'Bouzy'

Beginnings of Brewing in England.

Concerning the manufacture of Beer. Taken from 'Noted Breweries in England & Ireland' by Fred Bennett. Printed & pub. by Sir J. Causton & Sons. recommended by Mr. E. Buxton.

p. vi. 'As far as it is at present known, ale was first invented in Egypt, where the natives to this day make a similar liquor by pouring hot water on ground barley, which ferments the next day & is ~~ground~~ drank the day after.'

p. vii. 'They called it Bouzy - The English word to Bouze or Boose is derived from the above word - which originally signified 'to drink ale heartily.'"

" 'The date of the introduction of beer into England is so remote that it cannot be traced, but this we know, that in the reign of Edward the Confessor, it formed the chief drink at a Royal Banquet & in the days of Hy III. 1266, a statute was passed establishing a graduated scale for the price of ale throughout the kingdom .... But it was not until the reign of Anne that brewing as a trade began to flourish

The nature of malt.

Hops.

Breweries in London in 1585.

Their output.

Output of 12 principal London Breweries. 1836.

p. IX. 'Beer, ale & porter are all manufactured from malt that has been made from the parched grain of germinated barley.... There are several kinds of malt used by brewers; viz the pale, the coloured, crystallised brown & black – the 3 last named are chiefly used by brewers of porter & stout.....

p. X. Next in importance is the hop' whose active ingredients are, 'a volatile narcotic oil or aromatic resin called lupuline – a bitter principle & a certain amount of tannin which last helps to clarify the beer.

p XIII. 'From information collected by Stowe, it appears that in the year 1585 there were about 26 breweries in the city of London, suburbs & Westminster; one half owned by foreigners the others by English, who brewed among them 648,960 barrels of beer which they sent to their customers in open barrels before the process of fermentation was completed.

p XIV. Coming down to the year 1836, the 12 principal brewers in London brewed no less than 2.119.447 barrels of beer'

The Beer tax. (1880)

The amounts paid 1880 – 1886.

The origin of the word 'Entire'.

p. xiv. The beer duty is a tax of 6/3 per barrel
xv. ie a barrel of beer of a specific gravity of 1.057 degrees with an allowance of 60 degrees for waste & the gravity is ascertained by the saccharometer. 42 pounds weight of malt or corn is equivalent to a bushel of malt, & 2 bushels of malt produces 36 gallons of wort at a gravity of 1.057 degrees. Beer duty dates from 1880 & the following was the amount paid to Govt during the years mentioned.

1880 (five months only)	3,482,000
1881-2	8,531,000
1882-3	8,400,000
1883-4	8,488,000
1884-5	8,545,000.
1885-6	8,539,000.

p. 265. re Barclay & Perkins 'Entire'. 'In bygone days, beer retailers were wont to sell a kind of liquor called "half & half", that is half ale & half two-penny, which had to be drawn from two casks; afterwards a taste was acquired for "three-thread" a compound of ale beer & two pennyn which the retailer was

Process of malting p.10.

Steeping "They filled up a darksome pot
With water to the brim
They heaved in John Barleycorn
Flooring. There let him sink or swim./
"They laid him out upon the floor
To work him further woe
And still as signs of life appeared
They tossed him to & fro,/
"They wasted, o'er a scorching flame
The marrow of his bones;
But a miller used him worst of all
For he crushed him twixt two stones"
Burns.

was necessitated to draw from 3 casks; a process so troublesome that it led to the brewing of a kind of beer which should combine the qualities of the 3 sorts. & which being drawn entirely from one cask obtained the name of 'entire butt beer.'

The process of malting is carried on from Sep. to May. inclusive. It is divided into 3 stages.
1. Steeping 2). Flooring 3). Kilndrying.

Steeping. Barley thrown into steep half full of water. Good barley sinks. The light float & is skimmed off. When properly soaked & swollen
Flooring. the water is drained off & the malt as it is now called is spread out on the a con-crete floor where it is constantly turned. It is at this stage that the skill & attention of the maltster are in greatest request to ren-der the germination ~~greatest~~ equal in every corn. The temperature of the floor begins at 60. rises to 65. water sprinkled over the grain

Kiln drying.

In about 9 or 10 days the germ, called the acrospire grows nearly to the end of the grain. All vegetable life must now be extinguished & this is done by Kiln drying. & brought to a pale amber colour in about 4 days.

The next process is the grinding or crushing of the malt previous to mashing.

Mess. Charrington.

Employ just under 400

Different men employed with wages.

Sep. 6th 1895. G.H.D.

Messr Charrington & Co. Brewers. Mile End Rd
Whitechapel.
Interviewed 4 partners.

They employ rather under 400 regular men.
In busy times they add about 20 odd men more.
The different men employed & their positions are as under.

Cellar men.	25/.	27/.	30/-	foremen 42/.
Fining House	26/- to 32/.			
Stable men.	27/. to 40/.			
Watchmen.	25/. to 30/6.	night watchman 40/-		
Farriers	35/- to 42/-			
Wheelwrights	36/- to 42/-			
Wheelwrights' labourers.	28/.			
Yard cleaners.	24/.			
4 Women to clean offices				
Drayman	1st class.	Febr.	40/-6	to 37/6
		Aug.	63/-	- 44/-
	2nd. class.	Febr.	34/6	. 30/6.
		Aug.	55/-	- 49/

Classes of
Men employed at Cherringtons

Draymen.	3rd class.	Feb.	33/6 to 30/-	
		Aug	41/- to 37/6.	
Odd men Draymen. who go with the Drays & by custom drive back the carts who finally rise to be full blown draymen.		Feb.	28/- to 24/-	
		Aug.	29/.	
Tun Room men.			25/- to 29/-	
2 Yeast pressers.			30/- to 40/-	Piece
Mill wrights			40/- to 52/6.	
Mill wrights labourers.			29/- to 35/6	
Mill loft men.			27/- to 30/-	
Engine Drivers.			32/- to 40/-	
" assistants			30/-	
Gasfitters			38/.	
Stokers.			25/- to 28/.	
Coppersmiths.			42/.	Time
" labourers			26/- to 28/.	
Coopers.			37/- to 46/-	Piece.
Carpenters			37/6 to 42/-	
Sawyers.			37/6.	
Carpenters labourers.			23/- to 27/.	
Bricklayers			42/- to 45/-	
" lab			26/. to 30.	

Odd men:

Regular Employment.

Hours.

Overtime.

Draymen's hours.

Pensioners & Clerks.

Besides these there are odd men taken on as occasion arises by each dept at a rather lower rate than that given above.

All men except the odd men are ~~pai~~ employed regularly throughout the year.

The Hours of work are about 10 per day excluding meal times.

Fixed wages are paid with overtime rates. nearly every man in the establishment works overtime. ~~& the~~ Overtime is general here & liked by the men.

It wd be impossible to carry on the business at all with an 8 hours day.

Draymen work very uncertain hours. They are paid piecework - i.e by the number of barrels they bring back - Some times they are not back until 3 in the morning

Draymen & Trouncers.

Drink in the Brewery.

Gin for breakfast.

morning. The Draymen drive out the full carts & the Trouncers or helpers who go with them drive back. Trouncers rise to being Draymen. They have hard work & drink a good deal. They do not as a rule live long.

Speaking generally of the men, Mr Charrington said their wages had risen very greatly in the last 30 years. prices of food & clothing had fallen. Rents had increased but not in the same ratio as wages. But the men were no better off as far as he could see.

Of his own men he said 'They are almost always destitute when they die'.

He never sees them drunk on the premises but they do seem to drink outside. Each man is given a regular allowance of beer from the brewery per diem.

They ~~were so~~ found that the Draymen had taken to drinking gin for breakfast before starting & then beer on the top of it. They now provide them with

No apprenticeship

No Trades Union.

Though there was once.

London ale for Londoners.

Men from the country.

with hot coffee in the morning before they start.

There is no system of apprenticeship to brewing. To a certain extent it is a father to son trade.

There is no Union among the men connected with brewing proper though Coopers and farriers have one. About unions or no they make no enquiries.

At the time of the Dockers Union their men were got hold of & formed a branch. One of their men was a red hot agitator: they quickly got rid of him (for other reasons as well as this) & the thing dropped.

In London the large are absorbing the small brewers. Very few small brewers are left now.

London ale for Londoners. London brews nearly all her own ale. The London Brewers have so much capital to back them that they can crush any competition.

The majority of their men are countrymen. They have 160 horses in their stables.

though lately they have had more who were London-born

Mr. Barclay & Perkins.

Numbers employed.

Comparatively few employed in the manufacture of beer.

The London Trade.

The Brewer's Court.

Sep. 9th G. H. D.

Mr. Barclay & Perkins: The Anchor Brewery Park St. Southwark. &c.
Interview with F. Bevan one of the partners.

They employ rather under 700 men and do all the work - even the house building - of the Brewery by men constantly employed on the premises. With the except. of cart & van building which is contracted for by a firm outside.

Brewing strictly speaking probably engages fewer men than any of the other departments such as coopers, draymen, engineers &c all persons who are not included by the Census under this head.

The London trade is one of large Brewers. The 12 largest form the 'Brewers Court' which is the old Brewers Company & this Court rules the trade. They would not admit any of the smaller London Brewers & there are very few of them - hardly

Increasing Consumption of light ale.

Lager Beer

Hours of work.

Men come from the country.

hardly one in London itself he would say - but several about the outskirts - A small brewer would employ not less than 50 men.

There is an increasing tendency to brew light ale owing to an increasing demand. On the other hand the demand for stout & porter is decreasing.

Lager Beer is not made except by one firm near Romford (?) To make this requires 3 times the time that ordinary ale does - The fermentation for Lager beer has to be very slow & to be retarded by ice etc.

English workman will never take up lager beer, there is a want of body in it which does not suit them.

The work begins normally at the Brewery at 6 AM & closes at 6 PM. Night shifts are worked when the beer is in course of fermentation as then the liquor has to be closely watched.

The men are nearly all countrymen. A number are welshmen & the firm has a regular connection with Wales dating back a

~~for~~

Countrymen recruit the Brewery.

Draymen. Long hours.

A sober lot of men.

a great many years – longer than he cd remember. he hinted that it might be as far back as the Thrales time.

The countrymen either have learnt in small country breweries or are taken on & soon taught by being put in gangs with others. The firm prefers men from the country as they are generally stronger in health and more industrious than Londoners.

Draymen are almost entirely countrymen. These last work irregular hours depending on the orders & the readiness of the beer. They go out accompanied by a trouncer & some times another man from the 'store gang' which they keep going to supply any occasional wants. Draymen are paid a regular wage + a certain amount depending on the number of empty casks they bring back in good condition. This is done in order to prevent the loss & spoiling of casks.

They have a very sober lot of men who are allowed a given quantity of beer at stated

No apprentices

No Trade Union

Sick Club.

Employ a Scripture Reader.

'Going on the Stage'

stated hours. The day after Bank Holiday they have all their men regularly at work. All the same Mr Beran did not much approve of Bank Holidays.

They have no apprentices anywhere. 'We will not be bothered with them'.

There is no Union among the men engaged in the Brewing Departments.

He introduced me to Mr Muggeridge who next Thursday is to conduct me round the Brewery & explain everything.

'We have no secrets anywhere, but you must not go & print that we told you all that you will see & hear'

They have a sick club. with sick & burial Benefits

They employ a Scripture Reader who visits the men in their homes & has a class in the Brewery of about 70 or 80 men.

When men are employed in the Brew house they are spoken of as 'on the stage'. New men 'go on the stage' or are put in other Dep.ts

On the Ages of Brewers.

Observations on the chart made out to distinguish Brewers, Mineral waters wpts & the mean of occupied London.

Among Brewers, there are very few employed under 20 years of age. The majority are full grown men in the prime of life between 25 & 35 (1071): there follows a drop to 750 between 35 & 45; again a drop to 518 between 55 & 65 & then a larger fall to 194 between 55 & 65

At the age of 50 the numbers employed are slightly in excess of the mean for the whole of London. But from 60 onwards the numbers are below this mean.

Mr. Combe & Co.

On the appearance of Breweries.

& of the Public House.

Sep. 10th. G.H.D. 37.

Mr. Combe & Co. Brewers. Castle Street Long Acre. Interview with two partners.

Castle Street runs parrallel with behind Long Acre on the North side. The Street is made dark by the high prison like buildings of the Brewery. It is a mean street, ill paved with rough cobbles.

– Most Breweries seem to be in mean streets cobble paved eg. Buxtons Hoares Barclays & this one – They are all solidly built of yellow brick without the slightest ornamentation. Inside there is the same solidity & uglineess. What strikes one most is the cleaness & perfect repair & orderliness of everything inside a brewery. But everywhere a parsitanic uglineess –

Outward attractiveness, brilliancy & the commanding position in the High Street are reserved for the Publican.

Mr. Combe employs about 400 men throughout the

All regular & time workers.

Brewers Hall.

Brewers compete in quality but not in price

Draymen.

the year, of these about 20 are employed in Brewing Beer. The actual manufacture of the liquor employs fewer men than any other department of the Brewery.

All these men are regular workers. When there is an extra force they work longer hours. They are paid (those employed in the Brewhouse) regular weekly wages without regard to the hours.

The engine goes on without interruption day and night with the exception of between 3 & 5 AM.

Brewer's Hall is the brewers guild. Ten of the largest brewers are now on it. They regulate the price below which no member shall sell his beer. ~~The~~ Nothing is said about the strength of the beer. Hence brewers may compete with one another in quality but not in price.

Draymen work very irregular hours. They are paid a regular weekly wage & in addition a piece rate depending on how many casks they take out & how

many

No apprentices.

Coopers v machine made casks.

many they bring back.
They have no apprentices.

It being holiday time he cd. not give me more information without seeing & consulting with the partners. The wages sheets shall be filled up in a fortnight's time. if a clerk can be sent up to do it.

They are going to ~~set up~~ use machine made casks. If the ~~brave~~ coopers had not stood out for such high wages they would not have lost the work. A machine made cask is only 4/ or 5/- cheaper than a hand made one.

Mr. Reid's

Numbers employed.

Uncertain hours.

Draymen.

System of payment.

Sep. 10. G. H. S.

C. H. Babington. Director of Mr. Reids Brewery. The Brewhouse. Clerkenwell Road &c.

Employs about 230 men.

The men in the Brewhouse are taken on at certain fixed rates. They ask for how many hours & are told 'for as many as they may be wanted for.' As a matter of fact it comes to about 8½ hours per day. The men come at 6 in the morning & go away when the work for the day is done. Often there is work on a Sunday as well

The Draymen have irregular hours. They are paid 4d. per barrel. They come at 6 & go away when they have delivered the quantity for the day.

There are 12 master draymen here who draw all the money. They employ whom they like under them. These under men are given fixed rates which Mr. B knew to

The survival of Strike pay

The London Trade.

Beer now & beer formerly.

to be 30/- per week. The 12 bagmen themselves draw ~~a fixed~~ what they like per week & then divide the surplus at the end of the year.

In April of each year each man gets "Strike pay" provided that he has a good character. This is a relic of the old system of 50 years ago when every brewer shut up from April until October. At that time it was customary to give every man some thing to tide him over the slack period when the Brewhouse was closed & work was 'struck'. This pay is still given & really is a premium or bonus on good behaviour & it is still called 'Strike' pay.

In London the large brewers tend to absorb the smaller ones. Brewers Court consists of the largest brewers who compare prices of malt etc & settle the price of beer. They also manage the various charities & companies & schools connected with the Court.

The London public in old days liked their beer a year old & you brewed one year for consumption the next. Now you brew this week for

Regular employment for all.

Brewer's Coopers.

Their character.

Men live near brew house.

for next week's consumption.

All the men are regularly employed at weekly wages with the exception of Coopers & drag men. Employment for all is regular throughout the year.

The Coopers are regular brewers coopers & Reids pay them what every the Master Coopers Assoc (of which they are not members) decides that should be paid. They are rather a rough & a very independent set of men. Coopers come from a distance & generally bring their meals with them. The majority live in the East End. ~~Forcy~~ Machine made casks are coming in & work for the brewers' Coopers becomes less every year. Machine casks are as good & probably will be better than hand made ones. The Cooper in the future will be employed on repair work only.

Many of their men live in Buildings built by the firm in the neighbourhood of the firm. Those in the Brewhouse have to, as they may be called up in the night for fire or for

Country versus townsmen.

Beer ad lib

But no drunkenness.

the process of 'cleansing' which occurs as soon as fermentation has gone sufficiently far.
These men get their rooms at a less price than they would have to pay if they did not belong to the firm.

Countrymen are always preferred to townsmen. Day men are invariably countrymen.
Men from the country are nearly always steadier than town bred ones. They do not know their way about or how to amuse themselves in town as townsmen do to the detriment of their work. A countryman comes up & as soon as he is in his place marries & settles down quietly.

Each man can have as much beer as he likes & when he likes. If they were not allowed it they would take it so that it is better to allow it them.

But although the men hold a good deal a case of drunkenness is very rare.

He will fill up the detailed wages sheets & would prefer to send written answers to written questions which I accordingly gave him.

Mr. Mann Crossman & Co.

Numbers employed.

Hours.

Yardmen & Brewhouse men

Beer allowance.

Sep. 11th G. H. D.

J. W. Thorpe. manager to Mess. Mann Crossman & Co. Brewers. Mile End. E.

They employ about 500 men.
All men get regular work throughout the year. In busy times they must work longer hours. They do not take on & put off men.
The normal hours are from 6 AM to 6 PM.
Each Brewery has two broad divisions into Yardmen & Brewhouse men.
Yardmen include. Dragmen. Coopers. stablemen etc etc
Brewhouse men are those employed in the actual manufacture & storage of Beer.
Men are allowed a certain allowance of beer per day. 3 or 4 pts. The heads of depts. may give them leave to have an extra pint on occasion at discretion.

All their men come from the country.

No special training

Brewhouse look down on yardmen.

Men learn by seeing what others do.

Draymen. System of payment.

All their men are countrymen about 50% of whom live in Leyton & Essex districts & come in by the early workmens trains. Countrymen are harder workers & so-bers than Londoners.

There is no special training. The men who are taken on are unskilled. They begin generally in the Yard & are promoted to the Brewhouse gangs as they are found worthy.

Brewhouse look down upon Yardmen though Draymen are included among the latter & Draymen consider themselves to be the kings of a brewery. All men work in gangs under a responsible foreman. Here they learn what they have to do which is really nothing more than to obey orders. They are as common soldiers obeying their superior officers.

The Draymen are paid a regular weekly wage (21/) and then an allowance on every barrel they bring back. 3d for a big one.

Work & characters.

one down to 2d & 1d for smaller ones.
3d is for the 36 gall ~~Cask~~ Barrel & the 2d for the firkin.
The Draymen are very big strong men who have to work very long hours at times. They go out with a trouncer to help them. As a rule they drink a good deal but do not become drunk. They are always known as the worst cases at the hospitals. Even a scratch with a Draymen becomes an ugly sore. In addition to long hours their work is hard. It is a strain on the strongest man dealing with barrels. The temptations to drink are very great, everyone will treat them & it requires a strong man to refuse. In the Brewery they may have as much as they like but the System lately started of having to ask for it has put a stop to excesses. A man will help himself too often but shame will prevent him asking another to help him. Notwithstanding however a few

"flopping agin the business"
Dickens ("Tale of Two Cities")

Brewers Coopers.

Use of machine made casks.

The story of the Coopers demands.

a few of their Dragmen are teetotallers and used even to preach temperance outside the Brewery. This they stopped. They are glad to employ teetotallers, but, to preach against the consumption of beer is another thing. They told the men so & said they cd not keep them on if they continued. The men thereupon desisted.

Prospects rise to being full Dragmen in due time.

They repair but do not make their own casks. Now they use machine made casks (Chippendales) & find them to be superior to hand made ones. The coopers brought this upon themselves. Mr Thorpe had seen Mr Russell of Mr Chippendale & explained how it came about.

The coopers demanded some years ago a rise of 10% on existing rates this was conceded. Not content they followed with a further demand of 25%. & again with 10%. All was conceded; the last rise under special protest from Mr Russell who called up the men & pointed out

The introduction of machinery for making casks.

This of course only confirms what we have seen about "Coopers" excess so far as it is newest goes further.

Beer made in London

out that their action would lead to one of two things - Either Scotch casks would be imported or machinery would be introduced. The men replied that machinery had failed hitherto & that the master coopers would be wasting their own stock in trade if they merely imported ready made casks. This last Mr Russell admitted & the 10% was conceded. Chipperdales & Shaters however found a Canadian who had an idea for machinery & determined to make an attempt. This was successful. The barrel of the future & to a great extent of today is a machine made one. Coopers now walk the streets in search of employment. Only the other day Mr Thorpe had an application from a skilled cooper to be taken on as a cask washer at 25/- per week - a man who would not have been content with 50/- two years ago.

They make running ales chiefly - ie brewed one week & consumed the next. Stock beer they make very little of. The drinking of stout

Stout & porter not much drunk.

Minimum price settled by Brewers Hall.

? quantity also

In L'pool the pup department gives the "long" pull but perhaps this not done in London

The powers of appreciation of the British workingman.

Stout & porter has decreased - Porter being a weak form of stout. Workmen like now a clear light & sparkling ale; they have given up the black forms since the idea got about that they were adulterated with burnt sugar & whatnot. The tendency is to brewer lighter & finer ales.

Brewers Hall settles the minimum price at which ale ~~shall~~ ~~shall~~ shall be sold. The competition is therefore in quality - not exactly in strength but in the fineness of malt & hops used. The British workman is very slow to appreciate a change in the brew of a particular firm. It is not like in Germany where it gets about that ale of one months brew in one particular firm is particularly good. In England men only grasp this gradually & it is not for 18 months that you will find any increase in demand following on an increase in the quality of the beer supplied. Once you have your customers however they remain with you until they discover that someone else is brewing better beer than yourself - an equally long process.

The

Seasons.

Clubs.

Trade Union.

The busiest times are ~~both~~ the generally holiday & the hot weather.
The largest brewings are in October.
If the weather is very cold spirits are drunk in preference to beer.

They will allow a clerk most probably to fill up the full wages sheets.

They allow ½ pay to men on sick list & there is a burial club.
There has also just been started a Cricket & athletic club.
He believed that a Brewers Trade Union still existed: 80% of the men might belong. He did not recognize or approve of it but asked no questions

Mr Charrington & Co.

Extras

'Millage'

Sep. 11th

S. H. W.

Mr Charrington & Co. Mile End.

Took them the published volumes on the Trades to shew how wages wd appear in final form. They objected that there were so many odd payments that a whole year's wages for each man wd be the only fair way of giving a just average. A busy & a slack week cd give no idea. For instance for every new horse a sovereign is divided among the stablemen. 3/9 per ? is paid by the maltsers for every ? of malt delivered. This called millage. They are their own maltsters so they pay the men themselves. etc etc.

I offered to take out their wages for a whole year if they wd allow it to be published alone as a true record of the year's carry of men employed in an average London Brewery. The 3 partners present conceded this point but Spencer Charrington MP. has

get

to be consulted & the result must depend upon him

Dragmens wages presented the greatest difficulty owing to the manner in which they were paid.

It came out that they were great drinkers though not drunkards.
worked very long hours. generally slept on the barrels coming home from their journeys.
were the worst hospital patients & did not generally live long.

Dragmen.

Mr. Taylor, Walker & Co

Men employed. 90.

Employed only on mnfr. & distribution of beer.

Normal hours.

Draymen.

Paid regular time wage here.

Sep. 13. G.H.D.

Mr. Taylor Walker & Co. Brewers. Limehouse.
Introduction from Truman. Hanbury & Buxton.
They employ 90 men.
These are men actually engaged in the pro-
-duction and distribution of beer. They do not
make their own repairs or new casks.
For repair work they give all their to a
contractor who works for them only. This man
engages men as he wants them & manages
them & sends in the bill to the firm.
Hours are from 6 AM to 6 PM with
2 hours for meals, & until 1 on Saturdays.
Draymen work until they have finished
their rounds. They are paid a regular
weekly wage. The trouble is always to
get back the empty casks. They
had never tried the system of paying
so much per empty barrel brought back
in addition to a small weekly allowance.
None of their houses are more than
12 miles distant so that the men never
have

Give no preference to countrymen.

Dress of Dray, Stage & Yardmen.

Cooper.

Like the Sawyer he was rather too independent.

have very long distances to go.

They give no preference to country men - Would say that draymen now (theirs at any rate) are not the big men now that they used to be

Draymen ~~were~~ wear leather leggings & corduroys, stout brown cloth apron, & a red cap when in the yard (?)

Yard men wears white overalls & a red cap.

Stage men wear white overalls & a brown paper cap when at work.

The Coopers are the only pieceworkers they employ not to make new casks. but to repair old ones. They were formerly a very troublesome set of men. Speak to one about his work & he would take up his tools in a minute & be off. Now their union is broken & they are steadier. The same thing was the matter with the sawyers. They both tried it on too long and gave every inducement to the introduction of machinery. Now they use machine made casks

Machinemade casks.

Work is very regular.

Men allowed as much beer as they like.

An old firm.

Change in the taste for beer.

casks. These are perfectly symmetrical, smooth inside & slightly cheaper. Whether they will last as well as the hand made has yet to be discovered. They have hardly been in the market more than a twelve month.

Work is very regular throughout the year. They only vary about 6 men in a busy & in a slack time.

The men are allowed as much beer as they a barrel is put out in the yard & each takes what he likes. They used to allow men 4 pots per day but think that the present plan works more satisfactorily. Men do not exceed. they do not like to be seen going to the cask too often.

The firm was founded in 1730.

The taste was 30 years ago for stock ales – ales brewed in October & drank 6 months afterwards. There is still a demand in the country for such ales. They must be well hopped so as to keep well & are therefore bitterer & also rather

Taste for running ales.

They now brew all year round.

The busy seasons.

Slack in very cold weather.

Men must work until their work is done.

Men live near.

rather stronger. Now running ales - lighter & more sparkling - sweeter & less durable ~~for~~ the working men fancy. They are made this week & drunk next.

Formerly there was no brewing after April now they brew all the year round.

The demand is greatest just before the different Bank Holidays & in Summer more is drunk than in winter. When it is very cold men drink spirits instead & this last February they had a most marked shrinkage in their orders owing to the severity of the weather. Things have recovered again now.

There is no overtime because they have no regular hours. The nominal hours may be exceeded or no. It all depends on the work to be done. Stage-men must be at hand to arrange about the clearsing process. They cannot leave if this is coming on. They must stay until their work is done whether that be many or few hours.

Most of the men live within 1½ miles of the Brew.

The tied house system in London.

Small give way to large brewers.

Tied houses in the country

Brewery.

The tied houses in London are as a general rule tied for beer only. It comes about in this way. A respectable man with 2 or 300 pounds of his own wishes to run a Public. He has not enough money of his own for a Pub is an expensive thing to start so he applies to a Brewer & says he will ~~only~~ take his beer only if he will advance him the 700 £0000 necessary. This is accordingly done. It is to the brewers interest that the house should be well conducted for he has so large a sum of money at stake.

Small brewers are being absorbed by the larger ones. There are still a few small ones left who do a family trade ie they supply small casks for small orders & deliver them as they are wanted.

In the country the Publicans are more or less tied hand & foot. for tobacco, mineral waters spirits & everything. Thus when the tied house system is spoken of as a kind of slavery, ~~the London~~ it is a

mis

Halfpay to all men when sick.

No regular wages.

Yeast sold abroad.

See page 83

misnomer as regards London.

They have no clubs in the firm, but allow all their men ½ pay when sick.

There is no regular training. Men work in gangs. They learn by practice & do what they are told. They are first class labourers at skilled ~~labour~~ artisans wages.

They sell their yeast. Believe it goes to foreign distillers & comes back as German yeast.

He will fill up the detailed wages sheets & send by Sep. 18th

Mr. Smith, Garrett & Co

Numbers employed.

Preference given to countrymen.

Winter for stock ales.

Machine as good as hand made casks.

Sep. 13th G.H.D.

Mr. Smith Garrett & Co. Ld. The Bow Brewery - Bow Bridge. on an introduction from Mr. Truman Hanbury & Buxton.

Interview with A.H. Norman Secy

They employ 80 to 90 men regularly throughout the year.

Their men are chiefly from the country. They take countrymen by choice. The Londoner is such an uncertain workman & apt to be unsteady. Countrymen has often already had a preliminary training in a small country Brewery. He finds his way up to town - as often as not purely speculatively - he is sure to be given the preference.

In winter they brew stock ales - ie ales to keep for a year or so while in summer running ales keep them fully employed. The taste is for running ales.

They repair their own casks but do not make them. They buy machine made of Chippendale & find them every bit as good as the old hand

Tied Houses.

Yeast sold to Distillers

Lowest man gets 22/-

Beer allowance.

No regular training

hand-made.

Tied houses in London are as a rule tied for beer only. In the country they are often tied for everything. Sometimes a man has some money & the brewer lends him more. Sometimes he has none & the brewer puts him in.

They sell their yeast to distillers. English brewers have never succeeded in making German bakers yeast.

Their lowest paid man has 22/- per week & different allowances for unloading malt (3d each man per sack) & for loading spent hops. They sell their hops (those from the mash tun) as manure.

The men work no regular hours but as long as they are wanted.

They get 2 pts of beer allowed them at 12 & another 2 pts at 4.

The men do not exceed. One of their drayman is a teetotaller

No regular training: men work in gangs: often shifted from Yard to Brewhouse. Learn by practise. Are not really skilled men.

They

Diffr. sorts of beer brewed.

Pale ale.

Cooper

Draymen.

They brew X which is the common running ale. XXX which is the well hopped stock ale. Stout & porter.
The last two are decreasing. They are not drunk so much now.

Pale ale requires a diffr. system of brewing altogether & when it is wanted they buy it from Burton.

Cooper is the commonest of black beer - & the cheapest to buy. It is generally advisable not to drink it.

Draymen work very long hours one day & very short hrs the next. They are paid 12/6 as a starting wage + 3d for every empty barrel brought back.

He will fill in & return detailed wages sheet which were given him.

The Various Trades Employed by Mr. Truman, Hanbury & Buxton

This list might be given as a note

Different Depts in Mr. Truman, Hanbury & Buxtons business as shewn from their detailed wages return.

Carpenters.	foremen.	50/-
	artisan	
	labour.	
Sign Carpenters		
	labourer.	
Backmakers.		
	Slater	
	labourer.	
Smiths		
	labour.	
Wheelwrights		
	labour.	
Coppersmiths		
	labour	
Plumbers		
Gasfitters		
Millwright	foremen	
	artisan	
Engine Drivers		

✓ Furnace Repairers	foreman.
	artisan
	labourer.
✓ Engineers.	foreman.
✓ Painters	"
	~~Artisans~~.
	labourer.
✓ Sign Painters	foreman.
	artisan.
	labourer.
✓ Sign Writer	
✓ Bricklayers	Foreman
	artisan
	labourer.
Shives Turner.	
✓ Rope mender.	
✓ Sawyers	
✓ Brew house men	
✓ Coopers	~~foreman~~
	artisan.
	labourer.
✓ Sawyers	

✓ Horse keeper.	foreman.
	ordinary.
	Coachman.
✓ Farrier	foreman.
	artisan.
✓ Harness Repairer	
	Cabman.
✓ Labelling Boys.	
✓ Bottle washing Boys.	
	Youths
	Men.
✓ Fillers	
Inside ~~man~~	Men
	Boys.
✓ Carmen	Youths
Van boys	
✓ Cellarman	foreman.
	labourers.
	Coopers.
✓ Finings makers.	
Barton Store cellarman	
✓ Draymen	1st class
	2nd. class
	3rd. class.

Barclay & Perkins.

Process of brewing.

Barley.
|
malt
|
Grist
|
Infused in hot liquor (water)
|
Sweet Wort.
|
Infused with hops in Coppers.
|
Resulting in hot unfermented beer.

Sep. 19th G.H.D.

Mess. Barclay & Perkins. Anchor Brewery Park Street Southwark.

Interview with Mr Muggeridge. to whom I had been handed on by Mr Bevan.

The barley they use is malted in the country & also roasted there for the purpose making ale & stout.
On its arrival the malt is jacobed to the top of the Brewery. Then it is passed along channels by means of revolving screws & stored in various bins until wanted.
Out of these bins it descends by its own weight to be screened & passed over magnets to take out any old iron or buttons that may have fallen in.
After this it is crushed (not to a flour) but broken up & becomes pistle & then jacobed again

The Mashing stage.

Very few men employed.

From mash tuns to hop coppers.

to the grist cases or store bins when it falls into called mash tuns.

to the various coppers where it is turned to wort. Wort is the result of infusing crushed malt or grist with boiling water much in the same way as tea is made. In a Brewery water is never spoken of by name (under penalty of a fine), it is always called liquor.

Wort then is the result of infusing grist with liquor. It becomes beer after it has been further infused with hops & has fermented.

From the period of unloading from the cart until it is in the mash tun the malt ~~pass~~ gives employment to not more than 4 men. eg. 2 unloading & 2 at the mills.

The grist cases feed the mash tuns & are placed directly over them. When the grist is in the mash tun a pipe from the coppers lets in the water from below. The liquor takes the strength out of the grist & flows away as 'wort' through pipes into the underback. The same grist is treated in this way 2 or 3 times. From the under back the wort is pumped into Coppers where it is hopped. When the

Cooling stage.

Tun room

Hot unfermented beer.
|
Coolers.
|
Fermenting tuns
|
Wracking room. Beer vats.
|
Beer barrels
|
Brewers dray.
|
Publican
Consumer

infusion is sufficiently strong, both hops & wort ~~are pumped~~ descend into the hop back where the latter drains through a false bottom leaving the hops behind.
Hence the wort is pumped to the coolers - the first made up of a series of copper pipes through which the cold water is constantly passing - Over these pipes the hot wort trickles & then again flows through open shallow coolers.
The cool wort then descends to the fermenting room known as the Tun room. To start the fermentation yeast is added (6 gells yeast will become 600 gallons). As the yeast rises giving off a great deal of carbonic acid gas, it is swept off mechanically.
When fermentation is complete the beer descends to vats whence it is drawn off as required to fill the casks in the 'Wracking' cellar below.
There is still some fermenting power left in the beer after it is in the barrel, this overflows & before closing each barrel

Clothes worn in Breweries

175 Horses at B & P.

Divisions of Draymen.

must be filled 'tight' by hand.

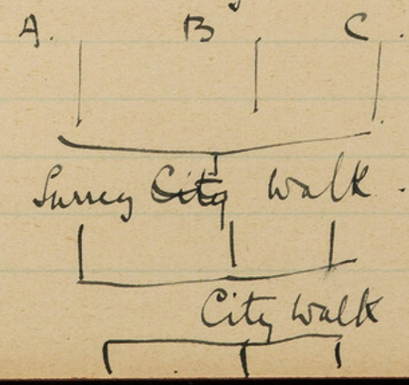
This is all the work of the cellarmen. who then close up the casks roll them along to the cask elevator which is a sort of jakob & delivers them on the loading floor - on a level with the Brewers Drays.

The men in Breweries ~~where~~ wear, white 'slops' or brown canvas aprons, clogs to keep out of the damp, leather gaiters. Red cotton caps are worn by Draymen when they go down into the publicans cellars.

The wearing of these caps is going out.

Barclay & Perkins have 175 horses now working

The Draymen are divided into 3 columns which 3 columns are divided into 3 divisions v. Long Walk.



System of payment & promotion of Draymen.

Below the City walk come 7 trouncers.
In each of the 3 divisions are 14 Draymen making 42 in all.
The middle column of Draymen gets a regular wage of 30/ per week.
The A & C columns pool their wages & divide the total weekly.
Each Drayman has 1 days holiday per week in consideration of the long hours they often have to work. On this day one of the 7 trouncers takes his place.
Each draymen goes out with one man from the Spare gang (called by most brewers trouncers)
The course of promotion is from

Spare gang.
|
to
30/ or middle column men
|
"Trouncers
|
Full Draymen
|
City walk.
Surrey walk
Ling walk.

Tied house system in London.

In the Country.

Halteration by Publicans

Usual practice.

Tied Houses in London Mr Brown said were totally different from tied houses in the Country

In London the ~~man~~ publican to whom you lent money on mortgage was seldom bound to you for more than beer. If he preferred some one elses beer he could go to the Brewer whose beer he prefered & get him to ~~pay~~ pay off the mortgage held by the brewer whose beer he disliked. This he said was constantly done.

In the country & in a few cases in London publicans were bound for beer, spirits tobacco & everything.

Halteration he fancies is usual among publicans: the usual thing is for them to add 6 galls of water to a barrel (54 galls) & some times perhaps generally they put in sugar to make the water pass unnoticed by the customer.

The detailed wages sheets shall be filled up in 3 weeks & returned here.

Numbers of barrels brewed in England. in a year.

p. 11

What is size of barrel? 54 gallons G.H.D.

Over 27 millions retained for home consumption.

Receipt from beer duty of over £10. million

Amount of duty per barrel.

Consumption per head.

p. 14

Appx p. xx.

Taken from 38th Report of Commissioners of Her Majesty's Inland revenue.

Number of barrels of beer on which duty was paid in England. year ending March 31. 1895.

— was 27. 419. 795 of these

245. 551 were exported on drawback or repaid

and 27. 174. 244 barrels were retained for home consumption.

For the United Kingdom 31, 382, 338 barrels were retained for home consumption.

The full net receipt of beer duty in the year amounted to £10. 494. 329 an increase of £560, 008 compared with 1894.

The duty on beer brewed was raised from Apr. 17th 1894 by 6d per barrel to 6/6 (irrespective of the 3d per barrel assigned to local taxation). This increased rate of duty ~~by 6d per barr to 6/~~ like that under spirits was imposed until July 1. 1895

For the UK. The consumption per head was .818 barrels.

Excise licenses granted to Brewers for sale in England 8,863. in number.

other Brewers. —— ~16.766. ---

A. W. Freborn. formerly at Charringtons

Now Secy to Loyal United friends.

Numbers in Society.

Entrance fees.

Benefits.

Sep 25th G. H. S.

A. W. Freborn. 200 Globe Road. E. formerly employed in the mill loft gang at Mess Charringtons Brewery, late organiser & secretary of the Brewery & Distillery servants Trade Union. Now joint secretary of the Loyal United Friends Society & manager of the 1, 2, 3, 24, 49, & 54th Branches, which have a joint membership of 6886. & a balance for the quarter ending June 29. 95. of £17,212. 2. 7

Entrance fee to join Sick & Burial fund 1/6.
Initiation fee 2/6 (members must be between 18-38)
Quarterly contributions from 18-30. 3/6.
30-35. 4/-
35-38. 4/6.

which entitle members to following Benefits
Death. £10.
Wifes Death. £5. } for free members.
Death £5 } for non free member.
Relief in sickness. 10/. per week.

The Society has 57 branches in all divided into

The Branches of the Loyal United Friends.

Short history of Mr Freeborn.

In Green grocery business.

in Royal Navy.

at Cyprus. 1878.

Invalided home.

23 sick & burial clubs each of which (ie of the 23) is financially independent of the other.
The 57 branches are supposed to be 80,000 strong.

Mr. Freeborn had had a curious career which came out in the course of the interview & which I have arranged as follows.

Born in 1859. Son of Father & Mother in greengrocery business. in which he helped. Mother died & Father married again. When 16 yrs old in 1875 he went to sea in the Royal navy.
Was out in the Eastern seas during Russo Turkish war, in 1878 he landed with the Fleet at Cyprus.
Then went to constantinople where he got his head bashed in in a street brawl. He was at this time a first class signalman ie a second class petty officer. The wound would not heal & formed an

Again at greengrocery.

Sells the business.

Applies at Fire brigade & SER.

Job at Charing X given up on marriage

Project of business with wifes brother fails

Gets job at Minories warehouse GER

an abscess. He applied for sick leave & as he had been at Cyprus was granted it for a year though his last was not a serious one. Once home he soon got well & to fill up his time joined his stepmother in the greengrocery line – His father had meanwhile died – He did not agree with her & so sold the business for £15.

Before this 2nd try at greengrocery & almost immediately after his arrival home 'like all seamen' he had applied for a place in the Fire Brigade & passed their exam. At the same time he applied to SER for a place as porter.

The SER offered him a job as soon as he gave up the greengrocery & in a year the Salvage Corps also had a vacancy for him. He refused the latter being already fixed at Charing X.

Then he married & left Charing X to join his wifes brother in a business in Hackney but wifes brother 'went queer' & the project had to be given up.

After that he got a place at the Minories warehouse.

Meets a messmate employed at Charringtons.

Applies for & gets a job at the Brewery.

Long hours & low pay & no immediate prospect of redressal of grievances makes him think of starting a Union

house of the GER at 21/- per week. This was pretty hard work & when one day he met an old messmate in the street who was employed at Charringtons brewery & advised him to come along there he at once did so. They liked to have seamen & at once gave him a place so he resigned GER & started in the brewery on June 21. 1882 being at the time 23yrs of age. His pay was 21/- per week which was no better than GER but the probability of a permanent berth & the fact of his old mess-mate being there decided him.
He was 4 yrs at 21/- & afterwards at 24/-. The hours were very long & meal times irregular. The organised trades employed by Brewers had fixed hours, why should not the Brewers men be organised too? He could get no complaints of the hours through the foremen to the principals. The idea of forming a trade union dated from this period of long hours & low pay & want of any immediate prospect of a redressal of his grievances.

AT

Placed in Mill Loft gang.

Duties.

A specimen days' work

at the Brewery he was placed in the Mill Loft gang which was considered the smartest in the place.

The Mill Loft gang is occupied in unloading malt, putting hops into the copper, grinding the malt to grist, taking out the spent hops & throwing them into the hopper a sort of jack for conveyance to the copper for the second boiling.

He started in the morning at 5 AM & worked stripped to the waist until 8.

8 - 9. Breakfast.

9 - 11. Unload malt again, & afterwards do the 'hopping'. I get inside hot underback from which only wort has been drained off & lift the hops, & throw hops into the hopper. Very hot work must always take in a towel with me to wipe off perspiration & wear clogs for the damp. This done, unload more malt or possibly do another hopping.

11 - 11.30. Lunch.

11.30 - 1 General work.

The Day's work in the mill loft gang.

Conditions are better now.

Work in the 'Dust holes'.

1-2. Dinner hour. Either on the place or off it at your own option. In this gang the hour was very irregular sometimes being earlier & sometimes later. The other gangs have dinner regularly from 1-2.

After dinner you either had to unload malt or to clean up machinery & floors of coppers & get the hops ready for the nights boil.

Cleaning up was the easier of the two & the millloft gang divided into 2 & took it in turns.

Unloading was never finished before 6 & sometimes not until 10

He admitted that the conditions were better at Charrington now, which he said was chiefly due to the deaths of the foreman & sub-foreman.

Sometimes the foreman would tell off 3 men to the 'dust holes to fill bags with the malt dust.

This was piece work (2d. per bag). There was some danger in it as the dust is very inflammable.

JT

Extra 'chits' for beer. i.e. cards ~~on presenting~~ in return for which at the taphouse you were given beer.

Afair & unfair days work.

Saturdays

Sundays.

It is unpleasant work for the dust is so fine that you have to work with a towel over your mouth & nose. One man is never sent alone for he might be overcome by the dust & die without anybody knowing.
When on this work the foreman wd give him an extra 'chit' for beer instead of letting him have time off for tea.
The extra 2d per sack was paid to him in lump sums quarterly. He complained that the foreman used to keep some of this back
These hours i.e 5 AM to 10 PM & very rarely until 6 PM were what made him start the mining 400 qrs of malt is a fair days work beginning after breakfast for 3 men: but on occasions he has had to unload 700 qrs. The rule in a Brewery is, that what work there is to be done must be done in the day whether it be much or little.
On Saturdays the Brewing side got finished by 2 or 3 PM. & the malt side between 4 & 6.
On Sundays there was no work in the Brewery except for 2 men in the tun room & a stoker in the

Men rises above him.

Complains to Spencer Cherrington.

Forms Union

Many cliques in a Brewery.

in the morning. at 6 PM the night duty stokers came on as usual.

In 1890 the other men in the mill loft were risen to 27/- above his head. He complained to foreman who said that the managers cd not raise his too because he was always making complaints that his mealtimes were irregular & such like.

Thereupon Freeborn directed a letter to ~~the firm~~ Spencer Cherrington M.P. the head of the firm. He was had up before them much to the disgust of the manager & given his rise. The manager naturally did not like him for this, nor did he like the manager: so he determined to surprise him one of these days by shewing him that the men in the Brewery were organised.

The men were in great fear of one another. In no place are there so many cliques as in a Brewery. But he got 47 to join. Then one of their rule books was discovered with his name as secy. This the firm cd not stand & he was told to leave. He left on June 21st 1890

Organises Brewers & joins them to Dockers.

Obtained rises of wages & decreases in hours.

Principals are generous but Foremen & managers are not.

1890. Just 8 years ~~after~~ to a day since his first entry into the firm.

The Dockers union was now in full cry. He went to Tom Mann who bade him organise the Brewing Trade & make them a branch of the Dockers Union. This he did going round to Breweries where there was great enthusiasm & men found in large numbers.

As secretary to the Union he went round & treated with principals in person. He got rises ~~from~~ wages with decreases in hours from Hoares Courages & Charringtons. He spoke very highly of the principals in all the breweries he saw & said how ready they were to alter any abuses as soon as they saw there was any real grievance.

The real fact is that one of the partners used always to live on the Brewery & know the men & the way in which the depts were managed. Now this is left to a paid manager who with the foremen stands between the man & master. Breweries are run now by Companies rather than by private firms.

The fall of the Union.

Now he meets the directors at their yearly dinner as an equal.

Long hours among drayman & stable men.

The Union received the final rebuff which put an end to it in the lock-out by Savill.
a levy of 1/- per man was necessary to maintain the men out. The members refused & the whole Union failed.
After this he was agent in an insurance office & then applied for the agency of the Royal United Friends which he now holds.
Now he is in the position of an investor in the Brewery (ie of the money of his Society) & with the other investors is invited to a yearly dinner given by the firm & there he meets the ~~other~~ principals who sacked him as equals.

In the Brewery the drayman & stable men work very long hours.
The drayments hours might be shortened by a refusal on the part of a firm to deliver orders without 24 hours notice. But though sometimes nominally done this is never actually the case in a brewery.
Men in tunroom often wear brown paper caps which they make for themselves. Drayman

If Brewers wd. look after their men as well as they do after their horses!

Beer allowance.

& Gardmen sometimes wear red caps & flannel aprons & gaiters. Capweering is going out.
'If Brewers wd. look after their men as well as they do after their horses there wd be very little to complain about'.

3 quarts of beer were allowed each man.
1 quart at 7. AM.
1 ——— 11 AM.
1 ——— 4. P.M.
The men drink a good deal but you seldom see any drunk. They wd be sacked at once. This is one of the strictest rules in a Brewery. The men know it & are careful not to drink more than they can stand.
In a brewery the salary is increased as you move up into a vacancy from above.

J. Pike. Brewers Engineer

His antecedents

Process of brewing.

Sep 25th G. H. D.

J. Pike. Brewers engineer. 25 De Beauvoir Square Kingsland Rd. N.
A an introduction from Jesse Argyle. at the Boro of Hackney working mens club in the Haggerston Road.

Was 10 yrs. with Mr Whitbreads in Chiswell St. & has worked in nearly every brewery in England.
Is now occupied with setting up refrigerating machinery. & will probably be sent out to Madras by a company to fix up cold storage works there.
The process of making beer he explained as follows
Barley comes to London brewers as malt
Malt is stored in malt cases.
Then passed over rollers & goes as grist to grist cases.
From grist cases passes to the hoppers over the mash tun.
From the hoppers on the road to the mash tun the

Process of Brewing.

Hours.

Work in gangs.
Clique ism

The grist passes through a 'Steel's machine' i.e. a hollow screw
~~which~~ & boiling water is added the while to mix
the grist thoroughly – so into mash tun
where more hot liquor is added – from
mash tun as sweet wort to underback –
pumped thence to coppers where hops are
added – passes away as bitter or beer wort.
thence to coolers – to refrigerator – to
fermenting vessels where yeast is added
to set up the fermentation – thence to settling
back where scum rises & lees sink: the
bright beer in the centre is racked off leaving
lees for the filter press – What comes from
the filter is put in the next brewing &
allowed for as drawback rebate by the Excise men.
The lees & yeast go to distillers who extract
spirit from it esp. in Scotland & Germany.
The normal hours in a Brewery are from 5 am
to 6 PM. with 2 hrs allowed for meals (breakf. & dinner)
But there are no real hours. They depend on
the management of the foremen.
Men work in gangs under foreman who takes n &
puts off his own men. Great clique ism in breweries

Men

Beer allowance.

No OT rates or hours &c for organised trades.

Horses v men.

No drunkenness.

Higher wages = longer service

Holidays.

are first class labourers. Generally countrymen of strong constitution

2pts allowed daily at Whitbreads but men can really manage to get as much as they like. It is the usual custom to take it tho' not actually allowed. It is winked at until you are anxious to get rid of a man when it is not difficult to catch him in the act. Tho somewhat an unjust system this, it is always done.

Men seldom shift from one dept to another tho sometimes extra bright men are changed.

No overtime rate except for the regular organised trades.

Engineers & coppersmiths work 54 hrs wk & paid 7/ per day. Assistants 4/-

Horses magnificent. Pity the men are not so well looked after as the beasts. But men get good pay. The uncertain hours are the hardship.

Less drunkenness inside than outside a brewery. Men discharged at once if seen drunk.

Increase of salary means length of service usually & good conduct.

One weeks holiday at full pay allowed each man in the year

The Tap House.

Compressed carbonic acid gas for publicans

year & full pay while sick

Every brewer has a tap house.

Thither publicans servants are sent for lunch or beer. The principal are given lunch & the small men a cigar, beer or bread & cheese. Checks are given out for the purpose. Men sometimes save these up & in the end buy a box of cigars or take bread & cheese instead of beer.

Brewers principal he has invariably found to be fair & generous men to deal with.

Has made a specialty of the food supply of London & W.d be very glad to give any information concerning it

Said that Combes had lately been collecting the carbonic acid gas from the fermenting vats & supplying it compressed in cylinders to the publicans who put it under the beer barrel. Beer needed then no pump but always frothed up fresh & full of the gas which gave life to it & for want of it beer became stale

Mr. Henry & Co.

Regular work.

Shifting rare.

Drayman.

Stows & hauls.

Sep 24th. 8th.

Mr. Henry & Co. Tottenham Court Road.
Interviewed with Mr Carter their manager
Employ about 350 men.
Work very regular, engage about 20 fewer in winter than in summer.
Shifting from one dept to another is exceptional.
Men are first class labourers. no skill needed - work in gangs under foreman.
Draymen have long hours - loiter on the way - difficulty of getting back their used casks before they are sour.
Men wait about outside so as not to be sent off on another job. Are a good deal treated by the publicans - generally demand it as a right. A pint before starting - a pint when at work, & a pint when finished.
Drunkeness rife the drayman.

Gave wages sheets for busy & slack to me to take away with me. will be very glad to help in any way if I will call.