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Extracts from rule book of Coppersmiths Soc. p. 99

Index to Interviews.

Name.	Address.	Page.
Mr. Frost.	Brassfounders. Allen St. Clerkenwell.	1
Alex Craven	Brassfinisher. 18 Stangate St. Lambeth	7
E. Karel.	Tinplate worker Vine Ct. Mile End Rd.	15
Goosey	Tinplateworker. 29 Mulberry St. Commercial Rd.	17
Pd Sentinella wkr	Brassfounders. Soc. 2 North St. Kennington Rd.	18
Managerness Co.	Brass & Bronze founders. St George wlk. Deptford.	23
Browning	Coppersmith 49 Cowell Rd.	27
R Dredge.	Pewterers Soc. 17 Maltby St. Bermondsey	30
Braham	Brassfinishers.	39.
London Amalg	Brassworkers. Soc.	46.
London United	Brassfounders.	48.
OF Burnett & Green.	Tin plate workers.	50
F.W. Potter.	Wireworkers. Weavers drawers.	59.
J. L. Pill	Small master wire workers.	66.
J. D. Grout	Secy. Wireworkers Society	see sep reports
G. Farnilow.	Lead works.	70
J. Chatterton.	Lead pipes.	73
Alf. Hughes.	Metal workers	80
C.H. Quinton.	London Soc of Coppersmiths	86
Pelham Bulkwell.	Wire rope & netting	91
Walker Parker & Co.	Lead pipes, shot, sheet lead.	95

Mrs Ross Brass founders.

Wages of men employed.

The 'set' system.

March. 14. 1894. G. H. D.

Mrs Frost. Allen Street. Clerkenwell. EC.
Brass founders.

They gave the following as being the average weekly wages earned by their men for two weeks ending March 17th & 24th respectively.

	17th		24th
Moulders	48/6.	—	45/.
Foreman.	35/6.	—	33/-
Trimmer.	30/-	.	28/
Coremaker (boy)	16/6.	—	16/-
Cleaning 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 cleaning 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.

3/. One or two coretrackers also paid by the week.

3/. a trimmer on piecework whose average wage would be 26/.

4/. a fireman who gets 10d per cast and 2d per day for keeping the furnace in order.

5/. a moulder who gets 1/ 3½ 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 wd 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 once if they don't. They have noticed a great improvement in drink. Men even send out for coffee now instead of beer. Thinks it is owing to their method of training their own men.

Boys are taken on at 7/- per week to do cleaning out, then they make cores, 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 we say there was a good deal in the trade generally.

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

For finishing they employ out of door men & 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 1/- per week above his wages which is paid into this fund and to which the man himself has to add 3d. 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 holidays ie if the Friday 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.

Shop fronts come from Birmingham.

of everything

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 piecworkers but although on piece they count a certain quantity as being a fair days 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 amalgum which they do not touch is undoubtedly the worst for men

All shop fronts come from Birmingham & nearly all kettles and lamps also

Tea & Coffee urns now come from Brum.

Pewterers

Tea & Coffee Urns which used to be a skilled branch of London manufacture now come entirely from Birmingham, though the handles & taps may be cast in London. Pewterers do box 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 3% are T.

March 15th 1894.

Alexander Craven 18 Slaugate 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 Chandelier work, stamping & fine work and admit polishers to their Society They originally belonged to Mr Davis's Society in Birmingham but seceded and formed a ~~opers~~ separate Society of their own

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

Average of hours per day. 6 to 8.30 & from 9 to 1. & from 2 to 5 work 52 hours per week as a rule. From 6 - 1 on Saturdays allowing half an hour for breakfast.

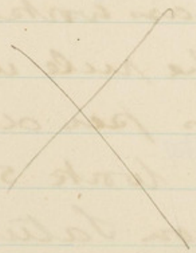
Out of the 400 who belong to the Society only 3% are day workers.

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.

Tylers ~~Bouldung~~ Boildings, Jennings, Warners, Mansslay Dewrances are the houses which employ the greatest number of brass finishers; and in every Engineers shop there are always a number of Brass finishers. Dewrances 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 8d, but supposing a man who has been earning 8d goes into a shop where the rule is 9d & 10d 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 8d 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 1d which may only

The National Association.

Electrical Instrument makers.

Finishers employed on Sanitary work.

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 Doultons, Jennings & Finch is a London specialty, and all employ 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 & Westend work for Brass finishers

No seasons.

Training

Each shop settles its own prices

Not much prospect of Daywork being introduced

Employed on ships works ie land rails, lamps settle lights (ie Porthole doors which are all of brass) In the West End they work on fancy electric and Chandelier 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 daywork becoming the rule, for the men will always ask for Piece work by preference

Men classed at Daywork rate & draw such 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.

At the Westinghouse Brake Co & in most shops men are classed at day work 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 Gravel Lane at the present moment.

There are a great many new priceings 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 Pewterers.

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 Pewterers 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 C reckons to use 1 month in the year compulsorily owing to holidays ie Easter 1 week or 9 days Whitsuntide 3 days Bean feast or Wassoose Saturday to Wednesday Xmas. His firm also close for a week stocktaking 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 garrett masters eg Pickersgill who do small screw down cock work make cameras &c generally with boys to help. have been journeymen themselves

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

Regular transition from clockmakers to Brass finishers

All Gas fitters are daymakers 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~~ except broadly 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 too finicking a worker for large work and unable to make good money.

Garnett & Fowler of Walworth use only boy labour

Shoolbred 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 8d 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, (journeymen). Come over and are glad to be given work

all piecework

used once to employ Christians, has now 10 foreigners, they are better than Christians, dont 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 undersell 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.

Homeworker & hawker.

Machinery is taking the place of men.

Opinion as to pay at Karsto.

21 March 1894.

Ossosky.

Tin Plate Worker 29. Mulberry St.
~~6 Pikeswell 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
ol 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 Karsto men would be too thankful to earn
15/- to 20/- on piece, many only make 10/- or 12/-

R.L. Sentinella 12 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.~~ the
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 meet the metal for the moulder
These men often work in sets of one each who take one the work at a price
Daywork shops he owned say were the rule the proportion being 7 daywork to 1 piecework

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' System.

where piece work ~~obtains~~ appertains 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 Moneday (boys) get 4° to 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 Broads 9½ per hour is the rule at Wilkinsons 8° at Veritys at so much per cast at Benham & Fronds piece work coming to 9½ per hour

There are a great many boys now in the trade but they dont suffer so much as other trades Very few are apprenticed. The system is practically dead only 1 in 3 be cause they were regularly indentured The improvers system has taken its place. personally he thinks the present-

London a huge jobbing shop.

About 500 journeymen moulders in the trade.

No seasons.

Much shifting esp: among firmes.

system the best - for the boy learns more to depend upon himself

Dewrances 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

Dewrance 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 Swithins Lane

There is much shifting especially among firemen

The foundries as a rule are much neglected

Lowest rates of pay.

Unhealthy fumes.

Trimmers.

Small shops really make for large.

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

6½ per hour is the Society minimum price and not many get less who belong to the Society, outside men get as little as 5d. & 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 Ague 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

Trimmers 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 founding consists of
Moulders.
Finishers.
Coremakers
Trimmers. are handypen with a few
only a few are legit Brassfounders. says you can
make a trimmer in 3 mths. often shift to be
smiths hammermen or dockers
about 500 moulders & fitters in London
" 200 finishers.
" 100 Coremakers men & a lot of boys who
drop in & out.

R. A. Satinella
Kingston Engineering Co.
Southwark Rd. Kingston Thames
Nr. Subway Station.
Will show me works anytime on dropping
line the night before.

29 of the 38 shops on this (i.e.) the South Side of the Thames 22 are nothing 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. Several even are avowed teetotallers. Satinella himself was blocked in his youth for being a teetotaller

26. V. 94.

Loam moulding is really iron moulders work & ironmoulders 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 jobbing in the general founding trade.

Manganese Brass & Bronze Co.

Moulders earnings

Lads in rolling mill

Firemen

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
Ingot shop 20

In the foundry the moulders earn from a min 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 Ingot shop firemen get 32/- fitters & machine men get 38/- to 42/-

Patternmakers 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 dont 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 more 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 compliment; all the rest may shift~~ 40 may be termed the tidal compliment and are the uncertain quantity.

Maudslay - Penns, Humphrys - Tennant &. all big Engineers do Brass founding also

He would say loam moulding and brass forging 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 &c. They said they would
prefer to work half an hour longer on Tuesdays
& 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

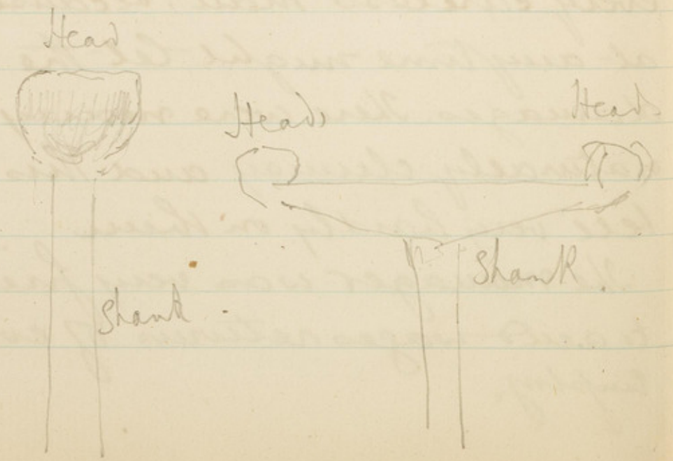
Speaking of the effect of the Employers Liability Bill if passed he said that it would at once add to the number of unemployed because the masters would at once sack every careless man, because such a one at any time might let the master in for £50 damages. There were many men who were naturally clumsy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

Articles manufactured

Method of work.



20 March 1894.

Browning a small master Coppersmith
Goswell Road EC

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 hardens and polishes by beating

Brazing.

Scalemakers are the poorest.

Rates of pay for Brazers.

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 shanks 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. ie 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 9d & 9½ 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 first season begins. Most houses have a few day work men as a regular staff & the rest they employ are piecework men

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

R. Dredge. Pewterers Society.

Divisions of Trade.

Earthenware has supplanted pewterplates.

March 31st S.H.D.

R. Dredge. President of the Pewterers. Society.
17. Maltby Street. Bermondsey.

Pewterers. have somewhat degenerated

Lead ware (Does not know why) ie teapots ice moulds, ice mixing machines & hot water dishes. (v little done in London) cake moulds.
Bar fitting. The main branch. } this is mostly
Pewter Pot making. } done in London.
The trade 2 men together: both must at the same firms.
One man should be able to do all 3 but men mostly stick to one branch.
Earthenware 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 (v little) hardened with copper or zinc, is called also Britannia metal, common metal, hard metal etc.
a pewterer sh. 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 for pots.
Plates are cast & then turned.
Brass pewter pots are always cast & then turned up.
German silver pots are span, but (Pewtering) they do none of the work.
London is the centre of the industry for Pewtering & Bar fitting but Birm & Sheffield for sadware.
Sadware & potmaking is P. but bar fitting is all without exception Day work.
He scattered all over London was far as Greenwich & in N London.
One price for pott 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 very heavy eg one for a quart pot wt. weigh nearly 40 lbs for the body only pot is made in 3 parts, body, bottom & handle; The difficulty of casting into

Moulds of copper.

Beer engines made of sheet metal.

get both your metal & your mould to the requisite heat if one or other is too cold or too hot you cannot cast. Herein lies 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 etc.

Then you take your castings to the Lathe & turn the inside of the pot

(Beer engines spouts are cast in gun metal with sand cores, otherwise no sand is used)

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

Basin & Beer engines are all made of out sheet metal which are cast & then rolled through steam rollers & then worked up to suit the particular order. Basins in which the glasses are washed are span or hammered up.

Society founded.

Election.

Subscription.

Benefits.

Numbers in London.

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

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

$\frac{2}{3}$ of the Known gentlemen in London are members. (wd. rather not give exact numbers so that masters may not know how weak or how strong they are.)

Not all new officers 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/- per wk.

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

for 3 mth & ½ the amount for another 3 mth.

No sick.

Dispute pay is decided by funds & according to numbers who are going to strike. Average is much as 30/- (exc) a week.

Probably not > 80 journeymen in London.

5 big shops employing from 18. to 6. men

(Cayport.) (Kegallett)

Among these 5.

Chief Losses in the Trade.

Each paid separately.

U & Non U men work together.

Relations pretty comfortable.

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

Heath. Rahere St. Cowell Rd. keep their own brass finishers, & carpenters.

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

Warne. Blackfriars Rd. where he works

Sandars & Co. High Holborn

Helen. Oxford 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.

$\frac{9}{10}$ of the work at these shops is day work.

Society & non soc. men do work together: has had a lot of controversy on this subject: but in non-soc finds much diff in getting into a soc. shop this not viceversa: 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 recog. 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 must be worked with the others & know them personally.

42/- a week (they are paid weekly). In piece they draw at about the same rate or a little more. Piece workers wd be bad workmen who did not earn 1/- an hour wd soon want to get out of it.

38/- 40/- an av. man. Wd say it wd be quite wd. The great majority in the soc. get 42/- for a full weeks work.

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

Soc 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 wd 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 as well pure tin.

Blackest time is Jan & Feb. men discharged & short time also. The work depending chiefly on publicans who wait till a week or 2 before every public holiday. Then esp in Dec the pewterers in December. Used to make a lot of O.T. T & ½ is the rule after 8 P.M.

8 – 7 are the usual hours. 1 hr dinner. Same ½ hr for tea.

8 – 1. Saturdays.

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

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

Trade is going down in London. Veto Bill has frightened

Work shared when slack.

The General holidays are a Dead loss to mechanics.

No shifting.

Always 7 yrs. Apprenticeship.

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

publicans. They dont know what is going to happen & do nothing in their uncertainty.

Work is tolerably well shared: no hands not discharged unless very slack. As a rule all wk. go in short time. in Jan & Feb wk. prob make 5 instead of 6 days. wk. never have suff OT to make this up.

They are not paid for the General holidays. Does not think they suit mechanics. at all who can always loc a week or two at just the same cost & then when you go out you dont have to pay twice the ordinary prices and you get pushed about. Thinks they are fair trade of time.

Men dont shift much from branch to branch & most are employed for many years: c. neither a score who have worked for firm for 15 to 25 years.

There are not sick clubs as rule in the diff.t shops.

Always 7 years Apprenticeship. has not died out at all. cannot get into soc. without showing an indenture the exceptions are sometimes made if a man is a very good man. Wk. think that

Painters can do gasfitters & Plumbers work but dont.

Rents in Maltby Street.

nearly every painter in London has been apprenticed. not 2% not apprenticed. he w. think

a Painter or c.d become a gasfitter or plumber with very little tuition but never do so. the out door work in Painting & gasfitting is much alike. only Painters uses paints instead of lead.

Gasfitters & plumbers 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 20 ft. garden. & a wash house.

Mess.r Braham, Brass finishers & workers.

London is the centre for the best work.

Wages.

19 March 1894

Mess Braham
Brass finishers & Brass workers
Clerkenwell E.C.

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 L 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 8d per hour as the lowest pay here The average is 9d.

Turners earn between 8½ to 10½ per hour

Earnings of the best men.

Sawpiercers.

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

Lacquering process.

All daywork.

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 1/2 per hour and a few even more than that

Saw piercers are mostly women It used to be a mans business but has now been given over to women, and is very suitable work for them The women here earn 24/- per week*

Lacquerers 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 daywork and are given time & quarter for overtime

They have no season and all here have

Apprenticeship system is dead.

Greater subdivision now.

Day v Piecework.

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 formaly 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 say that 1 in 50 of the masters in the trade were themselves practical workmen

Advantages of being a practical man.

Electrolier is supplanting gas work.

Electric Instr. 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 earn 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. There 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 9d & 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 not 1 in 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 Natl 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.
Men & Employers work well together.
Men work at lowest rate 8d per hour 54 hours per week Mostly daywork. 8 27/4 36/
Men at 55 years of age can do the work but the employers do not like them. There is a prejudice against old men begins to manifest itself at abmt 45
Busy Season September to March
Slack " Summer.
Many firms make stock work during the slack season & put the men on short time
Plumbers Brass workers are busy in the Summer when work (Building) is proceeding.
Overtime only in urgent cases The Society discountenances systematic overtime
In slack times some firms work short time

Very little shifting.

Lads pick up the work.

others discharge the men

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 articled for 5 or 6 years but it is not usual to apprentice lads Employers are good sheep 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 Unionists is smaller
The General Labourers Union is the only organization that takes them
Unionists & Nonunionists work together
The Men are practically in the Masters hands

Moulders 38/- for 54 hours
Core Makers, Brummers, Fremen } 6 per hour

These are the rates the Union seeks to enforce
There are moulders for 60 hours at 8d per hr
Other men are taken at a weekly wage Have a ~~no~~ case being investigated now. a man working 59½ 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

Trimmers fitters & coremakers may in slack times go as gen: labourers.

No shifting as a rule

Trade processes 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 Dont get any extra rate as a rule

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

The Trimmers, fitmen, & coremakers may in Slack times go as General Labourers. The Moulders do not.

As a rule the men dont shift from one branch of the Trade to another as work offers.

Fitmen & 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 hough. This is his usual method of learning.

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

History of the 'West End' Society.

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 Baily, and there was also another Society meeting at the Black Jack in Long acre. 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 trade make 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 guages of iron & is called 'tinned iron' and passes to 20 guage iron down to 12 guage 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 longer stuff is used. 14 guage is the thinnest 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/- in 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 8d per week and takes a 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 so hopeworking 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 is keen. The staple trade water pots in summer, Coal scoops in winter, &.

Scarborough 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 Burnett his father have never been out of work in their lives. A good workman need never be out of work. They can turn to fair meter making if their own trade fails them

The powers of earning good money begins

Capacity.

Overtime is unusual but
short time is proverbial.

Shipping is nearly all daywork

Minimum rate.

Cheap homemade work.

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

Overtime is unusual 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 not apprenticed any of them to the trade

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

The minimum rate is 9d 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 quaee 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.

Moulders on taskwork.

Average amount per week.

May. 30th. G. H. L.

R. L. Sentinella at the Kingston Brassfoundry Southsea Road. Surbiton.

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 six 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 ~~casts~~ moulds ~~depends~~ to a cast depends on the size of the ~~frames~~ or boxes. Ordinarily 29 'casts' make up a full week i.e. 5 per day & 4 on Mondays when

Trimmers.

Brass workers.

Wages.

Not a seasn trade.

Healthiness.

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

Trimmers are both piece & time workers.

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

Trimmers are the poorest section of the trade. They get 6d an hour. He wd not say there were any under this price.

Firemen get 6½d

Moulders. 8d or 9d

It is not a seasn trade. When in regular work a moulders 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 12 men gas may have 6 casts being poured and the fumes given off by the brass are very

Shot makers.

Moulders in the Brass workers soc.

The Societies in London.

heavy so that there will be a thick white cloud in the air for ½ an hour or more. The men say that this affects the urinary passages besides being hot work. Therefore they drink.

R.A.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 shot much rounder & better but we probably not shew this part of the work.

We will say there were about 60 moulders in the Brass workers Society. Ask Nash the secretary. Crown Tavern. Clerken. Wall Green.

London United Brass founders
Amalgamated Brass workers.
London United Brass finishers.
Mathematical Instr makers

Trade Societies.

Electrical Operatives &c.
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.
London & Prov. Soc of Coppersmiths.

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

Mess. F.W. Potter. Wire workers & weavers

Divisions of Business.

Wire workers.

Competition of small men.

June. 1. 1894. G. H. W.

A.B. Sons. Messrs F.W. Potter & Co. Wireworkers & wire weavers. Phipp Street. Great Eastern Street. EC.

Has been 27 years in the Trade.
Wire workers } are the two distinct divisions.
Wire weavers }
Wireworkers. make window guards, fire guards, screens and all work by hand. Guards for engine window guards, the back grounds for enclosed glasses to be fixed in for music halls & theatres, sieves were being made while I was there.
Nearly all work exc. sieves is done to 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

Earnings of good wire workers.

Gen. P. but a few dayworkers also

Wire weavers.

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 fireguards 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 shops) throughout the year on piecework.

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

Wire working } 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

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 another which raises the 'harness' through which the wire has been threaded. The harness is composed of two bits which alternate wires have been thread, as one is raised the shuttle is shot through with one hand & the wire pressed home with the 'hammer' (?). 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 ~~letting or~~ gauge has to be 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 wages 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 one 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 garret masters 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 20 or at Mr. Bedford's are power-looms.
Here they have 30 looms at work and at Bedford 25 so that more than half the number are confined to two houses in the trade.

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

London work has no specialty or special locality. 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 to when they come in. They are hard drinkers but have certainly improved in the last

Never really work ≃ 40 hrs per wk.

Not much boy labour in London.

Shifting.

Training. Apprenticeship Hours.

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.
Men 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 power-
-ful 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 ~~among~~ by calling a
shop meeting: master & man generally

Number of shops in London.

Wd not employ a man who could
Earn 30/ per wk.

Special seasn demands.

Wire drawing.

agree 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 12 fair sized shops in London altogether employing he wd say. 100 weavers and 2or 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 & fireguards in winter

Wire drawing. They draw their own fine wire. buying coarse wire. This is a branch of the workers trade as is screw making.

Wire when drawn is hard & springy. It is heated again with plate & put over a charcoal

All busy or 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 looms.
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 & working to catch a tide.
Men seldom have any night jobs.

J. & P. Pill small master box worker.

His history

Piecework trade

Price list

Earnings.

June 4th. S. H. W.

J. & P. Pill. 204 Kingsland Road. N. small master box worker.

Has 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 masters may not

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

The worst men in the trade make as little as 25/-

Sprattes (the dog biscuit makers) who also

Lessons.

Skilled work.

Small men.

make hen scattle 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/.

Sax May they are the busiest 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 & suiting 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

Weavers 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.

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 Potters 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 other men he would recognize as small master house workers.

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

Messrs Farmiloe. Lead Manufacturers.

What they make.

Home of lead.

The Desilverizer.

London vies with Newcastle.

June 5th G. A. W.

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

Manufactures of Chemical lead, Sheet lead, lead pipe, Soil pipe, barrelling, Composition Gas pipe lead encased block tin pipe, Tin pipe, lead pipe washed with tin, Window lead, Laminated lead. Incorrodible Tea lead. Pumps, Solder. lead washers. 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 Sea lead.

but the centre still is for white lead but for
blue lead London is running her hard.
Farmiloe 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 Hammersmith
Grey & Morten. City lead works. Southwark Bridge
Walkes Parker & Co. Belvedere Rd. S.E. are
among the larger firms.
The lead arrives in pigs.
The branches of the business are.
lead rolling.
lead pipe making. by hydraulic pressure.
Sea lead making.
Sea lead is much made by boys as it is
light work.
It is mostly machine work. The men stay in
one department & do not shift.
It cannot be called skilled.
The men are well paid but he ct or wd not
give any particulars as in the business at
Limehouse his relations. Tow Farmiloe 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 manufacturers profits have been cut root show. 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. G. H. S.

Messrs Chatterton & Co. Lead pipe makers.
Bridge Wharf. Caledonian 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. } are the three most im-
Shot & Bullet mafr } portant branches of the trade 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 casting between two heavy stones in some very ingenious way.

Australia & Spain are the chief senders 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. They are busiest in the Autumn when the builders are ready for them & slackest 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 Timework

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 piecework'rs turned out very nearly the same amount of work in less hours ~~than~~ as in the longer ones — They used to work 59 hrs & 59 hrs —
Therefore he called his men together & told them they need not come in until they after their breakfast ie 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 ~~was~~ is almost the same in the shorter as in the longer week because he uses 'intermittent machines' ie the machines are not in use producing new

T & P.

Earnings.

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

Overtime rate.

No dinner hour.

Drink.

work the whole time. The 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) processes). 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 machine leave very little opening for difference in quality.

He showed the wage book with men earning from ~~x~~ 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 5d & 6d an hour for over 52 hours.

They have no dinner hour. two men are on each machine & while 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 Trades 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? Man can quite well look after himself. There are no Trades Unions in this 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 6½d but an older one past 40 is not. Trades Unionism has its heel 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 footpounds of work other wise the LCC will have nothing to do with him.

Unhealthiness.

Small men less liable to the poison.

Course of trade.

There is no training necessary for the men
the foreman shews a new man what to do
the 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: doesn't
know if big men have bigger entrail but
they are certainly more liable to colic.
It varies among short 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
collect the lead too pass in the system & let it
pass out again esp in very hot summer
time. They seem to be pretty careful about
washing their hands before eating.
The dust 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 was 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 sul-
phuric 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
Walkers, Parker & Co.

Alfred Hughes. art metal worker.

Brass casting = moulding.

Door plate engraving.

Tubes rwcit from Brum.

Burnisher's work.

June 7th G.H.W.

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

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

Brass casting = Brass moulding in Brum 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 do. London. The medieval metal workers all do the monumental brass & it is better paid than the door & shop plate.

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

Burnishing in brass is done with a steel tool both on the lathe & in the vice. Done by men in London & Brum.

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
y. Bronzing } go together. is the work of one man
of. Dipping } 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 buffs & sand & then with felt & polishing lime then cleaned ~~with~~ for all grease by benzoline & then finished on swan's down mops. with a little lime

Bronzing. steel buying. 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 bronzing.

Metal Annealing

Metal platers.

Spinners.

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.. } does both silver & brass
~~Perforator~~ } are usually done by one man.
Piercer. }
Plater. }

Sugg plate both white metal & brass: most chalices & alter 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 spinners. Stills in Stalton Garden.
metal is spun up for lamps. by Sugg.

Chandeliers & brackets are mostly Brass work.

Busy seasons begins towards end of Oct.
Nov. Dec. Jan & Feb. in the ordinary chandeliers & gen fittings.

Medieval work } for church work come in just
Ecclesiastical brass fittings } before Easter

Difference between Brass workers and brass finishers

Apprenticeship dying

Some T — 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, he is a worker in sheet & drawn metal.
Brass finishers, ~~brass~~ things to which the form has already been given by casting.
Wheres workers give the form.
Apprenticeship is dying out, where there are so called Apps they are not indentured lad picks it up as it can.
Diff shops have diff system: some time & some piece.
Suggs. (where he works) is on a daywork piece work system. ie each is rated at so much per hr. & works on job at piece price at Suggs there is gen a deficit at the end of the job. When there is a plus Suggs 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 ie gogue at Allesley, Benham & Frood, (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 diff.t 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 worker good man 10/ or 1/- but exceptional fair average skilled man gets 9d hr. & in leading houses gen speaking the price in London for the majority of men is 8d & 8½d.

Outside work is very uncertain where possibly you w.d not earn more than ½ a week. ie in the summer months. There are 100s 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.

Workers can begin about 8 AM the shops open at 1 on Saturdays.

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

Polishers.

Burnishers.

Employment of boys.

have been very awkward to be a total abstainer some
years ago. Now none makes a remark.
Polishers, dirty work, decent men wont go into it
if they can help.
~~8d.~~ 8d for best brass polishers
Burnisher 8d. 9d. 10d. depending.
In brass work not many boys, but it is a
standard complaint in the electric brass.
fittings in switches, bells, telephones.

C. H. Quinton. London & Prov Soc of Coppersmiths

Piecework in Breweries.

But otherwise all time work.

Numbers in London.

June 7th.

C. H. Quinton 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 S&R shop.
Small Full engineering firm such as Maudslays, Humphrys Penns.
& East End shops such as Blundells, Breckleys, Cacod & Rogner are all time.
They consider P is detrimental to the public eg. Explosion on 'Elba' killed 10 men. defective pipe made on P.
Numbers both in & out Soc are not > 450.
Coppersmiths all over London. shops rather hang round the river.
Ramsden, Bennett & Shears Kingslin, Warson City rd.

Dirty work at breweries.

Hours.

Systematic OT.

Greatest Employers.

Brazier's work.

Piecemasters in Brewery line.

In 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 'dirt' money to travelling money.

54 full hours.

Much OT in Brewery. Marine repairing, & Distillery. Always v seldom OT:

Coppers pipes & engines are all attended to by the Maudslays & Donnegeroffs men work 2 hours. OT as the regular they paying T & ¼.

T. & ¼ is p.d after 2 hrs.

Marine employ the greatest No. of Coppersmiths. Then the Breweries.

Brazing is entirely P. have a distinct Soc. called the Braziers Soc. they do jelly moulds stew pans.

Coppersmiths do a little of it.

Brazing is a lighter finer class of work - Brazing & Coppersmithing compare something like watchmakers & clockmakers. (2)

In Brewery line few piecemasters who take job at a price same as daywork piecework in preceding interview. but there are a few of them.

Apprentices

3 to one man. (is this possible?)

Seasons.

Marine & Brewery is irregular work.

Very few small men.

Apprentice must serve 5 yrs. in one shop (need not be indentured)

3 allowed to 1 man.

where shops have only 1 man 1 boy allowed.

R'boy is the poorest part of the trade ∴ they have the most holidays

No season r'boy work.

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

When they are mostly out of work is in the marine repairing shops & at the Brewery ∴ it is such a seasonal trade & men shift much from 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 knows 2 small man coppersmiths who also makes life boat cases for Forrests life boats & the other helmets & diving app.

Ships copper bottoms are always put on by shipwrights. now done chiefly with Muntzs 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 mch
1892. £261 — — — — — — — 360.—
1893. 203.9.6. — — — — — — — — 365 — —

Braziers soc. is under the hundred.

Average wages 6/ per day. wont work less than the Rlway & marine 38/ per wk.

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

Copper nails at Pontifex in Shoe lane (Farringdon 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 Birm: annealed in the fire then filled with rosin or lead & then bent to shape.

The Art Copper workers are gen called metal workers & ~~have~~ are braziers rather than coppersmiths.

Bulliant & Co. wire rope &

Numbers employed

Australian custom.

Still required.

June. 7th. G.H.D.

Pelham Bulliant. of the firm Bulliant & Co. City offices 72 ~~Gracechurch~~ Mark Lane. Works. West Ferry Road Millwall. Wire rope & netting makers.

Employs from 250 to 300 men.
In very busy years he has worked double shifts night & day. e.g. for 3 years he turned out 200 miles a week. Australia was his chief customer for wire netting to keep out the rabbits. He used to get an order for 800 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. U.

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 smaller 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 shop. 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 trust to send a way to a job with money

Shifting.

Riggers.

Earnings.

in his pocket, he will 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 dockers 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 as wire rope makers & don't understand the tucking in & bragging of broken strands.

They have no season. 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 compose
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.

Seasons.

Manufacture of shot.

June 8th G. H. W.

Mess. Walker Parker & Co. Belvedere Road Lambeth. S.E. Lead pipes. Shot & sheet lead for roofing & flooring. On an introduction to the Secretary of the Company (Mr. Strachey) 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 £3 when they are very busy ordinary men between 28/ & 30/- & labourers 24/.

Autumn is the busiest season for sporting shot in 1893. in the autumn months they made 2000 tons. ~~in~~

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.

remelted & 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. Sometimes the shot do not fall clean but are joined together. These are separated by ~~being led~~ falling from the sift along an inclined scoop over a tub divided into two portions. The round shot gets up pace over the scoop & takes a good leap into the further partition while the inferior shot rolls quietly off into the nearer one.

Larger shot & bullets are cast & then put in a revolving barrel to take off 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 remelted. 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 manufacturers 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 ~~skilled~~ are first class labourers.
They begin at 6 in the morning.
10 ½ hrs. for 5 days.
& 6—1 on Saturdays.
The men have no Trade Union.
There is no club in the shops.

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

Is there an off beer license at the end of Hessett Rd Hometon
—— a grocers on S side of Brock Rd bet Homer & Brookfield Rd
—— off beer next to pub in Churchill Rd.

511. Look up exact positions of changes. ✓
113
17.
203 —— dark Hl. St bet Stockmar & Chalgrove Cottage St ✓