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Saddler. Harness Maker. sec. 24.

Census figures for 1891.

Saddler, Harness, Whip makers, Horse clothing Rag } 3877.

Name.	Profession.	Page.
J. Wilkinson.	Whip mounts, thongs.	1
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J. Wilkinson & Son.

Stick Dressers.

Stick Finishers.

All piece work.

Seasons.

Sep. 7th G.H.D

J. Wilkinson & Son. 124 Spa Road. Bermondsey.
Whip mounts. Thongs. Handles. Scales in
whip sticks.

Will send further wages return.

Stick Dresser is the man who has given a
whip stick in the rough.
He clipes the notches off, then pares off
the bark, & then varnishes it & returns
it for the handle & thong to be put on.
Earns 35/- to 40/- in busy season.
Stick Finisher who puts on thong & handle is rather
less skilled & get 30/- to 35/- in busy time.
All work is on Piece.
The men count to earn 2/- 8d an hour: but
the whole year through they probably
do not make more than 25/-
(This was the opinion of one of the
best workmen in the shop).
September & October are slack for the best

Busy. May to Sep

Regularity. for 40 wks.

Do nothing for 12.

class of stick work but are busy month for the thread & gut work which is used by farmers.

May to Sep. are the busiest months for gut & all kinds of work for then people go out driving.

Whip Finishers get more regular employment than stick dressers. They get 40 weeks of full regular work in the year.

They put on the thongs handles & mounts

Stick dressers. of whom there are about 20 in London do not get more than 40 weeks work in the year: they work at their own homes & the best of them work for one house only but they gen. work for others on the slg when their one customer has not sufficient for them.

Prices paid for work done by a whip stick vary from 3/ to 5/- according as many notches have to be cut & fashioned.

For the remaining 12 wks neither class does anything

Shifting.

Trade.

Training.

To make a whip.

They shift from house to house but have no alternative trade

1891. was busy.
92. falling rapidly.
93. very bad.

Stick dressing runs in families, the men are generally dressers because their fathers were. The skill varies with the class of stick. There are some men whom you wd never think of giving the very best work to, while others will not touch anything under 1/- per stick.

Finishers are usually apprenticed for 7 years & then learn not only finishing but dressing & the whole trade throughout.

It is not hard work & men last as long as life does.

The sticks come in the rough from Kent, Sussex, & Hampshire & are generally made of holly. Some come from France but they are generally too pithy.

The wood is kept 2 years to season when seasoned it is given out to the stick

Dresser who cuts the backs & straightens it.
He returns it to the ship maker who
stains & varnishes it (3 coats).
it is then ready for the handle & mounts
& stays wh are put on by the finisher.

Division of trade.

Finisher { fixes handles
" mounts.
'quills' up.
Ties thong to stick.

No sick club.

Rents of two of the men's town.

2 room.
1 Kitchen.
1 washhouse.
1 garden 20 ft long } 6/- wkly. in Spa Road.

4 rooms. washhouse. } 7/6. in Clerkall Rd
15 ft garden Rotherhithe

Americans will have whips & saddlery from
London. Smaine Rotterdam. Schomberg (for

Duties of a finisher.

Rents of men's rooms.

West End demand.

drag whips/ are the best whip makers.
These west end stores also provide curious crooked whips which an ordinary whip maker w.d not look at. Smart young men like to have something out of the way & will pay a large price for a whip with a bend in the middle.
Swaine & Adeney & Schomberg make their own whips & their men have sick clubs.
Americans run after rabbit bitten holly sticks for whip handles
When there is snow on the ground the rabbits bite off parts of the holly bark, then next then bea years growth, part of the bark will grow but where their saliva has run down it does not. A very pretty polish Can be put on such handles & big makers will give as much as 2/- each for them.

Drink.

Complained a great deal of drink & large families in Bermondsey

Seamless handles. These are the invention of Mr Wilkinson & are made from calves tails wh. are tanned & sewed. etc.

Brown Saddlers.

Wages.

Hours.

Sep. 11th. G. H. D.

Geo Smith & Co. Saddlers & Harness-makers
151. Strand W.C.

Brown saddlers are the aristocrats of the trade, their work is paid more highly & they consider themselves the pick of the trade.
They make hunting & other racing saddles for which the men are paid 18/6 each in the Strand & East End trade and 24/6. in the Hay market & West End.
But for the 24/6 the men have to put in a great of extra & what Mr Smith called unnecessary work.
Two saddles a week is considered good work in West End shops.
Each shop has probably a different rate of pay & different hours.
Here they work 56½.
7.30 to 7.30 with 2 hours for meals and 7.30 to 2. (without dinner hour on Sat.

Black Saddlers.

Harness makers.

Collar makers.

Saddle tree makers.

All saddlers throughout the trade work on piece.
I one man whose book he shewed me had drawn. £3. £3/10/. £3.15. £2.10. £2. the lowest in the year being £2 & it being nearly always bet £3 & £3.15.
Out of this however 1/- had to be deducted for a boy who worked with him.

Black saddlers. ie those who make draw harness saddles. They earn about 25/ per week. Their work is generally in basqued leather which is sold slightly cheaper than brown leather because the faults in the leather can be hidden by the blacking.

Harness makers. These men work day-work & earn about 25/ a week. The men stitch the harness which is heavy. Mr J. knew one very quick stitcher who could earn 35/ but he was an exception.

Collar makers. These men are well paid. they form a branche by themselves as do the Saddle tree makers. who make the saddle frame

Regularity.

Shifting &c.
Seasons.

Apprentice system dying.

which is made of steel or iron & beech wood
& cost from 12/- the cheapest to 30/-
each.

All the men in Mr Smith have had full employment until this year. Now they have so much stock on hand that they have for the first time turned men off. The remaining men have full work & slackness is not met by reducing men's work all round.

Men shift a good deal from house to house.

Seasons are not now so much marked as formerly. Mr Smith being chiefly an export trade there used to be a brisk demand in the Autumn from officers going abroad & a very slack time in the Spring, now without any apparent reason the seasons are much more equal. January & June used always to be slack.

Training by the Apprentice system is dying out. Men used to be willing to pay £50 premium & have their sons well taught from 14 years to 21. Now boys are taken on

How a boy is taught Saddlemaking.

& first to work with men they help the men
there they can & 4/- per week is
deducted weekly from a man's earnings
to pay a new boy. At 21. they earn 9/-
or 11/- per week & are still paid out of
the men's piecework earnings.
After that they generally go away &
seek work as an improver & will make
an av of 25/- until they are valuable
enough to get full piecework prices

Nothing unhealthy.

There is nothing unhealthy: one of their men
has been with them 45 years & says
he can do as good or even better
work now than formerly.

No sick club.

There is no sick club: most of the men be-
long to one of the Unions which is
nothing but a benefit club.

2 Unions.

There are 2 Unions (one the sick club & the
other a proper union with the "ordinary
union avowed objects."

Women as stitchers.

Women are employed to do all the stitching
work in a saddle. They earn 10/-
a week & very often do their work at

Saddle frame.

To make a saddle.

Walsall is the centre.

Harness makers recruited from the country.

Lone

A saddle is made by 1st getting the saddle frame.

Then broad bands are stretched down-wards & across & form a springy bed. These are then covered with a very loosely made cloth. A hole is slit in the cloth & the slit is beeswaxed to prevent fraying. Then stuffing is introduced & worked into place through the loosely made cloth with a sharply pointed instrument. The leather is then fitted, cut to shape & nailed in position on the beech-wood. Then the seams are sewn & the weltings made by women.

Walsall is the centre of the trade.

All harness fittings are cast in the mid(s) for very high class work they are foled up in London but for most work they are sent already finished.

Harness makers are recruited from the country

Small country makers make their own harness but generally buy their saddles

Course of Trade.

From some large maker.
Trade in 91 was good.
92. — falling off.
93 — very bad.
Men are allowed to draw their piecework wages in advance, this is one of the troubles of the trade, they nearly always draw too much & have a balance against them.

Was very friendly & gave introduction to whip makers & saddle-tree maker.

Walsall's best work looks better than London's best the difference is that London work is made to fit a particular horse, while in the country they are all made to suit a given pattern.

Messrs Swaine & Adeney.

Stick Dressers.

Wages.

Finishers.

Mounters.

Braiders.

Sept. 12th G.H.D.

Messrs Swaine & Adeney; Driving & riding whip makers. 185 Piccadilly.

Stick dressers. work at home, their business seems to run in families a father teaches his son & gets his son to help him
They do their work by piece & get 4½ to 4/6 for every stick they dress.
Sticks come from Kent Sussex & France, the best ones from Kent.
Theirs is skilled work: in a good week they will earn 35/- to 45/- in a slacker week in dead season they will prob. make about 30/-

Finishers. Those who 'quill up' & fix things to whips. & hunting crops.
earn from £2 to £2.10.0 per week

Mounters. those who put on the button (ie bottom mount of a whip): these are a separate part of the gold & silversmiths trade.

Braiders. ie those who with a machine braid

Thong makers.

Regularity.

Overtime.

Average earnings.

hunting crops: this work is always done by women at home with a machine for the purpose: they work on piece and earn between 10/ & 12/- per week.

Thong makers. is a trade of small masters: these masters only teach the men how to plait the leather: the cutting of the straps they keep as a secret to themselves. These men are given 33/- for 3 dozen thongs they have to supply the materials themselves which probably cost 8/- or 12/-

All men have 52 weeks work in the year (they employ about 13-15 men). Thong trade has been very slack they have had enough not to have to turn off any men.

In busy times there is a good deal of overtime: the men would rather work overtime than take on new hands. In the season the men often work from 7 AM until 9 PM.

The average earnings for a busy week is 40/- while for a slack week men get 30/- to 35/-. The work is hard & the men must work hard to make money

No shifting.

There is no shifting from Branch to Branch or any alternative trade. Whip stick makers never become walking stick makers. & men very seldom can make both riding & driving whips.

Trade.

Trade was good in 1891. in 92 came Prince of Wales death & trade declined: 93 is one of the quietest seasons ever experienced.

Skill required.

The Finer class of stick dressing ie where sham knots & a great many of them have to be made is the most skilled part. It also requires some considerable skill to make worm buttons ie the plaited wire rings round the whip handles. & also round the joints of crops where they take the place of a mount. This is all done by hand, & men can make one in perhaps 1½ hours.

Apprentices.

Apprentices do not pay so we S & Adcock do not take any. It pays them better to take on men who are already skilled The stick finishers are recruited chiefly from Birmingham & most of their men

Training.

No sick club.

The actual work done
on the Premises to driving whips

have already worked in B where the bulk of the whip trade is carried on & where very good whips are to be had.

Stick-Dressers are in London & come from London. Fathers teach their sons & it runs in families.

The men have a sick club among themselves with which the firm have nothing to do.

The chief trade of the firm is with the Continent & with America.

Australia buys chiefly from Birmingham.

Driving whips are really only put together & polished in the shops.

There are 3 floors of workroom fairly light & airy behind the Piccadilly shop.

The rough stick is bought & prepared & straightened for the Dresser. The stick that is naturally straight is marked with 3 notches at the bottom while another which must be straightened by heat in a flue is notched ||.

Then it is sent to the dresser who makes it smooth with a file & peels off the bark

To make a Hunting crop.

puts a more notches where wanted.
Then the handle is fixed on & it is sent to be mounted. Then the thong is quilled on to the top & the whip is complete except for varnish & polishing wh. is done by hand.

Hunting crops & ladies whips are made of cane and whale bone (whalebone now costs 3s/- a lb/ it was so expensive some years ago that none could use it so that the price had to go down.
Now it is used mixed with cane: a piece is chosen of the required length & planed square. so that the spring in every part may be equal.
Then strips of cane & whalebone are taken & fixed on by means of pitch to the centre piece of whalebone. The whole is then planed ~~the~~ with a taper towards the point:
This is rubbed over with pitch & again alternate layers of whalebone & cane are placed round about, the whole bound up & then moved through a gas jet to melt the pitch & make a good join of the whole together; this done it is again

planed true & then wrapped round with tow:
then it is rolled tight in a machine &
when cold is ready to go to the braider.

"Flashy young men like whips with a great
many knots, & sporting gents a whip
which has a curl in the middle."

Mr Swaine (?) was v. friendly: said he cd not speak abt
the trade generally as he only knew his own
business. He thought there was a good deal done
at home & then sold to cabbies & carters,
hawked round as soon as made: & recommended
the reading of Henry Mayhew's account of
the itinerant whipmaker in The Land & Labour
of London Poor. This he said was very true
40 years ago but there had been many
changes since.

Humphreys. Harness maker.

Saddlers.

Divisions.

Blacksaddlers.

Sep. 13. G. H. D.

F. J. Humphreys. Harness maker. Baker Street Bazaar.
Sells & repairs saddles but does not make them.
He has himself been in the Trade 50 yrs starting with a 5yr. apprenticeship of 5. He only completed 3. Has been in all the best West End Houses & claims to know the trade thoroughly.

Saddlers. A man generally starts as a flap & panel hand & then works his way up to becoming a full blown saddler who can take a saddle tree & finish it into a saddle.
Saddlers proper are divided into sidesaddle hands & hunting saddle hands.
The minimum pay for a full week's work is 28/-. The Union decrees this.

Black saddlers. These who make driving saddles are not so well paid but their minimum is 28/- also.

Harness makers.

Wages.

The union v Piecework.
Rates.

Hours.

Harness makers, all work on piece, all the men belong to the Union & earn from 25/- to 42/- per full week (56 hours). Just now things are very slack & the men refuse to work full time even where they have the chance in order to spread the work more evenly.
They have a book of piecework rates for almost every description of work, supplied by the union:
All good masters employ Union men only & pay union rates.
All the best men in the trade belong to the Union.
Where there is no price in the piece rate book the Union recommends the men not to accept less than 9d an hour

41

The men are now working from 9 AM until 7 PM with 1½ hours for meals.
As in all trades where piecework prevails, the public holidays are not paid for. This is only the case where

Regularity.

Prosperity 1887-91.

Seasons

May 1. for carmen's harness.

men are engaged by the week.

Regularity. As work for all men has been the rule until this year when things are abnormally quiet.

The first thing that a man gives up when he finds his income diminishing is his horse & carriage & with the trouble this year, this is what has happened & there is no demand for harness. 1887-91 were most prosperous years; when all the harness went & saddles too & it does not know but there was a demand for it. The men may come in at 7.30 AM & work until 8 if they like

The London season is the busiest time, & the Autumn for saddles.

For lower class harness May 1. is the great day for dressing new harness this is not so much the case as it once was but to a great extent the custom still prevails.

It may happen that one house is slack while another

All busy or slack together.

2 Benefit Societies in the Trade.

Diff bet London & Provincial work.

Collar making.

is busy, for orders for the renewal of the harness may fall in all together, but as a rule all are busy or slack together.

There is no sick club in the shop but there are two Benefit Societies in the Trade.

1. The Amicable Benefit Soc of Saddlers & Harness makers Bridle cutters & Collar makers.
Held at the 'Prince Albert' 5 Upper St Martin's Lane. Instituted 1779.
This is failing now for want of proper support.

2. Pension Fund Association.

The difference between London & Birmingham work is that things are not manufactured 'ready made', nearly all London work is made to order & each horse is measured.

Collar making is a distinct branch, the men are skilled & well-paid & make their collars to fit. In the midlands all are made after a given pattern. London is the centre of the very best har-

Training.

Women empld for horse rugs & stitching saddles.

ness. making supplies the world.
There is no kind of foreign competition, nor ever thinks of buying foreign harness or saddlery & the trade is probably unique in this respect

Training. Harness-makers have generally been apprenticed in the country & then come up to town & better themselves. The App system is dying out gradually but still in vogue in the country.
Birmingham men are not straightway fit for London harness work so much is the work by women cops the sewing that a man will only know how to cut out the leather: in London he must to the whole job himself

Women are employed in horse cloth making & in sewing saddle

Has cheerfully gave further wages for his men. & offered any further help.

W. Betts, saddle tree maker.

Divisions of trainers.
Average

No season.

All have regular work.

No shifting.

Sept. 14th G. H. S.

W. Betts. Saddle-tree maker. 40 Charles Square Hoxton n an introduction from Mr Geo Smith.

Divisions. 1. Saddle tree makers. 12/- women.
" " Riveters. } 40s av.
" " Canvassers. }

All work is piece work & every part is made in London except the 'Bars' which come from Birmingham Walsall.

There are no seasons.

Though there is a tendency to be busier for the hunting & park season: most of the work however goes abroad so that seasons are not of much account for the diff. parts of the world balance one another.

All the men have regular work if they will but they go on the booze for weeks together.

There is no shifting, each man sticks to his own.

Trade was very bad this year 93. was pretty

Training

79.

Age.

Govt. saddletrees made by
Cabinet makers.

To make a saddle tree.

fairs in 91 but falling in 92.
The men admit no apprentices except the
sons of men already in the business.
There are only 4 apprentices now working
in the London Trade
A man is allowed to bring his son into the shop
& get what work he can out of him; pay
is given to the Father for the amount of work
he can turn out with his son to help him.
This goes on until the Son breaks off & settles
to work for himself.
Though they are hard drinkers they are "like Donkeys
never die, to do so are to memmon ages."
Govt. military trees are generally made by
Cabinet makers.
Saddle-trees are made out of split beech wood,
the wood is not sawn but always split
with the grain wh. makes it very durable.
The wood is split & trimmed with an axe
to a rough shape & then is worked &
fitted by a man with a two handled
Knife. This he uses by paring towards
himself (something like cutting thin bread &

fasten with a strap over the shoulders.

Beechshavings & Vinegar.

Drink.

butter though there is a block of wood against his chest to prevent any damage should the knife slip.

The riveting is done by forging bars of iron into the shape required & fitting them to each tree in turn.

Then the whole is covered with canvas & glue (the wooden parts have been glued together already) - dirty work - by a woman.

The beech shavings are sold to Cross & Blackwell & help in the manufacture of vinegar.

There are only 2 big makers of saddle trees in London, there is no & employs 10 men.

The men drink hard (said there has been a slight improvement these last 5 years & it is not so bad as in the midlands (Birmingham) where it is no uncommon thing for men to go on the booze for a month).

The men work as they like & when they like, they have successfully resisted the introduction of machinery, all men are Union men.

Mark 'Dead Horse'

There is a great deal of drawing on account & consequently much 'Dead Horse' in the wages book against each man's name. This he is compelled by his society to pay off before he can seek employment elsewhere. The men from the midlands are not now allowed to come into the London trade though a London man may go to Birmingham & then come back to London if he likes.

2 workmens room in the neighbourhood cost 6/6 & 7/6. weekly. said Mr Betts.

Mr B. let me take away one book containing the wages of two of his best men which have been copied & shew the dragging periods & 'dead loss'. Ther are unusually favourable Examples he said.

1 man in the iron shops. 4/- for 1 room
another - - - - - 4/6. for a front room

Military Harness & Accoutrements.

Unionists all.

Wages & Hours.

Piece.

A little Day work.

Age.

Sep. 19th G. H. L.

J. A. Smith 108 Aldermaston Road. secy to the Military Harness, Accoutrement & Saddlers Trades Union. aff to Trades Council.

Started Aug. 8. 1888.
120 men in the Trade now.
All are Unionists.
Of them 80 are Helmet makers
Wages. Lowest men earn. 20/ 25/.
middle . . . 25/ 30/. } in Bag room
Best. 30/ 40/. }
All work is on piece.
The men average 6½ an hour now where the av. in 86. 87. 88/ (before the Sweating commission) was. 2½. This rise has been obtained by the Union.
9 hours is reckoned as the full day.
There is a little day work in the cutting room
Age is no matter, men are good workmen up

Seasons.

till 70 & middleaged men (one of whom is his Smiths) are the best.
Autumn & Spring are the busy season for the Volunteer manoeuvres
Mid winter is slack.
Contracts that are given out in August can be got to work on in September.

Overtime

In October some overtime is worked.
Some men are fully employed all the year round & these men who are married to a farm, that is they could not be certain of getting a job elsewhere & therefore stick on where they are.
Hackers & Accoutrements makers recognise one another's ticket wherever they are.

Shifting.

The men shift on one place or house to another as the contracts are placed. Men shift often it is nothing against a man to shift. & to have been employed in a great many different houses.

Contracts gone to Birmingham.

Lately a great many have gone to Birmingham. Wages are lower there and the contracts have been given out there since the dispute

Shifting to other Trades.

'A Mush'

No system of App.

Shoddy work.
Incompetent Inspectors.

Trade recruited from Boys.

in London wages.
When things are bad the men in the Trade go to the Boot-trade: play accordions to the Docks, turn riggers: or go out 'mashing'.
A 'mush' is a man who owns 2 or 3 Cabs of his own either permanently or for a short time.
It is a term of abuse to a Cabman to call him a 'mush'
There is no system of Apprenticeship except in the Harness Trade. whence the Saddler-maker also draw some of their men.
Military Harness has to be very strong it is much heavier than ordinary Harness.
There is a good deal of shifty work put in but not nearly so much as formerly because the Govt inspectors are not such Incompetent men.
The Trade is recruited from Boys who come in to rub up Harness: then they rivet: then they sew.

Admission to Society.

Manufacturing Houses in order of merit.

Union trying to break System of the subdivision of labour.

For admission to the Union, a man must be a competent worker in one or other branches, then he must be proposed & seconded & then election.

The relations with the employers depends on the contract. If the masters has got a good contract & can make his profit & pay good wages then they are good.

Order of merit of Stone in Trade.

Masons & Accents.		Stokers & Caps.	
Mr. Burgess.		Hotson.	
" Robert Hunt.	best.	Stone.	best.
" Almond		Silverton	
" Wallis		Herbert.	good.
" Hotson.	retrograd.	Almond.	"
" Herbert.	worst.	Blomfield.	
" Pallman.	unfair.	Christies.	worst.

The Trade is much less subdivided now than it used to be thanks to the Union. which is trying to break the system of diff[t] people doing diff[t] parts of a job.

Method of making Harness.

Birmingham & Walsall get a better finish than London but stitching is not so good. Trade there v. subdivided.

Women for Buff Leather.

You take your hide to make harness.

1. Cutters cut it.
2. Preparers who get it ready for sewers or rivetters by pricking & punching it.
3. Sewers sew it.
4. Goes back to the preparers to be finished off. Brown leather with glue & Black with ink on the edges only which are then polished by rubbing up & down with a glue rag.
5. It is 'creased' ie the brown line is put on by the heated creaser. along the edge.

Names of tools used.

1. Button holer or awl punch.
2. Head Knife to cut the round piece at th end.
3. oval & round punches (for making holes).
4. Prick iron for marking the stitches.
5. Creaser. & iron for crease on the edge.
6. Edge tool.

Women work at Buff contracts, now there are not so but sometimes there are 150

Drink.

House rents in Bermondsey.

Trade Slang.
'Cows'.
'Jacksons'
'Mumpers'.
'Calf'

in the trade, they migrate from the fam factory.
Drink was a great evil: the old hands still drink but the younger men are not so much addicted.
Mr Smith pays 10/- a week for 6 rooms & entrance & a yard 16 x 8 ft.
& the same is the rent of all houses down the street (Aldermiston Rd Bermondsey).
In the Leyton Road you pay 13/- for the same thing.
Trade slang.
Bad or rejected helmets are called 'Cows'.
Starveys rejections - - - - 'Jacksons' ie (fractions).
Mumpers are those who say they belong to any trade
'Dead Horse' is sometimes called 'Calf' which is really the Birmingham term.

On June. 12. 1888. March 26. 1889. } see first report
" 28 - - - }
April " - - - } on Sweating syste
" 12 - - - } pp. 458 - - -
for information with ref to the trade.

Horse collar maker.

Divisions of Business.

Earnings.

Oct. 25th G. H. D.

J. Briggs. Horse collar makers. Stoxton Market. on an introduction from Mr Baths the saddle tree maker. (p 23).

Mr Briggs himself was away at Margate where he had been for some months for his health, his foreman who had been secty to the Union for 18 years but had lately given it up in favour of Mr Joynt. took me round & explained all.

They employ 8 men. 2 women & 2 boys.

Forehale fillers.
Bodyers.
Finishers to put on the after-whele.

All these earn about 30/- per week in a slack week or a busy wk.
Women are employed to sew the afterwhale on to the body and are generally

Women's work.

Seasons.

Regularity.

Shifting.

the wives of horse collar makers: where these are not willing to do it then other women are engaged, if these are not willing then the men must do it themselves (he did not say the work was particularly hard or disagreeable but it must be heavy as it is necessary to sew through patent leather or to a 'basil' binding).

The busy season begins in January & lasts till October. Nobody buys new collars from Oct to Jan. The fog hides defects & in the winter noone rotten shabbiness.

All the men have regular work throughout the year. There is some fear that short time will have to be worked now as things are so bad but such a thing has never happened before.

There is no shifting to any other trade, the men are not capable of doing anything else. A great many of the men have been in Birmingham & Walsall where good collars are also made, but they are

Training.

Number of men in Trade.

Deaf & dumb.

Healthy.

there made in certain given sizes only and not to suit particular horses.

The Business is taught to Apprentices entirely. In London the Union allows 3 App to 10 men but in the country not more than 2 to 10 & they are very strict about it.

He would say there were 106 men in the Trade in London of whom all exc 10 were Unionists.

5 years to learn. There are a good many deaf & dumb in the line who are apprenticed by societies to certain masters but either they were unnaturally stupid or the masters to whom they were apprenticed did not trouble to teach them every part of the business, certainly the one in the shop was not up to much & had not learnt more than ½ his trade in 5 years.

It is very healthy: somehow he said everything to do with the preparation of leather & working of it was healthy.

Drink better owing to Union.

Hoxton Market the worst neighbourhood in London.

Rents.

Conditions of work.

80

The men drink a good deal but since the Union was started they had certainly improved there is less "Dead Horse" – what the Tailors call "Dead figs" – "than there used to be. The men knew more the value of money now.

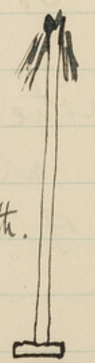
Hoxton market Mrs Betts & the foreman told me was the most disreputable neighbourhood in London. None would dare to walk about without alone at night you were sure to be attacked.

Rents were from 3/- to 3/6. for one room
to 6/- 6/6. -- 2 ---

there was a printed notice in one tenement saying that only respectable lodgers with furniture of their own need apply.

There were 4 rooms to the Factory: which was very small, dark & untidy looking 2 on the ground floor.
1 underground wh. I did not see.

<u>The manufacture of a horse-collar.</u>



rod with bits of straw across the tooth.

Lead hammer for shaping the straw.

& me upstairs when the leather is cut to shape.

The leather used is sheepskin which is cut to shape & then roughly sewn & then filled with straw.

The straw comes from France & is used in short lengths. The leather is damped & then the straw is forced in with a long steel rod with a fork or tooth at one end & a flat head.

the straw is held by the tooth & ~~hitt~~ & then poked in to the leather tube & rammed down by stamping the head against a foot board which is a thick block of wood let about 18 inches into the ground.

The shape is given by hitting with an oval headed mallet of lead.

The measurements only are given, the men have no pattern to work to but must judge by their eye only, so that it is a skilled handicraft.

Men usually learn every branch & then

No foreign competition

confine themselves to that at which they are best.

There is no foreign competition, collars are even exported from London.

Some French workmen who were taken round not long ago confessed that they could not do anything to touch English work in this respect.

Bull of Sheffield the latter of whom employs 20 men are about the largest makers in London.

Oct 26th. G. H. D.

Chaise Saddlers Society.

Founded.

Numbers.

Unionists do not work with Non Unionists.

Good relations with masters exc with Jenkinsons.

F. Whisker. 16. Lawrance Road. Old Ford. E.
sec'y to the London. Chaise saddlers.
Trade Protection society.
not affiliated to T.C.

Founded. March. 1890.
47. members out of a possible ~~79~~ 49 journeymen. 70
in London but includes small masters.

Chaise saddlers. Pad makers. (only 5). these last properly go with the saddlers & harness makers soc.
60 members highest in 1890.
47. - .. lowest. 1893.

U & Non U. do not work together.

Relations are very good with masters except now with Jenkinsons in 44 London Wall, a sweating place, this has already lasted for 4 months — 5 men were withdrawn all but two have now got work elsewhere. Jenkinsons have shifted their saddle making to the country but they do not know where.

Nearly all Piece.

Womens work.

55% of flaps in total trade
are sewn by men & boys.
in v. slack times the men sew their own work.

Work subdivided in small houses.

Union not strong enough to enforce its price list

Prices for making saddles.

Nearly all piece work: only about 4 men work on day work, one of whom is a foreman.
A chaise saddle & a gig saddle like a cab saddle.
A man is given a saddle tree who then takes it & finishes it - throughout exc. that women sew the flaps & the serge underneath.
about 50% of the men do the saddle themselves alone exc for the women: but in the very small houses the work is subdivided just the reverse to what ordinarily occurs in other trades.
They have not been able to bring out a piece work list & not two shops work alike. (They have got a price-book out but not one firm follows it & they are not able to enforce it). The prices are rather above those paid by the best firms at present.
Saddle made from 5/ to 18/
5/ are common gigs without sewing veging no womens work exc. 3d for the sewing of the serge against the horses back.

Amount of week's work

Average earnings

Seasons.

Work shared in slack times.

The av- price for cab saddles is 7/-
The best West end trees are made to order if you are told whether to make wide or narrow fittings according as the horse is mud or has narrow high withers.
5 of the very best can be made in the week but only by very quick men, ordinary men make about 4.
10 Of the common sort ones generally include some of one some of another quality.
a very quick man can earn.
The average earnings right through the London trade are 32/- throughout the year.
Winter is slack. earnings what you can get
Summer is busy. " £2.
It all depends on a mans quickness how much he can earn.
In slack time the work is shared all round.
The London season makes the difference.
Walsall is the great centre where a great many women do what in London is considered mens work. Such as sewing down the saddles, binding cantles is the

Busy time begins at Easter.

All busy together.

Foreign work.

Good Firms.

Small masters.

part behind.
Just about Easter they reckon to start working longer hours. according to Trade, as a rule masters work long hours, it is difficult to find men when things are busy.
All shops are busy together - Wal all does the largest export trade & London a little we should supply the world if it were not for the high import duties.
Nothing can beat English work for solidity & durability.
French Carvers is very neat but not so solid, machines are used largely in Paris but W has been there
Good Firms are.
Bliss's in Sun St.
Walters & Crouts.
They are trying to get the work of the whole trade like this but the small masters spoil the trade.
The majority of small masters are workmen who have had a row with the foreman

Good till any age.

Retailers.

Training.

Admission to Soc.

Names of small masters.

Bliss's do all work on the premises by their own men. age. the woman's work.

Men are good workmen till v. old, 2 a good workm in Walters shop are 70 & 71 still working a piece but not such quick workers earning good wages. say.

The wages are paid to the men for work done the men then employ women gen sadlrs widows or daughters.

One woman works for 3 or four men at a time.

Retailers never (handsewn) makes the chairs saddles themselves just as they never make the collars. Retailers are only practical harness or saddle makers.

Training always by apprentices indentured for 5-6-7 years. mostly premiumed beginning at 13 or 14. Earning according to amount of premium.

Man must be a skilled workman, all new men must join soc. within a fortnight.

Whittingham. Tidcob. Day. Milicher. Grabham

1 App to 5 men enforced. Wakefield Stores.

3 to be limit anywhere

Wholesale houses.

Wholesale Houses.

Wholesale firms are very good about making up for stock in slack time. Wellers are leaving off now at 5½ instead of 7.

Benefits.

The men very steady.

men employed.
13 Bliss. Sun St. Finsbury
3. Walters & Son. Market St. "
Jenkinson London wall (Do not make in London now)
2. Grant. Wormwood St. EC. (Wholesale & retail).

The rest of the 47 are all the small master saddlers. of whom there are about 8 employing from one to 6 hands.

Benefits.
No sick fund.
Out of work. 10/- for 2 wks } Then no more.
5/- ------ }
Death. £1. for members only.
No pension.
Subscription 3d. per wk.

Said employers will give more if they could get more. All the good West End work is done in London. but there is not enough to employ more than
There is no such thing as west E & City East End price. Most firms have shop clubs. (in the 4 mentioned above) Men a very steady lot, always has been, & to get better now.

Messrs Blies & Co.
Whole sale saddlers etc.

Division of Business. wages.

Piece.

Hours.

All regular.

Oct. 27th £. s. d.

Messrs Blies, Beauchamp & Co. 13-17. Sun Street Finsbury. Saddlers, Harness makers. Saddlers' Ironmongers.

They employ 120 men (including 27 women).

Brass saddlers	40/-	45/-
Black Saddlers.	30/-	35/-
Harness makers.	30/-	36/-
Bridle cutters.	35/-	40/-
Horse clothing mkrs.	15/-	w.

Very nearly all work is on piece.

Hours. 9 — 6.
9 - 2 Saturdays.
1 hr. for lunch.
20 min for tea.

All the men get 52 weeks work in the year.

For Saddlers & horse clothing the winter months are the busiest. for the hunting season when people want warm

Fashion.

No shifting.

Woman's work.

coverings for their horses
They make for stock when they do not
make for actual orders.
There is a certain amount of fashion within
narrow lines, last year there was a
run on Whippey's goods, this year
Champion & Wilton is the most fashion-
-able men. There are just little pe-
-culiarities which outsiders do not no-
-tice such a diff^t buckle etc but
in the main there is very little change.
There is no shifting: each branch is a
separate trade & worked at by men
who do not change from one to the
other
He did not know how much pig saddle makers
paid to women for sewing the flaps.
Women did some of the very fine bridle
sewing, the finest of which was
16 stitches to the inch, the number is
pricked & then sewed according the
hole being made with an awl &
then the needle pushed through.

Horseclothing.

French work.

Mr Edwin Bliss.

Machine work.

Two needles & thread are worked with at the same time.
Machines are used for doing the horse-clothing worked by women who earn about 15/-
The letters & crests are also made here but the embroidery work is given out.
Horseclothing is made more in London than elsewhere very well made -
The cloth comes from Chipping Norton (the best) when Mr Bliss has a connection & costs 7/6 a yard.
French do very neat work but not so durable.

Mr Edwin Bliss the senior partner was not he was not in favour of giving exact wages returns but the two partners who showed me over were asked me to call in some morning about 10-15 to see Mr Bliss explain myself.
Saddle flaps are mostly done by hand work. much stronger, stitches do not run.

Wholesale & Retail Prices

but Davis's of the Strand uses put machine work into their cheap £3.3.0 saddles.

The cheap saddles that Mr Bliss sells for £3.0. are resold by saddlers for £3.3.0 the expensive saddles that are retailed at £6.6.0 with the very best work & material are sold by Mr Bliss for £5.0/-

No name or trade mark is put on any of their work, retailers wont have it they like their customers to think that they make everything themselves. whereas they make only saddles & harness.

Messrs Jenkinson

His workshops.

All piecework.

Oct. 31. F. H. S.

Messrs Jenkinson & Co. Saddlers, ironmongers horse clothing - 44 London Wall. Wholesale & export. on an introduction from Messrs Swaine & Adeney.

Said he employed about 120 men & perhaps 3 times that number off the premises.
He will send full wages Returns & also fill up the employers form.
He would not see me for more than 10 minutes but sent his foreman with me round the works with an injunction that I was to ask no questions as I went round.
The workshops which are on the opposite side of the road to the shop itself are light & airy rooms but very dirty & untidily kept.
All the men women & boys were on piecework

Women & Boys.

Govt. work.

Gig saddles.

The seasons has f. said balanced one anothe
in the different departments, but the
men do not interchange.

A great many women & boys were noticed,
women doing bridle sewing & also
heavier work & boys sewing heavy
traces. (This was one of the Union
complaints). Their stitching was a
neat but did not seem to be so
well pulled through as that of
the men. Women & boys can easily
be strong enough to do this kind of
work well.

They have a great order for hose bags.

Gig saddles they now make in the
country. (There was a great deal
of hesitation in saying this first. They
said they were made on the premises,
then in another part of London,
& finally in the country). There has
just been a strike & all the Gig
saddlers called out: Mess Jenkins
will only pay 4 seating pieces but

Spurs.

Mr J. the foreman made no allusion to this.
nor did I.

Very few stirrups are made in London.
There is one small maker named Smart
in Soho somewhere but the majority
come from Walsall & Birmingham.
The only great demand is for army spurs
none of which are made in London.

A spur should be of wrought iron overlaid
with brass & then silvered.

Oct. 17th G.H.S

J. T. Morrison. London Saddle & Harness Making Trade Protection Soc. meeting 5 Up par St Martins Lane.
Gen meetings 1st Mondays.
Delegates 3. - - - s
Executive 4th . . .

Started Sep. 24. 1872.

658 members & books out of a possible 1200 in London. (not all financial). these are unquestionably the picked workmen of the Trade.
This is the highest they have ever had. Lowest about 300 in 1875.
The two do work together.
Relations are very good now & always have been
Collar makers, brown saddlers, black saddlers harness makers are all distinct & bridle cutters (very little done in London, most

No particular board of arbitration

Hours.

Minimum wage.

Time & piece work.

in Walsall where women do it.
No recog. board of arbitration though in harmony with London Chamber of Commerce conciliation & arbitration board of wh. Mr M is the "leather" member.

50½ hours. full working week.
O.T. is forbidden by the Union & it is fairly well carried out by the employers. They are threatened by the opp. of one working man (Whitby. Stapleton & Co. North Ayrshire) who will employ any men who agree they will work O.T. when necessary. The Union aims that this shd not be done while any boards are vacant.

Minimum wage. 30/- wk. Timework:
Some piece work men earn less but not more than 1 in 200.
The is a majority of day workers.
only 40 % on piece in harness.
but 75 ... ... brass saddlers.
Black saddlers & collar makers mostly piece. (each have an organization of their own).
Bridle cutters mostly day.

27% of employers are not practical men.

Ages of capacity.

Less seasons than 20 years ago.

Seasons.

No diff. bet east End wages & work recognized.
Not. 27% of the employers who are not practical men; workhouses in the city make the 27%.
16-65 years of age are the gen. age.
very healthy & not very laborious trade though this cannot be said to be due to the workshops supplied by the employers which are bad.
He has only seen one man who has ever seen a factory inspector.
Trade reorganised in last 20 yrs. with regard to season work.
20 yrs ago. harness makers flocked to town about March & had work till the end of July, working OT during the whole period.
Now this is altered, Trade is more general American & colonial trade has made more equability.
Harness season is busier. March to end of Aug.
∴ Park season.
Saddlers are busier. Sep — March ∴ busy

Work shared in slack times.

No shifting.

Strikes

Shifting to other employers.

Black saddlers,
Collar makers } follow with Harness & bridle
cutters with the saddlers.
In slack times the work is gen. shared
fashion does not affect harness or saddlers
in this they are exceptionally fortunate
The only new fashion is to have longer
narrower saddle for polo players.
No shifting -
Black saddlers do become a stitchers but
the trade do not encourage it.
The Union is very strong against the division
of labour.
Strikes: 19. since starting including lock-outs
3 serious ones.
1. in 74 at Jenkinsons for an increase
— 87 v. idea of Lady Aces working for Artistic wages.
who the work his work to well all.
Have spent over £650 up to present in strikes &
lock outs.
given to other T. U. more than £600.
Shifting to other employers is not usual. but
is done. Big orders are not of a
frequent occurrence, men give their
orders very regularly.

Training

Apprentices in the Country.

Girls & boys in City work.

Very Temporate.

in slack times men flock to army work if there is any about, but army work goes gen to Birmingham & Walsall where men get 7½ a hour for Govt contracts.

Train by Apprenticeship only.
Employers wont have Appts in London.
all must lads serve their Appp. in the country.
Trade is recruited from the country.
only 7 out of 33 at Mr Mus. firm have learnt in London.
Wilkinson Kidds, Chas Hand Peats.
Crates. 20 (excl) have gone also learnt in London.

In the city Lad women do stitching for Black harness, some brown saddle & harness.

This is quite distinct from the Manchester Soc. wh has 27 branches. Bromage is sec. & new member have to satisfy the Union that they be can earn the minimum wage.
A very temporate trade
Govt. arm. repair. will send rules, & copies of prices.

Benefits. 0-w. 12/- for 6 wks.
Funeral. £5 mem. £2.10 wife.
Benevolent. according to cash for members & nonmembers.
Strike 20/- & 1/- for each child.
There is a sep organization called Saddle & Harness makers Pension Fund Assoc.

Subs: 3d wkly.

Wages are calculated at 9d hr. for ordinary run working according to Union prices if slow. a quick man eg. Mr M. has made as much as 1/4 an hour.

Has made a great diff now that Gentlemen order their harness themselves. they used to let their coachmen do it for them; the coachmen used to like to turn out with new harness as they; they was a great deal of cheating. the old harness was sold in the same way that masters clothes are now; (Mr M said he knew this: his father was a coachmen.

Benefits.

Subs.

Wages.

Gentlemen now order their own harness.

Harness at State Drawing Room.

For Drawing Room coachmen used also always bowler new harness: Hunter went block at the last but only worked 20 out of 400 carriages with new trappings.

Jenkinsons is the worst sweating firm in London

Horse collar makers Soc.

80 members out of 110 in London.

Benefits

July 20th 1894. S.H.W.

W. Jogut. President. Horse collar makers Soc.
21. Victoria Chambers.
Paul St. EC.

Copy. Dear Sir.
In answer to yours, I am sorry that my Committee would not give me authority to write to you before, as regards the present request.
1st. We have now 80 members out of an estimated number of 110 in the trade in London.
2nd. The present Society was founded in 1872.
3rd. We give a sickness 14/- per week for 8 weeks 7/- per wk for 8 week £5 0 0. members death & on the death of a members wife a levy of 1/ per member.
also 12/- per week for 8 weeks when a member is out of work & when out of work over that time a levy is imposed to pay such member a further sum of 8/- per week. I am yours respectfully
W. Jogut
President Horse Collar makers Soc

are there 80. helmet makers } = 200 or 80 + 120 = 200
120. bit saddlers }
how many women } in collar making
draftsmen }

31 X. 93

seen	F Whisker.	chair saddler	still [illegible] work
seen	J. T. Morrison	Saddle tree maker.	
not ans.	W. Jowett	Collar makers	
—	Coopers	saddle tree maker	

Steel Dressers.
Women saddlers.
Small chair saddlers