



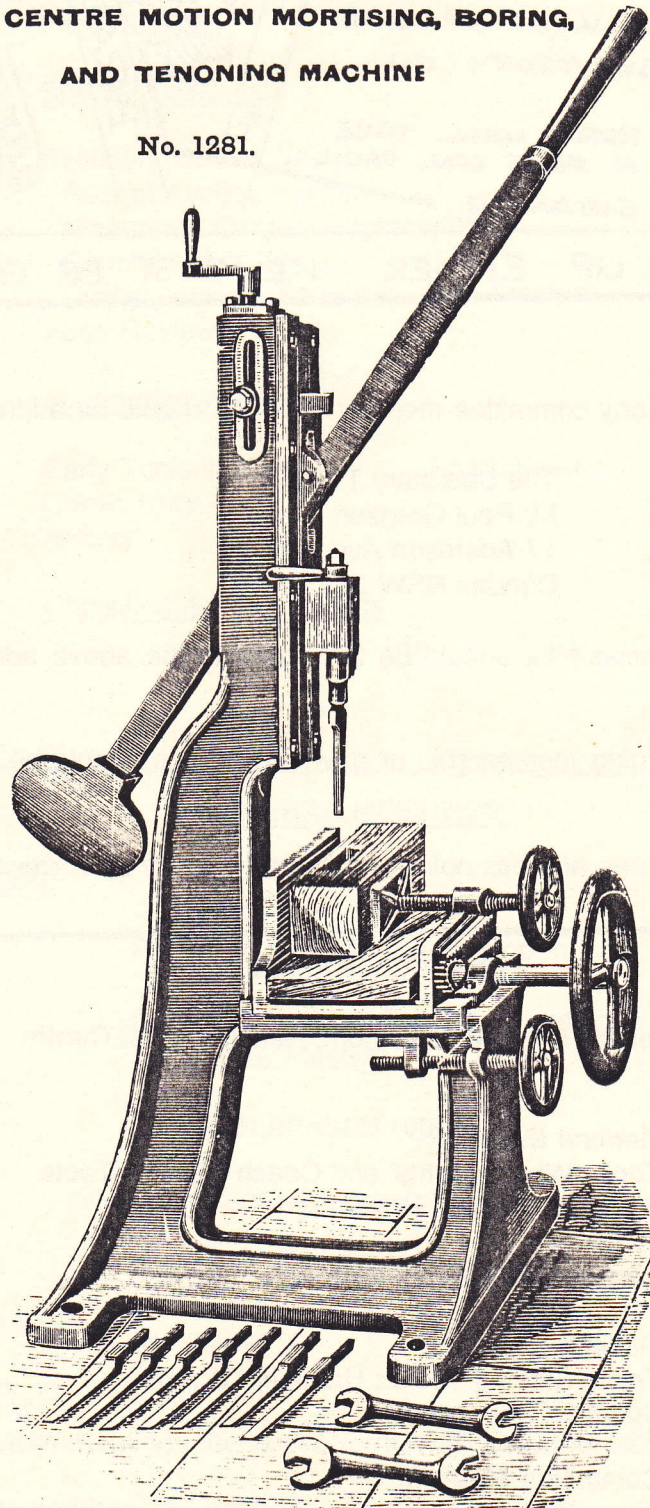
# THE TRADE TOOLS GROUP

TTTG NEWSLETTER NO.10

APRIL 1993

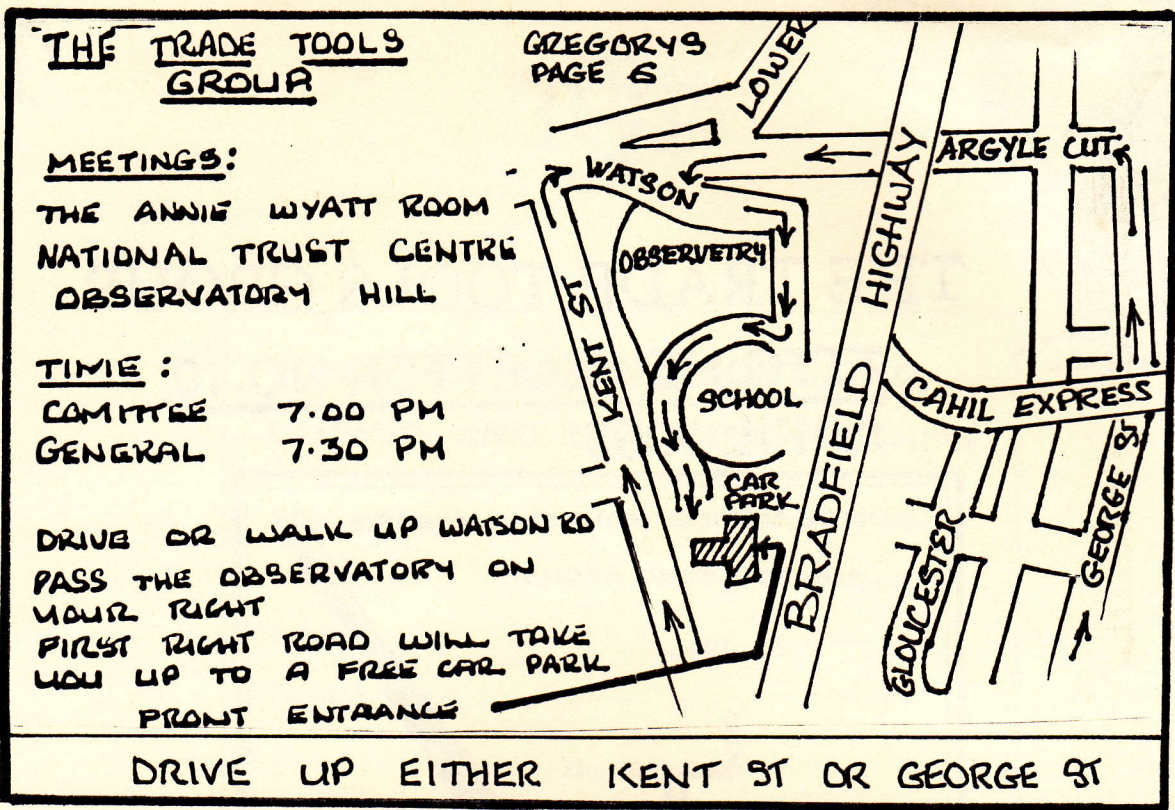
CENTRE MOTION MORTISING, BORING,  
AND TENONING MACHINE

No. 1281.



*Carriage Forward.*

'The History of Tools is the History of Man'



CORRESPONDENCE

All correspondence to any committee member of TTTG should be addressed to:-

The Secretary TTTG  
 Mr Paul Gregson  
 17 Adamson Avenue  
 Dundas NSW 2117

Contributions for the newsletter should be forwarded to the above address and endorsed "Attention Editor".

Correspondence regarding membership or payment of fees should be endorsed "Attention Treasurer".

Co-operation with this one address policy will greatly simplify all correspondence.

**TTTG PROGRAMME 1993**

Venue: Annie Wyatt Room, National Trust Centre

- |           |         |                                                                                                |
|-----------|---------|------------------------------------------------------------------------------------------------|
| April 13  | 7.30 PM | General Meeting<br>Topic: Wheelwrights' and Coach Makers' Tools<br>Speaker: Michael Hendrikson |
| May 11    |         | Committee Meeting                                                                              |
| June 8    |         | General Meeting<br>Topic: Striking Tools : Hammers & Axes<br>Speaker: Bob Lee                  |
| July 13   |         | Committee Meeting                                                                              |
| August 10 |         | Annual General Meeting - Election of Office Bearers                                            |

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APRIL 1993

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### Regular Features:

President's Report	Terry Butcher
Editor's Report	Bob Crosbie
Correspondence	
Last Meeting	

### Special Features:

Eveleigh Railway Visit  
- Recent Auction Prices  
- Nineteenth Century Engineering  
- Coachmaker's Tools  
- Cross Grooving Planes      Bob Crosbie  
Book Review

### Information Wanted:

Early Tools in NSW	Ralph Hawkins
Comic Cuts	
History	

### Classified Advertisements

## GENERAL MEETINGS

### FORMAL STRUCTURE

7.30	President declares meeting open.
	Secretary reads Minutes of previous General Meeting and Committee Meeting.
	Treasurer presents report.
	Discussion
	President introduces Speaker
	Questions

Please note in all future meetings the above format will be adhered to.

Refreshments will be provided, \$2 donation will be appreciated.

## PRESIDENT'S REPORT

1993 may well be a depressed year for our politicians but so far its been a great year for TTTG.

First we have swelled our ranks and have now passed the 100 membership - an excellent result for just a year in existence and my thanks to everyone. On this point a special thanks to John Macdonald our Canberra member and of course proprietor of Tools of Trade. He has been sending out Membership forms with book orders and as a result has brought in quite a few members through his personal efforts. Our thanks John.

Our last meeting on the 9th of February at the National Trust Centre at Observatory Hill brought out a big roll up of members to hear Bob Crosbie enlighten us on the uses and the many varieties of moulding planes. He brought along many different types and examples, and I noticed at the end of the meeting the members clustered around the table eager for a closer look-see - Moulding planes is a very interesting subject and the more you go into it you realise how big a subject it is and how much more there is to learn.

So we'll be looking up at a follow on, on this one Bob. Nice work and thanks from all those who attended.

The long awaited visit to the Eveleigh railway site was held on the afternoon of Wednesday the 24th of February and considering it was a week day a remarkable attendance was recorded.

After Paddys moves back to the Haymarket we may be able to arrange a week-end viewing for those who unfortunately had to work and couldn't come.

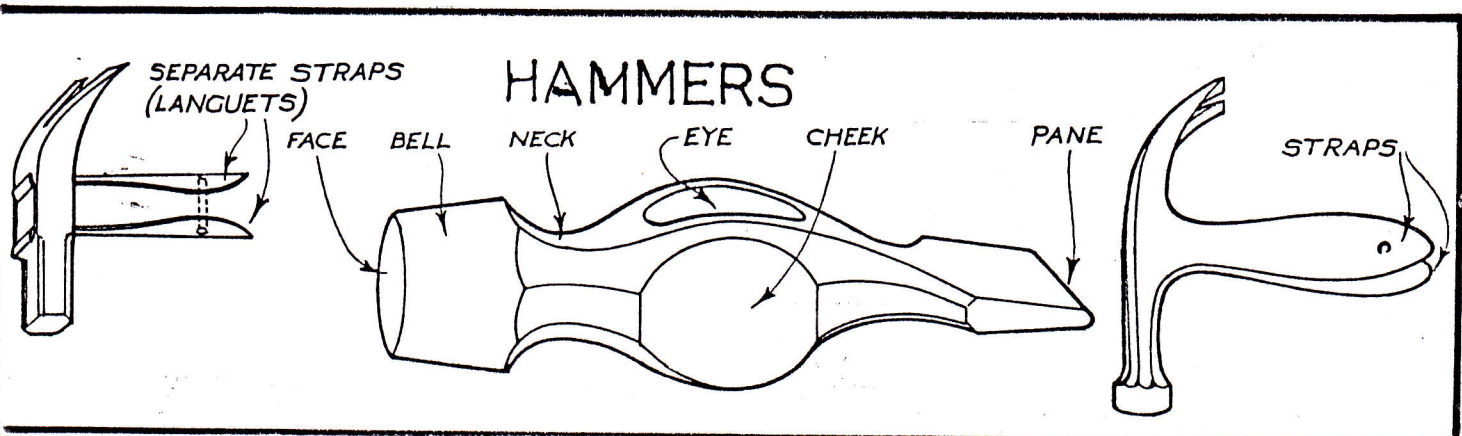
Our thanks to Guido Gouvenour and Werdie McCoffey for arranging this visit for us.

I would like to arrange a visit to the BHP Steel Works at Port Kembla later this year. Of course it must be a week day tour and will be an all day affair 'so if this should interest you please let me or one of the committee members know about it so we can have some idea of numbers and we can go ahead and set a date.

Again there will be no charge but bring a few dollars for lunch. We'll organise a motor pool and drive down, so let's have your preferences.

I'm looking forward to our next meeting as I'm sure you all come to hear Mike Hendrikson and his interesting talk on Wheelwrights and Coachmakers Tools.

Terry Butcher  
President



This is the tenth issue of our newsletter. Coincidentally TTTG now has over one hundred members. So it seems TTTG has found its feet. Even so this is not the time to be over confident. There is a lot to be achieved for TTTG to survive and to grow.

Those of us who are on the Committee need to know what you the members expect from TTTG. So please think about the group and discuss your ideas with fellow members.

Members are encouraged to submit articles for publication in this newsletter. Several members are in the process of writing interesting articles.

The next meeting should be a treat for all members. Mike Hendrikson will talk on Wheelwrights' and Coach Maker's Tools. Members will be pleased to learn Mike has offered to write a series of brief articles on this topic. Later in the year a visit to Mike's workshops will be arranged for members. Try to come to the next meeting and bring along any related tools for discussion.

On the 8th June Bob Lee will talk to the group on the topic of "Striking Tools". Bob has an interest in all types of hammers and axes, especially locally made ones.

The Working with Wood Show will be on soon and TTTG will be there. We intend to have a working display this year. Already volunteers are being called for. This will be discussed at the next meeting.

LAST MEETING

FEBRUARY 9 - TOPIC: MOULDING PLANES

Several members brought along some superb tools. Fred Muriel passed around some fine planes including a throating plane made of Santos Rosewood.

Maurice Brown displayed several interesting drilling machines. At a future meeting Maurice may be persuaded to discuss his engineering experience with the Group.

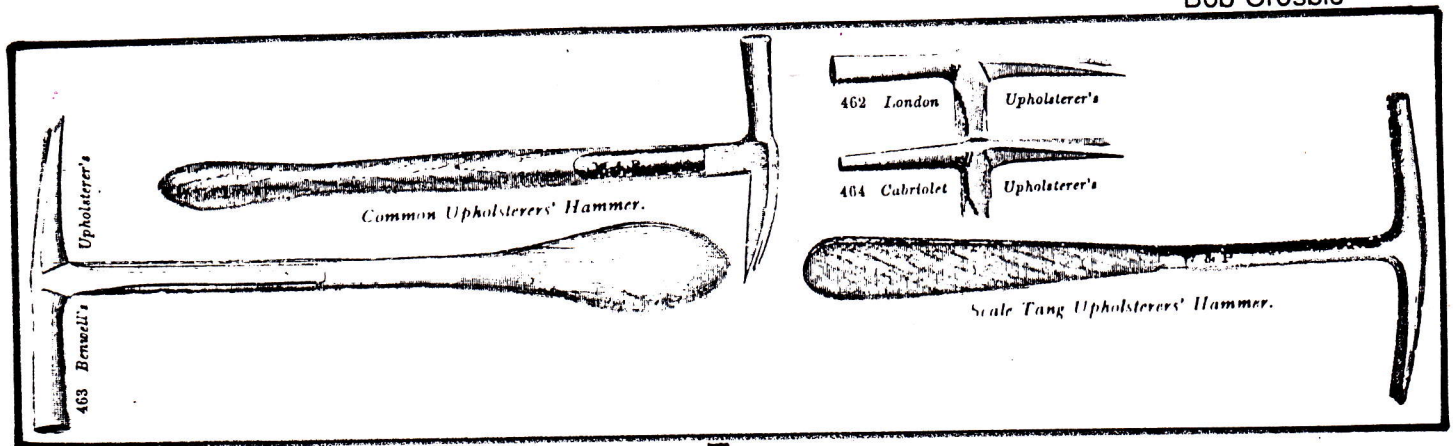
Ralph Hawkins created a diversion with his selection of gardening tools.

Terry Butcher informed the meeting of our latest acquisition, a hand operated Morticing Machine (see cover).

Conservation Committee

The work of this committee is progressing. Richard Weston is preparing a report on his experiments. Mike Williams is investigating applied Chemistry. Paul Gregson is formulating a "no risk" cleaning technique for the non expert. Eventually I will co-ordinate the final "guide" for the use of our members.

Bob Crosbie



**DETAILED REPORT ON VISIT TO EVELEIGH RAILWAY SITE  
ON 24 FEBRUARY 1993**

Rather than a tour, it was really more of a ramble through the various areas of the Main Loco Shed, as many of the machines were just shut down at the end of the shift and there they sit waiting for the power to be switched on again and go back into production. But this is not to be, for I do not believe we shall ever see the likes of such an establishment producing steam locomotives again. But here they are standing mute, those who knew what it was all about gone, retired, passed on or moved into other occupations. With a bit of luck we may be able to assemble some of the knowledge and some examples of what was made and show for ourselves and future generations a semi-working display.

Although a lot of the machinery, tools and work benches were disposed of not long after the shut-down, what remains is sufficient to make up some sort of historical layout - not sufficiently detailed to show every single process - but barely enough to cover what was unique and specialised to this area of loco manufacture and maintenance. It must be remembered that many establishments duplicated processes of which much history is recorded and, in fact, a lot of these processes are still being used today.

I think we all benefited by the day's outing, maybe each one of us carrying away a different viewpoint of what we saw, but a common thought was to see most of it preserved and put back into some kind of restored condition.

Of the remaining machinery, there exists a very large forging press, steam operated and most of the ancillary gear; the furnace for heating the billets of steel to be forged; many dies and handling tongs; plus the overhead gantry crane for moving the heavy items and some unfinished forgings are to be seen lying about ready for finishing. Adjacent to the heavy forge shop we encountered the blacksmith's shop with at least twenty bays where each blacksmith had his own forge, anvil, workbench, tools, grinder etc. Apart from most of the anvils having gone, most of the remaining equipment appears to be intact. It would be good to see two or three of these fully restored to a working "condition".

Apart from a lot of rubbish, the machine shop had some very interesting machines, some we believe, adapted for special processes; a gear planer for large bench gears is there, some quite large lathes and equipment for the making of both coil and leaf springs, a mess of items for the making of brass padlocks, a quantity of stamping dies and forging sets and quite a few partially working cock pieces.

Sitting quietly in a corner is our Wadkin Mill, now there as a storage item just waiting for eager hands to restore, this, our own piece of vintage machinery!

I trust all who were there enjoyed the tour.

Terry Butcher

SOME RECENT AUCTION PRICES - MOSS VALE - 27 FEBRUARY 1993  
- 413 LOTS OFFERED

Bob Lee

LOT	DESCRIPTION	AUCTION PRICE \$A
95	Dovetail Sole Matheson Panel Plane	340
196	Rutherford Panel Plane	260
197	Matheson Style Panel Plane	260
200	Wooden Block Tri Plane and Veneer Plane	90
201	3 Aluminium Glue Pots	20
202	19 The Rosewood Infill Rebating Plane	95
203	Matheson Wooden Infill Smoothing Plane	250
204	Norris Adjustable Smoothing Plane	360

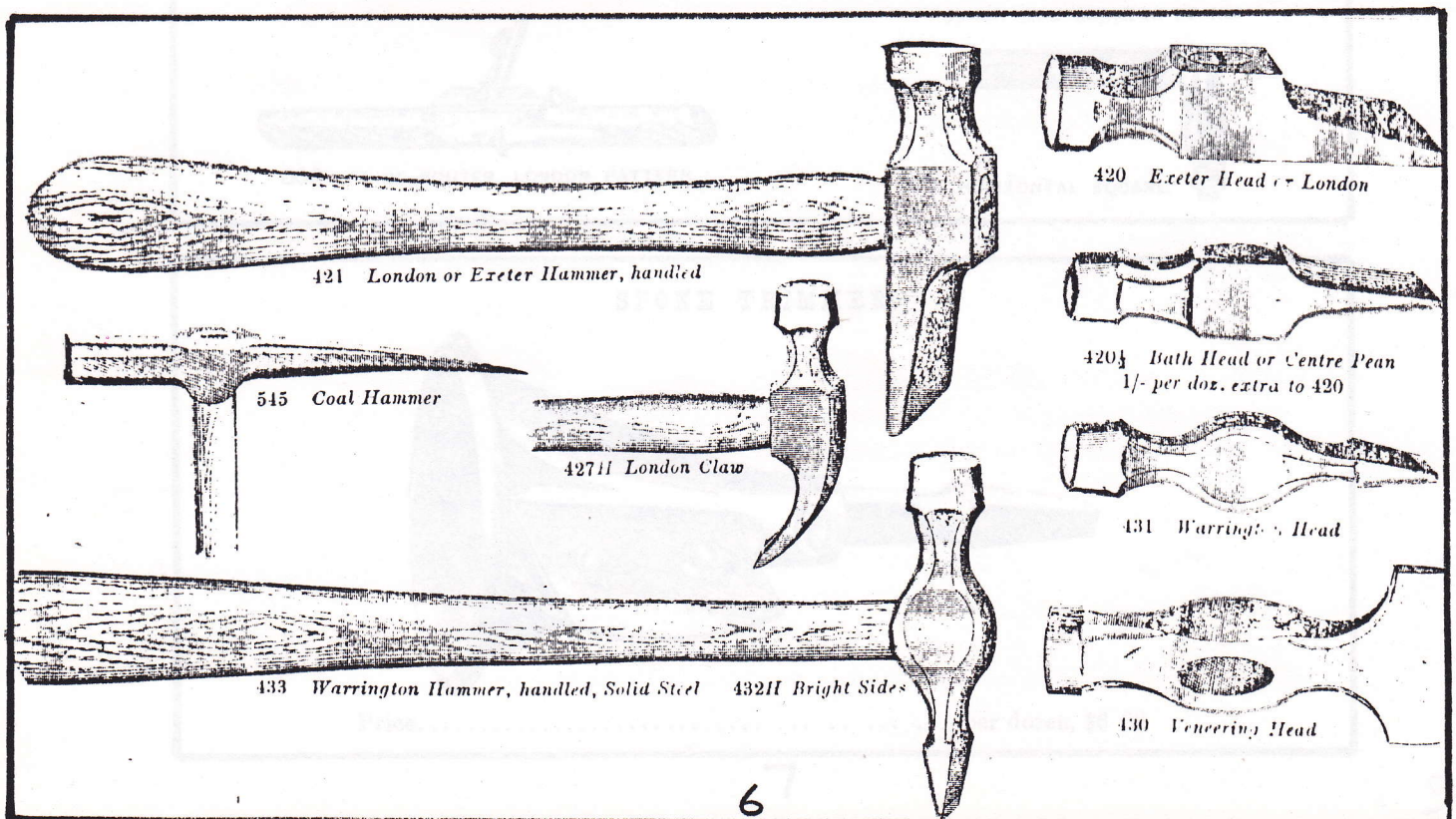
## ASPECTS OF NINETEENTH CENTURY ENGINEERING (Extract from Joshua Rose)

Joshua Rose was a Victorian authority on engineering practice. His texts were standard reference for the metal machinist. The extract below is the first of a series of reprints of Rose's writings in the magazine *English Mechanic*. It was published in the letters section of issue No.663 dated Dec.7. 1897 on page 315.

### SCARCITY OF GOOD WORKMEN

I have read with some interest the remarks made in the *English Mechanic* upon the "Scarcity of Good Workmen", "Piece Work", "the Trades'-Union", etc. These are to me matters of intense interest, and the opinions I hold upon them are the results of personal experience. First, then, the "Scarcity of Good Workmen". There can be little question upon this point, because the introduction of special machinery has obviated, in a great measure, the necessity for them. Special machinery will perform a large quantity of reasonably or, say, very accurate work, but I have never seen any special machine work of any size that could not be exceeded in quality by the use of the file. I believe that there are to be found today workmen who are as expert as any to be found in times past, but they are getting scarcer, and this is in a great measure due to the fact that such good work is not exacted by employers. Is it not a fact that as good samples of work, both in metal and wood, are to be found among the productions of bygone ages, as are to be found among our present productions? And yet their tools were crude. At the Philadelphia Exhibition, the Japanese bronzes far eclipsed any other samples of metal work, and so, likewise, their carpenters came with saws with the teeth sloping, what we should call backwards, and produced work of splendid quality. Their pulling the saw enabled them to use thinner blades; the duty strain was in a direction to keep the blade straight, and not to buckle it. They distance all for quality, and were not so very far behind in quantity, and the sandpaper could, in many cases, follow the saw. I found no difficulty in using their saws, and a sense of delicacy in the cut that at once proclaimed their method of cutting the teeth right for the production of fine work; but circular saws and gang saws will work havoc with the quality of Japanese workmen, just as fast as the latter catch the spirit of the age, which teaches to get all the quantity possible, and as much quality as you can in such a quantity and time. As for piecework, it is beyond question the correct method to work by, and could be easily carried out in almost all workshops, if both sides would be reasonable; but each blames the other when both are in the wrong, and, as a rule, the employer the most. The records of the South-Eastern Railway Company's workshops, at Ashford, in Kent, England, will show that in 1866 and 1867 I was doing piece-work there, not only at a greatly reduced cost over the daywork, but far below the prices of other piece-work men. Example: Engine No.199 was a new engine; she got smashed at the well-remembered Staplehurst accident. When repaired I did the new axle-boxes, brasses, etc., in the ordinary course of my piecework. Now, for that job I got about 30 per cent less than the man who was working within 50ft of me on precisely the same work! And yet I was asked to reduce my prices, while he was not. Why? because I earned too much money, and he didn't. The rule was a piecework man may earn half as much again as his day wages, and if he earns more his prices must be cut, no matter how cheap his work is, and I know that if I could have made locomotives for 6d. each, they would have grumbled if I earned more than the "time and half". I have not quoted an isolated case. I did by piecework

about 1,000 axle boxes, sets of link motion connecting-rods, coupling-rods, and, among other things, about 1,000 motion-bars; and it is a fact easily verified from the books that during the whole of the time that I did those bars others were paid some 30 per cent, more for bars done by piecework than I was, and it was a constant war with me because I earned so much money, while others remained unmolested. After I left the shop nobody would touch the bars at my price (17s. 6d. per 8 bars and 4 motion blocks). I used to average about, I think, 9s. per day on them, and yet the apprentices, who had served six years, and were paid 16s. a week could not do the bars at my price! A labourer was, when last I heard, trying to do them at my price, but I am satisfied he failed. I was in trouble for earning too much, the day workmen were in trouble because their work would cost twice or three times what mine did. The foremen were in trouble because the superintendent could not understand how there could be so much difference in the time taken on the job, which looked worse than the difference in the wages earned; and the superintendent was in trouble to have the books show that during about twenty years the job had taken an average of nine days' work, whereas my time was less than two. Now the work passed from my hands into those of the charge-men, who were scarcely likely to favour me much. For example, one of them refused to accept a set of bars because, though dead true to surface-plate when held in the vice, they showed hollow in their lengths when rested faces upwards, and upon two small blocks of wood, one placed under each end - the deflection of the bar from its own weight making the difference, though it was a heavy steel bar. If the backs of the bars were polished after the faces were trued it would alter the truth enough to have the bars returned to me. I have taken half a set of castings, another man the other half set, cast at the same time, of the same metal, and from the same patterns. I have taken the job for, say, 20 per cent less money, done the job in 20 per cent less time, and then had trouble because I earned too much. Did the superintendent at any time during the whole two or three years once come and ask me how I did it? Not he; it took him all his time to consider how to reduce my prices, and push the foremen to have others' work make a more respectable comparison with mine. Did the foremen ever come and ask that question? By no means. One of them was a boiler-maker or blacksmith's striker, I forget which, promoted for-for-for-well, I don't know what for, except that he sought economy in reducing wages, instead of by getting the work out in the best and quickest manner.



WHEELWRIGHTS AND COACHMAKERS TOOLS

The illustrations below give some idea of the range of specialised tools used in these tools.

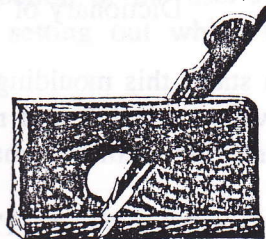
EDWARD PRESTON & SONS, L<sup>TD</sup>.

**Coachmakers' Tools.**

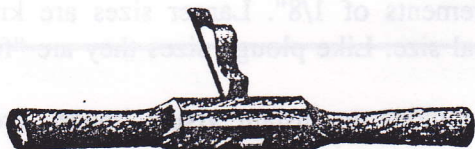
TRADE  MARK



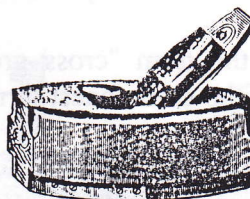
600. BEADING ROUTER.



T RABBET PLANE.



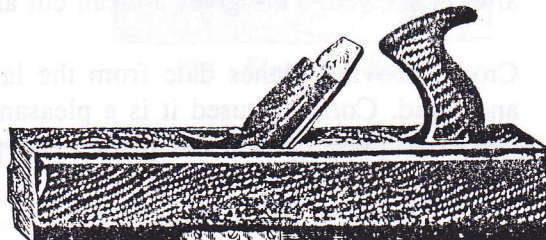
601. BOXING ROUTER.



COACH DOOR SMOOTH PLANE.



602. JIGGER ROUTER.



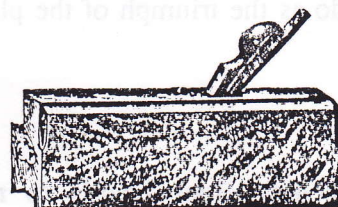
COACH DOOR JACK PLANE.



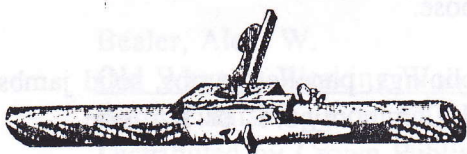
603. LONDON PATTERN JIGGER ROUTER.



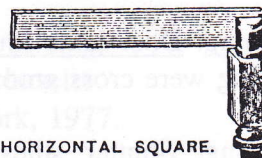
605. FENCE ROUTER.



COACH SIDE CHAMFER PLANE.

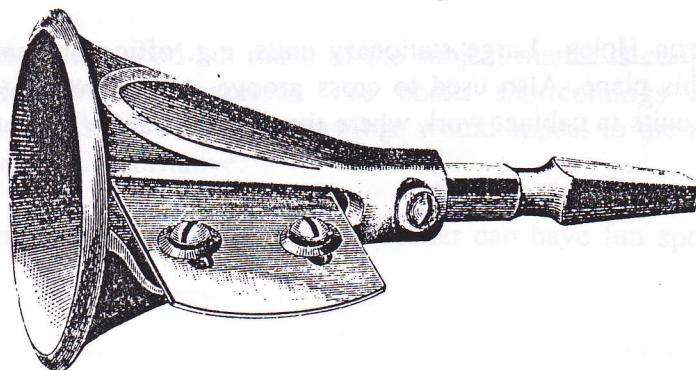


608. FENCE ROUTER, LONDON PATTERN.



1488. HORIZONTAL SQUARE.

**SPOKE TRIMMER.**



Price..... per dozen, \$6 00

## CROSS GROOVING PLANES - Bob Crosbie

also known as Dado, Trenching, Raglet, Carcase Grooving, Housing Plane  
related planes: Flooring Raglet  
Iron Dado Grooving

Definition see Salaman, R.A.

Dictionary of Woodworking Tools, Revised edition, pages 324 & 325

Salaman states this moulding size plane was rebated along the left hand side. In fact these planes were made left and right handed. I have used both right and left Cross Grooving planes and find them interchangeable. The original reason for this handedness is unknown.

Sizes range from 1/4" to 1" rising in increments of 1/8". Larger sizes are known. The planes cut fractionally wider than the nominal size. Like plough sizes they are "full".

I prefer the term "cross grooving" as it provides an instant visual image. Trenching is probably the commonest term.

These planes are provided with a depth stop. The common types are wood stop and brass thumb screw stop. The nicker iron is fractionally wider than the cutting iron. The blade is always skewed. This gives a clean cut and prevents the "eye" from clogging.

Cross grooving planes date from the late eighteenth century. The cutting action is clean and rapid. Correctly used it is a pleasant and efficient tool. In use a straight edge fixed to the work piece guides the plane. The plane can be used at 90° or any angle across the grain.

In appearance and execution these planes are superb. Only the Sash Filluter rivals the Dado as the triumph of the plane makers skill.

### Uses

Trenching floor boards to receive tongued skirting in first class work. The handled flooring raglet was usually used for this purpose.

Trenching: Door jamb linings etc Skeleton linings, panelled jambs, solid jambs and dado panelling were cross grooved with this plane. Commonly 3/8" or 1/2" size.

Trenching: Shutter stiles Stiles for shutters or louvred frames can be rapidly, and uniformly, cross grooved with this plane. As these stiles are handed left and right planes can take some of the awkwardness from the job. However one plane, of either hand is satisfactory. 3/8" or 1/2" blades are common sizes.

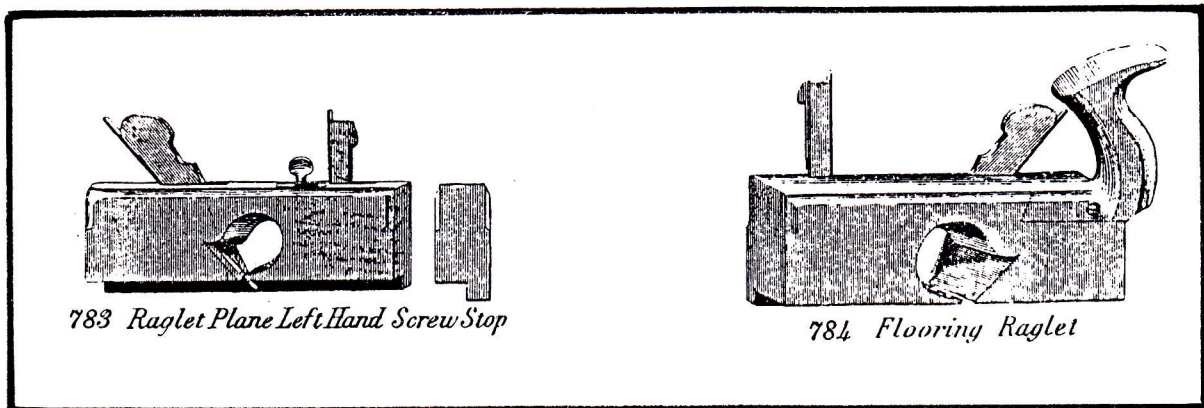
Trenching: Pigeon Holes Large stationary units, e.g. office or bank fittings were cross grooved with this plane. Also used to cross groove strong boxes etc. Not to be confused with stationary units in cabinet work where the divisions are V grooved. Sizes 1/4", 3/8".

Trenching: Carcase or Bookcase sides Used for cabinet work. Common sizes 5/8", 3/4", 7/8". Often seen in chest of drawer sides, bookcase sides for adjustable shelves and grooves for trays on fitted clothes presses etc.

It should be noted that these planes cut through trenches. However the bulk of stopped cross grooves can be worked with these planes.

The full potential of the cross grooving planes is a reflection of the user's imagination. The great advantage of these planes is the amount of setting out which is eliminated combined with the speed of use.

Stanley USA made iron versions of this plane.



## BOOK REVIEW

Bealer, Alex. W.

Old Ways of Working Wood

Barre Publishing Company Inc., Barre, Massachusetts

Distributed by Crown Publishers Inc., New York, 1977.

This is a well-known book. For this reason it is a likely starting point for anyone seeking to understand old technologies. It is the type of book that generates interest and disseminates misconceptions.

The author's intentions are good but much of the subject matter is conjecture. Many of the techniques are misleading or incorrect. The books shortcomings are obvious to the practical user of old tools. However the drawings would appeal to the academic reader and are likely to be cited as authoritative.

Even so it is an enjoyable read and the expert reader can have fun spotting the errors and absurdities.

## INFORMATION WANTED

### Early Tools in NSW

Ralph Hawkins

Steam powered machinery was in use in NSW by 1830. The following extract gives a description of a steam saw mill:

"The proprietor of the Cowan Saw Mill, the first that has been erected in New South Wales, has now brought his machinery to such perfection that he can cut 450 feet superficial of flooring boards, or 600 feet of batten in one hour, the teeth of the saws pass through the space of 8,200 feet per minute, being at the rate of 96 miles in the hour, a speed produced by animal power never known before. The flywheel of this machine travels at the rate of 7000 feet per minute."

Sydney Herald. 18 July 1831

This is one example of the many fascinating facts to be revealed in Ralph Hawkins soon to be published book. Editor.

## COMIC CUTS

The editor is anxious to include a few light hearted items in this newsletter. If any members know of old humorous advertisements etc please forward copies to the editor.



**Ruffle-proof Hair**

No matter in what predicament you find yourself, no matter how badly things are going, your hair at least is ruffle-proof if it's Kubist-fixed.

Kubist Hair Fixative was made originally to keep motorists' hair in order at any speed up to seventy-five, but it has also proved itself capable of keeping the most unruly hair flat 'midst all the slings and arrows of outrageous fortune - cut times, hard castings, growing families and rent days.

It is obtainable in bottles at 1/-, 1/9 and 2/9, in two grades, Plain or "Rosola" (amalgamated with delicately-perfumed Rose Oil.

**Ku-bist**  
**Hair Fixative**

is sold by most Chemists and Hairdressers and all branches of Taylor's, Timothy White's, Parke's, Hodder's, Needham's, Squire's, etc.

KUBIST - LEEDS. Also at London and Paris

ENGLISH MECHANICS      DECEMBER 6TH, 1929.

## HISTORY

New South Wales. Government Gazette. Jan. 9. 1833

Notice. Commissariat Office. Sydney. Jan 7. 1833  
Surplus items to be sold by Public Auction

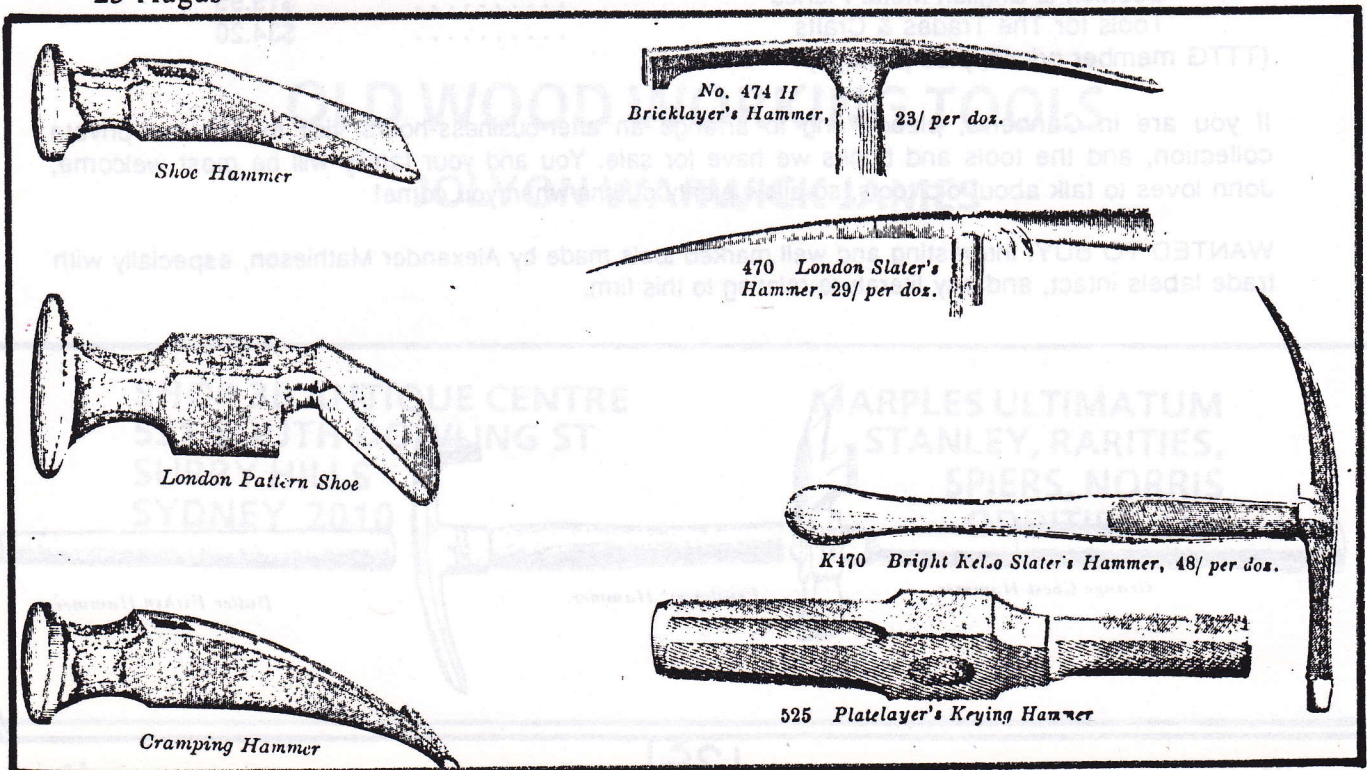
### Abstract. Joiner's Tools

Bits	Dividers
Buckle for Lathe	Dogs'
Bevels	Gouges. socket and carvers
Brace	Gauges
Callipers	Planes: bead, hollow, round, quirk ovolo, O.G.
Chisels, Turners	Squares
Cramps	Shell-lac

Timber: cedar, lignum-vitae, hardwood scantling, tulipwood

An Inventory of Stores at the Lumber Yard Parramatta.  
15 Jan. 1810. Mr Rouse. Superintendent  
A.O. NSW. 2/8131

20 Cross cut saw files	2 pr. Compasses
89 Saw Files	4 Pit Saws
38 Old Saw Files	2 Turning Saws
3 Long Planes	3 Drawing Knives
1 Smoothing Plane	1 brace and bit
20 Small planes	2 firmer chisels
1 Plough. 8 irons	4 socket chisels
11 Chisels and gauges	A Turner's Lathe
25 Augus	



ADVERTISEMENTS:

"Books and Catalogue Reprints". For the antique Tool Collector. Send for complete list.  
Inglewood Tool Co., PO Box 224, Moorooka 4105 (Fax 07-397 5998)

Woodies Books. Suppliers of the Finest Woodworking Books available. Send self-addressed stamped business size envelope for 1992 Catalogue. 21 Merrylands Road, Merrylands. 637 2932

Tools of Trade. John McDonald. Reprint Tool Catalogues and Old Books.  
Write to: 32 Rocklands Street, Duffy ACT 2611

**SYDNEY SECONDHAND MARKET**

Specialists in Secondhand Tools  
Machinery, Ladders, Wheelbarrows

HUGE RANGE

New Stock arrives Daily

: Cash paid for your tools, ladders, wheelbarrows, machinery :

Trading: Monday - Friday 8am - 5pm  
Saturday morning 8am - 12noon

Entrance via THE LADDER SHOP, 709 Canterbury Road, Belmore, Phone 787-2587

Catalogue reprints and books on many aspects of working in wood and using and collecting tools.  
Write for a free booklist to:

John & Priscilla McDonald  
Tools of Trade  
PO Box 13, Duffy ACT 2611  
Phone (06) 2886142

5% discount on books for TTTG members.

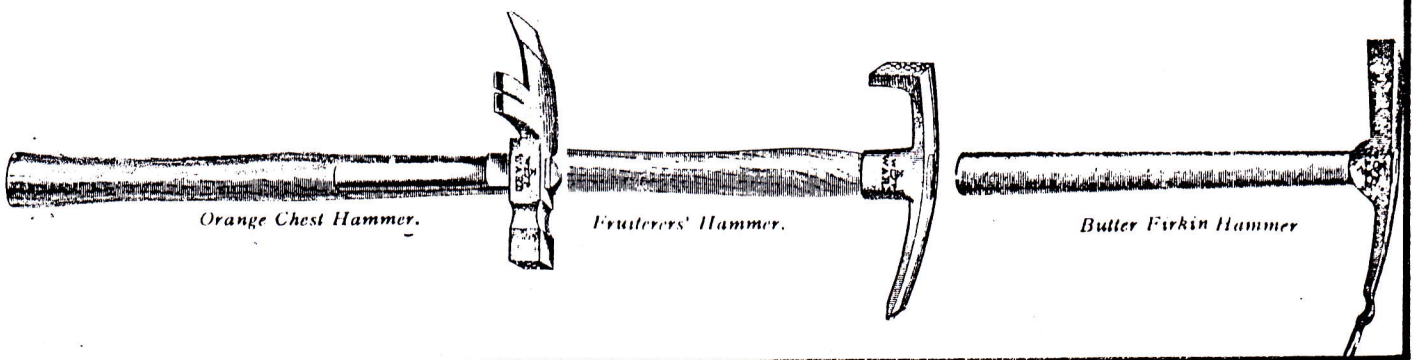
We currently have in stock several of Ken Roberts books, including:

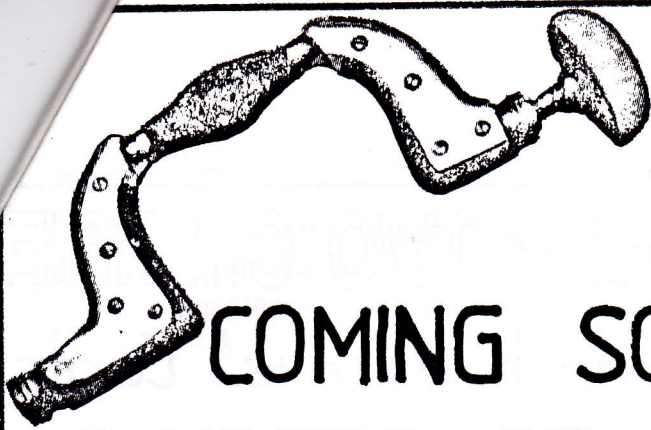
Some 19th Century English Woodworking Tools .....	\$57.00
Scottish & English Metal Planes .....	\$19.95
Tools for The Trades & Crafts .....	\$34.20

(TTTG member prices, plus postage)

If you are in Canberra, please ring to arrange an after-business-hours visit to see our private collection, and the tools and books we have for sale. You and your family will be most welcome, John loves to talk about old tools, so allow plenty of time when you come!

WANTED TO BUY: interesting and well marked tools made by Alexander Mathieson, especially with trade labels intact, and any literature relating to this firm.





**REG EATON**

*Specialists in Old & Antique Tools for the Collector & Craftsman*

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WITH A LARGE & VARIED STOCK OF TOOLS TO INCLUDE—

MANY ULTIMATUM & OTHER TYPES OF BRACES, NORRIS, SPIERS & MATHESON PLANES, A RANGE OF PRESTON TOOLS, PLOUGHS, SASH FILLISTERS & 18<sup>TH</sup> CENT. PLANES, CHISELS & CARVING TOOLS, FINISHING NEEDS ETC., ETC., ETC..

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FAX: (02) 326 1319

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SPIERS, NORRIS  
ODDITIES, ETC.



# >> KIRSCHEN << TWO CHERRIES

## Fine Woodworkers' Tools

*... because in the long run all that counts is quality*

Recognised, for more than 130 years, as Europe's leading manufacturer of ...

- \* Specialised Plane Irons (in both High Carbon Alloy and High Speed Steels)
- \* Chisel Blades : Joinery - Turning - Carving (each individually Hand-Forged)
- \* Bench Hardware - Draw Knives - Woodworking Accessories etc.

KIRSCHEN (Two Cherries) Tools are now available to Trade Tool Group Members through SIEPER & Co. - Strathfield Phone: (02) 764.2633 Fax: (02) 746.2386

### ADVERTISEMENTS:

#### Revised Rates

Members: For Sale, Wanted or Swap free for one issue.  
Thereafter 20 cents per word

#### Trader's Rates

First placement free  
Second issue and subsequent advertisements;

<u>Block</u>	Half Page	:	\$20 per placement
<u>Advertisements</u>	Quarter Page	:	\$15 per placement

Commercial Line 50 cents per word  
Advertisements

N.B. Artwork and/or Prime Position, subject to negotiation

## MORTISING MACHINE

TTTG has recently acquired a hand mortising machine. It is of the type illustrated on the front cover of this newsletter. Below is a reprint of an advertisement that discusses this class of machine.

### THE "ECLIPSE" MORTISING MACHINE

Mortising, like all operations in which great accuracy is required, is much better performed by a well-constructed machine than by hand. Even an expert and thoroughly competent workman is not always able to do his best, and, unfortunately the majority of workmen in nearly every department cannot be included in the category of experts. There are various mortising machines, more or less ingenious in construction and efficient in operation, in use, most of them having a rack and pinion, or rack and cog action in connecting the hand-lever to the part which carries the spindle of the cutter or chisel. That which we illustrate, which is manufactured by Messrs. F.W. Reynolds and Co., Southwark Street, London, differs from all others in having, in place of the usual rack and cog-wheel, an articulated elbow or toggle movement, the action of which not only produces the requisite vertical motion of the chisel, but gives an increased power as it penetrates deeper and deeper into the material being worked. This motion also ensures uniformity in the depth of such mortises, as it is not required to cut quite through the wood. Again, the requisite uniformity of depth is secured in the whole length of the mortise much more certainly and easily than in previous methods, owing to the bearings of the chisel spindle and the fulcrum of the lever being adjustable, and the lever having always to be brought down to the lowest point. In respect of ease and certainty of working, therefore, as well as accuracy, the "Eclipse" appears to possess capabilities that must give it a foremost place among machines of its class.

### THE BLACKSMITH'S SONG

Written by Moses Kipling, Prime Warden of London's Worshipful  
Company of Blacksmiths in 1828

In the good olden days when the gods condescended  
To visit this earth and enlighten mankind.  
Amongst those who most us poor mortals befriended,  
Still Vulcan, our Patron, the foremost you'll find;  
When he taught us with anvil and hammer to mould  
The plough-share, the spade and the sickle to reap,  
Had we paid for such knowledge a mountain of gold  
The purchase would still to mankind have been cheap.

To the mem'ry of Vulcan our voices we'll raise,  
May he and his sons be revered through the land  
May they thrive, root and branch, and enjoy happy days,  
For by hammer and hand all art doth stand.

Submitted for your enjoyment by Terry Butcher. (Maybe somebody knows the music?  
Please let me know if you do)



**CENTRE MOTION MORTISING,  
BORING, AND TENONING MACHINE**

Takes in Wood ... ..	12 in. × 7½ in.
Will Mortise ... ..	11 in. deep.
Weight ... ..	4 cwt.
Boring Apparatus ... ..	1 qr. extra.

**No. 1281.**

Price, including $\frac{5}{16}$ , $\frac{3}{8}$ , $\frac{7}{8}$ , $\frac{1}{2}$ , $\frac{5}{8}$ , and $\frac{3}{4}$ Best Cast Steel Chisels, 2 Core Drifters, and 2 Screw Keys ... ..	£9 10 0
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**No. 1282.**

Price, instead of ordinary Chisels and Drifters, but with Self-coring Chisels, sizes as above	10 10 0
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Price, with Boring Apparatus, complete with $\frac{1}{2}$ , $\frac{5}{8}$ , and $\frac{3}{4}$ Augers, also $\frac{1}{4}$ and $\frac{5}{8}$ Cast Steel Drills ... ..	1 10 0 extra.
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Price, with Tenoning Tool ... ..	2 0 0 „
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Price, Venetian Blind Punch and Die ... ..	0 10 0 „
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In our 1281 Patent Centre Motion Mortising Machine, the Stand and the Upright Frame are all cast in one piece, giving great solidity and firmness, which is required in all Mortise Machines. If required for shipment we can supply the Machines in sections, like our 1279, so as to be readily taken apart that when packed for shipment it occupies very little space.

**S. TYZACK & SON,**