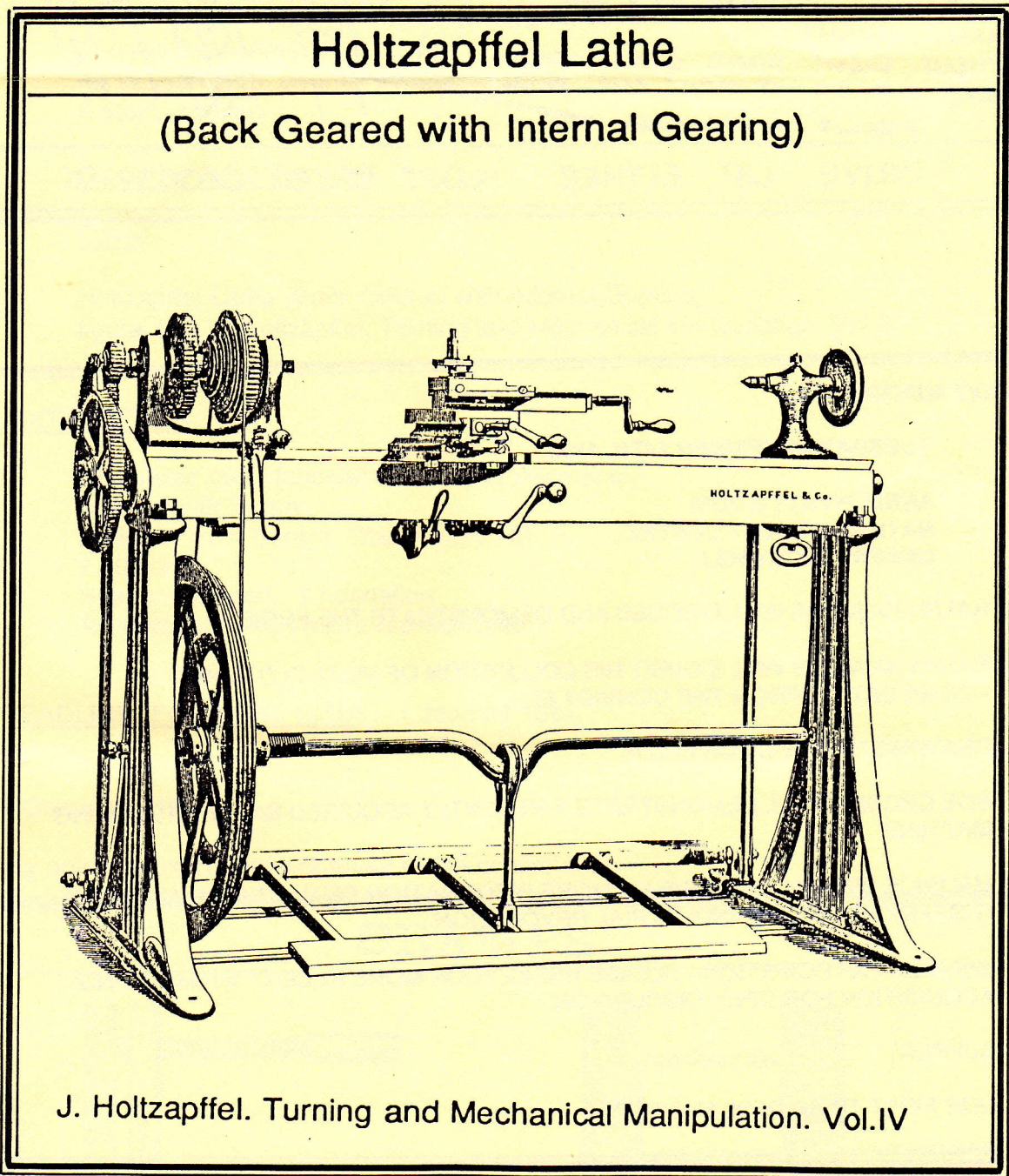


THE TRADE TOOLS GROUP INC.
TTTG NEWSLETTER NO.14
DECEMBER 1993



'The History of Tools is the History of Man'

THE TRADE TOOLS GROUP

GREGORYS
PAGE 6

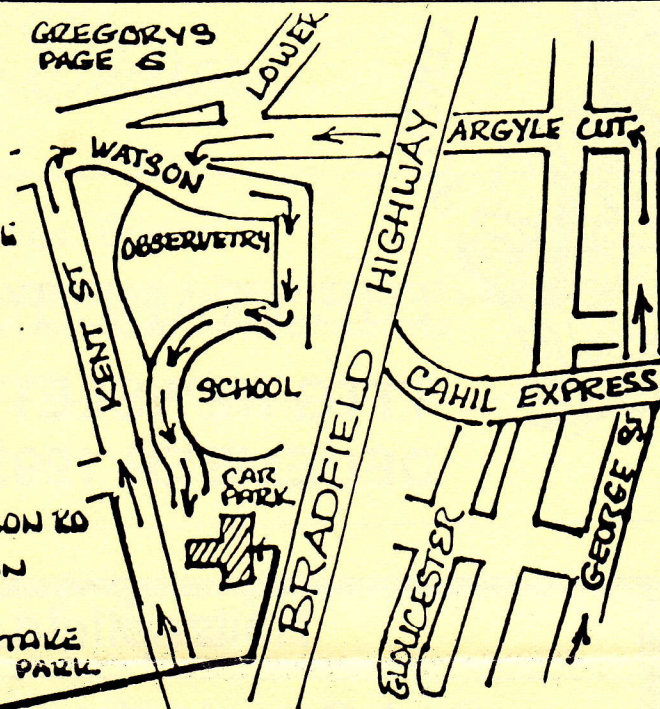
MEETINGS:

THE ANNIE WYATT ROOM
NATIONAL TRUST CENTRE
OBSERVATORY HILL

TIME:

COMMITTEE 7.00
GENERAL 7.30

DRIVE OR WALK UP WATSON RD
PASS THE OBSERVATORY ON
YOUR RIGHT
FIRST RIGHT ROAD WILL TAKE
YOU UP TO A FREE CAR PARK
FRONT ENTRANCE



DRIVE UP EITHER KENT ST OR GEORGE ST

NEXT MEETING:

TUESDAY DECEMBER 14TH, 1993.

**ANNIE WYATT ROOM
NATIONAL TRUST CENTRE
OBSERVATORY HILL.**

1. RALPH HAWKINS WILL DISCUSS AND DEMONSTRATE THE FROE.
2. RALPH HAWKINS WILL EXHIBIT HIS COLLECTION OF VERY OLD RAKES
- SOME DATING FROM THE CONVICT ERA.
3. DRAWING OF THE DOOR PRIZE.
4. BOB CROSBIE WILL DEMONSTRATE A RECENTLY ACQUIRED BARNES TENONING MACHINE
5. MAURICE BROWN WILL GIVE US MORE INFORMATION ON CAST IRON AND HOW IT SPARKED OFF THE INDUSTRIAL REVOLUTION.
6. MEMBER PARTICIPATION - PLEASE BRING YOUR MORE RECENT 'INTERESTING' ACQUISITION FOR OPEN DISCUSSION.
7. SUPPER
8. OUR FIRST TRIAL TOOL SWAP.

TTTG Inc.
THE TRADE TOOLS GROUP

TTTG NEWSLETTER NO.14
DECEMBER 1993

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Programme Organiser

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Maurice Brown

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Holtzapffel Lathe (Back Geared with Internal Gearing)
figure 114. J. Holtzapffel. Turning and Mechanical Manipulation. Vol.IV

NEXT MEETING

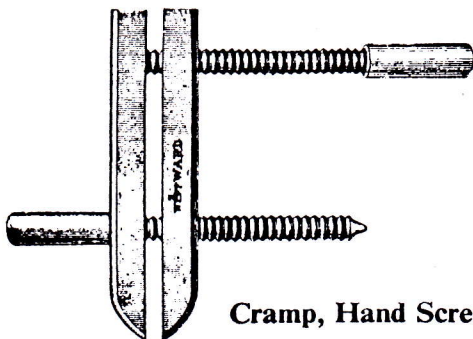
December 1993 (second Tuesday in December)
Annie Wyatt Room
National Trust Centre, Observatory Hill
7.30 p.m.
Supper provided. \$2 donation
All members and visitors are welcome.

"DEADLINE" FOR NEXT ISSUE: 1 January 1994

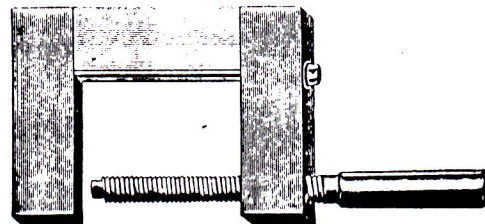
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Any opinions expressed are those of the contributor.

CRAMPS



Cramp, Hand Screws



Cramp, Wood

PRESIDENT'S REPORT

Issue No. 14 November 1993

Our last general meeting was such a success that I think we will have to extend both the lectures given. Firstly we had an interesting discussion on measuring instruments used mainly in the field of land measure. The wonderful range of tools available to the surveyor is quite amazing and further study of metrology is fully warranted.

Then we had Brian Evans telling (in a potted form) the history of iron - no mean feat - and, although Brian was extremely informative, there is much scope for further study in this very fascinating field.

Many interesting examples were shown at the end of the meeting.

Also the members voted to give a 'tool sale and swap' a try at the next meeting. The executive committee is a little wary of this and has cautioned me not to allow a bun rush to develop. Well, it's up to you guys - if you want this to succeed it must be done with some restraint. So for our first effort we'll lay down a few ground rules that you must follow if you want to play the game.

- a. Each member will be limited to three (3) items per meeting.
- b. Each item to be identified as to what it is and how much it's worth if it's for sale - or its equivalent value for swap.
- c. A list of the tools and values is to be handed to the secretary before the end of the meeting. 10% commission on items sold on items sold will be levied on each member and this money will go into TTTG's coffers.
- d. Trading will not start until the meeting is officially closed.

Any abuse of the above rules will be dealt with.

Good luck and I look forward to participating myself.

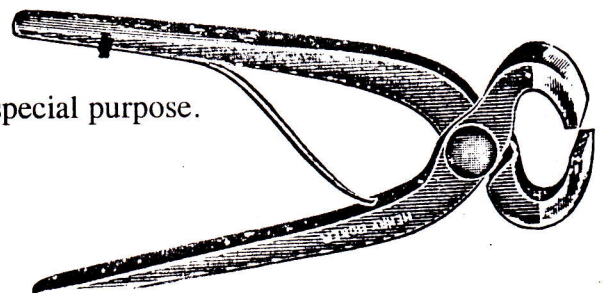
This being our last issue before Christmas, I would like to wish each and every member and his or her family the compliments of the season and wish you all a happy and prosperous New Year.

THIS MONTH'S WHATSIT

Yes, it appears to be just a pair of nippers but it has a very special purpose.

Answer elsewhere in this issue.

Terry Butcher



REPORT ON THE LAST MEETING - TUESDAY 14TH SEPTEMBER, 1993

Following the usual formalities Bob Peak was kind enough to talk on surveying. We have a great cross section of measuring tools including an old "chain" and two theodolites, one from around the 1940's and the other a solid brass vintage one. Bob proved an excellent and informative speaker and handled even the trickiest questions admirably. He captured everyones attention for some 40 minutes or so. A well informed source told me "Bob, had an unexpected trip down memory lane, because we were unable to give him any notice".

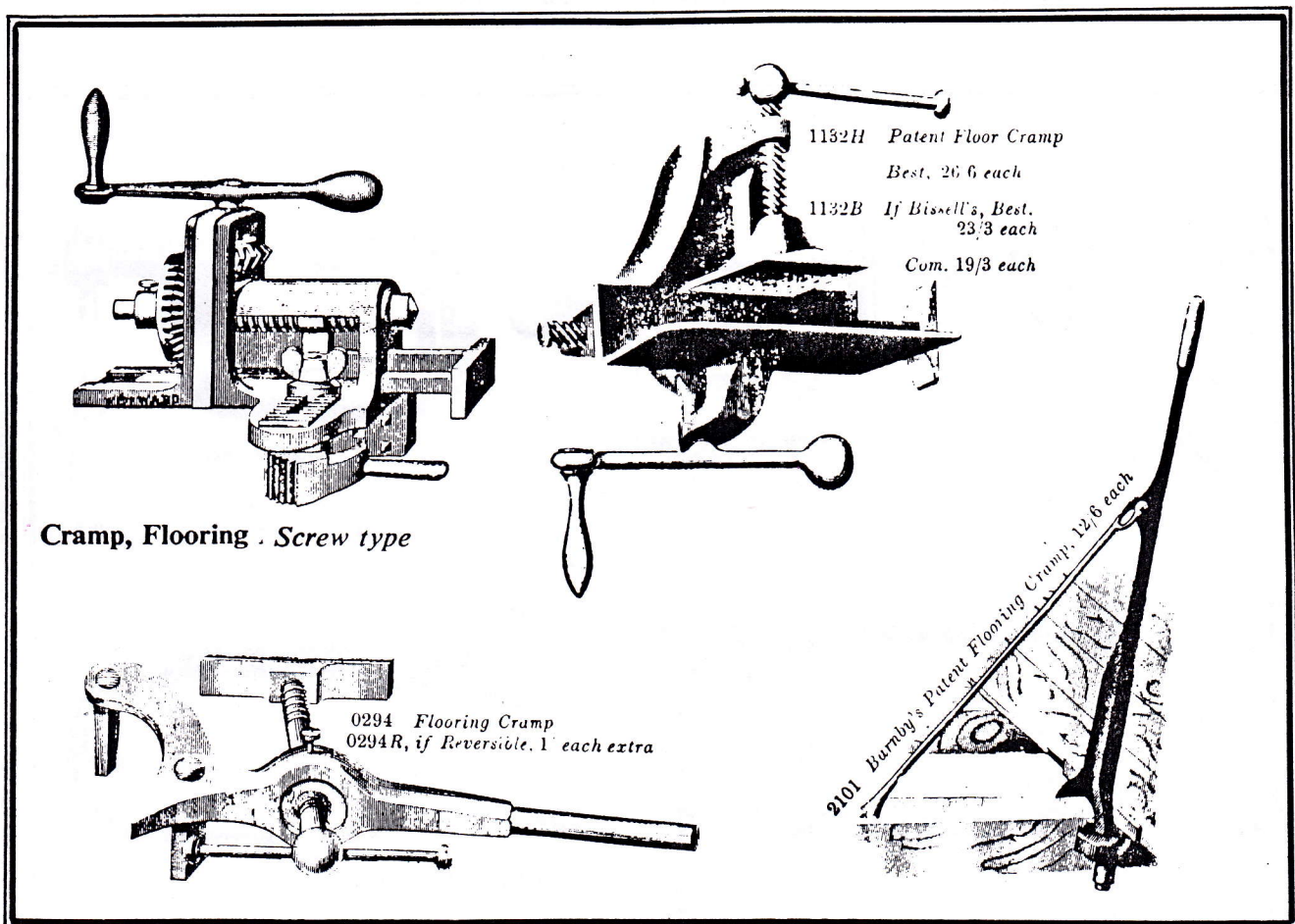
The door prize (which was kindly donated by Brian Evans) went to Fred Murrell, well deserved because he made a great contribution to our display of measuring equipment. Fred arrived and left like a pack-horse with bags in both hands and one on his shoulder.

Terry Butcher scored the 'booby', rigged of course, because I knew he'd appreciate a bar of carboric soap in its original wrapper.

Last but not least, Brian Evans gave us the rundown on Iron and Steel, I know those who attended are now better acquainted with the intricacies of steelmaking and his segment on Cast Iron captured everyones attention. Brian explained how Cast Iron was made and how extensive the range of items produced from Cast Iron e.g. tools, cooking pots, columns and lace for architecture, household cooking ranges, mangles, agricultural, engineering and woodworking machines and even a cast-iron bridge, built by Telford in the Ironbridge Gorge at Coalbrookdale England. The bridge (being the first time cast iron had been used as a structural material) used the joints of the woodworker - dovetails and mortice and tenon to fix the cast iron pieces together.

An extensive display of cast iron wares and tools at the meeting helped us appreciate the fineness of the work. I know Brian put a lot of time and effort into producing his speech so Brian, thank you again from us all.

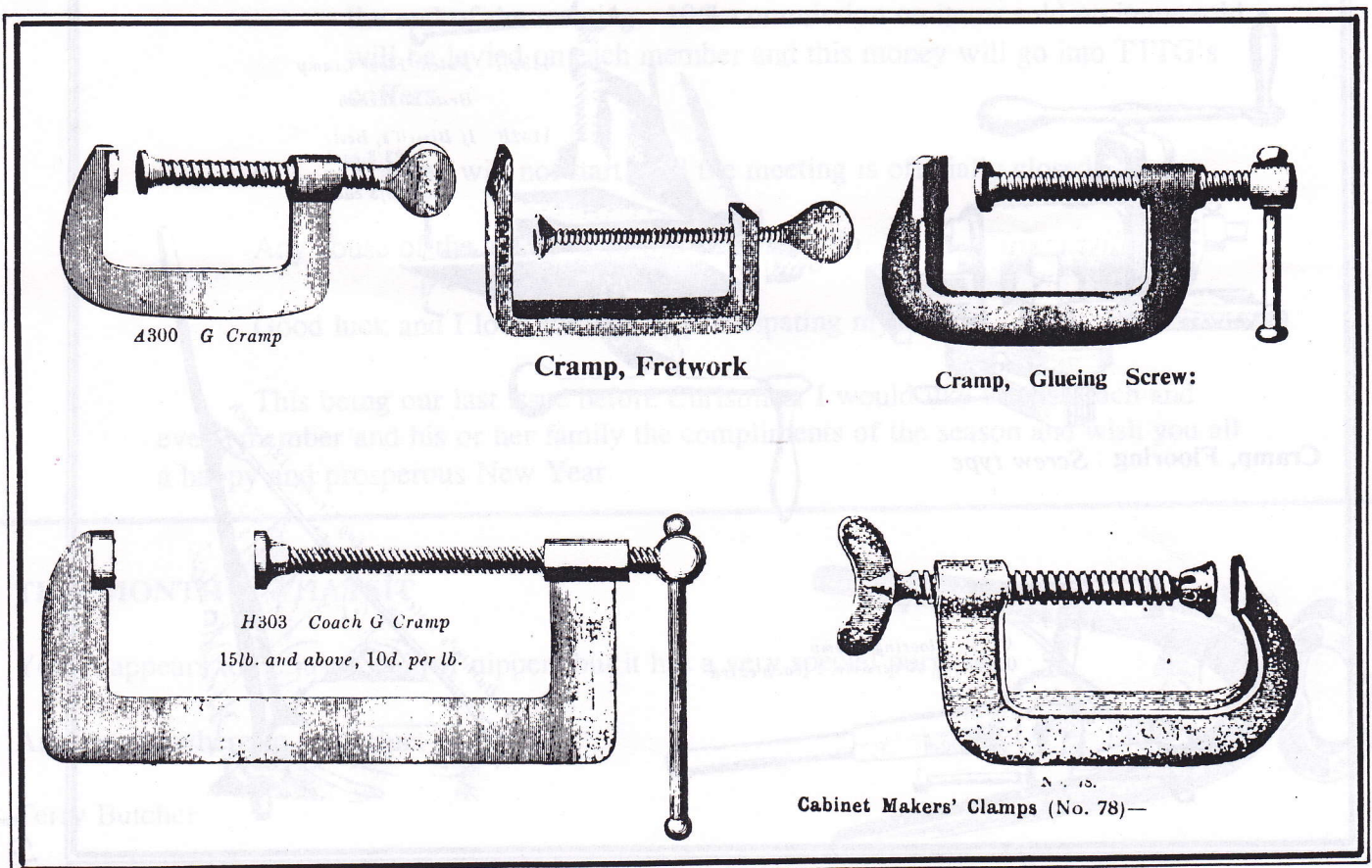
MAURICE BROWN



WE WOULD LIKE TO TAKE THIS OPPORTUNITY TO THANK THE FOLLOWING MEMBERS WHO CONTRIBUTED TO OUR DISPLAY AT THE 'WORKING WITH WOOD SHOW'

- RAY GURNEY** - FOR STORAGE OF SCREENS, MAKING SIGNS AND STAFFING THE EXHIBIT.
- TERRY BUTCHER** - LOANED TOOLS, SETUP AND STAFFED THE EXHIBIT AND ORGANISED THE SPACE.
- RICHARD WESTON** - LOANED TOOLS AND CABINETS, STAFFED THE EXHIBIT FULL TIME AND SET UP THE STAND.
- DONNA-MAY BOLLINGER** - LOANED A GLASS DISPLAY CABINET
- MIKE HENDRICKSON** - PROVIDED COFFEE FREE TO OUR MEMBERS
- EDDY STAPLETON** - STAFFED THE EXHIBIT
- PAUL GREGSON** - LOANED A TOOL BOX AND SIZE
- BOB CROSBIE** - STAFFED THE EXHIBIT
- SID BAILEY** - LOANED SECURE BOX AND TRANSPORTED BENCH
- MIKE WILLIAMS** - LOAN OF DUGCO BENCH
- FRED MURRELL** - LOAN OF ANTIQUE BENCH
- MAURICE BROWN** - FABRICATED METAL FRAME FOR SIGN
TRANSPORTED ITEMS, SET-UP AND STAFFED THE EXHIBIT

OUR APOLOGIES IF WE HAVE INADVERTANTLY MISSED ANYONE.



CAST STEEL

Brian Evans presented an excellent talk on iron and steel during the last general meeting. During question time an interesting question was asked about "cast steel" stamped on old chisels and plane irons. To clarify the matter readers may be interested in these brief notes.

Cast Steel was the trade name for crucible steel. This was steel produced by Huntsman's process. This steel was superior to early steels. Presumably the toolmakers stamped "warranted cast steel" to denote superior quality, and make a sale.

These old cast steels are fairly uniform in structure and were hardened and tempered to hold a superb edge. But the steel was only half the story.

Cast steel by itself is brittle when hardened. This simply means that a plane iron or chisel made entirely of cast steel and taken to a high temper would crack if subjected to a shock load. Such a load could be planing over a knot.

To overcome this all tools subject to shock loads were made by fire welding a layer of cast steel to a parent body of wrought iron. Being a "grainy" form of iron this wrought iron can absorb shocks. If you examine old plane irons and chisels you will see this fire weld and also the different appearance of cast steel and wrought iron.

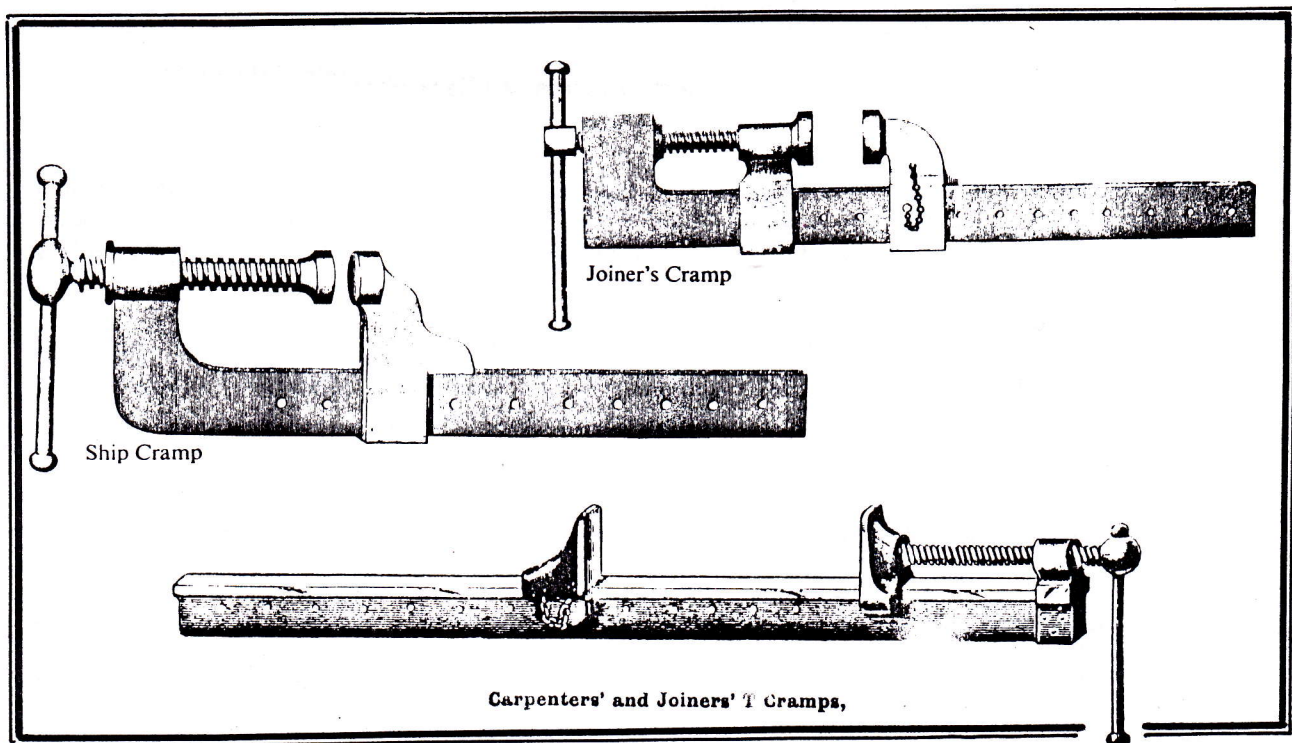
Of course this technique was applied to more than joiners' tools. Picks and crow bars were also made of wrought iron with a layer of steel inserted and fire welded to produce a cutting edge. It used to be a regular task for smiths to "re-steel" and "draw out" pick heads and bars for labourers and farmers.

Using a traditional bar with a well tempered inlay of steel one can chop through sandstone without jarring the hands. Try this with some modern solid bars and you may fracture most of the bones in the fingers. Axes were also made by this technique.

As for superior old steels and lost secrets, think about it.

Hopefully Maurice will persuade Brian to give another talk on Tool Steels. For my part it was a pleasure to listen to someone who really understood what he was talking about.

Editor



FILLISTER PLANES

In this article I intend to discuss the three types of Fillister Planes used by joiners in the British Isles and overseas colonies (including America).

What is a Fillister Plane?

It is a special purpose plane for cutting "rebates". It differs from a rebate plane in having a fence to guide the plane. Also fillisters usually have a "knicker" or secondary cutting knife and a depth stop.

Types of Fillisters

There are two broad categories of fillisters:

- a) planes which are "fenced" to plane a rebate into the face and edge of the stuff.
- b) planes which are fenced to plane rebates parallel with the face of the stuff.

Type (a) is known as a side fillister, type (b) as a back fillister. As type (b) was invariably used to stick rebates on sash stuff one variety was known as a Sash Fillister.

Side Fillisters

Side fillisters have a fence, a knicker and a depth stop. The basic concept can be enhanced by additional "extras", e.g. type of boxing, wood or brass or brass screw action stop etc., handle to the stock, exotic timbers. The iron is always set on the skew. Side fillisters can rebate along and across the grain. In reality they were seldom used by joiners, the plough and common rebate, or the Badger, serving the purpose. They were more commonly used by Cabinet makers.

Back Fillisters

These were the essential plane of the joiner being used to rebate stuff for sash windows, also jamb linings, gauging floor boards etc. Nicholson, early C.19th, talks of throwing shavings on and off the bench. A clearer way for the non user to visualise the two types of back fillister is to realise that the back fillister exists in an "old" and "new" form.

Old Pattern Back Fillister

In this plane the stock is rebated and has a plough type stop. No knicker is provided. This has two disadvantages.

- a) The cutting action is not visible to the user.
- b) If the grain runs the rebate is rough.

New Pattern Back Fillister : The Sash Fillister

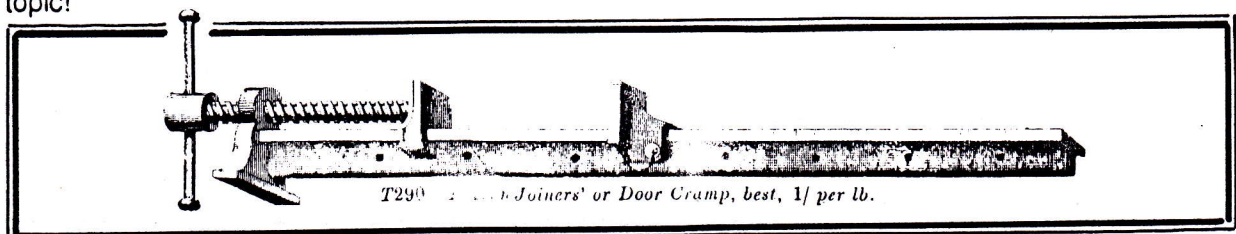
This plane has the eye opening towards the users left hand. The cutting action is unobscured. A knicker is provided to sever the fibres. This gives a clean cutting action. In sash making the "sticking on" and "sticking down" lines must be finished true from the planes. If they are not the sash will have open shoulders and scribes and probably be a slack fit. Unlike modern windows traditional sashes were precise, they must be water tight, if not wood and householder rot.

The iron is on the skew and the plane is subject to extras. All back fillisters are quickly identifiable by the outrigger fence. Superficially they are like ploughs.

Next to the plough they were the joiner's most expensive tool. First rate joiners treasured their ploughs and fillisters. Hence toolmakers lavished extras on these tools. Many patent fences were devised. Screw staves and metallic staves were great time savers and today are much desired by collectors.

A well sharpened and correctly adjusted sash fillister is a most pleasant tool to use. For sweetness of cutting action it equals the sash moulding planes. But of course they are partners in a technique which had reached total perfection before being displaced by the Spindle.

Patent metallic sash fillisters were also made for circular work or shaped sashes. That is another topic!



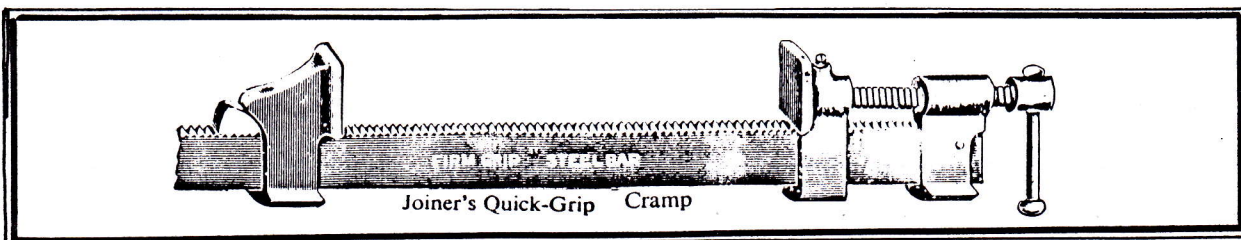
PATTERN MAKING

Extract from The English Mechanic, 16 March 1883

In the specialisation of trades once considered merely sections of the same handicraft, which has been going on during the present century, pattern-making has become a distinct occupation. Fifty years since, the old race of millwrights were "all-round" men in the engineering firms. They could fit up a mill throughout, design its arrangements, both general and in detail, make the patterns of the cast-iron work, gear the mortise-wheels, chip and file the iron toothed ones, weld a shaft, turn it in the lathe, forge the levers, fit up the pedestals and bearings, and, in fact, do all the work that is now divided among half a dozen separate and distinct trades. Necessarily this meant the sacrifice of some special skill, the absence of a certain mechanical facility which results from the division of labour. But, taken as a body, they were better craftsmen, because more complete than the mechanics who now do one thing, and one thing only. They were men of a strong representative character, skilful in the use of a few rough and ready tools, and equal to contingencies as they arose. The race, except in some isolated localities, has nearly died out. Now, the pattern-maker constructs the wooden models and gears the mortise-wheels; the fitter chips, files, and fastens different parts together; the planer, slotter, and shaper save the fitter's muscles and his time; the iron-turner turns his shafts and bores his wheels; and the smith makes the forgings, and if they be somewhat heavy; he has the steam-hammer by his side.

But this division of labour has its advantages, and very great ones too. Machinery has been cheapened immensely, there is more beauty and finish about it, and it can be turned out of hand much quicker than was possible under the old regime. More and more yet, the tendency of the time is to division - specialisation of labour. Men doing one class of work alone acquire a skill, a facility in that particular branch, which can be acquired and preserved in no other way. Science and the wide fields of knowledge yield no exception to this rule. Men in any and every walk of life can only acquire great distinction by moving in one groove. The boundless universe is fair and inviting; but each must be content to plough his own little furrow, glad if he accomplish worthy work before the night comes on.

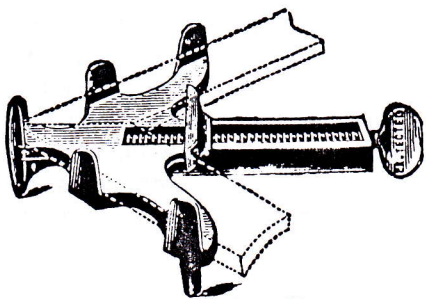
Enough of preface - now to our art and trade of pattern-making. Tools and timber, two essentials, may be disposed of briefly. Speaking generally, carpenters' tools are suitable for pattern work, but mortise-chisels are not wanted, neither is the plough and irons, nor the various bead and moulding-planes. And instead of a number of firmer chisels and gouges, long chisels and gouges, called paring-tools, are requisite. Special mention must be made of one tool - a tool which is used only by pattern makers - the "contraction-rule" As its name implies, it is a rule which is made longer than the standard measure by the amount which the metal iron contracts in cooling from the molten state to the ordinary atmospheric temperature. It would be obviously inconvenient to use a standard rule in pattern-making, because the workman would be perpetually making approximate allowances for contraction in fractional parts of a foot. So the contraction-rule economises his time and ensures something more accurate than approximations. A contraction-rule is nearly a $\frac{1}{4}$ in. longer than a common 2ft rule; strictly speaking, a $\frac{1}{4}$ in. in 2ft 6in. This represents nearly the maximum amount of contraction for iron, and is fairly correct, for general work. But an experienced pattern-maker knows that he must not trust too much to his rule, but that special allowances are required for special classes of work, and for different qualities of metal, as well as for different kinds of metal. Thus, while iron contracts an eighth in 15in., brass and steel contract an eighth in 10in., steel frequently rather more, and lead an eighth in 5in. A heavy casting will contract less than a light one, while a small casting will often come out as large, or even larger than the pattern. Hard iron will contract much more than soft iron, and the presence of large dried cores in the mould will diminish the amount of contraction. A plate with large superficies will almost invariably come out thicker than the pattern, owing to the fluid pressure exercised by the head of the runner, and also the top-part box not being entirely rigid. Experience alone can guide in these matters; and some element of uncertainty will always be present, for different mixtures of metal will show different contractions, as also will rapid or steady lowering of the temperature in the cooling of castings. But in general for castings of moderate size, the contraction rule is practically correct.



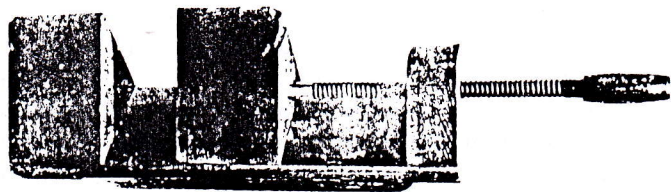
HOME CHIPS

Extracts from The English Mechanic, October 6, 1882

A correspondent has suggested a chapter or two upon home carpentry, as applied to the construction of fencing, sheds for bicycles, and such like everyday necessities; and, perhaps, such an article may prove of service to many readers of the English Mechanic. The correspondent in question lays down, however, certain postulates - viz., few tools, very clumsy fingers, and that the directions are not to be suitable to apprentices. These are hard conditions, and we must cap them with others. The fingers must cease their clumsiness, the tools must be suitable, and in good order, and the period of apprenticeship must be served - but may be shortened, it is hoped, by the present article. What is required, however, in this case, is plain carpentry, to the exclusion of that finer and neater work which is known as joinery; and, although in both the principles of construction are the same, carpentry is in some degree the easier of the two. No satisfactory work, however, can be done in either unless the workman is competent to undertake the primary operation of squaring up his timber, quartering, or boards. For this, some sort of work-bench will be necessary, with either a vice or an equivalent, the vice being cheap and very superior to any of the substitutes. Moreover, such a work-bench is easy to make, and may be made at first of sawn stuff, unplanned. It should be, at least, 6ft. long, and 2ft. wide, and a greater length is much better if the shop will take it. I have at the present time a great deal of carpenter's work going on at my own premises, to say nothing of masonry, which is far more detestable, and I have just measured a carpenter's bench set up in an empty coach-house - a bench I intend to keep, if possible, as I want another myself. It measures 8ft. in length by 2ft. in width, the top being of 1½in. board. The front board is 15in. wide, and the legs are of 3in. quartering, and the whole is 2ft.8in. high. This is a carpenter's bench, not an amateur's, and it is of decidedly rough build, but strong and serviceable, having already lasted a lifetime. I will give sketches and descriptions of its parts, and explain the method of its construction. First of all, the legs and framing of the ends are made (see Fig.1). For this you must saw off the required lengths of quartering, which need not be planed, but must be truly square, as upon the squareness of this stuff all the truth of the work will depend. Now here is a necessary apprentice's lesson. However rough the work and small the supply of tools, squaring the stuff must be somehow accomplished, or every part will be crooked, and the structure weak. Hence, a square must of necessity be one of those few tools spoken of. It may be of wood and home made, but it must be quite accurate. It is held as at *a* of Fig. 1B, to mark out mortises or lines by which to guide the saw in cutting wood off square, and as at *b* to try the squareness of a beam or board. Suppose the wood out of square, or in winding, a mortise marked by the square will not be true to the surfaces of the piece, and when the parts are put together they will be all on the twist, and cannot be forced into place. This, I believe, is the commonest of all faults in home carpentry. Moreover, you may try, as at *Bb*, with the square all along a bit of wood, and at each point it may be square, yet the whole may be in "winding", as it is called; and this has often deceived the home carpenter, and resulted in bad work. To ascertain this, two parallel strips of wood are placed some distance apart upon the wood, as *a, b*, of Fig. C, and the eye so placed as to look along them in the direction of the dotted line. If the top edges agree with each other, the stuff is so far true; but if not, it is winding, and the adze or plane, or both, must be used to rectify them, or the axe and plane if no adze is at hand.



Cramp, Corner



MITRE SHOOTING BLOCK

THE MACLEAY MUSEUM

On August 31 Julian Holland, curator of Scientific Instruments at the Macleay Museum, University of Sydney, gave a talk to TTTG members at the museum.

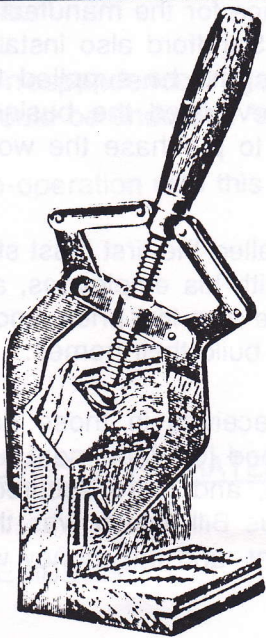
This was well received and the editor would like to convey the gratitude of TTTG Inc. to Mr Holland.

Members may not be aware of the treasures contained in the Macleay Museum. The collections include anthropological material, scientific instruments and a collection of early photographs.

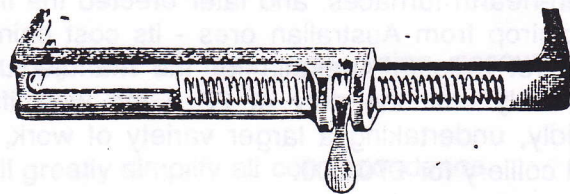
The Museum needs support and I urge all members to attempt to visit. Information can be obtained from:

Julian Holland
Curator of Scientific Instruments
The Macleay Museum
Gosper Lane
The University of Sydney
NSW 2006

Julian is researching the history of scientific instruments in Sydney. Members with old instruments, billheads, accounts catalogues or any references may be willing to share their knowledge, don't be afraid to write to the Macleay Museum.

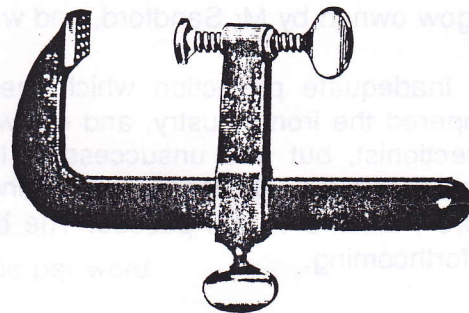


Cramp, Violin:

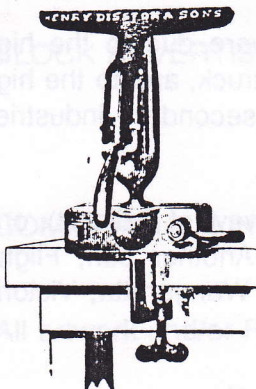


No. 78A.

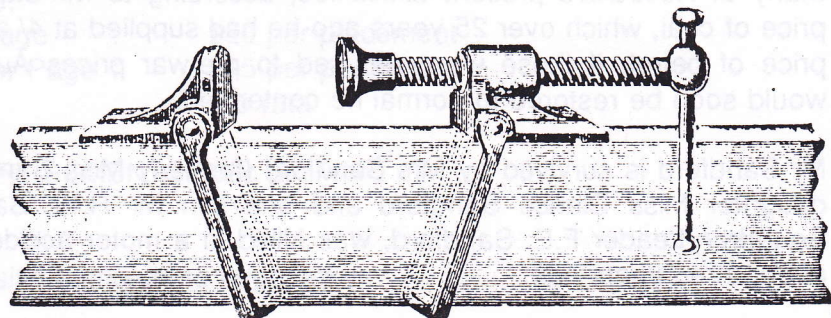
Universal Clamps (No. 78A)—



Cramp, Sliding Gee Pattern



Diston's Saw Clamp



No. 79x.

Cramp Head, head and tail (No. 79x)—

MR W. SANDFORD. SYDNEY. IRONMASTER

*Courtesy of Ralph Hawkins, Society of Australian Genealogists.
Undated newspaper clipping, Sydney Morning Herald, circa 1944*

The death occurred yesterday at his home in Ethel Street, Eastwood of Mr William Sandford, the veteran ironmaster and pioneer of the iron and steel industry in Australia, who celebrates his 90th birthday in September last. Despite his advanced age, Mr Sandford was a keen gardener, and until a few weeks ago attended daily to his vegetables and fruit trees. He was able to read with the aid of spectacles, and was remarkably active. He was keenly interested in the manufacturing industry and had an amazing knowledge of modern methods of steel manufacture.

Mr Sandford was born at Torrington (Devon), and was educated at a commercial school. He entered a bank at an early age, but disliking banking, he obtained a position on the London-Bristol railway. Later, he became interested in the iron and steel manufacturing business, and was appointed secretary to the Ashton Gate Iron Rolling Mills. Subsequently, he was engaged by John Lysaghts Ltd., to establish the first wire netting factory in Sydney. He came here in 1883, and after he had performed the contract for his employers he suggested that they should establish iron and steel works at Lithgow. They refused to do so. He took over the Fitzroy ironworks at Mittagong, where there was an old-fashioned blast furnace, but the difficulties proved too great. In 1886, he leased the ironworks and colliery at Eskbank himself, and commenced the manufacture of rails for the railway department. The works were antiquated, and the output during the first few months was only 30 tons a month. He was the first man in Australia to manufacture steel from open-hearth furnaces, and later erected the first modern blast furnace for the manufacture of pig-iron from Australian ores - its cost being over £100,000. Mr Sandford also installed the first mills in Australia for the manufacture of galvanised iron, and he supplied this profitably until the duty of £2 a ton was lifted. The proprietor developed the business rapidly, undertaking a larger variety of work, and, finally, decided to purchase the works and colliery for £70,000.

The number of employees increased from 200 to 1400, and he installed the first blast steel furnace erected in the country. He remained on excellent terms with his employees, and instituted a scheme whereby the men were encouraged to purchase at a low price land at Lithgow owned by Mr Sandford, and were guaranteed assistance to build their homes.

The inadequate protection which the Australian manufacturers received in those days hampered the iron industry, and on two occasions Mr Sandford stood for Parliament as a Protectionist, but was unsuccessful. In 1901 he went to England, and there secured a promise of £750,000 for manufacturing on condition that the Bonus Bill, which was then before Parliament, was passed. The bill was rejected by Parliament, and the money was not forthcoming.

In 1907 the firm of Hoskins took over the works and colliery, and since that date Mr Sandford lived in retirement at Castle Hill and at Eastwood.

Many of Australia's present difficulties, according to Mr Sandford, were due to the high price of coal, which over 25 years ago he had supplied at 4/ a ton on truck, and to the high price of petrol. If those were reduced to pre-war prices Australian secondary industries would soon be restored to normal he contended.

Mr Sandford is survived by Mrs Sandford (formerly Miss Caroline Newey, of Ballarat), one daughter Miss Clarice Sandford and one son Mr R.W. Sandford. Another son, Flight-Squadron-Leader F.E. Sandford, was killed in a motor accident near Wangaratta, Victoria about three years ago.

The funeral will take place this afternoon at the Northern Suburbs Cemetery.

EDITOR'S APOLOGY

In the last newsletter, No.13, an error occurred in placing advertisements. The incorrect advertisement for Reg Eaton was reproduced. Reg's shop is of course opened and stocked with many tempting items.

The editor takes full responsibility for this error and asks Reg to forgive this oversight. Naturally no charge is being made for this unwanted advertisement.

CORRESPONDENCE

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

The Secretary TTTG
Mr Paul Gregson
14 Railway Parade
Thornleigh NSW 2120

Contributions for the newsletter should be sent to this address and endorsed "attention editor".

Correspondence regarding membership or payment of fees, advertising accounts etc should be endorsed "attention treasurer".

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

ADVERTISING RATES

MEMBERS: Wanted or Swap or For Sale
First issue free. Thereafter 20¢ per word.

TRADER'S RATES: First Placement : Free
Second and subsequent advertisements

BLOCK ADVERTISEMENTS:
Half Page : \$20 per placement
Quarter Page : \$15 per placement
Other : pro rata

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STANLEY NO. 1

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ADDITION TO THE FAMILY

A SON - GRANT STANLEY

MRS COWEN REPORTED FROM HOSPITAL NO CUTTING WAS REQUIRED. IN FACT, IT
WAS JUST PLANESAILING. THE DOCTOR CHIPPED IN WITH 'HE'S A PERFECT LITTLE
SHAVER'.

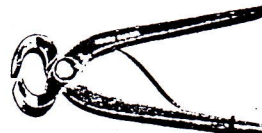
PETER HAS A VERY FINE COLLECTION OF STANLEY TOOLS. HMM, I WONDER IF
THERE IS SOME CONNECTION!

THIS MONTH'S WHATSIT

132

Heinrich Boker - Remscheid-Vieringhausen

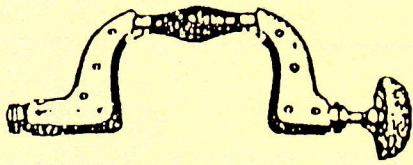
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14

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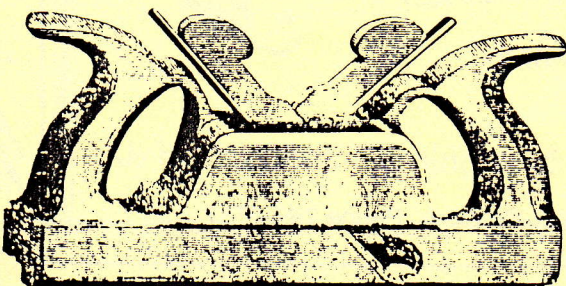
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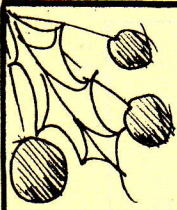
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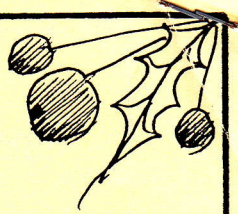


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