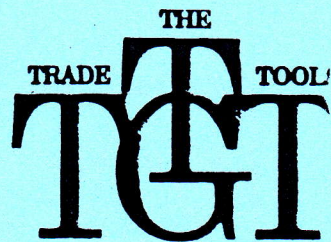


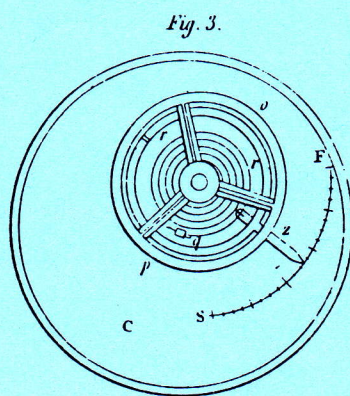
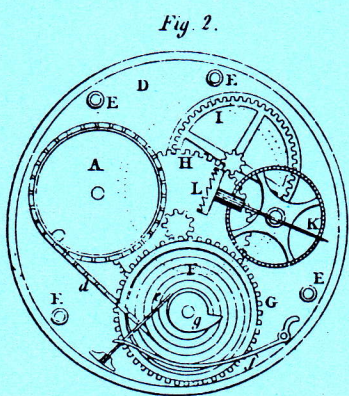
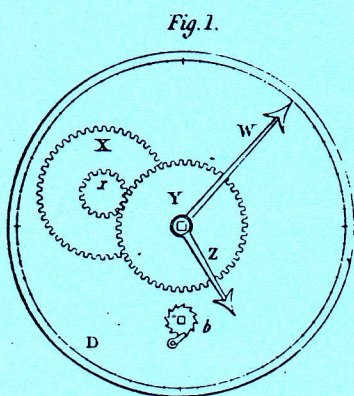
# THE TRADE TOOLS GROUP INC.



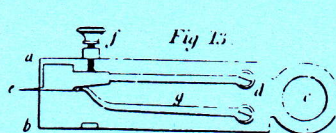
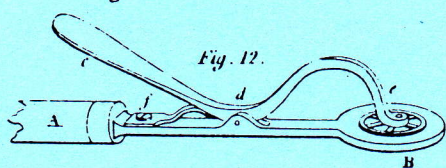
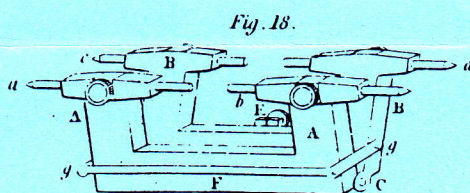
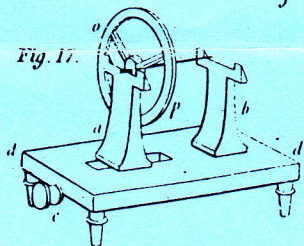
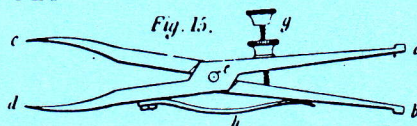
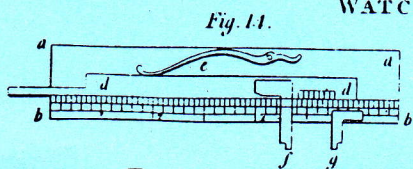
TTTG NEWSLETTER NO.19  
OCTOBER 1994

## THE CIRCLE OF THE MECHANICAL ARTS; WATCH WORK.

WATCH WORK.

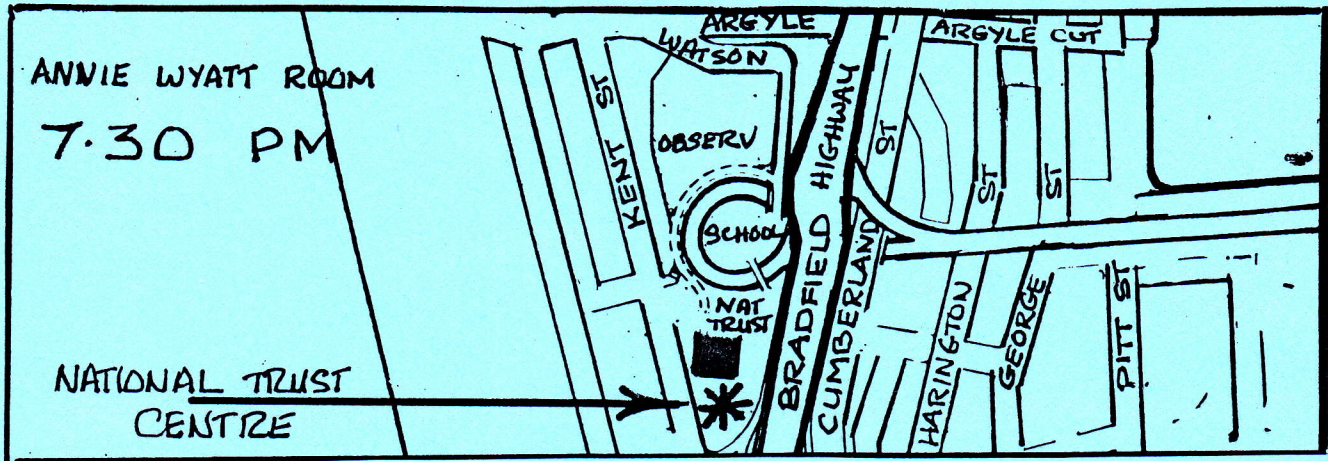


### WATCH TOOLS



By THOMAS MARTIN, CIVIL ENGINEER,  
ASSISTED BY EMINENT PROFESSIONAL MECHANICS AND  
MANUFACTURERS.

'The History of Tools is the History of Man'



### MEMBERSHIP

Members please note. If you have not renewed your annual subscription to the TTTG then this will be your last newsletter. We know how easy it is to overlook these things so if you are currently unfinancial please send your \$30 subscription to:

The Treasurer  
TTTG Inc.  
P.O. Box 240  
GROSVENOR PLACE  
SYDNEY NSW 2000

### **NEXT MEETING -TUESDAY OCTOBER 11TH**

**AT THE ANNIE WYATT ROOM, NATIONAL TRUST CENTRE, OBSERVATORY HILL  
COMMENCING AT 7.30 SHARP**

#### PROGRAMME.

1. COOPERS TOOLS AND THEIR USE. PRESENTED BY ANDREW BUTCHER. PLEASE BRING ANY COOPERS TOOLS OF YOUR OWN
2. DRAWING OF THE DOOR PRIZE
3. CHINESE TOOLS, THEIR USE AND RELEVANCE TO THE EARLY AUSTRALIAN CABINET MAKING INDUSTRY- INCLUDING MANY FINE AND INTERESTING EXAMPLES
4. FRED MURREL'S "WOTS IT" SESSION- BRING ALONG YOUR PUZZLES
5. SUPPER BY MARIO DAHTO
6. SID BAILEY'S LIBRARY TABLE
7. TOOL SWAP TABLE-BRING YOUR SWAPS

**TTTG Inc.**

**THE TRADE TOOLS GROUP**

**TTTG NEWSLETTER NO.19  
OCTOBER 1994**

**CONTENTS**

**REGULAR FEATURES:**

**Editor's Notes**

**Bob Crosbie**

**ARTICLES:**

**Extract from Nicholson. Part 2 of  
a continuing series  
Wood Infill Metal Planes. Part 3**

**Bob Crosbie**

**Letters to the Editor**

**Favourite Tools**

**Election Return**

**Book Review**

**Classified Advertisements**

***Cover: Watchmakers Tools (Martin's Circle of the Mechanical Art 1813)***

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Any opinions expressed are those of the contributor.

## EDITOR'S NOTES:

Looks like I'm editor for another year. This issue has a slightly changed format. I suppose I'm starting to get it right.

The new Committee is anxious to see TTTG improve and give the members even better value for our very moderate subscription.

We thought it might be an idea to state the obvious, if you have any friends who want to know about TTTG tell them to come to one of our meetings. Everyone is welcome though a small contribution to the cost of refreshments is appreciated.

The Committee is looking into the possibility of conducting a programme of occasional workshops. These would probably be on a Saturday and we have several venues in mind. Everything comes down to numbers so it is important that anyone who may be interested lets us know. A note to the Secretary at our Postal Address would help.

Possible workshops could be:-

- Using wooden planes
- Sharpening wood planes, e.g. moulding planes
- Wood adhesives
- Green woodwork, e.g. chair bodging
- Tool conservation: including metal working skills

Please let me know what you think of the idea.

This brings me to a delicate point. As convenient as it is we must ask members not to bypass our postal address policy. It is tempting to go directly to someone but long term it can cause a lot of confusion. This is the case when other societies are communicating with TTTG. Informal arrangements with say the President just don't work as they can frustrate the workings of the Committee. It is the Secretary's job to handle communication so let him do it by using our postal address. When it comes to donations this is especially important. Please don't give anything to a Committee member but approach the Committee via the Secretary at the Postal Address. No committee member wants to be put in a compromising position.

Hope to see you at the next meeting.

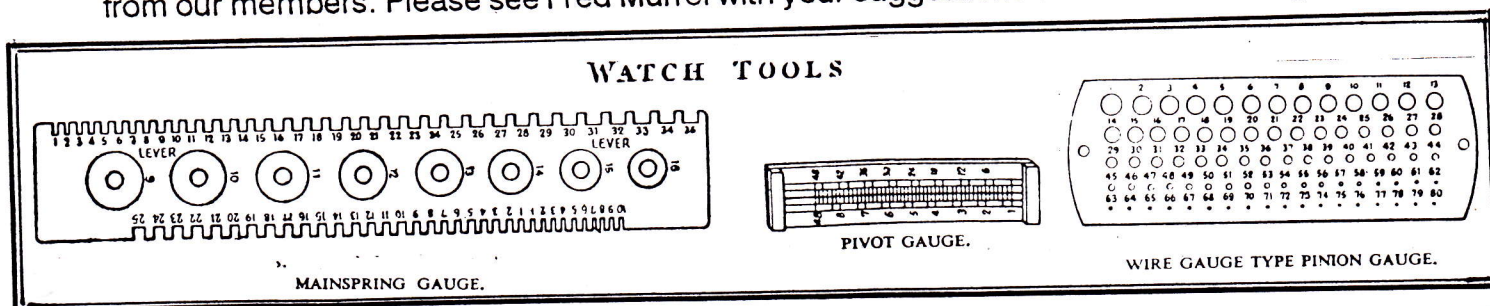
Bob Crosbie

## NEW NAME NEEDED FOR TTTG

Although we have registered TTTG Inc. there are a couple of businesses who have a title which is very close to The Trade Tools Group and we have been unable to obtain permission to use this name in its full form.

Suggestions for a new name have included "Australian Trade Tools Group" (probably hard to register this name); "All Trades Group"; "The Historical Tools and Trades Society (Group)"; "The Tools and Trades Preservation Society (Group)";

Any ideas for a new name (or comments and/or alterations to the above) are sought from our members. Please see Fred Murrell with your suggestions at the next meeting.



Extract from:

THE NEW  
**PRACTICAL BUILDER,**  
AND  
**Workman's Companion :**

Part 2

The GAUGE (*pl. LXVIII, fig. 13;*) consists of a rectangular prism, called the *head*, with a mortise of the same figure cut through it, between two of its opposite sides. In the mortise is inserted another square prism, called the *stem*, which is furnished with a steel point, nearly at the end of one of the surfaces, in the direction of its length, and projecting just sufficient to mark the surface of a piece of stuff when pressed thereon. The head can be set at any required distance from the steel point, by striking one or other end of the stem with a mallet, and then securing it at the point desired, by means of a small wedge, which passes through one of the sides of the mortise, and bears upon the stem.

The *Mortise-Gauge* is similar to the common gauge, only it is furnished with two teeth instead of one; the one of which can be placed at any distance from the other, which is stationary at the end of the stem. This gauge, as its name implies, is used for gauging mortises and tenons.

The GIMBLET (*pl. LXVIII, fig. 2,*) is a piece of steel, of a cylindric form, furnished with a worm or screw at the lower end, and with a transverse handle at the upper. It is used for boring small holes, by being turned round by the handle, while the screw at the other end draws it forward into the wood. To receive the core of the wood, it is formed with a cylindric cavity called the *cup*, just above the screw or worm; and it is by the edges, formed by means of the angle of the exterior and interior cylinders, that the fibres of the wood are cut across.

As the gimblet is a small tool of very slender construction, it is very liable to be twisted and broken before the workman is aware, unless it be frequently withdrawn, in order to remove the core excavated from the wood, as often as the cup or groove is filled. If the point of a gimblet is once broken, or the arris of the screw blunted, as it is very tedious and laborious to work with them in that state, they are generally thrown aside; but, though the grindstone cannot be applied for sharpening the gimblet, yet the point and

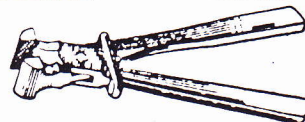
Watch Tools.



PIN VICE.



PIN TONGS.



SLIDING TONGS.

arris of the screw may, in a few minutes, be rendered fit for use again, by being sharpened with a file.

GOUGE.—See *Chisels*.

The HAMMER (*pl. LXIX, fig. 10.*) consists of a piece of iron or steel, flat at one end, for driving nails, &c.; and furnished at the other end with claws, inclined backwards towards the handle, so that the other end of the hammer may not penetrate into the wood in the act of drawing out nails with the claws. This inclination, likewise, encreases the power employed, by lessening the distance of the force to be overcome by the fulcrum.

The heads of hammers are fastened into their handles by two different methods; the first, by having plates of iron, extending from the head on each side, and thus forming a socket for the reception of the handle, which is fastened therein by means of screws, admitted into the wood of the handle through one or more holes in each of these plates of iron; the second method of fastening the handle into the head, is by passing the handle through a perforation in the head, and fastening it therein by wooden wedges driven in at the end of it.

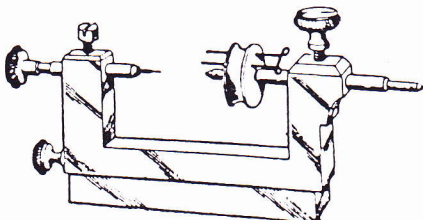
The object of having the head of the hammer perfectly well secured to the handle is indispensable, in order to avoid many accidents which might otherwise occur; but, though the first method is certainly well adapted to this end, yet, as the plates of iron render the handle inflexible at the very part where it is desirable that there should be some degree of spring, and, as the latter method possesses this advantage over the former, and may, moreover, be made equally secure, by dipping the wedges in glue before they are driven in; the latter manner of fastening the handle to the head must certainly obtain the preference.

The MALLET (*pl. LXIX, fig. 9.*) is, in construction, similar to the hammer, excepting that the head is a thick block of wood, in the form of the frustum of a pyramid. It possesses several advantages over the hammer; as, being of wood, it is less liable to damage substances struck with it; and being of equal weight, and, at the same time presenting a large surface, it is more easy to hit the ends of chisels, &c., with the mallet than with the hammer.

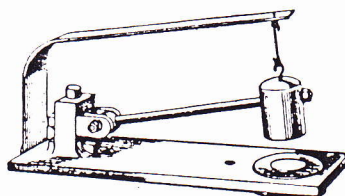
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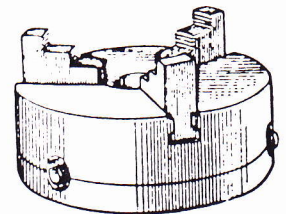
Watch Tools.



PIVOTING TOOL.



PLANISHING HAMMER.



UNIVERSAL CHUCK.

Mallets are generally made of the soundest and toughest wood that can be procured, as ash, beech, or the harder kinds of elm. They are usually made rather concave on that side into which the handle enters, and somewhat convex on the other; and, consequently, the ends with which the object is struck are not parallel with the handle, but inclined to it and to each other: but still the manner in which the blow is struck with the mallet, renders the striking end parallel with the surface struck.

Mallets are used principally for mortising and driving pins into wood.

MAUL.—See *Beetle*, page 236.

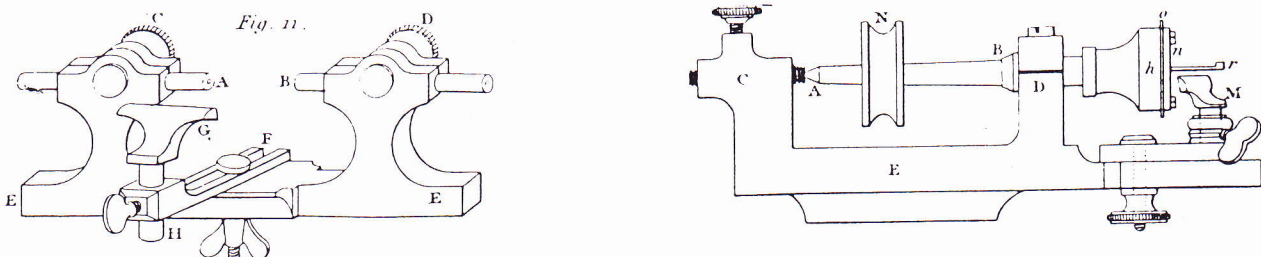
The MITRE SQUARE, an instrument so called because it bisects a right angle, or mitres a square; it is similar to the bevel, already described, excepting that the blade is set immoveably in the stock. It is used to strike an angle of forty-five degrees; this angle being required in joinery more frequently than any other angle, excepting the right angle.

The mitre square is used by laying the guide of the handle upon the arris, and sliding it along the face of the stuff till the oblique edge comes to the place required. By this edge the line required may be drawn.

PLANES.—Before we enter on a description of the various kinds of *Planes*, it may be useful to give a short explanation of the technical terms which it will be necessary to make use of in noticing this important class of tools. The *stock* (*a*, *fig. 1*, *pl. LXIX.*) is the block of wood in which the blade of the plane is fixed: it is generally made of well-seasoned beech, or any other species of close-grained hard wood. The *blade*, (*c*), which is called the iron of the plane, is made of iron and steel, welded together; the lower portion of the fore part, which goes into the stock, being of steel, and the remaining part of iron.

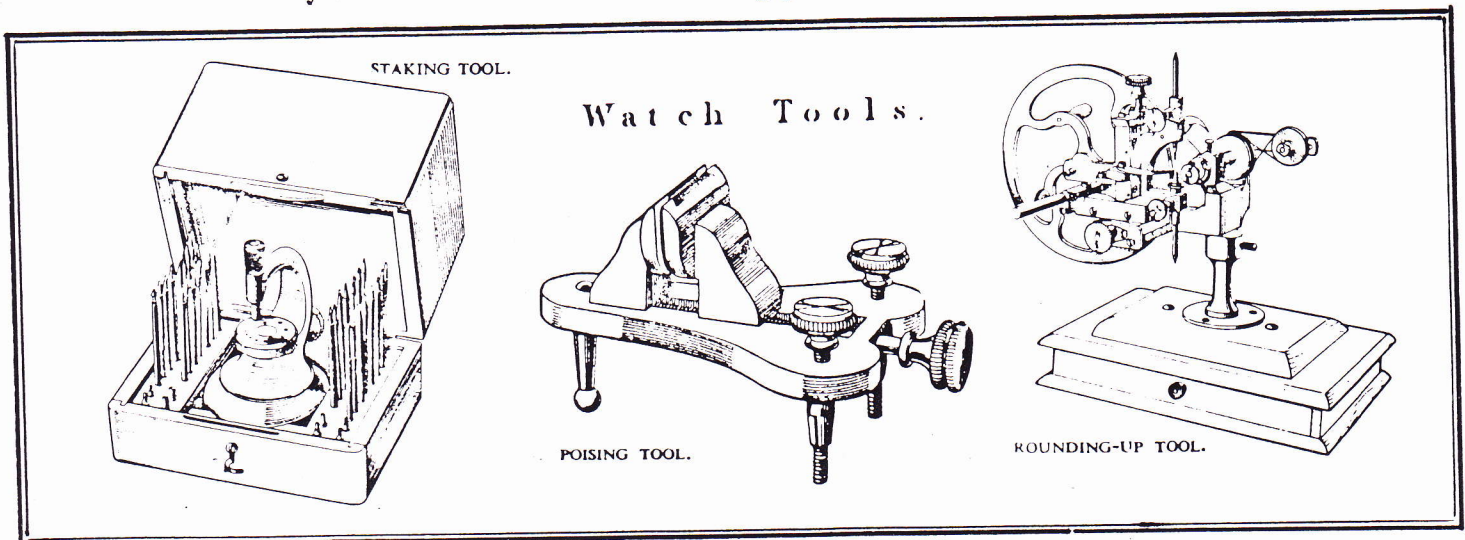
The *sole* of a plane is the under side of the stock, and the *height* or *depth* is the dimension of the plane from the sole to the upper surface. The *bed*, (*e*), which is a plane of various angles, according to the use for which the plane is intended, is the aperture in the stock, upon which the iron is laid, and secured by the wedge (*d*). The angle of the bed of the *jack-plane*, *trying-plane*, and *smoothing-plane*, is generally from forty-two to forty-five

## WATCH TOOLS



dégress; that of the *moulding-plane* about forty-five; and of those planes which operate by scraping, not more than four or five degrees: that is, they are nearly perpendicular. The *pitch* is the angle which the iron makes with the perpendicular mentioned above; and the greater this angle, the lower is the pitch of the iron said to be. The *basil*, which is the sloping edge of the iron of the plane, forms an acute angle with that steel side which is not ground, but always kept level. In grinding and whetting the irons of planes the basil must be made as flat as possible, or rather, in a small degree, concave, otherwise it will not seem to be sharp when used. For working soft wood the basil is usually made in an angle of twelve degrees, and for hard wood eighteen; it being remarked that the more acute the basil is, the better the instrument cuts; and the more obtuse, the stronger and fitter it is for service. The handle of a plane (*b*) is called the *tote*.

The generality of planes are about three inches and one-eighth deep; the jack-plane being something more, and the smoothing-plane something less. As it was found remarkably difficult to plane cross-grained stuff with the planes in common use, it became necessary to make planes for this purpose with a double blade (Nos. 1, 2, 3, *fig. 4*). The addition, in this case, consists of a piece of iron of the same breadth as the blade, with its lower end very thin, and its edge of the same shape as the edge of the blade. This piece of iron is called the *top-iron*, and is fastened to the other blade, by means of a screw fixed in the under blade, at the most convenient and useful distance from the edge. The edge of the top-iron should never extend below the sole of the plane, and should be at a certain distance from the edge of the plane, according to the thickness of the shaving which is required to be taken. The edge of the top-iron is arched in a small degree towards the lower end, so that the screw may necessarily make it fit so correctly to the level surface of the blade, that no shavings can get between, which is indispensable for its working clean and neat. The top-iron is generally used in the jack-plane, trying-plane, long-plane, and jointer-plane; but not in the smoothing-plane, or in any of the various kinds of moulding planes.



## Wood Infill Metal Planes. Part 3

### Screws

These are used for brittle castings or for planes stuffed by wood workers. Finished castings were available and men unskilled in metal working would naturally use wood screws. The use of screws on hard castings is self explanatory.

### Rivets

These are used for dovetailed planes and for annealed castings. Skilled plane makers could easily rivet a malleable casting. Early planes are wrought iron and riveted.

### Dating

If a screw is removed from a plane the form of the screw can be used to date the plane. The presence of screws as such is not an indication of age. The screw must be examined.

### The Wood Infill

Planes can be stuffed with any hardwood. Commercial planes are invariably Rosewood. Earlier commercial planes are more likely to be Mahogany. Later commercial planes are rosewood, ebony or beech stained to resemble rosewood. Owner stuffed planes can be walnut, mahogany, satin wood etc. As these planes were largely used by cabinet makers, shop fitters, and ship's joiners exotic cabinet woods are to be expected.

### Blades or Irons

The mouths of metal planes never "open". As a consequence irons should be of uniform thickness or parallel. The irons were of wrought iron steeled with cast steel. Most planes have irons by numerous Sheffield makers. In these the top is left black from the fire. Norris and Spiers supplied "all bright" irons. These were probably surface ground in a machine shop and not Sheffield ground by eye.

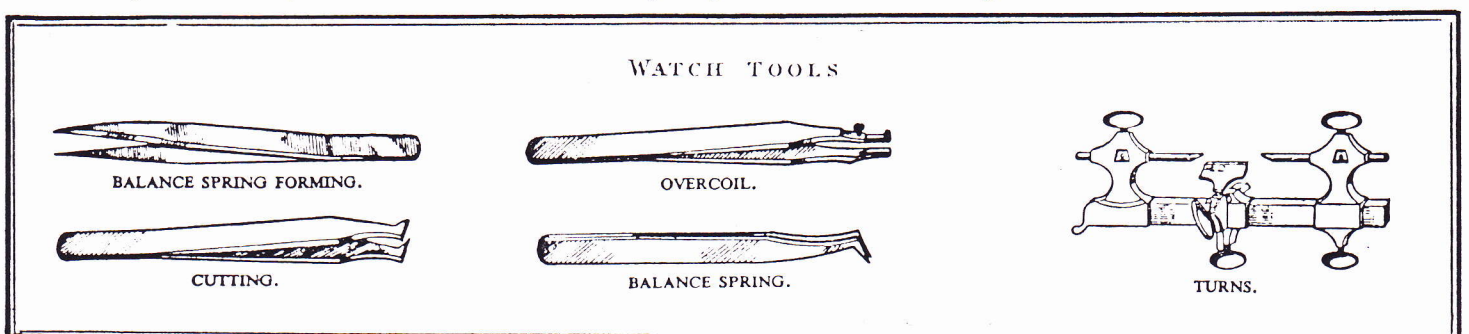
### Blade Holding

Several methods of blade holding were used in metal infill planes:

- a) Wedge, either
  - against side lugs cast with body;
  - against fixed bar or pivoting bar (used by Slater).
  
- b) Lever Cap. Gun metal or brass with jack screw.

From the late nineteenth century the Lever Cap was the preferred method. From the manufacturer's viewpoint it was probably the cheapest. Many tradesmen preferred the wooden wedge. My preference would be wedge and Slater's pivoting bar.

As makers such as Slater did not issue Catalogues their products are deemed inferior. If you want a plane to use examine the quality of the item and forget the label.



## Adjustment Mechanism

This occurs solely on Norris planes. What is its advantage? To a man who can hammer set a plane it has no real advantage. The device was first patented by Norris in 1913. After World War I the adjuster gave Norris a market advantage. Long apprenticeships were gone, men had to be trained or retrained quickly. Like the Stanley the Norris offered quick mastery.

## Setting non adjustable planes

A hammer used sensitively is capable of total control when setting a plane. Mallets etc are not used. Planes are not damaged by hammers, they are marked by users who cannot use hammers correctly.

## Types of Metal Infill Planes

The function of these planes is as follows:

Bench Plane: Smoothing, Panel, Joining or Jointing.

The terms Jack and Trying are not used to describe these planes. All sizes are finishing planes meant to produce fine shavings. It is the solidity of these planes and the freedom from chatter which achieves glass smooth results.

Mitre Plane - low angle bevel up plane with fine mouth.  
Used for finishing along or across the grain. Useful for end grain.

Rebate (Rabbitt) - High angle for finishing rebates along the grain.

Shoulder - Low angle, bevel up plane.  
Tenon shoulders, rebates across the grain.

Other types - Bullnose Rebate, Thumb, Chariot are usually all metal.

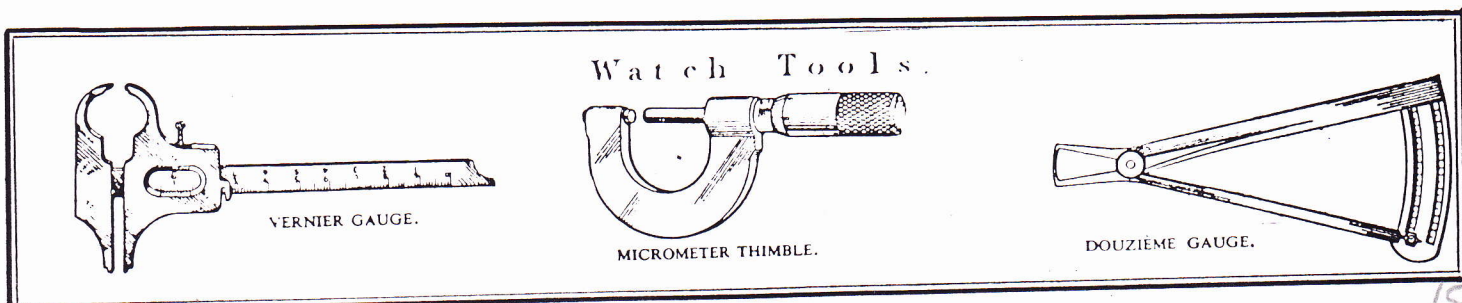
Skew Mouth or Eyed Planes - planes were available with skew blades to give a shear cut: mitre, shoulder.

## Replacing Blades

New owners of wood infill planes search the world for suitable blades. For those wanting to use these planes the solution is simple.

- 1) For the ultimate edge buy a heavy gauge German High Speed Steel Blade; wood plane type; or
- 2) Make a new iron from Non Distorting, Oil or Air Hardening alloy carbon steel. Harden and temper to 60-62 Rockwell C. Surface grinding should not be necessary.

Both will be superior to any old iron.



## Modern Wood Infill Planes

Reproductions of these planes are available. I am not aware of any maker who fully utilises modern production methods or materials.

The ultimate modern plane would have this specification.

Bench Plane: Smooth, Panel, Jointing.

Body:

stainless steel plates, welded and surface ground.

Wood Infill:

plantation grown hardwood secured by stainless steel rivets tung-oil finish.

Adjustment Mechanism:

Norris type. Stainless steel and gun metal. 40 TPI thread.

Back Iron:

Stainless steel, with stainless steel screw.

Lever Cap:

Gun metal. Removable pivots.

Blade:

High speed steel. 60-62 R.C.

N.B. Mitre, shoulder, delete cap iron, modify adjuster, optional wedge(wood).

## LETTERS TO THE EDITOR:

From Henry Lanz of Garrett Wade Australia Pty Ltd

*"I regret having missed your meeting on Tuesday evening after the reception that I had received the preceding Sunday by so many of your members at the Tool Sale in Burwood.*

*As a footnote to the talk presented on files I should like to add my experience over the past years in sharpening files and rasps. As I do not know the local product market well I may refer to American terms and assume that equivalents are available here.*

*The file must first be degreased and cleaned of any debris. I used tri-sodium phosphate which is a cleaner designed for dish-washing machine. This should be rinsed off after a vigorous brushing with this or an equivalent heavy duty detergent. Next the file is immersed in a 20% phosphoric acid bath for a few hours (depending upon dullness). After removing from the acid bath the surface of the file should be neutralised with a weak basic solution. There are commercial systems now being sold that are using comparable solutions. I have used the "Shark" brand with good results.*

*Needless to say, protective gear should be worn when using any of these materials especially the acid solution. At a minimum, gloves and goggles or a face shield.*

*Again, as I was not present at the meeting, this subject may have been brought out. If not, it may be of use to anyone trying to revive an old file or rasp."*

## FAVOURITE TOOLS

Everyone with an interest in woodwork soon develops a phobia for 'sharpness'. Once this was a skill learnt by practise and understanding of basic principles. Today it is an industry with a multitude of marvels on the market. You can spend a fortune on sharpening devices. I believe the modern woodworker has access to the best sharpening tools yet invented. Neither are particularly expensive. They are:

The Engineer's Grinder; and  
The Aluminium Oxide Oil Stone (Norton's "India")

The high speed grinder is the ideal way to grind woodworking tools provided:

- a) the correct wheels are used;
- b) the user knows how to grind.

In a future article we will explain why this tool has such a bad name and record the knowledge necessary before it can be used successfully. Perhaps put off spending all that money on wet grinders for a while?

But the subject for the moment is the Aluminium Oxide Oilstone, the India. Used correctly this gives the best edge for general joiner's work. With it you can produce an edge to shave with. The stone is cheap and long lasting. Kerosene is the best lubricant. To clean it use WD40. If it is really dirty it can be heated to burn out the rubbish.

In a future article we will discuss sharpening and oil stones. One more thing, don't try to flatten stones with sand, it is a waste of time, use plate glass and emery lapping compound; true a badly worn stone may take about 15 minutes but it's still cheaper than buying a new one.

For a general purpose stone the new Diamond Stones are excellent. But over all the India is hard to beat:

<b>YOUR NEW COMMITTEE</b>	
President	Fred Murrell
Vice Presidents	Henry Black Terry Butcher
Secretary	Mike Williams
Treasurer	Sid Bailey
Librarian	Sid Bailey
Membership	Ray Gurney
Editor	Bob Crosbie
Asst. Editor	Ian Goldsmith
Catering	Mario Dahto
Programme Organiser(pro tem)	Bob Crosbie
Telephone enquiries (after hours) (02)-44 6356 Secretary	

## BOOK REVIEW

### **The Convict Timber Getters of Pennant Hills**

**Ralph Hawkins**

**Soft Cover. Hard Cover**

Perhaps I will be accused of being biased in reviewing this book. The author is a good friend and I was one of the people to proof read "The Convict Timber Getters of Pennant Hills". Anyway I am going to try and convince members of TTTG to purchase a copy.

The Pennant Hills Ralph writes of is the Pennant Hills Establishment, a Government timber extracting settlement that cut and processed timber in the 1820's. The area of operation was from the base camp in present day Epping (Oxford Street) along the Ridge to present day Thornleigh. Here hardwoods were cut, conveyed to saw pits, converted and transported to the Parramatta River to be used in Parramatta or Sydney.

The men who cut the timber were convicts. For the first time in Australian history Ralph has written about convicts as real people and has examined their skills and life experiences. The book is a breakthrough in the methodology of Australian history. Some members of TTTG will buy the book for this reason.

Most members will not be so involved in our history. It is perhaps for people with only a vague interest in history or the part that the book has immediate relevance. All TTTG members are interested in tools. In this book Ralph talks tools but he places them in a wider context.

If you read this book you may become aware of this wider perspective. Like a growing number of people you may discover that Australia has a complex technological heritage. Ralph has shown that our origins both socially and technically are in our beginnings as a penal colony. If you want a good read, with pictures of tools, buy Ralph's book. At the least borrow a copy from the TTTG library.

Bob Crosbie

## Classified Advertisements

### FOR SALE

Alfred Ridge, Brass framed Brace, ebony infill, G+ condition  
Best offer.

Stanley 90A Rabbet Plane, not original iron. Best Offer.

Contact J. Black 059 431 061.

### WANTED TO BUY

Scottish Moulding Planes - Beveridge, Carrick, Chrighton, Christie, Conacher etc. etc. Also any two, three or four ironed planes and unusual Mathieson, Spiers planes.

Contact J. Black 059 431 061.

Specialist in Old & Antique Tools for Collector & Craftsman



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DON'T Miss SHOP 14 At The**

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Many 100s of unusual & quality tools

Planes by Norris, Spiers, Mathieson etc.  
Ultimatum and other braces, ebony tools, chisels,  
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18th Century items,  
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FURTHER INFO PHONE FLINDERS ST ANTIQUE CENTRE 02 332 3000

## **Green Woodwork Course Dates for 1994.**

3 day introductory course will cover the Bodging skills traditionally used by woodland workers and Mediaeval wood turners.

This includes selecting green timber, sawing the logs into butts, cleaving with wedges, axes and froe to produce billets which you will then shave in preparation for the Pole-lathe.

Learn the techniques and skills required to produce a turned finished article on the pole-lathe as the Bodgers once did in the ancient forests. Its safe, friendly, healthy, inexpensive, environmentally sound and can be set up in your garden.

The Courses will be held as follows at our workshop and campsite on the banks of the Hunter river at historic Morpeth, 2 hours north of Sydney:

The courses cost \$300 per person which includes materials, use of tools and equipment provided plus morning and afternoon tea. Class sizes will be limited to ensure maximum tuition and enjoyment. Tuition 9am - 5pm each day.

Sat 1st Oct - Mon 3rd October

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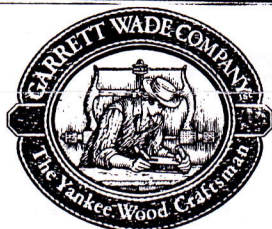
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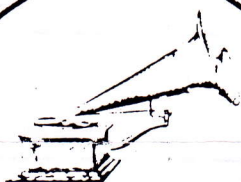
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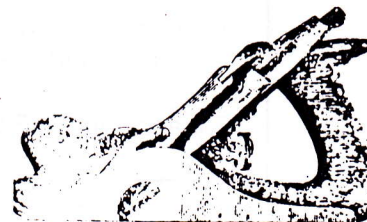
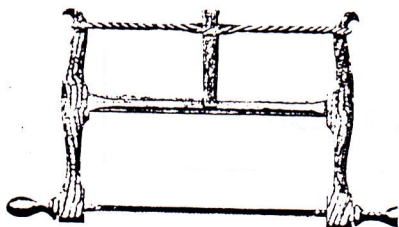
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