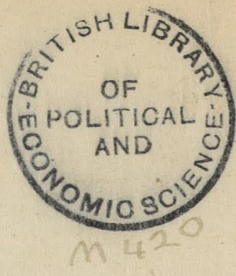


R. COLL. U.

B 977



Saddler, Harness Maker, sec. 24

Census figures for 1891.

Saddler, Harness, Whip maker, Horse clothing, Rag } 3877

for...
Wh...es

B 97

[i]

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leather Union
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J. Wilkinson & Son

Stick Dresser

Stick Finisher

All piece work.

Seasons.

Sep. 7th

G.H.D

J. Wilkinson & Son, 124 Spa Road, Bournemouth.
Whip mounts, Thongs, Handles, scales in
Whip sticks.

Will send father wages return.

Stick Dresser is the man who has given a
whip stick in the rough.
He clips the notches off, then pares off
the bark, & then varnishes it & returns
it for the handle & thong to be put on.
earns 35/- to 40/- in busy season.

Stick Finisher who puts on thong & handle is rather
less skilled & gets 30/- to 35/- in busy time.

All work is on Piece.

The men count to earn 25/- 8/- an hour, but
the whole year through they probably
do not make more than 25/-

(This was the opinion of one of the
best workmen in the shop).

September & October are slack for the best

Busy May to Sep

Regularity for 40 wks.

Do nothing for 12.

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

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

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

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

Prices paid for work done by whip stick vary from $\frac{3}{2}$ to 5/- according as many notches have to be cut & fashioned.

For the remaining 12 wks neither class does anything

Shifting.

Trade.

Training.

To make a ship.

They shift from house to house but have no alternative trade

1891. was busy.

92. falling rapidly.

93. very bad.

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

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

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

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

The wood is kept 2 years to season

When seasoned it is given out to the stick

Dresser who cuts the knots & straightens it.
He returns it to the whip maker who
stains & varnishes it (3 coats).
it is then ready for the handle & mounts
& things which are put on by the finisher.

Division of trade.

Finisher { fixes handles
 mounts
 'quills' up.
 Ties things to sick.

No sick club.

Rents of two of the men's houses.

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

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

Americans will have whips & saddlery from
London. Swaine & Honey. & Schomburg (for

Duties of a finisher.

Rents of men's rooms.

West End Demand.

Drink.

drag whips are the best whip makers.

These West End Horses also provide curious crooked whips which an ordinary whip maker w^d not look at. Smart young men like to have something out of the way & will pay a large price for a whip with a bend in the middle.

Swami & Adney & Schomburg make their own whips & their men have sick clubs.

Americans run after rabbit bitten holly sticks for whip handles

When there is snow on the ground the rabbits bite off parts of the holly bark, then next year's growth part of the bark will grow but where their saliva has run down it does not. A very pretty polish can be put on such handles & big makers will give as much as 2/6 each for them.

Complained a great deal of drink & large fankie in Bermuda

Seamless handles. These are the invention of Messrs Wilkin & are made from calves tails wh. are tanned & shaved etc.

Brown Saddlers.

Wages.

Hours.

Sep. 11th.

G. H. J.

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

Brown saddlers are the aristocrats of the trade, their work is paid more highly & they consider themselves the pick of the trade. They make hunting & other racing saddles for which the men are paid 18/6 each in the Strand & East End trade and 24/6 in the Haymarket & West End. But for the 24/6 the men have to put in a great deal of extra & what Mr. Smith called unnecessary work. Two saddles a week is considered good work in West End shops. Each shop has probably a different rate of pay & different hours. Here they work 5 1/2. 7.30 to 7.30 with 2 hours for meals and 7.30 to 2. (without dinner hours on Sat.)

Black Saddlers.

Harness makers.

Collar makers.

Saddle tree makers.

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

Black saddlers is those who make ^{driving} harness
saddles. They earn about 25¢ per week.
Their work is generally in lacquered
leather which is sold slightly cheaper
than brown leather because the faults
in the leather can be hidden by the
blackening.

Harness makers. These men work day-work
& earn about 25¢⁽²⁾ a week.
The men stitch the harness which is
heavy. Mr. J. knew one very quick stitcher
who could earn 35¢ but he was an
exception.

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

Regularity.

Lifting. yes.
Seasons.

Apprentice system dying.

which is made of steel or iron & beech wood
& cost from 12/- the cheapest to 20/-
each.

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

Men shift a good deal from house to house.
Seasons are not now so much marked as
formerly. Mrs Smith being chiefly an ex-
port trade there used to be a brisk
demand in the Autumn from officers going
abroad & a very slack time in the
Spring, now without any apparent reason
the seasons are much more equal.

January to June used always to be slack.
Training by the apprentice system is dying out
men used to be willing to pay £50 premium
to have their sons well taught from
14 years to 21. Now boys are taken on

How a boy is taught
Saddlemaking.

Nothing unhealthy.

No sick club.

2 Unions.

Women as stitchers.

& put to work with men they help the men
Here they can & 4/- per week is
deducted weekly from a man's earnings
to pay a new boy. At 21. they earn 8/-
or 11/- per week & are still paid out of
the men's piecework earnings.

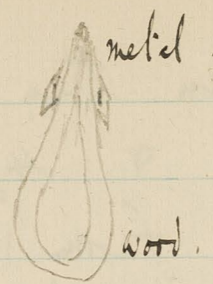
After that they generally go away &
seek work as an improver & will make
an av of 25/- until they are valuable
enough to get full piecework prices

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

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

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

Women are employed to do all the stitching
work in a saddle, they earn 10/-
a week & very often do this work at



Saddle frame.

To make a saddle.

Walsall is the centre.

Harness makers recruited
from the country.

London
A saddle is made by 1st getting the saddle frame -

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

Walsall is the centre of the trade.

All harness fittings are cast in the midlands for very high class work they are filed up in London but for most work they are sent already finished.

Harness makers are recruited from the country. Small country makers make their own harness but generally buy their saddles

Course of Trade.

From some large makers,
Trade in 91 was good.

92. — falling off.

93. — very bad.

Men are allowed to draw their piecework wages in advance, this is one of the troubles of the trade, they nearly always draw too much & have a balance against them.

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

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

Mason Swaine & Honey.

Stick Dressers.

Wages.

Finishers.

Mounters.

Braiders.

Sept. 12th

G.H.D.

Mason Swaine & Honey. Driving & riding whip
makers. 185 Piccadilly.

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

Finishers. Those who 'gill up' & fix things to whips.
& hunting crops.

earn from £2 to £2.10.0 per week

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

Braiders. ie those who with a machine braid

Thong makers.

Regularity.

Overtime.

Average earnings.

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

Thong makers. is a trade of small masters; these masters only teach the men how to plait the leather; the cutting of the strips they keep as a secret to themselves. These men are given 33¢ for 3 dozen thongs they have to supply the materials themselves wh. probably cost 1¢ or 1 1/2¢

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

In busy times there is a good deal of overtime; the men would rather work overtime than take on new hands.

In the season the men often work from 7 AM until 9 PM.

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

No shifting

Trade

Skill required

Apprentices

~~11~~
11

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

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

The Finest class of stick dressing is where stem knots & a great many of them have to be made is the most skilled part.

It also requires some considerable skill to make wire buttons in the plaited wire rings round ^{bottom} whip handles, & also round the joints of crops where they take the place of a mount. This is all done by hand, a man can make one in perhaps 1/2 hours.

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

Training.

No sick club.

The actual work done
on the premises to driving whips

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

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

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

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

Australia buys chiefly from Braunschweig.

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

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

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

Then it is sent to the dressers who make it smooth with a file & peel off the bark

To make a hunting crop.

puts a more notches when wanted.

Then the handle is fixed on & it is sent to be mounted. Then the thing is quilted on to the top & the whip is complete except for varnish & polishing wh. is done by hand.

Hunting crops. & ladies whips are made of cane and whale bone (whalebone now costs $\$2\frac{1}{2}$ a lb) was so expensive some years ago that some would use it so that the price had to go down. Now it is not mixed with cane: a piece is chosen of the required length & planed square, so that the spring in every part may be equal.

Then strips of cane ^{whalebone} are taken & fixed on by means of pitch to the center piece of whalebone. The whole is then planed true ~~and~~ with a taper towards the point.

This is rubbed over with pitch & again alternate layers of whalebone & cane are placed round about, the whole bound up & then moved through a gas jet to melt the pitch & make a good join of the whole together; this done it is again

17.
plated true & then wrapped round with tow;
then it is ^{rolled} rolled tight in a machine &
when cold is ready to go to the braider.

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

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

Humphrey. Harness maker.

Saddlers.

Divisions.

Black saddlers.

Sep. 13.

G. H. D.

F. J. Humphrey. Harness maker. Baker Street Bazaar.

Sells & repairs saddles but does not make them.

He has himself been in the Trade 30 yrs starting with a 5yr. apprenticeship of wh. he only completed 3. Has been in all the best West End Houses & claims to know the trade thoroughly.

Saddlers. A man generally starts as a flap & parcel hand & then works his way up to becoming a full blown saddler who can take a saddle tree & finish it into a saddle.

Saddlers proper are divided into sidesaddle hand & hunting saddle hand.

The minimum pay for a full week's work is 28s. The Union desires this.

Black saddlers. i. those who make driving saddles are not so well paid but their minimum is 28s. also.

Harness makers.

Wages.

The union & Piecework.
Rates.

Hours.

Harness makers, all work on piece, all the men belong to the union & earn from 25/- to 42/- per full week (56 hours). Just now things are very slack & the men refuse to work full time even where they have the chance in order to spread the work more evenly.

41

They have a book of piecework rates for almost every description of work, supplied by the union:
All good masters employ union men only & pay union rates.
All the best men in the trade belong to the union.
Where there is no price in the piece rate book the union recommends the men not to accept less than 9/- an hour.

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

Regularity

Prosperity 1887-91

Seasons

May 1. for carmen's harness

men are engaged by the week.

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

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

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

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

It may happen that one horse is shod while another

All busy or slack together.

2 Benefit Societies
in the Trade.

Diff bet London &
Provincial work.

Collar making.

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

There is no sick club in the shop but there
are two Benefit Societies in the Trade.
1. The Amicable Benefit Soc of Saddlers
& Harness makers Bridle cutters &
Collar makers.

Held at the 'Prince Albert' 5 Upper St
Martin's Lane. Instituted 1779.

This is failing now for want of proper
support.

2. Pension Fund Association.

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

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

ness. making supplies the world.

There is no kind of foreign competition, none ever thinks of buying foreign harness or saddlery & the trade is probably unique in this respect.

Training. Harness-makers have generally been apprenticed in the country & then come up to town to better themselves. The App system is dying out gradually but still in vogue in the country.

Birmingham men are not straightway fit for London harness work so much is done there by women except the sewing that a man will only know how to cut out the leather: in London he must do the whole job himself

Women are employed in horse cloth making & in sewing saddle

Was friendly gave further wages for his men & offered any further help.

Training.

Women emp^d for horse rags
& stitching saddles.

W. Betts, saddle tree maker.

Divisions of business.
wages

No seasons.

All have regular work.

No shifting.

Sep. 14th

G.H.S.

W. Betts, saddle-tree maker, 40 Charles Square Hoxton on an introduction from Mr Geo Smith.

Divisions. 1. Saddle tree makers, 22 women.
" " Riveters, } 40 ft av.
" " Canvasers. }

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

There are no seasons.

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

All the men have regular work if they will but they go on the booze for weeks together. There is no shifting, each man sticks to his own.

Trade was very bad this year 93. was pretty

Training

Age.

Govt. saddletrees made by
Cabinet makers.

To make a saddle tree.

79

fair in 91 but falling in 92.

The men admit no apprentices except the sons of men already in the business.

There are only 4 apprentices now working in the London Trade

A man is allowed to bring his son into the shop & to get what work he can out of him; pay is given to the Father for the amount of work he can turn out with his son to help him. This goes on until the son breaks off & settles to work for himself.

Though they are hard drinkers they are "like Donkey never die, to do are no mean no eyes". Government military trees are generally made by Cabinet makers.

Saddle-trees are made out of split beech wood, the wood is not sawn but always split with the grain wh. makes it very durable. The wood is split & trimmed with an axe to a rough shape & then is worked & fitted by a man with a two handed Knife. This he uses by paring towards himself (something like cutting thin bread &

fastens with a strap over the
shoulders.

Beech shavings & vinegar.

Drink.

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

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

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

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

There are only 2 ^{big} makers of saddle trees in Lassa, the
is one & employs 10 men.

The men drink hard (said there has been a
slight improvement there last 5 years & it is not
so bad as in the midlands (Bromsgrove) where
it is so uncommon thing for men to go
on the booze for a month).

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

much 'Dead Horse'

There is a great deal of drawing an account
& consequently much 'Dead Horse' in
the wages book against each man name.

This he is compelled by his society to pay
off before he can seek employment elsewhere.

The men from the midlands are not now allowed
to come into the London trade though a
London man may go to Birmingham & then come
back to London if he likes.

2 workmen room in the neighbourhood cost
8/6 & 7/6. weekly. said Mr. Betts.

Mr. B. let me take away one book containing the
wages of two of his best men which
have been copied & show the boozing periods
& 'Dead Horse'. These are unusually favourable
examples he said.

1 man in the wine shop. 4/- for 1 room
another - - - - - 4/6. for a front room

Military Harness & Accountants.

Unionists all.

Wages & Hours.

Piece.

A little day work.

Age.

Sep. 19th

G.A.N.

J. A. Smith 108 Alderminster Road. secy
to the Military Harness Accountant &
Address Trades Union. off to Trades
Council.

Started Aug. 8. 1888.

120 men in the Trade now.

All are Unionists.

Of them 80 are Helmet makers

Wages. Lowest men earn 20s. 25s.
middle 25s. 30s. } in Bangor
Best 30s. 40s.

All work is on piece.

The men average 6½ an hour now when the
av. in '86. '87. '88 (before the Sweating
Commission) was 22. This rise has
been obtained by the Union.

9 hours is reckoned as the full day.

There is a little day work in the cutting
room

Age is no matter, men are good workmen up

Season.

Overtime

Shifting.

Contracts gone to
Birmingham.

tall 70 & middle aged men (one of whom is Mr Smith) are the best.
Autumn & Spring are the busy seasons for the
Volunteer mechanics

Mid winter is slack.
Contracts that are given out in August can be
got to work on in September.

In October some overtime is worked.
Some men are fully employed all the year
round i.e. those men who are married to
a firm, that is they could not be certain
of getting a job elsewhere & therefore
stick on where they are.

Passes & Accoutrements makes recognize
me another ticket wherever they are.
The men shift one place or house to another
as the contracts are placed. Men shift off
it is nothing against a man to shift.
to have been employed in a great many
different houses.

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

Shifting to other Trades.

'A Mash'

No system of App'

Shoddy work
Incompetent Inspectors.

Trade recruited from Boys

in London wages.

When things are bad the men in the Trade go to the Boat-hack: play accordions, to the docks, turn riggers, or go out 'mashing'.

A 'Mash' is a man who owns 2 or 3 cabs of his own either permanently or for a short time.

It is a term of abuse to a cabman to call him a 'mash'.

There is no system of Apprenticeship except in the Harness Trade, whence the Helmet & accounts makers also draw some of their men.

Military harness has the very strong it is much heavier than ordinary harness.

There is a good deal of shifty work put in but not nearly so much as formerly because the Foot inspectors are not suff. competent men.

The Trade is recruited from Boys who come in to rat up harness, then they rivet, then they sew.

Admission to Society.

Manufacturing Houses in order of merit.

Union trying to break system of the subdivision of labour.

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

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

Order of merit of House in Trade.

Harness & Accents.

Mr. Bryan	} best.
" Roberts & Hunt.	
" Almond	
" Wallis	} not good.
" Hobson.	
" Herbert.	worst.
" Pullman.	unfair.

Helmets & Caps.

Hobson.	} best.
Stone.	
Silveston	
Herbert.	good.
Almond.	"
Blomfield.	
Christie.	worst.

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

Method of making
barners.

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

Women for Buff Leather.

You take your hide to make barners.

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

Names of tools used.

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

Women work at Buff contracts, now there
are not 50 but some times there are 150

Drink.

House rents in Bermondsey.

Trade Slang.

- Crows
- Jacksons
- Mumpers
- Calf

in the trade, they migrate from the jam factory.

Drink was a great evil: the old hands still drink but the younger men are not so much addicted.

Mr. Smith pays 10/- a week for 6 rooms & anteroom & a yard 16 x 8 ft. & the same is the rent of all houses in the street (Aldersminster Rd Bermondsey). In the Supton Road you pay 13/- for the same thing.

Trade slang.

Bad or rejected helmets are called 'Crows'.
Harness rejects are called 'Jacksons' i.e. (rejects).

Mumpers are those who say they belong to any trade.

'Dead Horse' is sometimes called 'Calf' which is really the Birmingham term.

On June . 12 . 1888 .	March 26 . 1889 .	} see first report on Sweating system pp. 458
	" 28	
	April "	
	" 12	

for information with ref to the trade.

Horse collar maker.

Divisions of Business.

Earnings.

Oct. 25th

G. H. D.

J. Briggs. Horse collar maker. Hoxton
Market. on an introduction from Mr
Batts the Saddle Tree maker. (p 23).

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

They employ. 8 men. 2 women & 2 boys.

Forewhale fillers.

Bodyers.

Finishers to put on the after-whale.

All these earn about 30s per week in a
slack week or a busy week.

Women are employed to sew the after-whale
on to the body and are generally

Women's work.

Seasons.

Regularity.

Shifting.

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

The busy season begins in January & lasts till October. Nobody buys new collars from Oct to Jan. The fog hides defects & in the winter none notices shabbiness.

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

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

Training.

Number of men in Trade.

Deaf & dumb.

Healthy.

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

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

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

5 years to learn. There are a good many deaf & dumb in the line who are apprenticed by societies to certain masters but either they were unnaturally stupid or the masters to whom they were apprenticed did not trouble to teach them every part of the business, certainly the one in the shop was not up to much & had not learnt more than $\frac{1}{2}$ his trade in 5 years.

It is very healthy. Somehow he said every thing to do with the preparation ^{of leather} was working of it was healthy.

Drink better owing
to Union.

Hoxton market the
worst neighbourhood in
London.
Rents.

Conditions of work.

80

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

Hoxton market Mr Betts & the foreman told me was the most disreputable neighbourhood in London. No one would dare to walk about without a gun at night you were sure to be attacked.

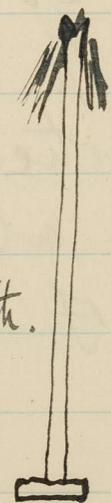
Rents were from 3/- to 3/6. for one room
to 6/- 6/6. - - - 2 - - -

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

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

The manufacture of a
horse-collar.

rod with bits of
straw across the tooth.



lead hammer for shaping the
straw.



7 on upstairs when the leather is cut to shape.

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

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

The straw is held by the tooth & ~~with~~ & then poked in to the leather tube & rammed down by thumping the head against a foot board which is a thick block of wood set about 10 inches into the ground.

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

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

Men usually learn every branch & then

No foreign competition

confine themselves to that at which they are best.

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

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

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

Chaise Saddlers Society.

Founded.

Numbers.

Unionists do not work with
Non Unionists.

Good relations with masters
except with Jenkinson's.

Oct 26th.

G. H. D.

F. Whisker. 16. Law frame Road. Old Ford. E.
sect 4 to the London Chaise saddlers.
Trade Protection society.
not affiliated to T.C.

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

Chaise saddlers. Pad makers. (only 5). these last
properly go with the saddlers & harness
makers soc.

60 members highest in 1890.

47. lowest 1893.

U & Non U. do not work together.

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

Nearly all Piece

Womens work

in total all the
50% of flaps in best West End work
are sewn by men & boys.
in v. slack times the men sew their
own work.

Work subdivided in
small houses.

Union not strong enough
to enforce its price list

Prices for making saddles.

Nearly all piece work: only about 4 men work
on day work, one of whom is a foreman.

A chaise saddle is a gig saddle like a cab saddle.
A man is given a saddle tree who then
takes it & finishes it - throughout eye.
that women sew the flaps & the
serge underneath.

about 50% of the men do the saddle them-
selves alone eye for the women: but in
the very small houses the work is subdivided
just the reverse to what ordinarily occurs
in other trades.

They have not been able to bring out a piece
work list & not two shops work
alike. (They have got a price-book out
but not one firm follows it & they are
not able to enforce it). The prices are
rather above those paid by the best
firms at present.

Saddle made for 5/- to 10/-
of an common gig without sewing requiring
no womens work exc. 3/- for the sewing
of the serge against the horses back.

Amount of week's work

Average earnings

Seasons.

Work shed in slack times.

The av-price for cat saddle is 7/-

The best West End trees are made to order if you are told whether to make wide or narrow fittings according as the horse is round or has narrow high withers.

5 of the very best can be made in the week but only by very quick men, ordinary men make about 4.

10 of the common but ones generally include some of one & some of another quality.

a very quick man can earn.

The average earnings right through the London Trade are 3/- throughout the year.

Winter is slack. earnings what you can get

Summer is busy. " 4/2.

It all depends on a man's quickness how much he can earn.

In slack times the work is shed all round.

The London season makes the difference -

Walsall is the great centre where a great many women do what in London is considered men's work. Such as sewing down the saddles, binding cantles is the

Busy time begins at Easter.

All busy together.

Foreign work.

Good Firms.

Small masters.

past behind.

Just about Easter they reckon to start working longer hours. according to Trade, as a rule masters work long hours, it is difficult to find men when things are busy.

All shops are busy together. Wal. all does the largest export trade & London a little we should supply the world if it were not for the high import duties.

Nothing can beat English work for solidity & durability.

French learners is very neat but not so solid, machines are used largely in Paris now has been there

Good Firms are.

Bliss's in Lambth.

Walters & Crofts.

They are trying to get the work of the whole trade like this but the small masters spoil the trade.

The majority of small masters are workmen who have had a row with the foreman

Good till any age.

Retailers

Training

Admission to Soc.

Names of small masters.

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

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

The wages are paid to the men for work done & the men then employ women son's widows or daughters.

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

Retailers never ^(handy men) make the chaise saddles themselves just as they never make the collars. Retailers are only practical harness or saddle makers.

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

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

Whittingham. Tidcot. Day. Mitchel. Gribham

1 App to 5 men enforced. Wakefield House.

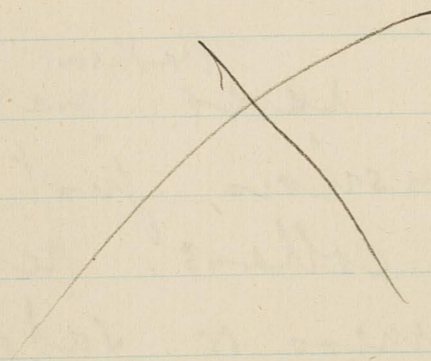
3 to be limit anywhere

Wholesale houses.

Wholesale
Houses }

Wholesale firms are very good about
making up for stock in slack times.
Willin as carry of raw at 5/30 instead of 7/.

Benefits:



The men very steady.

men employed.

- 13 men Bliss. Sun St. Finsbury
- 3. Walters Sun. Market St. ..
- Jankinson London wall (don't make in London wall)
- 2. Croot. Wormwood St. EC. (wholesale & retail).

The rest of the 47 are at the small master
saddlers, of whom there are about 8 employing
from me to 6 hands.

Benefits.

No sick fund.

Out of work. 10/- for 2 wks } then no more.
5/- ----- }

Death. 1/- for members only.

No pension.

Subscription 3/- per wk.

Said employers w'd give more if they could get more.
All the good West End work is done in London.
but there is not enough to employ more
than

There is no such thing as west & east ^{city} prices
most firms have shop clubs. (i.e. the 4 mentioned above)
Men a very steady lot, always has been, & no get better
now.

Messrs Bliss & Co.
Whole sale saddles etc.

Division of Business. wages

Price.

Hours.

All regular.

Oct. 27th

G.H.D.

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

They employ 120 men (including 27 women).

Brown saddlers 40/- 45/-

Black Saddlers. 30/- 35/-

Harness makers. 30/- 35/-

Bridle cutters. 35/- 40/-

Horse clothing mkes. 15/- w.

Very nearly all work is on piece.

Hours. 9 - 6.

9 - 2 Saturdays.

1 hr. for lunch.

20 min for tea.

All the men get 52 weeks work in the

year

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

FashionNo shiftingWoman's work

coverings for their horses

They make for stock when they do not make for actual orders.

There is a certain amount of fashion within narrow lines, last year there was a run of Whippes's goods, the year Champion & Wilton is the most fashionable men. There are just little peculiarities which outsiders do not notice such as diff. buckles etc but in the main there is very little change.

There is no shifting: each branch is a separate trade & worked at by men who do not change from one to the other

He did not know how much gig saddle makers paid to women for sewing the flaps. Women did some of the very fine needle sewing, the finest of which was 16 stitches to the inch, the number is pricked & then sewed according the hole being made with an awl & then the needle pushed through.

Horse clothing.

French work.

Mr Edwin Bliss.

Machine work.

Two needles & thread are worked with at the same time. Machines are used for doing the horse-clothing worked by women who earn about 15/-

The letters & script are also made here but the embroidery work is given out. Horse clothing is made more in London than elsewhere & very well made. The cloth comes from Chipping Norton (the best) when Mr Bliss has a connection & costs 7/6 a yard. French do very neat work but not so durable.

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

Wholesale & Retail Prices

but Davis's of the Strand now put machine work into their cheap £3.5.0 saddles.

The cheap saddles that Mr Bliss sells for £4.0/- are resold by saddlers for £3.3.0 the expensive saddles that are retailed at £6.6.0 with the very best work & material are sold by Mr Bliss for £7.0/-

No name or trade mark is put on any of their work, retailers won't have it they like their customers to think that they make everything themselves, whereas they make only saddles & harness.

Messrs Jenkins on

His works logs.

All piecework.

Oct. 31.

G. H. J.

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

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

Women & Boys.

Good work.

Sig saddles.

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

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

They have a great order for rose bags. Sig saddles they now make in the country. (There was a great deal of hesitation in saying this first they said they were made on the premises, then in another part of London, & finally in the country). Then he just been a strike & all the sig saddles called out: men Jenkins will only pay & waiting prices but

Spurs.

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

Very few stirrups are made in London.

There is one small maker named Smart
in Soho sometimes but the majority
come from Walsall & Birmingham.

The only great demand is for army spurs
some of which are made in London.

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

Oct. 17th

G.H.D

J. T. Morrison. London Saddle & Harness Makers
Trade Protection Soc. meeting 5 Upper
St Martin's Lane.

Gen meetings 1st Mondays.
Delegates 3. - - -
Executive 4th

Started Sep. 24. 1872.

658 members a books out of a possible
1200 in London. (not all financial).
These in are unquestionably the picked
workmen of the Trade.

This is the highest they have ever had.
Lowest about 300 in 1875.

The two do work together.

Relations are very good now & always have
been

Collar makers, brown saddlers, black saddlers
harness makers are all distinct & bridle
cutters (very little done in London, not

particular board of arbitration

ours

Minimum wage

Time & piece work

in Walsell where women do it.
No neg. board of arbitration though in
harmony with London Chamber of Com-
merce conciliation & arbitration board of
wh. Mr M is the leather member.

56 1/2 hours. full working week.
O.T. is forbidden by the Union & it is
fairly well carried out by the employer.
They are threatened by the opp. of one West's
man (Whitby, Staple C. North Hadley)
who will employ any man who agree
they will work O.T. when necessary.
The Union aims that this shd not be
done while any boards are vacant.

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

27 of employers are not practical men.

Ages of capacity.

Less seasons than 20 years ago.

Seasons.

No diff. bet east end wages & work recognized.
Not 27 of the employers are not practical men; warehouses in the city make the 27.

16-65 years of age are the gen. age. very healthy & not very laborious but though this cannot be said to be due to the workshops supplied by the employers which are bad.

He has only seen one man who has ever seen a factory inspector.

Trade revolutionised in last 20 yrs. with regard to season work.

20 yrs ago harness makers flocked to London about March & had work till the end of July, working OT during the whole period.

Now this is altered. Trade is more general American & colonial trade has made more equality.

Harness season is busier. March to end of Aug.

∴ Park season.

Saddles are busier. Sep — March ∴ busy

Work shared in
slack times.

No shifting.

Strikes

Shifting to other employers.

Black saddlers,
Collar makers, } follow with harness & bridle
cutters with the saddlers.

In slack times the work is gen. shared
fashion does not affect harness or saddles
in this they are exceptionally fortunate
The new fashion is to have longer
narrower saddles for polo players.

No shifting -

Black saddles do become a sketches but
the trade do not encourage it.

The Union is very strong against the division
of labour.

Strikes. 19. since starting including lock-outs
3 serious ones.

1 in 24 at Jenkinson for an increase
- 57 v. idea of long term working for 40% down wages.
who then took his work to well.

Have spent over £650 up to present in strikes &
lock outs.

given to other T. U. more than £600.

Shifting to other employers is not usual. but
is done. Big orders are not of a
frequent occurrence, men give their
orders very regularly.

Training

Apprentices in the Country.

Girls & boys in City work.

Very Temperate.

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

Training by Apprenticeship only. Employers wont have Apps in London. All but last serve their App. in the country.

Trades recruited from the country. only 7 out of 33 at Mr. Mr. firm have learnt in London.

Wilkinson Kidd, etc. 20 hand Pats. Crates. 20^(exc.) have some who learnt in London.

In the city ^{lads} women do stitching for Black harness. Some brown saddle & harness.

This is quite distinct from the Manchester Soc. wh. has 27 branches. Birmingham is one. If new member have to satisfy the Union that they be over the minimum wage. A very temperate trade

Gov. ann. report. will send rates, books of prices.

Benefits.

Subs.

Wages.

Gentlemen now order their
own harness.

Benefits. O.W. 14. for 6 wk.
Funeral. £5 memb. £2.00 wife.
Benefit. according to tier for members &
nonmembers.

Strike 20p x 1/- for each child.
There is a sep organization called Saddle & other
pension fund assoc.

Subs: 3⁰ wklly.

Wages are calculated at 9⁰ hr. for ordinary men
working according to Union prices if slow.
a quick man 29. hr. m. has made as
much as 1/4 an hour.

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

Harness at State Drawing Room.

58
For Drawing Room coachmen used also
always border new harness. Much went
back at the last but only used 20 out of
400 carriages with new trappings.

Jerkums is the worst sweating firm in India

Horse collar makers Soc.

80 members out of 110 in London.

Benefits

July 20th 1894.

J.H.W.

W. Jozant. President. Stone collar makers Soc.
21. Victoria Chambers.
Paul St. &c.

Copy. Dear Sir.

In answer to yours, I am sorry that my Committee would not give me authority to write to you before, as regards the present request.

1st. We have now 80 members out of an estimated number of 110 in the trade in London.

2nd. The present Society was founded in 1872.

3rd. We give in sickness 14/- per week for 8 weeks & 7/- per wk for 8 weeks. £5.00 members death & on the death of a members wife a levy of 4/- per member.

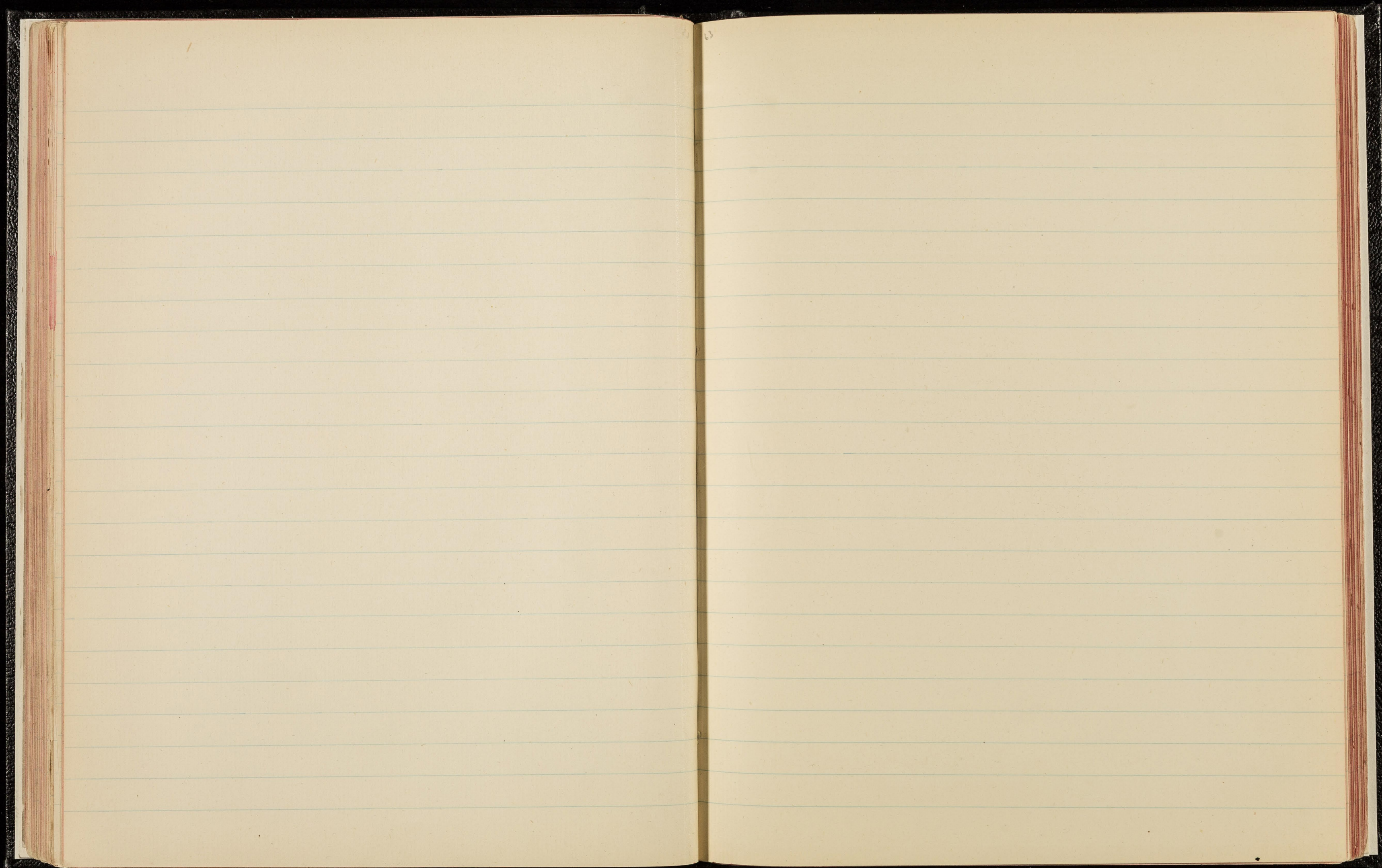
also 12/- per week for 8 weeks when a member is out of work & when a member is out of work over that time a levy is imposed to pay such member a further sum of 8/- per week. I am yours respectfully.

W. Jozant

President Horse Collar makers Soc

The first part of the book is devoted to a description of the various forms of life which are found in the different parts of the world. The author has been very successful in his attempt to give a clear and concise account of the most important groups of animals and plants. The second part of the book is devoted to a description of the various forms of life which are found in the different parts of the world. The author has been very successful in his attempt to give a clear and concise account of the most important groups of animals and plants.

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as there 80. helmet makers }
 120. with saddles } = 200 or 80 + 40 = 120
 how many women } in collar making
 draftsmen }

31 X 93

see F Whisker.	chair saddler	} still found work
see J. T. Morrison	saddle chamer.	
not ans. W. Jozat	Collar makers	
Cooper	saddle tree maker	

Shell Drosser.
 Women saddles.
 Small chair saddles

