

ROYAL COMMISSION ON LABOUR.

INDEXES.

VOLUME III.

GLOSSARY

OF THE

TECHNICAL TERMS

USED IN THE

EVIDENCE

TAKEN BEFORE THE

ROYAL COMMISSION ON LABOUR:

WITH INTRODUCTION, INDEXES, AND APPENDIX.

Presented to both Houses of Parliament by Command of Her Majesty,
June 1893.



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ROYAL COMMISSION ON LABOUR.

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ROYAL COMMISSION ON LABOUR.

44, Parliament Street,

London, S.W.,

October 28th, 1893.

MY LORD DUKE,

I have the honour to submit the Glossary which I have been directed to prepare of the Technical Terms used in the Evidence given before the Commission, and which forms Volume III. of the Indexes to the Minutes of Evidence.

I have added an Introduction explaining the principle on which it has been drawn up and the authorities which have been consulted, together with certain supplementary Indexes which I hope may be of use to the Commission.

I am,

Your Grace's Obedient Servant,

GEOFFREY DRAGE,

Secretary.

To

His Grace The Duke of Devonshire, K.G.,

Chairman of the Royal Commission on Labour.

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INTRODUCTION.

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The Glossary has been drawn up principally for the use of the Commission, but at the same time the requirements of working men and of foreign readers have been kept in view. An attempt has been made to explain clearly the exact significance in the evidence of all terms which although in common use are yet sufficiently technical to present some difficulty to average readers and students of the evidence. Main object.

The definitions have been obtained in the first instance by writing to each Witness,* enclosing a copy of his evidence and a list of technical terms used with the references to the evidence, and requesting definitions of them. The information thus obtained has been supplemented by Members of the Commission, and by the use of existing Glossaries, of which the following are the most important:— Sources of information.

1. "Dictionary of Trade Products" (Simmonds);
2. "A Glossary of Terms used in the Coal Trade of Northumberland and Durham" (Nicholson);
3. "The Pocket Law Lexicon" (Rawson);
4. "From Keel to Truck" (Paasch).

The Newcastle Weekly Chronicle and such Standard Works as Webster's, Nuttall's, Murray's, Ogilvie's, Johnston's, and the Century Dictionaries have also been consulted.

In the case of illiterate Witnesses much difficulty has been experienced in obtaining the information needed, and in some instances the letters received have actually rendered the points requiring elucidation more obscure than before. In these cases the insertion of a weak and possibly incomplete definition has been preferred to the omission of all mention of the term. Difficulties experienced.

A difference may have been observed between the definitions of the same term in different volumes of the Digest already published. This is accounted for by the fact that, for instance, the evidence published in Minutes of Evidence, Volume II., Group A., to which the Glossary in Digest, Volume II., Group A., relates, had not been received when the Glossary to Volume I., Group A., was compiled and published. It should be remembered that one of the objects of the Glossary has been to express in clear and concise language the witness's own definitions of the terms used, and at the same time to free them from any taint of partiality. Hence terms occurring in later volumes of the Digest are sometimes defined in different, but more accurate, phraseology from that used in a previously published volume, because later and more complete information has been obtained and utilised. Differences in definitions.

When a term has been used by a number of Witnesses an attempt has been made to evolve a definition complete in itself, and yet thoroughly applicable in each instance of usage of the term. But where one comprehensive definition is impossible, two or more definitions of the same term are given. In many cases where a term has different local meanings, localities have been mentioned. It must, however, be understood that no attempt has been made to produce a Glossary of which the definitions possess general application. The definitions given are intended to have a general application to the terms as used in the Minutes of Evidence only. Details of compilation.

Terms which are themselves defined, but which are also used to assist in defining other terms, have been placed between inverted commas. Use of inverted commas and of italics.

The italicised words in a definition are intended to illustrate, in some degree at least, the origin of the term defined, without entering too deeply into etymological questions.

Some of the diagrams have been drawn in the Office; some have been copied from the works enumerated above; and the remainder have been kindly supplied by Witnesses and others interested in the work. Diagrams.

The compiling of the Glossaries has proved a very valuable check upon the spelling and correct reporting of terms and phrases in the Minutes of Evidence, and has hence Indirect advantages of the Glossary.

* It may be here mentioned that some 700 letters have been sent out from the Office, and nearly 400 received on this subject.—G. D.

been of great use in the immense task of editing such a mass of evidence. The instances of inaccuracies which might have otherwise escaped notice are exceedingly numerous.

Plan of this
Volume.

It will be remembered that each volume of the Digests of Evidence taken before the Committees A., B., and C. of the Commission contained a Glossary of Technical Terms used in the evidence to which the volume referred.

These nine separate Glossaries contained in the nine volumes of the Digests have been amalgamated in the present volume, and a separate Glossary has been added of the Technical Terms used in the evidence taken before the Commission Sitting as a Whole.

Three separate independent Indexes have been drawn up of the Technical Terms here defined. The first two are prefixed to the Glossary in order to enable the reader to ascertain at a glance whether the term he desires to find has been used, and if used, in which branch or branches of the inquiry. The third, which is appended to the Glossary, is divided into two parts, of which Part i. is a List of the Trades and Industries under which the Lists of Terms forming Part ii. have been grouped.

NUMBER OF TERMS DEFINED IN DIGESTS.

Numbers
of Terms
defined.

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859			382			836		
2,077								

NUMBER OF TERMS DEFINED IN THIS VOLUME.

Committees.	Whole Commission.	Total.
2,078*	136	2,214

* This number has been ascertained by actual counting: its nearness to the total above is merely coincidental, since the first total includes the same terms in more than one volume, and the second total includes cross references but reckons the several parts of a definition as *one* definition.

I.

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II.

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GLOSSARY OF THE TECHNICAL TERMS USED IN THE EVIDENCE

TAKEN BEFORE

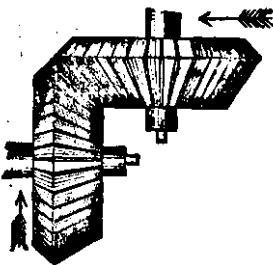
GROUPS A., B., AND C.

Term.	Definition.	Term.	Definition.
ABAFT - -	A nautical term meaning behind; on the after or hind part.	ALKALI WORKERS } -	The general expression for all men engaged in chemical (<i>i.e.</i> , alkali manufacturing) works.
A.B.'s - -	Contracted form for able-bodied seamen, <i>i.e.</i> , those who are supposed to be qualified to perform all the duties required of a competent member of a ship's crew. At present there is no stipulated period of service for such qualification. A clause in the rules of the Sailors and Firemen's Union defines the term thus:— "British seamen showing four years' service will be enrolled in this Union as A.B.'s, but if they show a less period they shall be enrolled as ordinary seamen until they have completed the four years."	ALLOTMENT NOTE } -	A note given to seamen on signing their articles entitling their wives or relatives to a portion of the money earned at the end of each month.
ABSOLUTE PIECE-WORK } -	Work paid for by the article at a price agreed upon for each article or for each dozen, &c.	ALPACA - -	A bright lustrous wool of the <i>alpaca</i> , a camel-like beast and native of the mountainous parts of Peru, Chili, and Bolivia. It varies in colour, being black, brown, white, grey, fawn, or piebald. It is not used in its natural colour, but is dyed black, and generally employed in the manufacture of dress goods for ladies' wear and linings for men's wear.
ACID WORKER -	Any person employed in the manufacture of acid. There are several departments in an acid works, such as "dust burners," "burners," "nitre furnace men," "towers men," and "chambers men." The men who work in these different departments are all called <i>acid workers</i> , or more broadly still "chemical workers."	AMIDSHIPS -	The centre of the vessel looking either from "forward" or from "aft." (See diagram XII.)
ADAM'S WORK -	See definition under "work."	AMMONIA-SODA PROCESS } -	The process by which soda ash (or in a dissolved state, carbonate of soda) is made from brine by the agency of ammonia (NH_3 , <i>i.e.</i> , a volatile alkali, a gas in its uncombined form, composed of hydrogen and nitrogen) and lime kiln gas.
ADMIRALTY SURVEYORS } -	Professional and practical engineers or shipbuilders in the employ of the Admiralty, appointed to inspect and approve engines and ships in the course of construction for Her Majesty's Navy.	ANCHOR-MAKERS	Men working in a gang or set (usually composed of eight men) who forge and hammer the iron into shape in the process of making ships' anchors.
AFFILIATED MEMBERS } -	See definition under "members."	ANCHOR-WATCH	The watch kept by one of the crew on the deck of a vessel at anchor.
AFT - -	Abbreviation for the <i>after</i> or stern part of a vessel (see diagram XII.). The expression "fore and aft" is used by seamen to indicate "in the direction of the ship's length," <i>i.e.</i> , from stem to stern.	ANGLE BARS -	V-shaped iron bars, used in shipbuilding, bent into various angles (chiefly into right angles) to form the skeleton ribs, &c. of the vessel. <i>Angle bars</i> are sometimes 30 and 40 feet long, and weigh from one to six hundredweight each. (See following diagrams.)
AFTER HATCH -	See definition under "hatch."		
AGATE - -	Here used in the sense of "going" (C. 5,246).*	<p>A B C, Single angle-iron or angle bar. A B C D, Double " " " E, Rivet. (See also diagram VII.)</p>	
AIR-WAYS -	Headings or passages in a mine along which there is a constant circulation of fresh air between the down-cast shaft, the working places, and the up-cast shaft.	ANGLE IRON SMITHS } -	See definition under "smiths."
ALDERT MONEY	See definition under "money."	ANGLES - -	Used for ships' frames and for iron or steel girders and roofing, and so named from their sectional shape. They are used for stiffening cast-iron "girders." They are rivetted together, and thus tightly hold the iron angle stiffeners and the plate iron through which the rivet is forced when hot, and the heads are then cap-flattened on either side of the iron frame.
ALKALI - -	Excepting when used in chemical text books and the like, this word (and its plural, <i>alkalies</i>) almost invariably means carbonate or caustic soda. But in such expressions as "alkali manufacture," "alkali trade," and "alkali works," it usually means the group of processes carried on in alkali works, including the manufacture of sulphuric acid, hydrochloric acid, bleaching powder, &c. Sodium and potassium are the two principal metals in alkalies; caustic soda, washing soda, and caustic potash are alkalies principally used for making paper, and in bleaching works for cleansing. Generally speaking, an <i>alkali</i> is a substance which combines with an acid and neutralises it, forming a salt. All <i>alkalies</i> (potash, soda, lime, and ammonia, the leading ones) have an acrid or soapy taste, and turn vegetable reds to blue.	ANNEALING OVEN } -	The oven used in the glass bottle making industry in which the bottles are slowly cooled.
		ANTHRACITE COAL } -	See definition under "coal."
		ARCHES - -	<i>Arches</i> in the potting industry are the first "bung" (see definition) put in the oven, that is, they are the bungs which stand nearest to the fire and between the fire-holes or mouths.

* In Digest, Group C., Vol. I., p. 74 the definition of "agate" as supplied by the Witness is given, *viz.*, "A space between dressing frames;" this definition, however, referred to "a gate," the usual expression in the textile industries for the spaces, ways, or avenues separating looms and necessary for locomotion. From this term "gate" the adverb *agate* is doubtless derived.

Term.	Definition.	Term.	Definition.
ARCHITRAVES -	The ornamental mouldings used for windows and doorways.	BANK ² -	See definition under "bank-watchers."
ARMOUR DECKS	Protective decks of steel plates, such as armour-plate, on the sides of a vessel; the thickness varies from 3 to 4 inches.	BANK-RIDERS -	Men in the mining industry employed to ride on the waggons or tubs on inclined planes, which may be either self-acting or worked by an engine.
ARMOUR } PLATING }	Special plating in ironclads and such vessels for protection. The thickness varies from 4 to 22 inches.	BANKSMEN -	Men in the mining industry and their assistants who draw the full tubs of coals from the cage at the top of the shaft and replace them by empty ones; they also have charge of the signals between the enginemen and the "onsetter."
ARMS -	Short branches of canals connecting the main canals with towns, villages, factories, collieries, ironworks, &c.	BANK-WATCHERS	Women or lads who attend to the second or third machines in the "carding" process (see definition); these machines are fed by another machine called a <i>bank</i> , hence the attendants are called <i>bank-watchers</i> .
ARTIFICERS -	"Shipwrights" (see definition) in Her Majesty's Navy.	BARGAIN ¹ -	Work such as stone or coal drifting, rolley-way making, &c., when let by tender to workmen in the colliery, is called <i>bargain work</i> , and the contract to take such work is called a <i>bargain</i> .
ASSISTANT } CONSTRUCTORS }	Junior officers in Her Majesty's dockyards who have had a technical training in naval architecture, and who assist the constructors, the next grade of officers above them, in supervising the construction, refits, and repairs of ships and their equipments.	BARGAIN ² -	Quarrymen work on a portion of rock 9 yards wide, with the height of the gallery varying from 50 to 60 feet; this is called their <i>bargain</i> , and is re-let to them every month at a certain price.
AWKWARD } MONEY }	See definition under "money."	BARGAIN-LETTER	In the Dinorwic quarries the <i>bargain-letter</i> is the person who lets the various bargains or contracts each month to the quarrymen, rockmen, and others who work by the piece. He has also to generally supervise the quarries. (See definitions of "setter" and "setting.")
AXMINSTER } CARPETS }	See definition under "carpets."	BARGAIN - } SETTING OR } LETTING }	See definition of "setting."
BACK-BYE MEN	Shifters, wastemen, and others engaged in <i>back-bye</i> work, that is, work <i>not</i> at the face of the ironstone workings.	BARGAIN-TAKERS	Those who perform bargain-work in a mine, i.e., work such as stone or coal-drifting, rolley-way making, &c., which in some cases is let by tender to workmen at the colliery.
BACKER -	The man (in a squad of five at dock work) who ties the mouth of a sack of grain, &c. when full, lifts it on to his back, and then tilts it into the cart or truck for removal.	BARGE -	In this instance used as another term for "lighter" (see definition). (B. 14,154.)
BACK JOINTS -	Joints or divisions sometimes appearing at the back of slate blocks in slate quarries.	BARGEMAN -	Term usually applied (in the London district) to men working on sailing and country barges who have served no apprenticeship, but who work below Gravesend and above Teddington. The term <i>bargeman</i> is used generally to mean a man who navigates a barge.
BACK MONEY -	See definition under "money."	BARGES -	<i>Chancework barges</i> .—Barges whose captains have to seek employment for the vessel, or who do not belong to a firm finding constant work. As these barges have therefore to depend on casual freights they are termed <i>chancework barges</i> . <i>Hoy barges</i> .—Barges making regular voyages to London and back with dry goods, such as groceries, provisions, wool, hops, &c. The crew employed on <i>hoy barges</i> are paid weekly wages. <i>Powder barges</i> .—Barges employed exclusively in carrying gunpowder from Faversham to the various depôts on the Thames, bringing in return raw materials for the manufacture of the same. The crews of the <i>powder barges</i> are paid weekly. <i>Share barges</i> .—All barges whose crews are paid by share of the freight earned by the vessel in contradistinction to barges whose crews are paid weekly wages. [For definition of <i>Tank-Barges</i> see under that heading.]
BACON-CURING -	The process of slightly salting pork for preservation is carried on very extensively in Birmingham, one central establishment killing from 800 to 900 hogs per week in the winter. The curing is performed in the majority of houses in the cellaring, and to prevent expense is performed by one man who works in a cellar, illuminated by one or two candles, from 6 a.m. till 7 or 8 p.m., and this, in conjunction with the cold air of winter and the freezing properties of salt and saltpetre, no fire being allowed. In the summer these conditions, it is alleged, are not altered, as the cellar is converted into an ice-chamber by the addition of about a ton or so of ice per week, in the meltings of which the man stands all day long.	BARGES AND } LIGHTERS }	There is here no real distinction, both words being used indiscriminately. The term "flat" (see definition under "boats") is generally used for any <i>lighter</i> longer than a canal boat, the local distinction being that any flat not propelled by steam is a
BAFF SATURDAY	Mining workmen are usually paid fortnightly on "Pay" Fridays. The following day is called "Pay Saturday," and the alternate Saturday "Baff Saturday."		
BAG-HOLDERS -	The two men (in a squad of five) who assist the "weigher" (see definition) to lift the loaded bucket of grain on to the hook of the weighing scale, and who hold open the mouth of the sack during the process of filling.		
BAKERS -	The term <i>bakers</i> as used in the potting industry denotes pie dishes.		
BANDING -	Spoilt yarn that can only be sold at little more than half its value to make cord.		
BANDS -	Interstratified impurities of stone or slate found in a seam of coal.		
BANK ¹ -	A term used in the mining industry to express above ground; the surface. Thus, hours of labour are reckoned from <i>bank to bank</i> ; that is, the time is reckoned from leaving the surface to returning to the surface.		


Term.	Definition.	Term.	Definition.
	berge, although it may be a "sailing-flat." The watermen are now usually termed flatmen, and the different classes of vessels <i>barges</i> and <i>steamers</i> . (C. 21,055, 21,094.)	BELL HORSES -	A term used by workmen to express very vigorous men employed by a builder or sub-contractor in the bricklaying industry to do more than the ordinary amount of work for, perhaps, 1s. per day extra, in order it is alleged that the employers may have some grounds for dismissing men who do not work up to this level.
BAR IN THE BURNERS }	See definition under "sulphur burners."	BELL-MEN -	Men who lower the materials into a blast-furnace after a certain number of barrows have been emptied therein. The materials are so lowered to prevent too great an escape of the gas, which is utilised for other purposes.
BAR IRON -	See definition under "iron."	BELLS -	The covering at the top of the furnace receiving so many barrows full of material for making iron and then lowered by means of a lever is termed the <i>bell</i> . As the apex of a kiln is smaller than the base the material slides off the <i>bell</i> into the furnace, the <i>bell</i> being raised by another lever into position to receive another load.
BARKER RAIL -	A light section of steel rail fixed to and supported by metal chairs (<i>i.e.</i> , heavy cast-iron sockets for receiving and securing the bars of a railroad).	BELTING -	Belts used in driving machinery.
BAR MILLS -	See definition under "mills."	BEN -	Term used in West of Scotland mines to denote the turn or supply of empty tubs. When a boy under 14 years of age enters the mine he is entitled to a half-turn or <i>ben</i> ; between 14 and 16 he has a three-quarter turn; at and over 16 he has a full or man's turn. At some pits, however, this rule is not adhered to, and each boy obtains an equal number of hitches with a man.
BASIC PROCESS	See definition under "processes in steel-making."	BENCHES -	A bench of retorts is the same as a setting or bed; that is, an arch inside which from 5 to 10 retorts are set and heated by one furnace.
BASINS -	A term used in the dockyards to denote the ordinary business docks, <i>i.e.</i> , the wet docks where vessels are kept afloat as distinguished from the dry "docks" (<i>see</i> definition). The term is also applied to that part of a harbour open to the sea, which boats first enter inside the piers, and into which the docks open.	BENCH MEN -	A term in use in the boot and shoe industry, once synonymous with <i>rivetters</i> , but the latter term is now hardly correct, since most goods which were formerly rivetted are now chiefly machine-sewn or machine-screwed. The <i>bench men</i> prepare the leather for this purpose.
BASTING -	The loose temporary sewing put into a garment preparatory to trying on and finishing.	BENDING ¹ -	The process of securing the sails in their proper places on a yard or stay, and attaching the necessary ropes, &c. <i>Unbending</i> is the process of removing them from that place.
BATCH -	The quantity of bread baked at one time.	BENDING ² -	A term used locally to indicate the mechanical operations necessary in bending plates, iron or steel angles, or beam material, on slabs, or at a hydraulic or other press, or in rolling a curve in iron or steel frame or beam material, by passing it through an appropriate "rolls" (<i>see</i> definition).
BATE -	A local term, expressive of the offer which some middlemen with their non-unionist workmen make to an employer to perform a Government contract at a deduction.	BENEAPED -	<i>Neap tides</i> are the lowest tides which occur at the time of new moon. To be <i>beneaped</i> is to be unable to get away from a port or wharf at such a time, the water even at high tide being insufficient to allow the vessel to leave.
BATES' PATENT STEAM PRESSES }	Presses heated by steam, in which the hosiery goods are pressed upon their shapes.	BERTH -	The space at a dock or wharf required by a ship or barge when loading or unloading cargo.
BATTENS -	Pieces of wood of the same kind as "deals" (<i>see</i> definition), and used mainly for fire-wood, but smaller. Light strips of wood generally used for temporary work in ship-building are also called <i>battens</i> . (<i>See</i> definition of "planks.")	BESPOKE DEPARTMENT }	The order department, that is, the department where garments are made to order in private trades or business houses, as distinguished from the wholesale clothing or warehouse trade.
BAULKING WITH TIMBER }	The operation of laying down on the fore-shore timber upon which the men engaged in barge-building stand and work instead of standing in the water and mud.	BESSEMER STEEL	Steel produced by the Bessemer process (<i>see</i> definition of "processes in steel-making").
BEAM -	A circular piece of wood, about two yards long, upon which the warp is wound. (<i>See</i> diagram XVII.)	BEVELLED WHEELS FEEDING INWARDS }	Two cogged or toothed wheels with their faces (and therefore the rims of cogs) inclined (or <i>bevelled</i>) to an angle of 45° with their axes. The shafts to which the
BEAMS -	Large transverse pieces of timber, the width of a ship, used for supporting the deck and staying (holding together) the sides. (<i>See</i> diagram VII.)		
BEAR -	See definition of "bulls and bears."		
BEARINGS -	Supports which are used for carrying or holding up shafts or shaftings, and on which the shaft <i>bears</i> .		
BEATER MEN -	Men who have charge of the beating engines, and who are responsible for supplying the pulp (disintegrated in a greater or lesser degree) to the paper-making machines.		
BEATERS -	Machines in paper mills used for reducing and separating the fibres used for making paper.		
BEAT-UP -	Two or more cab-drivers racing from different points to reach a place where a "fare" is waiting are said to be "having a <i>beat-up</i> ."		
BELAYING-PIN -	A staff or truncheon usually made of iron, brass or hard wood, from 7 to 14 inches long and 1 inch or 1½ inches thick. These pins are inserted where convenient through holes in the rails of vessels for making fast ropes and running gear, as required.		

Term.	Definition.	Term.	Definition.
	wheels are fixed are placed at right angles, hence one wheel is horizontal and the other vertical. As the teeth work into one another one wheel turns the other. Wheel-work of this order is termed <i>bevel gear</i> . (See following diagram.)		
			
BILGES	The lowest compartment of a ship (next to the "skins,"—see definition of "shell plating") where water from leakages and other waste matter, solid and liquid, accumulates and is eventually pumped overboard by the bilge pump as bilge water. <i>Bilges</i> extend from side to side of the ship, and are about 2 or 3 feet in height. (See diagrams X. and XI.)	BLACK ASH } REVOLVER } MEN }	coal added to every two tons) combined in a furnace for that purpose. It is used in the manufacture of sodium carbonate, and when crystallised forms a commodity for domestic use. When dissolved in water, boiled down, and ground, it is largely used in the textile industry.
BILGE SUCTION } PIPES }	See definition under "pipes."	BLACK-LEGGING	The act of doing the work during a strike refused by strikers.
BILGE-WATER	The water which always remains in the <i>bilges</i> (see diagrams X and XI) of a vessel even after the suction by the pump. In the case of a ship with a level keel it is of the depth of 2½ to 4 inches.	BLACKLEGS	The term applied to men who, during a strike, will do the work refused by the strikers.
BILKER	A person who hires a hackney carriage as a fare (perhaps for hours) and then slips off without paying. A driver so victimised is said to have been <i>bilked</i> .	BLACK LIST	A circular or notice sent by employers to one another stating that certain men are strikers, agitators, complainers, &c., or a similar notice sent by workmen's unions to prevent men working for certain employers.
BILLED	Entered on a pay-bill or pay-sheet.	BLACK SHOP	See definition under "shops."
BILLY FAIRPLAY	A system of weighing by which hewers are paid for large coal only. The tubs are weighed as they come to bank; they are then teamed, and the weight of all the small or duff coal, which passes through a screen into a catch or closet (called a "hopper") connected with a second automatic weighing machine, is deducted, and the men paid on the remainder, i.e., the round coal. This system derives its name from the screen upon which the coals are tipped, called <i>Billy Fairplay</i> , the bottom of which consists of bars from half-an-inch to an inch apart.	BLACKSMITHS	For the specific duties of a <i>blacksmith</i> , see definition under "smiths."
BINDERS	The work of book-binders is a separate trade from printing; the trades are connected only in very rare instances.	BLACKSMITH'S } SHOP }	See definition under "shops."
BINNED	To "bin" or "bing" coal is a Scotch expression, meaning to empty coal at some convenient place on the surface from which it may be removed when the supply of trucks or waggons becomes better, or when a higher price in the market would warrant the mine-owner disposing of it.	BLAST- } FURNACE } KEEPERS }	<i>Blastfurnace keepers</i> are those who take charge of the blast-furnaces, make the mould for the pig-iron, and tap out, i.e., run off the molten iron when the furnace is full. The latter work may only be done with the sanction of the foreman.
BIRMINGHAM } SYSTEM }	Local term for what is called in London a "slate-club system" (see definition), i.e., a benefit fund, the balance of which is divided at the end of every year among the contributors.	BLAST- } FURNACEMEN }	The men who superintend the heating of the furnaces in the iron industry by means of hot blast, which is produced in stoves and conveyed by pipes to the furnace to be then regulated as necessary.
BISCUIT OVEN	The oven used in the potting industry in which the ware receives its first fire. It is put in in the slay state and comes out in the <i>biscuit</i> , or unglazed state.	BLAST-MEN	See definition of "blast-furnacemen."
BITUMINOUS } GOAL }	See definition under "coal."	BLEACHING	Making cloth white by the use of chemicals and exposure in the fields or open air.
BLACK ASH	The product of limestone and salt cake in equal quantities (with 25 cwt. of slack	BLEACHING } POWDER }	<i>Bleaching powder</i> (otherwise called "chloride of lime") is the product formed by causing chlorine gas to combine with slacked lime (quick-lime impregnated with water). It is used for bleaching rags, for making paper, and for domestic uses, as washing, scouring, &c., and also as a disinfectant.
		BLENDING } ROOMS }	The rooms in which are blended the raw materials for web, such as cotton and mungo, to be spun by the weavers. The operation of <i>blending</i> is performed partly by hand and partly by means of machines called "teazers" and "willeys."
		BLIND } FURNACES }	Furnaces for salt cake, which need not be worked with an open door as several other furnaces used in the chemical industry have to be worked to retain the gassy fumes in the furnace and its flue.
		BLOCK CHAINS	Chains made to mathematical dimensions and used for Weston's patent and such kinds of pulley blocks, by which one man can lift a ton weight with ease.
		BLOCKERS	Formerly called "ironers"; are those men in the hat trade who shape the hats after they have been sewn and stiffened upon wooden blocks cut to the required style.
		BLOCKING ¹	Term used by factory inspectors to denote their system of going from street to street and house to house, visiting any places which from outside observation and inquiry appear to be workshops.

Term.	Definition.	Term.	Definition.
BLOCKING ²	The act of unionists refusing to discharge a ship manned by non-unionists.		
BLOCKS ¹	To "draw blocks" is to pull down good slate rock from which slates are made.	BLOWING ²	at the requisite heat. The working of these bellows, which is often done by children, is called <i>blowing</i> .
BLOCKS ²	A large anvil made of cast-iron, with an "oliver" hammer and frame attached.		
BLOCKS ³	In the shipbuilding industry <i>blocks</i> are the cast-iron slabs in front of the furnace, on which are set and bevelled the angle frames forming the skeleton frame of a vessel.	BLOW PIPE	A pipe (used in the potting industry) like the pipe of a blow bellows through which air is blown upon the rotating plate while it is being "towed" (<i>see definition</i>). The current of air so caused carries the dust from the worker through the "grid" (<i>see definition</i>).
BLOCKS ⁴	The term <i>blocks</i> is here used with reference to the shipbuilding industry, to denote short logs of timber placed one upon the other, as a basis on which keels are laid and vessels built. (A. 21,400.)	BLUE BEDS	In the chemical industry women pile up blue lead, layer upon layer, into stacks; these stacks are called <i>blue beds</i> .
BLOCKS ⁵	<i>Blocks for torpedo heads</i> are wooden blocks into which the torpedo head is fixed or stowed.	BLUE LEAD	<i>Blue lead</i> is a native sulphide of lead, also called "lead glance" and "galena." As it comes from the mines it is put through a process called separating (<i>i.e.</i> removing the dross), which fits it for the process to turn it into "white lead" (<i>see definition</i>).
BLOCK SYSTEM	The working of a railway upon a system of dividing the line into sections, and working trains by telegraphic or bell signals between one signal cabin and another. A signalman may not allow a train to pass and proceed until the previous train in the same direction has passed the next signal cabin in advance. Thus, take the cabins as A., B., C. A train between A. and B. is not allowed to pass B. until C. informs B. that the section B.C. is clear.	BOARD - AND - WALL PRINCIPLE	The system of working the coal by galleries about 6 yards wide, between which, at about 12 or 16 yards distance, other galleries are driven. These galleries are termed <i>walls</i> , and the working places between one gallery and another are called <i>boards</i> . "Whole" price is paid for such work.
BLOOD MONEY	<i>See definition under "money."</i>	BOARDS	Wooden flooring used in shipbuilding on which are "scrived" (cut) the shapes of every "frame" (<i>see definition</i>) of the ship, and to which the "frame turners" (<i>see definition</i>) work.
BLOODY	An adverb used as an intensive, meaning <i>very, exceedingly, desperately, &c.</i> This term is in general colloquial use among the lowest classes, and is frequently used as a qualifying adjective, but its derivation attaches no sanguinary meaning to it. The origin is uncertain. It has no allusion to the oath "'s blood," but there is good reason to suppose that it was at first a reference to the habits of the "bloods" or aristocratic rowdies of the 18th century. Thus, "bloody drunk" as used by Dryden in the <i>Prologue to Southern's Disappointment</i> , means "drunk as a blood," <i>i.e.</i> , "drunk as a lord." (From Murray's new English Dictionary.) According to Ogilvie's Imperial Dictionary and The Century Dictionary, <i>bloody</i> is derived from Anglo-Saxon <i>blodig</i> = very, &c.; in both of them the above quotation from Dryden is given. Johnston's Dictionary (by Lathom) gives the same meaning, and quotes from Swift, "It was <i>bloody hot</i> ." (C. 8194, 3221, 3254, 3336, 4123.)	BOATERS	The men, women and children employed in navigating the canal-boats.
BLOWER ¹	The <i>blower</i> here referred to is the man in charge of the Bessemer converter, into which molten metal is run for conversion into steel (A. 14,963.)	BOAT LINES	Strong ropes from 60 to 90 feet long, by which the boat horses draw the boats backward and forward as required.
BLOWER ²	The workmen in the glass-bottle industry who blows the piece of glass straight from the furnace into a bottle. The piece is on the end of a tube down which the <i>blower</i> blows.	BOATS	<i>Compartment boats</i> .—Boats built for use on the Aire and Calder Canal; they are square in shape, and made of iron, and are towed in a line of perhaps 20 at a time, similar to the railway carriages of a train. <i>Flats</i> .—A term used in the Mersey district for the craft upon canals and rivers called in other districts, such as on the Thames, lighters or barges, and on the Humber, keels. A keel is about 10 feet shorter than a flat (<i>see under "barges and lighters"</i>). <i>Fly-boats</i> .—The general expression for canal boats drawn by horses, and running quick passages at stated times, but sometimes used specifically to indicate barges of unusual length and of a narrow construction, drawing a very small amount of water, used for navigation along narrow channels. <i>Boats in tow</i> .—A vessel or barge is said to be <i>in tow</i> when she is being pulled along by a horse or a steam vessel. <i>Keels</i> .—A class of vessel, registered as canal boats, used in navigating the Humber, Trent and Ouse, and the adjacent canals. A <i>keel</i> averages about 95 tons burden, has one mast with two (or sometimes three) square sails, and is usually manned by two men called <i>keelmen</i> . <i>Large boats</i> .— <i>See definition under "deep sea tugs."</i> <i>Slow boats</i> .—Boats not carrying urgent goods, and therefore not compelled to travel constantly, both night and day.
BLOWER	The huge fan used in the potting industry to remove the dust of lead, &c.		
BLOWER MEN	Men engaged at the <i>blowing engines</i> connected with the manufacture of bleaching powder.		
BLOWERS	Gas under pressure issuing from the strata in a coal mine.		
BLOWING ¹	Passing cool air over furnaces on blast.		
BLOWING ²	In various processes of manufacturing chains bellows are required to keep the fires		

* The word *keel* is also used on the Tyne, Wear, and Tees to denote a quantity of coal or coke:—
Coal, 21 tons 4 cwts. per keel.
Coke, 11 tons per keel.

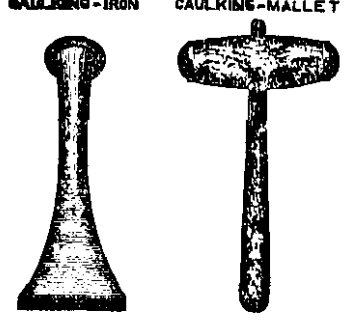
Term.	Definition.	Term.	Definition.
	<i>Small river boats.</i> —Small tug boats which are employed in towing barges on the upper part of the River (Thames), but which do not proceed to sea. <i>Steamboats.</i> —Boats carrying urgent goods and propelled by means of steam power, as opposed to boats "in tow." [For definition of <i>Monkey Boat</i> , see under that heading.]		table-knife blade. In forged blades <i>bolsters</i> are formed from the solid iron welded to the steel blade.
BOATSWAIN	A warrant officer in a vessel of war; in a merchant ship a subordinate officer who has charge of the boats, sails, rigging, ropes, and other gear, and calls the men to their duty.	BOND	The pit carriage or cage working up and down the shafts, upon which the miners are lifted through the shaft from the mine.
BOB ¹	A local term applied in the Wigan district to the system by which some of the colliers who want the pit to "play" obtain their wish. As the colliers approach the pit, before going down, one of their number is told off, hat in hand; and each man who is willing to play <i>bobs</i> his finger in the hat as he passes. This silent token usually results in the colliers going home, but the day-wage men frequently go down and receive their pay although no coals are wound.	BOOM ¹	The rise in money value of some article, the demand for which is greatly in excess of the supply.
BOB ²	The plates used by locksmiths are first made bright and smooth on a grindstone, and after that still smoother on an emery wheel or <i>bob</i> , which is turned round by an engine. Where there is no engine the worker has to file and smooth the lock by hand while it is in the vice.	BOOM ²	Equivalent to <i>beam</i> , a spar on which the foot of the fore and aft mainsail (see diagram XV.) is fastened, or on which a gin or pulley-wheel is hung. Over the pulley runs a rope or chain for loading and unloading cargo.
BOBBER	A man who stands on a form by the salesman, being in his employ, and receives the penny <i>bobbing-charge</i> .	BORERS	Men who have charge of machines used for drilling and <i>borings</i> holes in the various metals used in shipbuilding and engineering.
BOBBING CHARGE	Payment of one penny by a porter in Billingsgate Fish Market for the privilege of carrying bought parcels of fish for the buyer.	BOSS	The bottom half of the prints or dies in which the bolsters are made on forged table knives.
BODY MAKERS	The men who are engaged in that branch of coach-making which is concerned with the making of the <i>body</i> of a coach.	BOTCH	A <i>botch</i> or <i>botcher</i> is a man who cannot make a fair good job or turn out work with any credit either to himself or to his employer, and who therefore undersells good workmen.
BOGIES	Small trucks or waggons used for conveying metal and slag from blast-furnaces.	BOTHY	A house or shed in parts of Scotland in which agricultural labourers and farm servants (who are in Scotland hired for periods of six or twelve months, and are called "hinds") eat their meals and sleep.
BOILER-MAKERS	(a.) A term occasionally used to denote the owners or managers of boiler-making establishments, i.e., master boiler-makers. (b.) A term generally used to denote the mechanics and skilled workmen engaged in the construction, fitting, and repairing of boilers (marine, locomotive, and stationary) and similar wrought-iron work (such as the manufacture, fitting and securing of guards to machinery), both in shipyards and in the boiler department of engine works. Such mechanics are platers, rivetters, frame turners, cutters, caulkers, holders up, and angle-iron smiths (see definitions) who are embraced in the <i>Boiler-makers and Iron and Steel Ship-builders' Society</i> . It may be noted that the "drillers" (see definition), the only other class (except blacksmiths) whose work has close connection with the industries named, have separate societies.	BOTTOM ¹	The bottom of a furnace composed of cast metal plates fixed on a frame and covered with a coating of cinder or silica. (See definition of "scraps.")
BOILER MEN	Men engaged in the chemical industry in firing and attending steam boilers.	BOTTOM ²	The <i>bottom</i> of a furnace used in the chemical industry is always made out of yellow sand from the beach or sea shore. Three or four tons of the sand is thrown into the furnaces, according to the amount required, and flattened down level. The oven is then closed up and fired for nine or ten hours to fuse the face of the sand, which hardens on cooling. This <i>bottom</i> may last according to its composition from a week to two years.
BOILER SHOP	See definition under "shops."	BOTTOMERS	Men employed at the bottom of the shaft in taking the empty tubs or hutches (used for raising coal, &c.) out of the cages, and reloading the cage with full hutches. <i>Bottomers</i> are in full charge of the pit bottom of a coal mine, with the sole right of working the signal bells connected with the surface.
BOILER SMITHS	See definition under "fingers."	BOTTOMS	The sole, heel, &c., attached to the uppers of a boot. Hence <i>bottoming</i> is the process of attaching the <i>bottoms</i> and finishing them off ready for sale.
BOILER STOKER	A labourer in attendance on a boiler furnace for the purpose of feeding it with coal or other fuel, and giving the boiler such other attention as may be necessary.	BOUNTY SYSTEM	<i>Bounty</i> is an extra payment to act as a stimulant administered to increase the output of the machinery used in the cotton trade.
BOLSTER	The shoulder which stands between the handle and the blade of a table knife, made by the process of "running on" (see definition) in the case of a common	BOXES OF FOLDING MACHINES	Boxes of folding machines (used in printing) into which newspapers, books, &c., are delivered when passed through the machine and folded.
		BOW	The head part of a boat (see diagram XII.)
		BOXING FLEETS	Fleets composed of a number of sailing trawlers congregated together and fishing under the guidance of an admiral or leader, who forwards all fish caught by a steam fish carrier to London. The term <i>boxing fleet</i> arises from the fact that these

Term.	Definition.	Term.	Definition.
	fish are packed in <i>boxes</i> in contra-distinction to other trawling fleets which use <i>baskets</i> only.		coal in the nail and chain industry and in brick burning.
BOX LOOKS -	See definition under "locks."	BREWERS' DRAYS -	See definition under "carts."
BRACING WORK	See definition under "work."	BREWERY WORK -	A term in use in the coopering industry to denote the work connected with the making of barrels or casks to hold ale or porter.
BRAKES -	Drags applied to the wheels of carriages to check their velocity. Engines are provided with steam brakes; guards' vans with hand-lever brakes.	BRICK KILN -	A large oven for burning and hardening bricks.
BRAKESMEN -	Guards of goods or mineral trains (hence, sometimes termed "goods guards"), that is, the men who accompany and have charge of goods and mineral trains. Their duties are to travel in the brake-van at the rear of the train, to put on the brake when necessary, to see that waggons are put off or taken on as required at the stations at which the train has to stop, and to assist in the coupling or uncoupling, shunting, and marshalling (see definition). They have also to keep a journal of the running of the trains, causes of delays, &c., in the same way as the passenger guards do.	BRICKLAYERS -	Artisans whose sole duty is to set bricks and to do work connected with brickwork.
BRANCH HORSEDRIVERS }	Those who drive the horses drawing the waggons about the various waggonways, railways, and sidings, adjacent to collieries.	BRICKSETTERS -	Term synonymous with "bricklayers."
BRASS FINISHERS }	Skilled workmen competent to turn at the lathe and to fit at the vice all classes of sanitary, steam, hydraulic, electric, and gas fittings made of brass, gun metal, or other alloys, and to complete such fittings for sale and for use.	BRIDGE SHOP -	See definition under "shops."
BRASS FITTERS -	Skilled workmen engaged solely at the bench or at the vice, chiefly in works at large engineering and shipbuilding centres.	BRIDLE -	A bar of iron bent thus  It is used in the gas industry by the two men who assist in lifting the scoop full of coals into the retort.
BRASS FOUNDERS }	A general term for skilled workmen in brass of any class, &c., engaged in the production of such fittings as are enumerated in the definition of "brass-finishers."	BROKEN PRICE	Rate of wages for working out "broken," that is, <i>broken</i> ground in a mine, or "pillar-work," that is, the removal of pillars. Pillars are oblong or square masses of coal contained between two boards and two headways course, and left in the first working for the support of the roof.
BRASSIES -	Iron pyrites in the coal strata found in patches and veins. Owing to their nature they form a source of annoyance to coal hewers by destroying the points of picks. They are of some commercial value (5s. 6d. to 7s. a ton), but are reckoned foreign material, and are deducted from the produce of the mines.	BROKEN WORK	Conveying the damaged chests of tea (put into cloths) from the ships to the various warehouses to which they are consigned, and where they are mended.
BRASS TURNERS	Skilled workmen engaged solely as <i>turners</i> at the lathe on heavier classes of work than brass finishers, chiefly in works at large engineering and shipbuilding centres.	BROKERS' SWIPE SHOP }	A slang phrase used in Yorkshire for a low kind of public house kept by a ship broker.
BRATTICE CLOTH	Coarse tarred canvas used in a mine for doors, stoppings, and temporary <i>brattice</i> , i.e., a partition (more frequently of deal) placed in the shaft of a pit, or in a drift or other working of a colliery, for the purpose of ventilation. The terms shaft brattice, drift, headways, board, &c., brattices, are used according to the situation in which the partition is placed. The use of a <i>brattice</i> is to divide the place in which it is fixed into two avenues, the current of air entering by the one and returning by the other.	BRONZING -	In the printing industry <i>bronzing</i> is scattering over printed work Dutch metal in dust to give it the appearance of gold, silver, copper, or any other coloured bronze.
BREACHING -	Shuttling the weft or yarn.	BROOCH STICK -	A stick about 27 inches long, and tapered like a pointer, used by lappers (see definition) for drawing up or folding linen. (Local term.)
BREAD SERVING	Selling and delivering bread by van or otherwise.	BROUGHAM -	A four-wheeled hackney (close) carriage, of a particular design, invented by the late Lord Brougham, licensed to carry four passengers inside and one out.
BREAKING-DOWN ROLLS }	See definition under "rolls."	BROWN COAL -	See definition under "coal."
BREEZE -	(Fr. <i>briser</i> , to break.) Small cakes of cinder or coke produced from small dust coal, used for firing purposes instead of	BRUSHERS -	Those who, after the miners have excavated their coal, take down or <i>brush</i> additional strata to give height for carrying off the material excavated with hutches and drawers and ponies to the working places.
		BRUSSELS CARPETS }	See definition under "carpets."
		BUCK CARRYING	The practice of a driver allowing an unauthorised person, whether a cab is engaged by a fare or not, to ride on the vehicle. Such a person is called a <i>buck</i> .
		BUILDERS -	As applied to workmen, those who follow that branch of the masonry trade which consists in the dressing and building of rough rubble coursed or uncoursed, and the fixing or building of stones already dressed by hewers.
		BULKHEAD -	A partition across a vessel formed of sheets of iron, securely fastened to the sides, and thus dividing it into different parts. Its purpose is to prevent the passage of water into other parts in the event of a collision. (See diagram XIV.)
		BULKING -	Emptying tea from chests in a heap (that is, in <i>bulk</i>), for the chests to be mended or for the tea to be examined.

Term.	Definition.	Term.	Definition.
BULK SALT	Term used to indicate the white salt which is drawn out of the pan in bulk or great heaps, and not put into moulds for drying. <i>Bulk salt</i> is wheeled into the warehouse, where it remains in bulk until shipped in a loose state on to the lighters.		80 lbs. avoirdupois of water). It is used for raising the cotton or other seed into large bags which, when full, are hoisted to the upper story of a warehouse, to be removed as occasion requires.
BULLS AND BEARS	Terms used to denote buyers on the Stock Exchange; speculators who artificially raise or depress prices of stock. A <i>bull</i> is a jobber or dealer who has an interest in the rise of the market, and wishes to sell at a higher price than he bought at. A <i>bear</i> is a jobber or dealer who has an interest in depressing prices, wishing to buy back stocks or shares at lower rates than are current.	BUSHELLING	The operation of picking up grain with a bushel measure.
BUMPERS	Very loud noises similar to those produced by heavy guns occasionally heard in underground workings. These noises are due to the rupture in the strata caused by gas held in tension, and not unfrequently by the rending asunder of the strata overlying the workings where the coal has been wrought.	BUSHING SHELLS	<i>Bushing</i> is the operation of fitting a metal lining to a cylindrical body, such as the cylinder of a steam engine, in order to save the main body from friction, the <i>bush</i> or lining being replaced at comparatively small cost. Hence <i>bushing shells</i> is fitting on the nose or pointed part of shells (bombs).
BUNCH HOOKS	Double hooks which lift up four, five, or six bales, by means of cranes, from a ship's hold to the dock quays.	BUTTER FIRKINS	Casks holding 9 gallons (the <i>fourth</i> part of a barrel) or 56 lbs. of butter.
BUNGS OF SAGGERS	<i>Bungs of saggars</i> are piles of saggars (see definition) filled with ware and placed in the oven, one on the top of the other, until the roof of the oven is reached. Ovens will vary in height the same as in breadth; some ovens will fill with an average height of 21 saggars high, and others 26 and over.	BUTTERFLY CARMEN	Cabdrivers whose actual cab-driving extends over about as many months of a year as the existence of a <i>butterfly</i> ; they drive a cab during the best season of the year, competing with the regular driver to his detriment, and for the remaining nine months follow another calling.
BUNKER COAL	See definition under "coal."	BUTTY	The man in a blast-furnace working on the opposite shift, that is, if a man is working on the night shift, the day shift man is termed his <i>butty</i> .
BUNKERING	The term used to describe the operation of putting coal on board steamers for use on the voyage, the coal being stored in <i>bunkers</i> .	BUTTY COLLIERIES	Stall men or contractors who employ and pay from four to eight other men, such as "holers" and "fillers" to work the coal, load it into the tubs or hutches, and do other work at the face.
BUNKS	Sleeping berths on board ship.	BYRES	Cow-houses.
BURLING	That process of manufacture which consists of taking from the piece of cloth, subsequent to its being woven, any extraneous substance found therein. The operation of "mending" is also termed <i>urling</i> .	BY-TURN MEN	Men who temporarily take the place of workers, such as blast furnacemen, who are compelled to take a rest, but whose work must still be carried on.
BURNER DEPARTMENTS	The departments doing the work of loading and emptying the furnaces connected with the sulphuric acid chambers. (See definition under "sulphur burners.")	CABBER	A horse well suited to the hackney carriage business.
BURNER MEN	Men engaged in working the kilns in which copper ore is roasted. The gas given off is utilised in making vitriol, <i>i.e.</i> , sulphuric acid.	CABINET MAKERS	A superior class of "joiners" (see definition), who make the higher class of woodwork, all the finer classes of furniture, shop fittings, church fittings, &c.
BURNERS¹	Kilns in which copper ore is roasted (see definition under "sulphur burners").	CABINET TRADE	The cabinet trade embraces all classes of work required in the manufacture of household furniture, <i>viz.</i> :— <i>Cabinet makers</i> (men who make all classes of furniture, shop fittings, church fittings, &c.); <i>machine-men</i> (men who mind all the different kinds of wood-cutting machines, &c.); <i>chair makers</i> (men who make all kinds of chairs, couches, &c.); <i>wood-carvers</i> , <i>wood-turners</i> , <i>upholsterers</i> (men who stuff chairs, couches, &c., attend to window curtains, blinds, and so forth); and <i>French polishers</i> (men who put the finish on to all goods made in the cabinet trade).
BURNERS²	See definition under "cokemen."	CABINS	This term here refers to the houses in which signalmen are located and which contain signal and block telegraph apparatus, levers for working the points, &c.
BURRED	The screwed portion of the pipe here referred to had been damaged and somewhat distorted by contact with some hard substance and thereby a <i>burr</i> had, so to say, formed on it. (A. 25,548.)	CABLE CHAINS	All chains used for ships' cables.
BUSH	A ring of metal (usually brass) inserted round a shaft, rod, axle, &c., to take the wear and reduce the friction produced by the constant rubbing against the shaft &c. which it surrounds or supports. It can be easily replaced when worn. In connection with the railway industry it is the portion of the vehicle which rests upon the axle. It is usually made of brass, and when the friction causes the "journal" (<i>i.e.</i> , the bearing portion of the axle) to heat, making it dangerous to run, the <i>bush</i> is said to be defective.	CABLE ROPE	A strong rope for anchoring a ship, &c.; cables vary from 1 in. to 18 in. in thickness; 1 cable-length generally consists of about 15 = 90 feet. A rope cable is always composed of three strands, every strand of three ropes, and every rope of three twists; the twist is, however, made of more or less threads, according as the cable is to be thicker or thinner. A rope, two inches in circumference, and 120 fathoms (240 yards) long, is generally found to weigh nearly 1 cwt.
BUSHEL	An implement made of wood and iron to hold about a bushel (the contents of about		

Term.	Definition.	Term.	Definition.
CAGE	A place of call, very badly managed, it is alleged, where men are "taken on" at the London Docks.		wire, and used for combing and cleaning the material.
CAG-MAG	Odds and ends of meat.*	CARPENTERS ¹	Artisans who do the work on buildings up to the time they are covered in. <i>Carpenters</i> are not considered to be so skilful in neat work as <i>joiners</i> (see definition), but the distinction is merely nominal in most cases. In the employment of the Salt Union <i>carpenters</i> often include <i>ship carpenters</i> , i.e., those engaged in the building or repairing of lighters and other wooden boats or craft; hence, in this case <i>carpenters</i> are all workers in wood.
CAKE	<i>Oil-cake</i> is the marc or refuse after oil is pressed from flax-seed, rape-seed, coconut pulp, &c., which is imported for feeding cattle (linseed and cotton, the latter giving that yellow tint to beef), and for manure (rape) in the vine districts of France.	CARPENTERS ²	Skilled mechanics who work in wood, and, as distinguished from joiners, do the heavier parts of woodwork connected with the building of ships or with machinery. "Shipwrights" (see definition) are some times referred to as <i>carpenters</i> or <i>ships' carpenters</i> in contra-distinction to "house carpenters" (see definition). The term <i>carpenter</i> here refers to men doing heavier woodwork in connection with pile driving and the construction of jetties, piers, and the like. (A. 25,546.)
CALCINING MEN	A class of workmen employed in both copper and spelter works in obtaining acid from the raw materials put into the <i>calciners</i> which they fire. This is the first process the raw material goes through.	CARPETS	<i>Brussels</i> .—A familiar term applicable to a non-pile carpet in common use, as opposed to "tapestry" or "Kidderminster," &c. <i>Brussels</i> carpeting is in more general use than other makes in sitting-rooms, well furnished bed-rooms, or on staircases, &c. <i>Wilton</i> .—Practically a <i>Brussels</i> with a cut pile. In manufacture the same loom is employed, but the pile is higher, and a knife at the end of the wire cuts the worsted, producing a pile or velvet carpet. It is alternately known as "velvet pile." <i>Amminster</i> .—A pile carpet of many makes, hand-made to some extent, but mainly by machinery. There are many different looms employed, but in nearly all of them there is no limit to the colours employed, whereas in <i>Brussels</i> or <i>Wilton</i> carpets, which are made by the Jacquard process, the number of colours available is strictly limited. <i>Kidderminster</i> .—Also known as "Scotch," and but little made in Kidderminster now, are a lower grade carpet than <i>Brussels</i> , but sometimes made by a Jacquard process, very distinct, however, from <i>Brussels</i> . One peculiar feature is that the design is shown back and front, though the colours are reversed top and bottom.
CALENDAR ROLLS	Stacks (used in paper making) of from five to eight chilled steel rolls on the top of each other, through which the web of paper has to be passed from the drying cylinders, when a smooth or glazed surface is desired. Unless "doctors" or guards are used on the face of the running-in rolls, it is very dangerous work guiding the paper through the stacks, and the men often get caught.		
CALENDER	To pass cloth through the rollers of a machine called a <i>calender</i> , in order that it may be pressed and finished.		
CALENDERERS	The workers in a calendering or cloth-finishing department.		
CALENDERS	Public calenders are those departments in the jute industry to which unfinished goods are sent to be finished for the merchant or the exporter. Jute sacks are sewn by sewing machines in public calenders.		
CALICOES	Different kinds of cloth made from cotton.		
CAN	A tall tin box into which is pushed by hand the soft riband of jute, called "sliver," as it comes from the card or drawing. The process of pushing is called "tramping the cans."		
CANDYMEN	Men employed to assist the bailiffs or police in ejecting workmen from their employer's houses.		
CANLATAD	A term used in the Dinorwic quarries to denote a permit issued by an overlooker to a workman.	CARRIAGE PLATES	The plates screwed on by the police cab-inspector to the inside and outside of every licensed hackney carriage, the number corresponding with the licence.
CANNEL COAL	See definition under "coal."		
CARBONATES OF ALKALIES	This term, in the chemical industry, usually refers to soda ash, which is commercial carbonate of soda, i.e., a compound formed by the union of carbonic acid with soda.	CARTS	<i>Brewers' drays</i> .—Four-wheeled vehicles like lorries, but low and heavy, having an opening down each side of the bottom for the more convenient handling and transport of casks of beer. <i>Carts</i> .—Vehicles with two wheels, having deep sides, like a large box. They are generally used for conveying coal, lime, sand, &c. <i>Lorries</i> .—Vehicles or drays with four wheels having no side-boards. They are generally used in railway traffic, and for removing goods from one place to another. (Term used in Lancashire and Cheshire.) <i>Case-carts</i> .—Light two-wheeled vehicles, with sides, end, and front, used to convey to the packing-houses the wooden boxes in which textile goods for abroad are packed. <i>Pop-carts</i> .—In most cases <i>pop-carts</i> are of the same make as "lorries," with a high seat in front for the driver. They are used for conveying mineral waters from place to place.
CARBONISING DEPARTMENT	The retort house where the coal is carbonised, i.e., burnt in such a way as to convert it into carbon (gharegal).		
CARDERS	Those employed in minding <i>carding machines</i> .		
CARDING	A process of combing cotton in the raw state by leather <i>cards</i> with wire teeth in them to straighten the wool or cotton before it goes into the combing machine.		
CARDS	The clothing used for covering the scribblers and condensers; made of leather, set with	CARTWRIGHT	An artificer who makes or repairs carts.
		CASE CARTS	See definition under "carts."

* With reference to this definition, Mr. George Augustus Sala, writing to the "Daily News" on July 22nd, 1892, states as follows:—"Cag-mag is not by any means a technical term used exclusively at the Docks. It is properly 'cack-mag," and, according to Halliwell in the "Dictionary of Archaic and Provincial Words," "cack-mag" is chatter or idle talk, and is a term used in the Eastern Counties. I may add that as a Cockney, I have heard for more than half a century "cag-mag," sometimes spelt "cag-mag," used to signify inferior meat and rubbish of all kinds.

Term.	Definition.	Term.	Definition.
CASE CHAPEL -	See definition of "father of the chapel."		
CASE-MAKERS -	The men employed in the making of wooden packing-boxes. (See definition of case-carts.)		
CASES -	Wooden frames divided into receptacles or "boxes" for holding the types. There are two cases—the upper case and the lower case. The former contains all the capitals, small capitals, accented letters, &c. The latter all the small letters, figures, spaces for putting between the words, &c. Hence the expression to work <i>at case</i> . To put boys to case or at case is to teach them the initial stage of learning the printing business, by placing them at the case to learn thoroughly the position of the divisions for each letter, knowledge which must be acquired before they can start "composition," or setting up words and sentences, &c.		
CASING PIPES -	To case pipes is to fix a protector of wood in front of pipes on board ship, a necessary precaution when the pipes are lead.		
CAST -	A tube of brass or copper through which the molten metal from a blast furnace runs into a ladle (a large vessel), and thence into moulds prepared to receive it.		
CASTING FURNACES }	The furnaces in which the steel is made for the making of castings.		
CASTINGS -	Any parts of a construction in shipbuilding or engineering which are made by pouring steel or any metal in a liquid state into moulds. (See definitions of "steel castings.")		
CATARACT -	An automatic piston-governor usually attached to a pumping-engine for the purpose of regulating the number of strokes it is to make per minute or per hour.		
CATCHERS -	The workers in the iron industry who seize the plates as they come from the "rolls" (see definition).		
CATCHING THE MACHINES }	The cylinder of a printing machine revolves, say 1,500 times an hour; at each revolution grippers catch a sheet which must be laid true to the marks. (See definitions of "watching the marks" and "missing the sheet.")		
CAULKERS -	Skilled labourers in the shipbuilding, boiler-making, and engineering industries, who caulk, crease, set, or cut in, all edges, seams, joints, laps, and butts, in the combinations of iron plates or bars, after they have left the hands of the "rivetters" (see definition), in order to make them water-tight, oil-tight, or steam-tight, by compressing the material solidly together along the line of contact. In some cases red lead is used to fill in the seams, but usually a tool is placed against the edge and struck by a hammer, thus turning the edges close in against one another. The process above described is termed <i>iron-caulking</i> , and the plates, &c., so dealt with are referred to as <i>caulked work</i> ; this process immediately succeeds that of "rivetting." <i>Wood-caulking</i> is a process, also performed by shipwrights, of driving oakum into the seam by means of a caulking tool (a cold chisel, i.e., a stout tool of steel for cutting iron) and mallet (see following diagrams).		
			<p>CAULKING TOOLS.</p> <p>CAULKING-IRON CAULKING-MALLET</p> 
		CAUCHOED -	To caunch up bricks is to arrange them in small stacks when burnt and ready for sale.
		CAUSTIC -	The product of the liquor derivable from "black ash" (see definition). No. 1. <i>Caustic weak liquor men</i> are men engaged in preparing liquor for caustic. No. 1 and No. 2. <i>Caustic finishers</i> are men in the finishing sheds engaged in firing and attending caustic pots, and in seeing that the caustic is thoroughly prepared before it is ladled into the iron casks in which it solidifies.
		CAUSTIC SODA -	There are two forms of soda, <i>caustic soda</i> and "carbonate of soda." Carbonate of soda is a corrosive prepared in large quantities by the United Alkali Company, Limited, by the "Le Blanc process" (see definition). <i>Caustic soda</i> is made by boiling carbonate of soda and lime together with water and evaporating down the clear solution, when a white fibrous mass remains.
		CAVEAT -	Notice entered on the books of a registry or court of law to prevent a certain step being taken.
		CAVILS -	The workmen who hew the coal or get the iron in mines draw lots every three months for places in which they have to work during the ensuing three months. This operation is called <i>caavilling</i> , and the place obtained is called the <i>cavil</i> . A similar system is also in vogue by which lots are drawn for each "putter" to take the coals from a certain number of hewers daily.
		CEMENT TRADE	A term used in the coopering industry to denote the work connected with the making of casks for cement.
		CHAIN LOCKER	The space or compartment in the fore part of a vessel where the anchor chains are stowed.
		CHAIN TRADE -	See "small chain trade."
		CHAIRING -	The practice of a driver who keeps the whole of the receipts derived from working a cab and horses supplied to him by a proprietor. Thus, if a driver on a certain day paid no money for hire of cab and horses, it is said that he <i>chaired</i> his employer for that day.
		CHAIR-MARKING	The practice of a proprietor who endorses a driver's licence in such a way that another proprietor on seeing the licence, when a request is made to him for employment, may know that the driver has <i>chaired</i> (see definition) on occasions.
		CHALDRON -	All coal and coke was formerly sold by measure, the standard being the <i>chaldron</i> of 36 (and later 48) bushels. Coke is still largely sold by measure, and the <i>chaldron</i> represents 1½ full sacks each sack containing 4 bushels.

Term.	Definition.	Term.	Definition.
CHAMBER MASTERS } -	In some parts called "garret masters," are small master boot-makers, working for wholesale firms or factories in their own homes, and generally assisted by members of their own family.	CHECK-WEIGHMAN } -	Made from the stipulated wages; however, if the measurement is greater no extra remuneration is given.
CHANCERY JOINT	A joint of meat costing about 4d. per lb., occasionally purchased by a dockerman, and constituting a luxury for his family.	CHEMICAL PLUMBERS } -	A person stationed by the miners at the place appointed for the weighing of mineral and for determining deductions therefrom. He is employed and paid by the workmen.
CHANCE WORK BARGES } -	See definition under "barges."	CHIEF CONSTRUCTORS } -	See definition under "plumbers."
CHANDLERS	Marine provision dealers; tradespeople who furnish ships with all the small stores, &c., that they require.	CHIEF PETTY OFFICERS } -	The principal officers at the head of the Ship Constructive and Repair Department at each of the Royal Dockyards.
CHAR-FILLERS	A Scotch name for the men who fill the barrows and take them to the "table-loader" at the hoist which conveys them to the furnace-top, whence they are tipped into a blast-furnace with ironstone and ore which has been burnt in the kiln. In England these men are called mine-fillers and ore-fillers.	CHIFFENDALE WORK } -	"Shipwrights" in the Royal Navy who have passed certain technical and other examinations, are promoted to the rank of <i>chief petty officers</i> .
CHARGE	To load an oven with coal is to <i>charge</i> it; the quantity put in is termed the <i>charge</i> .	CHIPPERS	See definition under "work."
CHARGE-MEN	Locally-selected workmen who are paid slightly higher wages than the others, and are put in charge of a piece of work or number of men in lieu of "leading men" (see definition).	CHLORATE	In joining two plates together there may be, perhaps, an eighth or sixteenth part of an inch out of the straight line; a skilled labourer—generally a "driller" (see definition)—has to <i>chip</i> or cut the surplus away with a hammer and cold chisel until it fits evenly and to line. This work is called <i>chipping</i> , and the men so employed are called <i>chippers</i> .
CHARGE MONEY	See definition under "money."	CHLORIDE OF LIME } -	A compound of chloric acid with a salifiable base, i.e., a base capable of combining with an acid to form a salt.
CHARGER	Here means a foreman who makes a charge against a workman. (A. 16,601.)	CHLORINE	The chemical term for "bleaching powder" (see definition).
CHARGERS ¹	A Cleveland term for those who <i>charge</i> the holes (made by the "drillers") in iron-ore or stone, with gunpowder, and then fire it. As it is a very dangerous practice to get down the stone by means of blasting, the wages of the <i>charger</i> are high. In one shift a <i>charger</i> will do the charging and firing of 60 to 80 holes, using from 55 to 65 lbs. of powder, and he is paid, jointly with the driller, by the ton, which payment includes assistance and the cost of powder and squibs.	CHOCKS	A poisonous greenish-yellow gas obtained from the action of hydro-chloric or marine acid upon raw manganese (a black metallic ore) in "stills" used for the purpose; the <i>chlorine gas</i> produced by this action is passed through pipes connected with boxes which contain pure lime (see definition) in powder. The combination thus formed, viz., chloride of lime, is used as bleaching powder and as a disinfectant.
CHARGERS ²	Term synonymous with "furnace-fillers" (see definition).	CHOPPY	<i>Chocks for spare propellers</i> are pieces of wood on which the propeller (i.e., the fan working on a screw at the stern of a steam-vessel which propels the vessel through the water) is laid to allow of its being strapped or otherwise secured on board a ship, and prevented from shifting while the vessel is at sea. All steamships carry spare propellers in case of accident to the one in use.
CHARGES	The materials for the furnace in steel manufacturing.	CHROME	<i>Choppy or chappy</i> is a common expression for chaff, i.e., hay or straw, corn-husks, or grass, cut up small in a machine called a "chaff-cutter."
CHARGING MACHINES } -	Machines for charging the retorts used in gas making.	CHROME	A mineral compounded of chromium and potassium and oxygen; the term as used in the evidence means chromate of potash, a production from chrome iron ore used principally by dyers.
CHARTERS	Persons who engage a boat for a certain definite period, or for a given number of voyages.	CINDER MEN	Men in the chemical industry engaged in wheeling <i>cinders</i> from the furnaces.
CHARTERMASTER	A sub-contractor for getting the coal or other mineral at agreed prices, employing his own workmen.	CIRCULAR MACHINES } -	A machine for knitting looped fabric. It is circular in build, and, having a continuous circular motion, makes the fabric without a seam.
CHARTER PARTY	A mutual agreement drawn up between the merchant or broker who wishes to employ a barge and the master thereof. This <i>charter</i> or agreement, which relieves the owner or captain of all risk, sets forth when "demurrage" (see definition) is to be charged for detention in either loading or delivery.	CIVIL ENGINEERS' DEPARTMENT } -	See definition under "departments in a ship-building yard."
CHARTERS	See definition of "charter party."	CLARENDON PRESS } -	The University Press at Oxford.
CHASSES	Frames made of either cast or malleable iron used by printers to confine types when set in columns or pages.		
CHECK MEASUREMENT } -	A system occasionally adopted in Her Majesty's Dockyards of ascertaining the quantity and value of the work performed by workmen in a given time; if the measurement is less than the amount set an equivalent deduction is		

Term.	Definition.	Term.	Definition.
CLASSIFICATION SYSTEM	A system in use in Her Majesty's Dockyards under which the wages of the workmen are raised to the next higher rate when the foreman considers them deserving of such an increase. In the dockyards the hired rates vary from 30s. to 34s. (increasing by 1s.), and the established rates vary from 29s. 6d. to 33s. (increasing by 6d.), thus giving nine separate rates of wages for the performance of exactly the same work. The higher rates are theoretically given to the better workmen.	COAL	<i>Anthracite coal.</i> —A hard, compact, mineral coal, of high lustre, differing from "bituminous coal" in containing but little or no bitumen (a solidified inflammable earth-oil) and consequently burning without flame. The purer specimens consist wholly of carbon. <i>Anthracite coal</i> also burns without smoke and with an intense heat, and is therefore used for steam fuel. It is obtained in Wales and largely in Pennsylvania. <i>Anthracite coal</i> is also called "blind" or "giance" coal. The difference between anthracite and bituminous coal is explained on the supposition that the anthracite beds were formed earliest in the swamps and lagoons of the carboniferous period, and were longest exposed to that kind of decay which takes place in vegetable matter when immersed in water. The effect of such exposure is the loss of the hydro-carbons which constitute the volatile elements in ordinary coal. The covering with sedimentary deposits subsequently arrested further change. <i>Bituminous coal.</i> —Coal compounded with bitumen. (See definition of "anthracite coal.") <i>Brown coal.</i> —A variety of coal more commonly known as "lignite," which is obtained to a considerable extent in Germany and Austria. <i>Bunker coal.</i> —The coal used by a steamship for its own consumption during a voyage, and stored in the <i>bunker</i> (the portion of the ship's hold, most convenient to the boilers, which is partitioned off for the storage of coal). <i>Cannel coal.</i> —A true bituminous or high-class gas coal obtained from the Scotch coal-fields, and largely used in gas-making, with its allied varieties "parrot" and "bog-head" coals, because it increases the illuminating power of the gas. It is an extra rich form of coal, very hard and black, sometimes a mine in itself, sometimes forming part of a mine; it is also a <i>splint</i> coal (or splint coal, i.e., coal rent from the main body) and cannot be shovelled so easily as other classes of coal. <i>Cannel coal</i> differs from other coal in having a conchoidal fracture (i.e., a surface with curved elevations and depressions), and is generally of a bright shining appearance. It burns with a bright smokeless flame like a candle, hence the supposed derivation of its name of <i>cannel</i> or candle coal. <i>Clean coal.</i> —Pure, unalloyed coal, free from shale and refuse. <i>Coking coal.</i> —Soft coal greatly used for manufacturing purposes. <i>Dirty coal.</i> —Pure coal mixed with stones, shale and other refuse. <i>Easy or soft and stiff or hard coal.</i> —Soft coal or hard coal is due to the natural condition of the deposit, or caused by a fault or disturbance in the strata of the coal-bed, which has the effect in one case of softening, and in the other of hardening the coal. <i>Gas coal.</i> —A semi-bituminous coal obtained from the coal-fields of Newcastle, Durham, and South Wales, employed for producing the gas ordinarily used for lighting and heating. <i>House coal.</i> —Coal used for domestic purposes. <i>Jet coal.</i> —See under "jet seam." <i>Large coal.</i> —Lumpy coal; the best coals from which the small coal has been separated either by hand-picking or by screening. <i>Round coal.</i> —Large or lumpy coal (see preceding definition). <i>Seaborne coal.</i> —Coal brought to market by sea as distinct from that conveyed by rail. <i>Slack coal.</i> —Small coal, i.e., the duff, slag, or waste, which arises from the sorting of the large coal into nuts, and which passes through the screen bars. It is sometimes sent out with the large coal, and sometimes filled in separate tubs.
CLAY	Soft, tenacious, plastic, earth, which disintegrates in water and is thus suitable for making articles of pottery. <i>Clay potters</i> are all those who are actually engaged in making all kinds of ware. This does not include oven men or decorators of any description.		
CLAY BRANCHES	The branches or sections of the potting industry engaged in the making of articles of pottery from potters' clay, as distinguished from the firing and decorative branches.		
CLAY WORKS	Fire-clay pits where clay (aluminous or argillaceous earth which disintegrates in water and forms a plastic ductile mixture) for fire-bricks and retorts, &c., is raised.		
CLEAN COAL	See definition under "coal."		
CLEANERS	Charwomen.		
CLEANING THE BARS	Removing all the accumulated refuse in a blast-furnace from the grate bars to enable the fire in the grate to burn clearly.		
CLEAR MONEY	See definition under "money."		
CLEAT	Term used in Durham and Yorkshire to denote the perpendicular breaks or "slips" in the coal, running parallel to each other at distances varying from a few inches to a few feet. (See diagram III.)		
CLEAT OF LOWERING SPAE	A kind of machine over which passes a lowering rope, used in unloading a vessel. "It is like an arm fixed on the doorway with a piece of wood in the centre." There is no pulley attached to the machine, but the rope is in direct contact with the wood, and, being twisted round it several times, produces the friction necessary for the steady lowering of the goods.		
CLEAVAGES	See definition of "slips," and diagrams II. and III.		
CLICKERS	Called in Scotland "soft stuff cutters," are the workmen who cut out the various pieces which form the uppers of a boot with a knife from the different materials. These pieces are then fitted together and machined.		
CLINKERING THE FIRES	Breaking up and removing the <i>clinker</i> from the furnaces; <i>clinker</i> is the accumulated hard cake or refuse of coal (a vitreous scoria) which in this case is produced by the high temperature of the furnaces heating the retorts.		
CLIP HOOK	See definition under "hook."		
CLOD	Following stone, i.e., shale falling with the coal as it is being worked.		
CLOSING A JUNCTION	This expression here means "approaching" or "nearing" a railway junction. (B. 28,034.)		
CLOTH DRESSERS	Those who finish cloth by raising and cutting off the face of the cloth, one of the last processes before it is ready for use.		
CLOUT NAILS	See definition under "nails."		

Term.	Definition.	Term.	Definition.
	<p><i>Small coal.</i>—See preceding definition.</p> <p><i>Soft or manufacturing coal.</i>—Coal used for making gas and smelting iron, and household purposes. It is usually much softer than that used for raising steam, hence the name.</p> <p><i>Steam coal.</i>—Coal used in firing the furnaces of steam boilers.</p> <p><i>Thick coal.</i>—Coal obtained from a thick seam.</p> <p><i>Welsh coals.</i>—The steam coals almost universally used on board merchant ships; a variety, however, of Welsh coal is also used in gas manufacture.</p> <p><i>Yorkshire splits.</i>—A hard non-bituminous form of coal which yields no coke and is largely employed in smelting iron. This species is almost useless for gas manufacture.</p>	<p>COAL WORKERS - Those who load a ship with coal for a voyage.</p>	
		<p>COGGING - Drawing down the ingot (i.e., block of steel) to a square bar suitable for "bar mills," or to a size suitable for rolling at "plate mills." (See definitions under "mills.")</p>	
		<p>COGS¹ - In long-wall work, as the coal is removed, the space excavated is filled up with shale and dirt from the roof and bottom, or partings in the coal. After every six feet of coal have been removed, walls of rough rock and of timber are built up to the roof to retain this dirt, &c., and these are called <i>cogs</i>, cog-walls, or chocks.</p>	
		<p>COGS² - The teeth on the wheels attached to an engine and working into one another to increase or multiply power when lifting heavy weights. If not covered an accident may happen through a person's clothes or hands, &c., being drawn between the wheels. (See definition of "bevelled wheels.")</p>	
COAL DRAWERS	Men engaged in the Royal Arsenal in drawing coal from the coal sheds to the boilers.	COKE - Coal charred and deprived of its volatile matters; the solid product of the carbonisation of coal bearing the same relation to that substance as carbon does to wood. <i>Coke</i> is used for producing gas in a blast furnace, and melting the iron-ore and limestone to produce iron.	
COAL HULK	A <i>hulk</i> is the old dismantled hull of a vessel used to keep stores in, in this case used for a coal depôt.	COKE HOLDS - This term is used in the manufacture of gas to designate the floor (below the retort stage) on which the coke is drawn.	
COALIES	Men who unload coal ships or colliers into barges, and transfer coal from barges on to steamers. The term is used indiscriminately for both "coal porters" and "coal whippers" (see definitions). <i>Coalies</i> also store coal in the ship's hold directly from the crane which conveys the coal from the quay.	COKE-MAKERS - The workers in the process of coke-making who load and draw the coke.	
COALING A STEAMER	Loading a steamer from barges and railway trucks with the necessary amount of coal for a voyage. In the case of coaling from a barge an ordinary hand winch is used; from a truck, the men convey the coal along planks connecting the truck with the steamer. In some ports, Liverpool for instance, it is customary to coal steamers by baskets; in other ports coal is slid down an iron shoot to the vessel below, the rails on which the coal trucks run being on the quay above the vessel.	COKEBURNERS - <i>Burners.</i> ² —Men who superintend the burning of coal to change it into coke. <i>Drawers.</i> ⁴ —Men who with iron rakes break down and draw the coke out of the ovens. <i>Fillers.</i> ⁵ —Men who with gripes (i.e., large forks with many prongs) fill railway and other trucks with the coke from the bench, where it has been put by the "drawer." ⁴ <i>Levellers.</i> —In making coke, the coal is deposited in the oven by a tub which runs to the top eye, and is there tipped up, the coal naturally forming a conical heap at the bottom of the oven. The <i>leveller</i> rakes this coal <i>level</i> . He is the equivalent of a trimmer, who uses a shovel instead of a rake. <i>Small runners.</i> —Men who by means of waggons called tubs convey the coals from the pit or hoppers to the coke-ovens, and team the coals therein.	
COAL MEN	A term synonymous with "coalies" and "coal porters" (see definitions).	COKE-STACKERS - Men engaged in the manufacture of gas, whose duty it is to stack up the coke in the yard after it is brought from the retort house.	
COAL MINERS	Workmen engaged in a colliery.	COKING COAL - See definition under "coal."	
COAL PORTERS	Men (in the London district) employed to discharge and "load off" for delivery, coal, whether arriving by land or by water. Other men, formerly called "coal whippers," and now called "winchmen," put coal on board steamers for consumption by the engines. The two classes are separately organised, but the term "coal porter" may be loosely used for either. The term "coalies" is indiscriminately used for both. The process of unloading coal cargoes from ships' holds consists in removing the coals by means of "pan shovels" into tip-tanks, which being hoisted by cranes are tipped or emptied into trucks or barges.	COLLAR AND TWO ARMS } A mining term not in use in Scotland, but having the same meaning as the terms "straps" and "crowns" (see definitions).	
COAL TRIMMERS	Men on board ship whose duty is to go into the coal bunkers of a vessel, and to place the coals within reach of the fireman, whose rank is immediately above that of a trimmer. (See definition of "trimmers.")	COLLIERS ¹ - The general application to all workmen engaged in a mine.	
COAL-TRIMMING HORBLERS	Men who assist "coal trimmers" in cases of emergency, but who are not in regular employment.	COLLIERS ² - <i>Colliers</i> are either steam or sailing vessels employed in carrying coals from port to port. They vary in size from 300 tons upwards; the largest <i>collier</i> to-day is the "Long Newton" which can carry 2,500 tons.	
COAL WHIPPING	A process of unloading coals without steam or machine cranes formerly in general use. The men hauled up the coals by their own weight, a number of them handling a rope fall and pulley wheel. The work being very laborious necessitated what has now become a liberal scale of pay.	COMBERS - Those employed in minding the <i>combs</i> which disentangle and cleanse the raw wool before it is given to the weaver.	
		COMBINGS - The edges of the "hatchway" (an opening in the deck of a vessel) through which the cargo has to pass.	

Term.	Definition.	Term.	Definition.
COMMERCIAL REPAIRS } -	All work required in the repairs of ships, engines, machinery, or other work appertaining to the engineering trade that does not require a complete renewal, is classed as <i>commercial repairs</i> .	CONVERTER MEN } -	The men engaged in the operation of converting iron ore into the crude metal by melting it in furnaces called <i>converters</i> .
COMMON BOTTLES } -	Ordinary bottles used for general purposes, e.g., wine, pickle, sauce, jam, &c., bottles. Not specialties made by complicated and patented tools, e.g., "Codd's glass ball stoppered bottles," and other kinds of difficult construction requiring greater skill in making.	COOPRING -	The repairing of the damaged chests of tea emptied by "broken work" (see definition); or it may also mean the laying down of goods for the inspection by brokers, by piling one chest on the top of another to the height of about three feet.
COMMON SALT -	Chemically the same substance as ordinary table salt (i.e., chloride of sodium), the only difference being that table salt is in fine powder, whilst <i>common salt</i> is in coarse crystals. <i>Salts</i> are combinations of acids with oxide bases.	COOPERS -	The men who make and repair vessels and casks, &c., by putting together staves of wood and binding them with hoops of iron or of wood. If fully skilled, they are called "wet coopers," and are employed to make casks to hold liquids, or to open and re-cooper them. Less skill is required when the contents of the casks or barrels are dry; and less again when the work to be done is the repair of boxes, such as chests of tea. In each case, however, the work is called "cooperage."
COMPARTMENT BOATS } -	See definition under "boats."	COP-PACKER -	A person who packs yarn into "skips." (See definitions of "cops" and "skip.")
COMPOSING MACHINES } -	Machines used in the printing industry for "composition" e.g., Hattersley, Thorne, and Linotype, machines (see definitions).	COPPER MOULD } -	A trade term for a superior class of brick, chiefly used for the frontage of buildings.
COMPOSITION -	<i>Composition</i> is the act of lifting the letters used in printing, one by one from the type-case into a "stick," the width of the column of a newspaper, on the completion of a piece of work this type is lifted on to a bulk called the making-up bulk.	COPPERPLATE } -	A <i>copper plate roller man</i> has to work the copper in its first course. When the plates come from the refinery they are about 14 inches long, about 11 inches wide, and from 1 to 4 inches thick. The <i>roller man's</i> duty is to roll these plates down to various widths and lengths, so that they can be cut up into pieces of different sizes and weights.
COMPOSITORS -	Men engaged in the manipulation of the various types used in reproducing from manuscript a representation in type of the matter there written; their duties are also to correct errors pointed out when the matter set up is read, also to keep a sufficient supply of letters in their cases by "distributing" (see definition of the "Thorne machine") the letters previously used into the places reserved for them. <i>Compositors</i> are connected with book, newspaper, and jobbing work, but not with lithographic printing.	COPPER SHALE -	A mineral which contains copper in smaller or larger quantities.
CONDENSER } -	See definition under "pipes."	COPPER SMITHS -	See definition under "smiths."
CONDENSERS -	Machines used for the material as it leaves the "scribblers." They prepare the "slubbings" (i.e., combed wool brought into the dye-house to be dyed before manufacture into pieces) for the spinner, in whose hands it develops into weft or yarn.	COPPER WORKERS } -	<i>Copper workers</i> can be classified thus:— (1) loaders, smelters, and calcining men, who smelt the raw materials; (2) roasters, who further the process by means of air and fire; (3) refiners, who again further the process by working it up to the required quality; (4) finishers, who are furnacemen, and heat the copper ready for the rolls; (5) roller men, who, with the rolls, reduce the copper to its proper thickness, length, and width.
CONDENSER- DENCE } -	A part of the proceedings in a cause, setting forth the facts of the case on the part of the pursuer or plaintiff.	COPS -	<i>Copping</i> is the making of yarn into masses precisely the shape of a short carriage candle. This is the weft and goes into the shuttle of the weaver. The process immediately follows that of "spinning," and is followed by the "winding" of warp yarn upon very large bobbins. Both "warp-minders" and "cop-minders" are always women.
CONS -	Abbreviation for "contingencies," i.e., contingent money, a term used in the docks to denote special pay for special work.	COPY -	<i>Copy</i> is the general term applied to every description of work which comes into a printing office to be set. It is as applicable to a newspaper as to a book office.
CONSIGNMENT NOTE } -	A printed form with the description and quantity of the goods on a barge. By using a <i>consignment note</i> the owner of a barge is liable for the loss of, or any damage sustained by, such cargo. It is also used as a receipt on the delivery of goods, one part being then handed back to the master of the barge.	CORN CHANDLER -	A retail dealer in grain, meal, and seeds.
CONTINGENT BENEFIT } -	An extra weekly payment to members of the <i>Amalgamated Society of Engineers</i> on strike, locked out, or out of employment through resisting encroachments on advantages enjoyed by labour, &c. The money is paid from a fund which is replenished as required by a levy on all members who are working at the time when the levy is made.	CORN-METERS -	Men sworn in by a Corporation (in this instance by the Hull Corporation) to weigh goods, as between the seller and the purchaser of a quantity of corn. (B. 17,286.)
CONTINGENT MONEY } -	See definition under "money."	CORN-RUNNERS -	The men, employed at the docks, who carry the sacks of corn upon their backs from the ships to the stores.
		CORN-TRIMMERS -	See definition of "trimmers."
		CORVES -	A common name for the basket in which the coals used to be conveyed from the working places in the pit to the surface. This <i>corve</i> or basket was made of hazel, with an iron bar by which it was attached

Term.	Definition.	Term.	Definition.
	to the winding-rope. The basket is now superseded by "tubs" of wood or iron, which, however, still retain the names of <i>corves</i> in some places.	CRANE DRIVERS	See definition under "drivers."
COT HOUSES	Small cottages erected by farmers for the use of their labourers. The term is also used as a diminutive of cottages or houses built on allotments. The farm labourers who occupy these cot-houses are termed <i>cotters</i> or <i>cottars</i> .*	CRANK SHAFT	That portion of the shaft of any engine or steam pump acted upon directly from the steam cylinder through the medium of the connecting rod.
COTTON-RING	A syndicate of men formed with the object of artificially raising or depressing the selling price of raw cotton.	CRÈCHES	A French word meaning infant asylums; homes where women leave their young children whilst at work; they are partly self-supporting, partly dependent on public subscriptions.
COTTON SEED	The seed of a vegetable product of Egypt and the Southern States of America. The wool or down surrounding the seed forms the raw cotton. A bland dark oil is extracted from the seed.	CREELERS	Boys and girls employed to take out empty bobbins and replace them with full bobbins in the <i>creels</i> (or frames for holding bobbins) attached to mules, roving, intermediate, and slubbing frames used in spinning cotton.
COTTON'S PATENT FRAME	A rotary machine on an improved principle, invented by Mr. Wm. Cotton, of Loughboro', and used in the hosiery industry.	CREEP	A term synonymous with <i>crush</i> and <i>squeeze</i> , expressing the tendency of the roof, floor, and sides of the roadways and other openings of the underground workings in a mine to "creep, crush, or squeeze" together. The bottom is said to heave or creep up and the top to squeeze or crush down. (See diagram I.)
COUNTER AND SUB-COUNTER	In the Dinorwic quarries a <i>counter</i> is of the same grade as an "examiner" (see definition) and performs very similar duties.	CREOSOTE	<i>Creosote</i> or <i>creasote</i> is a product of the distillation of vegetable and of most animal substances, forming a powerful antiseptic, i.e., a medicine resisting the tendency to putrefaction. It is an oily colourless liquid with the smell of smoke. What is usually sold as <i>creosote</i> is not a pure product, being obtained from the coal tar produced in gas making.
COUNTERSHAFT	In mill-sawing machinery the smaller shaft used to direct the band to a given point when not driven direct from the main shafting is called the <i>countershaft</i> .	CRIMPING	The act of illegally supplying shipowners with seamen and taking money from the men for finding them employment. The persons who do this are called <i>crimps</i> .
COUNTESSES	The term used to denote all slates 20 inches long by 10 inches wide.†	CROFTERS	Cultivators of <i>crofts</i> or small holdings in the Highlands of Scotland.*
COUNTING THE OVENS	The operation of counting the contents of the ovens, i.e., the quantity of ware. The counting, it is alleged, is performed either by the master or the manager, and not by the men, whose wages largely depend on the quantity of ware drawn out of the oven with only a very few exceptions.	CROPPER WORKERS	A <i>cropper</i> is a machine for <i>cropping</i> all threads and fluff from the face of the cloth previous to its being mangled or calendered, by means of a series of knives working along both sides of the cloth. The <i>cropper-worker</i> is the person who carries the webs of cloth to and from the machine and who feeds it in.
COUNTRY SMITHS	See definition under "smiths."	CROPPING	A term used in the mining districts of Durham and South Wales, &c., equivalent to <i>fining</i> , or <i>docking</i> as it is also termed, i.e., deducting a certain proportion of the weight of coal in the tub when it contains an excess of small or refuse.
COUNTRY WORK	See definition under "work."	CROSS-CUTTING	Cutting wood across the grain, or cutting across the narrowest part, by means of a special kind of saw called a <i>cross cut</i> saw.
COUNTS	The number of "hanks" (see definition) to a pound of yarn is termed so many <i>counts</i> . By this means the different thicknesses of thread in different woven materials are compared.	CROSS-RAIL	A rail connecting a "pair of standards" (see definition) to keep them in position and to strengthen them.
CRABBER	A person who works or manages the "crabbing-machine." The <i>crabbing-machine</i> is used for setting or fixing the cloth previous to dyeing, in order to prevent creases and unevenness showing in the cloths after they are dyed and finished.	CROWBAR	A bar of wrought iron sharpened at one end and varying in length, chiefly used for purposes of leverage by hand.
CRAMPED	Brought or forced together with an iron <i>cramp</i> .	CROWN GLASS	Crown glass is the name used for a method of manufacturing window glass in round tables with a knob or bullion in the centre. This has been superseded by the method known as "German Sheet," which produces large squares, though not so smooth a surface.
		CROWNS	A term synonymous with "straps," but generally applied to the heavier class of wood which is put up in the main roads, i.e., horizontal timbering, held up by upright props to support the roof of a mine. (Term in general use in Scotland.)

* Her Majesty's Commissioners of Inquiry into the condition of the Crofters and Cottars in the Highlands and the Islands of Scotland in their Report, 1884, distinguish between these terms as follows:—"By the word *crofter* is usually understood a small tenant of land with or without a lease, who finds in the cultivation and produce of his holding a material portion of his occupation, earnings, and sustenance, and who pays rent directly to the proprietor. The term *cottar* commonly imports the occupier of a dwelling with or without some small portion of land, whose main subsistence is by the wages of labour, and whose rent, if any, is paid to a tenant and not to the landlord. The *crofter* is a small farmer who may live partly by the wages of labour; the *cottar* is a labourer who may have some share in the soil. But these definitions are deceptive, for there are *crofters* who are sub-tenants under tacksmen, and there are many *cottars* who pay rent to the owner. The distinction between the two classes is more easily felt and understood than delineated. Nor is a strict definition necessary. For the purposes of this Inquiry and Report we limit the class of *crofters* to tenants paying not more than 30*l.* annual rent, but we are unable to fix any point in rental below which the *crofter* descends into the *cottar* class."

† Slates are small shaped plates or large slabs of slate, chiefly used for roofing. For commercial purposes slates are classed into the following principal varieties:—*Doubles*, measuring 13 inches by 7, and smaller, 11 by 7; *ladies*, 16 by 10, 16 by 8, 14 by 8, or 12 by 8; *countesses*, 20 by 10; *viacountesses*, 18 by 10; *marchionesses*, 22 by 12; *duchesses*, 24 by 12; *princesses*, 24 inches long, various breadths. A thousand slates number 1,200, and 80 slates are also allowed over for breakage. There are also *rings* and *queens*, measuring 36 by 24; *imperial* and *patent* slates, 30 by 24; *Westmorelands* and some other kinds.

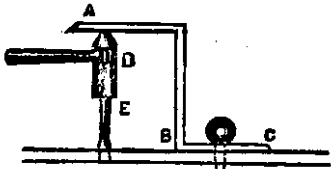
* See foot-note in preceding column.

Term.	Definition.	Term.	Definition.
CROWN STONE -	A stone used in the printing industry 15 by 20 inches size; the thickness varies from 3 inches to 4 inches.		
CRUCIBLE PROCESS } -	See definition under "processes in steel-making."	DAMP PLATE -	The clay on which all pottery is made is soft and damp, but it has to be dried before being sent to the oven to be fired.
CRUCIBLE SYSTEM } -	A method of melting glass in pots, round in shape and varying in size. Those used in Witness's firm (C. 80,243) are about 3 feet 6 inches high, 3 feet in diameter, and about 3 or 4 inches thick. They are at present used for melting varied colours of glass. The system was in general use until the introduction of Sir Wm. Siemens' gas regenerator furnaces, which render possible the use of tanks made of the best fireclay blocks and of large dimensions, in some cases holding from 150 to 200 tons of metal in a fluid state, whereas crucibles or pots only hold from 15 to 20 cwt. of molten glass, and are subject to bursting and other accidents.	DARG SYSTEM -	The <i>darg</i> is a day's work, that is, the number of tons or cwts. of coal in a particular seam to be raised in one day by one miner. The number is usually mutually agreed upon by the miners and the mine-owners. A <i>master's darg</i> is a wage which is settled by a master independently of the men.
CRUSH -	See definition of "creep," and diagram I.	DARK MONEY -	See definition under "money."
CRUSHERS -	Men employed at the mills or disintegrators for <i>crushing</i> copper ore or limestone.	DATAL HANDS -	Hands employed in cotton mills at a fixed rate per week of 56½ hours.
CUBE SHAFT -	A shaft, at the bottom of which is a ventilating furnace, and up which the foul air of a mine is conducted.	DATAL MEN -	See definition of "oncost men."
CUPBOARD LOCKS } -	See definition under "locks."	DATAL WORK -	Work performed by men who are employed a specific number of hours per day, or who may be paid their wages by day, and not by piece. Thus men employed in Oldham cotton mills at so much per week for the 56½ hours, are called "datal hands."
CURRIED -	The process through which rough tanned leather passes before it is ready for use for boot uppers, belting, &c.	DAY-DRIFTS OR DAY-HOLES } -	Galleries or inclined planes driven from the surface so that men can walk underground to and from their work without descending and ascending a shaft.
CURTILAGE -	In law the area of land occupied by a dwelling-house and its yard, piece of ground, or out-buildings, which are enclosed, or for legal purposes deemed to be enclosed.	DEACON'S PATENT } -	A large chamber with numerous shelves, over which are spread layers of lime; it is then screwed up, and the gas or fumes (after other treatment in the "decomposing pots") is forced into it for a limited number of hours, after which it is packed in barrels and sent off for bleaching or other purposes.
CUT LOOKER -	The person who examines and is held to be responsible for the work produced by the weaver. A <i>cut</i> or piece means a given length of calico.	DEAD ENDS -	Ends of stagnant canals, branches, wharves, or basins through which no fresh water flows regularly.
CUT NAILS -	See definition under "nails."	DEAD TICKETS -	A term used among 'busmen for tickets which have been used.
CUTS -	Sometimes called "ends" are pieces of cloth of a certain length (generally of or about 100 yards) <i>cut</i> from a warp. It may be cut off while the warp is still being wrought in the loom, or a finished warp of, say, 600 yards may be cut into <i>cuts</i> of 60 yards length.	DEALS -	Pieces of wood, usually three inches thick, imported from the Baltic and Canada in lengths of over 10 feet. (See definition of "planks.")
CUTTING THE HEADS OFF } -	In the shipbuilding industry this expression refers to cutting off the projecting upper portion of the piles (after they have been driven into place) in order to bring the heads to a level for receiving the longitudinal timbers which are placed on them.	DEBENTURE SHARES } -	<i>Debenture</i> was originally a note drawn upon Government; the term, however, is now applied to an instrument under seal issued by a company or public body as security for a loan. Debenture stock is usually irredeemable and is transferable in any amount. Hence all shares bearing a preferential claim to interest are called <i>debenture shares</i> ; <i>ordinary shares</i> only take interest after a certain fixed interest has been paid to debenture shareholders.
CUT-UPS -	Articles made upon steam round-about machines, sometimes in long straight pieces, which are cut up with scissors into the shape of stockings, shirts, or pants, and sewn together by a machine. In this class of work, the most inferior class of hosiery in the trade, the only fashioning process is that done by the clipping machine.	DECK HAND -	Here used for a man on board a vessel whose duties are solely upon deck, such as steering, attending to the tow ropes, &c. (B. 17,009, &c.)
CYLINDER -	A long round hollow casting* (usually of iron), closed at both ends, into which steam is admitted. The steam by means of expansion acts on the piston in the cylinder so as to work the machine.	DECK-HOUSES -	Houses of steel, iron, or wood, secured or built on the deck of a vessel.
DAIRY WORK -	See definition under "work."	DECKING -	A generic term, embracing all the operations incidental to fitting, fastening, and fairing the planks of which a wooden deck is composed. The fixing in place of the iron or steel plates which cover certain parts of a deck is included in the work of "plating" done by "platers."
DAMPERS IN THE FLUES } -	In chemical furnaces, the <i>dampers</i> , valves, or sliding plates are pushed every Saturday into the flues to keep up a slow fire, by checking the draught of air, until smelting is recommenced. On Sunday night the	DECK PIPES -	See definition under "pipes."
		DECKS -	The <i>decks</i> of a ship are the upper, the main, and the lower, and to these are fitted plates for purposes of strengthening and convenience in walking. (See diagrams VIII.-XII.)

* When the pressure to be supported by a *cylinder* is very great, a casting would not be made, but a solid mass of metal, cylinder shaped, would be made hollow by boring through from end to end.

Term.	Definition.	Term.	Definition.
DECOMPOSING POTS	Large metal pots into which about 25 cwt. of common salt is thrown together with a quantity of vitriol in proportion to its strength. The salt dissolves and hydrochloric acid gas is given off; this gas is used for the manufacture of "bleaching powder" and acid. The solid substance remaining is used for the manufacture of "black ash" (<i>see</i> definition).		man on completing his day's work looks on the <i>diagram</i> to ascertain his run for the next day. (<i>See</i> definition of "roster.")
DEEP SEA TUGS	Also called "large boats" or "first-class boats," are the larger class of tug boats, which tow vessels down the River and Channel, or to and from the Continent. (They frequently proceed long distances from their port in search of vessels requiring towing, &c.)	DIAL SQUARE -	A local name for one part of the Royal Arsenal at Woolwich, so-called because there is a sun-dial there. A term of no trade significance.
DELPHS -	Term used to denote the working places in Yorkshire ironstone quarries.	DIES -	Metal stamps or moulds used in foundries in connection with a steam-hammer for striking medals, for coining, &c.
DEMURRAGE ¹ -	Charges on overdue railway trucks.	DILIGENCE -	In Scotch law (a) a warrant to enforce the attendance of witnesses or the production of documents; (b) a writ of execution.
DEMURRAGE ² -	The charge incurred for failing to deliver a ship at the date at which she has been contracted to be delivered, representing more or less the loss which the owner has been subjected to by such delay. The delay itself is also termed <i>demurrage</i> . Legal holidays and Sundays are not included in demurrage charges. [The above definition of <i>demurrage</i> is solely from the shipbuilder's point of view; the following is a definition from the shipowner's point of view.] <i>Demurrage</i> is also the charge made by shipowners when a ship is not loaded or unloaded within the time specified in the bill of lading. It is a charge of from 1 <i>l.</i> per day according to the size of the ship. In the case of a barge it is customary to divide the demurrage money equally between the owner and captain; or if worked by the freight, the mate receives a third of the captain's share.	DIPPERS -	<i>Dippers</i> are the men and boys (or <i>dipping house lads</i>) in the potting industry who dip the ware in the glaze after its first fire.
DEPARTMENTS IN A SHIP-BUILDING YARD	<i>Civil engineer's department.</i> —This embraces boiler-makers, platers, riveters, drillers, &c., employed in the construction of bridges, girders, caissons (water-tight boxes), dock gates, &c. <i>Dry dock department.</i> —This embraces all classes of mechanics engaged in repairs. <i>Forge department.</i> —This embraces plate, angle, and bar, rollers, forgemen at steel hammers, steel makers, &c. <i>Shipbuilding department.</i> —This embraces boiler-makers, joiners, engineers, drillers, riveters, caulkers, smiths, shipwrights, platers, fitters, &c.	DIPPING HOUSE	The part of the factory in which the operation of dipping (<i>see</i> definition) is carried on.
		DIPPING HOUSE WOMEN	<i>Dipping-house women</i> are the women and girls in the potting industry who clean the ware after it has been dipped and become dry.
		DIPPING WARE	The process in which the ware, after a first firing, is dipped into a tub containing glaze, preparatory to the second and final firing.
		DIRTY COAL -	<i>See</i> definition under "coal."
		DIRTY FALLING -	Loading the hutches or tubs with an excess of dirt in proportion to the quantity of coal.
		DISCHARGERS -	Men in the chemical industry engaged in loading and unloading waggons.
		DISRATING -	A nautical term for <i>disranking</i> , that is, reducing from a higher rank to a lower, such as lowering a man from A.B. to ordinary seamen, or from fireman to trimmer.
		DISTRIBUTION -	The breaking up "a form" (<i>see</i> definition) or page, &c. of type and replacing into the type case all the matter (letters, spaces, &c.) which has been used.
		DOCKAGE -	Charge for the use of a dock.
		DOCKERS -	Men (in the London district) employed in the discharge of cargo or the handling of it for whatever purpose on the quays or in the warehouses.
		DOCKING OF VESSELS	This term applies to the putting of vessels into dry dock, preparing the "blocks" for the vessel to rest upon, and securing the vessel as the water leaves her, and she settles upon the blocks.
		DOCKMEN -	A term synonymous with "dockers" (<i>see</i> definition).
		DOFFERS -	Boys or girls of from 12 to 15 years who are employed to take off the full bobbins and to replace them on the throstle or ring frames by empty ones.
		DOGS -	A class of nails used for fastening down rails or sleepers. Each nail consists of a long spike, with ears on the side of the head, by means of which the nail may be wrenched up and re-used.
		DOG WATCHES -	Term used by sailors to denote the two watches between the hours of 4 and 8 p.m., viz., from 4 to 6 and 6 to 8.
		DONKEY-MEN -	Men on board ship who attend to the donkey-boiler and engine which are used in harbour when the large engines are not in use, for the purpose of supplying steam to the winches.
DESIGNER	The architect who designs the enrichment for the "modeller" (<i>see</i> definition) in the plastering trade.		
DESILVERING PROCESS	The process of separating silver from lead.		
DEVIL -	A machine used in the manufacture of mats. It consists of a drum with teeth that tear to pieces the fibre used in the industry.		
DEVILLING -	The same process as <i>willeying</i> (<i>see</i> definition).		
DIAGRAM -	A term used by the Scotch railway companies to denote the scale of working drawn up for each driver or fireman. In some cases the list contains but one day's running, in other cases one week's or possibly two weeks' running. Hence a		

Term.	Definition.	Term.	Definition.
DONKEY-WINCH	A winch is a machine placed on deck for the purpose of raising heavy loads, as, for instance, from a ship's hold to the dock. It is sometimes driven by steam (and called a steam donkey), sometimes by hand.	DRAUGHTSMEN -	Men with a mechanical training in ship-building and engineering who design plans, copy drawings, and delineate tracings to guide and instruct the workmen in the construction of, or repairs to, vessels and engines, &c. The duties of <i>draughtsmen</i> and "superintendents" are always combined, hence all <i>draughtsmen</i> are superintendents, and all superintendents <i>draughtsmen</i> .
DOSSER	An habitual loafer.	DRAWERS ¹ -	Also called "haulers," are the workmen in a coal mine who fill the tubs at the face and <i>draw</i> or <i>haul</i> them to the pit bottom or to the place whence a pony can convey them to the bottom of the shaft.
DOSS-HOUSE	Term used for a common lodging-house in the East End of London.	DRAWERS ² -	Women who put the warp into the "splits" or "heddles" for the starting of a web in weaving.
DOSS-HOUSE RANGER	The regular loafer.	DRAWERS ³ -	Women employed in <i>drawing</i> warps through the combs and reels before they are taken to the loom.
DOUBLE BOTTOMS OF SHIPS	The portion of a vessel lying contiguous to the keel from stem to stern. When the true bottom is put on, a space about 4 feet high in the centre and varying to 1 foot at the end and sides is left between the "skin" and the tops of the "tanks" (see definition) of the ship; through these tanks the workmen have to wriggle head first by means of a manhole; hence it is alleged suffocation sometimes occurs in the <i>double bottoms</i> . (See diagram VIII.)	DRAWERS ⁴ -	See definition under "cokemen."
DOUBLE JUMPS, LEAPS, OR LEADS	Terms used to mean increased payments. In the Durham sliding scale an extra 1½ per cent. was given on the wages of coal-getters for each 2d. per ton rise in the selling price of coal. If, however, the price rose to a certain point, the workmen then got 2½ per cent. instead of 1½ per cent. for each 2d. rise in the selling price of coal. This is called the <i>double jumps</i> , or <i>leaps</i> , or <i>leads</i> .	DRAWING ¹ -	A number of operations, from combing to spinning, performed wholly by female labour to reduce the thickness of the sliver of wool by <i>drawing</i> the warp through the "reed" (see definition).
DOUBLERS	Persons employed at <i>doubling</i> (otherwise known as "twisting") frames.	DRAWING ² -	(a.) In the potting industry to <i>draw an oven</i> is to remove the contents; in this case to relieve it of the saggars of ware which have been placed in it to bake. (b.) In the manufacture of gas to <i>draw a retort</i> is to perform a similar operation to (a), but to relieve the retort of the coke converted from the coal.
DOUBLES	A term applied to the two licences which are held by some cab-drivers, viz., licences for (1) cab-driving; (2) 'bus-driving; or (3) 'bus-conducting. If a driver holds all three he is said to own "trebles."	DRAWING A PAN	Taking out of a pan the draught (see definition) of salt which has accumulated there during the process of manufacture. It is the duty of the "waller" (see definition) to remove all the salt he finds in the pan, and then to fill up the pan with brine for the manufacture of more salt.
DOUBLE SHIFT	See definition under "shift systems."	DRAWING MACHINES	Machines in use in the gas making industry for <i>drawing</i> the charges from retorts.
DOUBLE TURN	The system of working part of a colliery by day and part by night with two sets of hevers. For instance, if a colliery is opened out north and south, and the north side worked by day only, and the south side by night only, that colliery is working a <i>double-turn</i> .	DRAWING-ON FURNACE MAN	A <i>drawing-on furnace man</i> has to keep the drawing-on rolls going when the plates have been cut up into pieces. He has to put them into the furnace, and when they are properly heated to take them out and hand them to the roller man. His work is not so heavy as that of the "plate furnace man," but his hours are longer; it is no unusual thing, it is alleged, for a <i>drawing-on furnace man</i> to keep at his work for 10 hours, with an odd moment's rest. There is one furnace man to each rolls.
DOWN LOCK	Men engaged on canal-boats on their return journey to Liverpool from Leeds, or from any intermediate station, are said to be engaged on the back passage or <i>down lock</i> .	DRAWING-ON ROLLER MAN	After the plates have been cut up into different sizes they are passed on to the <i>drawing-on roller man</i> whose duty is to roll the pieces into sheets. If they are small work he has to roll them thin enough to match into packs at the finishing roll. If they are large sheets, such as 4 by 4, 6 by 4 ft., &c., he has to roll them long enough to form the width of the sheet. To form a 4 by 4 ft. sheet he would have to roll the sheet 51 inches wide, and then the finishing roll would roll it 51 inches "on the cross" (i.e., in length).
DOWNTON PIPES	See definition under "pipes."	DREDGERS	Vessels fitted with iron buckets and machinery for deepening rivers or bars and keeping harbour or docks from filling up.
DRAIN PIPES	See definition under "pipes."	DRESSED STONE	See definition under "stone."
DRAUGHT	In the salt industry, a <i>draught</i> is the quantity of salt taken out of a pan each time the pan is cleared; sometimes, as in the case of boiled salts, this drawing takes place once or twice a day; sometimes, as in the case of coarse salts, it takes place only every two, three, seven, or fourteen days.	DRESSER	A skilled workman in a slate quarry who <i>dresses</i> , that is, shapes into blocks the rock as it is hewn from the quarry.
DRAUGHT FURNACE	A furnace used in the glass bottle making industry built immediately underneath a stack (or chimney), with the fire grate running through the middle and the crucibles containing the metal fixed on each side; thus the fuel is burnt on the spot where the heat is required.		
DRAUGHTSMAN	An engineer's helper (in this case in the gas making industry) who draws plans and makes specifications. (C. 24, 126.)		

Term.	Definition.	Term.	Definition.
DRESSERS	Men who attend to the machine upon which waste silk is dressed or combed out by steel combs and the different lengths of staple sorted out. They are also engaged in putting starch or <i>dressing</i> into the warp and wool in a machine for that purpose. <i>Dressers</i> may be engaged upon yarn, or cloth, or silk.	DRILLINGS	The system of punishing a work girl in a confectionery factory for lateness, by keeping her out for a fortnight or so without employment, and therefore without wages. This is termed giving her a fortnight's <i>drilling</i> .
DRESSING FLOORS	A <i>dressing floors</i> (not floor) is a surface works where the tin stuff as it comes from the shaft of the mine is first subjected to various crushing processes, such as "spalling" and "tin-dressing" (see definitions), and then "washed," that is, subjected to the action of water, in order that the tin may be separated from alien matter, for the tin having a high specific gravity sinks, while the pulverized tin-ore with metallic and earthy minerals is carried away in suspension.	DRIVAGES	See definition under "stone headings."
DRESSING LIME		The clot lime (calcareous earth or calcined chalk) on arriving at chemical works is slaked (or slacked, a chemical process of combination) by pouring water on it as it lies on a brick floor. After slaking, the slaked lime powder is passed through a sieve to remove coarse particles, and this operation is known as <i>dressing lime</i> .	DRIVERS
DRESSING SLATE	Trimming or smoothing the rough blocks of slate. Slates of the softer vein are <i>dressed</i> by a slate-dressing machine, those of the harder vein are dressed by a hard knife.	DRIVING BANDS	Leather bands wherewith the machines to be set in motion are connected with the engine producing the motive power. In the present instance the machines are type-setting machines. (C. 28,584, 28,621.)
DRIFT-MOUTH	The entrance to a "day drift" at the surface.	DRIVING COOPERS	Men in the coopering trade whose work is to tighten hoops on casks, and who are engaged in kindred labour requiring little skill.
DRILL ¹	A rod of iron, with a chisel end, which bores the hole in the coal or stone in which the blasting powder is to be placed. (See diagram of a <i>hand-drill</i> used in engineering, under definition of "drilling posts.")	DRIVING MONEY	See definition under "money."
DRILL ²	To <i>drill</i> a person is to refuse him employment for a certain period, say, a fortnight or a month, as a punishment.	DROSS	"Small coal" (see definition).
DRILLERS ¹	A Cleveland term for those who <i>drill</i> holes in ironstone or other mineral for blasting purposes. The <i>hand-drill</i> (see diagram under "drilling posts") is a rod of iron, with a chisel end, which bores the hole in the coal or stone in which the blasting powder is to be placed. It is not merely manual skill which is the chief requisite of a good driller; he must possess much experience in order that he may know exactly where to drill the hole, and the precise direction in which to drill it, in addition to the knowledge of how to drill it quickly and well.	DRY DOCK	A <i>dry dock</i> or <i>graving dock</i> is one from which the water can be pumped or let out after a vessel is placed therein, and the vessel thus left dry for examination, painting, or repairing the bottom, &c.
DRILLERS ²	Skilled mechanics in the shipbuilding industry who bore or <i>drill</i> holes through iron or steel plates, bars, beams, &c., for the insertion of rivets and bolts, or for manholes, ventilation tubes, portholes, &c. <i>Drillers</i> use either steam-power machinery or a hand tool called a ratchet brace. The former is termed <i>machine drilling</i> and the latter <i>hand drilling</i> .	DRY DOCK DEPARTMENT	See definition under "departments in a shipbuilding yard."
DRILLING	Making holes in rails for the purpose of putting in bolts to fasten them to sleepers.	DRY HEAT	The term <i>dry heat</i> was used to explain that although the workshops were heated by steam, the steam was not allowed to escape, thus leaving the atmosphere hot but quite dry. If the steam escaped from the pipes in the workshops the atmosphere would still be hot, but the heat would be "damp heat." (C. 80,484).
DRILLING POSTS	A contrivance for keeping in place the <i>hand-drill</i> as it is being used (see following diagram). HAND-DRILL.	DRYSALTER	One who deals in drugs, oils, potted meats, gums, &c.
		DUBBING A PLANK	To <i>dub a plank</i> is an expression used in the shipbuilding industry meaning to reduce with the adze, a shipwright's tool for cutting or chipping, having an arched blade at right angles to the handle, the breadth or thickness of a plank.
	A B C, Drilling posts. D, Ratchet brace. E, Drill.	DUCK LAMPS	Tin vessels containing oil and cotton wick, much used for lighting purposes in shipyards and dry docks. The name varies in some districts.

Term.	Definition.	Term.	Definition.
DUMB BARGE -	A barge or lighter which is not a sailing barge, but propelled by oars. <i>Dumb barge</i> is a term peculiar to the Thames; on other rivers such a barge is generally termed a "flat."		
DUMMY BARGES	Barges used as store barges in which to keep ropes, oars, and gear of all kinds; they are usually old craft covered in.	ENGINE-DRIVERS ²	Men engaged in the manufacture of gas and employed in the engine-house to drive engines attached to the exhausters which take away the gas from the hydraulic main as it is made. They also attend to the machinery used for other purposes.
DUMPING- } GROUND }	A waste heap or receptacle for refuse. Hence, when applied to the docks it means that the docks form a receptacle for the scum of the population.	ENGINE-DRIVERS ³	See definition under "drivers."
DUNT THE WARE	This accident in pottery making occurs only in the "biscuit ovens" (see definition), and is caused by pulling down the entrance to the oven too soon, in order to cool the oven more quickly than in the ordinary way.	ENGINEERING } WORK }	See definition of "marine moulding."
DUSTING - -	Clearing the dust off the roads in a coal mine.	ENGINEERS -	(a.) The term <i>engineers</i> or <i>master engineers</i> , as applied to employers, denotes owners or managers of works or establishments for the manufacture of engines and similar machines. (b.) The term <i>engineers</i> as applied to workmen comprises the skilled trades engaged in the construction, fitting, and repairing of engines, boilers, and machinery, such as smiths, fitters, turners, erectors, pattern-makers, millwrights, planers, borers, slotters, mechanical draughtsmen, brass-finishers, copper-smiths, machine joiners, ships' smiths, &c.
DUSTY MONEY -	See definition under "money."	ENGINE-FITTERS	Workmen employed in putting together, and in supplying the necessary workmanship for that purpose, the various parts of machines, engines, and their accessories, after they have been machined and prepared for the necessary fitting together.
DUTCH AUCTIONS	Sales from a street stall. The owner shouts forth that he will sell a certain article at such a price. If no one buys at this price he gradually reduces it until a purchaser is found or until he will lower the price no further, when he takes up a fresh article and proceeds with a like endeavour to sell that.	ENGINE-PLANE } MEN }	Those in mines who keep in repair and look after generally the roads or planes along which waggons are hauled by means of ropes from a "stationary engine."
DYERS - -	Skilled foremen who mix dyes and chemicals and superintend the dyeing.	ENGINE-ROOM } ARTIFICER }	A class of skilled workmen employed in the engine-rooms of Her Majesty's Navy, e.g., "engine fitters," (see definition) turners, boiler-makers, &c.
DYERS' } LABOURERS }	Those who do the necessary manual labour in a dye-house.	ENGINES -	<i>Fan engine</i> .—The engine erected at the top of a coal pit, used to drive the fan which forces or exhausts the air in or out of a mine. <i>Hauling engine</i> .—An engine employed to draw the coals along the engine planes from the workings to the bottom of the shaft, or by a drift to the surface. They are also similarly used along railways on the surface. <i>Locomotive engine</i> .—An engine employed on the surface of a mine on railways. <i>Pumping engine</i> .—The engine that drives the apparatus for raising the water out of a mine with a bucket pump. Others are erected in the mine, and by means of force pumps send the water to the top of the pit. <i>Traction engine</i> .—A locomotive (self-moving) engine for drawing (Lat. <i>tractus</i>) anything heavy along the highway. <i>Winding engine</i> .—An engine erected near the top of the shaft, and employed to draw coals out of the mine.
DYKES - -	Broad faults (or trap rock) of igneous rock, such as basalt or greenstone, of a hard granite (see definition) composition, occupying the rents or fissures of stratified rock; they usually run somewhat across the true slate vein. (At the Dinorwic quarries there are about 20 <i>dykes</i> of varying width and hardness).	ENGINE SMITHS	See definition under "smiths."
EAGLE BRAND -	The brand of work (boots and shoes) made by the Northumberland Co-operative Society.	ENS - -	See definition under "per thousand ens."
EASY OR SOFT } AND STIFF OR } HARD COAL }	See definition under "coal."	EQUIVALENT } GRANT }	In 1899 Scotland was given under s. 22 (6) of the Local Government (Scotland) Act a sum of money for free education proportionate to the money granted to the local authorities in England by the Local Government Act, 1888. This came out of the Local Taxation Account. When in 1891 money was provided by Parliament to free education in England, Scotland also got a grant from the votes which was called the <i>Equivalent Grant</i> . There was no particular purpose to which to allocate it, so the Secretary for Scotland divided it among local authorities to
ELASTIC WEB -	An elastic fabric produced by a combination of india rubber with some other substances.		
ELEVATOR } ENGINEMEN }	Those in charge of the engine that hoists the materials from the bottom to the top of a blast furnace.		
EMBARGO -	A restraint on ships, or prohibition of sailing either out of port or into port; a stoppage of trade for a limited time by public authority.		
ENDORSEING } LICENCES }	The expression "endorsing a conductor's licence" is a generally-understood reference to the custom of a magistrate, on convicting a bus or tram conductor of any offence, <i>endorsing his licence</i> , i.e., writing on the back of the licence "10 days," or "14 days," or whatever sentence may be imposed. Thus a licence will always show whether or not a conductor has been convicted, and, if so, the number of times and terms of imprisonment, since convictions for petty offences do not cancel a licence. An unendorsed licence is commonly termed a "clear licence." This process, of course, applies equally to a cab or omnibus driver's licence.		
ENGINE-DRIVERS	The term <i>engine-driver</i> is applied to every driver of a locomotive engine on the rail-		

Term.	Definition.	Term.	Definition.
	do pretty well as they liked with. In 1892, however, the 55 & 56 Vict. c. 51, re-introduced uniformity between Scotland and England by throwing the Scottish free grant on the votes, and thus freeing—for various purposes prescribed by the Act—that portion of the Local Taxation Account that was formerly used for free education. The <i>Equivalent Grant</i> , strictly speaking, has thus disappeared; but as local authorities under s. 2 (5) of the Act of 1892 have grants to deal with, which for their purposes are scarcely distinguishable from the portions of the <i>Equivalent Grant</i> formerly accruing to them, the name may still remain. The <i>Equivalent Grant</i> was the grant made to Scotland as an equivalent for the moneys voted for free education in England, and the same term may now be applied to that portion of the Local Taxation Account handed over to local authorities on conditions similar to those on which they formerly "touched" part of <i>Equivalent Grant</i> proper.		between pit-bottom and working places is stopped by a fall on a road.
ERECTING SHOP	See definition under "shops."	FALLEN } FLEECES }	Fleece, wool, or mohair, taken from the dead carcasses of sheep, &c., and therefore diseased.
ESTABLISHED } MEN }	<i>Established men</i> or <i>establishment men</i> are permanent workmen in the dockyards who are not liable to be discharged, excepting for offences against the regulations, and for whom the Admiralty are obliged to find employment. These men are, after the age of 60, entitled to receive a pension, for which a weekly sum has been deducted from their wages, according to their length of service.	FANDANGLES -	A term in use some forty years ago in country places in Lancashire to describe small trifles or fancy goods introduced into confectionery or biscuit baking; the term is now almost obsolete.
EXAMINER } AND SUB- } EXAMINER }	In the Dinorwic quarries an <i>examiner</i> is next below in grade to an "over-looker" (see definition), and to a certain extent has to assist the over-looker and sub-over-looker of the department. Their principal work, however, is inspecting the workmanship of, and counting, dressed slates.	FAN ENGINE -	See definition under "engines."
EXERCITION } MONEY }	See definition under "money."	FANMEN -	Men in charge of the <i>fan engines</i> , i.e., the engine erected at the top of the coal pit, used to drive the fan which forces or exhausts the air in or out of a mine.
EXHAUST } STEAM }	Steam which has been expended in a cylinder. After it has done its work it is allowed to escape or is used for heating purposes.	FANNY -	A local term, a corruption of <i>fanmer</i> or <i>fanblower</i> ; that is, a wheel with vanes fixed on to a rotating shaft enclosed in a case or chamber to create a blast of air. It is used in the scissor-grinding industry to carry away the dust created by dry grindstones.
EXHAUST- } STEAM PIPE }	A pipe through which the steam passes after working the engine of winches or cranes.	FASHIONING -	The process of shaping the stocking-leg and foot, also the shirt-sleeve and pant-leg, and back. This is done by hand by means of small points with which some of the loops are removed to narrow the stocking or pant at the ankle, and the shirt-sleeve at the wrist. In the steam-work these fashioning points are forced through the material by pressure, but do not turn out such good quality work.
EX PARTE -	From one side; one sided. Thus a statement made by one of the parties to a suit which his opponent had no opportunity of answering is termed an <i>ex parte</i> statement, and appeals decided in the House of Lords on the appellant's statement, the respondent not having appeared, are said to be decided <i>ex parte</i> .	FATHER OF } THE CHAPEL }	The members of the <i>Typographical Society</i> employed in one printing office (or, in very large offices, in one department, such as a case department or a machine department) form a chapel and hold meetings to discuss points of order or matters of difference; the <i>father of the chapel</i> is the member chosen as the representative.
EXPRESSED -	Here means literally <i>pressed out of</i> .	FAT PORTIONS	The open portions of printing work; for instance, advertisements, where space is inserted between each line, or poetry, which involves less trouble than closely printed matter.
EYELETS -	Metal laceholes.	FATTER WORK	In the printing industry all matter to be set up in type that is not straightforward is paid at an enhanced price, although to a skilled compositor it presents little more difficulty than the plain setting. Such matter is looked upon as advantageous to the setter and is generally called a <i>fat</i> piece of matter. (The term is also in use amongst actors on the stage where a <i>fat</i> part is one that gives the actor special opportunities of displaying his talents.) These intricate pieces of work are not suitable to the Thorne type-setting machines and therefore fall exclusively to the hand workers.
FACE -	The place in a pit where the hewer is employed in getting or working the coal in whole or "longwall" workings. (See diagram I.)	FATTING ROUND	Oiling the machinery.
FACE OF THE } PLATE }	Term used in the potting industry to denote that part of the plate which is "towed" (see definition of "towers"), viz., the concave part.	FAULTS -	A dislocation in the strata around a seam of coal. (See diagram IV.)
FAIR -	The expression to <i>fair vessels</i> is one in general use among shipwrights and means to keep the frames and other parts in their proper position during the construction of a vessel.	FEEDERS ¹ -	Women who lay the wool upon "carding" machines, and thus <i>feed</i> the machines are called <i>feeders</i> .
FALL -	Dislodged strata from roof or sides of workings or roads; a frequent cause of cessation of work when communication	FEEDERS ² -	Young persons in the woollen industry who <i>feed</i> the "scribblers" with the blended material.
		FEEDERS ³ -	Boys or girls in the printing industry who "feed the machines" (see definition).
		FEEDING THE } MACHINES }	In the printing industry laying on the printing machine, one by one, sheets of paper which are taken by the gripper of the machine round the cylinder over the stone so that the work is printed upon them. There must be only one sheet

Term.	Definition.	Term.	Definition.
	laid on at the time; if two sheets are laid on instead of one both are spoiled.	FINE COUNTS -	A trade term distinguishing between fine and coarse spun threads of cotton.
FELLING -	General term used in the tailoring trade to describe a special kind of sewing put in linings, facings, &c.; otherwise, outside the trade, called "hemming."	FINER -	The one who fines; a name given to the inspector by Lancashire factory hands.
FETTLERS -	Persons who clean "condensers" or "scribblers" by scraping the "fudd" and dirt and material that has stuck to the cards on machinery (<i>see definition</i>).	FINING -	Grinding <i>fine</i> .
FETTLING -	The rich oxides of iron ores, with which the molten pig iron is boiled by the "puddler" (<i>see definition</i>) to effect the purifying of the iron by the absorption of its impurities out of the pig when in a fluid condition in the puddling furnace.	FINISHER ¹ -	The <i>finisher</i> in the boot industry takes the boot from the rivetter or laster and scrapes and sandpapers the soles and edges, and afterwards colours the edges and heels black and the soles white or the required tint, thus <i>finishing</i> them. He then ties the goods up in pairs, and they are ready to pass into the warehouses.
FETTLING A FURNACE }	The lining of calcined sider or purple iron fixed round the inside of a puddling furnace requires constant renewal; this renewal is termed <i>fettling the furnace</i> .	FINISHER ² -	The workmen in the glass bottle industry who finish off the roughly shaped bottle as it comes from the blower. They are also called "makers."
FEU SYSTEM -	The feu system is a custom (in use in Scotland) under which a feu or piece of land is purchased by a perpetual yearly payment instead of by a lump sum down, or is leased for building purposes for a certain number of years, subject to the payment of a fixed rent. The feuar has all the rights and privileges of a proprietor subject only to the payment of the yearly sum agreed upon. In the event of the <i>feu</i> (or payment) not being made, the property can be claimed as by a mortgagee.	FINISHER ³ -	The <i>finisher</i> in the hat industry is one who, after the hats have been through the various processes of manufacture, sews in the lining and such outside trimming as may be required.
FIDDLEY -	The name generally applied to designate the space formed by the iron casing or protection round the deck opening leading to the stokehole of an engine room. This open space over the stokehole which is used for ventilation is usually covered by a grating of iron bars. It is generally raised above the deck to prevent water getting down. The word <i>fiddley</i> appears to have been in use for 10 or 15 years only.	FINISHING DEPARTMENT }	The mills in the copper industry where the copper is worked out and finished ready for the market in different shapes, sizes, and thicknesses, according to the requirements of the merchants.
FIDUCIARILY -	A term borrowed from Roman law. If a man transferred his property to another, on condition that it should be restored to him, this contract was called <i>fiducia</i> , and the person to whom the property was so transferred was said <i>fiduciam accipere</i> , and to be a <i>fiduciary</i> .	FINISHING FURNACE MEN }	To each "rolls" (<i>see definition</i>) there are two <i>finishing furnace men</i> , first and second hands, unless the work is very small, when only the first hand is kept on. Their duty is to sort the sheets of copper into packs, putting from two up to ten and even more, according to the weight of the sheet and the length it has to be drawn. They have to put the packs into the furnace, heat them to their proper pitch, bring them to the rolls, and then assist the roller man in the working of them.
FIELD-RANGING HOUSES }	Hastily and badly built structures erected on the outskirts of all large towns and cities by "jerry-builders" (<i>see definition</i>).	FINISHING ROLLER MAN }	The <i>finishing sheet roller man</i> has to roll out the sheets of copper to their proper length and finish them ready for the warehouse.
FILLER ¹ -	The man or boy in a mine who loads the coal in the trams at the "face"; sometimes called a "trammer."	FINISHING ROLLS	<i>See definition under "rolls."</i>
FILLER ² -	The man (in a squad of five) who fills or shovels the grain into the bucket in which it is weighed before being transferred to the sack.	FIRECLAY -	A natural deposit suitable for the manufacture of fire-bricks, tubes, retorts, and other articles which are required to resist extreme heat.
FILLER ³ -	A <i>filler</i> is a coal porter who fills the tip-tanks in a ship's hold by means of "pans" and "flat shovels," the "flat shovel" being used when clearing the floor of the hold.	FIREMEN ¹ -	The <i>firemen</i> on all locomotive engines work according to the instructions of the driver. Their principal duty is attending to the <i>fire</i> and to the handbrake where such is in use on the engine; they have also to assist the driver in keeping a general look-out for signals.
FILLER ⁴ -	<i>See definition of "char fillers."</i>	FIREMEN ² -	The <i>firemen</i> are the men in the gas-making industry who clean the <i>fires</i> , fill them with coke or coal, and keep the heats up to the required standard.
FILLER ⁵ -	<i>See definition under "cokemen."</i>	FIREMEN ³ -	A <i>fireman</i> in the potting industry is one who <i>fires</i> the ovens when they are filled with "saggers" (<i>see definition</i>) and superintends the baking of the ware. He is the head of the "placers" (<i>see definition</i>).
FILLERS OF THE OVENS }	The men in the baking industry who take charge of the ovens and fill them with bread to be baked.	FIRING -	Attending to the fires and keeping them up to the required heat for carbonising coal.
FILLING OUT FROM THE KILNS }	The mode adopted in England by which <i>char-fillers</i> fill their barrows from kilns or from a gantry provided for the purpose in close proximity to the furnace. This system is much easier for the men than that of <i>filling</i> from railway waggons at present existing in Scotland.	FIRING DEPARTMENT }	The department in a gas works where the <i>fires</i> for heating the retorts are fixed; in some works which are ground works the firing and carbonising departments are one and the same, but in London, where it is chiefly stage work, the firing is carried on below the iron stage in a cellar.

Term.	Definition.	Term.	Definition.
FIRING WARE -	<i>Firing ware</i> in the potting industry is the operation of baking ware in circular ovens or kilns. The expression applies to both "biscuit" and "glost" (see definitions).		
FIRST-CLASS BOATS } -	See definition of "deep sea tugs."		
FIRST-TURN MEN	Men who take out four-in-hands and fill up their time on cars or omnibuses. Such men have <i>first turn</i> at private work.		
FISH PONTOON	A wharf or fish market on the shore to which fish is transferred directly from the fishing boat. The term <i>pontoon</i> was originally applied to floating piers or landing stages which rose and fell with the tide, but is now frequently used for the more substantial markets and docks which have taken their place. The floating pontoon outside of Billingsgate Market is technically called the "dummy."		
FISH RINGS -	A system by which a number of buyers pre-arrange prices or appoint one of their number to buy fish, the remainder sharing with him after the purchase. As this system limits the buyers of fish (and therefore limits competition) it lowers the prices.		
FITTERS ¹ -	Term applied to those persons (usually young women, but sometimes men) who paste together the portions cut out to form the boot-ripper, to prepare them for sewing by the machinists. After they are sewn the <i>fitter</i> trims off any jagged edges or pieces of thread, and makes them generally fit for the affixing of the soles or bottoms.		
FITTERS ² -	Men in the salt trade whose business it is to make and <i>fit</i> all kinds of machinery.		
FITTERS ³ -	In the gas industry <i>fitters</i> are main and service layers, and lay gas on in the streets and houses.		
FITTERS ⁴ -	In the shipbuilding and engineering industries, the duties of <i>fitters</i> (i.e., engineers—see definition—who fit together forgings, blacksmiths' work, and metal work, and erect engines and machinery) embrace the final preparation or manufacture (forgings and castings also being supplied when required) of most metal ship fittings not usually understood to be included in what is technically called the machinery of ships, and the execution of necessary repairs to all yard machinery, engines, cranes, travellers, &c., sliding water-tight doors, valves of all kinds, torpedo discharge ports, pumps, copper pipes, &c., and the manufacture of the connecting gear of the same. In Pembroke Dock <i>fitters</i> also manufacture all such portions of steering gear as may be classed as machinery, other than the engine and gearing connecting it with the Chart House and Conning Tower, which is supplied by contract. The actual fitting in the ship of the gearing of water-tight doors and valves is executed by <i>fitters</i> , but the sliding water-tight door frames and sluice valves are fitted in the ship by "shipwrights." (see definition), who also make the patterns from which the door frames and valves are cast, although the water-tight surface of the frame and all the fittings and accessories connected with it are prepared by <i>fitters</i> . In the ordinary course of their duties, as well as working with hand tools at the vice, in iron, metal, brass, &c., <i>fitters</i> may be seen working lathes, planing, shaping, slotting, and (occasionally) drilling machines, &c., but the same individual does not pass a piece of work through all its stages at the different machines. It is customary to keep particular men at planing machines, who		
			do all the planing that may be necessary, and similarly with other machines. Thus, although most <i>fitters</i> would be expected to adapt themselves to work any machine, a man is not regularly required to work different machines in order to complete a job. Some of the least difficult planing, such as the edges of the plates, and all plain drilling or counter-sinking, is executed by what are called skilled labourers, who are continuously employed at planes or drilling machines, as the case may be. <i>Fitters</i> are divided into two classes, "engine-fitters" and "machine-fitters," the former being engaged exclusively upon the work of fitting engines, and the latter performing all other branches of fitting. In the Clyde shipyards the term <i>fitters</i> is often applied to "platers" (see definition).
		FITTERS' HELPERS } -	<i>Fitters' helpers</i> are skilled labourers who assist the mechanic "fitter" by performing the manual, while the fitter does the technical, part of the work. A <i>fitter's helper</i> must be a trained man and have a rough practical knowledge of the work, otherwise two fitters would be required to perform one piece of work.
		FITTING A KNEE	A <i>knee</i> , i.e., a bent piece of timber or metal, is put into corners to support the beams, &c. of a ship or to connect them with the sides or timbers (ribs); it is fastened to the beams, &c., by bolts passing through holes which have to be bored for the purpose. This work of boring and fastening is termed <i>fitting a knee</i> . (See following diagrams.)
		FITTING SHOP -	See definition under "shops."
		FITTING THE STANDING AND RUNNING RIGGING } -	The operation of <i>fitting standing rigging</i> (the stationary or fixed ropes and chains attached to the hull of a ship) consists of taking the rope, either of steel, iron, or hemp, and converting it into the finished article, such as the "stays" or "shrouds" which keep the masts, &c., firm and secure. The operation of <i>fitting running rigging</i> (loose ropes and gear, lifts, braces, &c., used about the masts, sails, and yards of a vessel during navigation) consists of taking the "blocks," "hooks," or "thimbles" (rings fastened in the corner of a sail through which to pass the rope that secures it), and <i>fitting</i> them by means of ropes, &c. to their allotted places.
		FLANGERS -	Also called "boilersmiths," are men, in the shipbuilding industry who bend the plate edges where angles cannot be made to fit. Formerly this work was done by heating, and afterwards bending to shape while hot by the use of hammers. Now, after heating, the bending is generally done by hydraulic machinery.

Term.	Definition.	Term.	Definition.
FLANGES	- Discs fitted on to the ends of pipes pierced with bolt holes, and intended, with the materials placed between them, to secure tightness or gas, passing through the pipes.	FORE AND BACK SHIFT	} See definition under "shift systems."
FLATMEN	- Term used in Lancashire and Cheshire for the men employed in steering and navigating flats upon canals and rivers; also termed, according to the district, lightermen or bargeman.	FORECASTLE	- That part of a vessel, generally forward (under the deck), assigned to the crew for their accommodation, and fitted with bunks, &c. (See diagram XIV.)
FLATS	- See definition under "boats."	FOREMEN OF THE YARDS	} A class of officers next above the "leading men" whose duty it is to supervise the building or repairs to ships and engines, and to whom the leading men are directly responsible.
FLATTING	- The flat is the station in a colliery to which the "putters" take the full tubs to be thence conveyed by the drivers to the engine-plane, landing, or shaft. Flattening, therefore, is the staking of coal by boys at the flat.	FORE-PEAK	- A compartment in the fore end of a vessel commonly used for storing ships' gear, &c., when at sea. (See diagram XIV.)
FLAX DRESSERS	Men who give the flax the final dressing and sorting previous to its being spun into yarn.	FORESAIL	- The lowest square sail on the foreward mast of a vessel, and one of the largest sails in a ship. In a fore and aft vessel it is the triangular sail before the mast. (See diagrams XV. and XVI.)
FLAX ROUGHERS	Men who roughly dress the flax preparatory to its being sent to the "flax dressers." (Term used exclusively in the linen trade in Ireland.)	FORESHORE OF THE THAMES	} The banks of the Thames.
FLINT YARD	- The name of a chemical yard in Flintshire, N. Wales.	FORE-STITCHING MACHINE	} Or "forepart-stitching machine," is a machine used in the manufacture of boots, and known to the trade as a fair-stitching machine.
FLOSS	- Also called "flue," "fly," and "fluss," the small particles of fibre in the dust given off in the processes of the manufacture of textiles. These particles are insoluble, and so, if inhaled, irritate the respiratory organs.	FORWARD	- Pronounced "for'ard" by seamen; the fore end of a barge or other craft. (See diagram XIV.)
FLOWING	- Changing the bottom of a furnace used in the chemical industry. The old "bottom" (see definition) is removed either by smelting, or by pulling out in pieces, according to the material of which it is composed.	FORGE DEPARTMENT	} See definition under "departments in a shipbuilding yard."
FLUES	- In the potting industry flues are the pipes which run from each "mouth" (see definition) to the centre of the oven under the oven bottom and carry the heat right through to the centre.	FORGEMEN	- Forgemmen at the dockyards make or prepare forgings of the heaviest and perhaps, in many respects, the most difficult pieces of work which fall to the lot of "blacksmiths" (see definition), of which they constitute the most highly paid class. Ships' davits (iron supports for hanging out over the side of a ship, thus clearing the side when it is desired to swing any fittings from the deck, such as ship's boats, anchors, &c.), cat heads (mostly made of wood and used only on sailing ships), and formerly stems, stern-posts, and struts to support the propeller shaft in twin screw vessels, are examples of the work which forgemmen execute. Stems, stern-posts, and many other articles hitherto forged are now cast in steel or metal. (See diagram IX.)
FLY	- Loose down.	FORGEMEN'S HELPERS	} Forgemmen's helpers are the men who assist forgemmen to handle, during the process of forging, the heavy masses of material of which forgings are composed. Helpers usually comprise blacksmiths of an inferior class to the forgemmen, hammermen, and ordinary labourers.
FLY-BOATS	- See definition under "boats."	FORGINGS	- Portions of iron or steel hammered or pressed into the desired shape, while in a heated state, by a steam hammer or in a forging press.
FLYING	- The process of cutting blades without "bolsters" (see definition) out of sheet steel.	FORKS	- In mill sawing machinery the forks are two upright pieces of iron one on each side of the band moved by a lever to throw the band on or off the driving wheels.
FLYINGS	- Short fibres thrown out from the wool on to the sides of the carding machine whilst in motion.	FORM	- A mass of types composed and arranged in order, disposed in pages or columns, closed and locked in a "chase" (see definition) ready for press. The outer form always contains the first and last pages and the inner form the second page.
FOGGERS	- Middlemen or small employers who do not sell in the open markets but who are open at any time to buy nails from the workpeople and to make profit by disposing of such produce to the larger employers in the district. Fogggers usually keep a huckster's shop (i.e., a shop where small articles are retailed).	FORWARD	- Also spelt <i>foreward</i> ; the fore end of a barge or other craft. (See diagram XIV.)
FOGGING	- The system by which small employers in the nail and chain trade, who do not sell in the open market, make their profits by paying their workpeople less than the recognised price, and by selling their work (which is consequently inferior) to the larger employers in the district. Such small employers are termed fogggers, or middlemen. (To fog = to resort to mean contrivances.)	FOUNDER	- (a.) Master founders are the owners or managers of a foundry for making iron or brass castings or both.
FOLDING MACHINES	} Machines which fold work after being printed.		
FOOT JOINTS	- Joints or divisions appearing at the foot or bottom of certain slate blocks.		

Term.	Definition.	Term.	Definition.
	(b.) <i>Founders</i> or "moulders" (see definition) are skilled workmen engaged in a foundry in melting, moulding, and preparing iron, brass, steel or other metal castings from wood patterns supplied to them.	FUDD - -	The refuse or dirt cleaned out of the materials during the processes of scribbling and carding.
FOUNDRY -	The particular shop in works where masses of metals are cast, <i>i.e.</i> , melted and run into moulds.	FULL MEMBERS	See definition under "members."
FOUNDRY FURNACES } -	Steel-producing furnaces in works where nothing else but steel castings are made.	FURNACE } -	Men who remain at the top of the furnace and empty therein the loaded barrows sent up from the bottom. The employment of such men is, however, exceptional, as, generally, in Scotland it is the custom for the man who fills the barrow (<i>i.e.</i> , the <i>char-filler</i>) to ride up the hoist with his barrow and empty it for himself.
FOUR-WHEELER	A hackney carriage on four wheels, licensed to carry four persons inside and one person outside.	FURNISHINGS -	
FRAME-BENDERS	Men in the shipbuilding industry who bend the frames, <i>i.e.</i> , scantlings of vessels. They are also termed "frame-turners."	FUR PULLERS -	Those who scrape the loose down off rabbit and other skins, and do various minor parts of fur-making, as, for instance, cutting the little bit of bone out of the tails of rabbits. The occupation is frequently carried on at the workers' own house, and is unhealthy, because the down is inhaled. It prevails on the south side of the River Thames, chiefly in Bermondsey and Deptford.
FRAMES - -	The <i>frames</i> or <i>framing</i> of a ship are the ribs to which the "plates" or "planks" (see definition) are secured, and which form the contour lines or shape of the ship. (See diagram VIII.)	FURTH - -	<i>Furth</i> of the United Kingdom means outside the boundaries of the United Kingdom.
FRAME-SETTERS AND THEIR HELPERS }	Mechanics engaged in the shipbuilding industry who make the frames of vessels with angle iron and plates. <i>Frame setters</i> are also called "frame turners" (see definition). Their assistants are termed <i>frame setters'</i> (or <i>turners'</i>) <i>helpers</i> .	GABBY - -	Too talkative.
FRAME TURNERS	Men, in the shipbuilding industry, who are employed at the furnace in bending and bevelling the angles to be used as frames for all classes of vessels, either steamers or sailing ships. One <i>frame turner</i> , with four, five, or six helpers, according to the weight of the angles, forms a squad. One "plater" (see definition) with four, five, or six helpers forms a board squad, that is the squad doing the actual fitting of the angles and plates together on the vessel.	GAFF - -	The spar to which the head of the fore and aft mainsail is fastened and then hoisted up the mast. (See diagram XV.)
FREEMEN -	See definition of "watermen." ¹	GAFFER - -	Term used by workmen in the textile and many other trades denoting the foreman or superintendent. Also generally used by waterside workers to denote their foreman, overseer, or ganger.
FREE-ON-BOARD PRINCIPLE }	Iron to be put on board ship by the seller at a given price.	GALLEY - -	A nautical term for that part of a ship which serves as a kitchen.
FREE-STONE :-	A durable species of stone composed of sand or grit, so called because having no grain it is easily (or <i>freely</i>) cut into blocks or worked with the chisel; it is a stone used in building and also for rubbing or polishing purposes.	GAME OF GRAB	"The good old rule sufficeth them : "The simple plan— "That they should get who have the power "And they should keep who can."
FREIGHTAGE :-	The hire of a ship, or money charged or paid for the transportation of goods.	GANGERS - -	Men engaged in the manufacture of gas in superintending gangs of workmen, such as a <i>ganger</i> placed over men emptying "purifiers" (see definition ²), or performing yard work of all description, where more than two men are engaged. In many other industries also men in charge of a party or gang of labourers are usually termed <i>gangers</i> .
FREIGHTERS OF COAL }	Merchants who arrange as to freight, <i>i.e.</i> , the charge for carrying cargoes by water.	GANTRIES - -	A kind of viaduct built to convey the iron-ore in railway trucks to the top of roasting kilns, which calcine the ore before it is put into the blast-furnace for smelting.
FRESH WATER PIPES }	See definition under "pipes."	GANTRYMEN -	Those who "fill out from the kilns" or <i>gantries</i> (see definitions) or tip the iron-stone or ore into kilns where it is burnt before going into the blast-furnace.
FRET-SAWING -	Cutting or carving various designs out of wood by means of a very narrow saw moving vertically.	GARDENER -	A term used in the cab-driving industry to denote an inexperienced driver. It is a more common expression than "whack," which has the same meaning.
FRIABLE - -	Apt to crumble, easily reduced to powder.	GARNISHER -	A person in whose hands a debt is attached, <i>i.e.</i> , who is warned not to pay money which he owes to another person, when the latter is indebted to the person warning or giving notice. In the High Court the notice is given by an order called a <i>garnishee order</i> , hence the verb <i>garnishee</i> .
FRONT AND BACK SIDEMEN }	<i>Front sidemen</i> are keepers, slaggers, helpers, and metal-carriers, who are employed at the front of a blast furnace. <i>Back sidemen</i> are mine-fillers, coke-fillers, limestone-fillers, who are engaged behind the furnace.	GAS COAL -	See definition under "coal."
FRONT MEN -	The two men in the gas making industry who lift the scoop of coal into the retort with a piece of iron bent in the middle. (See definition and diagram of "bridle.")		

Term.	Definition.	Term.	Definition.
GASMEN -	Those who watch the gas coming through tubes from the furnaces to the boilers and stoves used for heating purposes in connection with a blast-furnace, in order to see that there is no escape of gas.	GLAZING -	The operation of dipping the ware into the glaze after its first fire.
GAS PRODUCER MEN }	The workmen who make the gas for the heating of the furnaces in the iron smelting industry.	GLEEDS -	A glowing coal or small coke suitable for use in the nail industry. (<i>See</i> definition of "breeze.")
GASSED -	Choked by the chlorine gas used in the chemical processes connected with the manufacture of bleaching powder. To prevent this the men are compelled to wear thick muzzles, and to take other unpleasant precautionary measures.	GLOSSING WARE	This expression here means the same as "glazing" or "dipping" (<i>see</i> definitions).
GASSERS -	Those who work at the <i>gassing</i> machines. "Gassing" is the process which the spun thread of silk, cotton, &c., undergoes to render it smooth and even by getting rid of the nap or raised fibres. Each thread passes three turns through a small gas flame, moving so rapidly that all the "stuff" is burned off, but the thread uninjured.	GLOST OVENS -	The ovens used in the potting industry for the second fire of the ware after it has gone through the dipping house and received a coating of "glaze."
GASSY DISTRICT	A district where inflammable gas prevails in the mines.	GLOST PLACERS	The men in the potting industry who place the ware after it has been "dipped."
GAS TAR A } BRICK }	To <i>gas tar a brick</i> is to submit it to a process before it is burnt with the object of securing a higher colour, which the gas tar produces on penetrating the clay.	GLUCOSE -	A cheap sugary substance, used in the manufacture of common kid upper leather, somewhat improving its appearance, and also increasing its weight; to obtain this latter effect is the chief reason for its use.
GAS WORKERS -	The duties of <i>gas workers</i> are to draw and charge retorts, clean pipes, clean and fill up fires, wheel coal to the retorts, and wheel out the coke from the retorts.	GOOD TIME MONEY }	<i>See</i> definition under "mouey."
GATE END -	In the case of long-wall workings the end (nearest to the face of the coal) of the branch roadway leading from the main road to the coal face where the miners work.	GOVERNOR	An automatic machine attached to an engine for the purpose of regulating the quantity of steam admitted to an engine, and consequently its speed.
GATE LIPS -	The roof of the <i>gate-end</i> , that is, the place where the roof ceases to have been made high enough for horses to work in or the entrance to the face, divided from the gate-end by the "ripping."	GRAB -	A self-acting skip or bucket which fills itself on being lowered by a crane amongst the coals in a barge.
GATHERER	The workman in the glass bottle industry who gathers the metal out of the furnace ready for the "blower" (<i>see</i> definition).	GRADIENTS	Varying inclinations of streets and highways along which tram-lines pass.
GAUGE HOSE	<i>See</i> definition under "hose."	GRAINERS	Men in the printing industry who <i>grain</i> stone with sand for artists doing what is called "chalk work," that is, they use a greasy material which goes into the grain caused by the sand.
GAUGING -	<i>Gauging cartridges</i> is the operation of measuring cartridges by passing them through a <i>gauge</i> to ascertain if they are of the standard calibre.	GRANITE -	A plutonic or igneous (<i>i.e.</i> , proceeding from the action of fire) aggregate rock, composed of the minerals quartz, felspar, and mica, or at least of two of them, confusedly crystallised together. Being of great strength, hardness, and durability, it is much used for building. The colour is chiefly light gray, but there are also white, red, and mottled granites. The best is obtained near Penryn in Cornwall, but some comes from Aberdeen, the Channel Islands, and other quarters. The principal uses of this stone are for laying foot-ways, court-ways, railway stations, floors of factories and warehouses, kitchens, cellars, churches, engineering works, the columns and foundations of buildings, &c.
GELATINE	Gelatine dynamite, or one of the numerous nitro-glycerine compounds.	GRAVING DOCKS	Docks fitted with gates or caissons (water-tight boxes) so that vessels can be floated into them. Afterwards the gates are closed, the caisson is put in place, and the water pumped out to allow of the vessel—then resting upon blocks, and supported by shores to the dock side—being handled for painting or repairs, such as graving or breaming (<i>i.e.</i> , cleaning the bottom by burning off the barnacles and other accumulated matter), &c. A <i>graving dock</i> is also the place where new vessels are built.
GETTING OUT } COPY }	A printer's term to express the setting up in type of the composition for publication in the issue of the following day's paper.	GRMERNERS	Term used chiefly in connection with Jewish cabinet-makers to denote those who have but an insight into the trade, and work for whatever wages they can command. It is a term similar to "improvers." <i>Also</i> —as used in the boot trade—destitute Jews who arrive in England with no knowledge either of the language or of any trade, but are employed by Jewish sweating-masters.
GILT WORK -	The work of "metalling" or "bronzing" (<i>see</i> definitions).	GREY -	The <i>grey</i> is a term used in the cotton and worsted trade to describe pieces of yarn
GIRDERS -	Beams of wood or iron for supporting the superincumbent weight in any erection; as in houses, bridges, &c.		
GLANDS -	The <i>packing of glands</i> here referred to means the putting of flexible material, such as flax or rope into the space between the piston-rod and cylinder, known as the "stuffing box" of a railway engine. This stuffing-box is screwed up with a brass <i>gland</i> which prevents the steam escaping from the cylinder or steam chest.		
GLAZE -	A powder constituted of various ingredients (an important one being lead) which is used as a coating to pottery ware and which vitrifies, <i>i.e.</i> , is converted into glass by heat.		

Term.	Definition.	Term.	Definition.
	or "slubbing" as they come from the looms before going through any process of dyeing or finishing.	GULLOTINES	Machines used in the iron and steel industry for cutting square blocks of steel to a certain length.
GRID	A perforated sheet of metal through which the dust is driven by the "blow-pipe" (see definition) used in the potting industry.	GUN MOUNTINGS	The framework upon which the guns on a vessel are mounted, that is the carriages with their fittings and fixtures.
GRIDIRONS	Blocks of timber on which barges or ships lie so that the workmen can work on the bottom of the ships.	GUNNERY	Work done by "shipwrights" (see definition) in connection with guns and their stowage, &c.
GRINDER	The man who <i>grinds</i> the wire teeth of the card sharp. The card is a leather comb with wire teeth used in the process of "carding."	GUNNY	Bales of sacking weighing five or six or seven cwt.
GRINDERS	Men in the seed-crushing industry who put the rolled seed under a pair of stones to be ground preparatory to being made hot.	GUNNY BAGS	Bags made from heavy rough jute cloth to contain salt and such articles. They were formerly made by hand by the natives of India, but are now made by machinery. (The word <i>gunny</i> is derived from Sanskrit.)
GRINDERS } HULL }	The general expression in Sheffield for the workshop or room in which the <i>grinders</i> in the knife cutlery trade do their work.	GUY	A term used by sailors to denote a guide rope.
GRINDERY	See definition of "furnishings."	GYMP	A trimming made of fine cord covered with silk or worsted warp confined by a band of silk. The spinner makes all the small cords, which are then woven in a loom by the weaver into the required design. <i>Gymp</i> is sewn on to curtains and chairs by women. The industry has recently deteriorated owing to foreign competition and a diminished demand.
GRINDING } MONEY }	See definition under "money."	HACKNEY } CARRIAGE }	A cab, carriage, or coach, licensed by the Commissioner of Police of the Metropolis, to ply for hire, in contradistinction to a "stage carriage" (see definition).
GRINDSTONE	A revolving, circular-shaped, flat sandstone, moved by hand or steam, used for sharpening and grinding edged tools.	HAG PRINCIPLE	Term used to denote the system under which a skilled miner employs an unskilled man, paying him, say, 4s. per day, when, possibly, he might have earned 7s. or 8s. if working for himself. This practice is called <i>hagging</i> . Crudely put, the <i>hag principle</i> is the "sweating system."
GROUND LAYERS	<i>Ground layers</i> are the workers in the potting industry, who put various colours on the ware in a dry state. These colours are mixed with large quantities of lead. This mixing was formerly done by men only, but is now done chiefly by women.	HAIR WORK	Mixing or dragging hairs into $\frac{1}{4}$ -inch lengths. These hairs are chiefly obtained from pigs from Germany and Russia and some from India; of late a large quantity of black hair has been imported from China.
GROUND-OFF } SAW }	A circular saw, thick at its axle and ground off to a thin edge at the teeth.	HALF-TIMERS	Children who attend school one half of each day and help in cotton mills for the remaining half-day.
GUANO	A species of manure made by mixing various chemicals.	HAMMERING- } OUT MACHINE }	Or "rolling-out" machine, used in bottoming boots (when goods are machine-made) to flatten the bottoms and keep them from becoming lumpy. In goods made by hand a large-headed hammer is used by the operator.
GUARANTEED } MEN }	Men employed by a contractor, and having regular wages.	HAMMERMEN ¹	Men who manipulate the <i>steam-hammers</i> used for the purpose of drawing out the square blocks of steel into a long thin slab ready for rolling.
GUARDS*	The term is applied to guards of passenger trains (hence, frequently called "passenger guards" as distinguished from "goods guards"); whose duties are to take charge of the train on its journey and of passengers joining and leaving at the various stations at which the train stops, to see that the carriage doors are shut, and to look after the passengers' luggage, parcels, and mails, conveyed by the train. Guards, who have control of the continuous brake in their vans, have also to keep a look-out to prevent mishaps on the journey and to keep a journal of the running of the train, cause of delays, &c.	HAMMERMEN ²	The duties of <i>hammermen</i> or "strikers" (see definition) are to assist smiths in preparing forgings of all kinds by striking for them with hammers or sledges, &c.
GUARD OF THE } MACHINE }	Iron guards around cogs, grippers, and slabs of printing machines to prevent accidents.	HAND-MADE } NAILS }	See definition under "nails."
GUIDE MILLS	See definition under "mills."	HAND-MULES	Spinning-machinery, driven by steam power and manual labour combined, used in producing yarn. It stretches the thread out much finer, and at the same time twists it to give it strength; the process, however, is largely discontinued, and is now only used by producers of very fine yarn.
GUIDES	Also termed "slides," are the vertical rails, usually of wood, fixed in the shaft of a mine for keeping the cages in position.	HAND-OVER	Term expressive of a system of dishonest tipping in vogue in the building trade, whereby an incompetent workman bribes a foreman to keep him in regular employment.

* In supplying definitions of the terms *brakesmen, engine-drivers, firemen, guards, shunters, shunting engine-drivers, yardmen, &c.*, the manager of the Caldonian Railway Company remarks as follows:—"I may state that the same terms with similar meanings are in general use on all the Scotch railways, but I understand on some of the southern companies' lines there is a slight difference in the meanings of some of the terms;" and the manager of the London and North-Western, in supplying definitions of the terms *brakesmen, engine-drivers, firemen, guards, &c.*, remarks, "You will gather that in this matter there is some little difference of practice even between railway companies running out of London." However, a careful consideration of the respective definitions shows that the duties of the classes referred to are identical, although in some cases other designations may be used. The definitions (which have been compiled from various sources) here given show these alternative designations where they are used.

Term.	Definition.	Term.	Definition.
HAND-PRESS	A printing press worked by hand, and not by steam; a few presses only are worked by steam.		make an opening in the warp for the passage of the shuttle. This opening is called the "shed" (see diagram XVII.).
HAND-SETTING	<i>Hand-setting</i> is a term used in printing for the composition of matter, set up by hand at "case," each stamp or letter being picked out separately with the fingers. <i>Machine-setting</i> is the performing of similar work by means of a machine.	HEAT	To <i>get a heat</i> is to raise the heat in a furnace to such a degree that the plate required in "plating" (see definition) can be heated and shaped.
HANGERS-ON OR HOOKERS-ON	Other names given to "cutters" (see definition).	HEATING	In the iron and steel industry, getting the steel hot for rolling.
HANK	A <i>hank</i> is 840 yards length of yarn. (See definition of "counts.")	HEATS	The quantity of metal or steel placed in a puddling mill or Siemens furnace is called a <i>heat</i> .
HANSON	A two-wheeled hackney carriage, licensed to carry two passengers inside. (See definition of "showful.")	HEATS ²	The temperature of the "retorts" (see definition).
HARD HOILING	Hard strata underneath the coal which has to be holed or curved.	HEAVING THE LEAD	When a ship is heaving a coast or harbour, or when the weather is foggy, a man is stationed at the side of the ship with a line which is marked off in fathoms or half fathoms. To one end of this line is fastened a piece of lead weighing 7 lbs., and the whole being thrown into the sea shows the depth of water under the ship. The act of throwing and drawing up again is nautically termed <i>heaving the lead</i> . The deep sea lead weighs 28 or 56 lbs. To heave this the ship must, as a rule, be stopped.
HARD ROLLS	See definition under "rolls."	HEAVY MONEY	See definition under "money."
HATCH	In a broad sense, the square open space on a ship's deck down which the cargo is lowered; generally applied more specifically to that section of the cargo space immediately under the opening. (See diagrams X. and XI.) <i>Main.</i> —The largest and most central of such openings is termed the <i>main hatch</i> . (See diagram XII.) <i>After.</i> —The opening between the main hatch and the stern is termed the <i>after hatch</i> . (See diagram XII.)	HEAVY PLATERS	See definition under "platers."
HATCHWAYS	Openings in the deck of a ship. The <i>hatch</i> is properly the square open space in a ship's deck down which the cargo is lowered, though it is often applied to that section of the cargo space immediately under the opening. (See definition of "hatch," and diagrams X., XI., and XII.)	HEEL OF THE SAW	The back of the saw, supposing the saw to be revolving directly in front of the operator.
HATTERSLEY SYSTEM	A system by which type is distributed either by machines or girls into long tubes, each distinct letter having a distinct type. The machine is operated on by a man at the key board, which on being touched liberates a letter from the tubes above; this letter is then conveyed through grooves to a central spot where it falls into the required position as if guided by the hand.	HELPERS	The persons in the blast furnace industry who <i>help</i> the keeper to mould the beds, run the metal in, and generally assist at the front of the furnace.
HAULAGE	The means used both on the surface and underground in mines for carrying or transporting coal or other mineral, either by horses, by winding ropes (i.e., ropes wound round a drum and worked by a steam, electrical, or pneumatic engine), or by a small locomotive worked by compressed air.	HERRING COOPERS	The men who make the casks in which herrings are packed.
HAULERS	See definition of "drawers 1."	HEWERS ¹	Miners, i.e., workers or getters of coal in mines. They are usually paid by the piece.
HAULIERS	The men or boys underground in a coal mine who drive the horses or ponies which draw the trams conveying coals from the working.	HEWERS ²	Those who follow that branch of the masonry trade which consists in the cutting or dressing of the stone previous to its being placed on the walls.
HAULING ENGINE	See definition under "engines."	HIGGLE	To bargain; to discuss rates of payment.
HEADINGS ¹	Working places, generally narrow, driven in front of the other part of the working in order to open the work.	HIRER MEN	Casual workmen in the dockyards employed temporarily for such periods as may be necessary. They are distinguished from "established men" (see definition) in that they are not entitled to a pension, but receive a gratuity on being discharged after not less than seven years' continuous service.
HEADINGS ²	Main ways of a colliery.	HITCHERS	The men who put the trams of coal on the carriage at the pit bottom.
HEALDS	A series of loops knitted of twine upon two laths. In plain weaving a pair of these series are used, each series containing loops to half the number of threads in the warp. Through one series is threaded every other warp thread; through the other the alternate threads. In weaving the <i>healds</i> rise and fall alternately, and	HOBBLERS	Casual labourers.
		HOBBLING PILOT	A pilot who has the necessary marine knowledge but no licence from the Board of Trade. He is usually located at small ports which are unable to afford the services of a licensed pilot.
		HOB NAILER	An American machine for putting the <i>hob-nails</i> into the soles of boots.
		HOB NAILS	See definition under "nails."
		HOIST	A machine worked either by steam or by water-power, and used for conveying the loaded barrows of coal, ironstone, and ore from the bottom to the top of a blast-furnace, and for bringing back the empty barrows.

Term.	Definition.	Term.	Definition.
HOIST MEN ¹	Men attending the hydraulic cranes or steam winches used for <i>hoisting</i> the cargo from deck to quay.		catching up in anything and snapping the rope.
HOIST MEN ²	Men in the chemical industry, engaged in looking after the hoists or lifts in the yard.		<i>Open hook</i> .—A hook, universally used in loading from quay to ship, where there is no danger of the sling jumping off or of the hook catching in anything.
HOLDERS-UP	Skilled workmen (also called "holders-on") who form one of the set of three classes engaged upon rivetting work in the ship-building and engineering (boiler-making) industries, viz., heaters, holders-up, rivetters. The assistance rendered by the <i>holder-up</i> to the "rivetter" (<i>see</i> definition), who is opposite to him, consists in securing, by the use of a heavy hammer (or "dolly"), the hot-iron rivet in proper position in the holes in the plates which the rivetter is clenching together by knocking the rivet-ends flat or "cupped" (expression indicating a form of rivet head, viz., round), and tight.	HOOPERS -	A term used for "driving coopers" (<i>see</i> definition).
HOLE-BORERS	A class of men in the engineering and ship-building industries who bore holes through plates or bars by means of hand ratchet braces, where such work cannot be done by machine before the pieces are put together. (<i>See</i> diagram in definition of "drilling posts.")	HOPPERS ¹	Steamers which receive the dirt and deposit from the "dredgers" (<i>see</i> definition), and carry it out to sea.
HOLE-CUTTERS	Workmen in the shipbuilding industry who cut holes in the plates or frame-work of ships with hammer and chisel—of any irregular form—or in situations where "drillers" (<i>see</i> definition) cannot be so well employed.	HOPPERS ²	Large receptacles into which coals are shot from railway trucks. They have a shoot at the bottom by which the coals run down into the sacks beneath.
HOLERS' DAY OR STINT	The measure of undercutting, undermining, or curving a length of seam so that the coal can be brought down by blasting or wedging. In one seam, for example, a length of 7 feet cut under the seam for a depth of 5 feet is a <i>stint</i> . This <i>stint</i> or so-called day has always been considered as the standard on which contracts are based, and in relation to which advances or reductions are considered. Thus, if an advance of 3d. a day be given on a <i>holer's day</i> of 3s. (<i>i.e.</i> , 8½ per cent.), an advance of 8½ per cent. is given on all underground labour.	HOPPER WORK	<i>See</i> definition under "work."
HOLE	A set or group of hands employed (in glass bottle making) at each aperture in the furnace from which the molten metal is taken for making the bottles. The bottle finisher in such a group stands at the furnace to heat the neck of the bottle after it is blown so that the ring or lip can be welded on to it.	HORSE-KEEPERS }	A <i>horsekeeper</i> is a man who grooms, feeds, and generally attends to, say, ten horses; he also cleans the harness and attaches the horse to the cart, &c., in the morning, and changes the horses and washes the cab at changing time. In some parts such a man is called a "strapper."
HOLING COAL	Undercutting the coal in order to release it from the other strata.	HORSE-MARINE	The man or youth who is engaged in leading and attending to the horse drawing a canal boat.
HOLLOW-WARE PRESSERS }	Men and boys who are employed in the making of soup-tureens, sauce-tureens, cover-dishes, ewers, chambers, jugs, teapots, sugar-boxes, creams, foot-baths, garden-seats, umbrella-stands, vases, luncheon-trays, dessert ware, flower pots and many other kinds of earthenware and cast-iron kitchen utensils of a similar character.	HOSE -	<i>Wrought hose</i> .—A very elastic class of hosiery made wholly upon a hand-machine. It is fashioned by ticklers (<i>see</i> definition), and requires no menders to search for flaws. <i>26-gauge hose</i> .—Coarse, stout articles for winter wear, used by the military. A 26-gauge consists of 26 needles in every three inches across the frame, and produces 26 loops, or courses, to an inch in length of material. A 60-gauge (the maximum used) consists of 60 needles to the inch, and produces much finer work.
HOLYSTONING	Rubbing decks with a piece of sandstone in order to make them clean and keep them smooth.	HOSE-MAKERS	Skilled workmen who join together pieces of oiled leather into hollow pipes used by firemen, engine-drivers, cramenen, &c. for putting out fires, filling boilers, &c., and called <i>hoses</i> . The work is highly skilled, as the pipes have not only to be watertight but to stand a strong pressure.
HONEY-COMB SHAWLS }	A certain make of shawl, the pattern of which slightly resembles the honey-comb.	HOT MONEY	<i>See</i> definition under "money."
HONORARY MEMBERS }	<i>See</i> definition under "members."	HOUSE CARPENTERS }	Workers in woods and timber used in house building up to the time a house is covered in. <i>House carpenters</i> are not considered to be so skilful in neat work as "house joiners" (<i>see</i> definition), but the distinction is merely nominal in most cases.
HOOK	<i>Clip hook</i> .—A hook universally used in discharging with steam-power. It has a workable hinge which prevents the sling from jumping off when it comes into contact with any obstacle, such as hatch combings or beams, and the hook from	HOUSE COAL	<i>See</i> definition under "coal."
		HOUSE-JOBBERS	A class of people who hire houses from the owner or his agent, and make a living by dividing the houses into tenements and sub-letting at high rates.
		HOUSE-JOINERS	Artisans who construct the internal wood-work of a building, fix the doors and windows, lay joists and erect scaffolding, &c. They are frequently confused with "house carpenters" (<i>see</i> definition).
		HOUSE-PLUMBERS }	<i>See</i> definition under "plumbers."
		HOY-BARGES	<i>See</i> definition under "barges."
		HULLS OF STEAMSHIPS }	In the shipbuilding industry the term <i>hull</i> denotes the entire ship, <i>i.e.</i> , frame and body exclusive of engines and machinery.
		HUTCHES OR TUBS }	Small waggons into which the miner loads his coal.

Term.	Definition.	Term.	Definition.
HYDRO- CHLORIC ACID GAS	The colourless gas (HCl, i.e., composed of equal parts of hydrogen and chlorine) evolved when equal quantities (by weight) of common salt and sulphuric acid (vitriol) are heated together. The gas is dissolved in water, and the liquid is used for generating chlorine for the manufacture of bleaching powder.		
IMPOSING CHASES	Arranging the pages of a sheet in proper order for printing and otherwise preparing them for the press.		
INBYE	In the workings or in any direction away from the shaft.		
INCIDENCE OF TAXATION	The falling of taxation.		
INCLINE BOYS	Boys employed at the upper or lower end of self-acting incline-planes in attaching or detaching tubes to the ropes, also in attending to the working of the switches or points of the road and in regulating the speed of the tubs moving upon such incline-planes. These planes are sometimes called "ginneys," "jinnys" (see definition), or "jiggers."		
INSIDE PLATERS	See definition under "platers."		
INTAKE	The passages through which the fresh air enters the workings from the downcast shaft.		
INTAZZIA WORK	See definition under "work."		
INTERLOCKING SYSTEM	A system, formerly in general use on railways and adopted as a safeguard against collisions, of connecting the various levers of a signal cabin in such a manner that certain levers cannot be moved so long as others are in certain positions. This system is now superseded by the "block system" (see definition).		
IN THE RUN	The Witness (Mr. Matthew Carroll) states that by the expression <i>in the run</i> he means extra distance over half the length of the warehouse. Thus, if the length of a warehouse is 300 feet, a distance of over 150 feet is termed (according to the Witness) <i>in the run</i> . For carrying corn, &c., any distance within the specified limit, 1½d. per quarter or 12s. 6d. per 100 quarters, and over the specified distance, i.e., <i>in the run</i> , an extra ¼d. per quarter, making 14s. 6d. per 100 quarters is paid. This extra ¼d. is paid only for loading into craft, not into trucks. However, according to the Secretary of the Commercial Dock Company and others, Mr. Carroll is mistaken in the meaning he assigns to this expression as used in his evidence. The following is an extract from a letter on the subject, dated 17th December 1892, from the above-mentioned Secretary: "In making deliveries grain has sometimes to be conveyed by the men from one or other of the warehouses to the quay side. If the distance traversed does not exceed a certain limit agreed with the men (in this case 150 feet), the delivery is said to be <i>in the run</i> , and the men receive 12s. 6d. per 100 quarters. Mr. Carroll, in his reply to question 13,995, has inverted the meaning of the expression <i>in the run</i> as it is used and understood by the company's officers."		
INTO LOCK	Men engaged on canal boats journeying from Liverpool to Leeds, or to any intermediate station, are said to be engaged on the outward passage or <i>into lock</i> .		
IRON	<i>Bar-iron</i> .—Iron for nails and chains is wrought into malleable rods or bars from 6 to 10 feet long; usually all lengths up		
			to seven-sixteenths of an inch diameter are called <i>rods</i> and all thicker sizes <i>bars</i> . <i>No. 3, foundry pig</i> .—The usual quality of iron used for foundry purposes in Scotland and England; it is specially selected for its fluidity and softness in the castings made from it. It is also the quality usually stored in Glasgow warrants as a customary merchantable pig-iron. <i>Malleable iron</i> .—A decarbonised product from pig-iron, and thus iron freed from its brittleness and capable of being extended by beating. It is used in the production of all iron ships as distinguished from cast-iron, and is produced in the forge section of the rolling mills department. <i>Pig-iron</i> .—Clay ironstone mixed with coal and limestone is tipped by means of a trolley into a smelting-furnace where it liquefies. The oven has two pipes at the bottom, one for an inlet of air, the other for the outlet of cast-iron (i.e., granular iron) which collects at the bottom, slag being formed on the top. The slag is conveyed along a pipe leading from the middle of the "cast-iron" pipe to a mould. The first iron that comes out from the "cast-iron" pipe is crude metal called <i>pig-iron</i> . These kinds of iron, having passed through the pipes into moulds of sand, about 3 feet long, 5 inches broad, and 4 inches thick, become cooled into pigs and bars of wrought iron by a process of annealing, i.e., cooling very slowly to make the iron tough, and prevent brittleness. <i>Sectional iron</i> .—Any shape of rolled iron—flats, squares, or rounds—as distinguished from bar iron or rod iron. <i>Wrought iron</i> .—Iron made by melting pig-iron into a liquid state in a puddling furnace, by stirring or puddling it by manual labour until it becomes a pasty substance, then taking it in balls or lumps to the steam hammer, beating it into a solid state, and finally rolling it into bar or rod iron.
		IRON-CAULKERS	See definition of "caulkers."
		IRON DRESSERS	A term applied only to men engaged in <i>dressing the castings</i> ; they are sometimes called "fettlers." Their duties are to chip and in some measure polish up the "castings" (see definition) in brass, iron, or steel.
		IRON-FOUNDERS	The men in the shipbuilding industry who prepare the earthen moulds from the pattern-maker's model, and afterwards cast the metal.
		IRON-FOUNDERS ²	See definition of "moulders." This definition, which refers especially to workers in the brass industry, is equally applicable to the workers in iron known as <i>iron-founders</i> or <i>iron-moulders</i> .
		IRON-MOULDER	See definition of "iron-founders ² ."
		IRON MAN	The <i>iron man</i> is the name given to the machine used in gas-making for putting coal into the retorts and drawing out the coke.
		IRON-ORE MEN	Men who discharge iron-ore cargoes.
		IRON PYRITES	Rounded lumps of hard metallic substance formed of a combination of sulphur with iron, presenting a brassy metallic appearance, and generally used in making "sulphuric acid."
		IRONSTONE	General term for a stratified seam of iron-ore, i.e., hard clay bands. Clay ironstone is a compound of clay and carbonate.
		IRON-TYRED HANSOMS	Hackney carriages, broughams, or hansoms, having the wheels fitted with iron tyres.

Term.	Definition.	Term.	Definition.
IRON WORK	See definition under "work."		
IRONWORKERS ¹	Workmen employed in the construction of ships in performing other work than plating, rivetting, caulking, or drilling. The term is also frequently used to include the whole of these classes.		the goods are made, the cancelment accepted, or the goods may be made in error and not respond to a customer's requirements. Such accumulation is frequently dealt with as a <i>job</i> , i.e., offered and sold <i>en bloc</i> at a price less than the current or list charge per yard or article.
IRONWORKERS ²	Here used to denote ordinary coach-smiths. (C. 20,808.)	JOBBER	A <i>card jobber</i> is an under overlooker.
ITALIAN-WAREHOUSE-MAN	An oil man; a vendor of macaroni, vermicelli, olive oil, dried fruits, provisions, and such like comestibles.	JOINING SMITHS	See definition under "smiths."
JAMMING OF CARTRIDGES	Rifles are rendered useless in action when the cartridges, not having been properly "gauged" (see definition), fit too tightly to the chamber, i.e., are <i>jammed</i> .	JOINERS ¹	<i>Joiners</i> —a term used in the shipbuilding evidence as an abbreviation for <i>ship-joiners</i> —are tradesmen who make and fit up deck-houses, ships' cabins and saloons, ships' furniture, cabinet work, skylights on upper deck, companions, and the lighter, finer, and more highly finished class of work, linings, &c., required about a ship. A <i>joiner</i> completely finishes his work, with the exception of painting or polishing, by himself, and in some cases finishes off the heavier work performed by the shipwrights. His tools consist of the plane, chisel, and saw. A <i>ship-joiner</i> serves an apprenticeship of six to seven years. The term <i>joiners</i> , sometimes confused with "carpenters" (see definition for distinction), is generally understood to denote artisans employed in house-building and occupations of a similar character. For distinction between "joiner" and "machine-joiner," see definition of latter.
JERRY BUILDER	A speculating builder of "field ranging houses" (see definition) usually without capital, and financed by a money-lending solicitor.	JOINERS ²	In the house-building trade of Scotland the terms "carpenters" and <i>joiners</i> are identical, the workmen being equally skilled in either branch. In England <i>joiners</i> are artisans who construct the internal wood-work of a building, fix the doors and windows, lay joists, and erect scaffolding, &c.; but they are frequently confused with "carpenters" (see definition).
JERRY BUILDING	Building houses in a hasty, slovenly, ill-finished and even unsafe manner, chiefly as a speculation.	JOINERY	The art of fitting or joining pieces of timber in the construction of utensils or parts of a building so as to form one entire piece.
JERRY PLUMBING	Term synonymous with slop-plumbing, i.e., poor, inferior, workmanship.	JOINTING A PIPE	To <i>joint a pipe</i> is an expression used in the shipbuilding industry meaning to connect the end of a pipe to another or to a chest, pump, or tank so as to be watertight or steamtight.
JET SEAM	A bed of Durham coal of a coarse cannel species, nearly approaching to a black shale. <i>Jet coal</i> burns with a bright flame, but loses little bulk in the fire.	JOINTING UP	The completing of the joints in any series of pipes where either flanges or ferrules are used, by the use of some unguent or other medium, such as white lead, asbestos, india-rubber, &c. In flanged joints they are drawn together by the use of bolts. In screw joints the water or gas tightness depends upon the close-fitting of the ferrules.
JETTISON	The act of throwing cargo (heavy goods) overboard to lighten a vessel in extreme danger.	JOLLY	To <i>jolly</i> means to chaff.
JETTY	(a.) The projecting part of a wharf; (b.) a mole (Latin, <i>mole</i> , a mass, i.e., a mound or massive work formed of large stones laid in the sea before a port, which it serves to defend from the violent impulse of the waves) or timber pier of slight construction to land goods and passengers on; (c.) a projection into a river for narrowing it and raising the water above that place. The term is here used in the last sense. (A. 25,546.)	JUD	When a portion of a pillar or square block of coal has been worked in the broken mine, the place is called a <i>jud</i> .
JIB	The <i>jib</i> of a crane is a projecting arm supplied with a sheave wheel on which the crane chain runs.	JUMBOS	<i>Jumbos</i> are not retorts, but a new furnace used in gas making which heats 45 retorts instead of the 9 heated by the old furnace.
JIB CRANE	A crane working upon a point, and having a <i>jib</i> , or protecting arm, which is made to describe a complete circle, and is capable of being raised or lowered at will in the required direction for winding or landing at an extreme point. This <i>jib</i> is best compared to the human arm; when the arm is raised straight above the head, a string held in the fingers would fall perpendicularly very near to the body; when the arm is stretched out horizontally from the shoulder, the string would fall perpendicularly at some distance from the body.	JUMP	To drill a hole for the purpose of blasting, but, instead of a drill and a hammer being used separately, the drill is made of greater length and the opposite end from the chisel swelled out to make it heavy. Such a drill is driven by hand and called a <i>juniper</i> .
JIGGER BOY	Name given (at the Millwall Docks) to a boy working a jigger or loose chain.	JUMPERS	A term used to denote inspectors who <i>jump</i> on to the omnibuses and trams to examine tickets, and to check the conductors' returns as to number of passengers, &c.
JIGGER WORK	See definition under "work."		
JIGG	Term used in North Staffordshire in the steep measures to describe the road down which the trams are sent, the full trams pulling the empty ones up.		
JINNY	A self-acting incline where the full tubs of coal pull the empty ones up.		
JOBBED	Under the ordinary condition of manufacture (in almost any branch) a certain amount of "stock" will accumulate, e.g., an order may be cancelled, and, though		

Term.	Definition.	Term.	Definition.
	In cases of dishonesty they charge the offenders, and bring them before the manager.		covered with iron or brass; in other cases a solution of mud and hair is used.
JUTE	Cloth made from <i>jute</i> fibre, that is, the fibre of a plant of the <i>corchorus</i> family, grown in British India. It is used in the manufacture of coarse cloth, such as hessians, sackings, carpets, &c. (The word <i>jute</i> is derived from Sanskrit.)	LAI D-OUT TUB	A tub of coal filled by a miner, containing an over-weight of impurities, such as stone, sulphur, shale, brasses, dirt, or foul coal. The hewer who fills the tub is fined according to some graduated scale for the amount of such impurity over a certain specified quantity (the maximum on a tub of 8 cwt. is 56 lbs.).
KEEL	The principal timber in a ship, forming the lower extremity and extending from "stem" to "stern" (<i>see</i> definitions), upon which the vessel is built. (<i>See</i> diagrams VII. and IX.)	LAMP-LIGHTERS	Men whose duties comprise lighting, extinguishing, and cleaning the public lamps.
KENLS	<i>See</i> definition under "boats."	LAMP-LOCKING STATION	The place in a mine where the safety-lamps of all the miners are examined and locked by an official.
KEEPERS	<i>Furnace-keepers</i> are those who take charge of the blast-furnaces, make the mould for the pig-iron, and tap out, <i>i.e.</i> , run off the molten iron when the furnace is full. The latter work may only be done with the sanction of the foreman.	LANDAUS	Carriages with the head made to open, so that the top covering may be thrown back.
KETTLE	A Scotch mining term for the basket or <i>hibble</i> which takes the place of a cage in shafts not provided with "guides" (<i>see</i> definition). It is like a half-barrel attached to the winding-rope.	LANDING	Conveying the coal from the barge, &c. in which it has been brought to its destination.
KIBBLING	A <i>hibble</i> is a small wooden tub usually square, of the capacity of about 20 gallons, used in conveying rubbish in a coal mine from one place to another, in stowing for instance. It is frequently made with a bow similar to a corf bow, and is used in sinking, <i>ie.</i> , making a vertical excavation in the strata. <i>Kibbling</i> , therefore, is the act of conveying rubbish in a <i>hibble</i> .	LANDINGS	Usually the top stone of a flight of steps, having a greater area than the step.
KIDDER-MINSTER CARPETS	<i>See</i> definition under "carpets."	LANDLORD CATTLE	Cattle belonging to Irish landlords boycotted by Land League tenants.
KIST	A chest or box in a mine in which the deputies keep under lock and key anything which they are likely to require whilst at work, and where they examine all lamps before the workmen go inbye.	LANDSALES	Coals sold at the pit's mouth or at a depot, and taken away in carts.
KNOBSTICKS	A <i>knobstick</i> is one who takes the work of an operative on strike, or refuses to go out on strike along with his fellow-workmen; in fact, another term for "blackleg." Workmen of various trades who are not members of a trades union are frequently called <i>knobsticks</i> by the unionist workmen. The term is also applied to men who work at a trade to which they served no apprenticeship.	LAPPEERS	Male operatives who fold into shape for the market the various fabrics that are manufactured in the textile industry.
KNOTS	Two separate threads twisted together; or the material that fills the hole in a brush, whether set with pitch, glue, or cement, as in looms.	LAP SYSTEM	Also called "trip system," is a system (in the carters' industry) of piece-work, <i>e.g.</i> , a driver taking loads of coal a given distance for a stated sum, works under the <i>lap system</i> .
KNOTTERS	Young females employed to cut the knots of yarn off the pieces before they undergo the processes of "milling" and "finishing."	LARGE BOATS	<i>See</i> definition of "deep sea tugs."
LABELLERS	Men, in the Royal Arsenal, who label ammunition cases.	LARGE COAL	<i>See</i> definition under "coal."
LABOURERS	The workmen in engineering works who do unskilled work generally.	LASCARS	Asiatic seamen, subjects of the British Indian Empire, as distinguished from Malays, Chinese, and others.
LACHES	A legal term expressing negligence or unreasonable delay.	LASHINGS	Ropes used to secure stages slung over a ship's side, or between ship and quay, when the ship is breasted off, to allow coal flats and barges to pass or work between. The stages are used for trucking cargo to and from the ship and quay, the distance in some cases being as much as 30 feet.
LADLE MEN	The men who attend to the large vessels for receiving steel, &c., in a molten state as it comes from the converter. (<i>See</i> definition of "converter men.")	LASTERS	Men in the boot industry who put the tops on the lasts, tack them to the insole (inner sole), and then, by means of rivets, pegs, or machine-sewing, tack on the outer sole in preparation for the next process, <i>viz.</i> , that of machining the soles on before the heels are attached. This term is mainly used in London and the South of England.
LAGGING BOILER	Covering a boiler in a steamship with some material to keep in the heat. In some cases asbestos is used, and this is itself	LASTING MACHINES	Machines which draw the uppers over the lasts or footshapes on which the boots are made; this is called <i>lasting</i> , and forms one part of the bottoming process.
		LASTING SHOES	Shoes of which the tops or upper parts are made from lasting, a woven worsted material.
		LATHE MEN	Brass finishers (<i>see</i> definition) employed solely in turning at the lathes and not engaged in fitting at the bench or vice.
		LATHER	The workman in the housebuilding industry who places and fixes the laths in position.
		LATHES	<i>Lathes</i> , or more properly <i>turning-lathes</i> , are machine tools, used in the shipbuilding and engineering industries, in which the metal work to be manipulated is caused to revolve against a fixed cutting tool, and the work is thus reduced to a cylindrical or other similar shape. The common

Term.	Definition.	Term.	Definition.
	<i>lathe</i> of the "turner" in wood (<i>see</i> definition) is called a "pole lathe."		has to be made for convenience of manufacture in several pieces. These pieces are called <i>lengths of shafting</i> .
LATHS - -	Strips of fir wood used for building purposes, nailed to joists, as foundation or ground for plaster work on ceilings, and in certain cases on partitions of apartments. They have to be bent or split into shape to follow the grain, not sawn; the men engaged in this industry of splitting wood into laths are termed <i>lath-renders</i> . In building specifications, for quality and safety laths are required to be (a) seasoned; (b) cut with the grain or fibre of the wood lengthwise and not crosswise, and they are so described in the specifications for most important buildings. A third requisite in these contracts is (c) freedom from knots and cracks. These three usual conditions preserve the superiority of English or British hand-split laths in the market.	LENGTHS OF TYPE } -	The expression <i>lengths of type</i> refers to the quantity of matter or type set; lines, columns, pages, &c. It is more frequently used in newspaper than in book offices. The dimensions are the measurements ascertained by the process of "casting up," that is, by taking the length and breadth of a page, and multiplying the one by the other. In newspapers the payment is by the hundred lines, the process of ascertaining the dimensions being the same.
LAUNCHES -	Here used to denote the temporary structural arrangements, principally composed of wood, resorted to in order to effect the launch of a ship built on a slip. (A. 24, 408.)	LESSOR - -	The landlord of a mine.
LAUNCHING INTO BERTH } -	To <i>launch into berth</i> is to place in position.	LETTER-PRESS PRINTING } -	<i>See</i> definition under "printers."
LAW OF HYPOTHEC } -	<i>Hypothec</i> , in the law of Scotland, is a security established by law in favour of a creditor over the property of his debtor; as in the case of a landlord for his rent. (Cf. 43 Vict. c. 12.)	LETTING - -	<i>See</i> definition of "setting."
LAY-BYES -	Places or wharves on the canals where boats are tied up, or <i>lay by</i> idle, waiting for orders, repairs, call, or transfer.	LEVELLERS -	<i>See</i> definition under "cokemen."
LAYING DECKS -	The operation of laying the wood, steel, or iron flooring upon the beams of the ship; forming the several platforms upon which the ship is worked and fought.	LEVELS - -	The local term in South Wales quarries for what some miners call <i>adits</i> , that is, drifts driven in the water-level direction of coal for the purpose of mining coal.
LAYING DOWN AND RAISING MOORINGS } -	<i>Laying down moorings</i> is putting the heavy anchors and chains, to which the ships are made fast, into position on the bottom of the harbour or river, as the case may be. <i>Raising moorings</i> is getting such anchors and chains up for repair or renewal.	LEVER-DRAW LOCKS } -	<i>See</i> definition under "locks."
LAYING ON THE MACHINES } -	In the printing industry, placing to marks (<i>see</i> definitions of "watching the marks" and "missing the sheet") on the printing machines the blank sheets of paper for an impression of the matter to be printed.	LIEN - -	A <i>lien upon slates</i> would consist in such an understanding or custom that a workman might refuse to consent to the removal of slates on which his wages had not been paid on account of the insolvency of the employer, in which case the <i>lien</i> would entitle the workman to require that such slates should not be removed till his claim was satisfied.
LAYING THE KEEL } -	In the shipbuilding industry the operation of preparing to the proper declivity the "blocks" upon which the ship is built, and fixing the keel thereon, is termed <i>laying the keel</i> .	LIFT-LOADERS -	The men who receive the loaded barrows of ore for the char-fillers and place them on the hoist table, whence they are conveyed by either steam or water power to the charger at the top of the blast-furnace.
LEADAGE - -	Distance that coal has to be conveyed from the mine to a sea-board or railway.	LIGHT CARGO -	Goods for transport where the capacity considerably exceeds the weight of 50 cubic feet measurement to the ton or over.
LEADING - -	Conveying coals by carts from the pits to the workmen's houses.	LIGHTER - -	To <i>lighter</i> here means to convey by means of <i>lighters</i> , <i>i.e.</i> , craft without masts or other rigging used for the transfer of goods from one dock to another. (C. 27, 613.)
LEADING MEN OF TRADES } -	The subordinate technical officers or foremen in the dockyard usually on day pay, whose duty it is to overlook a limited number of workmen (a gang), see that they are fully employed and provided with the necessary material and stores for the work they have to perform, <i>e.g.</i> , <i>leading men of riggers</i> .	LIGHTERAGE -	Transport of cargo by a <i>lighter</i> .
LE BLANC } -	The name given to the combination of processes by which carbonate of soda is made from "common salt" (<i>see</i> definition). Le Blanc, who discovered this process, was an eminent French chemist.	LIGHTERMEN ¹ -	The terms <i>lightermen</i> and <i>master lightermen</i> are here used in the sense of barge-owners on the Thames. (B. 20, 291-2, &c.)
LENGTHS OF SHAFTING } -	The shaft which connects the engine in the engine-room with the propeller, and from which the propeller gets its rotary motion,	LIGHTERMEN ² -	Men (in the London district) employed in handling and navigating <i>lighters</i> , or barges for the conveyance of cargo between the docks and wharves by the river. The navigation demands skill, and licences, based on full apprenticeship (that is, from five to seven years), are granted by the Watermen's Company. Other men employed to assist or move lighters within the docks, called "non-freemen" or "two years' men" (having had two years' apprenticeship), are also usually included under the term <i>lightermen</i> . The two branches have separate unions.
		LIGHTERS ¹ -	The ordinary name for clerks at the docks.
		LIGHTERS ² -	Craft built of wood or iron without masts or other rigging used (chiefly on the Thames), for the transfer of goods from one dock to another, for the conveyance of cargo, such as coal, and for other river purposes. <i>Lighters</i> are now things of the past, since none have been recently built: 30 or 40 years ago there were many on the river. A <i>lighter</i> is flat bottomed,




Term.	Definition.	Term.	Definition.
	and nearly oval in shape, while a "barge" is nearly square.		having his day off on Tuesday, and the fifth on Friday, having his day off on Wednesday. The first of the link would then re-commence with the 10-hour shift on Saturday after his holiday on Friday, and the others in turn, until they had all worked back to their original positions in five weeks.
LIGHT MONEY -	See definition under "money."	LINKERS -	Workers (females) of <i>links</i> , that is machines for joining or <i>linking</i> together the loops of fabrics. In some cases these machines are used almost entirely for the toes and heels of socks and stockings.
LIGHT PLATERS	See definition under "platers."	LINOTYPE SYSTEM } -	An ingenious American invention of type-setting by machinery. The machine is recommended on the ground of the double qualification of setting up types by a system of "matrices," (singular, "matrix," a mould for casting type) and then casting these into a solid block or line, hence, <i>linotype</i> . The linotype machine thus combines the duties of compositor and stereotyper in one. As the lines form they are passed on to a chamber and fall into position, until a column of matter is ready for the making up. The matrices are automatically returned to the position from which they started.
LIGHT RAIN WATER AND ORNAMENTAL GOODS }	<i>Light rain water work</i> is chiefly rhones (a Scotch expression for "rain water pipes," more correctly spelt <i>rone</i> , a middle English preterite of rain), and conductors, but also includes conductors for heating conservatories, halls churches, &c. The term <i>ornamental goods</i> embraces all kinds of railings, gates, pillars, and figure work.	LINSEED -	The seed of the flax plant, a vegetable product largely grown in India. The seed is imported for sowing and for crushing into the oil which is used by painters for mixing paints. The cake or refuse is a splendid food for cattle.
LIGHT SHEETS -	The very light (in weight) sheets of copper which have to be rolled out. Some of them are about 7 feet long, and 3 feet wide, and only weigh about 10 lbs. These sheets are most difficult to roll, and it is only the skilful and experienced men who can roll them. Notwithstanding the extra charge made for these light sheets, the roller man does not receive extra payment for working them.	LITHOGRAPHERS	Lithographic printers (see definition under "printers").
LIME -	The lime used in alkali works is a pure variety of the same material that builders use for preparing mortar, viz., calcareous earth (CaO, i.e., calcium and oxygen united chemically). "Dressed lime" is the fine powder used for making "bleaching powder" (see definitions), and is prepared from clot lime by slaking with water and passing through a sieve. "Slaked lime," Ca(OH) ₂ , is calcium hydroxide. "Quick" or "caustic lime" is what is left when limestone is heated with coal in kilns and carbonic acid is given off; it is a white caustic earth, chiefly used for cement.	LITHOGRAPHIC STONE }	A fine oolite or granular limestone used in lithography; good stone should be of a uniform yellowish grey hue, free from veins and spots, cut by a steel point with difficulty, and in splintering it should show a conchoidal fracture, i.e., a surface with curved elevations and depressions.
LIME HOUSE -	In the chemical industry the shed or house in which the lime is prepared for the powder chamber.	LITHOGRAPHY -	Lithographic printing (see definition under "printers").
LIME PUTTY -	Ordinary lime run through a fine sieve.	LITHO WORK -	Lithographic printing (see definition under "printers").
LIME ROCK -	A rock from which is procured limestone (i.e. calcareous spar, chalk, or other carbonate of lime) for building purposes and for burning into lime.	LITTLE MUSHES	Term applied to those in the cab-driving industry who drive their own vehicles.
LIMESTONE -	When mixed with iron-stone in a blast-furnace <i>limestone</i> separates the iron from the refuse.	LLOYDS -	<i>Lloyds</i> is a society formed from among the underwriters, shipowners, and others, established in London for the purpose of obtaining a faithful and accurate classification of the mercantile marine of the United Kingdom, and of the foreign vessels trading thereto. They publish a corrected register-book annually, for the use of subscribers, containing ample details respecting the character of ships, and these books are periodically posted up with the necessary alterations and changes. The affairs of the society are managed by a committee of 24 members. This managing body, elected from among the shipowners, underwriters, and subscribers to <i>Lloyds</i> to manage, in conjunction with a secretary, clerks, and outlying agents at seaports, the general business affairs of a mercantile marine, is termed the Committee of <i>Lloyds</i> . They receive notice of, and register in their books, all movements of vessels, arrivals, departures, accidents, &c.; and publish these each evening in a daily sheet, termed " <i>Lloyds' List</i> ," for the information of subscribers and the public. The business affairs of <i>Lloyds</i> occupy the upper part of the Royal Exchange, and include a reading-room, underwriters' room, captains' room, and suites of offices.
LIMMERS OR LIMBERS }	Shafts by which a horse or pony is attached to the tubs used in mines for carrying coal, and upon which sits a boy directing the cart.		
LINEN -	Cloth made from flax or tow.		
LINEN LAPPERS	Men who examine, measure, and fold the linen for the various markets. (Term used in the North of Ireland.)		
LINES -	The ropes used in moving vessels from place to place in docks, harbours, or elsewhere.		
LINK -	A <i>link of men</i> means any number of engine-men and guards running certain trains daily in turn. The system (termed the <i>link system</i> , <i>working links</i> , or <i>links of runs</i>) is usually worked where it is not practicable to give the men concerned regular duties each day. A link may consist, for example, of 5 drivers, and 5 firemen, the first of whom would work, say, 10 hours on Monday, 11 hours on Tuesday, 12 hours on Wednesday, and 13 hours on Thursday, and be off duty on Friday. The second driver and firemen would commence with the 10-hour shift on Tuesday, having Saturday off duty, the third on Wednesday, having his day off on Monday, the fourth on Thursday,		

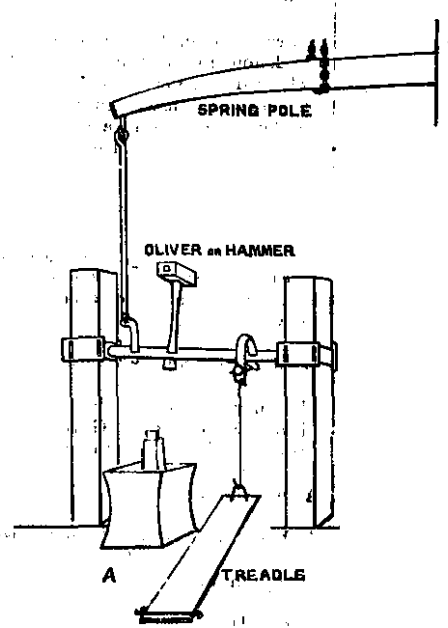
Term.	Definition.	Term.	Definition.
LLOYDS' SURVEYORS }	Practical engineers or skilled shipwrights with a thorough knowledge of shipbuilding employed by the Committee of Lloyds' Register of British and Foreign Shipping, to survey ships and their machinery which are classed or are to be classed in Lloyds' Register.	LONGITUDINALS	That portion of the frame of a ship which runs fore and aft, thus giving greater strength in the longest direction.
LOADERS -	Men loading manufactured slate (term used in North Wales quarries).	LONG-WALL	The system of working in a mine by which the whole of the coal is worked out in one working. The roof under this system is allowed to settle down behind the workmen as the coal is taken out. Close to the face the roof, or strata, is kept up by building squares (of about 8 feet in thickness) made of hard wood, and placed 8 or 4 feet apart. These props near the face are called "cogs" or chocks. At a greater distance packwalls, stone, and other refuse are employed. (See diagram I.)
LOADING-UP MEN }	Men at the docks who stop the bales from the cranes and pile them up on the trucks.	LOOMERS	Those who take the warp as it comes from the "taper," and prepare it for the loom.
LOADLINE	The draft to which a ship is authorised by law to be loaded, indicated by certain marks on the ship's side. These marks are measured from the upper deck, and are calculated at the rate of three inches for every foot of immersion. Thus, if the ship is drawing 20 feet of water the load-line will be at a distance of five feet from the deck.	LOOPS	Slings attached to the end of the ropes which formerly drew the corves to the pit-mouth of a coal mine. Persons ascending or descending the mine would place one leg through the loop, and thus sitting astride the corf, would be drawn up or lowered with it.
LOCAL MANAGER	In the Dinorwic quarries the <i>local manager</i> is resident at the quarries, being next in authority (at the quarries) to the directors and general manager. He is also the chief engineer, and has the general supervision of the quarries.	LOOSE WORK	See definition under "work."
LOCKER	A bench of wood, the whole width of the cabin, upon which a man can sit or lie down when he is in charge of a barge. On an average a <i>locker</i> is 10 feet long by 4 feet wide.	LOBBIES	See definition under "carts."
LOCKERS	Small cupboards provided for the stokers in which they can store their clothes, &c.	LUMPERS ¹	A term formerly used to denote stevedores and dockers indiscriminately, i.e., men who take contracts for loading and discharging by the <i>lump</i> , that is, piece-work.
LOCKING A FORM UP }	The process of <i>locking-up a form</i> (see definition) is the operation of wedging up the type when made up into page form, &c., in an iron frame or "chase" (see definition).	LUMPERS ²	Contractors; middlemen; sweaters.
LOOKS	<i>Box locks.</i> —Locks suitable for any kind of box or chest. <i>Cupboard locks.</i> —Locks suitable for any kind of cupboard to be fixed either on the right or left door. <i>Lever-draw locks.</i> —Locks suitable for any kind of drawer, but chiefly for those in a chest of drawers, and made with from one to eight levers in a lock. <i>6-inch Mortice locks.</i> —Locks in which the whole of the case or body of the lock is embedded in the door, the bolts only being seen. These locks are made from 4 to 8 inches, but the 6-inch is the usual size made. <i>Rimlocks.</i> —Locks in which the whole of the body of the lock is seen when screwed on to the door. Those for use in ships are made altogether of brass; those for the house doors are made of iron, Japanned black.	LUMP WORK	A system of work under which an employer offers a workman or mechanic a <i>lump sum</i> , without consideration of details, for the making of a complete article. <i>Piece-work</i> , on the other hand, is a system under which the workman agrees to make a complete article for a sum which he has calculated by minutely considering the costs of the various details.
LOOK TAIL	The entrance to the lower part of a river or canal lock.	MABON'S DAY	The whole of the coal miners of South Wales and of Monmouthshire decided to take a monthly holiday, which is termed Mr. Abraham's or Mabon's Monday, after Mr. W. Abraham, M.P., who is said to be the originator of it. The holiday, however, frequently extends over the greater part of the week; hence by coal owners and colliery managers this week is termed Mabon's week.
LOCOMOTIVE DRIVERS }	See definition under "drivers."	MACADAM STONE	Broken granite or the hard stone used in making or repairing roadways as introduced by Mr. Macadam.
LOCOMOTIVE ENGINE }	See definition under "engines."	MACHINE CHAPEL }	See definition under "father of the chapel."
LOGGING OFFENCES }	The entering (by shipmasters pursuant to sections 280-7, Merchant Shipping Act, 1854) in the "official log" of British vessels of offences committed by members of the crew.	MACHINE DRILLERS }	See definition of "drillers ² ."
LOGS	Pieces of wood of which the bark has been stripped and the sides squared.	MACHINE JOINERS }	Workmen employed in the construction of cotton, silk, flax, or woollen machinery. In the construction of looms, spinning frames, and other textile machinery, a portion is made of wood, and this necessitates the employment of a joiner who has also some knowledge of that kind of machinery.
LONG-DAY MEN	Cab-drivers who work two horses, their time averaging 15 hours per day. Their time of starting varies from 7.30 a.m. (the earliest comer) to 2 p.m. (the latest arrival).	MACHINE-MADE BRICKS }	Bricks made solely by machinery. The clay is ground, forced through a mould, and cut off by a wire-cutter (steam power) 10 bricks at each stroke.
		MACHINE-MADE NAILS }	See definition under "nails."
		MACHINE-MEN ¹	Workmen employed upon planing, shaping, slotting, drilling, and other machines distinct from lathes. They are sometimes termed machinists.

Term.	Definition.	Term.	Definition.
MACHINE-MEN ²	(a.) Those who have the charge of printing machines in any printing office. (b.) The term <i>machine men</i> is applied to the men who have charge of paper-making machines. (c.) In the gas making industry <i>machine men</i> are those in charge of machines. (d.) In the building industry <i>machine men</i> are those in charge of joiner's machines.	MAKING SMALL	The process of extracting the dust from the coal before it is delivered to the consumers. This is done by screening, and the men are paid for all the small coal which passes through the screens.
MACHINE MINDERS }	Men who are in charge of printing machines	MAKING UP	A term used in the printing trade to denote the putting together of a certain number of lines to form a "page," with head lines and folios.
MACHINES	Contracted term for "drilling-machines," such as:— <i>Pneumatic</i> , i.e., one driven by means of compressed air: <i>Hydraulic</i> , i.e., one driven by means of water, and others driven by hand or steam to make holes in coal or stone.	MALINGERING	Feigning or protracting illness in order (in this case) to obtain payments or the continuance of payments from sick funds.
MACHINE SEPTING }	See definition under "hand-setting."	MALLEABLE HOB-NAILS }	See definition under "nails."
MACHINE WORKERS }	See definition of "planers" and include workmen who attend "lathes" (see definition), boring machines, &c., used in the construction of engines and portions of ships.	MALLEABLE IRON }	See definition under "iron."
MACHINISTS ¹	Workmen in charge of machine tools.	MANGLE WORKERS }	The attendants at the mangles used for finishing jute and linen fabrics.
MACHINISTS ²	In the <i>boot</i> industry the persons who sew together by a machine the uppers of the boots after their several parts have been put together by the "fitter."	MANNING SCALE	A scale which fixes the minimum number of seamen to be employed on a vessel.
MACHINISTS ³	In the <i>straw</i> industry the persons (usually females) who sew the "plait" into hats or bonnets by means of specially constructed sewing-machines are called <i>machinists</i> , but those who sew or fabricate the plait by hand are called <i>sewers</i> .	MAN-ROPES	Ropes on board ship to prevent accidents. They are sometimes drawn through iron stanchions on the vessel's gunwale. On the Mersey, <i>man-ropes</i> are used for the double purpose of protecting the sailors, and acting as a safeguard to prevent the bales of cotton (carried on the decks, eight lengths on each side) falling overboard.
MAGAZINE CARTRIDGES }	Cartridges for the magazine rifle, i.e., a repeating rifle capable of being loaded with as many as six cartridges.	MARINE ENGINEERING }	<i>Marine engineering</i> as distinguished from "shipbuilding" (see definition) is the construction of the main engines and boilers for propelling a steamship; also the construction of the auxiliary steam machinery used for such purposes as pumping, &c., where the work was originally done by manual labour on board a ship. <i>Marine engineers</i> are those working at the production of engines as above, that is, at marine engineering. <i>Sea-going engineers</i> are those in charge of such engines when at sea on board steamships.
MAGAZINE WORK }	Printing work paid by the 100 lines.	MARINE MOULDING }	<i>Marine moulding</i> embraces all the practical engine work connected with the moulding of various parts of machinery used on ships.
MAIN HATCH	See definition under "hatch."	MARINE TRADE AND WORK }	The work performed in the engineering department of a shipbuilding yard.
MAIN ROAD WORK }	Scotch term synonymous with the term "putting" (see definition of "putters") used in the North of England.	MARKERS OUT	Leading hands in the shipbuilding industry, such as "fitters" (see definition), who mark out the work in the rough before it goes to the machine.
MAINS	Cast-iron pipes laid in the streets for the conveyance of the gas.	MARQUETERIE WORK }	See definition under "work."
MAINSAIL	The largest square sail in a ship, and the lowest sail on the after side on the main-mast. In a barge or fore and aft vessel it is the sail set on the after part of the mast, and hoisted and set by means of spars and booms. (See diagrams XV. and XVI.)	MARROW	Term applied by a Durham or Northumberland miner to denote his "mate," fellow workman, or partner.
MAJOLICA PAINTRESSES }	<i>Majolica painters</i> are women in the potting industry who paint ware in various colours. These colours are mixed very largely with lead all in a liquid state, and children and young girls are chiefly employed in the operation of mixing.	MARSHALLING YARDS }	Yards belonging to railway companies where goods and mineral waggons are arranged into trains for despatch to their respective destinations.
MAKERS	The workmen who receive the tops and then complete the making of hand-sewn boots and shoes. The term is also applied to those who <i>make</i> the bottom (with the exception of the finishing) of a rivetted or machine-made boot.	MARTINI HENRY CARTRIDGES }	Cartridges for the Martini-Henry rifle, i.e., a rifle capable of being loaded with two cartridges only.
MAKER-UP	After the bodies and parts of Britannia metal goods have been shaped by the stamping process or produced on a spinning lathe, the <i>maker-up</i> puts them together, completing the structural process and making the article.	MASONS	Artisans who prepare and fix all stone required in the building trade; the term is usually applied indiscriminately to both builders and hewers. (See definitions.)
		MASTER RIGGERS	For administrative purposes the dockyards are divided into departments. The riggers' department comprises—in order of responsibility—the "staff-captain" (the head

Term.	Definition.	Term.	Definition.
	or senior officer of the whole department, a naval officer of the navigating class), the <i>master rigger</i> (a chief "boatswain" of the Royal Navy), the "leading men," the "chargemen," and the "riggers" (<i>see definitions</i>). Thus working riggers can rise only to the position of leading men.	METAYER SYSTEM }	A system applying to the sugar industry in the West Indies, where the landowner supplies the land and the crushing machinery, and the labourer works it and pays rent in the form of perhaps 50 per cent. of the manufactured article. <i>Also defined as the system of a land-tenure in Tuscany, under which rent is not paid by the farmer to the landlord, but the landowner prepares and equips and, in a great measure, stocks the farm, the tenant being free to exercise his own discretion in working. The produce is sold for joint account, the gross result being divided in a proportion primarily agreed upon.</i>
MASTER'S MAN -	A man in the carters' trade who will extract as much work as possible out of both horses and men for 16 or 18 hours per day that he may secure the favour of his employer, who, in many instances, does not know how many hours his horses and men are at work.	MIDDEN -	An ash-pit and water-closet combined. (There are but few of the latter, it is alleged, in the factories in Sheffield.)
MASTERS OF TRADES }	This term is here used to convey the meaning that the workmen thus designated are tradesmen-mechanics in contra-distinction to a labourer, i.e., a man who has not learned any particular trade. (A. 25,811.)	MILES MEN -	Term synonymous with "surface men ² " (<i>see definition</i>).
MASTING AND DISMASTING }	<i>Masting</i> is the operation of putting a ship's lower (or bottom) masts into her; <i>dismasting</i> is the reverse operation.	MILK OF LIME	Water and lime mixed in proportion as necessary for putting in oxidisers with the liquor containing the unused manganese. It is generally made with "riddlings" (<i>see definition</i>) from the lime house, if there are any.
MATE -	The duties of a mate on canal boats and on tug boats are to assist the captain in the navigation of the vessel, and to take the captain's place in emergencies and when he is off duty for rest, &c.	MILLMEN -	Men employed in the finishing departments of iron and steel works.
MELTING SHOP AND PLANT }	The furnaces used in the melting and converting of iron into steel and the producers for the making of gas for such furnaces, i.e., the cranes, moulds, and other machinery used in converting the molten metal into "steel ingots" (<i>see definition</i>).	MILLNER -	The person engaged in milling, i.e., scouring or washing the cloth after it has come from the loom.
MEMBERS -	The <i>affiliated members</i> are those who merely subscribe to the early closing object and funds of the <i>Scottish Shopkeepers and Assistants' Union</i> . The <i>full members of the Scottish Shopkeepers and Assistants' Union</i> are those who contribute towards the sick benefit funds of the union; a proportion of their contributions is also allocated to the early closing fund. The <i>honorary members</i> contribute from 10s. per annum, or from 5l. at one time. Their contributions are allocated at the discretion of the directors. Up to the present (May 1898) the larger proportion has gone to the sick benefit fund.	MILLS¹ -	Double-headed hammers, weighing from 4 to 6 lbs., used for driving a wedge into the coal when bringing it down by wedging. Equivalent to the Cornish term "malls" or "mallets."
MENDERS -	Females who examine steam-made hosiery of all descriptions before it is sent to customers, and who repair any small defects in manufacturing, such as the accidental cuts produced in articles by the pressure of the steam-machine.	MILLS² -	<i>Bar mills.</i> —Mills in which the frames for ships and girders for bridges are finished. <i>Guide mills.</i> —The mills in which is finished small merchant iron, such as round, rivet, and steel rails, and other small sections of steel bars used for various purposes. <i>18-inch mills.</i> —The same as "bar mills" (<i>see definition</i>). <i>Nail-mills.</i> —Mills or works where nails are produced. <i>Plate mills.</i> —Mills in which plates for boilers and ships are finished and made ready for use.
MENDING -	Replacing (in woven worsted-coating pieces) threads of warp or of weft dropped by the weaver, a process akin to "burling."	MILL SAWYERS	Sawyers who cut wood by the use of circular or other saws driven by steam or other power.
METAL CARRIERS }	Those who take the pig-iron out of the troughs of sand into which it has been placed to cool, and stack it on the trucks used in conveying it away for sale.	MILL WORK -	<i>See definition under "work."</i>
METALLIC PROCESSES }	The various processes of the manufacture of lead which in a metallic state, such as the de-silverising process, the manufacture of sheet lead, and the various kinds of lead pipe, &c., are termed <i>metallic processes</i> . The term is here used to distinguish the men working at these processes from those working at lead after it is made into a pigment, such as red, orange, and white lead. (C. 21,738, 21,775.)	MILLWRIGHTS -	A now almost obsolete class of all-round mechanics who could do anything in either the iron or the wood work required in the fitting up or construction of a mill or factory. <i>Millwrights</i> are now generally engaged in doing any repairs to machinery and plant that may be required from time to time.
METALLING -	In the printing industry laying sheets of Dutch metal on to printed work chiefly for the purpose of its being embossed or raised up, and so giving it a better appearance.	MINDERS¹ -	<i>Back minders.</i> —Women who stand at the back of a drawing frame. Behind them is a row of "caus" holding "slivers," which the women "draw" and double on the frame to get a new sliver uniform in thickness. <i>Front minders.</i> —Women at middle drawings who "tramp the can" (<i>see definition of "can"</i>).
METAL PLANERS	<i>See definition of "planers."</i>	MINDERS² -	Young persons who <i>mind</i> the "condensers."
		MINE AND COKE FILLERS }	The men who fill the <i>mine</i> (ironstone or iron-ore) and <i>coke</i> into barrows, and draw the loaded barrows to the lift. (<i>See definition of "char-fillers."</i>)

Term.	Definition.	Term.	Definition.
MISSING THE SHEET	Failing to lay the sheet true to the marks on a printing machine. This results in a miss and causes delay, since it will be necessary to "run waste" to remove the ink, which ought to have gone on the sheet, from the cylinder.		
MODELLERS	The men in the plastering industry who model from the designs, the plasterers making the moulds from such models.		
MOHAIR	<i>Turkish and Van Mohair</i> .—The hair of the Angora goat, a native of Asia Minor. It is of a white silvery appearance, and very little is produced in colours. The Angora goat has been imported into the Cape Colony, and the annual produce there now equals in quantity and quality that of Asia Minor. This wool is largely used in the manufacture of goods for ladies' wear, braid-working, furniture-cloths, velvets, &c.		
MONEY	<p><i>Aliment money</i>.—Money paid by trades unions to men locked out or on strike.</p> <p><i>Awkward money</i>.—A special allowance per ton made to dockers unloading ships when the bunker holds are very awkward, and thus prevent the men from earning the same wages that could be got by working in the main-holds.</p> <p><i>Back money</i>.—A term used locally (in reference to the Southport tailors' dispute) to indicate the money retained by the employer owing to a doubt as to whether the men were entitled to it, until the question was settled by arbitration. (C. 15,338.)</p> <p><i>Blood money</i>.—In America and many Australian ports boarding masters offer to obtain crews for captains on condition that they give them (say) 60 dollars for each man procured. This is called "blood money," and is sometimes divided between the captain and the boarding master.</p> <p><i>Charge money</i>.—An additional fixed, extra amount paid per day to "chargemen" (see definition) according to their responsibility.</p> <p><i>Clear money</i>.—Term used in the fishing industry to denote those earnings which are left after deducting all other than stage expenses from the nett (that is, the remainder on deducting the pontoon expenses from the gross takings).</p> <p><i>Contingent money</i>.—The remainder or plus paid to workmen under the "plus system" on the completion of the contract.</p> <p><i>Dark money</i>.—Wages paid at the docks for work during overtime, which is usually during darkness.</p> <p><i>Driving money</i>.—The money (1s. per day) paid to the carmen in the coal trade for feeding and grooming their horses.</p> <p><i>Dusty money</i>.—A special allowance per quarter made when the corn to be unloaded at docks is dusty, thus presenting greater difficulty and causing more labour to the workmen, with less pay.</p> <p><i>Exertion money</i>.—The additional earnings received under a system (at one time adopted in the dockyards) of giving a small percentage (i.e., ten per cent.) or bonus to preserve industry and stimulate to extra effort during any emergency.</p> <p><i>Good-time money</i>.—A weekly bonus given to stokers who do not absent themselves from their work without leave. It was introduced to check the tendency to waste the day after pay day in drunkenness.</p> <p><i>Grinding money</i>.—The money paid in the barge-building industry for the time allowed for sharpening tools on leaving a job.</p> <p><i>Heavy money</i>.—Wages paid at the docks for working heavy grain, such as wheat, maize, and barley, as distinguished from light grain, such as oats.</p> <p><i>Hot money</i>.—A special allowance per quarter made when the corn to be unloaded at docks is extra hot.</p>		<p><i>Light money</i>.—Wages paid at the docks for work during daylight.</p> <p><i>Shifting money</i>.—Money paid by a union to its unemployed members to assist them in removing to a place where they have found work, at the rate of 5s. for the first mile and 1s. per mile for every additional mile up to 36. It was formerly paid to a workman, leaving one colliery for another, by the company to whose colliery he was removing in lieu of being removed by their carts, but it was abolished some time since.</p> <p><i>Smart money</i>.—An allowance, sometimes in the form of a weekly payment, made by employers to "hewers" who are injured whilst following their employment in the mine.</p> <p><i>Sponging money</i>.—Money allowed by master bakers to their men for "setting the sponge" (see definition), an operation which has to be done in the middle of the day, thus breaking into the time for rest.</p> <p><i>Subsistence money</i>.—A certain proportion of wages, equal to what one day's wages would be under the ordinary rate, i.e., 6d. per hour, paid every day under the plus system.</p> <p><i>Team money</i>.—Extra money paid to horse-keepers for turning out horses on Sunday. The rate in Manchester is a penny for every horse turned out. (B. 23,894.)</p> <p><i>Tonnage money</i>.—Wages paid according to the "tonnage system" (see definition).</p> <p><i>Trip money</i>.—A term used on canals to mean a payment in addition to tonnage; a bonus given in addition to wages as an inducement to extra energy.</p> <p><i>Under money</i>.—Wages at a less rate than "full money," which is the highest amount paid to ship-joiners.</p> <p><i>Walking money</i>.—A payment made to the labourers at the docks (ship-building) to compensate for the time lost in walking to docks which are situated at some distance from the shipyard.</p> <p><i>Wood money</i>.—Some yards in the barge-building industry allow the men to take home chips and small pieces of wood; others allow 2d. per day in lieu of wood; this is termed <i>wood money</i>.</p> <p><i>Yard money</i>.—Sometimes termed "ha'pence"; daily fees paid by cab-drivers to horsekeepers and to cab-washers for their services.</p>
		MONKEY BOAT	A small canal boat about 65 feet long, 6 feet 6 inches wide, and 3 feet deep, capable only of carrying between 20 and 35 tons on the narrow shallow canals in the Midland counties. At one end is a cabin of about 220 cubic feet of space forming the home of the workers, who frequently consist of man, wife, and several children.
		MOORING CHAINS	Chains at the bottom of the harbour with anchors for the ships to moor to.
		MOORINGS	See definition under "outport moorings."
		MOORING WORK	See definition under "work."
		MORNING AND EVENING MEN	Men driving either a four-wheel or a hansom cab, from about 9 a.m. till 8 p.m.
		MORTICE LOCKS (6-INCH)	See definition under "locks."
		MOULDERS	Skilled workmen in the brass industry, engaged in making moulds with sand from models or patterns, and pouring molten brass, gun-metal, or other alloys, into such moulds, thus producing repetitions (technically known as "castings"; see definition) of the models or patterns. The castings are then finished off by the "brass finisher" (see definition) or another workman, according to the class of work for which it is intended.

Term.	Definition.	Term.	Definition.
MOULDERS*	Men in the seed-crushing industry who draw the rolled seed from the fixture wherein it is made hot, and, after equalising the seed over a cloth, subject it to a slight pressure. <i>Moulders</i> are only required on the American system.	NAIL MASTERS -	Dealers in nails who travel over several counties buying and selling stock. In this respect nail masters are distinguished from "foggers" (see definition), who are local buyers only and usually confine their speculations to the purchase of nails brought to their shops by the workpeople themselves.
MOULDING-BED	An enclosed space in front of a blast furnace filled with sand, into which the molten pig-iron is run.	NAIL MILLS -	See definition under "mills."
MOULDINGS	Ornamental portions of wood, plaster, stone, or other materials used in the construction and decoration of buildings. <i>Mouldings</i> are also in use in the furniture trade, and are placed round the angles of a chest of drawers or panels of doors, &c. Thus  is called an O. G. or <i>Ogee</i> ;  an <i>Oval</i> ; and  a <i>thumb</i> moulding.	NAILS -	<i>Clout nails.</i> —These nails are of various kinds. <i>Town clouts</i> are of wrought iron and are countersunk (that is, they taper) under the head; they are used for nailing down plates of iron. Nails used for nailing on roof slates are of malleable iron. There are also <i>fine clouts</i> and <i>strong clouts</i> , both of which kinds are wrought. <i>Clout nails</i> are being rapidly superseded by "wire nails." <i>Cut nails.</i> —Machine-made nails cut from hoop iron, the iron being rolled out to the thickness required for the nails. <i>Hand-made nails.</i> —All nails forged (hammered out) by girls, youths, women, or men, with the help of hand hammers, and in some cases (for large-sized nails) of the "oliver" (see definition and diagram). Hand-made nails have no marks to distinguish them from machine-made nails, and often only experts can tell the make. <i>Hob-nails.</i> —Short hand-made nails with large strong heads; the larger sizes are used for shoeing horses and the smaller sizes for the bottoms of heavy boots and shoes. <i>Machine-made nails.</i> —All nails made entirely by machinery and used chiefly in building, ship-building, &c. This term embraces many varieties, such as wire nails, cut nails, &c. <i>Malleable hob-nails (or cast nails).</i> —Hob-nails (see definition) cast in sand from malleable iron, that is iron which may be extended by heating. Only experts can distinguish between the hand-made hob-nails and the malleable ones. <i>Rose nails.</i> —A class of "hand-made nails." <i>Wire nails.</i> —Nails made from hard iron wire, and now extensively used, superseding the hand-made nail imported from Germany. <i>Wrought nails.</i> —The term <i>wrought nails</i> is usually applied to all hand-made nails, but there is a class of machine-made nails called "patent wrought nails."
MOULDING } SHELLS }	The operation of making the sand moulds for casting shells.	NAP -	The downy or hairy surface of the cotton yarn, formed by the projecting ends of the cotton filaments. A cross-section of a thread of cotton yarn may contain from 90 to 390 filaments, which are very sensitive to electrical conditions, hence the importance of means to make them lie as smooth as possible, otherwise they polarise in all directions, that is "stare."
MOULDS (PROCESS OF DRYING) }	All small moulds are dried in specially built stoves. The moulds are placed, by means of a crane, upon carriages which run on rails into the stove and remain enclosed there whilst the moulds are drying. The <i>moulder</i> , after the time allowed for drying has elapsed, opens the door, draws the carriage out, and by means of the crane removes the moulds. Large moulds are made in what is technically called a "pit" in the "moulding shop." When a mould is finished it is covered over by bars and plates, and the pit is banked round with coal (possibly with tons of coal, the quantity varying with the size of mould). The fires then lit are kept burning for several days by the addition of fresh coal until the mould is dried.	NEUTRALISERS -	Men in the chemical industry engaged in a special department of the bleaching plant where acids are neutralised by the addition of ground limestone.
MOULDS -	A profile or shape composed of plaster of Paris from which articles of pottery are made or moulded.	NEW AND OLD WORK }	All work required in the construction of ships, engines, machinery, or other work appertaining to the engineering trade, or work required for a complete renewal of the same, e.g., converting old engines, supplying new engines to old ships, &c., is classed as new work. It is the work usually performed in private shipyards by "shipwrights" (see definition) or ship-carpenters. By <i>old work</i> is intended all jobs executed by the same class of men when employed on repairs to old ships. Similarly, in dockyards the application of the terms <i>new</i> and <i>old work</i> would be determined by ascertaining whether the work, to which it was desired to apply them, was executed on a new ship building or an old ship repairing.
MOUTH-PIECES -	Castings fixed on the open ends of "retorts" (see definition) to which the lids or doors are attached. The term is also applied to the pipes conveying the gas from the retorts.		
MOUTHS -	Fireholes all round the ovens used in the potting industry.		
MUCK BAR	<i>Muck bar-iron</i> is nothing more or less than "puddled bars." The expression is believed to have originated in Wales, where they were accustomed to put any sort of "muck" into the puddling furnaces. The expression is, however, still retained in America.		
MUD PLUNGERS	Men in the chemical industry engaged at bleach plant in stirring up the sediment from manganese and acid to extract the gas.		
MUNGO -	Raw material which is ground from rags.		
MUSHROOM-MEN	Men, having very little or no capital, who hire looms and start to compete in the cotton industry, on the principle that they have all to gain and nothing to lose.		
MUTATIS MUTANDIS }	With the necessary changes in points of detail.		

Term.	Definition.	Term.	Definition.
NEWSPAPER MEN	The term <i>newspaper men</i> comprises all those who are engaged in the case-room and reading-room of a newspaper, whether foremen, sub-foremen, 'stab, or piece-hands.	OIL CRUSHERS	Another term for "seed crushers" (<i>see</i> definition), <i>i.e.</i> , persons engaged in the extraction of oil by machinery from oleaginous seeds, <i>e.g.</i> , cotton seed, linseed, rape seed, &c. (<i>see</i> definitions).
NEW ZINC PROCESS	A process of de-silverising by which a large quantity of lead is melted in a pot, and about 5 per cent. of zinc added; the silver separates from the lead and combines with the zinc. This forms as a crust on the surface and is removed, the zinc being next eliminated by distillation in retorts. Zinc is a bluish white metal of crystalline structure which when heated can be easily rolled or hammered out.	OIL MILLERS	The term <i>oil millers</i> is generally used in reference to the men employed in the seed crushing industry in distinction to the masters.
NIGHT MEN	Men driving cabs from 9 p.m. till 7 a.m.	OIL-STONE	An oblong slab of a kind of hone slate (<i>i.e.</i> , of a fine grain) or similar substance which is lubricated with oil, and is used for putting a keen edge to tools after they have been ground at the "grindstone" (<i>see</i> definition). There are two varieties of <i>oil-stone</i> , black and white, imported from Turkey.
NIGHT SHIFT	<i>See</i> definition under "shift systems."	OIL TANK STEAMERS	Sea-going steamships specially designed and constructed for carrying petroleum in bulk instead of in casks.
NIPPER	A boy who attends stone-cutters and masons; he is also called a "tool-boy" as he is principally engaged in pointing tools.	OLD PATTINSON PROCESS	A process of de-silverising; nine or more pots are placed in a row, the lead containing the silver is placed into, say No. 5 pot, a fire is lit under the pot and the lead is thoroughly melted. The fire is then drawn and the lead allowed to cool. When it begins to crystallise on the top and round the edges of the pot it is turned into No. 4 pot (which thus has now about two-thirds of the contents of No. 5 pot) by means of perforated ladles. The remainder, consisting of enriched lead, is turned into No. 6 on the right, and so on. This process is falling into disuse in the Tyneside district, since 10 men can de-silverise as much lead in 12 hours by the "zinc process" (<i>see</i> definition) as 100 could by the Pattinson process.
NITRIC ACID	A strongly fuming liquid (HNO_3), colourless when pure, but usually slightly yellow, prepared from nitrates of potash and soda, popularly called <i>aqua fortis</i> .	OLIVER	A small lift-hammer (<i>i.e.</i> , a large iron hammer) worked by the foot by means of a treadle and a spring pole. The hammer varies in weight from about 60 lbs. to 50 lbs. It is used to assist the operator in the nail industry in work of a nature too heavy for a hand hammer, <i>e.g.</i> , for the purpose of heading bolts, nails, &c., which are at the same time being worked upon by another hammer in the hand.
No. 1. CAUSTIC WRAK LIQUOR MEN	<i>See</i> definition under "caustic."	<p>SKETCH OF OLIVER, used in the manufacture of hand-made nails and chains.</p> 	
Nos. 1 and 2 CAUSTIC FINISHERS	<i>See</i> definition under "caustic."		
No. 3 FOUNDRY FIG IRON	<i>See</i> definition under "iron."		
NON-FREEMEN	<i>See</i> explanation under "lightermen" and "watchmen."		
NON-LETS	A term in common use in the cab trade to signify working cabs for which horses, harness, &c. are provided, but which are left at home, unlet, or not hired, by the driver; and consequently the day's hire is lost to the proprietor.		
NURSING	The <i>nursing system</i> is a system adopted by the 'buses of one company to drive off the road those of a rival company. The competitive 'buses place themselves one in front, one behind, and one at the side of a rival 'bus, and as far as possible remain in the same positions the whole length of the route, thus effectually preventing the rival 'bus from obtaining any passengers. This is called <i>nursing</i> , a term peculiar to London.		
OCEAN TRAMPS OR TRAMP STEAMERS	A nautical term applied to all seagoing steamships (outside the regular liners, <i>i.e.</i> , not confined to one particular trade) which earn their freight solely by cargo-carrying to all or any parts of the world. Such vessels are those in the coal trade on the Baltic, Mediterranean, and Black Seas, and in the Spanish and other ore trades.		
OFF-HAND MEN	This term comprises firemen, roadmen, brushers, drivers, stablemen, runners, bottomers, stonemen, shifters, tub-loaders, &c., who are paid a certain fixed rate of wages either per day or per hour, but not a rate per ton. Such men are frequently termed in Scotland "oncot men" and in England "dotal men." Briefly <i>off-hand men</i> are all colliery workmen except "hevers" and "putters."		
OFF-HAND SHIFT	<i>See</i> definition under "shift systems."		
OFF-TAKES	All deductions retained from the men's wages for house-rent, house-coal, doctor's fees, tool-sharpening, closed lights, &c. This term does not include deductions for "dirty filling," &c.		

A, The workman stands here and work the treadle with his right foot when using the Oliver.

Term.	Definition.	Term.	Definition.
ONCOST LABOUR	Enginemmen, labourers, and others working for a fixed rate of wages, per day, or per hour (such as foremen), &c., who must be paid although only half the furnaces may be working.	OVERSMEN	Foremen or overlookers in the second degree.
ONCOST MEN	Scotch term equivalent to the English term "datal" or "day's-wage" men, which means all men who are paid a certain fixed rate of wages either per day or per hour, but not a rate per ton, comprising firemen, roadmen, brushers, drivers, stablemen, runners, bottomers, &c.	OXIDISERS	In the chemical industry tall tanks into which the unused manganese (see under definition of "chlorine") held in solution is run and subjected to blast from an engine fan to retain it for future use in making chlorine gas.
ONSETTERS	Men and their assistants who push the full tubs of coal in and remove the empty tubs out of the cage at the bottom of the winding shaft, or at any other intermediate landing or stopping-place. They also give to the enginemmen the necessary signals for the removing of the cage.	PACKERS ¹	Men in the chemical industry engaged in "packing bleaching powder" (see definition), the work necessitating the wearing of muzzles to prevent suffocation.
OPEN HEARTH STEEL	Steel made in an open-hearth furnace—a system introduced by Sir William Siemens (see definition of "processes in steel making").	PACKERS ²	Laths (see definition) used for packing calicoes in bales.
OPEN HOOK	See definition under "hook."	PACKERS ³	Men in warehouses engaged in the packing department solely in packing goods.
ORDINARY SHARES	See definition of "debenture shares."	PACKING BLEACHING POWDER	Packing bleaching powder consists in filling into casks the bleaching powder lying on the floor of the bleaching powder chamber.
ORIGINAL PACKAGES	The same packages that are put on board the ship at the port of loading, such as grain, &c., in merchant's bags and not in ship's bags under the Grain Act.	PACKING DEPARTMENTS	The departments in which the finished chloride of lime or bleaching powder is put into casks for shipment and the market.
ORLOP-DECK	The deck next above the keel; the lowest deck inside a vessel. (See diagram X.)	PADDLE	In the copper industry the paddle is used by the plate-furnace men for the purpose of putting the plates into the furnace, since they must be placed in such a way that each plate will be properly heated through. The paddle is about 8 feet long and has a flat end on which to lay the plate.
O.S.	An abbreviation for "ordinary seaman."	PAINTERS ¹	In the shipbuilding industry painters are workmen who have served an apprenticeship employed in painting ships both outside and inside, that is, the holds, cabins, masts, and sides.
OUTCROPS	Seams or veins of coal appearing on the surface.	PAINTERS ²	In the coach trade those whose work consists exclusively of painting coaches.
OUTLET STACK	In an acid works there are two classes of stacks or chimneys. By the one draught is obtained to draw the gas or sulphur through the chambers and towers, by the other waste gas passes into the open air. The latter is called the outlet stack.	PAIR OF STANDARDS	Two standards, i.e., two wooden legs with feet, which are often used instead of four legs to support the top frame of a table.
OUTPORT MOORINGS	Moorings are buoys in a harbour, securely anchored for the convenience of ships to make fast to. Outport Moorings are Admiralty moorings at any other place than the dockyard ports.	PAIR OF TIMBER	Two timbers placed against the sides of the tunnels in a mine at acute angles with the bottom. They support not only these sides but also another timber, which upholds the roof, hence the importance that the pair of timber should, in the first instance, be firmly and carefully fixed. (See following diagram.)
OUTPORTS	A term used in Her Majesty's Dockyards to denote any port other than the one in which the particular dockyard in question is situated; used generally to denote a harbour some distance away from the seat of trade, a port away from the chief custom house.		
OUTSIDE PLATERS	See definition under "platers."		
OUTSIDE SHOPS	The phrase <i>outside shops</i> is a Birmingham local expression of contempt for those employers and shopkeepers who do not pay overtime.		
OUTWORK	See definition under "work."		
OVERHAUL	The survey made by the Board of Trade inspector or other Government Official when a ship is about to undergo repairs.		
OVERHEAD PRICE	A sub-contract.		
OVERLAP	A break in a seam of coal pushing one portion over the top of another. (See diagram V.)		
OVERLOOKER AND SUB-OVERLOOKER	In the Dinorwic quarries an <i>overlooker</i> is next below in grade to the "bargain letter" (see definition), and with the assistance of a competent staff has charge of a department.		
		PALM	A leather protection for the hand, used in sail-making and canvas sewing, having fixed to it an iron thimble.
		PANEL	(a) Here means the sheriff's list of persons summoned to act as jurors at a particular sitting. (C. 30,459.) The word <i>panel</i> also means (b) the list of special jurors returned for the trial of a particular action after the process of nominating and reducing; and (c) the person accused in a criminal court.
		PAN MEN	Men in the chemical industry engaged in boiling down the liquor obtained from black ash.

Term.	Definition.	Term.	Definition.
PAN SMITHS	Men whose occupation is very nearly the same as that of the boiler makers. They are employed in making and repairing the iron salt-pans.		
PANTILES	Term used to express the hardness of old sea biscuits ground into meal and then re-baked.		
PAPER SHIP	A ship built of inferior material and badly put together.	PER LAST	Per 10 quarters of grain of any description.
PASS-BY	An underground bye or siding where the hutches pass one another.	PERMANENT- WAY MEN	Workmen employed in repairs of the tramway lines and in paving.
PATTERN MAKERS	A highly skilled class of workmen in shipbuilding and engineering industries who model and shape patterns in wood, from which castings in iron, steel, brass, copper, or other metal, are taken, or from which duplicates are copied or moulded. None of the work of a <i>pattern maker</i> is a finished production, since it is the original from which a copy is made to form the basis of a finished article.	PER PACK	(Wool weight) = 240 lbs.
PATTERNS	Wooden constructions used in shipbuilding and engineering, made the exact size, shape, &c., that the casting is required to be.	PER THOUSAND ENS	A standard by which compositors' wages are fixed. An "em" quadrat is the blank space calculated to represent the average thickness of all the letters of the alphabet between printed sentences—thus □ a square piece of metal the depth of the type. An "en" quadrat is exactly half the space—thus □, and a compositor receives so much per thousand "ens," i.e., he must "compose" a sufficient number of type-letters to fill the space which a thousand "en" quadrats will occupy.
PAY-LINES	A system in use in some collieries by which tickets are issued a day before pay day to each workman stating the particulars of his pay, thus allowing him time to make any complaints as to amounts, &c., before being paid.	PER 1000 ROUNDS	Per 1000 cartridges (<i>rounds</i> of ammunition).
PAYMENT BY BILLET	Payment by ticket (<i>Fr. billet</i>), a card or slip of paper on which particulars of wages are given.	PER TOD	(Wool weight) = 28 lbs.
PAYMENT ON THE BOX	Accident pay given by the employers whilst a workman is incapacitated by a mischance occurring during his employment.	PER TOP	Per lb. Wool made into a ball after leaving the combing machine ready for the spinning.
PEAK	The extreme forepart of the ship. This term is usually applied to the space below the fore-castle, in which the stores are kept. (See diagram XIV.)	PHASES OF RETORTS	The Witness here evidently means kinds or forms of retorts; <i>phases</i> is not a technical term as used by gas manufacturers. (C. 24,105.)
PEGGED OVER	The expression <i>instruments pegged over</i> refers to the operation of the man at the signal post in advance of a railway train, pointing or <i>pegging</i> the needle to "train on line" or "line clear" as the case may be.	PICK	A tool used by a hewer, consisting of an iron about 18 inches long, steeled and sharpened at each end, and weighing from 3 to 6 lbs. In the centre of the head is a hole or eye into which is fixed a shaft of ash about 2½ feet long.
PENOE MONEY	A custom in the brick-making trade by which the employer retains 3d. or 6d. per thousand from the wages earned by the moulders and pays it to them in a lump sum at the end of the season. If, however, the work is neglected in any way, or a man leaves his employment, or dies, the accumulated amount is forfeited.	PICKERS ¹	The workmen in a colliery who pick over the material filled into the hutches by the miners in order to ascertain the amount of deductions to be made for dirt and rubbish.
PERCH	To <i>perch</i> is to carefully examine pieces of cloth for defects. The method usually adopted is that of pulling the pieces over a roller fixed above a window.	PICKERS ²	Female workers who clean the woven fabric of stray and broken threads and other defects in weaving.
PERFECTING MACHINES	Double cylinder machines commonly called "bar" machines, used in printing.	PICKETING	The act of men standing at the gates of mills, docks, &c., watching those who go in and out, and inducing them to strike work.
PERICULO PETENTIS	<i>At the risk of the person seeking.</i> —All judicial warrants obtained at the instance of a private suitor are granted at his risk. Thus an interdict to prevent the sale of goods is granted to the petitioner entirely at his risk, for it is he who alone can be made liable in the consequences of its use should the party interdicted thereafter show that the application was groundless, and claim damages on account of any loss sustained by him in consequence of the interdict. The judge granting the warrant is not liable for its consequences, however disastrous they may be. In like manner	PICKING OUT SLATES	The process of cleaning the coal before delivery. All slates and impurities should be picked out by the loaders, and are paid for.
		PICKLING	In the copper industry when the sheets of copper come from the finishing rolls they are black like iron or steel. To change this black colour each sheet is washed in urine, placed in the furnace and heated, then hastily taken from the furnace and placed in a pool of cold water, and finally quickly dried by the furnace. This removes a black scale from the surface of the sheet and gives it its proper colour. One <i>pickler</i> and two small boys are attached to each set of rolls.
		PICKS	The number of threads of weft in one-quarter-of-an inch of cloth.
		PIECE BOOKS	Books in which values of different articles are entered when determined, to avoid the necessity of preparing a fresh estimate when a similar article is required again. This refers to the estimates on which Fellowship (see evidence C. 25,070) is based.

Term.	Definition.	Term.	Definition.
PIECERS -	Assistants to the mule spinner or minder, with the special duty of keeping the frames filled with "rovings." They derive their name from their work of <i>piecing</i> up the broken threads.		off the cage and weigh them. The term is also applied to men employed in a Scotch blast-furnace who work sometimes about the pit top or bank of a mine (which is in close proximity and belongs to the same firm), and sometimes in connection with the furnace, according to the sufficiency or insufficiency of labour at either place.
PIECE WORK -	See definition under "lump work."		
PIECE-WORK SYSTEM } -	See definition of "tonnage system."		
PIER-HEAD JUMP	The act of joining a ship as she is leaving the dock, owing to some of the (signed) crew not fulfilling their engagements.	PIT-MEN -	A collier as distinguished from a miner; a collier being attached to a coal mine or pit, and a miner more particularly to a metal mine. This distinction, however, has not of late years been closely preserved. The term <i>pitman</i> was formerly applied to every worker in a colliery, from the "trapper" to the "hewer."
PIG-BEDMEN -	Term synonymous with "pig-lifters."	PITT PRESS -	The University Press at Cambridge.
PIG-BEDS -	The beds where the pigs of metal are cast.	PLACERS -	<i>Placers</i> are the men in the potting industry who place the ware in the "saggers" (see definition) before firing, fill the ovens with them, and empty the ovens of the same; they work in the sagger house.
PIG-IRON -	See definition under "iron."	PLAITER -	In the straw-plaiting industry one who takes the straws in their prepared state and <i>plaits</i> or folds them into lengths according to a set design.
PIG-LIFTERS -	Also called "metal-carriers" (see definition).	PLANERS -	Workmen in the engineering industry who attend to the planing machines, vertical and horizontal, and slotting machines, for the shaping of objects made of cast iron, brass, malleable iron, steel, &c.
PILE-DRIVERS -	Workmen engaged in the shipbuilding industry in the sinking of piles by hand or steam pile-driving machines, and in doing other work in connection therewith to the structures of the pile foundation, such as jetties and piers.	PLANING A RAIL	To <i>plane a rail</i> is an expression used in the shipbuilding industry, meaning to make smooth and fair (with the <i>plane</i>) a rail which is the top or coping of the bulwark; this is usually put in place by shipwrights and smoothed and finished by joiners.
PILLAR AND STALL PRINCIPLE } -	Term used in Wales equivalent to the "board and wall" principle (see definition) of Northumberland and Durham. It is a system of working in which large blocks or pillars of coal are left between stalls to support the roof, such pillars being subsequently taken out by drawing back. This is called "broken work." In Scotland the system is known as the "stoop and room principle."	PLANING IRONS	A set of planing irons comprises all the steel or cutting portion of the tools used in planing timber.
PIPE CLEANERS	Men in the gas making industry who clean the pipes conveying the gas away from the retorts by removing the tar and pitch.	PLANING MACHINE } -	A machine tool, steam-driven, on the traversing table of which is fixed the work to be smoothed and manipulated. By its means a plane surface is formed on boards, metal surfaces, &c., passing under the fixed cutting-iron placed above them.
PIPE JOINTS -	See definition of "jointing up." Joints consisting of flanges or ferrules would bear this description.	PLANING	
PIPE-MOULDING	This term embraces the making of drain pipes, water pipes (of all sizes), and gas pipes which are not included in "marine moulding" (see definition).	PLANKING -	<i>Planking a ship</i> includes all the operations incidental to preparing wooden planks, from 2 to 4½ inches thick, for fixing them to the side or bottom of a wooden, composite, or sheathed ship, fastening, fairing, and generally completing such work. Top side planks fitted, fixed, fastened, and faired by shipwrights, are planed and finished by "joiners" (see definition) preparatory to painting.
PIPES -	<i>Bilge suction pipes.</i> —Pipes connected with the engines or donkey engines for discharging leakage from any source, from the bilges or lower portion of the ship. <i>Condenser pipes.</i> —Pipes communicating between the condenser and the engines, or the fresh water condensers and their cisterns. <i>Deck pipes.</i> —Pipes from the engine-room for washing the deck. <i>Downton pipes.</i> —Pipes for performing deck washing, or the removal of bilge water, or water proceeding from leakage, by means of the Downton pump. <i>Drain pipes.</i> —Pipes that are used for permitting loose water to pass from one part of the vessel to another by means of its own gravitation. <i>Fresh water suction.</i> —Pipes on a ship leading from the foot of a pump to the water that is required for drinking and cooking purposes. <i>Tank pipes.</i> —Pipes used for filling or emptying the water ballast or fresh water tanks.	PLANKS -	Long, broad, flat pieces of sawed timber used for building and similar purposes. All such timber having a less thickness than 9 inches is termed a "board;" <i>planks</i> differ from boards only in being thicker. Planks of fir or pine timber, for carpenters' use, above 7 in. wide are termed "deals" as distinguished from "battens" which must not exceed 7 in.; a whole deal is usually 1½ in. thick, a slit deal half that thickness. All timber is bought or sold by the load and a load or ¼ cord* is estimated at 40 cubic ft. of unhewn or rough timber, and 50 ft. of hewn or squared timber, which is supposed to weigh a ton. A load of 1 in. plank is 600 square ft.; of 1½ in., 400; of 2 in., 300; of 2½ in., 240; of 3 in., 200; of 3½ in., 170; and of 4 in., 150 square ft. In the Cape
PIT FRAMES -	The rests or supports in mines upon which the winding wheel revolves when raising coal from, or lowering the cages that convey the workmen to, the bottom of the shaft. They are now generally made of wrought iron or steel plates and bars fastened together by iron rivets, as in the shipbuilding and engineering industries.		
PITHEAD-MEN -	The men at the pit-head (the surface entrance to a mine) who take the hutchers		

* A measure for firewood, equal to 1,000 billets or four loads; so called because a stack of wood was formerly measured by a cord. The dimensions of a cord of wood are stated to be 8 ft. long, 4 ft. high and 4 ft. broad; the weight being about half a ton. The French cord for measuring wood is replaced by the *stère*.

Term.	Definition.	Term.	Definition.
	Colony two (what are called) "loops" of waggon wood, or 50 planks of yellow wood, or 10 planks of stink wood, each make a load.	PLATING A VESSEL }	To <i>plate a vessel</i> means to mould, mark, put in place, and to perform other incidental operations on steel plates on the outer and inner bottoms and sides, on the decks, and on the bulkheads (partitions) of a ship. This term can also embrace the work of the various classes of shipwrights, such as punching, shearing, rolling, and bending the plates.
PLASTER OF PARIS }	A composition of several species of gypsum dug near Montemarte, near Paris, used in building and in casting busts of statues. This term is, however, frequently applied to plaster stone, or to any species of gypsum. <i>Plaster of Paris</i> is formed by burning the gypsum (sulphate of lime containing 21 per cent. of water) to drive off the water, and then grinding it up.	PLATING OF A VESSEL }	The covering or skin of steel plates over the bottom, deck, bulkhead, and other portions of a vessel, from one-eighth of an inch to one inch in thickness.
PLASTERERS	The men who <i>plaster</i> buildings, both inside (walls, ceilings, &c.) and outside, make the moulds in which the ornamental work (such as cornices) is cast, run in all "mouldings," (see definition) in plaster or cement, and put down tiling.	PLATTER	Equivalent to <i>plate</i> , the more common term. The men and boys, and in some cases women, who make plates or platters, cups, saucers, slop basins, dishes and ware of a similar kind are called "flat pressers."
PLATE FURNACE MAN }	A <i>plate furnace man</i> has to serve the plate roll and keep the roller man going; his duty is to put all the plates into the furnace, heat them to a proper pitch, and then bring them out one at a time, and place them in the rolls. He has also to assist the roller man to roll the plates. A <i>plate furnace man</i> has to perform the most laborious and difficult labour connected with the copper trade. There is one furnace man and a boy attached to each set of rolls.	PLAY	To <i>play</i> is to cease work because there is no weft to be obtained from the store-keeper, and the operative has either to go home or remain about the mill until the weft is spun, or, as is often the case, to weave upon one loom, a weaver rarely having both looms weaving the same sort of weft.
PLATELAYERS ¹	Men who lay the rails over which the waggons run to or from a mine, furnace, &c.	PLAYING-OFF	A system, in use in the carters' department of certain railway companies and firms, under which a man whose booked hours amount to 10 or more over the ordinary 60 per week receives notice that on a certain day he will be booked off. This system is adopted in lieu of payment for overtime.
PLATELAYERS ²	In some parts of the country termed "surface men" (see definition). They lay, re-lay, and keep in repair the permanent way (sleepers, &c.) of the railway.	PLUMBERS	<i>Chemical plumbers</i> .—The duties of <i>chemical plumbers</i> are chiefly comprised in the building of chambers for the manufacture of acids, soaps, &c. Their work is both unhealthy and dangerous. <i>House plumbers</i> .— <i>House plumbers</i> require a knowledge of sanitation in all its phases, of hot water circulation for domestic purposes, of roof-plumbing (i.e., covering roofs with lead, zinc, or copper), and of hydrostatics and hydraulics, &c. <i>Ships' plumbers</i> .— <i>Plumbers</i> in the ship-building industry are workers in lead chiefly, but occasionally in iron, copper, brass, and zinc piping, who fit water and gas service connections, lavatories, water closets, bilge pumps, scupper pipes, draws, fresh water tanks, ballast tanks, ventilation, &c. <i>Ships' plumbers</i> require a knowledge of the sanitary arrangements of ships. The work is more laborious and unhealthy than house plumbing, since the pipes whether iron or lead are much heavier and larger than those used in houses.
PLATE MILLS	See definition under "mills."	PLUMBERS' ASSISTANTS }	Skilled labourers who have acquired a knowledge of the plumbers' work, and are therefore capable of assisting plumbers.
PLATE ROLLS	See definition under "rolls."	PLUSH	A pile cut fabric (i.e., a fabric with a fine hairy surface), made with a cotton back and silk pile face. It is usually made from China silk, and is dyed into fancy colours for curtains, cloakings, trimmings, &c.
PLATERS	Skilled mechanics in the iron shipbuilding, boiler-making, and engineering industries, who mark, shear, roll, flange, bend, shape, punch (rivet holes), set, fit, and fix in place, according to the design and specification, and otherwise prepare, the steel plates, angle bars (see definition and diagram; see also diagrams VII.), T bars, bulb bars, channel bars, &c., for the outside and inside and hull of a ship, or for boilers and bridges, &c., in readiness for the "rivetters" (see definition). In Scotland <i>platers</i> are sometimes termed "fitters" (see definition of "frame-turners"). <i>Heavy platers</i> .—Men who fit together the heavy plates for boiler shells and for furnaces and combustion chambers. These men, with the "flangers" (see definition), receive the highest wages, the work in both cases being the most important. <i>Light platers</i> .—Men who are engaged on light work, such as plating funnels and smoke boxes. They are usually paid about 2s. per week less than heavy platers and flangers. <i>Inside platers</i> .—Men who are generally engaged upon the plating for the interior of the vessels, such as bunkers, funnels, and bulkheads. <i>Outside platers</i> .—Men who are engaged upon the plating for the outside of vessels. [For definition of <i>shell platers</i> see under that heading.]	PLUS SYSTEM	Also called "bonus" system, is one by which a certain proportion of wages, called "subsistence money," is paid every day, and the remainder on the completion of the job or contract. This remainder is called the <i>plus</i> , or "contingent money."
PLATERS' HELPERS }	<i>Platers' helpers</i> are labourers who aid <i>platers</i> , by holding the plates in position and assisting in the rougher parts of the work, such as punching and shearing, &c., and removing, lifting, and fixing in place the boiler or ship plates, to be next dealt with by the "rivetters." <i>Helpers</i> are skilled, although in a less degree than <i>platers</i> .	POOKING OR POOKING }	The heaving of the bottom or floor of the travelling roads in a mine, which become raised through the action of gas, &c., thus making insufficient height for the horses and men to travel, and necessitating a further cutting of the road. (Term used in S. Wales.)

Term.	Definition.	Term.	Definition.
POLISHERS	Men in the printing industry who polish stone for artists and printers (lithographic) who do transferring.	PRESENTLY	Here used in the Scotch sense of, immediately; at this present; now; not as ordinarily understood, by and by; in a little while; shortly.
POP-CARTS	See definition under "carts."	PRESSERS	Men engaged in <i>pressing</i> the seams of garments with heated irons.
POP-SHOP	A pawnbroker's shop.	PRESSMEN	Mechanics engaged in printing by the old hand presses (very few now) taking off impressions on paper, whether from type, stone, wood-cuts, or metal plates.
PORTERS	<i>Goods porters</i> truck, handle, load, and unload goods in the warehouses and goods yards. <i>Passenger porters</i> attend to the passengers and handle their luggage on arrival at or departure from stations.	PRIMÂ FACIE	<i>On the first aspect.</i> —The expression is here used to refer to a case where, instead of a mere averment of liability, some evidence such as a bill or other writing should be required. (B. 26,099, 26,108.)
POTTERS	All men, women and children who are employed in any branch of the potting industry. The duties of <i>operative potters</i> comprise the making, firing and decorating of pottery ware. The term <i>potters</i> also includes the accessory branches, such as warehousemen, packers, &c.	PRIMING	When hot water is carried with the steam from the boiler into the cylinder of an engine, the boiler is said to <i>prime</i> .
POTTERS' } LATHES }	Machines, similar to those used by wood turners, engineers, &c.	PRINTERS	Lithographic printers print from lithographic stones (see definition); letter-press printers print from type and wood blocks in distinction to copper plates and lithographic stones.
POTTERS' OVENS	<i>Potters' ovens</i> vary in size from 12 to 21 feet in diameter. They are filled by gangs of men and boys whose number varies with the size of the ovens and class of ware made.	PRINTERS' } LABOURERS }	Men in the printing industry who "lay on" and "take off" (see definitions) in connection with the printing machines; also men who feed machines, carry paper, and generally assist the "machine minder" (see definition).
POTTERS' ROT	Asthma is locally called <i>potters' rot</i> , because of its fatal effects upon potters, many of whom die from the disease through the inhalation of the clay dust and other causes.	PRIVATE } MEMBER OF } PARLIAMENT }	A private Member of Parliament is any member of the House of Commons who is not a member of the existing Cabinet nor a holder of any office under the Government in power.
POTTERY TRADE	The industry devoted to the production of china and earthenware.	PRIVILEGE	The <i>privilege system</i> or "railway monopoly system" in the cab-driving industry is that under which a proprietor has the <i>privilege</i> of allowing his drivers to ply for hire at certain railway stations, i.e., to wait and take away a fare as well as to bring one. The privilege is conceded on the payment of a certain sum to the railway company, the proprietor recouping himself by charging his drivers a higher rate. (About one-seventh of the total number of cabs are privileged; a privileged cab, it is alleged, obtains seven jobs to every five by a non-privileged cab.)
POTTING } INDUSTRY }	The "pottery trade" (see definition).	PROCESSES } IN STEEL } MAKING }	The ordinary or " <i>Acid</i> " <i>Bessemer process</i> of steel making consists in taking quantities of from 6 to 15 tons of pig-iron, the quantity varying with the capacity of the plant, such pig being practically free from sulphur and phosphorus, and technically known as " <i>Bessemer pig</i> ." It is taken either direct from the blast-furnace in a liquid state or is re-melted in a cupola, but in each case it is poured into a Bessemer converter, lined with a siliceous lining, the slag produced being of an acid character. Through this liquid metal streams of air, at a pressure of 20 to 25 lbs. to the square inch, are blown. The silicon and carbon of the pig-iron are rapidly oxidised by the oxygen of the blast, the former passing into the slag, and the latter escaping in a gaseous form. After these two elements are taken out of the metal, which is now practically liquid malleable iron, the small quantity of carbon requisite to convert it into steel is added in the form of spiegeleisen, which is a pig-iron containing usually from 15 to 30 per cent. of manganese. The resulting steel is now poured into a ladle, and from that vessel is run into moulds to form ingots. These ingots usually weigh about 20 to 30 cwts. each. The process is a rapid one, the average time for conversion of a charge from pig-iron to
POUNDAGE ¹	A system in vogue in the slate industry to adjust the wages of the workmen. Every month when the claims of the slate quarrymen are made out an addition of so much in the pound is made upon the slate bill, that is, the payment due according to the standard rates.		
POUNDAGE ²	The system under which the wages of tacklers or overlookers in cotton mills are based upon the output of the looms, being so much in the pound on the total earnings of the weavers under their charge.		
POWDER } BARGES }	See definition under "barges."		
POWDER-BREEK	Smoke caused by the explosion of gunpowder used in blasting.		
POWER-LOOM	A loom driven by steam or water-power transmitted from a prime motor as distinguished from the hand-loom worked by treadles with the weaver's feet.		
PREAMBLE	(a.) Introduction, preface. (b.) The introduction of an Act of Parliament, which sets forth its intent, and the mischiefs to be remedied. If a committee of either House sitting on a private bill finds the preamble "not proven," the bill is rejected.		
PREPARERS ¹	Persons employed at the drawing and roving frames in <i>preparing</i> the wool previous to spinning (term used locally at Leicester). Generally speaking <i>preparers</i> in the cotton industry are female workers in any of the processes that precede spinning. They are considered to be unskilled workers, as no delicacy of touch is required.		
PREPARERS ²	See definition under "stone preparers."		

Term.	Definition.	Term.	Definition.
	<p>steel being about half-an-hour The steel thus produced is principally used for rails. In the "Basic" Bessemer process the converter or vessel is lined with strongly calcined dolomite (a mineral consisting of the carbonates of lime and magnesia), ground to powder, and called "basic material." The metal used for making steel may contain phosphorus, in addition to those elements which are found in Bessemer pig-iron. The blowing is done as in the Acid Bessemer process, with the slight difference that, after the carbon is all removed instead of terminating the blow, as in the latter process, it is continued for two or three minutes, so that all the phosphorus present may be oxidised and removed in the slag. In other respects the process is similar to the Acid Bessemer one. The slag, or cinder, is used, after grinding to a very fine powder, as a phosphatic manure.</p> <p>In the Siemens-Martin "Acid" process the pig-iron and scrap-steel are charged cold into a Siemens regenerative furnace, which is lined with silica bricks, and the bed or hearth formed of silver sand. In this furnace the charge is melted by hot gas and air. The silicon and carbon are oxidised by the oxygen contained in iron ore of good quality, which is added at intervals during the working of the charge after it is melted, until these two elements are almost entirely eliminated. When this is done, spiegeleisen, or, if steel with a low percentage of carbon is required, ferro-manganese, is added to effect the necessary re-carburisation, and the fluid steel is then tapped into a ladle and run into ingot moulds. Ferro-manganese is an alloy of carbon, iron, and manganese, differing only from spiegeleisen in that it usually contains 70 to 80 per cent. of manganese. The weight of charge for a furnace is from 15 to 30 tons, varying with the size of the furnace, and the time necessary for its conversion from solid pig-iron to steel is from 9 to 12 hours. In this process, as in the Acid Bessemer process, it is absolutely essential that Bessemer pig should be used, that is to say, such as is practically free from sulphur and phosphorus.</p> <p>The Siemens-Martin Basic process differs from the above in that the furnace, instead of being lined with a siliceous material, is lined with dolomite, and the hearth made of the same or a similar substance; some lime is also added in the furnace during the working of the charge. The effect of this is to maintain a slag of a basic character, and to allow of the use of an impure or phosphoric pig-iron, the element phosphorus only being removed when the slag is of the basic character described. A pig-iron containing phosphorus to the extent of 3 per cent. may thus be used, whereas, in the acid process, good steel could not be made from pig containing so much as 0.1 per cent. of phosphorus. The slag containing the phosphorus is run off before the steel is tapped out of the furnace. In other respects the charge is worked as in a furnace with a siliceous lining, the additions of ore and ferro-manganese being equally required. The duration of the process is from 6 to 12 hours, and the weight of a charge about 12 to 15 tons. The products of the Acid Siemens furnace are principally formed into plates, angles, girders, and similar forms for shipbuilding purposes, whilst those from the basic furnace are largely devoted to billets for wire, hoops, &c.</p> <p>In the Crucible process the weights used are generally small. The iron and scrap used is of the best quality; they are melted up in plumbago or fire-clay crucibles, usually in a modification of a Siemens' furnace; the weight in a pot is</p>		<p>generally about 56 lbs. The steel made is used for cutlery and best castings.</p>
		PROCESS MEN -	Men employed at particular branches of the chemical industry, such as "hurner men," "salt cake men," "lime men" (see definitions), and others who are necessary to the completion of the whole process of chemical manufacture.
		PRO LOCO ET TEMPORE }	For the place and time.—Where an objection has been taken successfully to the relevancy of an indictment, or anything occurs to induce the Public Prosecutor to delay proceeding with the trial, such as the absence of an essential witness, &c.; he may, before the jury is sworn, move the Court to desert the diet against the prisoner <i>pro loco et tempore</i> , and this reserves to him the power of indicting the prisoner again for the same offence at another time and place. [The foregoing definition shows that the phrase here (B. 26,081) qualifies the word "departed."]
		PROPELLERS -	Fans similar to the screw of a steam ship fixed near the window to regulate the emission of foul air.
		PROPS - -	Single pieces of timber in the workings of a coal mine set upright (at right angles to the strata) to support the roof or keep up the sides.
		PUDDLERS -	Men who puddle pig-iron or metal, i.e., charge it into a furnace, melt it, and stir it, thus gradually ridding it of impurities, changing the nature of the iron from cast to wrought iron, and producing malleable iron in its first stage.
		PUDDLING FORGE }	A number of puddling furnaces surrounding a steam hammer and rolling machinery for converting pig-iron into wrought iron.
		PUMPING ENGINE }	See definition under "engines."
		PUNCH - -	The top half of the prints in which bolsters (see definition) are made.
		PUNCHING -	The process performed by "platers" (see definition) in the shipbuilding industry of perforating the plates by means of a steam punching machine; it follows next in order to the marking and lining off. (See definition of "setting off.")
		PURCHASES -	Mechanical power or advantage in raising or moving heavy bodies is termed <i>purchase</i> : hence the appliances producing such power or advantage by increasing the force applied are here termed <i>purchases</i> . (A. 24,222.)
		PURIFIERS ¹ -	Men in the gas making industry who work in the <i>purifiers</i> , i.e., substitute fresh purifying material for that which has done its work.
		PURIFIERS ² -	Large rectangular vessels used in the gas making industry; they are comparatively shallow and have a movable cover. These vessels contain purifying material through which the gas is made to pass.
		PUTERS - -	Boys engaged in conveying the coal in a mine from the face to the flat or engine-station. The tram containing the coal is sometimes pushed by the boy, and sometimes pulled by a pony, hence the terms <i>hand-putters</i> and <i>pony-putters</i> .
		PUTTING SHOT-HOLES OFF }	Blasting the slate-rocks to get them into blocks or igniting the fuse in connection with explosives.

Term.	Definition.	Term.	Definition.
PUTTING TO PRESS } -	Preparing the last proof by carefully reading over, to note all marks made which may have escaped the attention of the reader when correcting the first proof and errors which may have occurred whilst making alterations, &c.	RAM OF THE PRESS } -	This is the part of a hydraulic bending machine (consisting in this case of cylinder and ram) which receives the water under pressure and communicates that pressure to the object to be operated upon.
PYRITES - -	A term applied indiscriminately to many of the metallic sulphides, especially to sulphuret of iron. <i>Pyrites</i> are formed of a combination of sulphur with iron, copper, cobalt, nickel, &c. Brass <i>pyrites</i> are frequently found in the strata forming the bed of a coal seam. <i>See also</i> under "iron pyrites."	RAMS - - -	The expression is here used for Government warships armed with <i>rams</i> (noses projecting forward from the stem, usually under water) for offensive purposes. (A. 20,387).
QUALIFICATION MARKS SYSTEM } -	A system in use in Her Majesty's Dockyards by which the constructor of each yard holds the disposal of 400 gratuitous marks, which he assigns at his discretion to the workmen under him according to merit, with a view to an increase of wages.	RAPE SEED -	The seed of a vegetable product (of the cole kind) of India and Russia, where it is grown for exportation. The oil crushed from it is used for burning purposes, some description being known as "Colza." The cake or substance left after pressing is used for manure.
QUARTER - -	Part of the stern of a boat. (<i>See</i> diagram XII.)	RAT LABOUR -	"Rat" is an offensive term applied by "union" workmen to all who are not members of the trades union governing the branch of labour they practice. Hence in the eyes of a trades unionist the terms <i>rat labour</i> and "non-union" or "free" labour are synonymous. By a unionist <i>rat labour</i> is defined as men who work for less than the established rate of wages.
QUARTERAGE -	Term applied to all annual payments made by the foremen to city companies. To the <i>Watermen and Lightermen's Company</i> it is 3s. per annum, except in the case of freemen barge-owners, when it is 6s. per annum.	RATTENING } -	This expression was used by the proprietors of the "Sportsman" (C. 23,129). About 25 or 30 years ago the term was brought into prominent use to denominate the acts of workmen in Sheffield and the Black Country, in destroying the tools of non-unionists.
QUARTERN -	Four pounds of bread.	REACH - - -	The reach is that portion of a river which lies between two bends or elbows. In this case the <i>reach</i> referred to is the bend of the River Thames just below Gravesend.
QUARTER-TIME	In the shipbuilding industry assuming the hours of an ordinary working day (in summer) to be from 6 a.m. to 5 p.m. quarter-time ends at 8.30 a.m., half-time at noon, and three-quarter-time at 3 p.m. If a man does not work the whole day, but loses a quarter or a half, &c., that quarter or half, &c. is deducted from any holidays the man may be entitled to; further, if a man is five minutes late the pay for quarter-time is deducted from his day's wages.	RE-BELLING -	Changing the old <i>bell</i> (<i>see</i> definition) for a new one.
BACKING AND UNRACKING RAFTS OF TIMBER }	To load and unload a <i>raft</i> holding, say, 20 timbers. If a special timber placed in the middle of the raft is required, it is necessary to <i>unrack</i> the raft, secure the special timber, and then <i>rack</i> the raft again.	RED LEAD -	<i>Red lead</i> is a pigment obtained by exposing lead or its protoxide—yellow oxide (<i>i.e.</i> , a compound of one equivalent of oxygen with one equivalent of the metal, and destitute of acid properties)—to heat in low arched furnaces, from which it is taken and, ground under millstones into a fine paste. It is then again charged into the furnaces and after lying for about 12 hours it is converted to a red oxide, acquiring a bright red colour. <i>Red lead</i> is used by glass makers and glass stainers, and in the manufacture of paint.
RAG - - -	A piece of cloth kept between the teeth of men in the chemical industry working at salt-cake and stills to prevent the inhaling of injurious gases.	RED LEADERS -	Workmen (common labourers) in the shipbuilding industry who scrape the surfaces of new iron plates, &c., and apply the first coating, which is <i>red lead</i> .
RAG-GROUNDING -	A process done in machines (worked by men) which pull into pieces old garments, stockings, and rags generally. It is made into shoddy and mungo, and ultimately into cloth.	REDUCING } -	The machines in which the operation before roving is performed by female labour.
RAIL BANKS -	Banks upon which "rails" when manufactured are placed to cool.	REED - - -	A comb of closely set, flat, steel, teeth, fastened to the slay beam of the loom. Each thread of the warp is passed through a separate interstice, and every time the shuttle "picks over" or passes across the warp this <i>reed</i> or comb drives the weft thread home to its place in the web. The ancients used a hand-comb for this purpose. <i>Reeds</i> are reckoned by the number of interstices per inch, thus, a 64 reed has 64 interstices to the inch (<i>see</i> diagram).
RAIL ENDS -	In the shipbuilding industry rail-ends are rail-brasses or junction plates on the ends of rails at the gang-way or other passages into the interior of a ship.	REWELERS -	Persons (generally girls) employed in winding or reeling silk yarn from the bobbin into skeins or hanks before it is put into bundles.
RAILS - - -	Steel bars used for railway lines.	REGENERATOR } -	A <i>regenerator furnace</i> , or more correctly <i>regenerative furnace</i> , is a furnace heated by gas. The gas producers, that is the furnaces in which the fuel is turned into gas, are situated at some distance from
RAILWAY MONOPOLY }	Also called "privilege" (<i>see</i> definition).		
RAMBLE - -	A thin stratum of tender shale or stone found lying immediately above a seam of coal, and falling down amongst the coals, has to be picked out by the coal-getter, thus causing him loss of time. This loss of time is remedied by an extra allowance of 3d. or 4d. per score called "ramble-money," or taken into account in fixing the hewing price itself.		

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Term.	Definition.	Term.	Definition.
	the retorts used in the gas-making, or from the furnace containing the metal used in the glass-making industry. In the gas-making industry the waste heat is used to heat the channels through which the secondary air supply is conducted to the top of the furnace. In the glass bottle making industry the gas and air pass separately through chambers of fretted brickwork until they reach the furnace, where contact ensues and the gas ignites.		<i>e.g.</i> , coal, cotton, iron, steel, &c. In the first instance the operators are called "bulls," in the second "bears." (See definition of "cotton rings" and of "fish rings.")
REGULAR TIMERS }	Men who are always employed all the year round, receiving their pay regularly every week, either when working or playing or during illness.	RING ² -	In the potting industry what is called the first ring is composed of the bungs set next to the arches forming the first circle of "saggers" (see definition) in the oven. Next comes the second ring, and then the third, and so on, until the whole of the oven is filled.
RELAY SYSTEM -	An expression here used to denote the system in use in Liverpool with regard to tugboats, under which two spare men are always ready to take the place of two men who come on shore when the boat returns.	RING-SPINNING -	A process of spinning on frames in which a ring is used on the spindle.
REPAIRERS -	Skilled workmen generally employed in mines at night in <i>repairing</i> and maintaining the roadways in height and width to enable traffic to pass through them by day.	RIPPERS -	Men cutting down the roof on travelling roads to make height when the roof has become bent down. (Term used in S. Wales.)
REPAIR WORK -	Work in the nature of making good damage to or defects in ships or their machinery; repairing old ships and their machinery in contra-distinction to the "new work" (see definition) in connection with the construction of new ships and their machinery.	RIPPING -	That portion of the roof which is cut down in the roadways to make sufficient height for men and horses to travel. Six feet is a common height, so if there happens to be four feet of coal it would be necessary to remove two feet above the coal, that is, two feet of <i>ripping</i> .
RETORT HOUSES	The portions of gasworks where the retorts are situated.	RIVERSIDE LABOURERS }	This term generally embraces all who are employed in loading and unloading vessels and a few who are employed in driving the horses that tow the boats on canals; the latter class in the West Riding of Yorkshire are more usually termed "horse-marines" (see definition). In the London district it includes all who work at the docks and wharves, and in the stream, except sailors and those who are engaged in the painting, rigging, or repair of the ships, &c.; the office staff of clerks is also not included.
RETORTS -	Retorts are the tubular chambers, 16, 18, or 20 feet long, composed of burnt fireclay, which contain the charge of coal or cannel to be carbonised in making gas.		
RETURNS -	An abbreviation for <i>return airways</i> , <i>i.e.</i> , the passages through which the air passes to the upcast shaft. (See definition of "airways.")	RIVETERS ¹ -	Skilled labourers in Her Majesty's Dockyards (frequently called "tradesmen" in private firms) who, in the iron ship-building, boiler making, and engineering industries, fasten the iron plates, bars, beams, &c., together by scientifically hammering the red-hot rivets, bolts, or pins, driven into holes made by the "drillers" (see definition). Riveters are assisted by "holders-up" (see definition), who insert the hot rivet in the hole and keep it in position. The responsibility of performing thoroughly this important work, upon which the safety of the vessel, boiler, &c., so greatly depends, is obvious. The process described above is termed <i>riveting</i> , and immediately succeeds the work of the "platers" (see definition).
RIB-MACHINES -	Machines which make <i>rib</i> work in contra-distinction to plain work.	RIVETERS ² -	Termed <i>lasters</i> in the Midland Counties and in London, <i>rounders</i> in the West of England, and <i>benchmen</i> in Scotland. They take the boot-upper as received from the fitters and the portions of leather that are to form the bottom of the boot and shoe, and by means of tacks fix the bottom to the upper. After the boot has been sewn the rivetter again takes the boot and hammers the sole out to make it level, trims the edge, and gives it a presentable appearance.
RIDDINGS -	The portions of lime rejected from the slaking because they are too coarse or stony or ill-burned to be utilised for bleaching powder, in the manufacture of which only the finest quality is used. The whole of the slaked lime is put through a sieve or <i>riddle</i> ; hence the term.	ROADSMEN -	Men paid by the mine-owner for the laying down and keeping in repair the underground haulage roads. They also look after the supply of timber or prop wood, and clear away any <i>débris</i> that may fall from the roof.
RIGGERS ¹ -	<i>Riggers</i> or <i>ship-riggers</i> are seamen, as a rule, who mast and rig ships and perform work incidental thereto, fitting wire and other ropes, <i>e.g.</i> , the standing and running rigging (see definition), the cordage (small rope used for lashing), sails, yards, tackle, and all necessary gear, and in attending generally to the repairs aloft while the ship is in dock without a crew. (See definition of "master riggers.")	ROCKMAN -	A skilled workman in a slate quarry, who gets the slate rock by hewing or blasting. To be fully qualified he should have a considerable knowledge of geology and mechanics.
RIGGERS ² -	In the mill-sawing industry the band wheels revolving on the shafting are called <i>riggers</i> ; those driving the saw-spindle, receiving motion from those on the shafting, are called pulleys.		
RIGGING -	<i>Rigging Work</i> .—All work appertaining to the fitting of vessels with masts, yards, ropes, and other necessary gear. (See diagrams XV. and XVI.) <i>Rigging Lofts</i> .—The workshops on shore, in which the ship's gear is fitted for use.		
RIMLOCKS -	See definition under "locks."		
RING ¹ -	A ring is a Stock Exchange or other combination formed for the purpose of raising or lowering the price of stock or produce,		

Term.	Definition.	Term.	Definition.
ROD	A long measure of $16\frac{1}{2}$ linear feet, or a square measure of $27\frac{1}{4}$ square feet.		
ROLLER	An iron roller covered with a composition of indigo. It works on a "slab" (see definition) and inks the type used in printing. The weight of a roller is from 28 to 50 lbs.		which all the very heavy plates are rolled. Plates from five cwt. up to two tons can be worked in these rolls. <i>Soft rolls.</i> —The first pair of rolls through which the steel goes after coming out of the heating furnace. [For definition of <i>Calendar Rolls</i> used in paper making, see under that heading.]
ROLLER-COVERER	A person who covers rollers for spinning purposes.	ROOM	A passage driven in a coal seam. (See definition of "stoop and room.") (Term in use in Scotland only.)
ROLLERS ¹	Men in charge of the mill for rolling rails, and of the forge iron, &c. They are responsible for the mill being properly manned with workmen, and the material properly rolled. Also men, who, after the puddled iron is left by the "shinglers" (see definition), put it through various grooves in the "rolls" (see definition), and produce billets of square iron or flat bars as required.	ROSE NAILS	See definition under "nails."
ROLLERS ²	Rollers are round pieces of iron placed in the furnace, over which the large plates produced in the copper industry roll into the furnace and are drawn out again when hot.	ROSTER	A roster or "diagram" (see definition) is a table or list used in the railway industry setting forth the work to be performed, and fixing the rotation in which the men are to take duty.
ROLLEY-WAY MEN	The <i>rolley-way</i> is the underground horse-road in a mine. Thus, a <i>rolley-wayman</i> is similar to a platelayer on a railway, his work being to keep the permanent way in order, to repair and lift tubs on the way, &c., so that no time is lost in getting the full tubs to the shaft and the empty ones in-by again.	ROTARY MACHINES	Machines for knitting looped fabric, but differing from circular machines in having the needles on a straight bar instead of in a circle. These are fed by a traverse carried with the thread, the machine working by rotation.
ROLLING	The process of straightening, bending, twisting, curving, and otherwise shaping in the <i>rolls</i> the plates used for vessels.	ROUGHERS	The workers in the iron industry employed at the "rolls."
ROLLING MACHINES	Machines used to put a glossy surface on sheets after being printed.	ROUGH STUFF CUTTERS	Also called <i>presemen</i> ; the men who cut all the bottom stuff for boots and shoes (the heavy soles, insoles, top-pieces, lifts, welts, and clumps, &c.), by means of presses (knives cut to the shape of the foot).
ROLLING MILLS	A <i>rolling mills department</i> , where iron is produced, may be divided into two sections, each consisting of furnaces and machinery. The first is where, in furnaces, the pig-iron is reduced to wrought-iron, and subsequently hammered and rolled into puddle-bar. The second section is where the puddled bar is, along with scrap iron, treated in heating furnaces, and subsequently rolled out either as plates or bars of various sections required in ship-building. In a steel mill the rolling mills department consists entirely of furnaces and plant for producing plates in the various sections required for steel ship-building, the steel itself being produced in another department.	ROUND COAL	See definition under "coal."
ROLLS ¹	Irregularity or indentation in the top or bottom of a seam of coal.	ROUNDERS	A country expression for the youths in the boot and shoe industry who cannot be trusted to cut the best materials, and who therefore cut such materials as common outsides, fittings, and linings. In London they are termed <i>improvers</i> .
ROLLS ²	Machines used in the shipbuilding industry for the levelling, straightening, bending, or twisting of iron or steel plates. They are composed of hardened cast metal or steel turned into grooves of various patterns and sizes, driven by engines, and through which hot iron or steel passes, and is produced to the size or shape required. <i>Plate or sheet rolls</i> have no grooves, but present a plain hard face. <i>Breaking-down rolls.</i> —The rolls working upon a balance in which the plates are first worked. By pressing a lever the rolls can be lifted up as to receive a thick plate, and by working a screw brought close together. <i>Finishing rolls.</i> —The <i>finishing rolls</i> is a pair of rolls which forms part of the mill for rolling out copper sheets to their proper length. <i>Hard rolls.</i> —The last pair of rolls in which the plate is finished. <i>Plate rolls.</i> —The <i>plate roll</i> is known as the <i>loco plate roll</i> . It is the set of rolls in	ROVERS	Women minding the roving frames, the most complicated machinery in jute spinning. They are "preparers" of the highest class, but have to exercise more attention than skill, as the machine is self-acting.
		ROVING BOXES	Machines in which is performed the last operation before spinning, by still further reducing the sliver of wool to the thickness required for convenience in spinning.
		ROVING-FRAME	A machine used in the preparatory processes of cotton-spinning for producing bobbins for the mule and throstle-frames.
		ROYALS	Men who get the first chance of dock work, and, like a casual labourer, can be paid or taken on at any time, but receive no week's notice as permanent men do.
		ROYALTY	Possession of the minerals, with the right of working them. They belong to the owner of a freehold, unless stated in the title deeds to the contrary. Beneath copyhold land the royalty is vested in the lord of the manor.
		RUBBER-TYRED CABS	Hackney carriages, broughams, or hansom having the wheels fitted with rubber tyres.
		RUBBISHER	A labourer in the slate industry who carries away all the material from the rock-man the valuable to be made into slates, the worthless or <i>rubbish</i> to be thrown away.
		RUBBLER	An irregular workman in a slate quarry, who is paid at the end of the month by the quarry owner for the slate he then produces. He obtains his slate-blocks as payment from the bargainers for assistance rendered to them. This constitutes the sole method of learning slate-quarrying

Term.	Definition.	Term.	Definition.
	and becoming proficient in it, hence all boys and beginners are <i>rubblers</i> at first.	SASHES -	The sliding or opening portions of a window which hold the glass and can be opened for purposes of ventilation, &c.
RUNKER -	A small iron trolley used in the printing industry for shifting stones about; the stones are placed upright upon it.	SASH FRAMES -	This refers to the "cased" frames of ordinary sashes hung with lines and weights. If the frame has more than one opening it is called a "casing" frame.
RUNNERS -	A class of men employed in taking ships on short voyages, such as from London to Cardiff or Antwerp. They leave the vessel at the port of arrival and are paid a certain sum for taking her there. Such men are employed when the owners do not desire to sign on a crew.	SAW BENCH -	The table, in a slot of which the saw revolves, and along which the wood is slid to be cut.
RUNNING A SHIP ON END }	Placing a ship's masts, yards, and rigging in their proper positions ready for sea again, after such ships have been stripped or dismantled.	SAWNEY -	Term used to denote the accident when all the threads in a mule are broken at the same time by some faulty action of the mule.
RUN ON -	The process of placing imitation or spelter bolsters on common table knife blades. The process is to "fly" (see definition) a blade out of sheet steel, then to place the "tang" (see definition) in a mould, and lastly to pour zinc in a molten state into the mould. This forms a "bolster" (see definition) according to the shape of the mould.	SAW SPINDLE -	The axle tree of a saw.
SACK WORK -	See definition under "work."	SCAB -	An opprobrious term synonymous with "blackleg" (see definition).
SACRIFICE ALLOWANCE }	A weekly sum paid by workmen's unions to those members who are discharged from work because they take an active part in their organisation or are too weak to make the average. These latter are called <i>sacrificed</i> men.	SCAFFOLDS -	Projections formed by adhesion to the walls of the materials used in a blast furnace. <i>Scaffolds</i> vary considerably in size, sometimes extending right round the furnaces.
SAGGER HOUSE	The part of the factory in which the "saggers" are kept, and in which the "placers" (see definitions) work. As a general rule the entrance to the ovens is in the <i>sagger house</i> , so that when the men have filled the saggers with ware, they can conveniently carry them into the ovens.	SCALEBOARD -	A kind of large shovel, made of planks, which serves as a shoot and guide, down which goods are slid from ship to quay.
SAGGERS -	<i>Saggers</i> or <i>suggars</i> are a kind of clay boxes, made of marl and used in the potting industry; they are of various shapes and sizes, according to the class of ware to be placed in them; some are round, some oval, and some square, varying in size from 10 to 60 inches square, and from 4 to 20 and 24 inches high, but when piled up in the oven each <i>sagger</i> covers the one beneath it to protect the fine stoneware from immediate contact with the smoke and flame.	SCALLIWAGS -	An opprobrious term, equal to scamp or villain, applied to men who will not work.
SALT-BOILER MEN }	See definition of "waller."	SCAMPING -	Executing in a superficial manner; performing in a careless, perfunctory manner.
SALT CAKE -	Commercial "sulphate of soda" (see definition).	SCOOP -	A <i>scoop</i> in gas making is a piece of steel 10 feet long, 7½ inches wide at the nose, 6 inches deep at the end of straps, 5½ inches wide at the straps, and 5 inches deep.
SALT CAKE PROCESS }	The process of manufacturing salt cake from common salt and sulphuric acid, used for making carbonate of soda, black ash (compound of salt cake, limestone, and slack, or small coal), or common washing soda.	SCOOP DRIVERS	The <i>scoop driver</i> is the man who lifts up the "scoop" (see definition) that the "front men" (see definition) may place the bridle underneath; he also guides the <i>scoop</i> into the retort, turns it over, and then brings it back again for filling.
SALT HEAVERS -	Men who discharge the salt from the barges by <i>heaving</i> or throwing it up, either upon the deck of the barge or into a tub so that it can be weighed.	SCOTCH DERRICK DRIVERS }	See definition under "drivers."
SALT MAKERS -	Term embracing all the men directly engaged in the manufacture of white salt from brine.	SCOURGER -	A cab-driver who treats his horse with undue severity.
SALVAGE WORK	All work connected with vessels grounded or gone ashore, such as endeavouring to get them off the beach or rocks and to float them into a dock for repairs.	SCOURING -	A process done by a <i>scouring-machine</i> , that is, a machine consisting of two large rollers, by means of which the cloth is passed through a trough containing a certain solution, and is cleansed thereby.
SAMPLE PASSER	A proficient smelter who chemically tests a sample of metal drawn from the furnace when to the eye it seems about the desired quality; he also orders it to be cast when it is in the requisite state.	SCRAPING -	Cleaning the spars of a ship and parts of the hull with a small piece of sharp iron, steel, or glass.
		SCRAP IRON WORK }	In a large shipyard there is always an amount of small pieces of iron called <i>scraps</i> . In Government yards, where they do not sell old boilers, &c., these are broken up and the pieces are placed in heaps (scrap heaps) and sold as old iron. Men employed at this are said to be on <i>scrap iron work</i> .
		SCRAPS -	When the bottom of a puddling furnace requires renewing, malleable scrap-iron is put in and burned up till the bottom is covered with a coating of silica. This operation is termed "putting <i>scraps</i> on" or "making a bottom." The term <i>scrap iron</i> includes all bad steel and the shavings off angle bars, plates, &c., when they are cut to their proper dimensions.

Term.	Definition.	Term.	Definition.
SCREENERS OR SORRENMEN }	Men at bank who shovel the coals over the flat of the screens into the waggons and clean them, <i>i.e.</i> , pick out the pyrite stones (composed of iron and sulphur), foul coal, brasses, and other impurities. The screen is a frame 4 or 5 feet wide and from 12 to 15 feet long, the upper side of which inclines from the settle-boards down to the top of the waggon. It is furnished with iron or metal bars placed at a distance of from a quarter to three-quarters of an inch apart, upon which the coals are teemed as they are drawn out of the pit. The coals which pass over the screen are sent away as merchantable; and the small coal which passes through between the bars falls into a small hopper or box, whence it is taken to the apparatus to undergo a second screening.	SEALS - -	A pile out fabric having a cotton back and silk pile face. It is usually made from Tussah silk, and is dyed a dark brown or black to imitate the real seal skins.
SCREENING -	The act of passing coal over screens or sieves, which are fixed or movable, in order to extract the dust.	SEAM - -	A stratum or bed of coal. (<i>See</i> diagrams I. to VI.)
SCREW COLLERS	Steamers employed in carrying coal and driven by a screw.	SEAMERS - -	Workers (females) of machines for joining or <i>seaming</i> together the selvage fabrics (<i>i.e.</i> , fabrics with a woven border of closer work) used in making socks and stockings.
SCREWING -	(a.) The uniting by screw bolts and nuts the component parts of a structure. (b.) The operation of cutting a screw thread upon a bolt or in a nut, plate, or piece of metal.	SEAM RIP -	The ripping or tearing of the seams or joints of a boiler, caused by a too sudden expansion or contraction, &c.
SCREWING MACHINE }	Standard screw machine used in the boot and shoe industry.	SECOND-CLASS BOATS }	An inferior class of "deep-sea tugs" (<i>see</i> definition) as distinct from the "third-class boats" which do river work only.
SCRIBBLING -	After wool has been "sorted," "washed," "dried," "teazed," or "willeyed" (to loosen the locks "felt" by the washing), "burred" (when necessary to remove seeds, &c.), "blended" (in grades and colours), and "oiled" (to soften and reduce friction), it is <i>scribbled</i> , which is a process in the nature of "carding." The <i>scribbling-engine</i> consists of series of combinations of rollers clothed with "cards" (fine smooth wire-points to the number of 56,000,000) to which the wool is fed, and divided into its fibres without breakage, and crossed and blended into a mixture of homogeneous density. Thus the natural order of the fibres is rearranged, so as readily afterwards to take the form of a thread. <i>Scribbling</i> does not lay them in parallel lines, but mixes and crosses all the fibres long and short, curly and straight, uniformly, and a steel wire comb or doffing-knife, the width of the roller, with a shaving-stroke to the surface of the last card-roller, removes them in a continuous fleecy web, ready to be rolled into the "sliver" (or first stage of the untwisted yarn) by the "condenser."	SECTIONAL IRON	<i>See</i> definition under "iron."
SCRIBBLING MACHINES }	Machines which prepare the blended raw materials for the condensers in the wool industry. (<i>See</i> "scribbling" above.)	SECURING -	Fixing and securing the piles used in pier-building, &c., in a vertical position by means of timber, shores, struts (supports), and braces (used for holding together).
SCUPPERS -	<i>Scuppers</i> are (a) the openings or channels in the upper deck of ships intended to carry off water that may be thrown over from the sea or used in washing the decks; and (b) also the pipes for conveying the waste water and matter from the intermediate and protective deck to the bilges. <i>Scuppers</i> are similar to sink, bath, and other waste pipes in domestic use.	SEED-CRUSHERS	(a.) The <i>master seed-crusher</i> is the proprietor of a mill for crushing seed and thereby extracting the oil. (b.) A <i>workman seed-crusher</i> is one engaged in the manipulation of cotton seed, linseed, and the like, in a seed-crushing mill.
SCURFING RETORTS }	Removing from the retorts the accumulations of hard carbon which form from time to time, in the interior of the retorts.	SELF-ACTORS -	Spinning machinery driven wholly by steam power.
SCUTCH-MILL -	A flax <i>scutch-mill</i> is a building where flax is received from the field and the fibre separated from the husk by the action of fluted rollers and other machinery preparatory to the spinning.	SEMI-DRIED BRICKS }	Bricks manufactured from clay, one half dry and the other half damp. This method dispenses with the use of water and the grinding of clay which is required for other kinds of bricks.
SEABORNE COAL	<i>See</i> definition under "coal."	SET - -	A <i>set</i> is the quantity of seed placed in the press or machinery, &c., the manipulation of which occupies from 15 to 30 minutes and forms one operation.
		SET-OUT TUB -	A tub of coal insufficiently filled by a miner. The hewer who fills the tub prefers usually to forfeit payment for it rather than to reduce his average by reckoning the short weight.
		SETT ¹ -	<i>Sett stone</i> is a quality of stone composed chiefly of granite, and largely used for street-paving purposes.
		SETT ² - -	A piece of bar-iron bent to the same curvature or shape that an iron pipe is required to take. The question whether the fitter should make the <i>sett</i> and the plumber bend the pipe to the shape is one of the disputed points with regard to the demarcation of shipbuilding work.
		SETT ³ - -	A <i>sett</i> consists of one scribbler and one condenser.
		SETTER - -	A <i>bargain-setter</i> (or <i>letter</i>) is the official who <i>sets</i> or <i>lets</i> the contract to the quarrymen.
		SETTER OUT -	An under or assistant foreman of joiners or leading joiner, whose work is to accurately <i>set</i> or <i>line</i> out every detail of each piece of joinery. He also measures off the quantities of material required, and must be well versed in architect's drawings and specifications.
		SETTERS - -	The men in the baking industry who <i>set</i> , <i>i.e.</i> , put the bread into the oven.
		SETTING - -	Sometimes termed "letting," is a term used in the slate industry, and means agreeing upon a contract for a month. The quarrymen work on a portion of rock 9 yards

Term.	Definition.	Term.	Definition.
	wide, with the height of the gallery varying from 50 to 60 feet; this is called their "bargain," and is <i>re-let</i> or <i>re-set</i> to them every month at a certain price, which may or may not vary each month.	SHEAR MEN	Men who put iron or steel into the <i>shears</i> (i.e., a machine for cutting hot or cold iron or steel), and square it and cut it into the required lengths before sending it into the shipyard.
SETTING OF THE BRICK }	The fixing of the bricks in the kiln.	SHEARS	A pair of <i>shears</i> are two spars lashed together at the upper ends with the lower ends apart, erected to lift any weight where a single spar is insufficient.
SETTING-OFF	Duplicating the iron plates from the "template" (see definition), that is, marking upon the surface of a plate the position and number of holes that have to be punched through it; also lining off the exact size and shape required to make it fit its position on the ship.	SHEATHING SHIPS }	The operation of fitting wood over steel decks and over the bottoms of steel and iron ships from the load-line down to the keel. The bottoms of ships are <i>sheathed</i> to permit their being coppered or covered with yellow metal (a composition of two-thirds copper and one-third zinc).
SETTING THE SPONGE }	In the baking industry the universal practice of putting together yeast (see definition), water and flour for the purpose of fermentation previous to making the dough for bread is termed <i>setting the sponge</i> , "stirring up," and "fermenting." The late Mr. Nevill, of London, adopted the plan of putting the yeast, water, salt, and flour together and making the dough without the sponge stage, but the system does not appear to recommend itself to those who wish to have fine-looking bread where appearance is necessary for competition in the open market.	SHEERS	An engine consisting of two or three spars or columns either of wood, iron, or steel, erected for the purpose of putting on board ships the masts, guns, boilers, and such heavy weights. Some <i>sheers</i> are fixed at a certain angle, but others can be raised or dropped perpendicularly.
SETTING TREES	The placing of timber props to support the roof in a coal mine.	SHEET MAKERS	Manufacturers who work <i>sheet mills</i> , as distinguished from plates and strip mills.
SETTING TYPE	See definition under "hand setting."	SHEET ROYAL	A stone used in the printing industry, 25 by 19 inches in size; the thickness is the same as a "sheet crown" (see definition of "crown stone").
SETT QUARRIES	A number of mines or quarries taken on lease.	SHEETS	This term distinguishes the thinner from the thicker plates used in ship-building and engine-building; a plate one-eighth of an inch in thickness would be called a <i>sheet</i> ; above that thickness it would be called a "plate."
SET WAGES	A fixed weekly wage, apart altogether from piece-work.	SHELL-PLATERS	See definition of "inside platers" under "platers."
SHAFTING	The axle tree (usually running the length of the building) of the band wheels by means of which the bands transmit the motion to the saws. (See also definition of "lengths of shafting.")	SHELL-PLATING	The series of shell plates (also called "skin plates" or "shells") that are fitted and rivetted to the ribs of the ship. These are caulked and made water-tight before the ship is launched.
SHALE	A geological term for blue lias formation, i.e., a formation of argillaceous limestone, &c., underlying the oolitic system, and exhibiting a laminated structure split up more or less perfectly in the line of bedding. It is generally found adjacent to coal, sometimes forming the roof, sometimes the floor of the seam.	SHELLS	The outside scantling or skin of a vessel ranging from keel to gunwale and from stem to stern.
SHARE BARGES	See definition under "barges."	SHERATON WORK	See definition under "work."
SWEARING ¹	The cutting or lopping-off (in the ship-building industry) of any surplus material after the exact size of plate required is outlined. The machine for this purpose may be either a double-ended steam shearing machine, or a combination shearing and punching machine. (See definition of "punching.")	SHIFTERS ¹	Shift-men, i.e., underground workmen employed at miscellaneous work, such as timbering, keeping the rolley-way, taking up bottom stone or taking down top to make height where necessary, setting doors, building stoppings, clearing falls of stones, &c.
SHEARING ²	When the plates made in the copper industry are rolled in the "breaking down roll" (see definition) they have to be cut up into pieces with a <i>shears</i> , and this work is known as <i>shearing</i> . When the sheets have passed through the "drawing-on rolls," and before they go to the "finishing rolls," they have to be cut to pattern and to weight. Also, when the sheet is rolled out to its proper length and width, all the rough edges have to be removed; this work is also known as <i>shearing</i> . Again all sheets and platers have to be cut to a gauge, and this work is also called <i>shearing</i> .	SHIFTERS ²	Children (frequently half-timers) who <i>shift</i> the full bobbins from the roving frames used in the jute industry, and replace them with empty ones. <i>Shifters</i> are supervised by the "forewoman of the shifters," a responsible post and the highest paid to which spinners attain.
SHEARING MACHINE }	A machine having knives to remove the rough fibre from the face of mats, a process preceding the finishing-off by hand.	SHIFTMEN	Term synonymous with "oncost men" (see definition).
		SHIFTING MONEY }	See definition under "money."
		SHIFT SYSTEMS	<i>Double shift.</i> —The <i>double</i> or <i>night shift</i> system is that of working a pit both night and day, with two sets of hewers and one set of "repairers," each working a specified number of hours. <i>Single shift.</i> —Under the <i>single</i> or <i>day shift</i> system only one set of hewers are worked, the repairing work being done by night. <i>Foreshifts and Backshifts.</i> —One set or shift go underground early in the morning at 4.30 or 5 a.m.; these are called

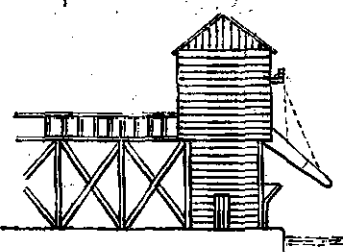
Term.	Definition.	Term.	Definition.
	<p>"foreshift men." The second set go underground about 9 a.m., and are called "backshift men."</p> <p><i>Nightshift.</i>—Term used to denote the third set of men who, under the double-shift system, work during the night.</p> <p><i>Off-hand shift.</i>—When a man, usually paid for his work by the yard, score, or ton, is temporarily consigned to do some other work at a fixed datal wages, he is said to be working an <i>off-hand shift</i>. Such men would consist of stonemen, shifters, and tub loaders. This term is in use in North of England mines, and is synonymous with the Scotch term "oncost labour."</p>		<p>iron, and steel—a branch of skilled mechanics who serve an apprenticeship of six or seven years. In the evidence the term <i>shipwrights</i> is used in two senses. (a.) It is used in the universal sense, when referring to the class of men in private shipyards frequently spoken of as "carpenters" (<i>see definition</i>) or ship carpenters, whose duties vary somewhat in different localities but generally relate to woodwork, though they frequently include placing frames and beams of iron, steel, or composite ships in position, and securing them, fitting and fixing armour plates, and several other jobs of a similar character. Some of these duties are preparing the blocks in which the keel of a ship is laid, and afterwards cutting off all props, &c., necessary for holding up the iron plates or ribs whilst the "shell" (<i>see definition</i>) is being built up, fitting up sailors' bunks, laying all decks and ceiling, setting up staging, laying the ways for launching, and generally executing all the rough and heavy woodwork about a ship, and connected with its construction. (b.) It is also used in the local sense in which it is understood in the dockyards, as applied to a class of artisans whose duties include all those of (a) and, in addition, the preparation, fitting, and fixing in place of all the interior structural arrangements of ships; the plating of ships; the preparation, fitting, and securing of all pumping, ventilation, and drainage arrangements; the fitting of sliding water-tight door frames, sluice valves, torpedo tubes, and all castings which penetrate a ship's bottom, decks, or sides; the manufacture of all hinged water-tight doors, scuttles, gun ports, and armour gratings; the sheathing of iron or steel ships with wood and copper or other metal; the entire work of building wooden ships when required; the planking of composite ships; the lying, securing, and caulking of wood decks over the thickness (e.g., 1½ ins.) specified in the "joiners'" lists of demarcation of work; ["caulkers" (<i>see definition</i>)] are regularly employed at caulking wood decks, but shipwrights are also expected to do that work when required;] the work of trimming and fastening wood backing for armour plates, and the fixing and securing of armour plates; the manufacture of masts and spars for ships, whether made of wood or iron; the building of boats; and a variety of other occupations. Until a few years ago dockyard shipwrights' duties were even more extensive, for they then did a great deal of the machine work now performed by skilled labourers; the bending of frames and plates now executed by blacksmiths was also performed by them, as was the curving and bending of armour plates, now executed by the manufacturers, to moulds supplied. <i>Shipwrights</i> also make the patterns for all pieces of work which they fit in place, and of which castings are required. They also supply to smiths moulds or sketches of all forgings required, measure the plates and mark them for the "drillers" (<i>see definition</i>), and instruct the "rivetters" (<i>see definition</i>) as to the size of bolt required, &c. Latterly, too, some few <i>shipwrights</i> who, being ex-dockyard apprentices, and, as such, having served one year of their apprenticeship at the fitters' shop, have been retained there, and are employed making sliding water-tight doors. Much of the work above enumerated is included in the term "fitting" (<i>see definition</i>); and the workers in iron and steel are frequently termed "iron shipbuilders" (<i>see definition</i>).</p>
SHINGLERS	Men who, by means of large steam or other hammers, <i>shingle</i> or shape puddled iron bars, or steel, to the required size for entering the "rolls" (<i>see definition</i>).		
SHIPBUILDERS	<p>(a.) The term <i>shipbuilders</i>, as applied to employers, denotes owners and managers of establishments for building ships either of wood or of iron.</p> <p>(b.) The term <i>shipbuilders</i>, as applied to workmen, comprises all the skilled classes engaged in the construction of ships, such as shipwrights, joiners, carpenters, fitters, rivetters, caulkers, drillers, platers, moulders, &c.</p>		
SHIPBUILDING	<i>Shipbuilding</i> , as distinguished from "marine engineering" (<i>see definition</i>), consists of the construction of the hull, masts and spars, cabins, &c., also arranging and fitting up outfit of all vessels.		
SHIPBUILDING DEPARTMENT	See definition under "departments in a shipbuilding yard."		
SHIP CARPENTERS	See definition of "carpenters."		
SHIP JOINERS	See definition of "joiners."		
SHIPMEN	In this case the term <i>shipmen</i> applies to coal porters who unload ships as distinct from those who work in barges or at railways or coal merchants' wharves. (C. 27,839.)		
SHIPPERS	Used here to denote the men employed in putting cargo on board a ship. Used generally to denote merchants who ship their own cargo, or agents who contract to ship cargo. (B. 11,553, 13,551.)		
SHIPPING SMITHS	See definition under "smiths."		
SHIPS' CASTINGS	Cast-iron work used in the construction of ships' hulls.		
SHIPS' HUSBAND	Here used as a synonym of "chandler" (<i>see definition</i>). Generally used in reference to a person, such as an old sea captain, appointed by a shipowner as a marine superintendent, to see that all needful repairs are done, and that proper stores are put on board a vessel previous to her starting on a voyage. (B. 11,299, 11,301, 14,137-8, 14,754.)		
SHIP SMITHS	See definition under "smiths."		
SHIPS' PLUMBERS	See definition under "plumbers."		
SHIPS' WAYS	The longitudinal timbers laid under a ship, and on which the cradle is built up for launching her into the water.		
SHIPWRIGHTS	The term <i>shipwrights</i> was formerly applied to the builders of the old wooden vessels, but though the introduction of iron and steel shipbuilding has almost abolished wooden shipbuilding the term has been retained, and is now applied in private firms to workers in wood, and in Her Majesty's Dockyards to workers in wood.		
SHIPTARDS	The yards where vessels are built.		
SHODDY	A technical term in use in the heavy woollen district of Yorkshire, of which Dewsbury and Batley form the centre.		

Term.	Definition.	Term.	Definition.
	It refers to the material made from soft all-wool rags, without much twist in them, such as socks and stockings, torn up into shreds, and odds and ends of all sorts imported from the Continent as distinct from the material made from newly manufactured woollens or cottons.	SHOVELLING } WORK }	A term applying to gas-works where no machinery or scoops are used for charging the "retorts" (<i>see</i> definition).
SHOKING } SMITHS }	<i>See</i> definition under "smiths."	SHOWFUL -	Another term for hansom cab, which was named after its inventor, Mr. Hansom.
SHOOTING ¹	The process by which the iron which is to form the "bolster" (<i>see</i> definition) and "tang" (<i>see</i> definition) in a genuine hand-forged table blade is welded to the steel of the blade.	SHUNTER } ENGINE } DRIVERS }	This term is applied to the drivers of engines employed in stations and yards, whose sole duty is the shunting of vehicles into suitable order for making up trains for despatch.
SHOOTING ²	The operation of emptying the sacks of coal into the consumer's cellars or stores.	SHUNTERS -	This term is applied to men at large passenger stations, whose duties are to attend to the shunting and coupling and uncoupling of carriages, &c., for arrangement into trains as required.
SHOOTING } FLOUR }	In the baking industry the flour loft is usually over the bakehouse and oven, and the flour is emptied down the shoot through the floor out of the sacks or bags straight into the troughs in which the dough is made. This operation is universally termed <i>shooting flour</i> .	SIDE AND } MAIN DRAINS }	A modern invention instead of "scuppers" and "bilges" (<i>see</i> definitions) on board of the war ships recently built.
SHOOTS -	Sometimes spelt "shutes," are movable iron spouts (attached to the "tip"), down which the coals are dropped into the ship's hold. This term is principally used in Wales; in the North of England it is called a <i>spout</i> . (<i>See</i> definition of "upshoot.")	SIDE-MINDERS -	Young persons (all females) whose duties are to piece up the ends in the spinning frame.
SHOP-DAY	A technical term used on railways to mean a day off work.	SIDE-PIECERS -	Boys about 16 are called "little piecers"; and young men from about 16 to 21 are called "big piecers"; these develop into mule-spinners. They are termed <i>piecers</i> because they assist the mule-spinner or minder in <i>piecing</i> up broken threads.
SHOPS -	<i>Black shop</i> .—Abbreviation for <i>blackleg shop</i> , a shop which is blocked to unionists by the employer who objects to employ unionist labour. <i>Blacksmith's shop</i> .—The workshop of a blacksmith where the furnace and anvil, &c., is situated. <i>Boiler shop</i> .—A workshop where iron boilers for steam-engines are constructed from boiler plates (flat sheets of iron) as bought to complete tested boilers. <i>Bridge shop</i> .—A workshop where bridges are erected. <i>Erecting shop</i> .—The shop which receives the main parts of engines from the "fitting shops," and in which those parts are erected or put together. <i>Fitting shop</i> .—The shop in which the parts of engines for small machines are prepared in detail by handwork with files and chisels. <i>Smith's shop</i> .— <i>See</i> definition of "blacksmith's shop." <i>Tool shop</i> .—The shop in which the larger parts of the engines are prepared.	SIDES -	A term used to denote the number of spindles on one side of a spinning or two-folding frame which is "minded" or attended to by a spinner or twister. The number of spindles in spinning and two-folding frame varies in accordance with the width of the mills in which they are placed, but the standard of payment is by <i>sides</i> .
SHOP } STEWARDS } AND CON- } TRACTORS }	Men appointed either by the squad in which they are working or by the lodge or branch of the association to which they belong to collect members subscriptions, to call all meetings of the squad in the case of any grievances, and to act as overseers or agents of the branch, although appeals against the decision can be addressed to a general meeting of the members.	SIDE STRIKER -	A person who <i>strikes</i> on chain with a sledge hammer, and who assists the "welder" (<i>see</i> definition) generally.
SHORE -	The expression to <i>shore vessels</i> is in general use among shipwrights, and means to put temporary stints (<i>i.e.</i> , pieces of timber obliquely placed to support a rafter) at the sides of vessels to keep them upright and in position.	SIEMENS } MARTIN } PROCESS }	<i>See</i> definition under "processes in steel making."
SHORED UP	The operation resorted to in the case of buildings considered unsafe by a surveyor, or when works are undergoing extensive alteration, by propping the walls with "die squares" (heavy timbers), "stretchers," "needles," brick "grips," "dog-irons," and "collar straps," shoring wedges, &c.	SILICA -	Pure <i>silicic acid</i> , <i>i.e.</i> , a composition of silicon with oxygen, a light white powder, inodorous and insipid. Rock crystal, flint, and other varieties of quartz, are nearly pure <i>silicic acid</i> .
		SILVER BUFFING	A process by which the men called <i>silver buffers</i> remove all the surface marks found on the article in course of manufacture. It is done by bringing the metal into contact with a piece of leather having a smooth surface and swiftly revolving in a machine with a constant application of Kent sand. This process takes place before the article is silver-plated.
		SILVER FINING -	A process by which the men called <i>silver filers</i> remove the rough edges or surface of spoons and forks before they are "buffed" (<i>see</i> definition of "silver buffing"). This process applies to cast work as distinct from that which is wrought.
		SILVER } FINISHING }	A very delicate process by which the men called <i>silver finishers</i> remove every mark or scratch found upon the finished plated article, and perfect the colour as nearly as possible.
		SILVERSMITH -	After the bodies and parts of silver goods have been shaped by the "stamping" process (<i>see</i> definition) the <i>silversmith</i> puts them together, completing the structural process and practically making the article. In the Britannia metal trade the workman corresponding to the <i>silversmith</i> is called the "maker up" (<i>see</i> definition).

Term.	Definition.	Term.	Definition.
SILVER STAMPING	The process by which hollow ware (such as teapot bodies) is produced. A steel die is cut the shape of the article required and put under a heavy stamp, which presses the "die" and forces it into the same shape; thus it is ready for making up. It is the first process after the metal is produced.	SLATE BILL	The original payment due to a slate quarryman upon which poundage is reckoned at so much per thousand slates.
SINGLE CYLINDER MACHINES	See definition of "Wharfedale machines."	SLATE CLUB SYSTEM	A club formed for mutual benefits and worked on a system of which the cardinal principle is that any balance shall be divided at the end of each year, by this means wiping everything off the slate and making a fresh start. (See definition under "Birmingham system.")
SINGLE OR DAY SHIFT	See definition under "shift systems."	SLATERS	Artisans who fix the <i>slates</i> and tiles for the covering of buildings.
SIZE	A glutinous substance made up of various ingredients, used in dressing warps to make them smoother and stronger, thus preparing them for the process of weaving. Formerly this was done to strengthen the threads only, and make them better to weave, but latterly, it is alleged, considerably more of this glutinous substance has been added by some firms, with the object of making the cloth heavier and fuller, to meet the demand of some foreign market, though it is a system of adulteration.	SLATE VEINS	The layer of argillaceous (<i>i.e.</i> , of the nature of clay) schist (<i>Gr.</i> <i>σχιστος</i> , split) or mountain rock, a stone which readily splits into plates. (At the Dinorwic quarries there are five distinct veins.)
SKIN PLATES	See definition of "shell plating."	SLAYING	After the warp has been taken through the "healds" it is drawn through the weavers' "reed" or <i>slay</i> by a reed hook or slay knife, two threads through each dent or split of the reed for plain cloth, three, four, five, or six threads through one interval for different makes. " <i>Slayers</i> " do this work (see diagram XVII.).
SKIP	A large strong basket used in a cotton or woollen mill.	SLIDES	Coverings to an opening in a kiln used in the blast furnace industry, so constituted that on being withdrawn, they allow the material in the kiln to fill a barrow placed underneath. When the barrow is full the supply can be stopped with ease by replacing the slide. <i>Slides</i> are in general use in England, but not in Scotland.
SKIPS	<i>Skips</i> are a kind of bucket used for lifting coals from barges. Patent skips or "grabs" (see definition) are self-filling, and have simply to be lowered into the coals.	SLINGERS	When armour plates, stem pieces, propeller sections, and other heavy material, require cutting, shaping, planing, drilling, punching, &c., they have to be placed upon the machine for that purpose. Many of the pieces are awkward in shape, and these must be hoisted and deposited by means of a chain and slings. The man who puts them on the slings is called the <i>slinger</i> . He is responsible for the safety of the article and also of the machine upon which it is to be put. The operation is termed <i>slinging</i> . After the article is raised, a "traveller," <i>i.e.</i> , a travelling crane, is generally used to convey it into position, since such a crane can be made to move both the length and breadth of the shop. "Steam travellers" (see definition), however, are sometimes used.
SKIP WORK	See definition under "work."	SLIP	A narrow dock or place having a gradual descent on the bank of a river convenient for shipbuilding and for hauling up a ship.
SLAB	A <i>slab</i> used in the printing industry, is generally made of iron; it takes ink from one roller and feeds the other rollers used for inking the type.	SLIPS	A synonym with cleavages, <i>i.e.</i> , natural slanting breaks forming smooth partings in a seam of coal. These breaks generally run parallel to each other at distances varying from a few inches to a few feet, and sometimes extending into the roof or floor. (See diagrams II. and III.)
SLAB TRUCK	A truck (usually running along a tramway) on which the men place slate blocks or slabs. <i>Slate slabs</i> are sheets or plates of slate. Those of first quality are sawn all round and split as near the thickness required as possible. Sorted slabs are of all lengths and breadths. Some slabs are sawn to order. Ended slabs are those sawn at the ends only. Second-quality slabs are unplanned.	SLIPWAY	(a.) The timber construction upon which a new ship is built. (b.) A patent slip by means of which a vessel can be hauled out of the water for painting or repairs.
SLACK COAL	See definition under "coal."	SLIVER	Cotton as it comes out of each machine from the carding machine onwards. When it finally reaches the spinner it has developed into thread.
SLAG	The refuse produced when limestone and ironstone are mixed in a blast furnace; also vitreous matter which collects on the sides and bars of furnaces, and of boiler fires, produced from the earthy matter of iron ore. Blast-furnace slags are essentially silicates of lime and alumina, frequently called cinder.	SLOPERS	<i>Slopers</i> or <i>sloping retorts</i> , used in gas-making, are retorts of the new system built in a slanting manner so that the coal will run down them instead of having to be thrown in with a shovel or put in with a scoop.
SLAGGERS	Those in the blast furnace industry who attend to the <i>slag</i> as it is run down the trough prepared for it into bogies or ladles (<i>i.e.</i> , large vessels used for receiving steel, &c., in a molten state as it comes from the converter) to be carried away. Their work is called <i>slagging</i> .		
SLAKED	To <i>slake lime</i> is to apply water to burned limestone so as to make it into a powder by chemical action.		
SLAPPING	Breaking out openings in a solid work in operation in building.		
SLAPPING AND BANGING	The opening or closing of the lock doors on rivers and canals and winding or lowering of the lock paddles or sluice gates (for raising or lowering the boats) without care or respect for life, boats, cargo, or property.		

Term.	Definition.	Term.	Definition.
SLOP-DASH WORK }	The production of the jerry builder; scamping.		
SLOP TRADE	Orders received from wholesale clothing houses making ready-mades, suits, and overcoats.		
SLOTTERS	Workmen engaged in engineering who tend a machine which has a vertical slide or movable parts whereon is fixed a steel tool which cuts, or <i>slots off</i> , portions of the material on which it is operating.		
SLOW-BOATS	See definition under "boats."		
SLUBBING ¹	A <i>slub</i> is a part of a thread that is thicker than another part. <i>Slubbing</i> is (combed) wool brought to the dyehouse to be dyed before manufacture into pieces.		
SLUBBING ²	Reducing the "sliver" in thickness by taking it from the drawing or carding machines and passing it through the <i>slubbing frame</i> . This process of thinning is the first process in which the sliver is placed upon a bobbin, and it is continued with finer frames (called "intermediate" frames) and still finer (called "roving" frames), until finally the sliver is thread ready for "spinning."		
SLUGGER	A machine which makes and drives into the bottoms of boots very thick rivets or sprigs called <i>slugs</i> , muds, or studs, to make the soles wear longer.		
SLUMMING	A slang term applied to the action of gaugers (see definition of "gauging") in the Royal Arsenal, &c., when they pass cartridges by the handful instead of submitting them to the proper tests.		
SLUMPED	The expression, as here used, means "aggregated." That is, instead of detailing the hours for each day, the Witness gave the aggregate number of hours worked in one week or in one fortnight. (B. 26,511.)		
SMALL CHAIN TRADE }	This branch includes all sizes, from No. 12 W.G. (wire gauge, a steel disc with numerous slots which are numbered from No. 0, largest size, downward to about 80) to 0 W.G.		
SMALL COAL	See definition under "coal."		
SMALL RIVER BOATS }	See definition under "boats."		
SMALL RUNNERS	See definition under "cokemen."		
SMALL SLOOP	A term applied to English vessels with one mast, used for coasting purposes. A <i>sloop</i> is usually under 100 tons.		
SMART-MONEY	See definition under "money."		
SMELTERS	The furnace men who <i>smelt</i> the pig-iron, and convert it into ingots of steel for boiler plates or shipbuilding purposes.		
SMELTING DEPARTMENT }	The department where the raw material, such as ores, is smelted furnace after furnace until it becomes pure copper and ready to be worked in the mills or finishing department. The men working in this department are called <i>smelters</i> .		
SMITHS	<i>Smiths</i> as distinguished from <i>pansmiths</i> (see definition) are the ordinary blacksmiths or general smiths. The term <i>smiths</i> has been used throughout the evidence as an abbreviation for "blacksmiths" (see definition), but it may also include "whitesmiths," i.e., tinsmiths and workers in metals who finish off iron work.		
		SMITHS' SHOP	See definition under "shops."
		SMOKE INSPECTORS }	Government inspectors who have legal right to enter any mill at any time and examine the furnaces, economisers, &c.
		SNAP	A suspension of work for half-an-hour for refreshment by the colliers in a Leicester mine. The time when <i>snap</i> is taken is usually from 11.30 to 12 a.m. In Durham and Northumberland it is termed "bait-time."
		SNATCHING	<i>Snatching a victory</i> by getting an advance in wages. The method employed is to choose a time when the masters are divided in opinion as to the wisdom of giving or resisting the demand for an increase in wages.
			<i>Angle-iron smiths</i> .—Smiths whose work is almost exclusively confined to manipulating, forging, and welding <i>angle iron</i> , i.e., iron rolled in an angle pattern (thus > T Z), or "bulb iron" (see diagram VII.), used for making different parts of a vessel, boilers, bridges, girders, &c. <i>Angle smiths</i> , as they are commonly called, work in fires as blacksmiths do. <i>Blacksmiths</i> .—In the shipbuilding and engineering industries the duties of <i>blacksmiths</i> or <i>smiths</i> (skilled tradesmen) comprise the forging or rough initial manufacture out of iron or steel of a great many of the wrought portions of a ship's hull and fittings (whether formed of solid materials or iron or steel angles), portions of machinery, repairs of machine tools and hand tools for iron work, iron pillars, rails of stanchions, block bindings, hooks, boats' davits, &c. The bending of frames, the bevelling and a considerable part of the bending of iron and steel angles, and the bending of twisted plates, although formerly the work of shipwrights, now form part of a <i>blacksmith's</i> duties. As illustrating the distinction between the work of a "shipwright" (see definition) and that of a <i>smith</i> , it may be said that it was generally sufficient to determine whether the iron or steel material of which the job is composed needed to be heated (by forge, fire, and furnaces) in the course of manufacture. If so, the work belonged to a <i>smith</i> , but if the material could be wrought cold, it was the shipwright's duty to do it. "Shipwrights" are now, however, more generally known as ship's carpenters, and <i>blacksmiths</i> do all their former work. <i>Boiler-smiths</i> .—See under "flangers." <i>Coppersmiths</i> .—Smiths working in copper, chiefly employed in locomotive and shipbuilding establishments; they make cupelas or domes, bend and fix copper and other pipes in the engines, make the huge air-tubes for the ship, &c. <i>Coppersmiths</i> frequently combine the trade of brazier and tinplate worker. <i>Country smiths</i> .—Blacksmiths in rural districts engaged in shoeing horses, repairing agricultural implements, &c. <i>Engine smiths</i> .—Smiths who devote themselves entirely to "engine forgings." <i>Jobbing smiths</i> .—Smiths who work either at the forge or at the vice, and are largely engaged on building material and house furnishing. <i>Ship smiths</i> .—Smiths who devote themselves entirely to the "spar and mast mounting" and to "forgings" for the keels of ships and to similar purely technical work connected with shipbuilding. <i>Shipping smiths</i> .—A term here used as synonymous with "ship smiths." (A. 23,533.) <i>Shoeing smiths</i> .—Smiths who devote themselves entirely to shoeing horses.

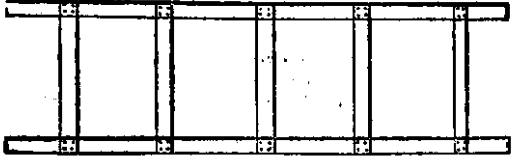
Term.	Definition.	Term.	Definition.
SNIGGING -	Term used in the hosiery industry to describe cases in which the thread is partly cut and escapes the notice of the menders; it is caused chiefly by the fashioning points when the yarn comes off the spool or bobbin rather tight.	SPELLER WORKERS } -	More properly called zinc-workers, are men in the chemical industry working at the furnaces but on a different system from smelting. They condense the raw material ores in pots and pipes, and in this way turn it into metal; less work is required for zinc than for copper. <i>Speller</i> is the impure zinc used for commercial purposes.
SODA FINISHERS	The workmen employed in the department where soda ash is finally treated, and the last of various processes necessary for the manufacture of the article completed.	SPEM CANDLE	Pure wax candles composed of a white, transparent, brittle, lamellar (disposed in thin layers or scales), crystalline, mass which separates from the oil obtained, from the head matter of the spermaceti whale, together with about 30 per cent. of bees' wax added to prevent crystallisation. They are used to test the strength of gas by photometer; a seven-inch jet of gas is compared in volume to so many sperm candles.
SOFT OR MANUFACTURING COAL	<i>See</i> definition under "coal."	SPEW-OUT -	The emanation similar to treacle of the glucose from the uppers or leather when kept for a time.
SOFT ROLLS -	<i>See</i> definition under "rolls."	SPIKES - -	Large nails more than five inches long in the shanks.
SOLDERERS -	Men in the Royal Arsenal who <i>solder</i> tins and cases for ammunition, i.e., apply the solder, a metallic cement consisting of an alloy which has an affinity for both metals to be united.	SPIKE TRADE -	This branch includes all kinds of wrought or hand-made <i>spikes</i> (<i>see</i> definition) from 4 to 12 inches long, and also "railway," "chair," and "dog" spikes.
SORTER - -	The <i>bottle-sorter</i> is a man in the glass bottle industry who examines the bottles when they reach the warehouse to see that they are perfect and of good quality as regards workmanship and colour.	SPILCING -	A trade term applied usually to a brick (machine made) which on being exposed to the weather becomes dry, crusts, and gradually falls away.
SPADE WORK -	In the chemical industry filling bleaching powder into barrels with a spade.	SPINNERS - -	Women employed on the frames spinning or twisting flax, tow, or jute into the different sizes of yarn.
SPALES - -	<i>Spales for packing cotton</i> in are a subordinate branch in the lath-wood industry. In the Manchester district lath-cleavers are occupied to some extent in making spales. The same tools, and a similar manual operation is necessary for the hand-splitting of "packing laths" as for the hand-splitting of building laths. The term <i>spales</i> designates technically a strip of wood thinner than a building lath. The word is used for this purpose in Lancashire and in Scotland.	SPINNING FRAME MINDERS } -	Children employed in watching spinning throistles or frames, on which yarn is spun, and in piecing up or <i>mindin'</i> broken ends or threads.
SPALLERS - -	Women who, with a mallet, break the tin-ore as it comes from the mine-shaft into small pieces; the operation is called "spalling."	SPINNING MULE	A machine also called the "self-actor," being entirely automatic in its movements, which completes the spinning of the yarn, and winds it on the spindle in a "cop" or cylindrical coil, conical at each end. It consists of a fixed part, creel, roller-beam, &c., and a traversing part or carriage which runs out about 64 inches, drawing out and spinning the "roving" to the required fineness, then runs back winding the spun yarn on the spindles. The newest mules contain as many as 1,200 to 1,500 spindles.
SPAN - -	A length of chain or wire rope used for suspending "derricks" (<i>see</i> definition and diagram XIII.) to the masts of ships. The <i>span of a crane</i> is the distance from the crane post to the crane chain.	SPIRIT TRADE -	A term used in the coopering industry to denote the work connected with the making of casks for holding spirits and such liquors.
SPARS - -	The term "spars and rigging" includes all the masts, yards, and standing and running rigging in use on board ships of every rig and size. "Standing rigging" is used for keeping the masts in their proper position, and "running rigging" for manœuvring the vessel at sea. (<i>See</i> diagrams XV. and XVI., and also definition of "fitting the standing and running rigging.")	SPLICING A HAWSER OR ROPE } -	The operation of interweaving the separated strands of two ends of a tow-line or rope so as to make a clean strong joint free from knots.
SPECIES FACTI -	The particular character of the thing done.—The peculiar circumstances attending any act or transaction are termed the <i>species facti</i> . Thus in libelling a theft, the Public Prosecutor avers that the prisoner on a certain day and at a specified place, feloniously appropriated a certain thing then in the lawful possession of a certain person; and that (where the crime is aggravated by house-breaking) he did so by entering a house in a certain specified manner. Or in libelling a murder, he must aver the time, place, and manner, in which the crime was perpetrated, as by assailing the deceased with a lethal weapon, by administering a certain poison, &c. These constitute the <i>species facti</i> of the crime.	SPLITS - -	The radiating passages through which the main current of air ventilating a mine is subdivided or <i>split</i> up for circulation.
SPELTER - -	A mixture of lead and zinc used in the table knife trade of Sheffield. It is very injurious to the workers owing to its poisonous properties.	SPLITTERS -	The workmen in a slate quarry who split the slate blocks into thin layers or cakes.
		SPONGE -	<i>See</i> definition under "setting the sponge."
		SPONGING MONEY } -	<i>See</i> definition under "money."
		SPRAGGING -	Building up <i>sprags</i> or "gibs," i.e., short trees or props used for supporting the

Term.	Definition.	Term.	Definition.
	coal during the process of undermining or holing it, in order to keep it from falling on the collier.	STAITHS -	A mechanical construction for shooting coal into holds of vessels, worked by balance weights. (See following diagram).
SPRAGS -	Short props to support undercut coal. They are also termed "gibs."		
SPREADERS -	Women who spread the softened jute on the card.		
SPRIGGER -	A machine used in the boot industry to make and drive rivets or <i>sprigs</i> into the goods to hold the parts together. The term is also applied to boys who cannot fit on the parts but can only <i>sprig</i> them together, while acting as assistants to the "rivetter."		
SQUAD -	The group or body of workmen employed at a building job. Thus an employer having several jobs or building contracts in progress at the same time employs several separate squads, one to each particular job. (See definition of "weigher.")		STALL -
SQUEEZE -	See definition of "creep" and diagram I.	STAMPERS -	Presses formerly used in the seed-crushing industry, but now an obsolete piece of machinery. <i>Stampers</i> acted on the principle of a pile-driver <i>stamping</i> oil from seed.
STABBER -	A candle-holder used by the trimmers.	STANCHIONS -	The <i>iron stanchions</i> in shipbuilding are the upright iron pillars or supports to which the rails are fixed. <i>Stanchions</i> are also made of wood. (See definition of "man-ropes.")
'STAB WAGES -	Wages earned by men in the printing industry regularly engaged on the <i>establishment</i> (contracted into 'stab') and therefore earning fixed weekly wages, i.e., a "set" wage. 'Stab wages' are the opposite of "piece" wages, which naturally fluctuate according to the work done. The work for which 'stab wages' are paid is termed 'stab work.'	STANDARD SCREWER } -	An American machine for screwing the rivets into boots instead of having them driven in by hand.
STAFF -	A train <i>staff</i> is a metal <i>staff</i> which has the stations at each end of the sections (see definition of "block system") engraved upon it and is carried upon the engine between those stations only. It is also the key of the staff box at either end, from which "tickets" can be obtained to send on trains, the staff following by the last train.	STANDING CHARGES } -	Expenses that cannot be debited to a particular article, such as rent, taxes, management, travelling, agents' commission, &c.
STAGE -	A <i>stage</i> on canals is the distance between one coal "staith" and another. A staith is a line of rails projecting over the canal from which coal is loaded into vessels.	STAPLE (Shorter and Longer) } -	As applied to raw cotton, wool, flax, &c., means the length of the individual fibre in the fleece, the <i>web</i> of wool or hair being formed of the aggregation of such fibres.
STAGE CARRIAGE -	A 'bus or other public conveyance which performs stated journeys. (See definition of "hackney carriage.")	STARR -	See definition of "nap."
STAGE-MAKING -	Whilst a ship is being constructed <i>stages</i> have to be erected upon which the men work. <i>Stages</i> are made of spars slung by ropes from beams overhead and planks placed from one to another. Inside the ship they are built as circumstances permit.	STATIONARY AND PORTABLE DRIVERS } -	See definition under "drivers."
STAGES OF THE MACHINES } -	A square piece of iron fixed to a printing machine on which the "layer-on" stands to feed the machine, which is high. The Witness recommends wooden stages with a ladder attached, and fixed to the top of the machine with a grip of iron so that the labourer cannot slip. (C. 28,459.)	S. T. DRIVERS -	Abbreviated expression for the cab-drivers employed at the yard belonging to Lord Shrewsbury and Talbot.
STAGING -	Narrow platforms upon which workmen sit or stand whilst executing work in elevated positions. They are usually made by placing two planks, 10 inches broad by 2 inches thick, side by side. These are bound together by cross pieces of wood, and the whole is suspended in position by ropes or chains.	STEAM BOATS -	See definition under "boats."
		STEAM COAL -	See definition under "coal."
		STEAM CRANES -	Machines worked by steam power, for raising heavy weights and moving them to a distance.
		STEAM-ENGINE MAKERS } -	See definition of "fitters'."
		STEAM, NAVY, AND GRAB DRIVERS } -	See definition under "drivers."
		STEAM PLOUGHING TACKLE } -	Machines for ploughing by means of steam-engines.
		STEAM TRAVELLERS } -	Travelling cranes working on a tramway upon scaffolding, for lifting stones or heavy materials.
		STEAM TRAWLERS AND SAILING TRAWLERS } -	A <i>steam trawler</i> is a fishing vessel usually built of iron, and propelled by means of steam power, in contra-distinction to a <i>sailing trawler</i> which is propelled by sails only. Also a <i>steam trawler</i> carries two trawls, one on either side, and when one trawl is hauled up the other is immediately put down, as the two trawls are never used at once. A <i>sailing trawler</i> , on the other hand, carries but one trawl.

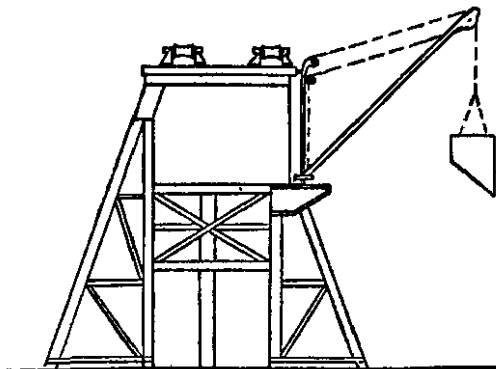
Term.	Definition.	Term.	Definition.
STEEL CASTINGS	Castings are any parts of a construction in shipbuilding or engineering which are made by pouring steel in a liquid state in moulds. Castings were formerly made of iron, but are now superseded by steel. <i>Steel castings</i> take much longer to make than iron castings, through having to be annealed (cooled slowly) and from other causes.		stone and acid from which chlorine gas is obtained. Men who are in charge of the <i>stills</i> are called <i>stillmen</i> .
STEEL INGOT	A mass of steel formed by the molten metal being run into a cast-iron mould. In shape it is generally square at the bottom, and tapers slightly its full length, which admits of its being easily turned out of the mould when cool.	STINT	An allotted portion of work; for instance, if a man is engaged to work for eight hours, and a certain quantity of work given him to perform in that time, he is said to be working by <i>stint</i> . The term is used in questions 15,487, 17,262, 17,266, (A.), to indicate the number of heats a puddler works during day or night. It is generally six, but in the better class of iron five only.
STEEL WORKERS	Men employed at Bessemer converters or open hearth furnaces.	STINT-HOLER	The man who undercuts the coal by "piece" (see definition of "holers' day").
STEEP MEASURES	A description of the seams of coal on the South crop (or "outcrop," see definition) in South Wales, which are highly inclined; that is, dip from the outcrop at angles varying from 45° to 10°. The term may also be in use in North Staffordshire, where the dip is similar to that of South Wales; but where the dip is greater the seams are termed "rearers."	STITCHERS	Workers (females) of machines for stitching together two sides of fabrics to form the feet of socks and stockings.
STEM	The circular piece of timber to which the two sides of a vessel are connected at the fore end: the prow. (See diagram IX.)	STOCKINGERS	Men who make stockings in the old stocking-frames. (A local term.)
STEMMED	A term used in the quarrying industry to express that the employees have had posted to their credit the time they have worked.	STOCK-TAKERS	The men who keep account of the working of iron or of the iron and coal and fettling used in the process of working malleable iron.
STEREOTYPE PLATES	Cast-metal plates, obtained by running type metal in a liquid state into a mould taken from the type when ready for printing, thus releasing a certain weight of type and enabling a work to be kept in print at a smaller expense.	STOKERS ¹	Labourers in attendance on a boiler or other furnace for the purpose of feeding it with coal or other fuel, and giving the boiler such other attention as may be necessary.
STERN POST	The straight piece of timber to which the two sides of a vessel are connected at the after end (the extremity of the keel), and which supports the rudder. (See diagram IX.)	STOKERS ²	The men in the gas-making industry who draw and charge the retorts when the coal is put into the retorts with a shovel.
STERN SHEETS	Nearly all coal barges are without cabins, but have a sort of rough deck in place of the ordinary cabin top, where the barge-man stands to steer either by tiller or by oar. This after part of a boat is called the <i>stern sheets</i> .	STONE	<i>Dressed stone</i> .—Hewn or chiselled stone, generally used by architects; for instance, brick buildings frequently have stone dressings. <i>Worked stone</i> .—All stone worked by the masons and ready for buildings, synonymous with dressed stone.
STEVEDORES	Men employed in loading and discharging, i.e., stowing cargo on board ship for export and removing imported cargo. The arrangement of merchandise in ships' holds so that as much as possible may be packed in, so that the weight may be well distributed, and so that no damage may occur during the voyage, requires experience and a certain amount of skill in the men as well as in the foremen. It is this, together with the great care required in discharging (unpacking), which makes the difference between the stevedore and the ordinary "dock labourer." In the London district <i>stevedores</i> are employed in loading only, in other ports they both load and discharge.	STONE CAUNCHES OR CANCHES	The step-like projection in the roof or floor, the removal whereof is necessitated by the thinness of the seam of coal, which does not give sufficient height for the passage of men or ponies. The portion of stone which is removed from the roof is called <i>top-caunch</i> , and that from the floor <i>bottom-caunch</i> .
STICKING MOULDINGS	The mechanical operation of forming either by hand or machinery the <i>mouldings</i> used in building.	STONE HEADINGS	Drivages other than coal formed in stone. [<i>Drivages</i> are tunnelling through any description of ground other than coal beds that may be met with in mining.]
STIFFENER	The person who, after the hat has been sewn, applies it to a <i>stiffening</i> or gelatine to make it firm, and to allow it to be properly fitted to the required shape.	STONEMASONS	Artisans who prepare and fix all stone required in the building trade; the term is usually applied indiscriminately to both stone-builders and stone-hewers.
STILLS	Small chambers six or seven feet square, made from a hard Yorkshire stone. In them are placed quantities of manganese	STONEMEN	Men more or less regularly employed in a mine in stone-drifting or in taking down top-stone, or taking up bottom, to give sufficient height for the tubs or horses to travel. Such work is usually paid by the yard when working "bargain-work."
		STONE PREPARERS	"Polishers" and "grainers" in the printing industry (see definitions).
		STONE SHIFTERS	Men in the printing industry who lift the stone in and out of the presses and machines.
		STOOP	A pillar of coal. Coal is usually worked by either the <i>stoop and room</i> system or the <i>long-wall</i> system. In the <i>stoop and room</i> the seam is divided into pillars called <i>stoops</i> by passages at right angles to each other called <i>rooms</i> ; these pillars are afterwards extracted by an operation called "stooping." In <i>long-wall</i> (see definition) the whole of the coal is removed in one operation. (Term peculiar to Scotland only.)

Term.	Definition.	Term.	Definition.
STROOPING	Removing <i>stoops</i> , i.e., the coal-pillars left to support the roof while the main body of the coal is being mined. It is a very dangerous occupation.		
STOPPERING	<i>Stoppering</i> is the grinding of glass stoppers to fit the necks of bottles such as are used by chemists, druggists, &c., by machinery, the use of water, sand, and emery. The grinding of glass balls for aerated water bottles (Codd's glass ball stoppered bottles) is an easy process in comparison with <i>stoppering</i> . The operation of grinding consists in removing a small excrescence left on a small portion of the balls after they are chipped from the waste metal. Grinding is necessary to make the stoppers and balls even and round.		
STOPPER PRESSES	The <i>stopper press</i> is a machine used in making the glass stoppers used instead of corks or bungs. Molten metal is poured into a mould by a ladle and pressed down by means of a lever. The waste metal is then chipped off while the ball is in a semi-molten state. The process is hot since the metal and moulds give off much heat.		
STOP-WAGGONS	A term used in Scotland and South Wales when there is a stoppage of work owing to a scarcity of the trucks or waggons by which coal is conveyed from the collieries; equivalent to the English term <i>play-day</i> .		
STORAGE	The price paid or charged for keeping goods in store.		
STOREHOUSEMEN	Each <i>storehouseman</i> in Her Majesty's Dockyards has a separate and defined charge of all stores of a particular class, and of that section of the storehouses in which they are stowed. Naval stores are classified under the following subheads:— a. Timber: Sub-divisions 1-10: 3 shipwrights—storehousemen—employed. b. Metal and metal articles: Sub-divisions— 1-6: 1 storehouseman 1 labourer employed. 7-12: " " " 13-20: " " " 21-22, 24-29: " " " and 1 wharf labourer. 30-36: 1 storehouseman, 1 labourer. c. Coals: Sub-divisions 1-3: 2 storehousemen. d. Hemp, canvas, textile fabrics, &c. Sub-divisions 1-13: 4 storehousemen, 6 labourers. e. Paint and miscellaneous articles: Sub-divisions 1-31: 4 storehousemen, 6 labourers. f. Electrical, and torpedo and other apparatus: Sub-division 1-7: 1 storehouseman, 1 labourer, and 1 boy. To preserve the above classification, accuracy and intelligence is required with regard to stowage, issues, stocktaking, &c. The <i>storehouseman</i> is responsible for seeing that the articles in his charge are classified and arranged in the order in which they appear in the authorised list of stores, &c. and in such manner—in equal numbers, weights, &c.—that stock may be readily and quickly taken; that the description and pattern number of the articles are painted on each compartment or bin, &c. in which they are stowed; and also that stores are carefully stowed. Care must also be taken to practice economy by systematically issuing stores, that is, issuing the oldest in stock, the longest manufactured, broken quantities, ullages, repaired articles, &c., before the more recent stock; by preserving stock as well as possible; e.g., woollen goods from moths, from goods from rust, ash goods from worms, &c.	STOREHOUSE LABOURERS	Further a <i>storehouseman</i> has clerical duties connected with the daily dealing with receipts, vouchers, issue notes and return notes, all of which have to be deposited in the storekeeper's office; and also with the transportation of goods for shipment. Other duties may be briefly classified under the heads of:— Renewal of stock. Posting in ledgers of all daily transactions. Periodical examination of stores. Restriction of stores on floors to the prescribed weight per superficial foot. The wages of 2nd class storehousemen are 24s. per week, for five years, 27s. per week for next five years, then continuing at a maximum of 30s. unless he passes into 1st class, when he receives 33s. after another five years, and 36s. at the end of 10 years as a 1st class man. Special rate 39s.: one only is in receipt of this maximum.
		STOREKEEPER	A highly responsible dockyard official, in charge of all the stores, and under whom are foremen of storehouses and storemen. (See definition of "storehousemen.")
		STOREMEN	See definition of "storehousemen" above.
		STOVE	Barges employed carrying goods have a <i>stove</i> fixed in the cabin; the <i>stoves</i> are not all of the same size, but a good fire can be kept up in any one of them.
		STOVED SALT	Boiled salt drawn out of the pans, put into wooden moulds, and afterwards taken into <i>stoves</i> or hot-houses for the purpose of being thoroughly dried. All table salt is <i>stoved salt</i> .
		STOVE MEN AND WOMEN	Stove men are the men in the chemical industry who put the dishes into the stove and ladle the lead into them. The women carry the dishes and hand them to the men. The stove used is called a wet stove. In the dry stove the men draw out the dishes and pack the lead (now in the proper state for white paint) in casks, the women carrying it.
		STOW	The packing of the cargo in a ship in such a manner that all possible space is utilised, but with the primary object of preventing the cargo moving during bad weather when the ship is at sea.
		STOWERS	Those engaged in stowing, that is, removing refuse material from falls and stone-drifts in a coal mine to an old working-place, or to one driven especially for the purpose.
		STOWING THE TOPSAIL	The act of making the topsail (see definition) fast with ropes, performed by sailors who go up the rigging on to the yard.
		STRAIGHTENING	Putting rails under the press to <i>straighten</i> them when they have become bent in cooling.
		STRAIGHT HOBIERY	Articles made by cutting up into lengths a long seamless piece (made by a steam roundabout) and stitching upon them a

Term.	Definition.	Term.	Definition.
	stocking foot or sheet sleeve. In this process no fashioning, not even with scissors, is done.	SULPHATE OF SODA } -	The residue of salt after boiling in sulphuric acid to make hydrochloric gas and then being dried in open or closed furnaces is termed <i>sulphate of soda</i> . It is used in the manufacture of soda.
STRAPPERS -	There is a system in vogue at the docks by which the conveyance of goods from the dock-quays to the piling grounds is done by contractors. The workers under this contract system are experienced deal-porters, and elect one of themselves to act as leader; but all share equally whatever payment is obtained. Sometimes they require more men, and these are called <i>strappers</i> ; they receive from 10d. to 1s. per hour as wages, but do not participate in a share of the profits made by the original contractors.	SULPHUR BURNERS } -	The closed furnaces or kilns (constructed of bricks and large iron plates with bracing iron rods to prevent expansion) in which sulphur dioxide is procured by burning either iron pyrites or copper pyrites or sulphur. When the ore has merged into a viscous mass a bar is inserted through a hole in the front of the oven, and the ore is by this means hoisted up to enable it to burn better and produce more sulphur di-oxide.
STRAPPING PIPES AND TUBES } -	To <i>strap</i> is to fix in position all water, gas, ventilating or steam, &c., tubes to their place (in shipbuilding) by means of iron straps or straps of other material. The "strapping" is secured to the bulkheads, beams, brattices (partitions), &c., by means of bolts.	SULPHURIC ACID -	See definition of "vitriol."
STRAPS -	Lengths of wood, either round or flat and from four to eight feet long, placed up to the roof and across the working places of a mine. At either end they are supported by props called legs.	SURFACE HANDS -	Those employed in or about the top of the pits, consisting of banksmen, screeners branch horse-drivers, labourers, &c.
STRIKE ALIEMENT } -	Money paid by trade unions to their members locked-out or on strike.	SURFACEMEN ¹ -	Men employed about a colliery, above ground.
STRIKERS -	Unskilled assistants to smiths (<i>see</i> definition) engaged in manual labour. <i>Strikers</i> are more usually termed "hammermen" (<i>see</i> definition).	SURFACEMEN ² -	Otherwise known as "miles-men," are platelayers, <i>i.e.</i> , men who lay and maintain the permanent-way of the railway (the rails and sleepers).
STRINGERS -	A term used in the shipbuilding industry to denote the margin of plating stronger than deck plating laid on the end of beams adjoining the shell.	SWABBING -	That which is swept up by the <i>swab</i> , a mop used for cleaning the floors in woollen mills.
STRING IN LENGTH } -	Is three yards three inches of warp. It is a method of measurement of work in the weaving trade to be paid by the piece at so much per string.	SWIVEL-BARS -	A particular class of waggon used for carrying long iron or timber.
STRIPPER -	The man who <i>strips</i> the cards or leather combs of fluff.	TABLE-LOADERS -	Terms synonymous with "lift-loaders" (<i>see</i> definition).
STUFFING PLACE -	The place, most convenient to the place where the dyeing is carried on, in which the dye wares are kept mixed ready for use.	TACKER -	One who puts in the tacks used in "lasting" (<i>see</i> definition).
STUFF SHOES -	Shoes of which the tops or upper parts are made from "lasting" (<i>see</i> definition of "lasting shoes"), cashmere, or fancy cloth. This is a generic term.	TACKLERS -	Men employed as overlookers in weaving-sheds, with the special duty of repairing or <i>tackling</i> looms when out of order.
SUB -	Money paid to workmen at the Scotch blast-furnaces on account, as there exists a monthly pay-day. To <i>sub</i> in the cotton and woollen industries is to obtain a portion of the price that would be due to the weaver for a piece wholly woven. Some pieces of cloth cannot be finished in one week, therefore a weaver must either do without wages or <i>sub</i> .	TAKERS OFF -	The boys and girls in the printing industry employed in "taking off" (<i>see</i> definition).
SUBBING -	A term used to express the part payment to a workman of wages due on the task work system when the work is not finished, or of wages in advance paid at an hourly rate, the payment in the first instance being made to oblige the workmen, and in the second for the master's own reasons.	TAKING COPY -	Copy necessary for the production of matter for a newspaper is supplied direct from the advertising or editorial departments to the foreman of the case-room, who in turn hands portions of the same to the men employed, the men thus <i>taking copy</i> .
SUBSISTENCE MONEY } -	See definition under "money."	TAKING OFF -	In the printing industry taking the sheets off the cylinder after having been round and over the stone as described in the definition of "feeding the machines."
SULPHATE OF LIME } -	<i>Sulphate of lime</i> is made by dissolving salt cake in water, then mixing with chloride of lime. It is used principally for increasing weight of paper and cloth, and similar adulterative purposes.	TALLY -	A check account made by a person receiving goods; here used for the number of bricks or tons of other goods carried on canal boats and river barges. (B. 18,902-3.)
		TANG -	That portion of a knife blade to which the handle is attached.
		TANK-BARGES -	Barges used specially for conveying tar and oil in bulk in large tanks fitted or built in the barges.
		TANKERS -	The men in the coal trade who fill with coal the tanks which are lowered by cranes into the holds of the vessel discharging.
		TANK-MAKING -	The construction of cisterns, reservoirs, and such receptacles made of plate-iron, placed in the hold of a vessel and used for storing water, oil, &c.

Term.	Definition.	Term.	Definition.
TANK MEN ¹	Men employed in large steamers to look after the water tanks.	TEAMSTERS	Men who drive a team, consisting of one, two, three, or four horses. This term is usually used to denote rural drivers, but is here equally applicable to denote the London carman.
TANK MEN ²	Another term for "coal fillers" (see definition of "filler ³ ").	TEAZER	A machine used for bleeding purposes.
TANK PIPES	See definition under "pipes."	TEEMERS	Men employed at the top of the coal-shoots by means of which coal is tipped into the hold of the vessel.
TANKS	Enclosed spaces at the bottom of a ship running the whole length (but for convenience divided into compartments) between the "skin" (see definition of "shell plating"), and the plating fitted on the top of floors (flat the same as decks) on which the cargo rests. Tanks are used for holding water as ballast when the vessel is light or has no cargo. The tank top forms a second bottom in case the "skin" is damaged (see definition of "double bottoms"). (See diagram VIII.)	TEMPERING	A process of watering and mixing the clay for hand-made bricks, which obviates the necessity of grinding.
TAPERS	Those in the cotton mills who take a number of "beams" or bobbins as they come from the warper, generally four or five, but sometimes more, and run them through the "size" upon another beam (called the weaver's beam). When this process is complete, the produce is called a "warp." The machine used by the taper is called the <i>tape-sizing</i> machine.	TEMPLATES	(a.) In the shipbuilding industry <i>templates</i> are wooden moulds usually of rectangular form used by platers in "marking" and "setting off" iron and steel plates. (See definitions; see also following diagram.) (b.) In the plumbing industry <i>templates</i> are patterns to which large pipes are bent. "Joiners" sometimes make their <i>templates</i> of wood; "plumbers" make theirs of $\frac{1}{4}$ -inch iron rod or pipe.
TAPPING-OUT	Running off the molten iron from the furnaces into the pig moulds made in the sand. This is done by driving a steel bar through a plug of fire-slag (known as the <i>tapping-hole</i>) in the furnace, and then withdrawing it, thus permitting the molten metal to flow in an unintermittent stream into the moulds beneath.		
TARE	The <i>tare</i> of the tub is the weight of the empty tub or hutch used in conveying the coals or other minerals from the working-face to the surface. After weighing, the <i>tare</i> is deducted from the gross weight registered, the remainder being credited to the miner.	TENEMENT HOUSES	<i>Tenement houses</i> in Dublin are houses formerly occupied by gentlemen who have either left the country or who have gone to the suburbs to live. Such houses are generally four stories high, and are now occupied by about seven or eight families
TARRING	Application of tar by means of a brush or more frequently by hand to a ship's riggings and various other parts.	TENTERS	Assistants to the weaver, generally children, who have gone through a short process of probation, and have then been put to a weaver to assist him in weaving, he taking the responsibility of the work the <i>tenters</i> perform, and paying them out of his own earnings. Also the men engaged in regulating or <i>tenting</i> the women's looms, i.e., keeping them clean and in order, removing the web and substituting full bobbins of yarn for the empty ones.
TASK AND JOB WORK SYSTEM	The system of paying wages in the shipbuilding industry according to the number of plates put on a ship, and the number of rivets driven, as opposed to payment according to weight, viz., "tonnage system" (see definition).	THACKED UP	A local term for <i>thatched</i> , i.e., covered up with dried grass, straw, palm leaves, or other vegetable materials.
TASKMASTER	One who takes work from the original contractor in the plastering industry, and sets a given quantity of work to be done in a certain time.	THICK COAL	See definition under "coal."
TASK-WORK	<i>Task-work</i> is work which takes two factors into account, viz., quantity and time; <i>piece-work</i> takes into account quantity only without reference to time; while <i>day-work</i> takes into account time only without reference to quantity. <i>Task-work</i> arises thus: a fixed price is given for certain work done (<i>piece-work</i>); according as the worker becomes expert and earns higher wages, in the same ratio is the price reduced, until a rate is reached at which, in the employer's opinion, a fair wage can be earned by a skilled worker; here the factor of time is introduced; <i>piece-work</i> becomes <i>task-work</i> , and the conditions are that a certain quantity of work done in a certain time is paid for at a fixed rate. Hence <i>task-work</i> may be defined as a combination of <i>piece-work</i> with <i>day-work</i> .	THIMBLE-RIGGED	An expression in general use descriptive of speculative operations in the stock, produce, or other markets by combination for other than legitimate trade or market requirements. Thus in a strike of miners the middleman might take advantage of the circumstance to raise the price of coal and create a panic, thus <i>rigging</i> the market.
TRAE	A hard, heavy, and durable timber (<i>tectonia grandis</i>) obtained from the West Indies, used for ship, waggon, carriage, and other building purposes.	THIN MINERS	Miners who get coal out of thin seams.
TEAM MONEY	See definition under "money."	THORNE TYPE-SETTING MACHINE	A labour-saving machine greatly increasing the working capacity of a compositor. It is also an automatic distributor, i.e., accomplishes without any assistance from the workers, the replacing of letters used previously into their proper position to be utilised again. This work had previously to be done by the compositor in his own time, and generally occupied about one quarter of the working week. The Thorne machine is operated on by two persons, and is worked by a key-board.
		THREADING A NUT	Here used in the case of screwing a nut on a piece of wrought iron pipe on which is a screw (spiral) thread (A. 25,548).
		THREE-DECKER	See diagram X.

Term.	Definition.	Term.	Definition.
THREE-FRAME WORK	Hosiery work fashioned upon a hand-machine or wrought machine, but practically made upon three different machines, the leg, the gusset (<i>i.e.</i> , a triangular piece of material inserted for the purpose of strengthening) and the foot, each being produced by a separate machine, and joined on the hand-machine.	TIN AND IRON PLATE WORKERS	<i>Tin-plate workers</i> (or <i>makers</i>) are those generally engaged in making tin vessels for culinary purposes, but who are not qualified to assist in the making of steam boilers or engines. The work of a <i>tin-plate worker</i> consists in rolling iron plates, passing them through various processes, and finally dipping them in molten tin; the tin-plates are then used for lining packing cases, making domestic utensils, and in America for roofing churches and dwelling-houses. <i>Iron-plate workers</i> are engaged in similarly manipulating thin iron-plates.
THREE STICKS	The common expression amongst sailors for the three masts of a vessel.	TIN-DRESSING	After the process of "spalling" (<i>see definition</i>) the mine agent decides whether the broken-up tin-ore is sufficiently good to send to the stamps, where it is ground fine, and then subjected to the action of water, by means of frames or "bundles," as they are locally called. <i>Tin-dressing</i> is the term applied to this last operation.
THROSTLE-SPINNER	A woman who has charge of the <i>throstle-frame</i> , a machine used in spinning cotton.	TINGLES	Also called <i>tacks</i> , <i>i.e.</i> , small nails very like a small tin-tack used by the benchmen in fastening the upper to the inner sole.
THWARTS	In the shipbuilding industry <i>thwarts</i> are pieces of strong timber, placed horizontally between the uprights, for the purpose of erecting staging for the use of the workmen.	TIN STREAMS	A <i>tin stream</i> (not stream) deals either with alluvial deposits or with the refuse of the mines (which, however treated, always contains more or less tin), and separates what is valuable and what is worthless by washing processes similar to that in a "dressing floors" (<i>see definition</i>). Though the highest and each successive "streamer" down the course of the river rifles it of as much tin as he can, there is always some tin still left, for when the river has poured itself into the sea the ground swell throws back upon the sand tin of good quality and well worth collection.
TICKET	<i>See explanation under definition of "staff."</i>	TIP	A lofty erection of wood and iron placed upon the quay wall at the side of the dock, and under which ships are placed to receive their cargoes of coal. (<i>See following diagram.</i>)
TICKLERS	Four small points firmly fixed into a piece of wood which are pressed upon the eyes of the needles and remove the stitches in the hosiery industry. This is the operation of <i>fashioning</i> . With steam-made hosiery six points are used to fashion further from the selvedge (<i>i.e.</i> , the edge or border).		
TIE IN THE DOCK	The method of mooring vessels by means of buoys, in use in harbours, bays, and rivers, in which vessels lie two or more abreast of each other.		
TIGHT SHOPS	Workshops in which <i>tight work</i> (<i>see definition</i>) is performed.		
TIGHT WORK	<i>See definition under "work."</i>		
TIMBERING	Propping up the roof or sides of a mine by means of planks and cogs, &c. (<i>See definition and diagram of "pair of timber."</i>)		
TIMBER-LEADER OR PLATE-LAYER	A person whose duty is to ensure the sufficiency of props, planks, brattice, and crown trees, supplied to each hewer in northern coal mines for purposes of safety and convenience in the coal hewing, and also to keep the air-currents in proximity to the face. When this occupation is amalgamated with that of plate-laying the <i>timber-leader</i> is also called a "plate-layer."		
TIMBERMEN ¹	Men who are permanently engaged in propping up the roofs and sides in the travelling roads of a mine when they are too weak to support themselves.		
TIMBERMEN ²	Men who discharge timber cargoes from ships, and stack timber on shore and upon raft on water.		
TIME-CHARTER	An agreement under which the owner hires his vessel for a stipulated monthly payment, generally in advance, in which case the charterer loads and discharges the vessel instead of the owners, and sometimes pays the crew also.		
TIMEKEEPERS ¹	It is the duty of a <i>timekeeper</i> in the Dinorwic quarries to assist the other officials of the department, and to "stem" (<i>see definition of "stemmed"</i>) or keep the men's time in his department.		
TIMEKEEPERS ²	Men in charge of the depôts from which tramway cars or omnibuses start. Their duties are to start the cars or 'buses at the proper time, to keep account of the men's times, and to hand the conductors the bundles of tickets, &c.		
TIME LOG	The printed statement of times allowed for making garments in the tailoring trade, agreed upon between employers and employed. The number of hours allowed to		

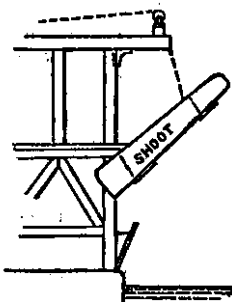


- TIPPERS¹ - Those who empty coal waggons or truck by *tipping* up one end.
- TIPPERS² - The men at the docks who *tip* the coal into the hold of a vessel by means of the hydraulic lifts on the quays called "tips."
- TIPS¹ - Screens or other arrangements upon which the mineral is upset from the tub or tram and conveyed into a waggon, cart, or boat.
- TIPS² - "Staiths" (*see definition and diagram*) or other erections with shoots into which the coal is emptied from waggons and the shot or *tipped* into the hold of the vessel.

Term.	Definition.	Term.	Definition.
	By some tips the waggon of coal is lowered down the hatch of the vessel, where the coal is started, and the empty waggon returns to the staith head.	TRACTION ENGINE } -	See definition under "engines."
TONGS -	Tongs are used in the copper industry for handling the hot sheets and plates. A roller man's tongs are about 36 inches long; a plate tongs are about the same length, but much heavier; a plate-furnace man's tongs are about 30 inches long; a drawing-on and finishing furnace man's tongs are about 48 inches long; the tongs used by the boys for raising behind the rolls are about 24 inches long; the pickler's tongs are about 60 inches long, and the tongs of the two boys washing and drying are about 18 inches long.	TRADER'S WAGGON } -	This is a waggon not belonging to a railway company, but supplied by a trader for his own traffic, which is consequently carried at a lower rate than if it had been carried in a waggon belonging to the company.
TONNAGE ¹ -	A system adopted in Her Majesty's Dock-yards, whereby the men are supposed to be paid according to the weight (number of tons) of material (iron or steel) they place per week on a vessel (that is, on the hull) during its construction. When the material used is wood the men are paid per foot, and this is termed "piece-work" system in contra-distinction to <i>tonnage</i> system.	TRADESMEN -	Here used to indicate the <i>men of a trade</i> , that is, the mechanics, such as smiths, carpenters, joiners, &c. (A. 25,843, 26,271), (C. 21,248-9, 21,404, 26,614), employed about a coal pit (A. 18,468, 18,512), and employed in the construction of railway carriages (B. 27,335).
TONNAGE ² -	A system in the paper trade of paying the workers as a bounty so much per 1,000 lbs., or so much above a given quantity of paper produced.	TRAMMERS -	Men or boys who remove the tubs or corves of coal from the miners' working-place to a main road or inclined plane.
TOOL-FACED FLAGS } -	Flags or flat stones chiselled by the masons at the quarries with a very wide tool called " <i>tooler</i> ."	TRAPS -	Also called " <i>smashes</i> " or " <i>mashes</i> ," are faults in weaving caused by the shuttle becoming <i>trapped</i> , which will break out the twist or warp threads for several inches in the width. To piece up these " <i>ends</i> " leaves an ugly place; therefore, if the weaving is continued this blemish has to be cut out and the piece seamed.
TOOL-MAKERS -	Manufacturers of machines for cutting metals used by engineers.	TRAPPER-BOY -	One who is engaged in opening and shutting <i>trap-doors</i> in the airways of a mine, when required to do so for the passage of tubs.
TOOL SHOP -	See definition under "shops."	TRAVELLING CRANES } -	Machines for hoisting heavy weights, which, being fitted with wheels and placed on rails fixed to overhead beams, can be moved, or travel, with the articles hoisted, from one end of the shop to the other.
TOP MAKERS -	Some woolstaplers are also " <i>top-makers</i> ," i.e., woolcombers. In woolcombing the long smooth fibres are combed out into " <i>tops</i> ," so called from the form in which the " <i>ribbon</i> " of wool is coiled upon its spindle being like a spinning top. The shorter wavy fibres are called " <i>noils</i> ."	TREBLES -	See definition of " <i>doubles</i> ."
TOPSAIL -	A square sail; the principal sail in a square-rigged ship, generally the last to be taken in during bad weather. In position it is the second sail from the deck. (See diagram XVI.)	TRIMMERS ¹ -	Men on board ship whose duty is to go into the coal bunkers of a vessel and to place the coals within reach of the fireman, whose rank is immediately above that of the trimmer. The name of <i>trimmers</i> is also applied to men employed at the docks (where a ship is discharging) in <i>trimming</i> , i.e., bringing grain in bulk from the ends of a ship to a point immediately below the hatchway, whence it is discharged from the ship by a different body of men, such as corn porters. When a ship is loading grain in bulk, the <i>trimmers</i> move the grain from the point under the hatchway to the ends of the ship.
TORPEDO DEFENCE WORK } -	See definition under "work."	TRIMMERS ² -	Skilled workmen engaged in shaping and pressing hosiery goods.
TORPEDO TUBES	<i>Torpedo tubes or ports</i> are fittings of a special character and design for firing torpedoes out through the ships' broad-sides, bows, and sterns, both below and above water.	TRIMMING CASTINGS } -	The operation of <i>trimming off</i> with chisel and file the " <i>runners</i> ," i.e., rough edges of metal castings.
TORPEDO WORK	See definition under "work."	TRIP MONEY -	See definition under "money."
Tow -	The waste fibres or refuse after carding flax and hemp, which is made into bags, sheeting, and yarn, and is used for other purposes, in this case for wiping pottery in a clay state. (C. 30,497.)	TRIP SYSTEM -	The <i>trip system</i> on railways is the equivalent of the piece-work system in productive industries. The men working a trip train are paid a full week's wages in respect of the time their train is calculated to keep them on duty during the week, but when serious delays occur through accident or other exceptional cause, the men are paid such an addition to the week's wages as fairly represents the extra work done. <i>Two-trip train</i> —The two-trip train is a mineral train for which no regular times of running are appointed, but which is intended to make two trips out and home during the day. <i>Three-trip train</i> —This train is worked in a similar manner to the two-trip train and is intended to make three trips out and home during the day.
TOWERS -	A new class of pottery workers, who, when plates that are still unfired are dried till nearly all the moisture is out of them, pass over the surface while they (the plates) are rotating on a wheel a piece of " <i>tow</i> ," or sardpaper, to make them smooth.		
TOWING-WORK	See definition under "work."		
TRACKMEN	Men who clean the groove of tramway rails with scoops, and when necessary sand or salt the track between the metals.		

Term.	Definition.	Term.	Definition.
TROUGH ¹	A <i>trough</i> in the printing industry is a box, lined with lead, with pieces of wood laid across for stones to rest on; the water runs off from the stone into the trough.	TURPS RAGS	Rags saturated with turpentine (a transparent resinous substance which flows from incisions made in the stems of trees, of the pine, larch, fir, &c., species) used in the printing industry for washing out work on stones. Turpentine is used for this purpose because it removes grease
TROUGH ²	A long hollow vessel made of iron in which runs the grindstone employed in the scissor grinding industry. Rent is paid for a trough, as there are several of them in one room, consequently it is customary to speak of the <i>trough</i> not only as the actual vessel indicated above, but as the place rented, <i>i.e.</i> , the portion of the room containing the <i>trough</i> . In this sense the term is local.	TWEAR	The pipe which conveys the hot blast into the furnace. It is surrounded by a large pipe, through which passes a constant flow of cold water to keep the <i>twear</i> cool.
TROUSER	To <i>trouser</i> is to put money into one's pocket, that is, to earn; a slang expression used by cabmen.	TWEEN DECKS	Abbreviation for <i>between decks</i> , used to denote the inside deck immediately below the main or upper deck. (See diagram X. and XI.)
TRUCKING	Giving or receiving payment in kind. In this case (in the nail trade) the workmen accept "breeze" (see definition), &c., instead of wages in cash. (A. 19,965-6, 20,014.)	TWILL	The pattern of a piece running diagonally from left to right.
TRUCK SYSTEM	The system by which as an equivalent for wages the workpeople draw goods out of a store. This system is therefore a part payment in kind, instead of a whole payment in cash, but is now illegal.	TWINNERS	Operative spinners who double yarn which has been spun by the common spinners. They do not form a large body of operatives.
TRUNNELS	<i>Trunnels</i> , more commonly called <i>treenails</i> , are wooden pins or plugs employed where metal bolts would be injurious, as in ship-building, for nailing planks to the timbers. A common size for such wooden pegs is $1\frac{1}{4}$ inch diameter.	TWIST	Yarn is generally divided into two classes called <i>twist</i> and <i>weft</i> respectively. <i>Twist</i> yarn is used for the <i>worps</i> which run lengthwise in a piece of cloth. <i>Weft</i> is the yarn which runs across a piece of cloth, being put into the cloth by the shuttle. <i>Twist</i> yarn is always made much stronger than <i>weft</i> , and is so called because more <i>twists</i> per inch are put into the yarn while being spun.
TRY-SAIL	A fore-and-aft sail set on the after part of a mast, and hoisted and set by means of spars and booms. It is of the same description as a <i>yacht's</i> principal sail.	TWISTING	<i>Twisting</i> , in this instance, is synonymous with turning, and means making wood look as though it was twisted, by turning it into screws, or by making a spiral groove with a steel tooth on the lathe, &c. (C 33,594.)
TUB LOADERS	Men who hew at night-time and on other occasions, while the pit is not drawing coals, and fill the empty tubs left in the pit.	TWO DECKER	See diagram XI.
TUNING	A term used in Yorkshire synonymous with the term "tackling" (used in Lancashire); it means repairing, &c., a loom when it breaks down and keeping it generally in order. These duties are performed by a special workman, called a "tuner," when it is a woman who works the loom.	TYPE LIFTING	<i>Type-lifting</i> and <i>type-setting</i> are synonymous terms, and apply to the operation of the compositor in setting-up types. The term <i>type-setting</i> is more frequently used than <i>type-lifting</i> , although both are good technical expressions.
TURN-CLAIMERS	The persons occupied in a coal-mine who possess the privilege of claiming a "ben" (see definition), that is, a tub to fill in turn, tubs being distributed to each miner in rotation.	TYPE-SETTING	See definition of "type-lifting."
TURNERS ¹	Skilled workmen in the engineering industry engaged in <i>turning</i> and attending to a lathe. When a <i>turner</i> himself holds the tool which cuts the iron or other material he is turning, he is termed a <i>hand tool turner</i> .	TYPO-GRAPHICAL PRINTERS	See definition under "printers."
TURNERS ²	Potters who shape pottery ware upon a lathe.	ULLAGES	Used by the Witness as a milder term than pilferage, in fact, a euphemism for thefts. Generally used to mean a quantity short of that mentioned in the invoice.*
TURNING ¹	The process of turning wood upon a "lathe" (see definition) by foot or steam-power in various articles, such as drawer-knobs, stair banisters, ornamental parts of book-cases, &c.	UNDER-CUTTING FIRMS	Here used to denote contractors in the engineering trade who make a practice of substituting faulty, or defective, for the best workmanship (boys and low-paid unskilled labour being employed), and inferior material instead of the good material specified in their contracts, thus cutting down cost of production, to enable them to undersell their competitors, who supply best material, and use skilled (highly paid) workmanship only (A. 23,166.)
TURNING ²	Work in the furniture trade produced by means of a lathe, such as a square block of wood rounded into a table leg with a square top. The men who do this work are called <i>turners</i> .	UNDER MONEY	See definition under "money."
TURN-OVER CONCERNS	Mills and machinery which have been worked for some years by private firms, and then sold or <i>turned over</i> to a limited liability company as distinguished from a concern which has been built with new machinery by the company.	UNHOOKERS	Old men or boys who stand on the plank connecting a ship with the dock and unhook the coal when it is in a stable
TURNOFF	An apprentice who has passed from one employer to another to finish learning his		

* Referring to this definition the "Daily News," on July 22nd, 1894, states that *ullage* is "well understood in the wine trade as meaning a deficiency in the contents of bottles or casks." The next day's issue contained some remarks by Mr. George Augustus Sala, to the effect that the term *ullage* is also applied by waiters at public dinners to "the small portions of wine or liquor left in glasses from which the main portion has been drunk."

Term.	Definition.	Term.	Definition.
	position on the back of the men who carry it to the waggon conveying it to the stores.	WAGGON-MEN	Men or boys in a mine who bring in the waggons to the face of the seam, and take them out again.
UNSTOWING OR BREAKING OUT	The act of conveying the goods packed in a ship from the place occupied whilst travelling to the square immediately under the hatchway, whence it is drawn up by a machine.	WAGGONING SKINT	The stint or station where the waggons belonging to a mine are stored.
UP-CAST SHAFT	The shaft in a mine up which the air returns after passing through the workings.	WAKE-TIME	An annual village feast lasting nearly a whole week. It commences in Leicestershire on the first Sunday in August.
UPPERS	The tops or upper portion of boots and shoes, in contra-distinction to the bottom or sole.	WALKING MONEY	See definition under "money."
UPRIGHTS	Timbers supporting a rafter; iron stanchions or pillars.	WALLERS	A local term, applied to salt boilers, <i>i.e.</i> , those who look after the boiling of the salt. It is applied to the men who look after the making of any white salt, whether the pan is required to boil or not. Doubtless the word is derived from the Saxon " <i>weallere</i> ," one who boils (from " <i>weallan</i> ," to boil); cf. Ger. <i>wallen</i> , to boil up or cause to boil.
UPSHOOT	To <i>up-shoot</i> is to hoist up the tip or shoot used in loading, so that it cannot be used. (See following diagram).	WARP	The produce obtained by the "tapers" from the process of running "beams" (<i>i.e.</i> large bobbins upon which are wound four or five hundred threads) through the size upon another beam, called the weaver's beam. A <i>warp</i> is generally from 500 to 1,000 yards in length.
		WARP DRESSERS	Those who dress the yarn preparatory to the process of weaving.
USER	Consumption of raw cotton.	WARPER ¹	Those in cotton mills who "beam the yarn," <i>i.e.</i> , take the bobbins from the winders, placing them in a machine, and wind up some four or five hundred of the threads, side by side, several thousand yards in length, upon what is called a warper's beam, something like a very large bobbin with a flanged roller.
VALVE MEN	Men engaged in the gas industry to regulate the valves controlling the inlet and outlet of "purifiers," gas-holders, &c., and also to regulate the valves and governors supplying the district.	WARPER ²	Women employed in reeling <i>warp yarns</i> from bobbins on to reels, before they are taken to the dressing machines.
VALVES	In the engineering and shipbuilding industries the term <i>valves</i> bears the usual significance of contrivances of various forms for controlling the flow, emission, or passage in pipes or vessels of steam, water, gas, air, or any of them, or any other fluid or vapour under pressure.	WARPING WOOF (OR BARS)	A frame of wood or iron, consisting of two uprights, each mounted with a series of pegs or pins, over which the threads are passed during the making of the warp. These uprights are connected by rails, from which project the "healding lease-pins" and the "footing leasepins." The weaving woof, as distinct from the warping mill, is adapted for warping by hand, and is 10 feet in length (= "one string").
VELVET	A fabric made from silk or cotton, with a close shaggy pile.	WARPS	The threads that lie lengthwise in any woven material, the produce obtained by the <i>tapers</i> from the process of running "beams" (<i>i.e.</i> , large bobbins upon which are wound 400 or 500 threads) through the size upon another beam, called the weaver's beam. A <i>warp</i> is generally from 500 to 1,000 yards in length; after being wound round rollers it is sent to the dye-house to dye, and is then crossed by the woof in weaving; thus a variety of colour is obtained.
VICE	(Fr. <i>vis</i> , a screw.) A large iron or wooden press with screws for holding articles fast while being filed or worked by smiths, &c. The <i>vice</i> is screwed to the bench at which the man works.	WASHERS	Men engaged in washing and cleaning tramcars and omnibuses and cabs; they are employed on night work, and also have to assist the driver to unharness the horses and put them in the stable.
VICE-MEN	Workmen who fit details of work together, at bench or "vice" (see definition), to form the complete article ready for use.	WASTEMEN	Generally old men who are employed in building pillars for the support of the roof in the waste, <i>i.e.</i> , old workings and airways; and in keeping the airways open and in good order.
VICTORIAS	Open carriages with a hood.	WASTERS	Men who are incapable of doing the work which they have contracted to do, or have been shipped to do by crimps, &c.
VITRIOL	Vitriol or sulphuric acid (H_2SO_4 , <i>i.e.</i> , a combination of sulphur, hydrogen, and oxygen) was first prepared by distilling ferrous sulphate or green vitriol. It is now extensively manufactured by passing into airy chambers made of sheets of lead, air, sulphur di-oxide (obtained by burning sulphur in air, or by roasting iron pyrites), nitrous fumes, and jets of steam. <i>Vitriol</i> is used in nearly all industries, but principally in chemical works for producing other chemicals, such as salt cake, a quantity of nitre (a salt) being added to increase its strength.	WASTES	To <i>draw wastes off the tips</i> is to clear the "tips" (see definition of "tips") of rubbish and worthless rock.
VITRIOL BURNERS	Men in the chemical industry who work at the furnaces for roasting iron pyrites to burn the sulphur free from iron, and thus produce sulphur di-oxide gas.		
VITRIOL MEN	Men in the chemical industry engaged in the preparation of vitriol.		

Term.	Definition.	Term.	Definition.
WASTREL PORTION } -	The comparatively useless portion of inferior workmen who are only employed when no better can be got; men who have proved themselves to be incapable of performing the operations of the trades they profess to have learnt.	WEIGHT ¹ -	A weight is the gradual or sudden lowering of the roof of a mine after the coal has been worked on the long-wall system.
WATCHING THE MARKS } -	It is necessary to <i>watch the marks</i> on a printing machine in order to lay the sheet true, otherwise the grippers on the cylinder will not catch it and a "miss" will be the result. A "miss" stops the machine and causes delay. (See definition of "missing the sheet.")	WEIGHT ² -	<i>Short, statute, or imperial weight.</i> — 2,240 lbs. to the ton (112 lbs. to the cwt.). <i>Long weight.</i> —2,400 lbs. to the ton (120 lbs. to the cwt.).
WATCHMEN -	Men (also called "non-freemen") who load and deliver goods from and to barges in docks or canals, and perform work very similar to that of lightermen (see definition ²), the difference being that lightermen are licensed to navigate barges on the river. The <i>watchman</i> has nothing to do with the goods until they are placed on the deck or in the hold of his barge, when he stows them. The duties of the <i>watchman</i> also include tallying (i.e., checking the goods), attending to the pump, and <i>watching</i> the work of the stevedores, dockers, or riverside labourers in connection with his particular barge.	WELDER -	The man who holds the tongs and directs the <i>welding</i> of the link, as distinguished from the "striker."
WATER-LOGGED	When a ship loaded with timber is full of water and yet is prevented from sinking by the cargo (being wood), she is said to be <i>water-logged</i> .	WELDON'S PLANT MEN } -	Men employed at Weldon's patent process for neutralising the acid used in the manufacture of bleaching powder.
WATERMEN ¹ -	<i>Watermen</i> properly include licensed "lightermen," being all who are freemen of the Watermen's Company, but the word may be used for boat and wherry men (i.e., river boatmen) only. The term is here used in its wider sense. (B. 17,090, 17,104.)	WELL-DECKER -	See diagram XII.
WATERMEN ² -	This term is here used to mean captains of barges and canal boats on rivers and canals; their duties are to superintend the navigation of the vessel and to employ the labourers to discharge their cargoes. (B. 28,393.)	WELSH COAL -	See definition under "coal."
WATERMEN ³ -	The term <i>watermen</i> here refers to the men who hang about public-houses at a 'bus terminus and earn a few pence watering the horses, &c. (B. 18,180.)	WELT -	A double piece at the bottom of a shirt or at the top of a stocking, put on both by hand and by machinery.
WAYLEAVES -	A rent charged for a right of way to carry minerals; in this case for the privilege of conveying from the pit (at the surface) to the boundary, coal worked from another royalty by outstrokes (encroachments) and drawn up the pit. (A. 18,991.)	WELTERS -	Those who make a <i>welt</i> , that is, turn up a piece of work and join it at the beginning of a stocking or end of a shirt.
WEAVERS -	Women employed in the manufacture of cloth.	WHACK -	Term used in the cab-driving industry synonymous with "gardener" (see definition).
WEB -	To <i>weave</i> .	WHARFDALE MACHINES } -	Single cylinder machines used in printing.
WEDGES -	A piece of metal, thick at one end and sloping to a thin edge at the other, used in splitting.	WHEELERS -	Men engaged in the manufacture of gas who wheel the coke into the yard after it is drawn from the retorts and quenched with water.
WEFT -	A certain kind of yarn as distinguished from twist yarn prepared for weaving (see definition of "twist").	WHIPPING TACKLE } -	The machinery used in the operation of "coal whipping" (see definition).
WEIGHER -	In the working squad of five men which undertakes the entire operation of weighing bulk grain, bagging it, and thereafter loading it into carts, &c., the <i>weigher</i> is the man who performs the operation of <i>weighing</i> a specific quantity into each sack. In doing this he assists in lifting the filled buckets in which the grain is weighed on to the hook of the weighing scale, adjusts the weight of grain in the bucket, and then tilts the bucket so as to transfer the grain from it to the bag.	WHIRLER -	A <i>whirler</i> is a disc or wheel upon which the makers of plates and other operative potters work when pressing or making the articles from the clay.
WEIGHING MACHINES } -	Machines used for weighing the coal out to the stokers, a system in use in some gas works.	WHISTLE TO WHISTLE } -	The steam whistle which in South Wales quarries sounds at the hour to commence work in the morning and to leave off at night. Thus the term <i>from whistle to whistle</i> is simply an expression for a day's work. In the morning the whistle sounds at the time when all the men should be on the property, <i>not</i> (as it is contended) at their working places, for they do not reach the latter for some 15 minutes afterwards.
		WHITE ASH FINISHERS } -	Men in the chemical industry who are engaged upon the manufacture of soda ash by means of furnaces from salts derived from black ash.
		WHITE ASH WHEELERS } -	Men in the chemical industry who wheel the ash from where it is deposited to the grinding mills.
		WHITE BEDS -	In the chemical industry women pile the white lead into stacks, called <i>white beds</i> , and carry it to the rollers.
		WHITE DRY -	Articles of pottery in the clay state are described as <i>white dry</i> when nearly all the moisture has been dried out of them.
		WHITE LEAD -	A carbonate of lead prepared by exposing sheets of blue or pig lead to the joint action of the vapour of acetic acid, air, and carbonic acid, which changes its colour from blue to white. The vapour of acetic acid (i.e., the pure acid of vinegar, composed of carbon, oxygen, and hydrogen) is obtained by treating tanners' barks with acid. The white lead is then mixed with linseed oil and forms the white paint (a zinc paint) used by colour makers, shipyard painters, and such classes of painters.

Term.	Definition.	Term.	Definition.
WHITE LEAD } GRINDERS }	In the chemical industry, after the lead goes through the rollers it is ground by millstones to a very fine powder. This operation is performed by men called <i>white lead grinders</i> .	WORK -	<i>Adams' work, Chippendale work, Sheraton work.</i> —The three best-known classes of designs in the furniture trade. Each of these names is applied to a distinct style of work, and is derived from the name of the designer. <i>Bracing work.</i> —The bracing here referred to consists of diagonal or vertical struts or supports of timber fitted to the piles or other wood-work used in shipbuilding to hold them in place. (A. 25,546.) <i>Hopper work.</i> —Work done at the docks by the assistance of hoppers. (See also "skip work" below.) <i>Intazzia work.</i> —Designs in the furniture trade of woodwork inlaid with metal or ivory. <i>Iron work.</i> —Work done by "shipwrights" (see definition); it is any work or part of work in the construction of a ship as distinguished from pure and simple wood-work. <i>Jigger work.</i> —Work done at the docks by the assistance of a <i>jigger</i> , that is, a loose chain worked not through the medium of a crane, but by hydraulic or steam power. <i>Loose work.</i> —Work at the docks in grain in bulk, i.e., not in sack or other packages. <i>Lump work.</i> —See definition under "lump work." <i>Marqueterie work.</i> —Designs in the furniture trade, and greatly in vogue at present. The term is applied to fancy cabinets and tables where the ground work is inlaid with another species of wood, and frequently with several different species. Thus in the centre of a rose-wood table an imitation of a vase containing flowers may be inlaid; this is known as <i>marqueterie work</i> . <i>Millwork.</i> —Work connected with the machinery required in the construction and equipment of a mill, factory, or workshop, and comprising the shafting, pulleys, gearing, &c. <i>Mooring work.</i> —Any work in connection with the moorings (see definition of "out-port moorings") to which ships are secured when in port. <i>Out-work.</i> —Work connected with the erecting or fixing of machinery or plant at an establishment outside the firm in which it has been manufactured. <i>Piece work.</i> —See definition under "lump work." <i>Sack work.</i> —Work at the docks in grain in sacks, as distinguished from grain in bulk. <i>Skip work.</i> —Work done at the docks by the assistance of Priestman's skips. Both hoppers and skips are appliances for giving additional despatch to the discharging of grain from ships and barges. <i>Tight work, country work, and dairy work.</i> — <i>Tight work</i> is a term used in the coopering industry to denote the making of casks or any vessels to hold water or liquids. <i>Country or dairy work</i> is a special branch of <i>tight work</i> , and the terms <i>country work</i> and <i>dairy work</i> are used with reference to the making of milk churns and buckets, and firkins for holding butter, &c. <i>Torpedo defence work.</i> —The construction of a net-work protection of a man-of-war, at some distance from the side, to ward off the attacks of locomotive or other projected torpedos. <i>Torpedo work.</i> —Work done by "shipwrights" (see definition) in connection with torpedo fittings, stowage in magazines, lifts, and travellers (see definition of "slingers") for its transport to the ports; and the fitting of "torpedo tubes" (see definition) on the ship. <i>Towing work.</i> —The work done in the potting industry by <i>towers</i> (see definition.) <i>Yellow pine work.</i> —"Patterns" (see definition) made of yellow pine.
WHITE PAINT } GRINDERS }	In the chemical industry, after the lead is dried it is mixed with oil and ground through millstones by men who are called <i>white paint grinders</i> .		
WILLETER	The person who blends the raw material by means of a machine called a <i>willey</i> , consisting of a cylinder with teeth, into which a quantity of mungo is thrown and beaten up; it is a machine dangerous to use, since the material has to be taken out by handfuls.		
WILLYING	A process known in Huddersfield as "teasing" and in Bradford as "devilhole" or "devilling" work. It is performed by a machine which tears the material asunder.		
WILTON CARPETS	See definition under "carpets."		
WINCH	A machine fitted with a large barrel or drum around which winds a chain or rope (called a "hoist") and placed in a high position for the purpose of raising heavy loads, as, for instance, from a ship's hold to the quay. When driven by hand it is called a hand-winch, and when by steam, a steam donkey or "donkey-winch" (see definition).		
WINDERS ¹	Those who are employed with the winding engine.		
WINDERS ²	Women employed in <i>winding</i> weft or warp yarns from hanks or cops, in which it comes from the spinning mules, upon spools or bobbins, for the greater convenience of working on the fabric frames.		
WINDING ENGINE	See definition under "engines."		
WINNERS	Another term for <i>hewers</i> , i.e., the men who win the coal.		
WIPERS	Rags used in the printing industry for wiping over the face of the stone before the ink-roller passes over the face.		
WIRE-OUT BRICK	See definition of "machine-made bricks."		
WIRE NAILS	See definition under "nails."		
WITERS	Iron hoops or bands used for binding bales of cotton or rags.		
WOOD-BOUND } TRADE }	In the coopering industry making packing casks in which to put bottles for export from breweries.		
WOOD MONEY	See definition under "money."		
WOOD TURNERS	Workers at a turning lathe (see definition of "turning ¹ ").		
WOOD WORKERS	In the coach-making trade <i>wood workers</i> consist of wheel-makers, body-makers (see definition), and carriage-makers (i.e., those who hang the body and make everything ready for the road).		
WOOL COMBING	Preparing wool for the spinner.		
WOOL SORTERS' } DISEASE }	A disease due to the irritation of the respiratory organs and to blood poisoning occasioned by the fluff and fine dust inhaled by sorters in sorting wool.		
WOOLSTAPLERS	Merchants who buy wool from the farmer or importer and sort it into various qualities for the manufacturer. Qualities vary according to the parts of the fleece, and also generically according to country and breed.		
		WORKED STONE	See definition under "stone."

Term.	Definition.	Term.	Definition.
WORSTED -	A description of yarn spun from wool. <i>Worsted yarn</i> can be distinguished from woollen yarn by the arrangement of the fibres, which lie parallel to each other in the direction of the thread.	YARDSMEN -	This term is applied to men engaged in goods and mineral yards, whose duties are to shunt and marshal goods and mineral waggons into trains for despatch to their respective destinations.
WRITERS -	A particular section of the clerical staff of Government dockyards consisting mainly of mechanics employed on clerical duties of a more or less mechanical character. <i>Writers</i> are either professional or non-professional, according as they have or have not passed a trade examination.	YARN -	The thread into which the wool is spun.
WROUGHT HOSE	See definition under "hose."	YARN DRESSERS	Men who dress the yarn and prepare it for the weaver. (Local term.)
WROUGHT IRON	See definition under "iron."	YEAST -	Barm, the froth of beer or other liquor in fermentation, a substance used for leavening bread. German yeast in a dried form is largely imported from the Continent.
WROUGHT NAILS	See definition under "nails."	YELLOW PINE WORK	See definition under "work."
YARDAGE RATE	A method of calculating the wages due to a hewer in a coal mine at a fixed price per yard of working, as opposed to "tonnage rate," that is, per ton of material worked.	YORKSHIRE SPLITS	See definition under "coal."
YARD MEN AND YARD LABOURERS	Men working in the yard attached to gas-works; such work is called <i>yard work</i> .	ZINC PREPARERS	Men in the printing industry who prepare graining and polishing zinc-plates for artists; the process is similar to that used for lithographic stones.
YARD MONEY -	See definition under "money."		

DIAGRAM I.—Showing "Squeeze," "Creep," and "Crush," in a "Stall," also illustrating the system of "Longwall Working."

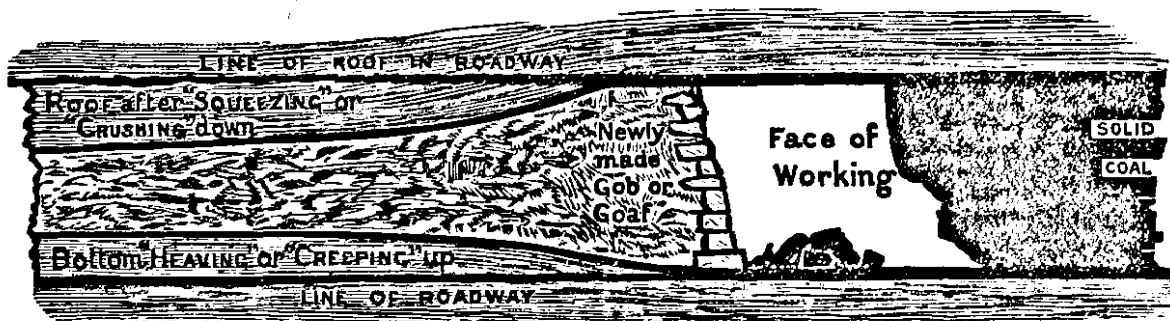


DIAGRAM II.—Seam of Coal with "Cleavage" or "Slips" inclining.

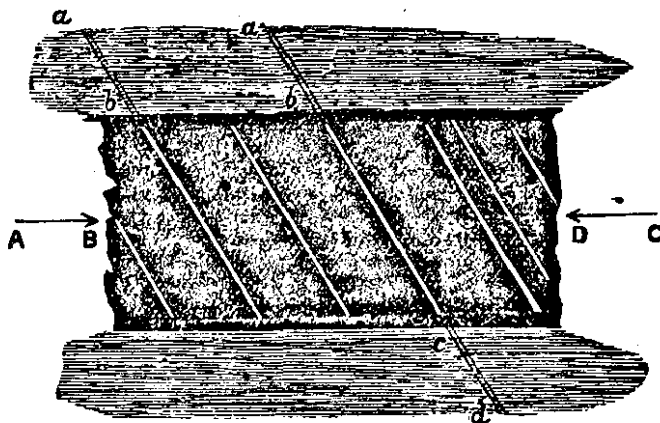
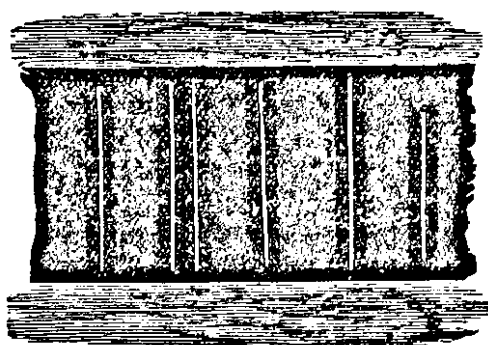


DIAGRAM III.—Seam of Coal with "Cleavage" or "Slips" vertical.



When working in the direction of A B it is called working "on face of slips"; in the direction C D "on back of slips." *a b* and *c d* are slips from Coal penetrating into Roof, &c.

DIAGRAM IV.—FAULTS.



DIAGRAM V.—OVERLAPS.



DIAGRAM VI.—ROLLS.



DIAGRAM VII.

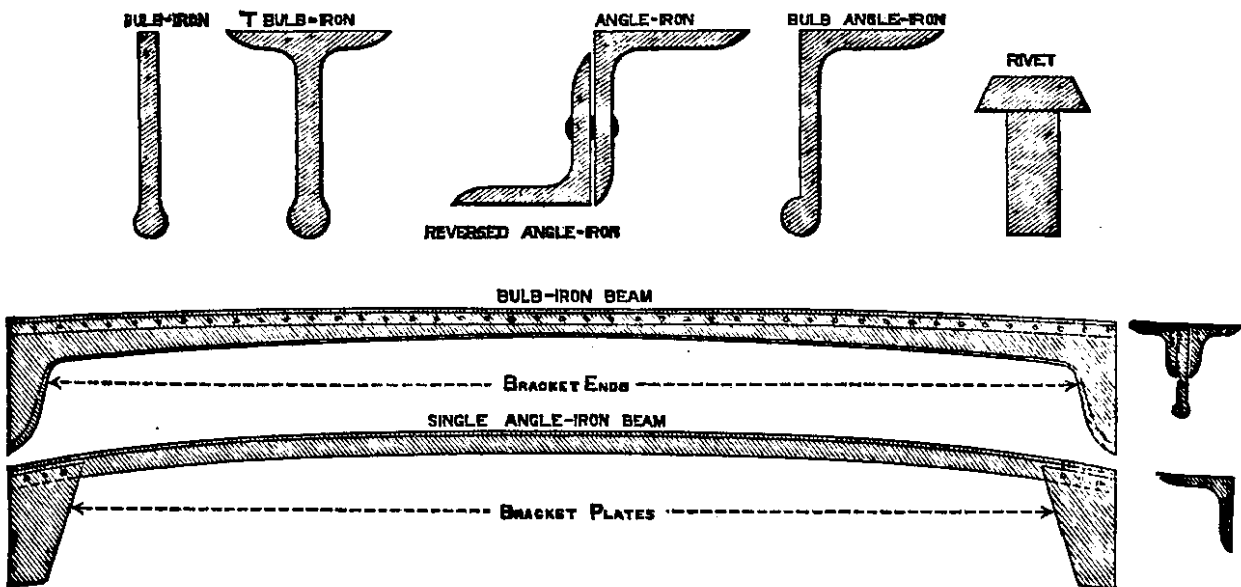


DIAGRAM VIII.

MIDSHIP SECTION.

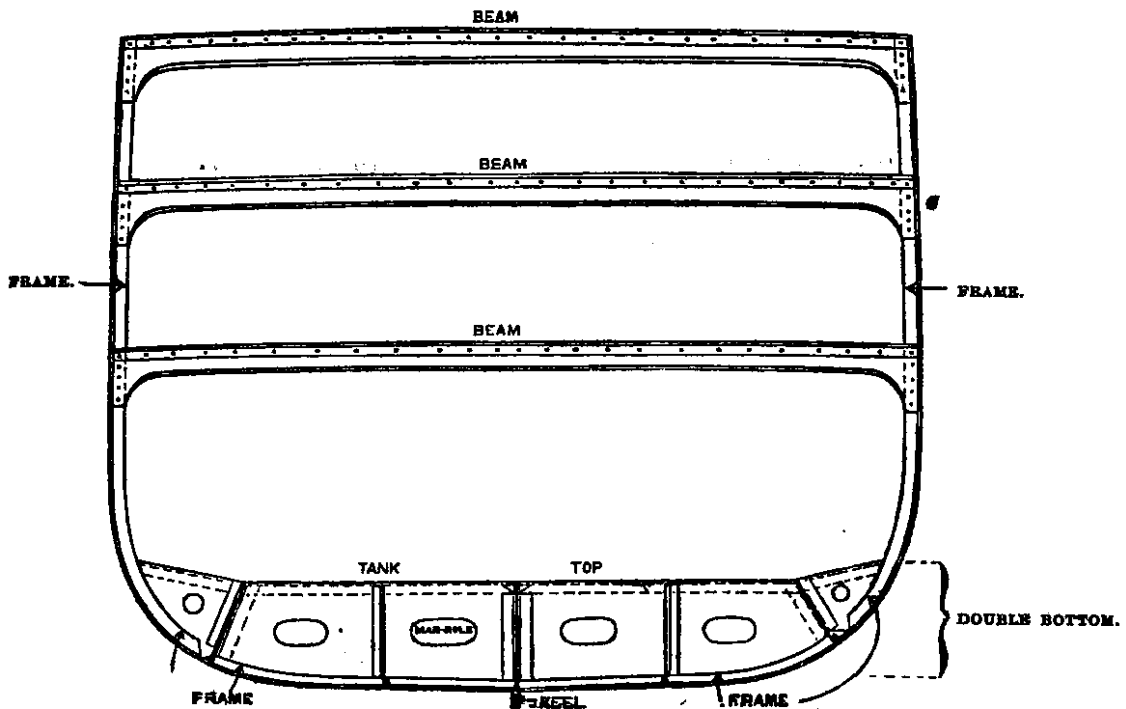


DIAGRAM IX.
SECTIONAL ELEVATION OF A SHIP.

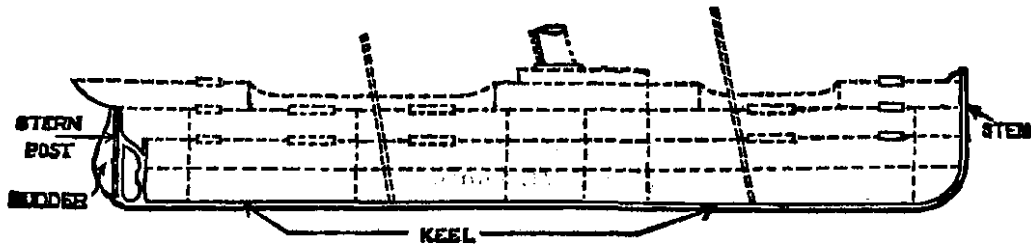


DIAGRAM X.
THREE-DECKER.

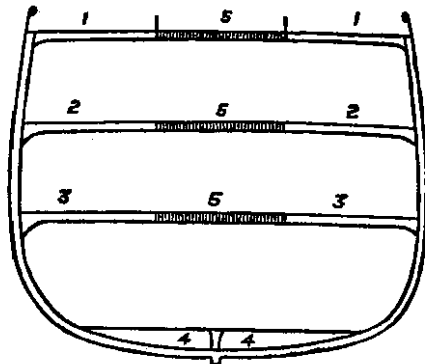
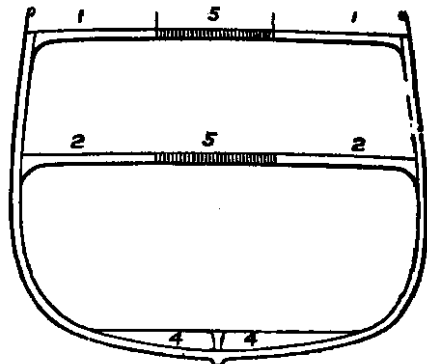


DIAGRAM XI.
TWO-DECKER.



- 1. Upper deck.
- 2. Tween decks.
- 3. Orlop deck.
- 4. Bilge.
- 5. Hatch.

DIAGRAM XII.
WELL-DECKER.

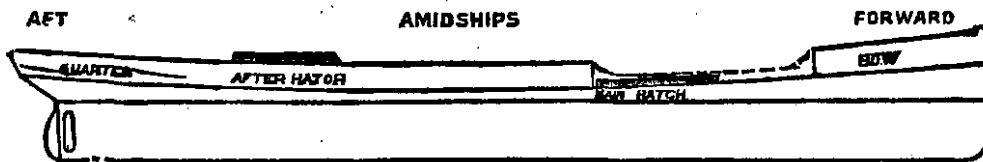
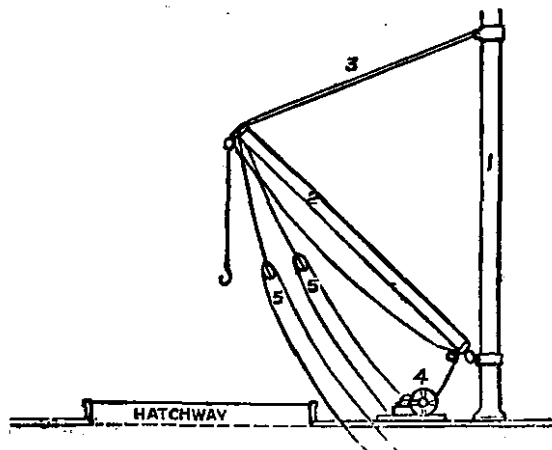
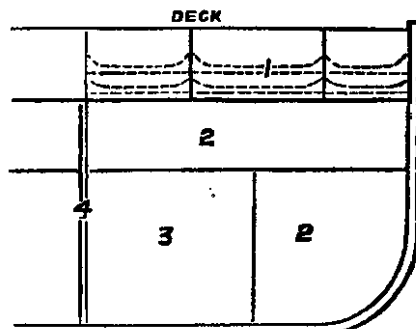


DIAGRAM XIII.



- 1. Mast.
- 2. Derrick.
- 3. Span.
- 4. Winch.
- 5. Guys.

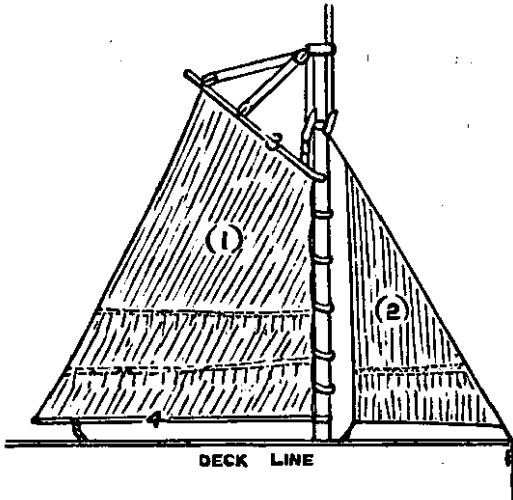
DIAGRAM XIV.



(For'ard section.)

- 1. Forecastle.
- 2. Forepeak.
- 3. Chain locker.
- 4. Bulkhead.

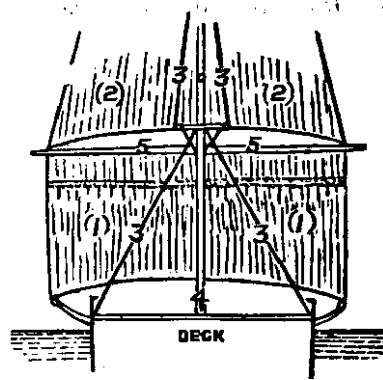
DIAGRAM XV.



(Fore and Aft Rig.)

1. Mainsail.
2. Foresail.
3. Gaff.
4. Boom.

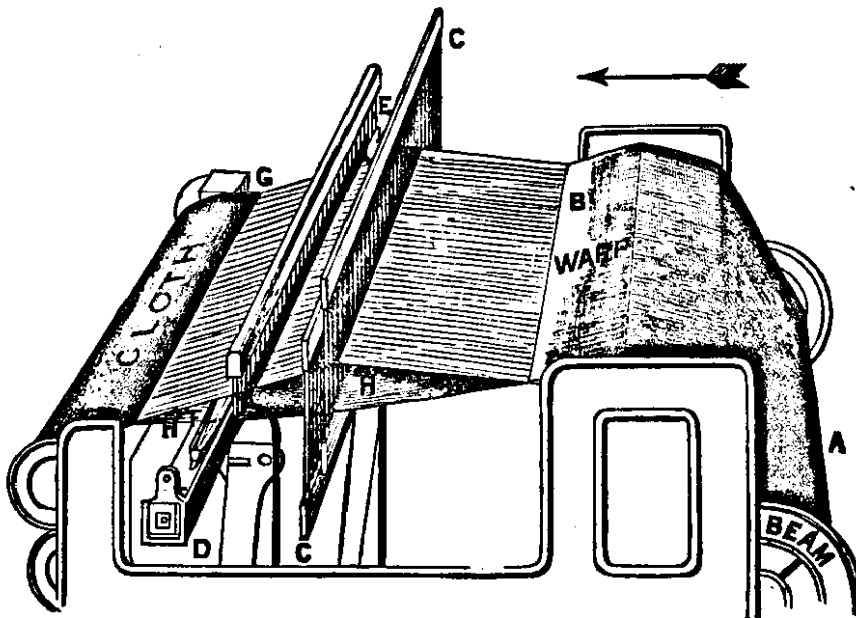
DIAGRAM XVI.



(Square Rig.)

1. Foresail or mainsail.
2. Topsail.
3. Rigging.
4. Mast.
5. Yard.

DIAGRAM XVII.



- A. The "beam" from which the warp B gradually unwinds.
- CC. The "healds" apart to form the "shed" HH.
- D. The "slay beam" to which is fixed the "reed" E.
- F. The "shuttle."
- G. The last thread of the weft driven home by ED.

GLOSSARY OF THE TECHNICAL TERMS USED IN THE EVIDENCE

TAKEN BEFORE THE

ROYAL COMMISSION ON LABOUR (Sitting as a Whole).

Term.	Definition.	Term.	Definition.
ABUTMENT JETTY	See definition (page 50) under "jetty." (2281.)	COLLECTING SOCIETIES	See under "societies." (1260, 1265.)
AFFILIATED ORDERS	See definition of "affiliated societies" under "societies." (1261-2, 1774.)	COMPOSITORS	See definition (page 38). (4724.)
AFFILIATED SOCIETIES	See under "societies." (1260, 1264.)	CONTRARY	To <i>contrary</i> means to contradict or oppose. (6588.)
ALFALFA GRASS	A rich flowering natural grass which grows most luxuriantly in the Argentine Republic and makes admirable hay. (8454, 8456.)	CONVERTING DEPARTMENT	The department in a blast-furnace in which the iron is <i>converted</i> into steel. (5106.)
BALLAST HEAVING TRADE	Shingle, water, stone, pigs of iron (sometimes termed "Kentledge"), or any heavy material is placed in the hold of a ship as <i>ballast</i> , to steady it in the water. Hence the <i>ballast heaving</i> trade is the trade carried on by a <i>ballast heaver</i> (porter) or river carrier, who loads a ship with such <i>ballast</i> . (1257.)	COOPERING	See definition (page 38). (2171, 2292.)
BANKS	A <i>bank of retorts</i> consists of a number of retorts set back to back, or side by side, in one enclosing mass of brick. (5048, 5082, 5088.)	DELIVERING	Taking tea chests from the "pile" (see definition of "warehousing") in the warehouse and placing them in vans. (2170-1, 2292.)
BANKSMEN	See definition (page 21). (3100.)	DIVIDING SOCIETIES	See under "societies." (1260, 1267.)
BESSEMER STEEL	See definition (page 64) under "processes in-steel making." (5119.)	DIVI. HUNTING	Seeking the highest dividend. (1800, 2276.)
BIRMINGHAM BENEFIT SOCIETIES	See definition of "Birmingham system" (page 23). (1268.)	DOCKERS	See definition (page 37). (2134, 2171.)
BLACKLEGS	See definition (page 23). (8085.)	DOCTRINAIRE	A cant term in the politics of France denoting one who is desirous of giving to the King more power than is admitted by the ultra-Liberals and less than is demanded by the ultra-Royalists. (6745.)
BLACKSMITHS	See definition (page 75) under "smiths." (2562.)	DRAWING A CLEARANCE	Some societies having provisions respecting industrial migration provide for the transfer of a member from one branch to another, and for the acceptance by the branch to which he removes of the liabilities of his original branch towards him. This acceptance is termed <i>drawing a clearance</i> . (1266, 1476.)
BLAST FURNACE MEN	See definition (page 23). (5112.)	DRILLERS	See definition ² (page 39). (1409.)
BLAST FURNACES	See definition of "blast furnace keepers," &c. (page 23). (5104, 5112, 5118.)	DYERS	See definition (page 39). (967, 1086, 1099.)
BOILER-MAKERS	See definition (page 25). (2132, 6193.)	EMBARGO	See definition (page 39). (1775.)
BOILER SMITHS	See definition (page 49) under "flangers." (2562.)	ENGINEERS	See definition (page 39). (2568, 8523.)
BOOM	See definition ¹ (page 25). (5959.)	ENGINE FITTERS	See definition (page 42) under "fitters." (2132.)
BOOZE-UP	A drinking bout. <i>Booze</i> is a corruption of "booz," the Arabic name for beer. (2679.)	ETIOLATION	Derived directly from French <i>étioiler</i> , and indirectly from Greek <i>αἰσθ</i> , to whiten, to blanch, to become pale: hence here used in the sense of a becoming weakened, that is physical deterioration. (8406.)
BRANCH	See under "affiliated societies" under "societies." (1262.)	ETIOLOGY	The science of the causes of a thing, especially of diseases (Greek <i>αἴτια</i> , a cause, and <i>λογία</i> , science). (5353.)
CHANNELLING	A term used in the boot trade to express the process of cutting the sole preparatory for sewing. (5748.)	FEND	Strive. (5877.)
CLEARANCE	See definition of "drawing a clearance." (1266, 1476.)	FETTLING UP	<i>Fettling</i> is a common term, especially in the North of England, for replacing and setting in order. See definition of "fettling a furnace" in Glossary. (5048, 5070-1, 5103, 5127, 5130.)
COALIES	See definition (page 32). (2184.)	FINANCIAL RINGS	See definition of "ring" ¹ (page 67). (2368.)
COAL RING	See definition (page 67) under "ring!" (4809.)	FITTERS	See definition ⁴ (page 42). (2568, 6193, 6361, 8523.)
COASTWISE	By way of, or along, the coast. (2142, 2159.)	FORESHORE	See definition (page 43). (2171, 2179, 2185.)

Term.	Definition.	Term.	Definition.
FORGES - -	The furnaces where wrought metals are heated to render them soft and more malleable. This is the department following on "smelting" and succeeded by the "rolling mills" (<i>see</i> definition). (5118.)		which better describes their position. The duties of the jobbing men who have served their time as carpenters or joiners is to make shelters, aviaries, byelaw boards, and similar things. The work performed by the smiths consists of repairing iron hurdles, locks, and tools. The work performed by the handy men who, although they have not served their apprenticeship are yet clever at carpentering or like work, is the repairing of greenhouses, wheelbarrows, and a number of other duties of a similar character. (7720.)
FUSTIANS - -	A coarse stout twilled cotton fabric, including many varieties, as corduroy, jean, velveteen, thickset, &c., used by working men. Plain fustian is called pillow; strong twilled fustian, cropped before dyeing, is known as moleskin; when cropped after dyeing, beaverteen. (961-3, 1086, 1105.)	JOINERS - -	<i>See</i> definition ² (page 50). (7576, 7630.)
GAFFER - -	<i>See</i> definition (page 44). (5210)	LABOURERS - -	Under the head of <i>labourers</i> (employed in the Parks and Open Spaces Sub-Department of the London County Council) are classed men who are not only "spade and shovel" men, but also those who are practical gardeners, and can attend to the flowers, prune trees, and hoe and dig amongst shrubberies, as well as bed out and perform other acts of gardening. (7720.)
GANGERS - -	<i>Gangers</i> (employed in the Parks and Open Spaces Sub-Department of the London County Council) are practically sub-foremen, that is, say in Battersea Park, which is a large one, the foreman breaks up the staff into gangs, and at the head of these gangs places a man who takes the title of <i>ganger</i> , and, of course, receives extra pay. (7720.)	LAGER BEER - -	Light German beer; very much drunk and extensively brewed in the United States. It has no body, is destitute of nourishment, and on account of the absence of alcohol no human being can possibly get drunk on it. (8454.)
GENTILE SETTLEMENTS }	Settlements of natives who are bound together by relations of kinship and not by relations of property. The unit of these relations of kin is the "gens" and not the modern "family." These "Gentile" settlements, such as the pueblos of New Mexico and Arizona, &c., are communal. (8687.)	LETTER-PRESS PRINTING }	<i>See</i> definition (page 64) under "printers." (5897, 5940-1.)
GREENERS - -	<i>See</i> definition (page 45). (5545, 5547.)	LIEN - -	A right in one man (1) to <i>retain</i> that which is in his possession belonging to another, until certain demands of the person in possession are satisfied; or (2) to <i>charge</i> property in another's possession with payment of a debt &c., e.g., a vendor's lien. It may be either (a.) <i>particular</i> , arising out of some charge or claim connected with the identical thing; or (b.) <i>general</i> , in respect of all dealings of a similar nature between the parties. It may be (i.) by agreement between the parties, express or implied (<i>conventional</i>), or (ii.) by operation of law, owing to the special relation between them, as in the case of a solicitor and client. (414.)
HARTFORD AXES	Hartford axes are axes made at Hartford in Connecticut. They are celebrated as the best axes for all sorts of pioneer work.* (8585.)	LIGHTERMAN - -	<i>See</i> definition ² (page 52). (2134, 2187.)
HAULAGE RETURNS }	Returns of the traffic in freight on the railways with working expenses, &c. (8543.)	LIGHTERS - -	<i>See</i> definition ² (page 52). (2134.)
HEWERS - -	<i>See</i> definition (page 47). (8100.)	LOOP-HOLES - -	Openings in warehouses through which goods are brought in and taken out, the crane lowering the article from the <i>loop-hole</i> into a van in the street, or "lighter," or ship in the river. (2171, 2180.)
HOLE-CUTTERS - -	<i>See</i> definition (page 48). (1409.)	MALFRANÇON - -	Evil-doing; wrong; illegal deed. In law, the performance of some injurious act which the party had contracted not to do, or had no right to do. (6767.)
HUNGARIAN BELT SYSTEM }	This is a system of charge for freight on the Hungarian Railways by which a low fixed uniform charge per ton is made for freight on goods transported within a radius of 50 miles or any portion of 50 miles, a higher charge within the limit of 100 miles, and so on. The success of the system in every respect has been something extraordinary. The railways are managed by the State. (8449.)	MASONS - -	<i>See</i> definition (page 55). (4242.)
HUTH'S - -	Messrs. Frederick Huth & Co., one of the largest commercial houses or firms in the city. They are wholesale merchants and consignees dealing with all kinds of produce, over some of which they have a complete control. (8556.)	MILL - -	<i>See</i> definition of "rolling mills" (page 68). (5111-2, 5118.)
HYPOTHECATED	Pledged as security for a debt or money borrowed. (<i>See</i> definition of "law of hypothec," page 52) (1784, 5916.)	MOOT - -	Debatable; disputed. (1153, 4679, 7456.)
INDIFFERENTLY	Here means "with impartiality"; not "carelessly." (4210.)	MUTARRI MUTARRI }	<i>See</i> definition (page 58). (1817.)
IRON FOUNDERS	<i>See</i> definitions 1-2 (page 49). (1629, 1688, 3225-6, 3228, 3232.)	NEGATED - -	Competition, when it has reached its fullest possible development, <i>negates</i> itself in the form of combinations among the competitors, and the gradual establishment of monopoly. This process can be seen clearly in operation in the United States. The reference is to Hegel's <i>negation of a negation</i> . Competition itself <i>negated</i> the old communal forms. (8,478.)
JOBGING MEN - -	The duties of <i>jobbing men</i> (employed in the Parks and Open Spaces Sub-Department of the London County Council) vary. Most of them do ordinary carpenter or joiner's work, and some of them do smith's work. They were formerly called handy men,	NON-FREEMEN - -	<i>See</i> definition (page 59). (2134, 2187.)

* To this definition Mr. Hyndman adds that "Sheffield might have had the manufacture of this beautiful axe, but masters and men both decided that the hatchet of our fathers was good enough for them, and for their customers, so the customers refused to argue and dealt elsewhere."

Term.	Definition.	Term.	Definition.
PARK-KEEPERS	<i>Park-keepers</i> (employed in the Parks and Open Spaces Sub-Department of the London County Council) are the constables in uniform employed to preserve order and protect property, and enforce the byelaws. They are, to all intents and purposes, police constables in the service of the Council. (7720.)	SCHEDULE A.	Schedules A. and B. are the headings under which the value of all lands, tenements, and hereditaments whatsoever is assessed for the purposes of taxation; under Schedule A. in respect of property, under Schedule B. in respect of the occupation. (4202-3, 4206, 8099, 8148.)
PATTERN-MAKERS }	See definition (page 61). (3224.)	SCHEDULE B.	See preceding definition of "Schedule A." (6922.)
PERIODICITY	The state of having regular periods in changes or conditions. (6547.)	SCHEDULE D.	The heading under which the income from profits of trades and professions is reckoned in Great Britain for the purposes of taxation. (8631.)
PIECE-WORK	See definitions under "lump work" (page 54) and under "task work" (page 61). (4502.)	SCOUR	The effect caused by the tidal flow of a river. The outgoing tide carries much of the filth down the river and deposits it in the sea. Thus, if the rate at which the water runs is increased, the <i>scour</i> will be greater: in the Thames this would be beneficial. (2172, 2236.)
PIGS	The bars or rough ingots about 3 ft. long, 5 in. broad, and 4 in. thick, formed during the first process of iron manufacture, viz., by the cooling of the molten iron from a smelting furnace, poured into moulds of sand. (8590.)	SHACKLER	A man who does his work in a perfunctory or careless manner. (6018.)
PLASTERERS	See definition (page 68). (6879.)	SHIP CARPENTERS }	See definition of "carpenters" (page 38). (3182.)
PLUMB	Quite straight, as indicated by a <i>plumb line</i> . (2180.)	SHODDY	See definition (page 72). (2077.)
PRESIDENTLY	See definition (page 64). (4491.)	SHOERING SMITHS	See definition (page 75) under "smiths." (6879.)
PRESSERS	See definition (page 64). (5547, 5750.)	SLAG	See definition (page 74). (5889.)
PRIMORDIAL	First in order; original; existing from the beginning. (6741.)	SLATE CLUB	See definition (page 74). (1271, 1801.)
PROPAGATORS	The duty of <i>propagators</i> (employed in the Parks and Open Spaces Sub-Department of the London County Council) is to produce all the plants required at the greenhouses in which they are stationed, under the direction of the park superintendent, and to attend at such hours as may be necessary for this purpose. The superintendent bases the actual number of hours served by the <i>propagator</i> on that laid down for a day's work by the Council, viz., nine hours in summer and eight hours in winter, but this time is not necessarily all worked together, as in places where there are no night stokers the <i>propagator</i> has to come in say at 10 o'clock to see to his fires. (7720.)	SLATERS	Workmen skilled in shaping and working slates and in roofing buildings with slate or slate laying. (6019.)
PUDDLERS	See definition (page 65). (5107, 5111.)	SOCIETIES	<i>Affiliated Societies.</i> —Friendly societies having branches, a branch being legally defined as a number of the members of a society under the control of a central body having a separate fund or funds under the control of the branch itself or its committee or officers, but having a fund which is under the control of its central body and to which every other fund contributes. (1260, 1264.) <i>Collecting Societies.</i> —Friendly societies which send round from house to house to receive the subscriptions for burial money from the members. (1260, 1265.) <i>Dividing Societies.</i> —Friendly societies in which the funds, with the exception of a small sum, are periodically divided, in the majority of cases at the end of each year, but in some cases at the end of every 5 or 7 years. Such societies are "slate clubs," "Birmingham benefit societies," "Tontines," &c. (See definitions in Glossary.) (1260, 1267.)
PUDDLING	See definition of "puddlers" (page 65). (5106, 5110, 5112.)	STEAM SAWYERS	See definition of "mill-sawyers" (page 56). (6879.)
PUTTERS	See definition (page 65). (3100.)	STEREOTYPING	See definition (page 78). (7584.)
RETORTS	See definition (page 67). (5043.)	STEVEDORES	See definition (page 78). (2134, 2137.)
RIGGING	Taking means to enhance, fictionally the market value of the shares in a Company. See definition of "thimble rigged" (page 81). (5986.)	STINT	See definition (page 78). (5750.)
RINGS	See definition of "ring!" (page 67). (2369, 3568, 4006.)	STOCKMEN	Herdsmen; keepers of cattle. (6879.)
RIVERSIDE LABOURERS }	See definition (page 67). (1857.)	TARE ON TRUCKS }	In commerce a <i>tare</i> is an allowance or abatement of weight or quantity from the gross weight or quantity of a commodity in consideration of the weight of the cask, bag, or package which contains the goods, or for the papers, string, wrappers, &c., that enclose merchandise. It is used here to denote the amount of dead weight of the railway truck or wagon itself which has to be hauled to and fro in addition to the weight of the paying load. (8560.) [For use of this term in another special instance. see definition page 81.]
RIVETERS	See definition ¹ (page 67). (6198.)		
ROLLING MILLS	See definition (page 68). (7658.)		
ROLLING-STOCK	The locomotives, passenger and freight cars, and waggons used on a railway. (8451.)		
RUSHING SYSTEM	The present industrial system, which makes speed of production a more important element than quality of production. (2634.)		
RYOT	A Hindoo cultivator of the soil. (7926.)		
SALT RING	See definition (page 67) under "ring!" (2871, 2876.)		

Term.	Definition.	Term.	Definition.
TASK WORK -	See definition (page 81). (4502.)	WATERING STOCK, CAPITAL, ESTIMATES, &c.	To <i>water stock or capital</i> is to assign a higher value to stock or capital than is the actual case in order to conceal large profits by spreading the dividend over the real capital, plus the fictitious additional capital, and thus apparently reducing the rate. As an illustration—a firm or company with an actual capital of 80,000 <i>l.</i> selling the concern to a new company with a nominal capital of 40,000 <i>l.</i> , without adding to its assets, is said to be <i>watering its stock</i> . In such a case the usual practice is to issue additional shares to each shareholder without requiring further payment either upon the shares already held or the bogus shares issued. (3572, 3576, 5986, 6682.) The expression to <i>water estimates</i> was presumably here used to express a practice of adding to a group of ascertained figures other groups of figures, either ascertained or approximate, to obtain in this case a more accurate or more comprehensive result. The Witness, when requested to supply a definition, merely stated that he thought a definition was unnecessary. (6976.)
THATCHERS -	Those who lay straw and thatch (dried grass, palm-leaves, or other vegetable materials) on the roof of a house and bind and secure it there. (6379.)	WATERSIDE } WORKERS }	See definition (page 67) under "riverside labourers." (2171.)
TIES -	<i>Ties</i> in "banks of retorts" (see definition) are long iron rods, passing right through the mass of brickwork, to support and bind the whole. (5043, 5055, 5083-4, 5087-8, 5090-1.)	WHARFINGER -	The owner or occupier of a wharf, that is, of a landing place or mole (see definition in Glossary of "jetty") by the waterside, in a harbour or river, for landing or shipping goods. (2155, 2192.)
TONTINE -	<i>Tontine</i> is a very ingenious form of life annuity with a culminating bonus, introduced in 1653 into France by its inventor, Count Lorenzo Tonti. The subscribers were divided into ten classes, according to their ages; and a proportionate annuity being assigned to each class, those who lived longest had the benefit of their survivalship by the whole annuity being divided among the diminished number. In 1689 a second Tontine was opened in France, and the last survivor proved to be a widow, who at the period of her death, at the age of ninety-six, enjoyed an income of something like three thousand pounds sterling, for her original subscription of twelve pounds. The last Government Tontine in England was opened in 1798, and a few payments on account of subscribers of English and Irish Tontines remained until recent years as a small charge on the National Debt. (1268, 1272.)	WHEELWRIGHT -	A maker and repairer of wheels and wheel carriages. (6379.)
TURNERS -	See definition ¹ (page 84). (6198, 6361, 8528.)	WINSTONE -	<i>Winstone</i> or <i>Whinstone</i> is trap or greenstone, a provincial name given to basaltic rock, and applied by miners to any kind of dark coloured and hard unstratified rock which resists the point of the pick. (5889.)
VALENCIAS -	<i>Valencias</i> or <i>valencias</i> are a kind of cloth manufactured chiefly in Huddersfield and neighbourhood. The material is used in making up livery servants' vests. It is woven with a fine striped worsted "warp," usually red and white or blue and white, and with a fine plain worsted "weft." (948.)	WORKING -	The term generally applied to the mixing of teas,—a process which takes place in the tea warehouses to equalise qualities,—and the treading in again of the tea into the damaged chests now repaired by "coopering" (see definition, page 83). (2170-1, 2292.)
WAREHOUSING -	Piling up the chests of tea in warehouses ready for delivery to merchants' vans. (2171.)		

III. APPENDIX. (Part i.)

LIST OF TRADES AND INDUSTRIES.†

<i>Agriculture.</i>	<i>Knife Cutlers.</i>
Bakers.	Lath-renders and Mill-sawyers.
<i>Barge Builders.</i>	<i>Law.</i> ‡
Barmaids and Barmen.*	<i>Lead.</i>
<i>Blacksmiths.</i>	Linen.
Blast Furnaces.	<i>Lock and Key Making.</i>
Boot and Shoe Trade.	Mats and Matting.
Brass Founders.	Metal Smiths.*
Brush-makers.	<i>Millmen.</i>
Building Trades.	<i>Moulders.</i>
Cabinet-makers.	<i>Nailmakers.</i>
Cabs (see <i>Hackney Carriages</i> below).	<i>Nut and Bolt Trade.</i>
Carpet-making.	Omnibuses and Tramways.
Carters and Carmen.	Paper Mills.
<i>Chain Makers.</i>	<i>Pattern Makers.</i>
Chemical (including copper, lead, silver, tin, zinc).	<i>Plumbers.</i>
Coach-makers.	Pottery, Earthenware and Brick-making Trades.
Coal (mining).	Printing.
Coal (portage).	<i>Purveyors.</i>
Coke making.	Railways.
Confectionery.	<i>Riggers.</i>
Coopers.	Rivers, Canals, &c.
<i>Copper.</i>	Royal Arsenal and Ordnance Store.
Cork Cutters.*	Seed-crushing.
<i>Corn, Grain, and Seeds.</i>	Ship-building.
Cotton (spinning and weaving).	Shipping.
Covent Garden Porters.*	<i>Shipwrights.</i>
Cutlery.	Shop and Warehouse Assistants.
Docks, Wharves, and Warehouses.	Silk.
<i>Dockyards.</i>	<i>Silver.</i>
Domestic Servants.*	<i>Silver Plate Manufacture.</i>
Dress-making.*	Slate.
Dyers.	<i>Smelting.</i>
Engineering.	<i>Stone.</i>
Fishing.	Straw-plaiting.
<i>Furniture Trade.</i>	Tailoring and Ready-made Clothing Trade.
Gas-making.	<i>Timber.</i>
Glass-bottle Trade.	<i>Tin.</i>
Granaries and Warehouses* (see <i>Corn, &c.</i> , above).	Upholstery.
Grinders.	<i>Whitesmiths.</i>
<i>Hackney Carriages.</i>	Woollen and Worsted (spinning and weaving).
Hardware.*	<i>Zinc.</i>
Hosiery.	
Iron and Steel (manufactured).	
Iron (mining).	
<i>Joiners.</i>	<i>Miscellaneous.</i>
Jute and Rope Makers.	<i>Slang Terms used in various trades</i>

† The List of Trades and Industries here adopted is taken from the Trades Indexes. However, it has been found necessary to add some Trades (printed in italics) which are not included in the Trades Indexes.

* The Trades marked with an asterisk have no terms referring to them defined in this Volume.

‡ Although not one of the Industries inquired into by the Commission, it has been found convenient to insert this heading at this place.

III. APPENDIX. (Part ii.)

INDEX TO ALL TECHNICAL TERMS GROUPED UNDER THEIR RESPECTIVE TRADES AND INDUSTRIES.*

<p>AGRICULTURE.</p> <p>Bothy. Cot houses. Crofters. Landlord cattle. Metayer system. (Ryot.) Steam ploughing tackle. (Stockmen.)</p>	<p>Puddling forge. Re-belling. Scaffolds. Slag. Slaggers. Slides. Sub. Table loaders. Tapping out. Twear.</p>	<p>Jerry builder. Jerry building. Jib. Jib crane. Joiners.² Joinery. Landings. Lather. Laths. Lime putty. Lime rock. Machine men. Masons. Modellers. Mouldings. Nipper. Planks. Plasterers. Plaster of Paris. Plumbers. Rod. Shored up. Slapping. Slaters. Slop dash work. Squad. Sticking mouldings. Stone :— Dressed. Worked. Stone masons. Taskmaster.</p>	<p>CHEMICAL (COPPER, LEAD, SILVER, TIN ZINC).</p> <p>Acid worker. Alkali. Alkali workers. Ammonia soda process. Bar in the burners. Black ash. Black ash revolver men. Bleaching. Bleaching powder. Blind furnaces. Blower men. Blue beds. Blue lead. Boiler men. Bottom.² Bulk salt. Burner departments. Burner men. Burners.¹ Calcining men. Carbonates of alkalies. Caustic. Caustic soda. Chemical plumbers. Chlorate. Chloride of lime. Chlorine. Chrome. Cinder men. Common salt. Copperplate roller man. Copper shale. Coppersmiths. Copper workers. Creosote. Crushers. Dampers in the flues. Deacon's patent. Decomposing pots. De-silverising process. Dischargers. Draught. Drawing a pan. Drawing-on furnace man. Drawing-on roller man. Dressing floors. Dressing lime. Finishing department. Finishing furnace man. Finishing roller man. Finishing rolls. Fitters.² Flint yard. Flowing. Gassed. Gelatine. Guano. Hoist men.² Hydro-chloric acid gas. Iron pyrites. Le Blanc process. Light sheets. Lime. Lime house. Lime putty. Lime rock. Metallic process. Milk of lime. Mud plungers. Neutralisers. New zinc process. Nitric acid. No. 1 Caustic weak liquor men. Nos. 1 and 2 Caustic finishers. Old Pattinson process. Outlet stack. Oxidisers.</p>
<p>BAKERS.</p> <p>Batch. Broad serving. Fillers of the ovens. Quatern. Setters. Setting the sponge. Shooting flour. Sponge. Sponging money. Yeast.</p>	<p>BOOT AND SHOE TRADE.</p> <p>Bench men. Bottoms. Chamber masters. (Channelling.) Clickers. Curried. Eagle brand. Eyelets. Finisher.¹ Fitters.¹ Fore-stitching machine. Furnishings. Glucose. Greeners. Grindery. Hammering out machine. Hob nailer. Lasters. Lasting machines. Lasting shoes. Machinists. Makers. Riveters. Rough stuff cutters. Screwing machine. Sligger. Spew out. Sprigger. Standard screwer. Stuff shoes. Tacker. Tingles. Uppers.</p>	<p>CABINET MAKERS.</p> <p>Botch. Cabinet makers. Cabinet trade. Greeners. Mouldings. Subbing. Turnover.</p>	
<p>BARGE BUILDERS.</p> <p>Baulking with timber. Grinding money. Wood money.</p>			
<p>BLACKSMITHS.</p> <p>Blacksmiths. Foregemen. Forgemen's helpers. Maker-up. Shops. Smiths. Strikers.</p>			
<p>BLAST FURNACES.</p> <p>Bellmen. Bells. Blast-furnace keepers. Blast-furnace men. Blast men. Blowing.¹ Bogies. Bottom.¹ Butty. By-turn men. Cast. Char fillers. Chargers.² Cleaning the bars. Coke. Converter men. (Converting department.) Elevator engine-men. Filler.⁴ Filling out from the kilns. Front and back sidemen. Furnace fillers. Gantries. Gantry men. Gasmen. Helpers. Hoists. Keepers. Lift loaders. Limestone. Metal carriers. Mine and coke fillers. Moulding bed. Oncoot labour. Fig-bedmen. Fig beds. Fig lifters. Pit head men. Puddlers.</p>	<p>BRASS FOUNDERS.†</p> <p>Bevelled wheels feeding inwards. Brass finishers. Brass fitters. Brass founders. Brass turners. Founders. Lathe men. Moulders.</p>	<p>CARPET MAKING.</p> <p>Carpets :— Brussels. Wilton. Axminster. Kidderminster. Jobbed.</p>	
	<p>BRUSH-MAKERS.</p> <p>Hair work. Knots.</p> <p>BUILDING TRADES.</p> <p>Architraves. Bearings. Bell horses. Bricklayers. Bricksetters. Builders. Carpenters.¹ Cramped. Designer. Field ranging houses. Girders. Hand over. Hewers.² House carpenters. House joiners.</p>	<p>CARTERS AND CARMEN.</p> <p>Carts :— Brewers' drays. Carts. Lorries. Case carts. Pop carts. Cartwright. Case-makers. Lap system. Master's man. Playing off. Team money. Teamsters.</p> <p>'CHAIN MAKERS.</p> <p>Block chains. Blowing.² Breese. Cable chains. Fogging. Side striker. Small chain trade. Welder.</p>	

* This Index includes the Terms defined in the Glossary relating to the Evidence before the Committees, and also those defined in the Glossary relating to the Commission as a Whole (pp. 92-5). To distinguish the latter every term defined in the Whole Commission Glossary is here placed in brackets.

† The order of processes in a Brass Foundry is as follows :—1. Moulders and Brass Founders; 2. Brass Turners and Lathe Men; 3. Brass Turners in connection with Lathes; 4. Brass Fitters; 5. Brass Finishers.

Packers.¹
 Packing bleaching powder.
 Packing departments.
 Paddle.
 Pan men.
 Pan smiths.
 Pickling.
 Plate furnace man.
 Process men.
 Rag.
 Red lead.
 Riddings.
 Rollers.²
 Salt boiler men.
 Salt cake.
 Salt cake process.
 Salt heavers.
 Salt makers.
 Shearing.²
 Silica.
 Slaked.
 Soda finishers.
 Spade work.
 Spelter workers.
 Stills.
 Stoved salt.
 Stove men and women.
 Sulphate of lime.
 Sulphate of soda.
 Sulphur burners.
 Sulphuric acid.
 Tongs.
 Vitriol.
 Vitriol burners.
 Vitriol men.
 Wallers.
 Weldon's plant men.
 White ash finishers.
 White ash wheelers.
 White beds.
 White lead.
 White lead grinders.
 White paint grinders.

COACH-MAKERS.

Body makers.
 Ironworkers.
 Painters.
 Wood workers.

COAL (MINING).

Airways.
 Baff Saturday.
 Bands.
 Bank.¹
 Bankriders.
 Banksmen.
 Bargain.¹
 Bargain takers.
 Ben.
 Billy Fairplay.
 Binned.
 Blowers.
 Board and wall principle.
 Bob.¹
 Bond.
 Bottomers.
 Branch horse drivers.
 Brassies.
 Brattice cloth.
 Broken price.
 Brushers.
 Bumpers.
 Butty colliers.
 Cavils.
 Chaldron.
 Charter master.
 Checkweighman.
 Cleat.
 Cleavages.
 Clod.
 Coal:—
 Anthracite.
 Bituminous.
 Brown.
 Bunker.
 Cannel.
 Clean.
 Coking.
 Dirty.
 Easy or soft and stiff or hard.
 Gas.
 House.
 Jet.

Large.
 Round.
 Sea-borne.
 Slack.
 Small.
 Soft or manufacturing.
 Steam.
 Thick.
 Welsh.
 Yorkshire splits.
 Coal miners.
 Cogs.¹
 Collar and two arms.
 Colliers.¹
 Corves.
 Creep.
 Cropping.
 Crowns.
 Crush.
 Cube shaft.
 Darg system.
 Datal men.
 Day-drifts or day holes.
 Dirty-filling.
 Double jumps, leaps, or leads.
 Double turn.
 Drawers.
 Drift mouth.
 Drill.¹
 Drillers.¹
 Drilling posts.
 Dross.
 Dusting.
 Engine plane men.
 Engines:—
 Fan.
 Hauling.
 Locomotive.
 Pumping.
 Winding.
 Face.
 Fall.
 Fanmen.
 Faults.
 Filler.
 Flattening.
 Friable.
 Gassy district.
 Gate end.
 Gate lips.
 Guides.
 Hag principle.
 Hangers-on or hookers-on.
 Hard holing.
 Haulage.
 Haulers.
 Hauliers.
 Headings.^{1,2}
 Hewers.¹
 Hitchers.
 Holers' day or stint.
 Holing coal.
 Hutchies or tubs.
 Inbye.
 Incline boys.
 Intake.
 Jet seam.
 Jigs.
 Jinny.
 Jud.
 Jump.
 Kettle.
 Kibbling.
 Kist.
 Laid-out tub.
 Lamp locking station.
 Landsales.
 Leadage.
 Lessor.
 Limmers or limbers.
 Long wall.
 Loops.
 Mabon's day or week, or Mr. Abraham's week.
 Main road work.
 Making small.
 Marrow.
 Mills.
 Off-hand men.
 Off-takes.
 Oncost men.
 Onsetters.
 Out-crops.
 Overlap.
 Pair of timber.
 Pass by.

Pay lines.
 Pick.
 Pickers.¹
 Picking out slates.
 Pillar and stall principle.
 Pit frames.
 Pit men.
 Pooking or pucking.
 Powder reek.
 Props.
 Putters.
 Pyrites.
 Ramble.
 Repairers.
 Returns.
 Rippers.
 Ripping.
 Roadsmen.
 Rolley-way men.
 Rolls.¹
 Room.
 Royalty.
 Screeners or screenmen.
 Screening.
 Seam.
 Set-out tub.
 Setting trees.
 Shale.
 Shifters.
 Shiftmen.
 Shift systems:—
 Double and single.
 Fore and back.
 Night.
 Off hand.
 Slips.
 Smart money.
 Snap.
 Splits.
 Spragging.
 Sprags.
 Squeeze.
 Stall.
 Steep measures.
 Stint holer.
 Stone caunches or canches.
 Stone headings.
 Stone men.
 Stoop.
 Stooing.
 Stop waggons.
 Stowers.
 Straps.
 Surface hands.
 Surfacedmen.
 Tare.
 Thimble rigged.
 Thin miters.
 Timbering.
 Timber-leader or platelayer.
 Timbermen.
 Tippers.
 Tradesmen.
 Trammers.
 Trapper boy.
 Tub-loaders.
 Turn-chimners.
 Up-cast shaft.
 Waggon men.
 Waggoning stint.
 Waste-men.
 Wayleaves.
 Wedges.
 Weight.
 Winders.¹
 Winners.
 Yardage rate.

COAL (PORTERAGE).

Chaldron.
 Coalies.
 Coaling a steamer.
 Coal men.
 Coal porters.
 Coal whipping.
 Coal workers.
 Colliers.²
 Driving money.
 Fillers.²
 Grab.
 Jib.
 Jib crane.
 Landing.
 Leadage.

Leading.
 Screw colliers.
 Sea-borne coal.
 Shipmen.
 Shooting.
 Skips.
 Tankers.
 Tank men.²
 Unhookers.
 Whipping tackle.

COKE-MAKING.

Carbonising department.
 Coke.
 Coke holes.
 Coke-makers.
 Cokemen:—
 Burners.²
 Drawers.⁴
 Fillers.⁵
 Levellers.
 Small runners.
 Coke-stackers.
 Firing.
 Firing department.
 Iron man.

CONFECTIONERY.

Drillings.
 Pandangles.

COOPERS.

Brewery work.
 Butter firkins.
 Cement trade.
 Coopering.
 Coopers.
 Driving coopers.
 Herring coopers.
 Hoopers.
 Spirit trade.
 Tight shops.
 Tight work, country work,
 and dairy work.
 Wood bound trade.
 (Working.)

COPPER.

Burner departments.
 Burner men.
 Burners.¹
 Calcining men.
 Copperplate roller man.
 Copper shale.
 Coppersmiths.
 Copper workers.
 Drawing-on furnace man.
 Drawing-on roller man.
 Finishing department.
 Finishing furnace men.
 Finishing roller man.
 Finishing rolls.
 Light sheets.
 Paddle.
 Pickling.
 Plate furnace man.
 Pyrites.
 Rollers.²
 Shearing.²
 Sulphur burners.
 Tongs.

CORN, GRAIN, AND SEEDS.

Bushel.
 Cake.
 Choppy.
 Corn chandler.
 Corn meters.
 Dusty money.
 Filler.²
 Heavy money.
 Hot money.
 Linseed.
 Per last.
 Rape seed.
 Weigher.

COTTON (SPINNING AND WEAVING).

Agate.
 Banding.
 Bank.²
 Bank watchers.
 Beam.
 Blending rooms.
 Blowing.²
 Bounty system.
 Breaching.
 Burling.
 Bushel.
 Calicoes.
 Carders.
 Carding.
 Cards.
 Cop-packer.
 Cotton ring.
 Cotton seed
 Counts.
 Creelers.
 Cut-looker.
 Datal hands.
 Doffers.
 Elastic web.
 Fine counts.
 (Fustians.)
 Gassers.
 Grey.
 Grinder.
 Half timers.
 Hand-mules.
 Hank.
 Healds.
 Loomers.
 Mushroom men
 Nap.
 Picks.
 Poundage system.
 Preparers.¹
 Reed.
 Ring spinning.
 Roller coverer.
 Roving frame.
 Sawney.
 Scutch mill.
 Self-actors.
 Side piecers.
 Sides.
 Size.
 Slaying.
 Sliver.
 Spinners.
 Staple (shorter and longer).
 Stare.
 Stripper.
 Sub.
 Tapers.
 Throstle spinner.
 Turn-over concerns.
 Twill.
 Twiners.
 Twist.
 User.
 Velvet.
 Warp.
 Warp dressers.
 Warpings.^{1,2}
 Warping woof (or bars).
 Warps.
 Web.
 Weft.
 Withes.
 Yarn.
 Yarn dressers.

CUTLERY.

Bolster.
 Boss.
 Flying.
 Grinders' hull.
 (Hartford axes.)
 Punch.
 Run on.
 Shooting.¹
 Spelter.
 Tang.

DOCKS, WHARVES, AND WAREHOUSES.

(Abutment jetty.)
 Backer.
 Bag holders.
 Basins.
 Beneaped.
 Berth.
 Blocking.²
 Bobber.
 Bobbing charge.
 Broken work.
 Bulking.
 Bunch hooks.
 Bushel.
 Bushelling.
 Cage.
 Cleat or lowering spar.
 Coalies.
 Coal men.
 Cons.
 Coopering.
 Corn runners.
 Corn trimmers.
 (Delivering.)
 Dockage.
 Dockers.
 Docking of vessels.
 Dockmen.
 Donkey winch.
 Dry dock.
 Duck lamps.
 Dumping ground.
 Graving docks.
 Gunny.
 Hook.
 In the run.
 Jetty.
 Jigger boy.
 Lashings.
 Laying down and raising moorings.
 Lighter.
 Lighterage.
 Lightermen.^{1,2}
 Lighters.^{1,2}
 Lines.
 Loading up men.
 (Loop-holes.)
 Lumpers.¹
 Money :—
 Awkward.
 Contingent.
 Dark.
 Heavy.
 Light.
 Subsistence.
 Walking.
 Mooring chains.
 Moorings.
 Non-freemen.
 Outport moorings.
 Outports.

Packers.²
 Plus system.
 Porters.
 Qualification marks system.
 Riverside labourers.
 Royals.
 Scaleboard.
 Shoots.
 Slip.
 Stabber.
 Staithes.
 Steam cranes.
 Steam travellers.
 Stevedores.
 Strappers.
 Teemers.
 Tier in the dock.
 Timbermen.²
 Tip.
 Tippers.
 Tips.²
 Trimmers.
 Unhookers.
 Upshoot.
 (Warehousing.)
 Watchmen.
 Weigher.
 (Wharfinger.)
 Winch.
 Work :—
 Hopper.
 Jigger.
 Loose.
 Sack.
 Skip.
 (Working.)

DOCKYARDS.

Artificers.
 Assistant constructors.
 Basins.
 Chargemen.
 Check measurement.
 Chief constructors.
 Chief petty officers.
 Classification system.
 Coal drawers.
 Established men.
 Foremen of the yards.
 Forgemen.
 Forgemen's helpers.
 Forgings.
 Guaranteed men.
 Hired men.
 Leading men of trades.
 Master riggers.
 Masters of trades.
 Money :—
 Charge.
 Exertion.
 Tonnage.
 Outports.
 Piece-work system.
 Qualification marks system.
 Rivetters.¹
 Royals.
 Storage.
 Tonnage.¹
 Writers.

DYERS.

Chrome.
 Crabber.
 Dyers.

Dyers' labourers.
 Slubbing.¹
 Stuffing place.

ENGINEERING* AND BOILER-MAKING.†

Admiralty surveyors.
 Angle bars.
 Bending.²
 Belting.
 Blacksmiths.
 Boiler-makers.
 Borers.
 Burred.
 Bushing shells.
 Cataract.
 Caulkers.
 Cogs.²
 Commercial repairs.
 Contingent benefit.
 Crank shaft.
 Cylinder.
 Draughtsmen.
 Drillers.²
 Drivers :—
 Crane.
 Engine.
 Locomotive.
 Scotch derrick.
 Stationary and portable.
 Steam, navvy, and grab.
 Engineering work.
 Engineers.
 Engine fitters.
 Engine room artificer.
 Engines :—
 Fan.
 Hauling.
 Locomotive.
 Pumping.
 Traction.
 Winding.
 Exhaust steam.
 Exhaust steam pipe.
 Fitters.⁴
 Fitters' helpers.
 Foundry.
 Governor.
 Holders up.
 Hole borers.
 Hose makers.
 Iron caulkers.
 Iron founders.²
 Iron moulders.
 Lathes.
 Machine men.¹
 Machine workers.
 Machinists.¹
 Marine engineering.
 Marine trade and work.
 Metal planers.
 Millwrights.
 New and old work.
 Pan smiths.
 Pattern makers.
 Pipe joints.
 Planers.
 Plate mills.
 Platers :—
 Heavy.
 Light.
 Inside.
 Outside.
 Platers' helpers.
 Priming.
 Ram of the press.
 Rivetters.¹

* The following is the usual order of processes in the Engineering Industry :—
 When the requirements of the Engine and various other particular have been decided, the Draughtsman draws out suitable designs. Copies of these drawings on tracing paper or cloth are made and sent to the various Shops.
 In the case where Castings are necessary, Patterns are first made by the Patternmakers, and then sent on to the Foundry (either Brass or Iron), where Moulders prepare the Moulds, and the rough Castings are made; these Castings go through the Fetter's bands, and are passed on to the Turning or Lathe Shop.
 In the case of Wrought Iron or Steel, the material is prepared at the Forge or Blacksmith's shop in the rough state, and then sent to the Turning or Lathe Shop.
 In the Turning or Lathe Shop the Casting or Forging passes through the hands of Turners, Slotters, Planers, Screwers, Millwrights, and Drillers. Thence it goes to the Fitting and Finishing Shops, passing through Fitters' and Finishers' hands. Finally it goes to the Erecting Shop, where the whole construction is erected, and every part put into its allotted place by Fitters. The moving of the parts is done by means of Travelling, Hand, and other Cranes manipulated by Slingers, &c.

† The following is the order of processes in the Boiler-making Industry :—
 The Plates are first Flanged, Rolled by means of Rolls, &c., by Boiler Smiths. They are then Marked off, Drilled, Machine-planed, &c. (by their respective Markers off, Drillers, Machinists, Planers, &c.). The Plates are next put into position and rivetted together by Rivets, in which operations Heaters, Holders-up, and Rivetters are employed. Joints are then caulked by Caulkers, and Fitters place the Fittings, Valves, &c.

Glossing ware.
Glost ovens.
Glost placers.
Grid.
Ground layers.
Hollow ware pressers.
Machine-made bricks.
Majolica paintresses.
Moulds.
Mouths.
Pence money.
Placers.
Platter.
Potters.
Potters' lathes.
Potters' ovens.
Potters' rot.
Pottery trade.
Potting industry.
Ring.²
Sagger house.
Saggers.
Semi-dried bricks.
Setting of the brick.
Spilching.
Tempering.
Thacked up.
Tow.
Towers.
Towing work.
Turners.²
Whirlers.
White dry.
Wire cut brick.

PRINTING.

Binders.
Boxes of folding machines.
Bronzing.
Case chapel.
Cases.
Catching the machines.
Chases.
Clarendon Press.
Composing machines.
Composition.
Compositors.
Copy.
Crown stone.
Distribution.
Driving bands.
Ens.
Father of the chapel.
Fat portions.
Fatter work.
Feeders.
Feeding the machines.
Folding machines.
Form.
Getting out copy.
Gilt work.
Grainers.
Guard of the machine.
Hand press.
Hand setting.
Hastlersley system.
Imposing chases.
Laying on the machines.
Lengths of type.
Letterpress printing.
Linotype system.
Lithographers.
Lithographic stone.
Lithography.
Litho work.
Locking a form up.
Machine chapel.
Machine men.
Machine minders.
Machine setting.
Magazine work.
Making up.
Metalling.
Missing the sheet.
Newspaper men.
Perfecting machines.

Per thousand ens.
Pitt press.
Polishers.
Preparers.²
Pressmen.
Printers.
Printers' labourers.
Putting to press.
Rat labour.
Rattening outrage.
Roller.
Rolling machines.
Runner.
Setting type.
Sheet royal.
Single cylinder machines.
Slab.
Stab wages.
Stages of the machines.
Stereotype plates.
Stone preparers.
Stone shifters.
Takers off.
Taking copy.
Taking off.
Thorne type-setting machine.
Trough.
Turps rags.
Type lifting.
Type-setting.
Typographical printers.
Watching the marks.
Wharfdale machines.
Wipers.
Zinc preparers.

PURVEYORS.

Bacon curing.
Chandlers.
Drysalter.
Italian warehousemen.
Outside shops.
Ships' husband.

RAILWAYS.

Barker rail.
Billed.
Block system.
Brakes.
Brakesmen.
Bush.
Cabins.
Closing a junction.
Demurrage.¹
Diagram.
Dogs.
Drilling.
Engine drivers.
Firemen.¹
Glands.
Guards.
(Haulage returns.)
Hauling engine.
Hoppers.²
(Hungarian belt system.)
Interlocking system.
Link.
Locomotive drivers.
Locomotive engine.
Marshalling yards.
Miles men.
Pegged over.
Platelayers.
Playing up.
Porters.
Rails.
(Rolling stock.)
Roster.
Shop day.
Shunter engine drivers.
Shunters.
Staff.
Surface men.
Swivel bars.
(Tare on trucks.)

Ticket.
Traders' waggon.
Tradesmen.
Trip system :—
Two trip train.
Three trip train.
Yardsmen.

RIGGERS.

Charge men.
Master riggers.
Riggers.
Rigging :—
Work.
Lofts.

RIVERS, CANALS, &c.

Arms.
(Ballast-heaving trade.)
Barge.
Bargeman.
Barges :—
Chance work.
Hoy.
Powder.
Share.
Barges and lighters.
Boaters.
Boat lines.
Boats :—
Compartment.
Flats.
Fly.
Boats in tow.
Keels.
Large.
Slow.
Small river.
Steam.
Charter party.
Charters.
Charterers.
Coalties.
Consignment note.
Dead ends.
Deep sea tags.
Derricks.
Down lock.
Dredgers.
Dumb barge.
Dummy barges.
First class boats.
Flatmen.
Foreshore of the Thames.
Foreward.
Forward.
Freemen.
Gaffer.
Hoppers.¹
Horse marine.
Into lock.
Lay-byes.
Lighterage.
Lightermen.^{1,2}
Lighters.²
Locker.
Lock tail.
Mate.
Monkey boat.
Non-freemen.
Quartermen.
Racking and unranking rafts
of timber.
Reach.
Relay system.
Riverside labourers.
(Scour.)
Second class boats.
Slapping and banging.
Span.
Stage.
Stern sheets.
Stove.
Tally.
Tank barges.

Tier in the dock.
Trip money.
Watchmen.
Watermen.^{1,2}

ROYAL ARSENALS AND
ORDNANCE STORE.

Coal drawers.
Dial square.
Gauging.
Jamming of cartridges.
Labellers.
Magazine cartridges.
Martini-Henry cartridges.
Moulding shells.
Per 1,000 rounds.
Rams.
Slumming.
Soldiers.
Storehousemen.
Storehouse labourers.
Storekeeper.
Storemen.

SEED CRUSHING.

Cake.
Expressed.
Grinders.
Linseed.
Moulders.
Oil crushers.
Oil millers.
Rape seed.
Seed crushers.
Set.
Stampers.

SHIPBUILDING.*

Admiralty surveyors.
Angle bars.
Angle iron smiths.
Angles.
Armour decks.
Armour plating.
Artificers.
Assistant constructors.
Beams.
Bending.²
Bilge suction pipes.
Blocks.^{2,4}
Boards.
Bracing work.
Carpenters.²
Casing pipes.
Castings.
Caulkers.
Chief constructors.
Chippers.
Chocks.
Commercial repairs.
Cutting the heads off.
Decking.
Decks.
Demurrage.
Departments in a shipbuilding
yard :—
Civil engineer's.
Dry dock.
Forge.
Shipbuilding.
Double bottoms of ships.
Draughtsmen.
Drillers.²
Dubbing a plank.
Engineering work.
Fair.
Fitters.²
Fitters' helpers.
Fitting a knee.
Fitting the standing and run-
ning rigging.
Flangers.
Flanges.
Frame-benders.
Frames.

* The following is the order of processes in the Shipbuilding Industry :—

Plans are prepared by Draughtsmen and particulars sent out to the Yards. Draughtsmen also prepare the Boards for the Frame-turners to work to. Frames are then prepared by Frame Turners. Keel, Stem, Sternpost, Beams, Knees, Angles, &c. are next placed by Shorers and Platers. Plates, Decks, &c. are then put into position by Platers and their Helpers, after going to the Punching and Shearing Machines. Heaters, Holders-up, and Rivetters then add their work, and Rivets and Plates are Caulked. Painters follow, and then comes the Launch. Once in water, Engines and Boilers are placed in position and the internal Fittings started; Blacksmiths are employed for Stanchions, Hand-rails, Davits, &c.; Biggers for Masts, Rigging, Sails, &c.; Joiners and Carpenters for Decks, Cabins, and Fittings; Fitters for Pipes used for Pumping arrangements; and finally Painters for finishing off.

Frame-setters and their helpers.
 Frame turners.
 Gridirons.
 Gun mountings.
 Heat.
 Holders up.
 Hole borers.
 Hole cutters.
 Hulls of steamships.
 Iron caulkers.
 Iron founders.
 Iron work.
 Iron workers.
 Jointing a pipe.
 Keel.
 Lathes.
 Launches.
 Launching into berth.
 Laying decks.
 Laying the keel.
 Lengths of shafting.
 Longitudinals.
 Machine drillers.
 Machine made nails.
 Machine workers.
 Marine trade and work.
 Markers out.
 Mast and dismasting.
 New and old work.
 Painters.
 Piece books.
 Pile-drivers.
 Pipes:—
 Bilge suction.
 Condenser.
 Deck.
 Downton.
 Drain.
 Fresh water.
 Tank.
 Planing a rail.
 Planing irons.
 Planing machine.
 Planking.
 Platers.
 Platers' helpers.
 Plating a vessel.
 Plating of a vessel.
 Punching.
 Quarter time.
 Rail ends.
 Red-leaders.
 Rigging:—
 Work.
 Lofts.
 Rivetters.
 Rolling.
 Rolls.²
 Scrap iron work.
 Scuppers.
 Securing.
 Sett.²
 Setting off.
 Shearing.
 Sheathing ships.
 Shears.
 Sheets.
 Shell platers.
 Shell-plating.
 Shells.
 Shipbuilders.
 Shipbuilding.
 Ship carpenters.
 Ship joiners.
 Ships' castings.
 Ships' plumbers.
 Ships' ways.
 Shipwrights.
 Shipyard.
 Shops.
 Side and main drains.
 Skin plates.
 Slingers.
 Slip.
 Slip way.
 Smiths.
 Stage-making.
 Staging.
 Stanchions.
 Steel castings.
 Stem.
 Stern post.
 Strapping pipes and tubes.

Stringers.
 Tank making.
 Tank men.¹
 Tanks.
 Task or job work system.
 Templates.
 Thwarts.
 Torpedo defence work.
 Torpedo tubes.
 Tradesmen.
 Trunnels.
 Uprights.
 Valves.

SHIPPING.

Abaft.
 A.B.'s.
 (Abutment jetty.)
 Aft.
 Allotment note.
 Amidships.
 Anchor watch.
 (Ballast-heaving trade.)
 Battens.
 Belaying pin.
 Bending.¹
 Beneaped.
 Berth.
 Bilges.
 Bilge water.
 Blocking.²
 Blocks.
 Blood money.
 Boatwain.
 Boom.
 Bow.
 Boxing fleets.
 Bulkhead.
 Bunker coal.
 Bunkering.
 Bunks.
 Cable chains.
 Cable rope.
 Chain locker.
 Charterers.
 Chocks.
 Coal hulk.
 Coaling a steamer.
 Coal trimmers.
 Coal trimming hobbler.
 Coal workers.
 Colliers.²
 Combings.
 Crimping.
 Deals.
 Deck hand.
 Deck houses.
 Decks.
 Deep sea tug.
 Demurrage.²
 Derricks.
 Distrating.
 Dog watches.
 Donkey man.
 Double bottoms of ships.
 Embargo.
 Fiddley.
 First class boats.
 Forecastle.
 Fore-peak.
 Foresail.
 Foreward.
 Forward.
 Frames.
 Freemen.
 Free on board principle.
 Freightage.
 Freighters of coal.
 Gaff.
 Galley.
 Guy.
 Hatch:—
 After.
 Main.
 Hatchways.
 Heaving the lead.
 Hobbling pilot.
 Hoist men.
 Holystoning.
 Hoppers.¹
 Iron ore men.
 Jettison.
 Jetty.

Keel.
 Lagging a boiler.
 Large boats.
 Lascars.
 Laying down and raising moorings.
 Lengths of shafting.
 Light cargo.
 Lines.
 Lloyds.
 Lloyds surveyors.
 Loadline.
 Logging offences.
 Longitudinals.
 Main sail.
 Manning scale.
 Man-ropes.
 Mooring chains.
 Moorings.
 Mooring work.
 Non-freemen.
 Ocean tramps or tramp steamers.
 Oil tank steamers.
 Original packages.
 Orlop deck.
 O.S.
 Outport moorings.
 Overhaul.
 Palm.
 Pantiles.
 Paper ship.
 Peak.
 Pier head jump.
 Pipes.
 Propellers.
 Quarter.
 Rams.
 Relay system.
 Repair work.
 Runners.
 Running a ship on end.
 Sailing trawlers.
 Salvage work.
 Scabs.
 Scraping.
 Screw colliers.
 Scuppers.
 Second class boats.
 Shears.
 Shippers.
 Ships' husband.
 Shoots.
 Side and main drains.
 Small sloop.
 Span.
 Spars.
 Splicing a hawser.
 Stabber.
 Steam trawler.
 Stem.
 Stern post.
 Stow.
 Stowing the topsail.
 Tank men.¹
 Tarring.
 Teemer.
 Three decker.
 Three sticks.
 Timbermen.²
 Time charter.
 Tips.
 Topsail.
 Torpedo defence work.
 Torpedo tubes.
 Tramp steamers.
 Trimmers.
 Try-sail.
 Tween decks.
 Two decker.
 Unstowing or breaking out.
 Wasters.
 Water-logged.
 Well decker.
 Winch.

SHIPWRIGHTS.

Artificers.
 Chief petty officers.
 Engine room artificer.
 Fair.
 Gunnery.
 Ironwork.

Lloyds' surveyors.
 Shipwrights.
 Shore.
 Torpedo work.

SILK.

Dressers.
 Fly.
 Gassers.
 Gymp.
 Plush.
 Reelers.
 Seals.
 Velvet.

SILVER.

De-silverising process.
 New Zinc process.
 Old Pattinson process.

SILVER PLATE MANUFACTURE.

Silver buffing.
 Silver filing.
 Silver finishing.
 Silversmith.
 Silver stamping.

SLATE.

Back joints.
 Bargain.²
 Bargain letter.
 Bargain setting or letting.
 Bargain takers.
 Blocks.¹
 Caniata.
 Counter and sub-counter.
 Countesses.
 Crowbar.
 Dresser.
 Dressing slate.
 Dykes.
 Examiner and sub-examiner.
 Foot joints.
 Free stone.
 Gelatine.
 Granite.
 Lessor.
 Letting.
 Levels.
 Lien.
 Loaders.
 Local manager.
 Overlooker and sub-overlooker.
 Poundage.
 Putting shot-holes off.
 Rockman.
 Rubbisher.
 Rubbler.
 Sett.¹
 Setter.
 Setting.
 Sett quarries.
 Slab truck.
 (Slaters.)
 Slate veins.
 Slate bill.
 Splitters.
 Stemmed.
 Timekeepers.
 Tips.¹
 Wastes.
 Whistle to whistle.

SMELTING.

Converter men.
 (Forges.)
 Gas producer men.
 Melting shop and plant.
 Puddlers.
 Puddling forge.
 Sample passer.
 Smelters.
 Smelting department.
 Steel workers.
 Stint.

<p>STONE.</p> <p>Chargers. Drill.¹ Drillers.¹ Drivages. Free stone. Granite. Landings. Macadam stone. Sett.¹ Slate veins. Stone. Stone headings. Tool faced flags. (Winstone.)</p>	<p>Drawers.^{1,2} Drawing. Dressers. Fallen fleeces. Feeders.^{1,2} Fettlers. Flax dressers. Flyings. Fudd. Grey. Gymp. Honey-comb shawls. Jobber. Knotters. Mending. Millner. Mindors. Mohair. Mungo. Perch. Per pack. Per tod. Per top. Pickers.² Picks. Piecers. Play. Power loom. Preparers.¹ Rag grinding. Reducing boxes. Roving boxes. Scouring. Scribbling. Scribbling machines. Sett.² Shoddy. Side minders. Skip. Slubbing.^{1,2} Spinning frame minders. Spinning mule. Staple (shorter or longer). String in length. Sub. Swabbing. Tacklers. Teazer. Tenters. Top makers. Traps. Tuning. (Valensias.) Warps. Weavers. Weft. Willeyer. Willeying. Winders.² Wool combing. Wool sorters' disease. Woolstaplers. Worsted. Yarn.</p>	<p>MISCELLANEOUS.</p> <p>Absolute piece-work. (Affiliated orders.) (Alfalfa grass.) Aliment money. Bate. Bevelled wheels feeding in-wards. Birmingham system. Boom.¹ (Branch.) Brokers' swipe shop. Bulls and bears. Byres. Cag-mag. Chancery joint. Cleaners. (Clearance.) Coal hulk. (Coal ring.) (Coastwise.) (Contrary.) Corn chandler. <i>Crèches.</i> Datal work and wages. Debenture shares. Demurrage.¹ (<i>Doctrinaire.</i>) (Drawing a clearance.) Dutch auctions. (Etiolation.) (Etiology.) (Fend.) (Fetting up.) (Financial rings.) Fou system. Fur pullers. Furth. Gaffer. Game of grab. Gangers. (Gangers.) Gelatine. (Gentile settlements.) Hobblers. House jobbers. (Huth's.) (Indifferently.) Jib. Jib crane. (Jobbing men.) Jolly. (Labourers.) (Lager beer.) Malingering. Members :— Affiliated. Full. Honorary. (Moot.) (Negated.) Ordinary shares. Packers.² (Park-keepers.) Payment by billet. Payment on the box. (Periodicity.) Picketing. Piece books. (Piece-work.) (Plumb.)</p>	<p>Presently. (Primordial.) Private member of Parliament. (Propagators.) Purchases. Regular timer. (Rigging.) Ring.¹ Sacrifice allowances. (Salt ring.) (Schedule A.) (Schedule B.) (Schedule D.) Set wages. Shifting money. Shop stewards and contractors. Slate club system. (Societies :— Affiliated. Collecting. Dividing.) Standing charges. Strike ailment. Task work. Tenement houses. (Thatchers.) (Tontine.) Truck system. Ullages. Wake time. Wastrel portion. Weight :— Long. Short, statute, or imperial. (Wheelwright.)</p>
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