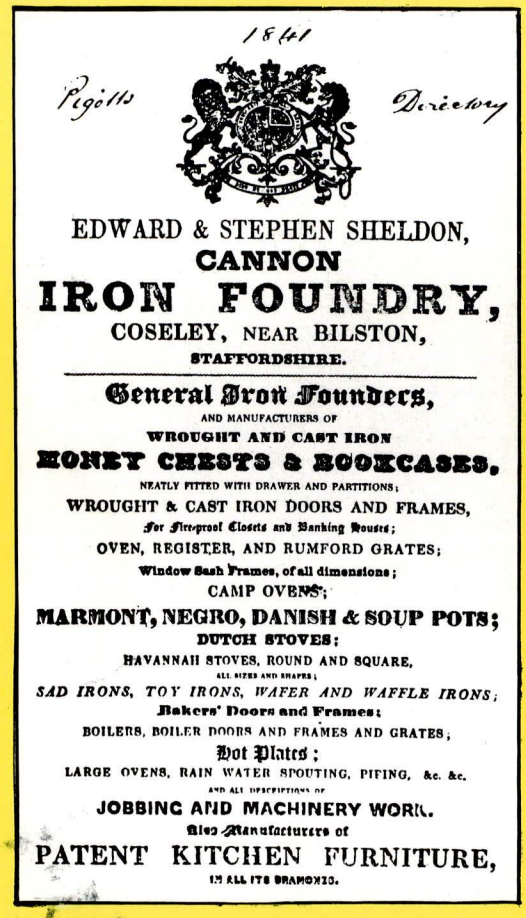
THE CANNON FOUNDRY COSELEY

THE FIRST 100 YEARS 1826-1926



Black Country Society Studies in Industrial Archaeology No. 5

A storeroom view showing the many sizes and patterns of Negro, Kaffir and Cannibal pots.

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THE CANNON FOUNDRY COSELEY

Prepared for press by RON MOSS

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THE CANNON FOUNDRY

INDEX

THE HISTORY OF THE CANNON FOUNDRY
DEEPFIELDS, COSELEY 1826 – 1926

FOREWORD

By Ron Moss,
Director of The Industrial Archaeology Group
of The Black Country Society

In May 1979, members of the Industrial Archaeology Group, who are always keenly noting the complex changes taking place in the Black Country, passed by the foundry site of The Cannon Iron Foundries, established in 1826 on a piece of land situated between Havacre Lane, Coseley and the Birmingham to Wolverhampton canal near to the Coseley Tunnel. They observed that this once bustling busy site, famed throughout the world for its castings appeared to be deserted.

Over the past few years, many famous, long established firms in this area have closed down and in a very short time the buildings associated with it have been razed to the ground. Fearing that these buildings might encounter the same fate I wrote to Cannon Industries saying that in our opinion this was a historic site and the buildings contained on it formed probably the finest mid-19th Century foundry complex remaining in the Black Country. I asked if it would be possible for a group of our members to have permission to pay a visit to the site to enable them to carry out a photographic and measured survey. I received a reply from Mr. W. I. Jenrick the present Managing Director who at that time held the position of Finance Director offering us any assistance that we may require to carry out our survey. Two surveys were in fact carried out, the first being a short 'reconnaissance' in August 1979 and the second being a day-long survey on Saturday 1st September 1979. Many interesting buildings were surveyed including one of the moulding shops, an inside photograph of which appeared accompanying an article in The Blackcountryman magazine in 1973[1]. This photograph clearly shows the casting of 'Negro' or 'Kaffir' pots, the more popular name for these products being 'Cannibal pots', one of Cannon's early successful export items.

Two very generous donations to help with the production and printing of this booklet have been received from Cannon Industries, one during September 1979 and another in April 1986.

It was most fortunate that we carried out our survey of the Cannon Foundry site at the time we did because eight or nine months later a major fire swept the site leaving the buildings in such a dangerous condition that Cannon had no alternative but to demolish the remains and clear the site. For the next few years the only reminder of the foundry and other workshops that had occupied the site for the past 150 years was a chimney stack. Set in the brickwork a few feet from the top was a stone bearing the date 1882. This stack was demolished using explosives on the 5th February 1984, its bricks were transported to the Black Country Museum to be used in the construction of a similar chimney stack to serve the Anchor forge on that site.

Documentary research was carried out by members of the Industrial Archaeology Group over the next few years at various places, the most prolific source of information being the records stored in 'strong rooms' at the offices of Cannon Industries. At the kind invitation of Mr. Pritchard of Cannon we were able to examine early deeds, papers and maps. From this information we were able to pinpoint the exact part of the site on which the works were originally established in 1826. The impression formed when we first surveyed the site was that the first buildings were constructed at the Biddings Lane end; on examination of the mass of information gathered during our research, it was realised that the first part of the site that was occupied was the opposite end.

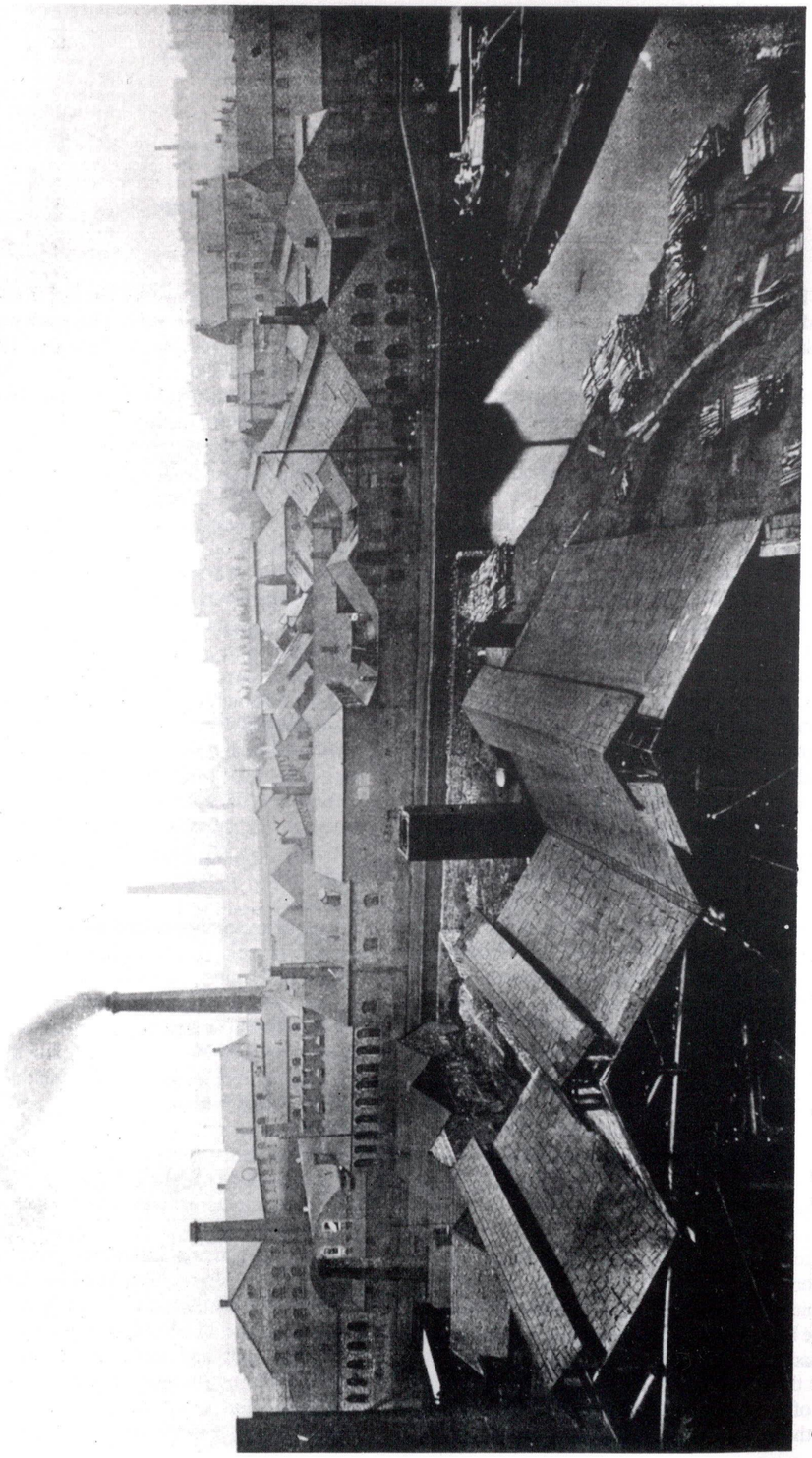
Barry Harris, a member of our Group, volunteered for the formidable task of putting the wealth of information collected into some sort of order so that the first draft could be typed, from this the final text was produced.

A complete change of land use has taken place on this vacated historic site, from industrial to residential. A visitor to the site today will see rows of neat detached houses where once the Foundry buildings stood. Cannon Industries meanwhile are concentrating development on their other site situated on the other side of the railway main line between Darkhouse Lane and Gough Road, here several million pounds have been spent creating a factory capable of competing in this specialised field on equal terms with the best in Europe.

The following members of the Industrial Archaeology Group were involved with me in the surveying, research and writing up of the following account of the early activities of Cannon Industries, John Cooksey, Pete Glews, Barry Harris, Dan Houldin, Keith Hodgkins, Andy Rutter and Ann and David Whyley.

I would like to record our grateful thanks to the Directors, staff and members of Cannon Industries without whose help most of the information contained in this account would never have been recorded for posterity.

1. 'This Cannon has fired for almost 150 years' Harold Parsons, 'The Blackcountryman' Vol 6, No. 3, p 13.



Some idea of the buildings on the Cannon Iron Foundry site can be gained from this photograph probably taken from the top of one of the blast furnaces at the Priorfields Ironworks. The large warehouse can be seen on the left while to the extreme right can be seen the towpath bridge over the entrance to the Cannon canal basin. This very interesting photograph appeared in a magazine of 1898.

ONE

THE HISTORY OF THE DEEPFIELDS SITE

The "DOWRY" Land Piece

A large proportion of the first 100 years activities of the Cannon Foundry that this publication sets out to cover were carried out on a substantial site at Havacre Lane in Deepfields, Coseley. It was established in 1826 by the Sheldon brothers originally on a small piece of land covering barely half an acre in one corner of this site. The original site was called the "Dowry" in early deeds. The description of the plot when conveyed in February 1827 to Edward and Stephen Sheldon was that it was bounded on one side by a towing path of the Birmingham Canal Navigations of a length of 20 yards; and measuring 27 yards on the opposite side having a depth of 17 yards. The rights to coal, ironstone and other minerals however remained with the Rt. Hon William, Viscount Dudley.

This plot of land can however be traced back to the ownership of the Turton family. The earliest mention of this family is of Sir William de Turton Kt. of Turton Tower in Lancashire, while the Staffordshire branch appears to begin with a reference to Nicholas Turton of Dudley about 1470. The Black Country branch of the Turton family rapidly became wealthy landowners with a prominent position in social circles. The ownership of the Dowry plot at Deepfields which was to have the historical distinction of being the origin of the present Cannon Industries can be traced back to John Turton of Cotwall End. John Turton (born 1758, died 1787) had two children, Elizabeth (born 1786, died 1828) and John (born 1788, died within 12 months). It appears possible that at the birth of Elizabeth, a piece of land, part of the Turton estates was set aside as a dowry for her by her father as was fashionable in those days. A glance at the aforementioned dates shows that he died one year after her birth. Although it is not known what settlements went to his wife Sarah, or how long she lived after his death, Elizabeth is mentioned in a deed dated 25th September 1807 (either on or around her 21st birthday) leasing land at Coseley to Joseph Lane of Sedgley and Richard Fryer of Wednesfield for the sum of five shillings.

The piece of land that was possibly set aside for Elizabeth carried the name 'The Dowry' or 'The Dowry Piece' and is so called in deeds and referred to on the earliest map in the Company's records as the original site of The Cannon Foundry. A letter to Cannon from The Priorfields Ironworks (on the opposite side of the canal) mentions "Dowry Wharf" and it is interesting to note that the canal arm that was cut later to serve the site is located on the Dowry Piece.

The 1827 deeds show that the land and hence the foundry was served by a branch of the Birmingham Canal Navigations the main line of which turned towards Bradley before reaching the site, and so provided a useful transport facility. Many branches or arms off the main line, cut to serve various industries and colliery workings would be present in the vicinity of the 'Dowry Piece' as early as 1772. A survey for the B.C.N. was carried out by J. Robins in 1793 and this proposed a new cutting and tunnel between Bloomfield at Tipton and Deepfields, then in the parish of Sedgley, this would reduce by many miles the contour canal route as originally constructed by James Brindley encircling Coseley Hill and passing through Bradley on its way to Birmingham. The estimated cost of this venture was £19,200 but construction was suspended owing to objections from landowners, cutting however began in earnest in 1798. The length of the cut was a little over one and three eighths miles and eventually reached the point where tunnelling would need to begin and work was once more suspended.

In 1836 mines under the intended tunnel were purchased and work re-commenced only to be hampered by the strata which had been 'jumbled' by coal workings. On 2nd April 1838 the Coseley Tunnel was finally opened and this further enhanced the transport opportunities to the Cannon Works and probably encouraged expansion of the works on that site.

The area of land on which the Dowry piece was situated had numerous small collieries working and these included in the immediate neighbourhood – Ladywood, Coseley New and Hitchin collieries. The seams being worked varied from brooch and fireclay coal to bottom coal at depths varying from 182ft to 575ft deep.

Hitchin colliery actually mined under the 'Dowry' site in the early years of the 19th century. Some idea of the seams and depth of coal in the area around the Cannon Foundry site can be formed when looking at a section diagram of the area below the nearby mainline railway which runs parallel with Havacre Lane. This line and Lane divide the two portions of Cannon, the old original site next to the canal and the newer site on which today's Cannon Industries buildings are located.

The seam of coal known as 'Brooch coal' which varied in thickness from 3 feet 6 inches to 4 feet 6 inches was

situated between 120 and 170 feet below the Railway trackbed. 'Flying Reed' coal, which varied from 4 feet to 5 feet 6 inches thick was to be found at 200 to 231 feet deep. The 'Thick coal' in this area was around 24feet thick and occured at 260 to 360 feet down, while below this there were seams of 'New mine' coal around 5feet 6 inches thick at 400 to 500 feet deep and 'Bottom coal' which was around 4 feet thick. A layer of Ironstone was to be found about 350 feet down. The variations in depths were due to faults in the area.

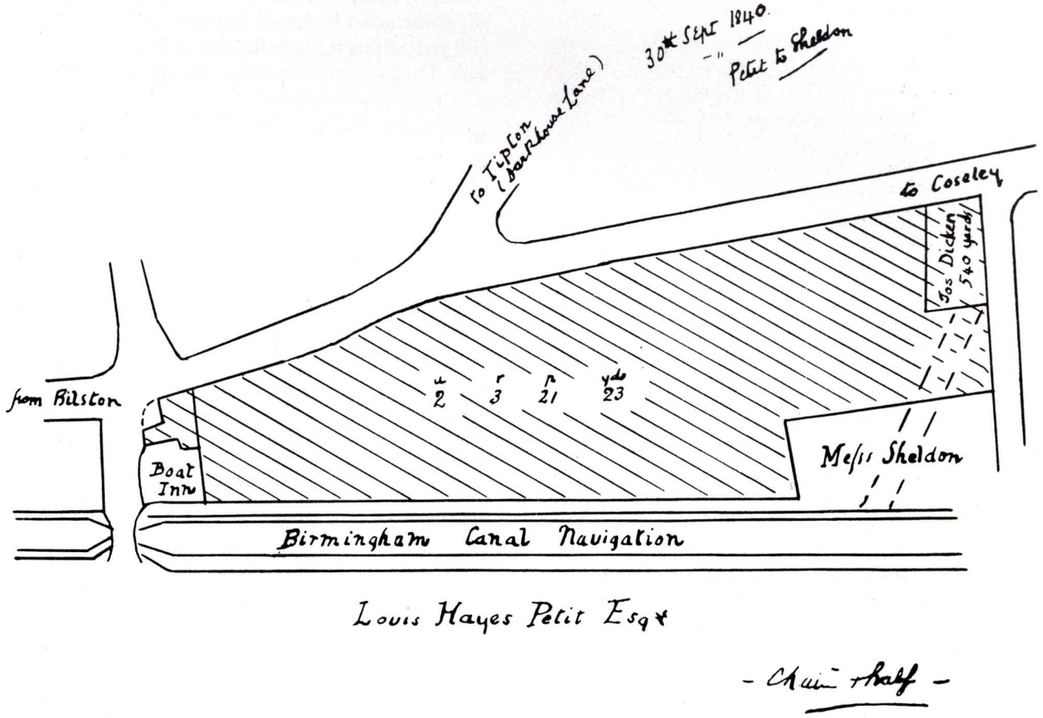
When recorded mining was carried out in this area in the 1850's, a note in a report stated that "old workings in all seams were encountered". Owing to the nearness of the coal to the surface numerous small pits known as 'Jack Pits', 'Gin Pits', 'Oss Pits' and 'Open works' were in operation in this district.

There are numerous documents in the Company's possession concerning the purchase or lease of various lands in the Coseley area, for example on the 14th October 1826 land was conveyed to the Sheldons from a Mr. Hartland at a cost of £13 5s. 6d. Documents are in existence relating to land at Fullwoods End, Coseley in 1834 and the leasing of mines and land at Headsall Colliery from 1850. Several plots of land were acquired by the Company over the period covered by this book so that by 1926 the Cannon Foundry site covered 26 acres.

The Land Bordering 'The Dowry'

The piece of land conveyed to the Sheldons was bounded on two sides by over two acres belonging to one Louis Petit Esq. This relatively large parcel of land stretched along the B.C.N. Canal to premises called 'The Boat Inn' and bounded by Darkhouse Lane. In the corner of the plot was an area of 540 sq. yards belonging to a Joseph Dickens. In 1840 the land belonging to Petit was conveyed to the Sheldons and was held by the family until conveyed to Cannon itself in the 1880's. The small area owned by Joseph Dickens was in fact purchased by Dickens in 1840 from the same John Louis Petit for the sum of £14 5.0. This small parcel of land changed hands several times until acquired by Cannon sometime after 1863.

The whole of this land became bounded on one side by the B.C.N. and on the other by the London & North Western Railway line which is recorded as being opened on July 1st 1852. The railway was completed two years



The original of this map, which is held by Cannon Industries is in very poor condition. The above reproduction is a close copy. It is a very important map because it shows the original works site of Edward Sheldon in the bottom right-hand corner. This map was produced to show the site, between the canal and Havacre Lane (shaded) which was being conveyed to the Sheldon family from John Louis Petit in 1840. This area was destined to become the Cannon Iron Foundry, until vacated in 1978-9. The dotted line across the Sheldon 'Dowry Piece' is pencilled in on the original map and obviously shows the proposed canal basin.

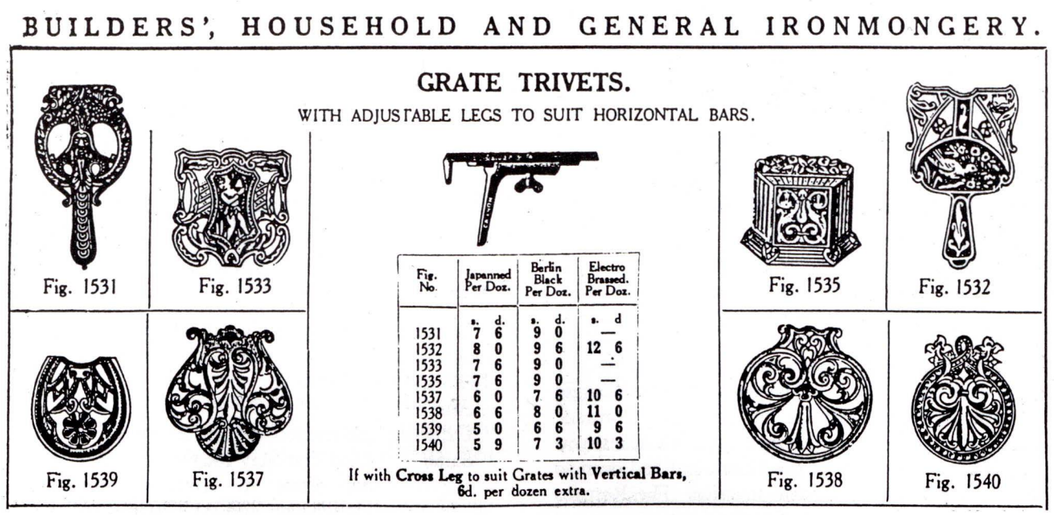


Fig. No.	Japanned Per Doz.	Berlin Black Per Doz.	Electro Brassed. Per Doz.
	s. d.	s. d.	s. d
1531	7 6	9 0	—
1532	8 0	9 6	12 6
1533	7 6	9 0	—
1535	7 6	9 0	—
1537	6 0	7 6	10 6
1538	6 6	8 0	11 0
1539	5 0	6 6	9 6
1540	5 9	7 3	10 3

earlier but remained unopened owing to a dispute between the L.N.W.R. as lessees of the Severn Valley Railway and the Shrewsbury & Birmingham Railway over running powers between Birmingham and Wolverhampton. A branch or siding originally left the main line railway and curved its way down to serve the site. Deepfields Goods Depot and Deepfields passenger station were close to the site. As the firm expanded the site gradually became taken up by the necessary buildings generally associated with a growing foundry such as, the melting, moulding and casting shops, pattern shops, finishing departments and warehouses.

On the other side of the L. & N.W.R. line there were parcels of land called Big Havacre, The Hill, Little Havacre, Copps Piece as well as three acres called Barn End Piece backing on to Church Lane and over four acres known as Clowe Piece and Arleys Piece which backed on to houses and Green Foundry. In addition there were other parcels of land owned respectively by Wm. Webb, Messrs. B. Whitehouse & Sons (the proprietors of the Priorfields Blast Furnaces) and a plot called Bucknalls Piece. All this land was subsequently acquired by Cannon to accommodate the Gas Stove foundries and fitting shops, the cooperage, various stores and the power houses. There are a number of deeds in the Company's possession which relate to arrangements between Cannon and the Whitehouse family and Company from the 1870's into the 1910's.

Fullwoods End can be traced back to deeds of the 18c when a Sarah Fulward owned the land and in 1787 conveyed a parcel of it to George Caddick. The parcels of land in this area were owned by the Caddick family, the Dixons and the Grocutts and were acquired by Cannon at the turn of this century. The Grocutts were Ironmasters of Bankfield Ironworks, Bilston, and the Caddicks were Cupola Tenders and screw turners in the mid 19c.

The street names around the Cannon site bear witness to the previous owners of parcels of land acquired by Cannon. Havacre Lane, for example, after land of the same name, Foundry Street after Greens Foundry, Webb Street after land owned by William Webb and Fullwoods End (previously mentioned) after Sarah Fulward. Gough Road refers to Ralph Gough who's name appears in deeds in the early 19c and had dealings with the Sheldons over a period of years including an agreement between himself and Edward Sheldon in 1852 regarding a right of way.

TWO

THE ORIGINS AND FORMATION OF THE COMPANY

The Sheldon family interests

The Company was established in 1826 and was known as Edward & Stephen Sheldon & Co. Ltd., for the manufacture of cast iron pots and pans. Stephen Sheldon is referred to in the magazine 'The Hardwareman' as a "Junior partner who either died or retired from the firm", this appears to have been in the early years of its life. We have had little success in establishing the correct reason why he left the firm. Domestic holloware manufacture prior to the Sheldons was primarily in the hands of the Dutch and had been so since the days of the Roman invasion. The Romans brought with them the art of pot and pan making but when they left Britain the craft disappeared and cooking utensils were imported into the country until the 16c.

In 1584 a lease of works at Iselworth was granted to John Brode a citizen and goldsmith of London for the making among other things of 'Kyttles' which he fashioned by hammer from brass plate. In 1634 two companies were in existence at Tintern and Wandsworth for pot and pan manufacture, whose owners were Dutchmen who had migrated from Mechelen in Flanders. One of these Dutchmen, Cornelious Holland Jr. settled at Coalbrookdale and had removed to Stourbridge by 1682. His descendants followed in the same trade and one of them, David Hallen established himself in Birmingham. It appears therefore that the holloware trade was establishing itself quite early in the Midlands.

In 1826, an early Parish map indicates that a parcel of land designated with the reference '359[n]' and covering an area of two rods and ten perch was partly occupied by Edward and Stephen Sheldon who were also described as the proprietors, and a Mr. Turton whose plot of land was owned by a Mr. Henry Smith. Adjoining this area was a plot of land over three acres occupied by George Jones and owned by Louis Hayes Petit. On the latter were shown collieries, a brick kiln and yard. An engine foundry was shown on the plot in the ownership of the Sheldons.

By 1843 the Sheldons had acquired an area of one acre, three rods and 29 perches. Shown occupying the site at this time was the Deepfields Foundry, a yard, a basin, brick kilns and a clay hole. An area in the top corner of the overall plot was a house occupied by Joseph Dickens, being sited on 17 perches of land owned by him. Edward Sheldon purchased further land in 1852 from Ralph Gough, by which time Stephen Sheldon had left the Company and his name dropped from the firms title.

The death of Edward Sheldon

Edward Sheldon died 1st April 1853 and from 1st January 1855 the company traded for a time under the name of the "Executors of the Late E. Sheldon".

Under Edward Sheldon's will his real and personal estates were left to his wife Mary (died 17th March 1857) and his daughters:

Ann
Catherine (married to William Barnett)
Sarah (died 21st May 1869 leaving residue of her estate to brother-in-law John Hawthorne and Mr. John Creswell, secretary of the Company)
Matilda
Mary Jane (married to John Hawthorne; died 1862)

From the death of Edward Sheldon the business was continued by his sons-in-law William Barnett and John Hawthorne.

In June 1860 William Barnett a director of the Company took the decision to drop the "Executors" prefix and the business traded under the title of E. Sheldon & Co. William Barnett and wife Catherine had a son Edward Sheldon Barnett and a daughter Fanny Eliza whilst John Hawthorne and wife Mary Jane had a son William Henry Hawthorne. Both sons (the grandsons of Edward Sheldon) later became directors of the Company.

In 1874 Richard Clayton (b 1846) from Ingwardine Scotland, a practising solicitor, married the granddaughter of Edward Sheldon, the aforementioned daughter of William and Catherine Barnett, and he became involved in the Company's business.

A further name change

In May 1884 the title of the Company was changed from E. Sheldon & Co. Ltd. to the Cannon Hollowware Co. Ltd. which became registered with a capital of £50,000. The conversion of the concern into a private limited company was to simplify the interests of the partners; and the title reflected the company brand name to which it had become identified as being synonymous with the Company.

The allotment of the company shares were made as follows:

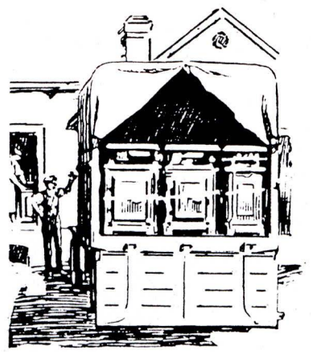
Matilda Sheldon	323
Ann Sheldon	323
Catherine Barnett (nee Sheldon)	323
Edward Sheldon Barnett (appointed Managing Director)	323
Richard Clayton (appointed Chairman)	223
Fanny Eliza Clayton (nee Sheldon)	100
William Henry Hawthorne (Director)	323
John Creswell (Company Secretary)	12

The shares in the 'New' Company were to be held exclusively by the members of the original firm of E. Sheldon & Co. and could only be disposed of subject to the stringent rights of pre-emption reserved to the then partners.

In 1897 some share transfers took place, these being:
Matilda Sheldon to Fanny Clayton – 107
to Edward Sheldon Barnett – 107
to William Hawthorne – 108
Catherine Barnett to Edward Sheldon Barnett – 322

Illustration from a Cannon Catalogue of October 1847. This was manufactured for a trap dealer.

The Cannon Iron Foundries Ltd.

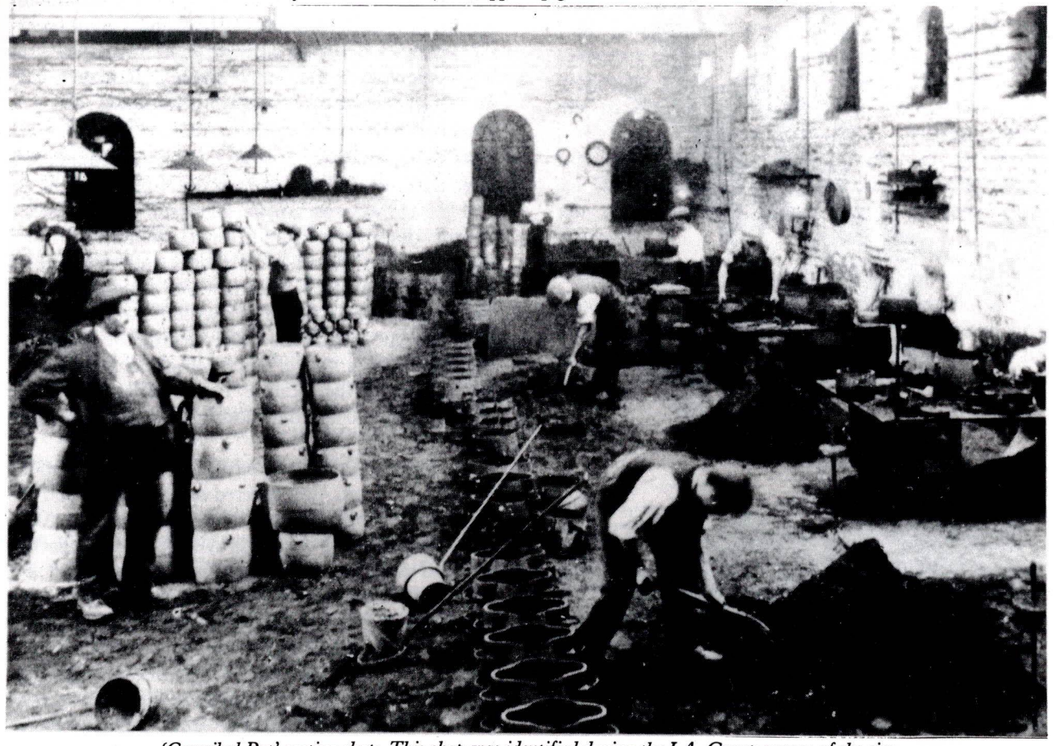


In 1900 the Cannon Holloware Co. Ltd. changed its name to The Cannon Iron Foundries Ltd. to reflect more accurately the nature of its business. Apart from the holloware business the Company's activities had been extended to include Porceliron sanitary ware, chemical ware and grindstones, gas cooking and heating stoves. The position of the firm's site was well situated for its raw materials, the coal coming from collieries surrounding the site, probably by means of tramways shown on various early plans of the area, while the pig iron (obtained during most of the period covered by this book) came from Priorfields Furnaces on the opposite side of the canal from the works. The site was well served from a transport viewpoint, the London and North Western Railway adjoined the works on one side and the canal system on the other. The offices for the directors, managers and clerical staff were conveniently in touch with the works while speaking tubes connected the different departments, the firm being connected to the National Telephone system at an early stage having the number of 'Bilston 21'.

At the turn of the present century the Company's estates and works covered 16 acres. The Company remaining a private concern, the shares still held exclusively by the descendants of the firm's founder, Edward Sheldon. The Board of Management consisted of Richard Clayton – Chairman, while Edward Sheldon Barnett and William Henry Hawthorne were directors. By 1902 Mr. John Mason had become the Company Secretary with a staff of nearly 40 clerks and was the largest firm in the locality. The total workforce was approaching 700 and the annual wage bill had reached £35,000.

By the time of the Company's centenary celebrations in 1926 the works sites covered some 26 acres and the number of people employed was approaching 1000. The Managing Director was Mr. R. Talbot Clayton who had taken over the position from his father Richard Clayton who had died a few years previously. On the board with R. Talbot Clayton at this time were his two brothers R. Douglas Clayton and Francis E. S. Clayton. Other members of the board included Edward Sheldon Barnett, William Henry Hawthorne and his two sons Herbert Sheldon Hawthorne and William Edgar Hawthorne.

The Birmingham to Wolverhampton Canal, looking towards Coseley Tunnel, that divided the Cannon Iron Foundry on the left from the Priorfields Iron works (that supplied pig iron to Cannon) on the right.



'Cannibal Pot' casting shop. This shop was identified during the I.A. Group survey of the site.

THREE

THE CANNON HOLLOWARE BUSINESS

The mainstay of the firms business in its earliest days was cast iron domestic holloware or 'Sheldon's pots and pans' as they were commonly known. It remained an important section of the Company's activities one hundred years later by which time the firm had expanded into sanitary ware, chemical ware, grindstones and their famous gas cooking and heating stoves.

Cooking Utensils

The Sheldons started their business in 1826 for the manufacture of cast iron holloware and it was the Company's proud boast that the Cannon brand of holloware was known and in use world wide. The sales record over the century remained substantial and healthy despite the later increasing competition of enamelled steel and aluminium. The Foundry when first established covered barely half an acre of land and employed about 15 to 20 people. During the first one hundred years of the Company's operations it produced and distributed throughout the world literally millions of saucepans, stewpans, kettles, oval pots, preserving kettles and similar items. The Company's products reached their customers by road and the developing canal system and thence via British ports to their large overseas market later of course helped by the railway system.

Most of the Company's supply of pig iron used in the first 100 years came from the Priorfields Blast Furnaces situated on the opposite side of the canal to the works site. These were owned by Messrs. Henry Bickerton, Whitehouse and Sons and there are in existence many records of dealings between Mr. John Crump and Mr. Benjamin Whitehouse of this firm with Mr. Edward Sheldon of 'Cannon'.

Over the years the Deepfields Foundry developed and modified their holloware products and patented many improvements. They started to produce their wares with an enamelled or tinned finish. The Company's porcelain enamelling process was a jealously guarded secret, this was their own development and patent and was known as 'Porceliron', it made their wares universally popular. This process was both elaborate and costly and required specialised knowledge and expensive equipment. The enamelling consisted of a pure vitrified lining guaranteed free from lead or any other deleterious ingredients. Other qualities of this process are mentioned later in the story.

The later hollowares were produced with tinned interiors, being of best English refined pure tin. The method of tinning used at Deepfields was for the tinsmith to pour into the utensils to be coated the liquid tin, distributing it carefully over the interior by means of cork fastened in a long pair of tongs.

A particular feature of the holloware manufacture was the patent hexagon handles fitted to saucepans. To make these, large power presses were installed. The handles were known as 'F.G.', simply meaning 'firm grip', the hexagon shape providing an easy and effective grip and preventing slipping in the hand when the contents of the saucepan were being strained.

A noticeable feature of the products was Claytons patent 'Perfect' self ventilating strainer cover, this was the invention of Richard Clayton. The cover had a number of perforations around its edge which ensured that the steam escaped and avoided the possibility of boiling over, a dangerous situation when used on a gas stove.

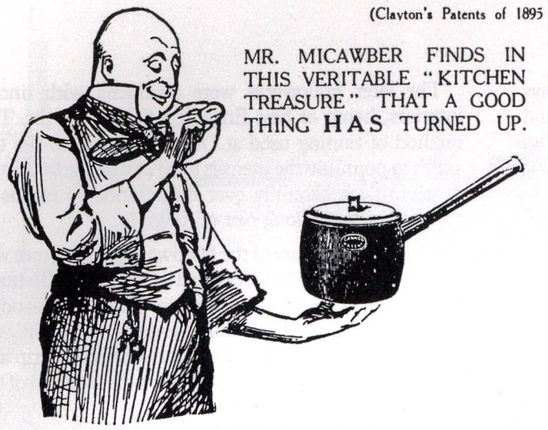
The lids were produced on steam driven automatic presses and tools, cutting out and shaping the sheet steel used for this purpose. One machine cut out the disc and a power press roughly fashioned the lid. Another machine cut off the rough edge and at the same time formed the ledge or rim in the lid. The next operation was the attaching of the lid handle, the ends of which were passed through the lid and securely clenched and fastened on the inside. The covers were subsequently tinned all over. By the late 1890's the exterior of the various utensils were japanned. The japanning shop had a double tier of drying stoves, each stove accommodating from 400 to 500 pots and pans which were loaded into the ovens on wheel mounted racks. When they emerged from the drying stoves the wares travelled, on the racks by means of tramlines to the finished warehouse, which comprised five large floors, each floor measuring 300 feet long by 80 feet wide. The weekly output from one floor of the warehouse exceeded 5000 saucepans.

The five floors of the warehouse were connected by a power lift. A quite distinct speciality introduced around the turn of the century was a cast iron new shaped broad bottomed saucepan known as the Cannon Reform saucepan. The chief advantages of the design was the greater diameter of the bottoms giving an increased heating area size for size; and the greater cubical area of the lower part giving increased cooking space size for size.

"CANNON"

"Perfect" Self-Vent Strainer Covers.

(Clayton's Patents of 1895 and 1909)



MR. MICAWBER FINDS IN THIS VERITABLE "KITCHEN TREASURE" THAT A GOOD THING **HAS** TURNED UP.

Advantages.

Used with ordinary Saucepans.
The capacity of the Saucepan is not reduced.
Holes in the rim do **not** retard boiling.
Prevents boiling over and scalding.
Steam escape improves cooking.
Cooking made delightfully easy.
Straining with either hand.

UTILITY SELF-EVIDENT.

The Opinions of Experts—

Miss IDA CAMERON

(Principal) Earls Court School of Cookery, says :—

"It is **one of the best** I have ever used. It is a **capital strainer,** and quite prevents boiling over, because it allows the steam to escape at the proper moment.

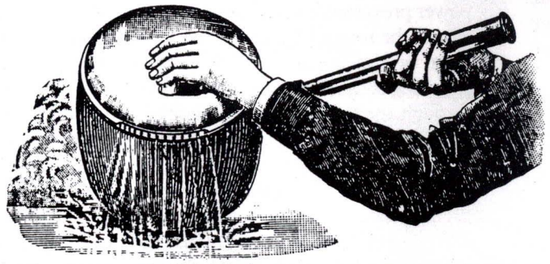
The **Holes are beneficial** as a means of **self-ventilation,** and there is no objection to them on any ground whatever."

Miss JANET S. MARSHALL

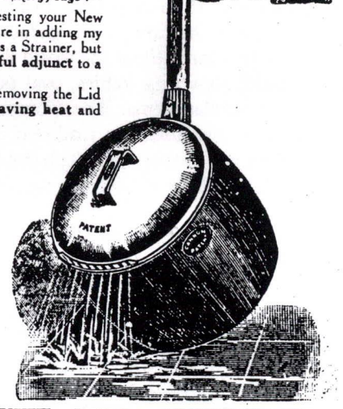
(Former Staff Teacher N.T. School of Cookery) says :—

"I have had an opportunity of testing your New **Strainer Cover,** and have much pleasure in adding my testimony as to its usefulness, not only as a Strainer, but to its **utility as a Sanitary and healthful adjunct** to a Saucepen.

It dispenses with the necessity of removing the Lid when cooking Green Vegetables, thus **saving heat** and therefore **economising fuel."**



This Cover Strains in any position with either hand.



A SAUCEPAN THAT THE INTELLIGENT HOUSEWIFE WILL APPRECIATE

SANITARY! APPROVED! POPULAR!

Ventilation is essential if perfect cooking is desired, and the "Perfect" Strainer and Self-Venting Steam Escape accomplish this.

This Cover was Awarded the Special Medal of the SANITARY INSTITUTE AT BIRMINGHAM, 1898.

:: N.B.—PLEASE ORDER SAUCEPANS OF "CANNON" BRAND WITH PATENT "PERFECT" STRAINER COVERS. ::

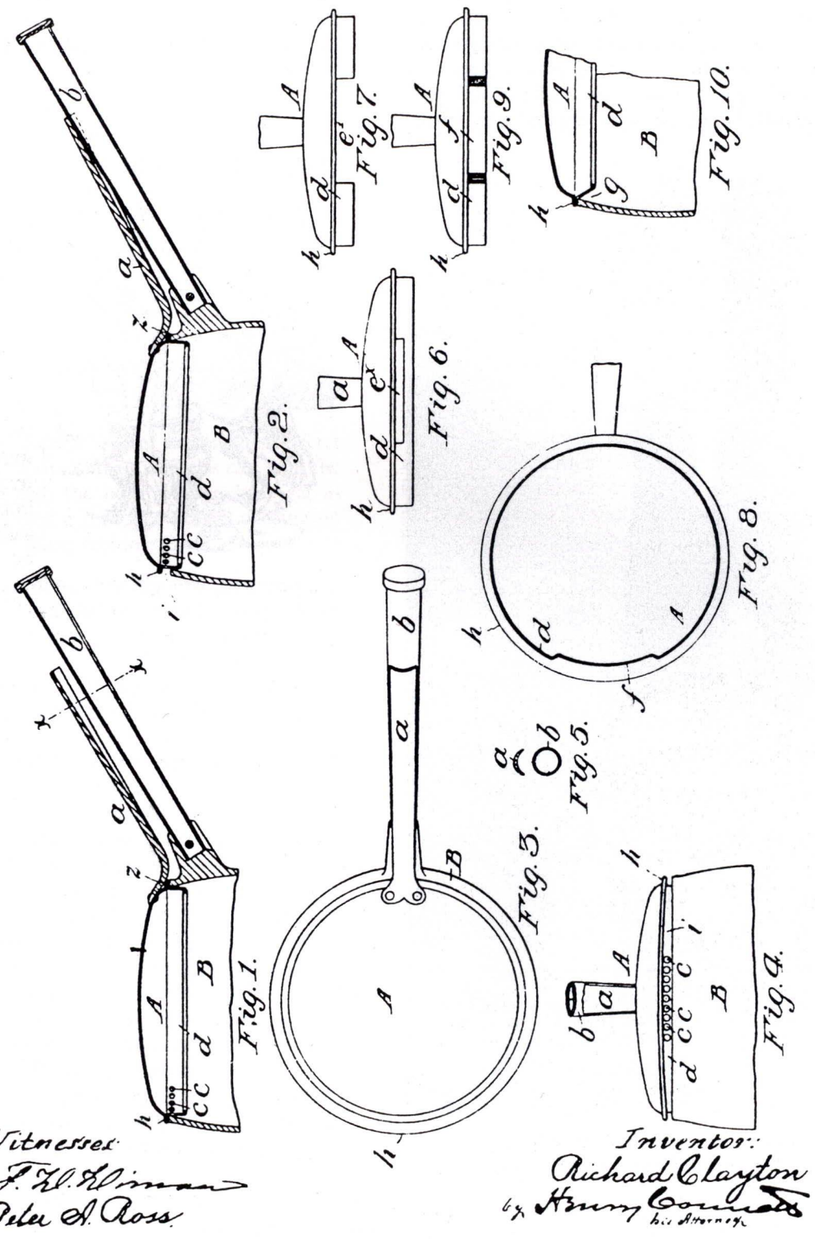
:: :: For List Prices, &c., see Tinned Section, page 2, and Enamelled Section, page 18 :: ::

(No Model.)

R. CLAYTON.

COVER FOR COOKING UTENSILS, &c.

No. 561,763. Patented June 9, 1896.



Witnesses:
F. H. Kinman
Peter A. Ross

Inventor:
Richard Clayton
by Henry Connett
his Attorney

The Cast iron holloware at this time was suffering from competition from enamelled steel and aluminium pans. It became a popular fallacy that cast iron cooking vessels were slow boilers. The Secretary of one of the largest Provincial Gas Companies after careful experiments reported that in connection with a series of tests each carried out under precisely the same conditions with pans of equal capacity, a Cannon cast iron broad bottomed saucepan boiled quicker than either enamelled steel or aluminium ones. Further independent tests to try to allay the fallacy were made by the Professor of Physics at Birmingham University who reported after testing cast iron saucepans against enamelled steel ones that in every case the cast iron boiled in less time under the same conditions.

Despite these attempts to instill support for their holloware business, the cast iron utensils business was a declining industry by the turn of the century due in part to the extended use of stamped holloware. Nevertheless, the Deepfields foundry were still casting their iron pots and pans a century after the business was founded by the Sheldons.

This cupola's loading platform affords little protection from the weather for the loaders. The 'team' of men in the foreground are probably responsible for transporting the molten iron to the casting shops.

Colonial Castings

A few years after the casting of pots and pans and certainly by 1841 the Sheldons had diversified substantially to become General Iron Founders. In 1841 Edward and Stephen Sheldon were manufacturing wrought and cast iron money chests and bookcases neatly fitted with drawers and partitions; wrought and cast iron doors and frames for fire proof closets and banking houses; ovens and grates; camp ovens; irons; rain water spouting and various other items.

The Deepfields foundry became particularly noted for their Cannon brand colonial castings, destined for the African and South American markets as well as the West Indies and the Far East. Most famous was the celebrated Kaffir pots with legs, or legless, to suit particular needs. These pots were usually wired together one on top of another 8 to 10 feet (2½ to 3m) high, loaded on to a narrow boat and were to be seen leaving the Works canal basin en-route for the Manchester Docks for delivery overseas.

Also produced were Danish, Marmont, French, African, St. Lucia and many other pots; together with Dutch and Havana Stoves, Camp ovens, bake pots, cooking and cassada plates, rice bowls, rice plates or comales, African rice pans and many other items.

The use of the various pots apart from cooking purposes included sugar pans, soap pots, palm oil boilers, lead boilers; having accessories such as doors and frames, gratings and fire bars, all manufactured by the company.

One of the largest pots produced by the foundry was a huge three legged pot of some 140 gallons capacity. This was mostly used for palm oil boiling in the West African Markets.

FOUR

GENERAL IRON FOUNDRY, SANITARY AND CHEMICAL WARES

Household and Builders' Ironmongery

Articles produced by the Company included various kinds of smoothing and polishing irons. Of particular note was a new pattern introduced at the turn of the century of a sad or smoothing iron branded 'Cannon 1900'. Its special feature was an improved type of wrought tubular handle which gave good strength and a firm grip.

The Company also produced an assortment of dumb bells for the athletic and keep fit enthusiast.

Also manufactured was an assortment of cast butt hinges (for doors), ranging in size from one inch to six inches in length. Cannon hinges enjoyed the reputation of being reliable in quality, of uniform thickness and a good finish.

Another item produced was the firm's patent Secret Axle Pulley. The body of the pulley was cast with the axle, passing through the hole in the wheel, set in position. This formed a complete pulley, needing no rivets or any other fixing requirement.

Sanitary Ware

The Cannon sanitary ware was known by the Company's registered trade mark 'Porceliron' which was specially applied to this ware, indicating that the articles were fine cast with a surface of true white porcelain.

Before the 'Porceliron' process was invented, most sanitary ware was produced by pottery firms.

At the turn of the century enamelled iron ware was beginning to overtake pottery-ware due to its high class surface finish and greater durability, being practically unbreakable. It was somewhat of an achievement by Cannon to overcome the preference for the long established glazed pottery ware. By 1926 'Porceliron' products were considered to be easier to install and more adaptable. Their reputation in the trade became second to none.

The Cannon Porceliron technique was applied to a wide selection of products which included baths, lavatory ranges, lavatories, plug bowls, urinals, showers and foot baths. New designs by Cannon were constantly being registered for most of its products.

One of the most noticeable baths that Cannon produced was the 'Ideal' pattern. This bath was parallel and equal in shape, mounted on massive ornamental feet of elegant design. The exterior was chastely decorated with an appropriate centre view, flanked with ornamental scrolls in gold, giving the bath as a whole a very superior and attractive appearance.

The Cannon 'Royal Sovereign' combination bath, embodied the latest improvements when displayed at the Wolverhampton Exhibition in 1902. The bath had an exposed removable waste, hot and cold supply valves and complete trapping arrangements above the floor line. It was furnished with large supply valves, enabling the bath to be quickly filled and waste arrangements which allowed for a rapid discharge. The 'New Era' bath also exhibited in the 1902 show illustrated another modern pattern of neat design. The soap tray, waste and supply fittings were arranged on the roll at the foot end, thus making a compact and convenient arrangement.

At the turn of the century a new lavatory range, the 'Eton' was designed having a scalloped front and moulded edge, furnished complete with nickel plated fittings. The wash basins were oval and roomy. Other patterns included a pattern of angle lavatory with high back moulded in one piece, also a high flat back washhand-bowl with capoten head supply valve. By 1913 Cannon had registered several new designs in Combination Lavatories, these had high roll rim backs fitted with bevelled plate glass mirrors and artistic tiles. Included as accessories were such items as a vase, sponge and toothbrush holders, comb racks and plate glass shelves.

In 1926 the Company's output of porceliron sanitary ware was still on the increase and it was in demand in ever increasing quantities for use in public buildings, schools, factories, hotels and private residences.

Chemical Department

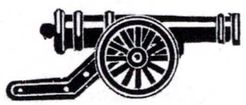
The growth of the chemical industry and the many discoveries and increasing activities of those engaged in it, found the Company in the early growth stages of this specialised business to examine the possibility of producing articles for use in this trade. Cannon naturally turned its attention to the production of cast iron chemical plant, which in later years was destined to become one of the most important branches of the Company's business and to achieve an enviable reputation throughout the chemical industry. So extensive was the Company's experience in the chemical field that by 1926 the Cannon plant was frequently designed and manufactured to meet special customer requirements.

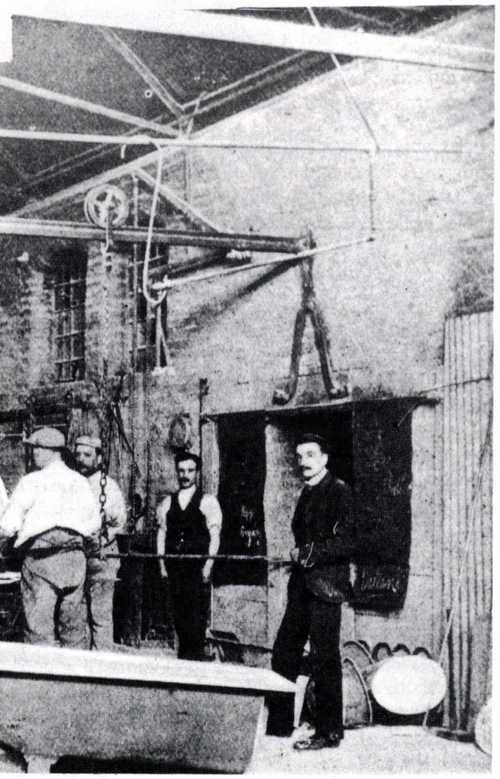
In many instances advice was solicited from the Company and willingly given as to the types of chemical plant most suitable for particular needs.

The bulk of the Cannon cast iron chemical plant was lined with a special acid resisting enamel, which had the characteristics of high tenacious adhesive and high vitrified qualities. Among the many articles manufactured by Cannon were autoclaves (strong sealed vessels used for chemical reactions at high pressure and apparatus for sterilizing objects), boilers, bowls, condensers, crystallisers, digesters, evaporating pans, mining, vacuum and steam jacketed pans, stills and tanks. Many of these were supplied over the years to British and French Government contracts.

The purposes of use of the articles produced for the chemical industry included – mixing, nitrating, evaporating, condensing, distilling, as well as the preparation of pharmaceutical products and aniline dies. Cannon also supplied articles for gold prospecting, we find that in 1926 'Cannon Cast Iron Quartz Crushing Mortars' with long handled pestles were still being exported to the goldfields of South Africa, Australia and other gold mining areas in the world.

Tremendous developments took place in the chemical industry during World War 1 (1914-18) and experience and knowledge gained by Cannon was successfully applied to subsequent plant produced. The Company saw its activities in the chemical plant industry still increasing to meet greater demand on the occasion of celebrating its centenary in 1926.



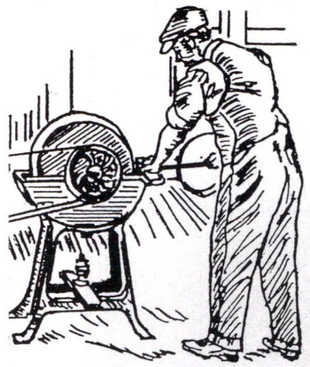


Enamelling Shop (Porceliron).

FIVE

THE GRINDSTONE AND GAS DEPARTMENTS

Grindstone Department



This 'new' venture by the Company was brought about by the purchase of the grindstone business of Richard Hickman of Wolverhampton and Bilston in 1895. At first this business was quite small but soon expanded rapidly so that by 1926 grindstones were being exported to many parts of the world. The stones, selected by Cannon were sawn up at the quarries and great care was exercised in choosing the various stones to suit specific applications.

In 1898 large orders for glass cutting stones were being supplied to Russia and Sweden, as well as continental and colonial markets. Some 50 tons weight of grindstones were being despatched every week from the Cannon Works at this time. Many of these were supplied to fill Government contracts for the War Office, The Admiralty and H.M. Prisons.

All types of grindstones were produced either mounted in wood or iron frames, ranging from a small domestic stone of six inches diameter for sharpening table cutlery and similar items up to stones of 48 inches diameter fitted with pulleys for use with power drive. These were complete with accessories such as Stauffer box lubricators, belt striking gear and improved adjustable tool rests. There were also intervening sizes mounted for hand or treadle drive for agricultural and general requirements, a particular feature being a patent tool holding appliance which was in considerable demand for Technical Schools and Manual Training Centres.

At the turn of the century some of the many grindstones being produced included the 'Little Wonder' which was specially suitable for hotels and householders and was noted for its fine cutting, cleanliness and durability. It was fitted with Cannon's adjustable bearings. The 'Excelsior', 'Standard' and 'Universal' grindstones were also of the very best make and finish, and were fitted with either plain or roller bearings.

The unmounted grindstones included the 'Adament', which was specially suited for tool grinding and engineering purposes, and the 'Orbem' used in the agricultural industry.

The glass cutting stones were supplied in several patterns, as follows – Craigleith, fineline, bevelling, blue mike, fluting and Craigleith lapidary stopper stones. The Cannon brand for these stones had a reputation for being of first class quality and reliability in use.

Rubstones were specially used on plantations abroad, being particularly exported to South America, 'skinners' stones were in demand in the leather trade.

Gas Meters

This department was instituted in 1905 by the acquisition of the commercial control of the old established business of William Smith of London (established in 1834) for the provinces and abroad. At first it was intended to manufacture the meters at the Deepfields Works but it was eventually decided to concentrate production at the Stannery Street Works, London. This branch of the Cannon business grew rapidly and large supplies were being shipped abroad, and thousands of meters were in use with the leading English Gas Companies.

The Cannon prepayment meter with patented 'Radius' price-changer attachment was particularly favoured and was solely adopted by one of the largest of the English Gas Companies who had placed many contracts for regular supplies with Cannon. Ordinary meters both wet and dry were also being produced in large quantities by the Company.

Gas Fires

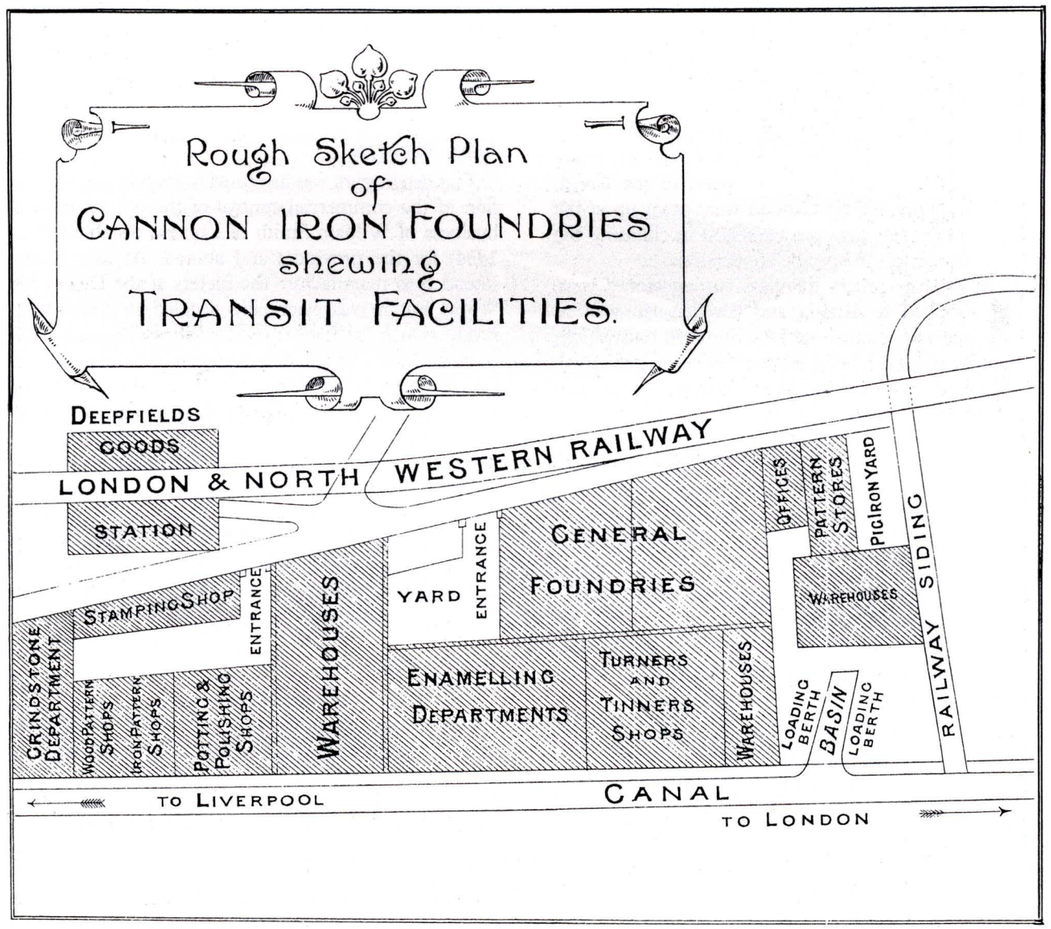
Shortly after the turn of the century, Cannon introduced an assortment of very varied gas fires which included many artistic designs calculated to meet all possible requirements. The rapid expanse of the Company's business in this direction was little short of phenomenal. The gas fires quickly achieved popularity, for their excellence was recognised in official tests, and among many other awards they were placed first for hygienic efficiency, and first for radiant efficiency in smoke abatement trials.

The Company introduced a distinctly new process for enamelling their fires known as 'Vitro Lustre' which

was registered as a trade mark to describe the patent process. It had remarkable durability and was unaffected by the heat.

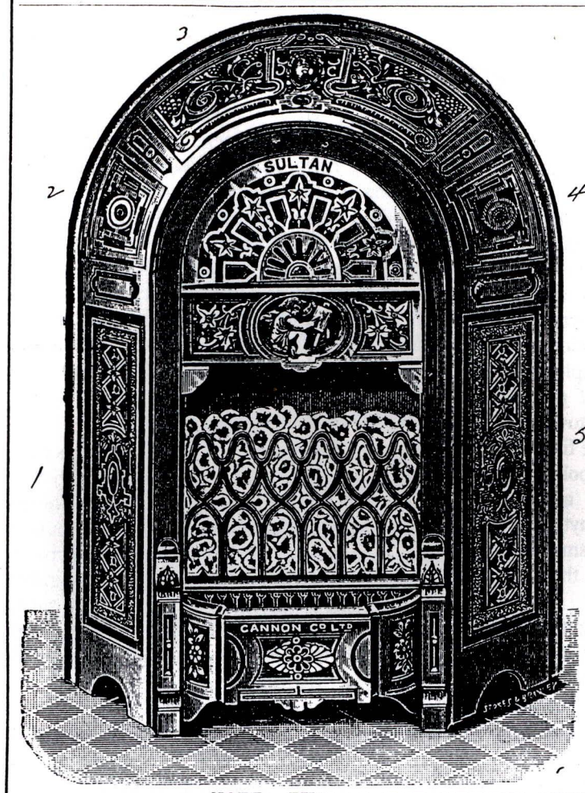
Cannon were consistently updating their fires to meet modern designs and construction, and requirements and regulations. They were fitted with every improvement, including regulators for adjusting the air and gas supplied to the burners.

They produced various gas heated radiators including the Cannon patent 'Radio' pattern which was cast in one piece. Cannon later introduced their new inclined gas fire which was entirely novel and had the quality of ensuring the dispersion of heat not only outwards but upwards. The latest models outstripped even the most optimistic hopes of the Company and demand for the fires was tremendous.



This map is very useful because it shows not only the 'Transit facilities' but the position of the many departments on the site. The date is unknown but because of the 'Grindstone Dept'. and the 'LNWR Railway' is somewhere between 1895 and 1923.

CANNON CO.'S GAS FIRES. ELEGANT IN DESIGN AND FINISH.



THE
"SULTAN."
(Registered)

The "Sultan" Fire is constructed on scientific principles, and embodies all the latest improvements possible to be contained in a Gas Fire. It is complete with internal chambers for utilising the waste heat after it leaves the fire. The following are some of its advantages:—

1.—Perfect Construction!
2.—Excellence of Design!
3.—First-class Finish!
4.—Fitted with our new Perfected Burner!

NOTE.—THIS IS THE NEWEST DESIGN IN THE MARKET.

No.	Sizes. Height.	Sizes. Width.	Width of Fire.	From hearth to centre of Flue	From back of builde to centre of Flue	Price, Ground and Best Finished	Price, Ground and Best Finished. Fitted with Tiled Sides.
2141	29"	20"	8"	19"	3½"	42/6	55/-
2142	30½"	22½"	10"	19"	4"	56/-	66/-
2143	31½"	25½"	13"	19"	4"	65/-	76/-

Any of these Stoves can be finished in Bronze or Brass.
Prices and particulars on application. All the above Stoves are guaranteed.

THE "CANNON" HOLLOW-WARE COMPANY, LIMITED,
CANNON FOUNDRY, DEEPFIELDS, near BILSTON.

SIX

THE CANNON GAS STOVE DEPARTMENT

Establishment and growth

Richard Clayton was instrumental in introducing Cannon to the world of gas heating and cooking. With considerable business acumen and foresight Clayton began preparations for the complete manufacture of gas and heating stoves and in 1895 the first Cannon gas cooker was produced and despatched. It is doubtful whether Richard Clayton himself fully realised the extent to which these small beginnings would eventually expand, but expand they most certainly did.

Starting in 1895 with a floor space of only 300 square yards, the Cannon gas stove department rapidly expanded so that by 1926 it covered no less than 12 acres!

By 1902, the gas stove department had grown in leaps and bounds. Cannon were by this time on the 'hire list', serving not only the leading provincial gas companies but also many London companies. These included the Gas Light & Coke Company, the South Metropolitan Company, The Brentford Company, the Crystal Palace Company and many others. The department was first located in the General Works, but it soon became clear that this accommodation was totally inadequate to meet its rapidly growing needs, so much so that an entirely new and extensive works began to be built on the opposite side of the railway to the original works site. The new works was laid out on modern lines with a large area allotted for the foundry operations, excellent store rooms, and fitting shops containing the most up to date machinery. Finishing and testing shops and extensive warehouses completed a most modern and splendid factory, coming into full use in 1906.

The output of the department over the initial years of production embraced not only a large selection of gas cooking stoves of every variety for home and export requirements of the ordinary domestic type but also included large gas cooking ranges, ovens, carving tables and hot closets for hotels, schools and institutions. In addition to this extensive range of equipment the department also produced an innumerable variety of breakfast grillers, boiling rings, laundry irons, washing boilers, tailors heaters, in a wide range of models.

In 1913 the Cannon Gas Stove Department began to turn its attention to the manufacture of hot water producing apparatus and began to embark on the production of bathroom geysers, water circulators and gas heated steam radiators. Cannon were so successful in the making of these goods that they soon became the leading manufacturers, renowned for the quality of these items.

Method of Manufacture

The majority of the patterns for the Cannon gas stoves were first designed in lead and covered a variety of beautiful models of elegant and unique design. The lead patterns then went from the pattern shop to the foundry. The stove parts were cast in iron in sections and passed through the dressing shops for fettling and grinding. The grinding shop was equipped with twelve steam-driven grindstones supplemented by a series of rapidly revolving leather polishing 'bobs'. The gas stove castings were then transported to the fitting shops which were equipped with steam-driven automatic machinery for boring, drilling, milling, planing, slotting and any other work that was needed. The shop included two sets of testing apparatus; one for testing the accuracy of the brass taps and valves; and the other for ascertaining the heating capacity of every stove or oven that left the works. Having been carefully assembled, the stoves were then taken apart and sent to the warehouse in sections to facilitate packing, all the parts being interchangeable. The warehouse held a vast collection of all kinds of gas heating and cooking apparatus, prominent amongst them was the 'Hercules' cooker.

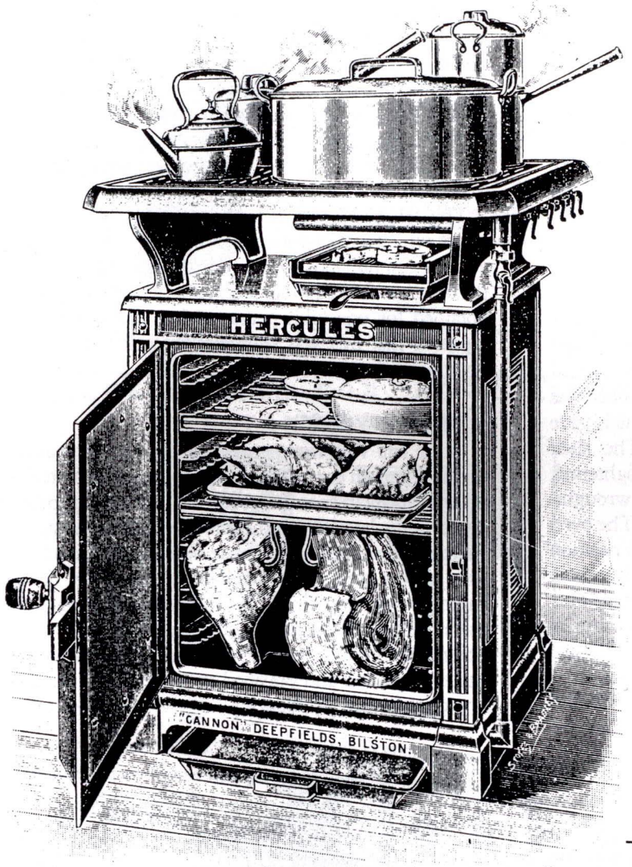
The Hercules

This cooker was one of the most popular and earliest (pre. 1900) of the Cannon products and met with exceptional success. Its distinct advantage was the 'Porceliron' lining which considerably increased the durability of the cooker and enhanced the utility of the stove. The 'Hercules' was a combination of best materials and thorough workmanship; it was perfectly clean; and could be taken apart very rapidly to maintain this condition. Besides being foremost amongst gas cookers for cleanliness it also led the field for convenience and

List No. 86. Page 37

CANNON CO.'S COOKERS. STRONGEST AND BEST.

A Card of Instructions sent with each Cooker.



The "HERCULES"

INDESTRUCTIBLE

Cast-Iron Enamelled

series of

GAS COOKERS.

ADVANTAGES.

1.—***Modern "up-to-date" improvements.***

2.—***Economy in Consumption of Gas.***

3.—***Freedom from Smell.***

4.—***Perfection in Cooking.***

5.—***All cast iron, Enamelled by our own special process, known as "Porceliron," which is true Porcelain on cast iron.***

6.—***Economical arrangement of hot-plate burners.***

7.—***All parts interchangeable.***

NOTE.—Our ***Enamel*** is guaranteed free from ***any poisonous*** ingredient.

Supplied complete with Griller Pan and Grid, Bottom Pan, two Grid Shelves, one Browning Shelf, and Meat Hook.

The Shelf Rests are Enamelled without extra charge.

The best Stove manufactured for hiring-out purposes. No extra charge for Enam^d Crown Plate.

No.	Inside dimensions of Oven. High.	Wide.	Deep.	Hot Plate.	Gas Supply	Height over all.	Burners on Hot Plate.	Average cost 3 meals per day. Gas 3/6 per thousand.	List Price with interior Enamelled complete, and Enamelled Crown Plate. £ s. d.	
2013	26-inch	~~10~~-inch	10-inch	21 × 17½-inch	3	36-inch	2	2d.	4 12 6	Each.
2014	26 ,,	~~12~~ ,,	12 ,,	23 × 19½ ,,	"	36 ,,	3	2d.	5 15 0	,,
2015	26 ,,	~~14~~ ,,	14 ,,	25 × 21½ ,,	"	36 ,,	4	2½d.	6 10 0	,,
2016	26 ,,	~~16~~ ,,	16 ,,	27 × 23½ ,,	"	36 ,,	5	3d.	7 13 6	,,
2017	26 ,,	~~18~~ ,,	18 ,,	29 × 25½ ,,	"	36 ,,	6	3½d.	9 4 0	,,
2018	26 ,,	~~20~~ ,,	20 ,,	31 × 27½ ,,	"	36 ,,	7	4¼d.	12 10 0	,,
2019	26 ,,	~~22~~ ,,	22 ,,	33 × 30½ ,,	"	36 ,,	8	6d.	13 5 0	,,

NOTE.—No Extra Charge for Enamelled Crown Plate.

THE "CANNON" HOLLOW-WARE COMPANY, LIMITED, CANNON FOUNDRY, DEEPFIELDS, near BILSTON.

2024. "Hercules" w/ 2-16" Ovens & Combined Hot Plate. £18- subj.

economy in gas. Its efficiency in roasting, baking and grilling had been testified by practically all the leading authorities of the day. It was demonstrated in 1898 that a 'Hercules' gas range could provide the cooking needs of a household for about half the cost of a coal range; and that about 3d. (just over one new penny) per day expended in gas would cover the whole cost of cooking for eight to ten persons. It had also been demonstrated that the depreciation or loss in weight of meat cooked in the gas range was much less than that cooked in a coal range. A comparison recorded in 1898 was that of two joints of meat, each of 10 lbs weight. The joint cooked in the 'Hercules' weighed about 7½lbs when thoroughly cooked whilst the joint cooked in a coal fired range weighed only 6lbs. It was concluded therefore that the 'Hercules' had a cooking economy advantage over the coal range of approx 25%.

The 'Chef' Cooker

A new series of gas cookers named the 'Chef' was introduced in the late 1890's by Cannon. This cooker still retained the distinct advantage of their special 'Porceliron' interiors but the outside of the cooker was constructed of dark-green enamelled iron which gave the stove a very handsome appearance. The shelf supports in the cooker had been considerably lightened, thereby reducing the weight almost to that of wrought-iron, but retaining the durability of cast-iron. The oven burners were loose fitting, being kept rigidly in position by means of a spring, Cannon patented this improvement. The Cannon loose burner had the advantage over ordinary loose burners in that when it was fitted into its correct position it was impossible to accidentally displace it. It therefore embodied the advantage of a fixed burner but had the facility of being readily taken out when required for cleaning purposes. The Cannon loose-burner was held in position by springs made of best hardened and tempered steel which were copper-plated to prevent rusting and located in such a position as not to be affected by the heat of the oven.

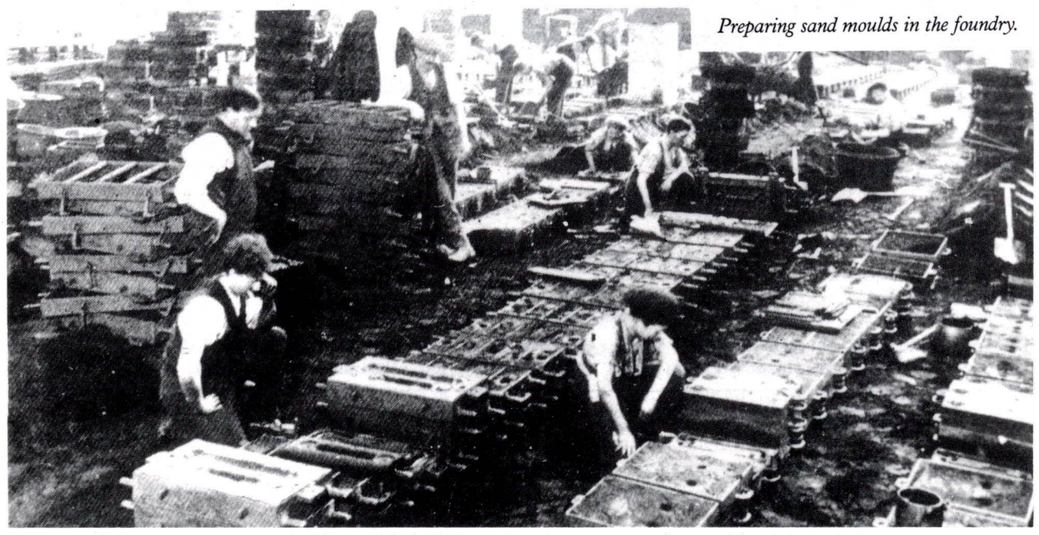
The 'Penny in the Slot' Cookers

Owing to the increasing demand for a cheaper class of stove having reliable qualities for use with 'penny in the slot' meters, Cannon were quick to meet the requirements of this type of situation by introducing a variety of models during the late Victorian period. These included models bearing the following names – Villa, Bromley, Renown, Suburban, Sparta, Bilston and Homely. The 'Suburban' and 'Sparta' gas cookers were supplied mainly to the London gas companies.

The 'Homely' was fitted with stationary deflector plates which avoided mechanical parts, they incorporated the Cannon loose burners on the hot plate as well as the oven itself. In 1898 some 25 cubic feet of gas could be obtained for one (old) penny and at that date it was reported that this was sufficient to cook a dinner for several persons

The Grosvenor

In the late Victorian period the 'Grosvenor' was the leading Cannon gas heating stove. It was constructed on scientific principles and embodied all the latest improvements of the late 1890's. It came complete with internal chambers for utilising the waste heat after it had left the fire. It was well constructed to an excellent design having a first class finish. Its tubular ventilating stove was suitable for halls, shops and offices. The 'Grosvenor' was made in two sizes with ornamental cast iron base and top, ground and polished to a fine finish. It was a first class heating appliance.



Preparing sand moulds in the foundry.

EXPORT, COLONIAL AND GENERAL CASTINGS.

CHARCOAL LAUNDRY BOX IRONS.

IMPROVED PATTERNS, WITH WROUGHT IRON HINGES.

PATENTED SPRING PIN PATTERN.

Automatic Self-closing Patent Spring Pin, and Wrought-iron Hinge.

Quality.

Bodies Bright Polished.
Tops Japanned and Gilt Bronzed.
Brass or Tin Guards, as required.
Grates inside.

To Open this Iron, hold it in either hand, and pull the knob at the back. The lid is then free to open. It will close and secure itself by pressing down.

SIZES.

Fig. 762. Bent Chimney.	5	5½	5¾	6	6½	6¾	inches.
,, 763. Straight Chimney.	6¾	7	7¼	8	8¼	9	,,

OUTSIDE LEVER.

Fig. 756. Straight Chimney.

Fig. 766. Bent Chimney.

SIZES.

4	4½	5	5½	5¾	5¾	6	6½	inches.
6¼	6¾	7	7¼	8	8¼	9	,,

ACCESSORIES FOR "PORCELIRON" SANITARY APPLIANCES

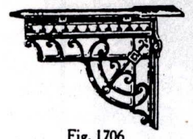


Fig. 1706
Without Building-in lug

Fig. 1709
With Building-in lug, (as illustrated).

Projection ... 13⅜ inches
Height ... 11½ ,,
Fig. 1706 4/6 per pair
,, 1709 4/10 ,,

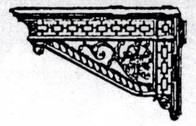


Fig. 1707

Projection ... 16 inches
Height ... 9½ ,,

6/- per pair.

CORK SQUEEZERS.

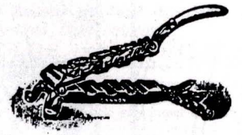


Fig. 2462

Lever	7¾	10½ inches.
For Corks	2	4
Japanned	1/-	1/4 each.

"FLORAL" SERIES.

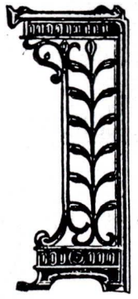


Fig. 2716
Right and Left Hand.
Top. Bottom.
Projection 12 × 12 in.

"FALCON" SERIES.

Fig. 2738.
Right and Left Hand
Top. Bottom.
Projection 12 × 12 in.

Prices Per Pair.

Fig. 2716					
Height—	24	26	28	30	33½ in.
	13/-	13/6	14/6	15/6	17/-
Fig. 2738 Height, 30in. 16/-					

SAD AND BOX IRON STANDS.

Fig. 1510
Vertical Rim.
Edge only Polished.

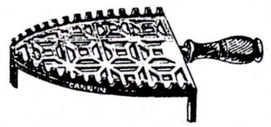
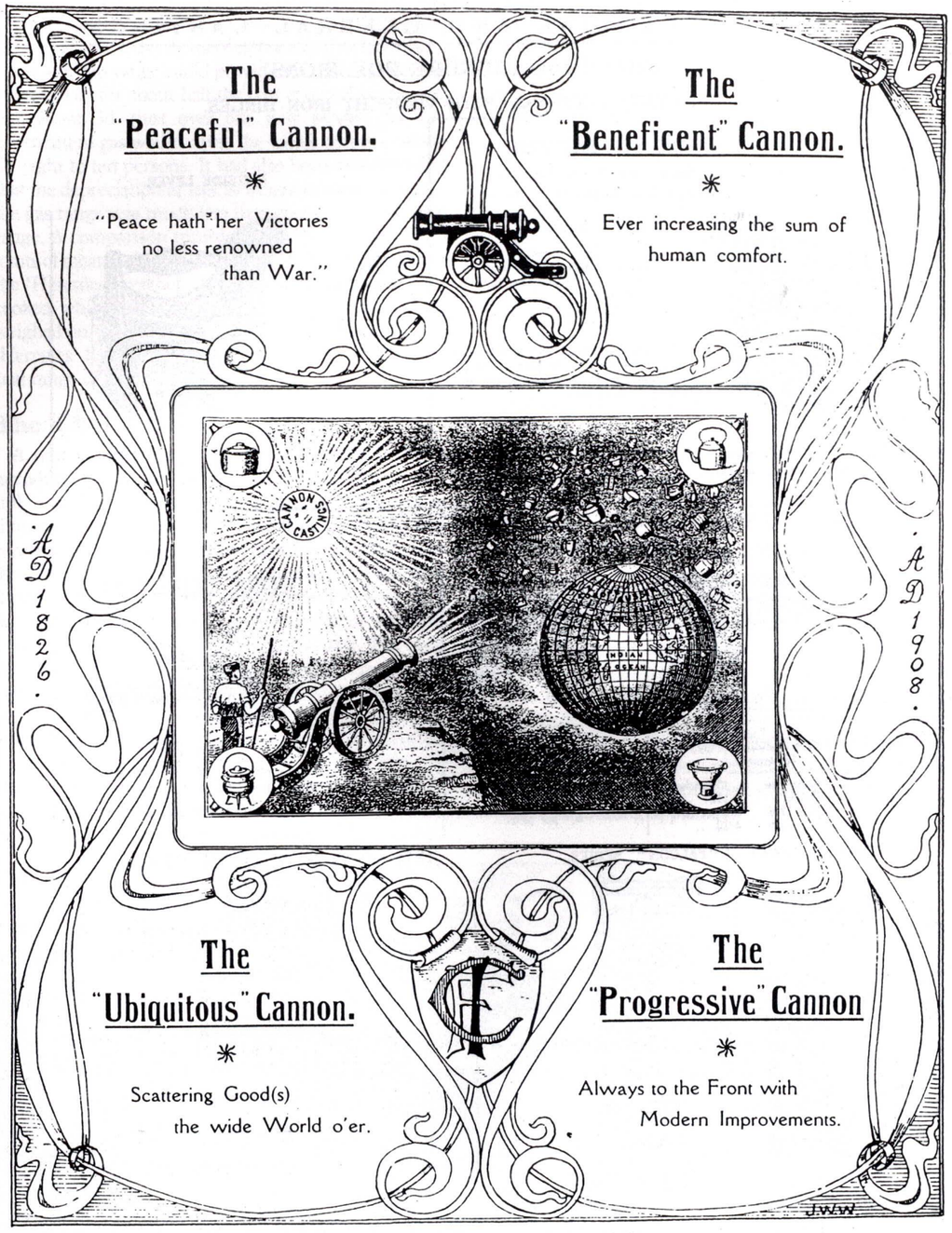


Fig. 1511
Without Vertical Rim.
Polished.

Fig. 1510 Iron Handle per doz.	Fig. 1510W Wood Handle per doz.	Size No	Inches.	Fig 1511 Iron Handle. per doz.	Fig. 1511W Wood Handle. per doz.
s. d.	s. d.			s. d.	s. d.
5 6	7 0	1	6½ × 4	4 0	5 6
6 3	7 9	2	7⅛ × 4½	4 6	6 0
7 0	8 6	3	8 × 5	5 0	6 6

Edge only Polished.
Size, 6½ × 4 in. Per doz.
Fig. 1513 Iron Handle 3/6

Edge only Polished.
Size, 5½ × 3½ in. Per doz.
Fig. 1514 Iron Handle 2/6



The Cannon is generally regarded as a destructive weapon. It is shown here in this advert distributing products from the Coseley Foundry all over the world for the benefit of man.

SEVEN

PATENTS, PRIZES AND REGISTRATION MARKS

Patents

The list of patents taken out by the Cannon Company is both varied, covering their wide range of products, and numerous, too numerous to list in full. Here however are just a few examples to supplement some of the patents already referred to in the foregoing text.

Patent No.	*Date taken out*	*Description*
2736	1882	Detachable legs for Kaffir Pots
11034	1884	Improvement in preparing holloware moulds
11035	1887	Improvement in filters
6811	1893	Improvement in fastening handles to holloware
24991	1893	Preparing castings for tinning
	1879	Design of Sad Iron
	1880	Ornamental cover for Kaffir pots
	1895	Long handle Strainer cover
	1895	Perfect Strainer Cover
561 763	1896	Cover for Cooking Utensils

Clayton's Patent 'Perfect' self ventilating strainer cover was a particular success, and became a feature of the Cannon brand of holloware. By the special method of construction, the straining slots were provided in the rim of the cover. Ventilation was ensured during cooking. It also had the facility for straining vegetables without having to remove, or tilt the lid as was the case of ordinary saucepans. The cover was awarded a special medal by the Sanitary Institute of Great Britain for its intrinsic value from an hygienic and safety point of view. The slots in the cover allowed steam to escape and hence avoid the dangers of boiling over.

These 'Perfect' self vent strainer covers were an improved variation over the Cannon patent 'Duplex' covers and patent 'Duplex Strainer' covers which had ventilating holes in the top of the lid.

Such was the success of the 'Perfect' self vent strainer covers that other companies in the holloware business tried to copy the cover and infringe the patent. The infringements were hastily pursued by the Cannon company to protect their rights. Two examples of the patent wrangles are evidenced by correspondence entered into by Mr. Clayton in the late 1890's (the company name infringing the Cannon Clayton Patent has been omitted for obvious reasons).

1898 from Cannon to Company "X"

"Sir,

We can only repeat our warning to you in our letters of the 21st and 28th June, whatever course you take is at your own peril.

We have been to great expense in taking patents out in various parts of the world. Before doing this we had the best opinions to their validity and we may mention that we have granted Royalties to important firms in our own trade.

We mention these facts because we should be sorry if you still contemplate infringing our patent. If you do we shall immediately instruct our legal advisers".

Oct. 1898 Cannon Company to Mr. "Y".

"My Dear _____,

So you have got intoxicated with the strainer cover craze. I think you will find that the game is not worth the candle.

I hope you are not doing my patent down in any way but it reads (unquote – the alleged patent strainer cover of Mr. Y) as though it is somewhat similar.

I enclose you a catalogue of my patent from which you will see what a terrible waste of money as been perpetuated".

TO IRONFOUNDERS, MERCHANTS, WORKMEN, & OTHERS.

£50 REWARD

INFRINGEMENT OF TRADE MARK "CANNON."

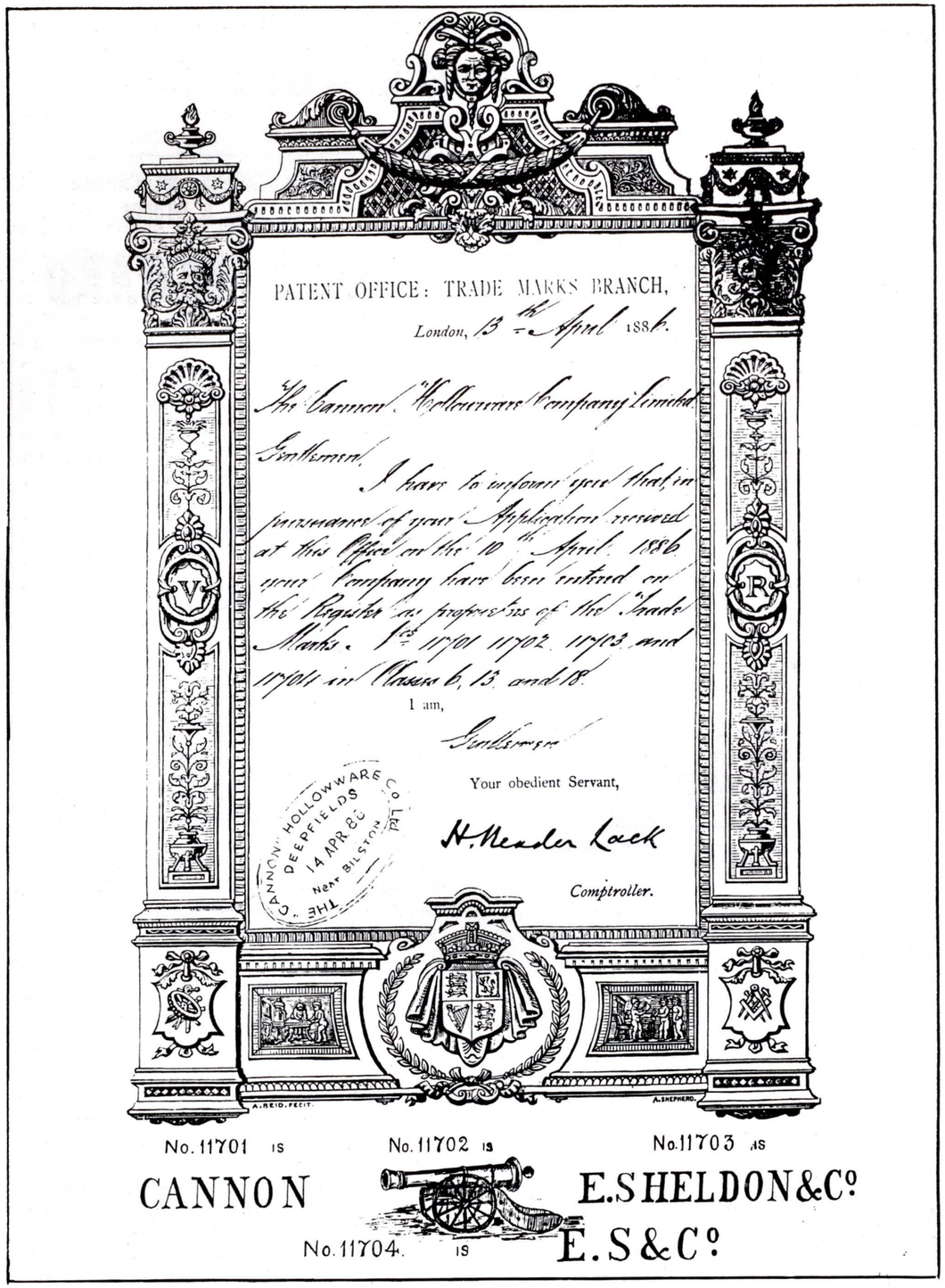
WHEREAS we have discovered that Goods NOT of our make, but bearing our principal Trade Mark "**CANNON**" (registered pursuant to Acts 38 and 39 Vic., c. 91, and 39 and 40 Vic., c. 33,) have been placed in the market with the intention that such inferior goods shall pass as "**CANNON**" Castings, or resemble our well-known "**CANNON**" Brand.

Any person giving us such information as WILL SUPPORT THE EVIDENCE in our possession shall be liberally rewarded, and on conviction of the offenders the above reward will be paid. The Goods in question are principally Sad Irons, Pots, &c., and our Trade Mark "**CANNON**," and in some instances a colourable imitation, viz.:—"**CANTON**," has been cast upon them. Information received in strict confidence (if desired)

EDWARD SHELDON & Co.,
Manufacturers of Enamelled and Tinned Hollow-wares, &c.,
CANNON IRON FOUNDRY,
DEEPFIELDS, NEAR BILSTON.

NOTICE IS HEREBY GIVEN that pursuant to the Act 25 and 26 Vic., c. 88, any person forging the said Trade Mark or falsely applying any mark with intent to defraud, is subject to prosecution for misdemeanour, and any person selling any such spurious or counterfeit goods will be proceeded against.

Any person selling such spurious goods is bound to give information where he procured the same, otherwise he is liable to penalties and forfeiture. Any person aiding, abetting, counselling or procuring another to commit any such offence, is guilty of a misdemeanour which is punishable by imprisonment.


PATENT OFFICE: TRADE MARKS BRANCH,

London, 13th April 1886.

The Cannon Hollowware Company Limited

Gentlemen,

I have to inform you that in pursuance of your Application received at this Office on the 10th April 1886 your Company have been entered on the Register as proprietors of the Trade Marks Nos. 11701 11702 11703 and 11704 in Classes 6, 13, and 18.

I am,

Gentlemen

Your obedient Servant,

H. Meade Lack

Comptroller.

THE "CANNON" HOLLOWWARE CO. LTD. DEEPFIELDS 14 APR 86 Near BILSTON

A. REID. FECIT.

A. SHEPHERD.

No. 11701 IS CANNON

No. 11702 IS

No. 11703 IS E.SHELDON&Co

No. 11704. IS E.S&Co

The Patent Office Certificate dated 1886 bearing the numbers allotted to four Cannon Trademarks. The original certificate measures approx. 8 × 13 inches (200 × 325mm).

Prizes

Like many other industrial concerns of the Victorian period, Cannon introduced and displayed their wares at various national and international Trade Exhibitions. The degree of excellence of their exhibits is attested by some of the awards picked up at these Exhibitions.

International

1879	Sydney	Two Prize Medals
1883-4	Calcutta	Two Prize Medals
1888	Melbourne	First Order of Merit and Medal
1891	Jamaica	Gold Medal and Certificate of Honour
1892	South Africa	Silver Medal
1913	Antwerp	Silver Medal, Exposition Internationale duGaz

National

1896	Wolverhampton	Gold Medal
1896	London	Silver Medal, Imperial Institute
1896	Newcastle-on-Tyne	Bronze Medal, Sanitary Institute
1896	Cardiff	Diploma, Fine Arts Industrial and Maritime Exhibits
1897	Leeds	Bronze Medal Sanitary Institute Exhibition
1897	Portsmouth	Gold Medal, Southern Counties Trades and Industrial Exhibition
1897	Sheffield	Gold Medal Yorkshire Trades and Industrial Exhibition
1897	Newcastle-on-Tyne	Diploma, Electrical and Engineering Exhibition
1898	Birmingham	Silver Medal 'Porceliron' Sanitary Ware, Sanitary Institute Exhibition
1898	Birmingham	Bronze Medal 'Perfect' Strainer Cover, Sanitary Institute Exhibition
1902	Wolverhampton	Diploma, Art and Industrial Exhibition
1902	Bideford	Gold Medal, Trades Exhibition
1902	Manchester	Silver Medal, Sanitary Institute Exhibition
1899-1903	Birmingham	Gold Medals, Industrial and Trades' Exhibitions
1905	London	Bronze Medal, Smoke Abatement Exhibition, Royal Sanitary Institute
1908	London	Silver Medal, Franco-British Exhibition

In addition to this splendid and impressive list of awards and medals, 'Cannon' had the distinction as a Company of holding one of the only two gold medals ever awarded at any exhibition for their cast iron, enamel, and tinned hollowares. Quite a remarkable achievement.

Registration Marks

The Cannon

The most significant of the many marks registered by the Company was the 'Cannon' itself, this became famous and recognised throughout the world. This was followed closely by the name 'Porceliron' denoting the company's famous coating process. Edward and Stephen Sheldon had designated their Deepfields Foundry the 'Cannon' Iron Foundry from the earliest days of the Company. The various products and the undertakings of the Sheldons eventually became synonymous with the word 'Cannon', and this became an overall symbol of their products. Due to the quality and reliability of the goods produced by the Company, the 'Cannon' marked wares acquired an enviable reputation for excellence in the market place. Cannon in essence became the Company's hallmark. The Company reaffirmed their hallmark by renewing registration in 1886 following the replacement of the Commissioners of Patents set up by the Patent Law Amendment Act of 1852, by the Patents, Designs and Trade Marks Act of 1883. The 1883 Act saw the introduction of a Comptroller General under The Board of Trade and was the start of the British patent system as we know it today.

The Company applied for registration of its various names and marks on the 10th April 1886 and received confirmation as proprietors of Trade Marks Nos. 11701, 11702, 11703 and 11704 from the Patent Office Trade Marks branch on the 13th April 1886. These numbers covered respectively, the Cannon name, the Cannon symbol, E. Sheldon & Co., and E.S. & Co.

Such was the excellence of the Cannon products that imitations came onto the market of 'questionable quality'. These inferior goods bore the mark of Cannon or similar marks such as Canton and as such infringed upon the Company's Cannon trade mark.

Edward Sheldon & Co. offered rewards for information leading to the conviction of offenders.

Porceliron

The Porceliron trade mark was registered on the 7th July 1899 and became a speciality of the Company when applied to its products, in particular the articles produced in the Sanitary Ware and Gas Stove departments. The Company's Porceliron process made its wares universally popular creating a dedicated following. The actual details of the enamelling process and the formula was kept a closely guarded trade secret by Cannon.

The Company's archives include documents and correspondence dealing with enamelling recipes dating from 1844. The earliest reference gives details of a mixture of flint and borax for what was known as a regular glaze intended for pots, saucepans and other culinary wares. A scientific paper dated August 1883 gave details of a 'metal covering glass' using a mixture of flint glass, boracic acid and carbonate of soda. The Colour Works at Hanley produced a 'modern recipe for enamel and underglaze' by a Mr. W. R. Creyke in 1883 followed by another one in 1887. These recipes were supplied to Edward Sheldon & Co., by Mr. Creyke and from these and numerous other recipes, the Cannon Company experimented and successfully produced 'Porceliron', an invention that was to prove to be a winner in its field. 'Porceliron' consisted of cast iron

coated with true white porcelain. Its special features were its strength and durability. It would not chip or wear away, it was unaffected by the action of soaps, climatic changes and heat. Due to the absence of pin holes the articles so coated were quite rust proof.

The man in charge of the 'Porceliron Enamel' process at Cannon was Mr. Bert Stewart of Roseville House, Ivyhouse Lane, Coseley. The details of the formula and the process were kept such a close secret that it is said that no one was allowed into Bert Stewart's shop except "Old Man Clayton".

EIGHT

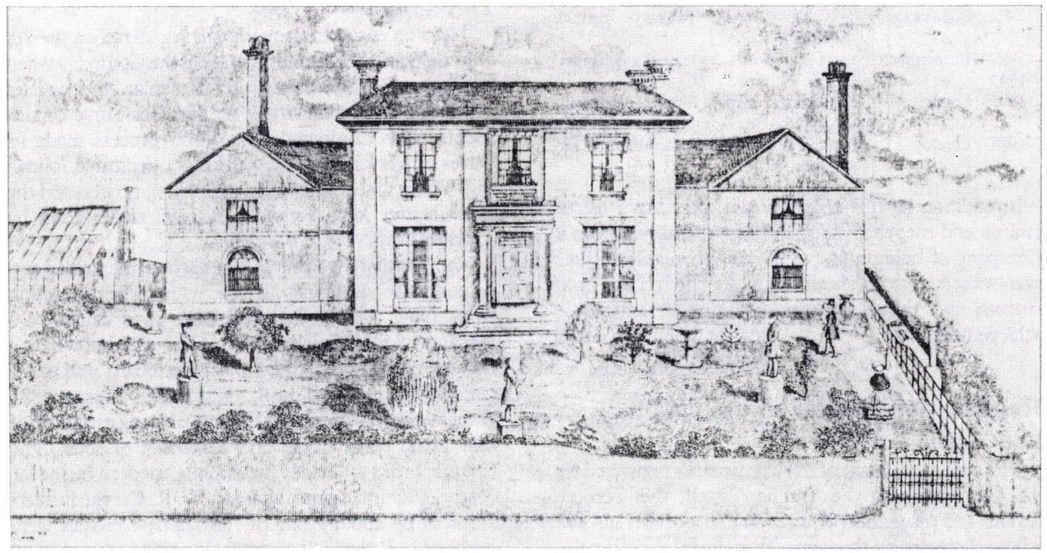
THE CENTENARY CELEBRATIONS

Excursion to Blackpool

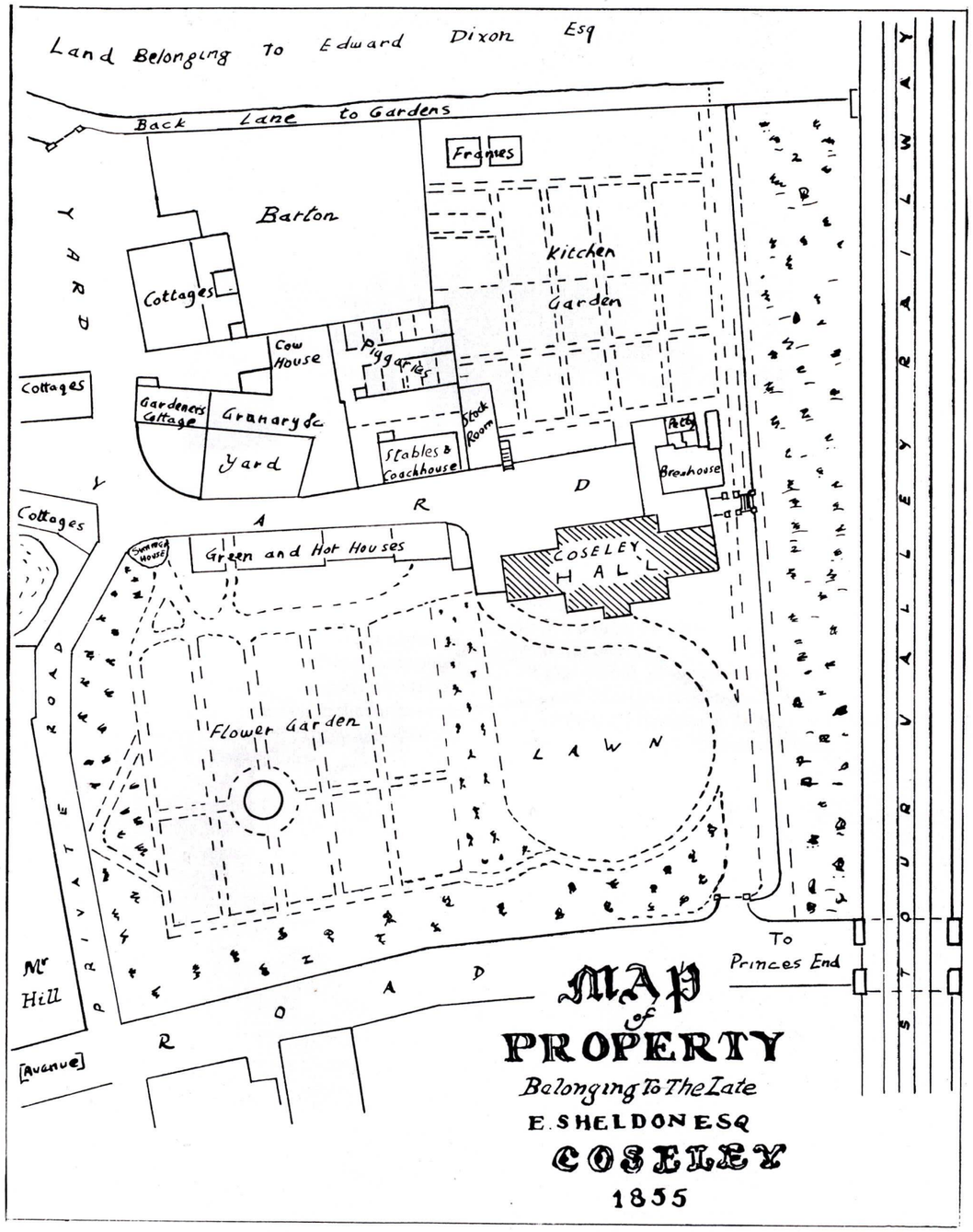
In 1926 Cannon Iron Foundries Ltd. celebrated their centenary, and by way of marking this milestone in the firm's distinguished history and development, the Company entertained its workforce to a visit and a meal in Blackpool on Saturday 19th September.

Two special trains composed of dining cars conveyed the party of some 850 to this popular Lancashire coast resort. Breakfast was served on the outward journey and supper on the journey home, this alone must have been an unforgetable experience. The Company had secured arrangements for free admission to the Winter Gardens, Big Wheel, the famous Tower, the Baths, each of the resort's three piers, and several of the popular entertainments on the Pleasure Beach. These were enjoyed to the full, especially by the people who had never before visited Blackpool. There were probably many of the Black Country party who had never before even seen the sea.

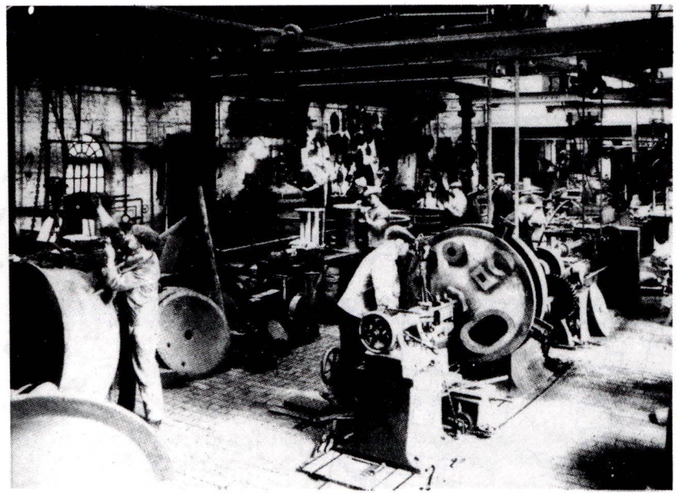
Cannon had previously celebrated their 80th anniversary in September 1906 by entertaining the 800 plus workforce to a celebration dinner party in one of the main halls of the new building which had just been built to house the gas-stove department at Deepfields. The dinner in 1906 was served by Messrs. H. C. Reynolds, a Wolverhampton caterer. On that occasion each of the men were presented with a briar pipe and a packet of tobacco, the youths with cigarettes and the work girls with boxes of chololates.



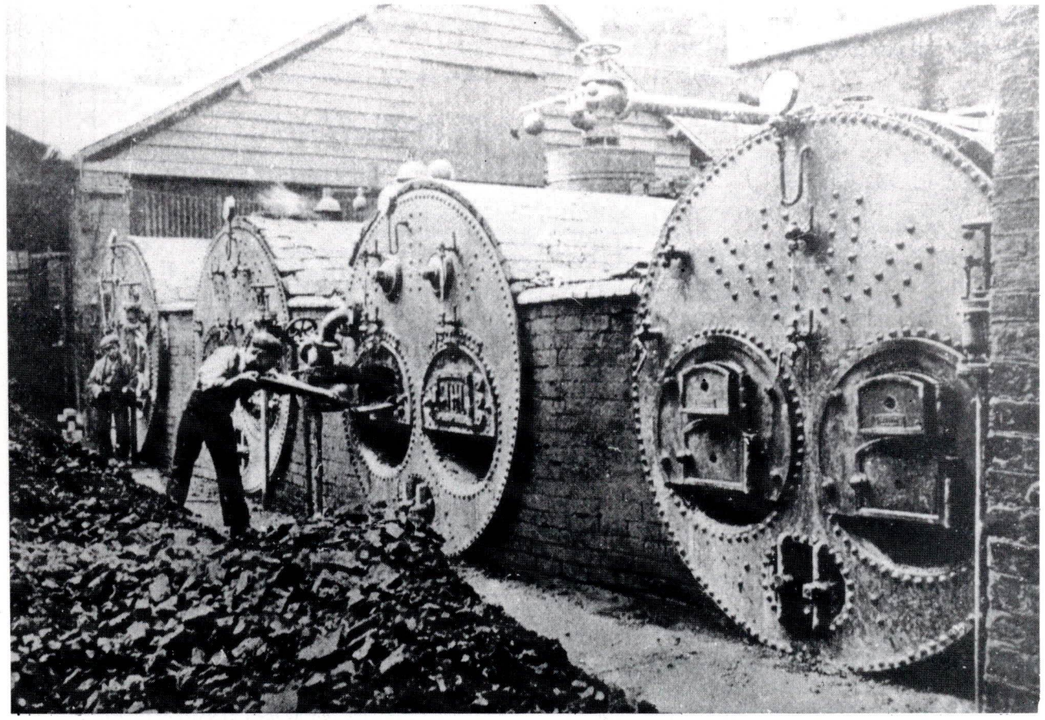
An early sketch of Coseley Hall, the home of Edward Sheldon the founder of 'Cannon Iron Foundry'. Beneath the original is handwritten "Coseley Hall about 1846". This date appears to be a little early as on the extreme right of the picture can be seen an early train using the Stour Valley Railway line which was not opened to traffic until July 1852. Edward Sheldon complained about the smoke and steam that drifted over his house and grounds from engines using this line. Coseley Hall also provided a home for later Directors of 'Cannon'.



Land was purchased at Fullwoods End by the Sheldons in 1834, this could have been used for the building of Coseley Hall and the many outbuildings and gardens shown on the above plan. It appears that Edward Sheldon was able to provide a great deal of home grown and reared food for his family. The Hall still stands today with modifications carried out during the 150 years of its existence.



Fitting Shop – Chemical Plant.



Outdoor boiler installation. Ideal in the summer but . . .

For their 100th Anniversary the Company dinner was served in the elaborate and beautiful Indian Lounge at the Blackpool Winter Gardens. Throughout the dinner an orchestra played on the balcony. Mr. William Henry Hawthorne presided in the absence of the Chairman of the Board, Edward Sheldon Barnett, who had been forbidden to make the journey on doctors orders. With Mr. W. H. Hawthorne on the top table were fellow Directors Messrs. R. Talbot Clayton, R. Douglas Clayton, Francis E. S. Clayton, W. E. Hawthorne, and H. S. Hawthorne. Also, the Company Secretary John Mason and various nationwide Company representatives including the Chief Representative, Alfred Austin.

The seating arrangements for the dinner were such that the men of the workforce had blue menus and the ladies, red. The Directors menus were grey, while the members of the press had orange menus.

Everyone was seated by 1.28pm, the dinner commencing at 1.30 prompt.

Royal Telegrams

Prior to saying of grace for dinner a telegram was sent by the Company, signed by R. Talbot Clayton, the Managing Director and W. Bradley, an employee of 56 years service to the King at Balmoral.

The message went as follows:

"The Directors and over 800 staff and employees of the Cannon Iron Foundries Ltd. of Bilston assembled here in Blackpool to celebrate the Company's centenary and knowing your Majesty's interest in the furtherance of British trade, desire humbly to express their keenest loyalty and to wish Your Majesty long life and happiness".

Later in the day there came the following reply:

"The King heartily thanks the Directors, staff and employees of the Cannon Iron Foundries Ltd. assembled today to celebrate the centenary of the Company for their loyal message and His Majesty wishes continued prosperity to the firm. Signed, Private Secretary".

A message was also sent to the Prince of Wales, which evoked the following reply:

"The Prince of Wales thanks Directors and staff at Cannon Iron Foundries for their kind telegram of good wishes which His Royal Highness heartily reciprocates. Signed General Trotter".

Long Service Awards

Following a welcome from the Chairman to the guests, Company Secretary John Mason responded by explaining that the employees wanted to show their appreciation of the kindness and hospitality displayed by the Directors in some practical form. It was proposed to benefit the Wolverhampton and Staffordshire Hospital by providing a cot, to be known as the "Cannon Centenary Cot". The cost of the cot was £500 and this was met equally by the employees and the Directors.

A pleasant surprise to the many employees present at the dinner followed when the twelve members of the staff with service of 40 years and over received a gold watch each. These twelve members between them had registered 507 years service and their names were as follows:

Edward B. Crump	51	years	service
John Mason	44	„	„
William Hawkins	44	„	„
George D. Lloyd	42	„	„
Walter R. Hawkins	42	„	„
William Caddick	42	„	„
James W. Wright	40	„	„
John Hinckes	40	„	„
James A. Hancock	40	„	„
Ernest Flavell	40	„	„
Isaac Grainger	40	„	„
John Cheshire	40	„	„

In addition, thirty five employees with service of over 40 years received wallets containing treasury notes, those having over 50 years service contained £10 and those having between 40-50 years service contained £5. Between them the men had a total of 1588 years service with Cannon.

(The record of service in the Centenary year of Cannon belonged to Benjamin Worton who had been employed for a remarkable 71 years by the Company and who was then a very honoured pensioner).

The long service employees who received these awards were:

William Bradley	56	years	service
James Cope	55	„	„
William Caddick	54	„	„
Samuel Turley	54	„	„
Thomas Aston	52	„	„
Joseph Richards	50	„	„
Edward Bradley	50	„	„
Thomas Richards	48	„	„
William Taylor	48	„	„
Samuel Thompson	47	„	„
William Barratt	46	„	„
John Hand	46	„	„
Thomas Southall	46	„	„
Thomas Taylor	45	„	„
Charles Fletcher	45	„	„
Harry Russell	45	„	„
Charles Turner	44	„	„
Alfred Bywater	44	„	„
John Davies	44	„	„
Arthur Creswell	43	„	„
William Martin	43	„	„
Joseph Nock	43	„	„
David Lane	43	„	„

Tom Penn (senior)	43	„	„
Jonah Smallman	43	„	„
Albert Law	43	„	„
William Cooper (senior)	42	„	„
William Howell	42	„	„
Thomas Weaver	42	„	„
Thomas King	41	„	„
William Nock	41	„	„
James A. Steward	40	„	„
Benjamin Creswell	40	„	„
James Challenger	40	„	„
Harry Hand	40	„	„

The Directors of the Company acknowledged and honoured these men "with the greatest pride".

As the employees left the hall each man was presented with cigarettes and each lady a box of chocolates. All were presented also with a medal bearing the company's "Cannon" trade mark, and an inscription in commemoration of the centenary.

A 'crowd' scene outside the works in Havacre Lane. Date and occasion unknown.

The Directors of the Cannon Iron Foundries Lim., and the Sons who follow in their Footsteps

NINE

THE CANNON WORKS FIRE BRIGADE

In common with many firms of a reasonable size, Cannon had its own Fire Brigade. This was formed in 1894 'for the protection of the Works'. Although the official local Fire Brigade would hurry to the scene of a fire as quickly as possible, we must remember that up to the end of the nineteenth century and sometimes into the twentieth this would consist of a horse-drawn, steam operated appliance. It will readily be appreciated that if a fire can be quickly 'nipped in the bud' at an early stage by trained persons already on the scene this obviously prevents the fire spreading and becoming a costly, major disaster. By comparison, the modern powerful fire appliances can today be on the scene within minutes. However, an efficient quickly assembled works fire brigade can contain a fire on their own site, preventing it from escalating until the main brigade arrives. The Works Fire Brigade then is still an important and necessary organization

The Cannon Works Fire Brigade consisted of a Captain, a Lieutenant, an Inspector, a Foreman, an Engineer and ten Firemen. An undated booklet giving details of the members of the Brigade and the rules laid down to guide them in their task was photocopied by members of the I.A. Group while carrying out research into the Cannon history.

The Officers in charge at this time are listed as follows:

Captain	— R. D. B. Clayton
Lieutenant	— E. Hawthorne
Secretary	— E. B. Crump 45 Tunnel Street, Coseley
Inspector	— F. Davis 17A Bissell Street, Wallbrook, Coseley
Foreman	— A. Turley 58 Tunnel Street, Coseley
Engineer	— D. Peplow 78 Broad Street, Wallbrook, Coseley

The ten firemen are also listed as follows:

J. Pickerill	44 Hampton Street, Roseville, Coseley
B. Bowater	18 Old Meeting Road, Coseley
J. Clark	29 Chapel Street, Wallbrook, Coseley
J. Hall	28 Bank Street, Coseley
M. Wilson	58 Ward Street, Coseley
W. Howell	13 Havacre Lane, Deepfields
J. Smith	3 Rookery Lane, Lanesfield
W. Bradley	22 Bank Street, Roseville, Coseley
J. Jones	60 Tunnel Street, Roseville, Coseley
E. Smallman	56 Hollywell Street, Hurst Hill

We have reproduced the complete list because it is interesting to note the addresses of the members of the works fire brigade. If one refers to the local street guide we find that the majority of the members live in streets surrounding the works in Havacre Lane making it very convenient for them to attend a fire if one arose.

Under the heading of 'Interesting Items' to be found on Page 9 of the booklet the following historical notes are very useful. The first Captain of the Brigade was Mr. W. H. Hawthorne (a Director of the Company) and when the brigade was reorganised in 1906 Mr. F. E. S. Clayton became its Captain. Owing to the increase in business, Mr. Clayton became more and more involved in 'travelling' and 'looking after' the London Office for the Company and so he found it necessary to retire from the brigade, his place being taken by Mr. R. D. B. Clayton. As his name appears as Captain at the head of the list of Officers in the booklet copied by the I.A. Group's researchers this puts the date of the publication as sometime after the reorganisation in 1906.

With regard to equipment the Cannon Fire Brigade booklet tells us that as well as being the proud owners of a Manual Fire Engine supplied by Merryweathers of London and 'New Era' fire extinguishers and fire buckets in various parts of the works it also had a central stationary steam pump. This was complete "with hose pipe to reach to all parts of the works including the NEW (Gas Stove) side".

The following are a few other interesting facts contained in the booklet.

Rule 17 states that "In case of fire, the first members arriving to proceed immediately to the boiler, raise the dampers, and start the fires". The Engineer is stated as being responsible for the working parts of boiler and pump, and must see that all is satisfactory and well oiled, before starting.

Item Number 4 on page 10 states that "members of the Brigade will take off their checks in Time Office when entering the Works, and hang them on Check Board in the Fire Station". This was a simple but very effective method of knowing which members of the Works Fire Brigade had reported for work that day. It might be worthwhile making clear at this point that these men were not solely employed as firemen for the firm but had jobs in the works to attend to until summoned.

Page 11 of the book of rules gives instructions to the watchman for calling out the Works Brigade. Two of them are as follows: No. 1 – The Bull or Steam Whistle *must* be blown *three times,* the third time to continue until all the members of the Brigade have arrived.

No. 2 – At holiday times, when there is no steam to blow the Bull, the Bell on the Warehouse must be rung, and kept ringing until all the members of the Brigade are present.

At the time of our survey the Belfry could still be seen on top of the Large Warehouse.

Page 12 gives the signals (by means of "Blows on Trumpet") to be used when fighting a fire:

1. One blow — Extra length of Hose Pipe required.
2. Two blows — Engineer to turn on Steam Valve and start Pump.
3. Three blows — Stop Pump.
4. Four blows — Wrap up Hose Pipe.

Drills were required to be carried out three times per quarter on dates to be fixed by the Captain.

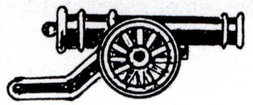
Anyone missing a fire or was absent from three consecutive drills of the Brigade without giving the Captain a satisfactory reason for his absence was dismissed from the Brigade. Any member wishing to leave the Brigade was required to give fourteen days notice to the Captain.

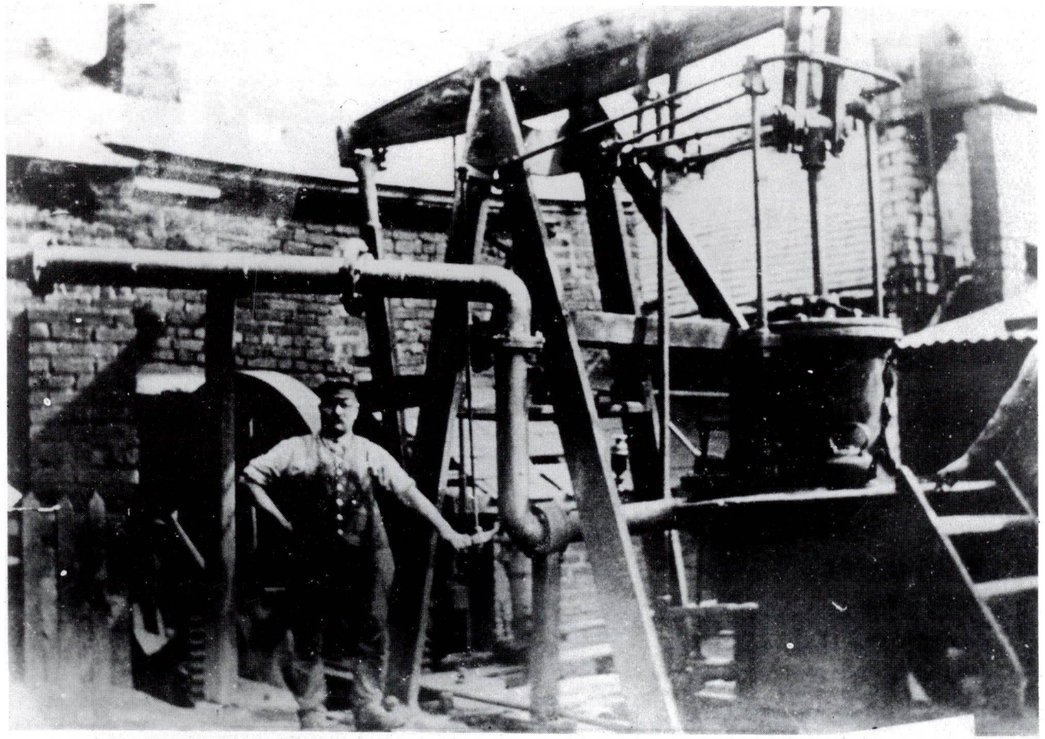
Rule 10 on Page 7 states that:

"Any member guilty of practical joking, or unseemly conduct or language, whilst at Drills or Fires, will be dismissed".

Rule 11 tells them that "Smoking is strictly prohibited while on duty".

While on a lighter note – Rule 18 on Page 8 informs us that – "The officers of the Brigade to fix both time and place for the Annual Outing, and any Member absenting himself from the latter, will forfeit his share of the Outing money, which will be divided amongst the other members.





An early 'A' frame beam engine sited outdoors. Used for driving machinery; note the flywheel and gear-wheels behind the 'driver'.

The present Cannon Factory at Coseley covering 21 acres. Six million pounds has been spent over the past few years on a redevelopment plan to modernize the factory.

Two modern examples of Cannon products.
On the left the famous K15 Gasmiser Fire production of which began in 1954. In 1958 changes were made with regard to its colours and ignition becoming K15/2. In 1962 the width of the Gasmiser was increased from 18 to 20 inches and given the model number K16. In this form it is still in production today (1986). On the right is an example of the modern Cannon gas cooker; a far cry from the early cookers illustrated in this book.

This old advert in glorious colour was found on the top floor of the large warehouse during the 1979 survey. The I.A. Group members are from left to right – Ron Moss, Dave Whyley, Keith Hodgkins, Andy Rutter and Pete Glews.

"CANNON"

Export, Colonial and General Castings.

"CANNON" BRAND is the HALL-MARK of RELIABILITY.

NEGRO OR KAFFIR POTS.

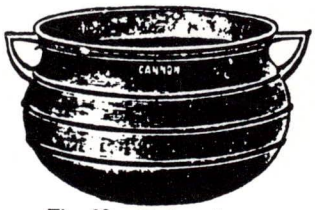


Fig. 38. Without Legs.

Fig. 38X. Extra Short Legs.

NEGRO OR KAFFIR POTS, WITH LOOSE LONG SCREW LEGS.

Fig. 2571.

Pot shewing legs screwed in ready for use.

CLAYTON'S PATENT.

SPECIALLY DESIGNED FOR EXPORTATION.

IMPORTANT ADVANTAGES claimed for this patent :—

1. **Simplicity of Fixing.** The method of securing the legs has been worked out technically to the utmost point of simplicity, so that they are readily screwed in by hand. If, however, an extra twist by a spanner is applied the legs become practically irremovably fixed. (Spanners supplied free for fixing legs at destination).
2. **Saving of Freight space.**
3. **Prevention of Breakage.**
4. **Pots and Legs delivered sound into store.**
5. **Economy in storing and warehousing.**
6. **Extra length of legs where desirable.**
7. **Pots serviceable without the legs.**
8. **Facility in handling stock.**

Notes.

The Pots can be used without the legs if desired.
Supplied in any of the sizes scheduled above as required.
These Patent Screw Legs can also be supplied to Soap Pots, Bake Pots and similar castings.

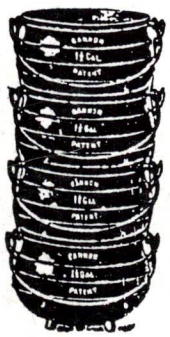


Fig. 2573.

Bundled nest of pots, shewing the economy in space, and risk of breakage reduced to a minimum.

Legs for bundled pots packed inside the top but one pot of the respective bundles.
Legs for larger size pots that go loose, packed separately.