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MADRAS RECORD OFFICE.

Government of Madras.

Finance DEPARTMENT.

G.O. No.	632-633	Press
	93-95	~~Mis.~~
Dated	28-8-	1862.

93-95

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Not to be folded or roughly handled

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*Proceedings of the Madras Government, Financial Department,
28th August 1862.*

No. 93. Read the following letter from Lieutenant Colonel C. A. ORR, Mint Master; to T. PYCROFT, Esq., Chief Secretary to Government, Fort Saint George, dated 26th August 1862, No. 114.

Paragraph 1. With reference to the Proceedings of Government of the 30th July 1862, No. 565, furnishing me with a copy of a Despatch from the Right Honorable the Secretary of State for India, under date the 25th June 1862, No. 36, and desiring me to afford the information required in the third paragraph regarding the flat blister steel and round cast steel indented for by me in February last, I have the honor to inform you that the 3 inch flat blister steel is required principally for the manufacture of the collars within which the coinage blanks receive their impressions between the dies, and that it should be of the thickness noted in the margin. The 1½ inch round cast steel is required for dies, and I trust that it may be supplied of the very best quality, such as is manufactured expressly for Dies by Messrs. Hawksworth and Co., of Linlithgow, and is used, I believe, in the Royal and Birmingham Mints under the name of Hawksworth's round steel.

½ ton of ½ inch.	
½ do. of ¾ do.	
1 do. of 1 do.	

2. With regard to the suitability or otherwise of tubes made of sheet iron instead of copper for annealing purposes, I beg, with all deference, to state that my experience of their use during many months past will not allow me to acquiesce in the opinion which has been expressed of their unfitness by the Master of the Royal Mint, for it has been found that whereas an iron tube on the average anneals 2,309 lbs. weight of blanks, one of copper was worn out after annealing 1,158 lbs. Both metals are liable to rapid destruction by the high temperature of the annealing furnaces, but contrary, I must say, to my expectations, iron is found to stand it better than copper, while it is many times cheaper notwithstanding that a large portion of the cost of the burnt out copper tubes is recovered by the sale of the remaining metal. I give the preference therefore to sheet iron over sheet copper as the material of which to form annealing tubes, and I recommend its use failing the successful application of the cast iron pots lined with copper which are being sent out.

No. 94. ORDER THEREON, 28th August 1862, No. 632.

Ordered that a copy of the foregoing letter be transmitted to the Right Honorable the Secretary of State for India, in reference to his Despatch, dated the 25th June last, No. 36.

(Signed) T. PYCROFT,
Chief Secretary.

No. 95. To the Under Secretary of State for India, dated Fort Saint George, 28th August 1862, No. 633.

With reference to the Despatch from the Right Honorable the Secretary of State for India in this Department, dated the 25th June last, No. 36, I am directed by the Governor in Council to transmit to you a copy of a letter* from the Mint Master, furnishing the information required in paragraph 3 of that Despatch regarding the flat blister steel and round cast steel indented for in February last; and also stating his reasons for giving the preference to sheet iron over sheet copper for forming annealing tubes.

(Signed) T. PYCROFT,
Chief Secretary.

N^o 114

Fort St George,
Mint, 26th August 1862.

From

Lieut. Colonel G. C. A. Orr

Mint Master

To

J. Pycroft Esq^r

Chief Secretary
to Government

Sir,

Para 1.

With reference to the
Proceedings of Government of,
the 30th July 1862, c N^o 565, furnish-
ing me with a copy of a Des-
patch from the Right Hon^{ble}
the Secretary of State for India
under date the 25th June 1862
c N^o 36, and desiring me to afford
the information required in the
third para. regarding the flat
Blister Steel and round Cast
Steel indented for by me in
February last, I have the
honor to inform you that the 3
inch flat Blister Steel is required
principally

principally for the Manufacture of the Collars within which the Coin-age Blanks receive their impressions between the Dies, and that it should be of the thicknesses noted in the Margin. The $1\frac{1}{4}$ inch round cast steel is required for Dies, and I trust that it may be supplied of the very best quality, such as is manufactured expressly for Dies by Messrs. Hawksworth & Co. of Linlithgow, and is used, I believe, in the Royal and Birmingham Mints under the name of Hawksworth's round steel.

$\frac{1}{2}$ Ton of $\frac{1}{2}$ inch
 $\frac{1}{2}$ do. of $\frac{5}{8}$ do.
1 do. of $\frac{3}{4}$ do.

2. With regard to the suitability or otherwise of Tubes made of sheet iron instead of Copper for annealing purposes, I beg, with all deference, to state that my experience of their use during many Months past will not allow me to acquiesce in the opinion which has been expressed of their unfitness by the Master of the Royal

Royal Mint, for it has been found that whereas an iron tube on the average anneals 2,309 lbs weight of Blanks, one of Copper was worn out after annealing 1,158 lbs. - Both metals are liable to rapid destruction by the high temperature of the Annealing furnaces, but contrary, I must say, to my expectations, iron is found to stand it better than Copper, while it is many times cheaper notwithstanding that a large portion of the cost of the burnt out Copper tubes is recovered by the sale of the remaining Metal. I give the preference therefore to sheet iron over sheet Copper as the material of which to form annealing tubes, and I recommend its use failing the successful application of the cast iron pots lined with Copper which are being sent out.

I have the honor to be,
Sir,
Your most obedient servt.,
Amos A. Briggs.
Mint Master

P.B.V.

19th 28th

Letter to the Secretary of State for India

today

Financial Department

No 633-

The Secretary of State for India.

Sir,

With reference to the despatch from the R. & the Secretary of State for India in this Department, dated the 25th June last, No 56, I am directed by the Governor in Council to transmit to you a copy of a letter from the Mint Master, furnishing the information required in para 3 of that despatch regarding the flat Blister Steel and Round Cast Steel indicated for in February last, and also stating his reasons for giving the preference to Sheet Iron over Sheet Copper for annealing Tubes.

Fort St. George,
28th Aug 1862

JP

Checked by the Inspector

Order No 28 Aug 1862 No 632

Ordered that a copy of the foregoing letter be forwarded to the R. & the Secretary of State for India, in reference to the letter despatched dated the 25th June last, No 56.

JP

Financial Department.

From

The Mint Master

No 632

To Government (Mint & Treasurers)

Dated 26th

Decr. 26th Aug 1862

No 114

No 692

With reference to Order of Govt No 565 dated that the flat Blister Steel is required of 2 1/2 to 3 inches thickness & the Round Cast Steel for dies of 4 to 6 inches diameter.

Let of 5 Sept

For 30 July 1862

With an Order

13-95

Sept 5th 1862

93095

Final 1862 Sept.

2453-

To the Secretary
of the Board of
Education

Sept 28th 1862