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(3) Initials of the Referencer_____

MADRAS RECORD OFFICE.

Government of Madras.

Public Works DEPARTMENT.

G.O. No. 739	Press / Mis.
Dated 11-3-	18

Not to be folded or roughly handled

Proceedings of the Madras Government, Public Works Department, 11th March 1864.

No. 266. Read the following Proceedings of the Madras Government in the Military Department:—

Authorizing the erection of a new furnace for the Brass Foundry at the Gun Carriage Manufactory, Presidency District, and requesting that the work may be undertaken by the Department Public Works, in communication with the Superintendent of the Gun Carriage Manufactory. } (Here enter 3rd March 1864, No. 741.)

No. 267. ORDER THEREON, 11th March 1864, No. 739.

Communicated to the Superintending Engineer, 4th Division, with a request that an Estimate of the cost of the work may be submitted to Government without delay. In the meantime the construction of the furnace may be proceeded with.

(True Extract.)

(Signed) CHARLES A. ORR, Colonel, R. E.,
Secretary to Government.

To the Superintending Engineer, 4th Division, with two enclosures.
„ Controller and Auditor of Public Works Accounts.
„ Accountant General.

Exd. S. T. Augustin.

MILITARY DEPARTMENT.

PROCEEDINGS OF THE MADRAS GOVERNMENT.

Read the following papers:—

From the Officiating Inspector General of Ordnance and Magazines, Fort Saint George, 4th November 1863, No. 150; to the Secretary to Government, Department Public Works.

The arrangements connected with the casting of Brass at the Gun Carriage Manufactory, having been pronounced defective and causing loss to the State, it has been deemed necessary to effect a remedy. The remedy proposed is specified in the margin, and is based upon the recommendation of Mr. Scott, the Founder at the Mint.

To build a set of Furnaces for melting Brass in all respects like those existing at the Mint, of which a Plan is herewith submitted.
That the intensity of heat evolved from charcoal fire not being sufficient to melt the metal to such a degree of fluidity, as is required to produce good casting coke, should be used instead.
That the crucibles should be made of sufficient capacity to contain 200 lbs. of metal, and should be open and not luted over as at present. If made after the plan pursued at the Mint, they would last for four or five castings instead of only one, as is now the case.
That the metal to be used should be made with Copper and Tin, and not from the metal of old Guns, as the proportion of their composition appears uncertain.
That in all cases when tin or zinc is used, they should be mixed after the copper has been properly melted.
Above all, the moulds should be thoroughly ventilated and dried.

2. I enclose an Estimate of the materials that will probably be required, but as the work is of a character that cannot be undertaken by this Department, I have the honor to request that sanction may be accorded for its being undertaken at an early date by the Department Public Works. Every information and specification that may be required will be furnished by the Superintendent of the Gun Carriage Manufactory.

Referred to the Military Department.

(Signed) C. A. ORR, Colonel, R. E.,
Secretary to Government, D. P. W.

6th November 1863.

From the Inspector General of Ordnance and Magazines, Fort Saint George, 17th February 1864, No. 215; to the Secretary to Government, Military Department.

With reference to your memorandum, dated 16th November 1863, calling for further and fuller information of the nature and extent of work to be carried on in the proposed new Furnace for the Brass Foundry at the Gun Carriage Manufactory, I have the honor to supply the following particulars for the information of Government.

2. The work of casting at the Manufactory is not periodical, or occasional, but continuous, and chiefly consists of the following articles, which are used in the construction of Gun Carriages:—

Naves for Wheels.
Elevating Screw Boxes.
Beds for do.
Trucks for Garrison Carriages.
Do. for Hand-spikes do.
Elevating Screw boxes do.
Beds, Bolts, Nuts do.
Bouches for Cast-iron Truck wheels.
Hinges for Ammunition boxes.
Boxes for wooden Naves.
Vent pans. } For Armstrong Carriages.
Saddle blocks. } For Armstrong Carriages.
Wheels Traversing. } For Armstrong Carriages.
Buckets. } For Armstrong Carriages.
Nipples oil-can. } For Armstrong Carriages.
Sockets and covers. } For Armstrong Carriages.
Lock-plates for Ammunition boxes.

3. The average total weight of Brass casting monthly is about 5,000 lbs., the weight of the heaviest article is about 100 lbs.

4. I have placed myself in communication with the Mint Master, and have ascertained from that Officer that the work of casting Brass articles for the Gun Carriage Manufactory can be undertaken at the Mint, but "that an expenditure of about "Rupees 1,000 in Building a new "Chimney, enlarging a Store, put-"ting up a moulding bench, and "improving the floor of the Brass "Foundry in the Mint, would "enable us to supply monthly the "quantity of castings required "by the Gun Carriage Manu-"factory," will be necessary. The Mint Master has further informed me, that he cannot undertake to supply Brass castings to the Gun Carriage Manufactory, at a less cost than 14 Annas per lb., whereas, from the annexed letter of the Superintendent Gun Carriage Manufactory, it will be observed that, such castings can be turned out at that Manufactory (including the cost of the metal, Annas 9-5) at Annas 10-5 per lb.

With reference to your memorandum, No. 7300, dated 9th January 1864, forwarding a communication* from the Mint Master, for any remarks, I have the honor respectfully to urge in the strongest manner, that I consider the proposed transfer of Brass castings from the Gun Carriage Manufactory to the Mint most objectionable, for the following reasons:—

* No. 348, 7th January 1864, herewith returned.

1st. If the work of casting Brass articles at the Gun Carriage Manufactory, is transferred to the Mint, this Manufactory will be deprived of the means of training Ordnance Artificers as Brass Founders, and as this is one of the trades taught them, with a view to meet demands from up-country Arsenals, &c., &c, it would be most detrimental to the Ordnance Department, to transfer the work.

2nd The expense of Building a Furnace for the Brass Foundry, proposed in my letter No. 961, dated 29th October 1863, amounts to only Rs. 299-0-10, as per Estimate herewith sent, while the Mint Master states that he requires Rupees 1,000 for preparations to undertake the supply of Brass Castings to this Department, therefore the preparatory work, if done at the Mint, will be more expensive to Government than if it is allowed to be done here on the Plan proposed by me.

3rd. It must be evident that a considerable amount of responsibility will be transferred from this Department to the Mint, as the former cannot be responsible for defects in Casting made in another Department, which are not apparent on the surface, and there will be constant correspondence and probably disputes about defective Castings which must be returned by this Department, moreover, the routine writing and correspondence caused by two Departments being employed in making up Gun Carriage work will be considerable.

I submit a statement shewing the price of Brass Castings at the Manufactory, including every expenditure but the Brass, which amounts, as you will observe, to only one Anna per lb. It is therefore desirable to ascertain the rate at which the Mint Master is able to furnish these Castings. The Bazar rate, I believe, is from 6 Annas and upwards per lb., according to the nature and difficulty of the work.

5. The Superintendent Gun Carriage Manufactory, however, strongly deprecates the transfer of this work from the Manufactory to the Mint, and concurring, as I do, in the views set forth by the Superintendent Gun Carriage Manufactory, I trust Government will be pleased to entertain the proposal contained in my Report, No. 150 of 4th November 1863, and direct that the work may be undertaken by the Department Public Works, in communication with the Superintendent Gun Carriage Manufactory.

6. The Cupola at present in use at the Mint, and originally transferred from the Gun Carriage Manufactory, with the view of economising the casting of metal, is only intended for Iron Castings, all which description of work required for the Ordnance Department is now executed at the Mint, in accordance with the proposition made by this Department when obtaining the sanction of Government for the transfer of the Cupola.

ORDER, No. 741, *3rd March* 1864.

The Governor in Council authorises the erection of a new Furnace for the Brass Foundry at the Gun Carriage Manufactory, and directs that the work be undertaken by the Department Public Works, in communication with the Superintendent of the Gun Carriage Manufactory.

(True Extract.)

Secretary to Government.

To the Public Works Dept., with Plan and Estimate. 20 spare Copies.
" Inspr. Genl. of Ordnance.
" Quarter Master General.
" Examiner of Ordnance Accounts.

Exd. J. E. Cashart.

Ord: of Gen.l Fortescue
H. 1864 Dep.t
No 1009
Ord: - 11. Feb.y &c.
in the Mil.y Dep.t
Dated 3rd
Rec.d 5th } - Mar.y/64
82 - No 741

No 739 - 11th March/64.

Authorizing the erection of a new Furnace for the Brass Foundry at the Gun Carriage Manufactory, Pimlico; and requesting that the work may be undertaken by the D.W.W., in communication with the Sup.t of the Gun Carriage Manufactory -

Letter an Order

No. 256. 257

No 739.

Communicated to the Superintending Engineer 4th Division with a request that an Estimate of the cost of the work may be submitted to Government without delay. In the meantime the construction of the furnace may be proceeded with.

Chepmell
11th March/64

To The Sup.t Eng.r 4 Div.n with 2 Encl.s
" — " Controller & Auditor of W.W. Accounts
" — " Accountant General
Dep.t 12 Mar.

x82 Rec.d the Sup.t Eng.r 4 Div.n Dep.t