

Public (1898) Department.

ORDINARY MS.

G.O., No. 665

Dated 16-5-88

INDEXED.

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1898

[Despatch Abstract.]

Coming to the supply
Hot Press, for report, letter from
the Director-General of stores, India
office stating, with remarks, that
it is proposed to defer the supply
of Gull's patent hot rolling mill
required for the use of the Hot
Press.

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BACK PAPERS.

G.O.	No.	Department.	Date.	G.O.	No.	Department.	Date.

FURTHER PAPERS.

G.O.	No.	Department.	Date.	G.O.	No.	Department.	Date.

[Pub.
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Public (1898) Department.

CURRENT No. 1421

From

The Director General of Stores
India Office, London

Order No 665, of 16 May 1898.
his Communicated to the
Supt. Govt. Press for report
with reference to G.O. No.
Pub. 2.5.2.18.

No. D.O. 8653

Dated 21. April 98

Received 10. May 98

Registered 10. " "

Enclosures 8

Spare copies.

To the

Supt. Govt. Press (a) of present
enclosures in
encl. to be sent

SUBJECT.

Stating with reference to the
indent of the Govt. Press for a
Lill's patent hot rolling
machine, that the Supt. of
Govt. Printing Calcutta states
that the machine is of no use
on account of the excessive
spoilage of paper by it.

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14/5/98

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13.5.98

BACK PAPERS.

G.O.	No.	Department.	Date.
	212-3	Pub.	5.2.98
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FURTHER PAPERS.

G.O.	No.	Department.	Date.

No. 2500 P.

Office of the Superintendent of Government Printing, India,
No. 8, Hastings Street.

From The Superintendent of Government Printing, India.
To The Director General, Stores,

India Office, London.

Calcutta 8th March 1897.

Sir,

I have the honour to inform you that I have provided in this year's indent for repairs to be done to a Gill's Hot Rolling Machine to be sent home for that purpose; but before despatching the machine, I would solicit your advice in the matter.

The machine was received from Messrs. Furnival & Co. in the year 1878, and has virtually been of no use since, owing to excessive spoilage. When I took charge of this department in 1891 I found that the machine had been discarded, but I had it refitted, and all worn parts renewed; and the most expert advice I could obtain locally was engaged in the examination of the machine; but the result was the same as before: the percentage of spoilage was excessive.

Messrs. Furnival & Co. were then communicated with, and their first suggestion that the fault was not in the machine, but in the paper was carefully tested, but without resulting in improvement. It was found that very thick papers could be rolled with reasonable spoilage, but thin papers could not be rolled at all.

Their

meir second suggestion was that after being in use for so many years, the rolls perhaps required regrinding, and they suggested that they should be sent home for this purpose. The argument against this is that the trouble existed even when the rolls were new, and as the machine has hardly been used at all, they could not have become defective through wear. As the machine, however, had been put aside for a long time, the rolls have no doubt contracted some rust on the face and on this account it may be essential to have them reground. The objection to this is that we may go to the expense of regrinding, with freight both ways, and after all find the machine as useless as it is at present. We are not likely to find a purchaser for it in this country, unless for its value as old iron, and I am unwilling to let it go at this value until all means of effecting a better arrangement have been exhausted.

My opinion therefore is that the machine should be shipped home and tested by Messrs. Farnival & Co. both with English made papers, and with the locally made papers of which we shall send you samples. If it is found that by adopting any improvements which may occur to them the machine can be made to roll the locally made paper, with the lowest possible spoilage, the improvements might be effected, and after careful testing, the machine returned here. If on the other hand, it is found that the locally made paper cannot be rolled in the machine without an unduly high percentage of spoilage, then arrangements might be made for disposing of the machine to the best possible advantage.

Awaiting your opinion.

I have, &c.,
W. Ross,
Superintendent.

From Furnival & Co.,

Printers' Engineers,

Reddish, Nr. Stockport,

April 22nd 1897.

The Director General of Stores,

India Office,

Whitehall, London.

Sir,

In further reply to your S.4402 of the 1st instant, we beg to say that we have been looking very fully into the matter about which you write and find that we have already been in correspondence with Mr. Ross the Superintendent of Government Printing at Calcutta and we really are at a loss to add anything to the suggestions we have already said.

So far as our memory serves us, the paper which was sent over by your people in India sometime ago was of very poor quality, such as we do not think could be Rolled on any machine without a large proportion of spoilage, and it really does seem to us very probable that the paper you wish to Roll on the machine is unsuitable for the purpose, in fact we are at a loss to explain the difficulty on any other ground seeing that a large number of these machines are at work in Great Britain and elsewhere of which we never heard a word of complaint.

The most practical method we could suggest for ascertaining whether this suggestion is sound or not would be for the Superintendent in India to send us a quantity of paper such as he wants to roll, say 100 sheets of each
sort

sort packed in the flat between boards and not Rolled or Creased and we would have them tried on a machine here by people accustomed to the work, and if they failed to produce a satisfactory result, we should have to come to the conclusion that it would scarcely be any use expecting to get satisfactory results in India. We have met with papers in this country that will not Roll without creasing and cutting and it may be that it is the same with the paper in question.

To put you in possession of what has been previously said on the subject to Mr. Ross, we enclose you copies of our letters to him under date March 3rd 1892 and November 7th 1895.

We may further add that in the event of our suggestion for sending paper over to England being accepted, it would be better for it to come to our London address 32 St. Bride Street E.C. as there are several machines in London, and our people there would make arrangements for the Rolling and returning the paper.

Regretting that you should have so much trouble in the matter.

We are, &c.,

(Sd) Furnival & Co.

S. 4402.

India Office,
30th April 1897.

Sir,

Referring to your letter, dated 8th March 1897, regarding the despatch of Gill's hot rolling Machines for repair, the matter has been referred to Messrs. Farnival & Co., the suppliers, and a copy of their letter in reply, dated 22nd April 1897, is enclosed for your information.

From this it will be seen that Messrs. Farnival & Co. adhere to the opinion that probably the machine is not adapted to the quality of paper which you wish to roll.

In view of the cost of freight which would be incurred in sending home the Machine and the possibility of its proving to be unserviceable, I am disposed to concur in Messrs. Farnival's suggestion that some of each of the different papers required to be rolled should be sent home for trial with Messrs. Farnival's machine. If the papers can be successfully rolled here it would indicate that the machine is at fault and it might be worth while to send it back for repair. But if the process fails also in England with the locally made papers it would hardly be advisable to send back the machine which could not be expected to succeed in India even after repair.

I have &c.,

(Sd) E. Grant Burls,

Director General of Stores.

The Superintendent
of Government Printing, India,
Calcutta.

667/P

Office of Superintendent of Government Printing, India,
8, Hastings Street, Calcutta.

To The Director General of Stores,
India Office, London.

Dated 15th June 1897

Sir,

With reference to your letter No. S.4402 dated 30th April last, I have the honour to advise despatch through the Agent for Government Consignments to your address of a box containing locally made papers as noted overleaf, for Experimental Rolling by Messrs. Furnival & Co. as suggested.

I have, &c.,

(Sd) W. Ross,

Superintendent.

-----LIST OF PAPERS.-----

	Rms.	Qrs.	St.
Azuire Laid Imperial 72lb.	0	4	4
Super Royal 54lb.	0	4	4
Royal 44lb.	0	4	4
c Medium 34lb.	0	4	4
Demy. 25lb.	0	4	4
Double Foolscap 30lb.	0	4	4
Foolscap 15lb.	0	4	4
White Cartridge 72lb.	0	4	4
Imperial			
Super Royal 50lb.	0	4	4
Royal 40lb.	0	4	4
Demy 32lb.	0	4	4
Cream Wove Double Demy 50lb.	0	4	4
Do. 48lb.	0	4	4
Double Foolscap 28lb.	0	4	4
Do. 24lb.	0	4	4
White Printing Super 34lb.	0	4	4
Royal			
Super Royal 28lb.	0	4	4
Royal 30lb.	0	4	4
Do. 28lb.	0	4	4
Do. 25lb.	0	4	4
Do. 20lb.	0	4	4
Medium 20lb.	0	4	4
Demy 24lb.	0	4	4
Do. 18lb.	0	4	4
Double Foolscap 28lb.	0	4	4
Do. 24lb.	0	4	4
Do. 20lb.	0	4	4
Cream Wove Bank Folio 18lb.	0	4	4
Post.			
English Hand made Do. 12lb.	0	4	4
White Printing Double 44lb.	0	4	4
Royal			

Handwritten notes:
 1/2 lb 4 0
 1/2 lb 4 0

32 & 34, St. Bride Street,

Ludgate Circus, E.C.

Aug. 28th 1897.

To The Superintendent of the India Store Depot,
Blvedere Road, Lambeth, S.E.

Dear Sir,

Referring to your favour No. 24/144 we have now got the paper rolled and await your instructions for its disposal. You might let us know whether you wish any of your people to inspect it here or if we shall put it in the box and return it to you as it came, or where you wish it sent to.

We understand the principal difficulty experienced by your people in India in rolling these papers was their tendency to crease and cut in passing through the machine, and so producing considerable spoilage. You will see on examination that there has been practically no spoilage in rolling the papers here; but some of the thinnest of the papers which were rather uneven and crumpled remain so; but if we had felt at liberty to cut the sheets in half probably they would have been much improved, as we have frequently found sheets that creased and cut would come out all right when cut in half and rolled at twice, as the slackness in the paper all gathers up towards the tail of the sheet and the longer the sheet is the worse it becomes, until it overlaps and cuts. If you think it would be of any service to your people we could introduce any of them to the firm who rolled the paper for us, and they might possibly get some useful hints; but we think it likely that the time which has elapsed since the paper left India has improved its condition

condition for rolling, as it is more difficult to roll new paper without spoilage than after it has been kept for a time, and warehousemen here are so conversant with this difficulty that they usually, when compelled to use new paper, hang it up or spread it out for a day or 2 (or several days if they can afford the time) to season it, and find it gives less trouble in rolling afterwards.

We trust the above will assist your people in overcoming their difficulties; but shall be pleased to give you any additional information we may possess, and remain

Yours truly,

Furnival & Co.
per (Intld.) E.C.

COPY REPORT BY SUPERINTENDENT, INDIA STORE DEPOT,
DATED 7th OCTOBER 1897.

I regret, that to some extent the trial we suggested has failed to give any definite results. Instead of having the samples received from India, rolled with great care so as to ascertain whether the paper or the Indian machine were in fault, they were intrusted, by Messrs. Farnival to a firm who rolled for the trade, who have rolled them hastily, and have not taken much trouble with the matter, their machine was not in very good order. Even with these drawbacks it will be seen that the sheets, with the exception of the handmade ones, are fairly rolled, and that there has been little, or practically, no spoilage.

A few sheets of India made paper, enclosed in the case returned, have been rolled in the presence of an Officer of this Department by an expert workman of another firm, whose machine is in good condition. As no preparation beyond altering the pressure, was made for these sheets, they will show what can be done in the ordinary way with the machines.

Respecting handmade paper;- it is the opinion of efficient workmen in England that, although it can, at times, under certain conditions, or with humouring according to circumstances, be rolled fairly well, no satisfactory results can be universally depended upon; but with machine-made paper there should, under ordinary circumstances and in the hands of efficient workmen, be no difficulty whatever.

It was explained by Messrs. Farnival that these

machines

machines are not primarily intended for surfacing unprinted papers; that is only a secondary use for which the machine has been found capable by the users. The primary object is to dry, and take out the impression of printed matter, and so supersede the hydraulic and standing presses and for such a purpose; there is no doubt the machine is a success in England, and there is no known reason why it should not be so in India, provided it is kept in good order, the paper is in a fit condition to be rolled, and there is an efficient workman to attend the working.

In order to fully test the machine in India, it is suggested, the sliding bar and points be taken off, and some sheets of various sizes and thicknesses passed through the rolls, care of course being taken in the feed; and if it is then found the sheets are fairly surfaced, allowance being made for any imperfections in the rolls, as is probably the case after nearly twenty years, it may then be concluded it will be advisable to return the machine to England to be overhauled and have modern points fitted to it.

In making the experiment the greatest care should be taken in regulating the pressure evenly, so as not to draw the paper on one side, or if the paper is one-sided the pressure should be regulated accordingly. If these precautions are carefully carried out it will be found the machine will probably be a success, at least with printed matter. Of course with plain paper extra precaution should be taken to ensure success, and it should always be remembered that it is essential to have

at least one straight flat edge for feeding. Paper with bad edges may often be rolled successfully by first having the margin cut off in the guillotine. Twice rolling will overcome the difficulty with some paper, first lightly, and second with increased pressure.

S. 9393.

India Office,
Whitehall, S.W.
15th October 1897.

Sir,

With reference to your letter dated 15th June 1897,
No. 667 P, ^{advising} ~~advising~~ the despatch of a box containing
locally made papers for experimental rolling by Messrs.
Furnival & Co., I have the honour to enclose for your
consideration and for the favour of any remarks thereon
copies of a report dated 7th October 1897, by the
Superintendent, India Store Depot, and of a letter from
Messrs. Furnival & Co. dated 28th August 1897.

I have, &c.,

(Sd) E. Grant Burls,
Director General of Stores.

The Superintendent of Government Printing,
8, Hastings Street,
Calcutta.

It is requested that in any further communication on this subject the under-mentioned letter and number may be quoted, and the reply addressed to
The Director General of Stores,
India Office,
Whitehall,
London, S.W.

D.O. 8663.

India Office,
Whitehall,
London, S.W.

21st April 1898.

Sir,

In the Indent for printing &c. materials for the Government Press, forwarded with your letter No. 213 dated 5th February 1898, a demand occurs for Gill's patent hot rolling machine, (items 6 & 7), to be obtained from Messrs. Furnival & Co.

I have the honour to inform you that the Superintendent of Government Printing Calcutta has one of these Machines in his Office, but has stated that the Machine is of no use owing to excessive spoilage of paper, and has been discarded. It is thought that the Machines require specially skilled workmen for their manipulation.

If the Machine is required only for taking out the impression of ordinary printed matter, it might in the hands of an expert workman be satisfactory; but if it is intended to deal with hand made paper, to surface machine-made paper, or to stretch paper for litho. work, the results, it is thought, will not be satisfactory.

In these circumstances it is proposed to defer the supply of items 6 and 7, pending the receipt of a further expression of your wishes in the matter.

I have the honour to be, Sir,

Your obedient Servant,

The Secretary to the
Government of Madras,
Public Department,
Madras.

Director General of Stores.

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