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INDUSTRIAL STATISTICS

The industrial statistics presented here were gathered in the census of 1850, the heyday of the milling industry. In that census, no industrial establishments of over \$500 annual production were reported from Calvert and Caroline Counties. Nothing relevant to this history was reported from Dorchester; Garrett and Wicomico Counties did not exist, and Howard County was merged in the statistics with Anne Arundel. It was essentially with this

accumulation of plant and resources that Maryland's fragment of the United States went into the War Between the States, a conflict that called forth courage and fortitude of almost Messianic proportions on both sides, and yet was brought to its end by the superior industrial productivity, inventory of productive machinery, and accumulated mineral resources that lay in greater preponderance in but one of the almost random groupings of states that participated in that conflict. The data is from Dr. R. S. Fisher's *Gazetteer of Maryland*.

ANNE ARUNDEL COUNTY INDUSTRIAL STATISTICS – 1850

	No.	Capital	Hands	Value of Product
Factories, Cotton	2	\$125,000	314	\$207,500
Factories, Wool	1	,300 [sic]	6	3,500
Furnaces, Iron	3	115,000	195	168,600
Mills, Clover	1	150	1	2,000
Mills, Flour	4	88,500	18	315,925
Mills, Grist	13	15,950	18	31,180
Mills, Paper	2	1,200	5	5,600
Mills, Saw	13	12,300	16	27,650
Tanners	1	300	3	900

NOTE: All the sites above except the furnaces, were in the Howard District of Anne Arundel County, and their sites are in present Howard County. No figures are recorded in the original census book for mills in Anne Arundel County itself.

BALTIMORE CITY INDUSTRIAL STATISTICS – 1850

	No.	Capital	Hands	Value of Product
Distilleries	5	\$75,300	9	\$358,864
Forges	1	30,000	35	60,000
Furnaces, Iron	2	27,500	403	195,000
Furnaces, Copper	1	100,000	40	450,000
Mills, Flour	4	130,000	22	491,133
Rolling Mills	1	60,000	96	171,531
Tanners	7	141,000	72	277,150

CARROLL COUNTY INDUSTRIAL STATISTICS -- 1850

	No.	Capital	Hands	Value of Product
Mills, Flour	10		50	\$96,350
Tanneries	20		57	99,315
Factories, Cotton	1		40	24,000
Factories, Woolen	6		18	12,790

CECIL COUNTY INDUSTRIAL STATISTICS -- 1850

	No.	Capital	Hands	Value of Product
Factories, Cotton	2	\$48,000	97	\$89,284
Factories, Woolen	5	31,500	45	45,754
Furnaces	2	68,000	204	81,000
Mills, Flour	22	104,600	35	121,000
Mills, Grist	8	32,400	15	57,548
Mills, Paper	3	42,500	16	42,000
Mills, Rolling	3	111,000	70	86,000
Tanneries	2	10,000	7	8,850

FREDERICK COUNTY INDUSTRIAL STATISTICS -- 1850

	No.	Capital	Hands	Value of Product
Mills, Flour	72	\$350,550	135	\$798,586
Tanneries	41	243,100	179	429,508
Furnaces, Iron	1	80,000	90	100,000
Mills, Woolen	9	25,600	45	26,950

HARFORD COUNTY INDUSTRIAL STATISTICS -- 1850

	No.	Capital	Hands	Value of Product
Mills, Woolen	3	\$7,600	20	\$13,100
Mills, Paper	1	6,000	5	8,000
Forges, Iron	2	38,500	27	29,300
Furnaces, Iron	4	280,000	144	171,800
Mills, Flour	12	65,500	21	262,010
Tanneries	6	11,000	17	9,700

MONTGOMERY COUNTY INDUSTRIAL STATISTICS – 1850

	No.	Capital	Hands	Value of Product
Mills, Cotton	1	20,000	70	\$39,200
Mills, Woolen	4	15,200	30	24,500
Mills, Flour	6	25,050	13	124,945
Mills, Grist	15	12,050	15	15,852
Tanneries	3	3,900	9	9,668

PRINCE GEORGE'S COUNTY INDUSTRIAL STATISTICS – 1850

	No.	Capital	Hands	Value of Product
Mills, Cotton	3	\$298,000	215 Male 340 Female	\$275,000
Mills, Woolen	1	2,500	11	6,000
Furnaces	1	15,000	25	27,000
Mills, Flour	2	33,000	11	40,294
Mills, Grist	2	4,000	3	8,800
Mills, Saw	1	2,200	10	7,000

QUEEN ANNE'S COUNTY INDUSTRIAL STATISTICS – 1850

	No.	Capital	Hands	Value of Product
Mills, Bark	1	\$5,000	5	\$3,000
Mills, Grist	8	17,800	13	64,992
Mills, Saw	3	5,500	30	15,200

SAINT MARY'S COUNTY INDUSTRIAL STATISTICS – 1850

	No.	Capital	Hands	Value of Product
Mills, Cotton	1	\$10,000	11	\$7,000
Mills, Grist	9	23,000	9	49,312
Mills, Saw	1	5,500	11	12,000

SOMERSET COUNTY INDUSTRIAL STATISTICS – 1850

	No.	Capital	Hands	Value of Product
Mills, Flour	3	\$6,000	3	\$5,860
Mills, Grist	28	35,000	40	41,560
Mills, Saw	31	39,250	54	51,535
Tanneries	2	2,500	4	3,400

WASHINGTON COUNTY INDUSTRIAL STATISTICS – 1850

	No.	Capital	Hands	Value of Product
Distilleries	6	\$15,000	9	\$32,520
Mills, File	1	25,000	20	30,000
Mills, Nail	1	15,000	24	47,000
Mills, Woolen	3	12,500	25	14,675
Mills, Flour	59	405,600	108	1,309,412
Mills, Rolling	1	25,000	9	25,000
Forges	1	5,000	12	26,000
Furnaces	2	58,000	85	80,500
Tanneries	18	58,800	49	96,985

BALTIMORE COUNTY INDUSTRIAL STATISTICS – 1850

	No.	Capital	Value Raw Material	Hands Male	Hands Female	Value of Product
Cotton Goods	15	\$1,713,000	\$853,461	617	1,317	\$1,258,512
Woolen Goods	4	134,200	105,000	76	73	159,900
Paper	13	69,400	80,501	69	43	152,740
Tanneries	7	75,000	52,445	35		77,700
Iron Mines	13	26,700	26,700	179		133,000
Iron Furnaces	2	350,000	163,053	165		155,000
Iron Forges	1	21,000	13,420	16		20,000
Iron Nail Mills	1	105,000	56,700	140		140,000
Copper Mines	1	1,000		23		5,375
Coffer Refining	1	45,000	105,400	15		155,500
Flour Mills	20	500,500	1,085,272	70		1,340,426
Grist Mills	20	56,000	77,800	25		95,150
Distillers	3	91,500	133,481	30		157,700

SUMMARY OF MILLS IN 1850 – VS- SURVIVALS FOUND IN 1976

COUNTY	GRIST	FLOUR	PAP.	CTN	WOOL	FORGES	FURN	TAN	NAILS	BONE	ROLLING	DIST	SAW	1976
Alleg.							1	7					4	1
Anne A.							3							0
B. City	5	4				1	2	7					5	10
B. County	20	29	13	15	4	1	2	7	1				3	21
Calvert	No report that year													0
Caroline	No report that year													6
Carroll	9	30	4	1	6			20						22
Cecil	8	22	3	2	5	2		2			3		4	11
Charles	No report that year													2
Dorchester	No report that year													4
Frederick		72	1		9		1	43				1	13	13
Harford		12	1		3	2	4	6					2	16
Howard	13	4	2	2	2			1					13	3
Kent	6	5			1									1
Montg.	25	6	1	1	4			3			1		15	2
Prince G.	2	2		2	1		1						1	2
Queen A.	8												3	3
St. Marys	9			1									1	3
Somerset	28	3			2			2					31	2
Talbot	5	6												3
Wash.		59			3	1	2	18	1		1	6	3	18
Worcester	17					1		2					17	0
Dist. Col.				1	1									2
Garrett	Not yet established, included in Allegany statistics													2
Wicomico	Not yet established, included in Somerset and Worcester statistics													2

GRAND TOTALS:

Type of Mill	Count
Grist	147
Flour	245
Paper	25
Cotton	33
Woolen	43
Forges	5
Furnaces	19
Tanyards	116
Nails	8
Bone Mill	3
Rolling	5

Distill. 16
Sawml. 118

Mills of antiquarian interest surviving 1976: 149.

NOTES: Except for the furnaces, all the sites listed under Anne Arundel County in the statistics were actually in Howard District of Anne Arundel County. See original census of manufactures returns in Maryland State Library, Court of Appeal Building, Annapolis.

In 1968, the author counted 242 mills, furnace, and primitive industry sites, but that counted the 20th century feed mills. The 1976 tabulation counted 12 furnace ruins and 82 mill ruins.

GLOSSARY

***Ad Quod Damnum*, writ of:** A legal device available in the colonial period for condemning 20 acres of another person's property to build a mill.

Air furnace: A reverberatory furnace like a baker's oven used to melt pig iron at a foundry.

Bails: The "iceman's tongues" hoisting apparatus to lift the upper millstone for sharpening.

Bank: The earthen hill into which an iron furnace is built. Also an easily worked deposit of iron ore.

Bark mill: A works that rolled a large stone with a corrugated edges over oak and hemlock bark to provide a powder for tanning hides. Usually powered by an animal.

Bate: A tanyard vat for steeping hides in lye (from the Swedish word *beta*, meaning to tan).

Beam house: The area of a tanyard where de-hairing and liming occurs, the first step where hides are stretched over wooden beams for hand scraping.

Bedder: Or bed stone, the lower millstone, the one that does not move, being bolted to the floor.

Bellows: The leather bladder or accordion-like chamber that was pumped by water power to create a forced blast to fan the fire in an iron furnace.

Bessemer process: A method for making mild steel by blowing a cold blast through the bottom of a crucible to burn out the carbon content. First used in this region at Sparrows Point in 1891.

Bill stuff: At a sawmill, an assortment of different sized board and scantling for filling out contractors' bills of material.

Billy: Nickname of a slubbing machine or roving machine.

Blast: The entire period an iron furnace is continuously fired up, as much as a year. Also the constant current of air pumped into the bottom of the furnace stack.

Bleach works: A plant where cloth was whitened by caustics and exposure to the sun, e. g., Rockland Bleach Works in Baltimore County.

Bloomery: A primitive works where about a bushel of iron ore was heated to a hot pasty mass to produce a type of wrought iron.

Blue stones: See Cologne stones.

Bobbin: The wooden spool on which rovings or yarn is wound after spinning. See also cop.

Bog iron: A form of iron deposited by aquatic microorganisms, usually lying near the surface, a species of limonite, easily melted by colonial iron furnaces.

Bogus: A heavy grade of paper suitable for lining the inside of railroad box cars.

Bolster: In mill-wrighting terms, a large shaped wooden block set on top of a post and under the overhead girts in the interior framing of a mill. The bolster was pinned to the girts with 1-inch diameter "treenails," "trunnels," or pegs.

Bolter: A device used to sift flour for fineness.

Bolting cloth: Usually made of silk in historic times, the fine mesh cloth used to sift flour. Now available in nylon.

Bosh: The widest part of the furnace chamber; located at the bottom where the molten materials accumulated under blazing hot conditions.

Bran: The outer coating of a wheat grain, some times discarded to sell as feed, sometimes ground to make whole wheat flour.

Breast wheel: Water wheel that is fed at mid-point on its diameter.

Bridge house: A wooden ramp at the top of an iron furnace where hand carts full of ore, flux, and charcoal could be dumped into the top of the furnace to keep the furnace going for weeks or months.

Buckets: The receptacle built into a water wheel to hold the water while the wheel rotates.

Buddle: A wooden placer mining apparatus or sluice box, used for washing chrome ore from streams in Baltimore County.

Burr, or buhr: A millstone.

Calcine: To reduce to a powder or friable state by application of extreme heat.

Calender: A roller machine that gives a luster or smoothness to manufactured cloth.

Calico: Cotton cloth decorated with colors by roller machinery similar to a printing press for comic strips.

Cap: The rotating roof of a smock windmill. Only the roof and the windmill sails were turned into the wind.

Cam: projecting stud or protrusion on a revolving wheel or axle to activate a hammer or pounding mallet once each cycle. Used at both tilt-hammer forges and in fulling mills.

Canvas: A class of plain, heavy cotton fabric, including duck. Includes entire range of tent material, sailcloth, belting, material for threshing aprons, mail pouches, laundry carts, tarpaulins, tire fabric, shoe material.

Carding machine: A combing machine employed in (1) woolen mills to align fibers into rolls suitable for spinning. (2) in cotton mills to produce a spiral rope of soft cotton fibers aligned in parallel (i. e., a sliver).

Carding Mill: A mill used for processing wool before it is spun or woven.

Cassimere: A plain or twilled woolen cloth used in men's suiting. Variously spelled by country millers.

Cassinet: Variously spelled by rural millers, it probably meant an all-wool suit material, the same as kersey, if made at a small fulling mill wool factory. Nationally, cassinet might also contain cotton.

Casting arch: A masonry arch, usually brick, to allow the furnace workers access to the bottom of the bosh to unplug the clay seal and let the molten iron gush out.

Casting house: A wooden shelter at one end of the furnace to keep the elements off the molten iron released into earth gutters to form pigs of iron. A rebuilt casting house can be seen at Catoctin Furnace.

Centrifugal system: A device for forcing middlings particles through the bolting cloth by forced air.

Chaffery: The part of a forge mill where blooms or "anconys" were beaten by tilt hammers into inch-thick bar iron suitable for reworking into horseshoes or hinge material. Rendered obsolete by the puddling mill. An example can be seen at Saugus, Massachusetts.

Charge: The first batch of iron, flux, and charcoal dumped into a furnace at the start its season in blast.

Cinder hole: The orifice through which slag could be periodically be raked out of an iron furnace while in blast.

Clothe: To equip the vanes of a windmill with canvas sails to catch the wind.

Clover mill: A mill devoted to extracting clover seed.

Coal: “Coal” always meant charcoal to colonial furnace men. It was stored in a coal house. Anthracite, never called “anthracite coal,” was used for smelting in Harford County in 1815 and in Allentown, Pennsylvania in 1839 in early experiments.

Coatings: Bulk quantities of woven material suitable for cutting into coats at tailoring shops. Similar term to “suitings” and “sportscoatings.” Large weaving mills did not ordinarily make items of clothing.

Cockeye: The slot cut into an upper millstone to mesh with an iron bracket fitted to the shaft, supporting the millstone from below.

Cockloft: The uppermost floor of a mill.

Cold blast: The stream of forced air pumped into the bottom of a colonial iron furnace. There was no method to heat the blast until the 19th century.

Collier: The iron plantation workman who stayed out in the woods day and night to make sure the smoldering mounds of burning wood for charcoal would not break out into open flame.

Cologne stones: One-piece millstone of volcanic rock from the vicinity of Köln in the Rhineland. Also spelled “Cullins.”

Conveyor: An Oliver Evans invention of 1787 using an endless screw mechanism to move flour or grain horizontally through the mill, an Archimedean screw device using wooden fins mounted on a shaft.

Cop: A cardboard cone on which the threads from an early mule spinner were accumulated.

Couch: Pronounced “cooch,” the felt or wire belting in a paper mill into which the slurry of dissolved rag or straw stock was poured to begin its flattening and drying into a web of paper.

Count: The yarn count or thread-size number indicates the number of yards that weigh one pound. A low number (e. g., No. 10) indicates coarse thread. A number such as 240 indicates a very fine thread.

Creel; A spool rack used to wind up warp yarns on a mule.

Creel boy: An employee assigned to collect filled-up bobbins in the spinning frame or mule.

Crucible: The bowl-like depression below the bosh where the molten iron accumulated in a furnace. A late 19th century crucible was a vessel for purifying molten iron of carbon with a forced air blast.

Custom mill: A mill where the owner operated on a commission or barter basis and did not buy wheat crops from farmers (as opposed to a merchant mill).

Damsel: A wooden device that keeps shaking the hopper to hasten the movement of the grain. Old millers said it was so called because it chattered while it worked.

Descender: An Oliver Evans device of 1787 designed to move grain or meal horizontally through the mill.

Descorticator: A grain cleaning machine that removes the husks of wheat.

Doffing: The act of lifting filled bobbins of spun threads from the throstle frame—done by hand, once a child's job.

Doubling: The stage of combing and stretching two or more slivers or threads.

Drawing: The stage of stretching the carded sliver to render the fibers parallel and uniform.

Dress: The design or configuration of the furrows on a millstone. Several different patterns have been used.

Dressing: The application of chemical coating to the warp threads in a textile mill.

Dressing: The re-sharpening of the furrows on a millstone.

Drill: An Oliver Evans device that used a shaft with small wooden fins to pull material through a flour mill in a horizontal direction.

Drill: Twilled cotton fabric sometimes in herringbone design, suitable for ticking and shoe lining, pocket material, etc.

Driving stocks: Water powered tilt hammers employed for fulling cloth.

Duck: The heavier type of cotton canvas sail-cloth, plainly woven. A duck symbol had been applied to this grade in Scotland to distinguish it from the lighter “Ravensduck.” Duck is derived from the Dutch word for canvas rather than the name of the bird. Available in numbered varieties.

Duster: A badly designed and unsuccessful mill.

Dusty: Nickname for a miller or for his sweeper apprentice.

Elevator: An Oliver Evans invention using belting and scoops on an endless chain to lift flour to the upper levels of a mill for storage or further treatment.

Evans improvements: Term used in advertising for the five patented devices invented by Oliver Evans before 1787 to automate flour mills.

Extra: A finely sifted grade of flour.

Eye: The center hole in a millstone.

Factory: In 19th century terms, a small works to prepare, spin, and weave wool into cloth of various grades.

Faggoting: The pounding of many rods of hot bar iron into a single iron shaft. See Franklinville Iron Works in Baltimore County.

Falling stock: Water-powered stamping devices for fulling cloth, driven intermittently by cam action.

Filling: The threads running crosswise in weaving—inserted by the shuttle. Its opposite was “warp.”

Finery: A part of a forge mill where pig iron was remelted and hammered by tilt hammers into blooms or “anconys” that could be pounded further at the chaffery to produce bar iron or wrought iron.

Fish weir: A dam built in a river to herd fish toward a cage.

Flask: A sand-filled wood-framed mold used for forming cast iron objects such as pots and plow parts. Filled from ladles with small quantities of molten iron drawn from the furnace crucible.

Flume: A wooden trough to lead the water the last stretch to the millwheel.

Flutter wheel: A wide wooden wheel propelled by the current of the water.

Flux: Derived from the medical concept of a purgative, lime stone or oyster shells were used in iron furnaces to absorb impurities. It was drained off as slag, a useless, glassy product when hardened.

Flyer: A spinning wire device that wound threads from a throstle onto the bobbins. Replaced by ring spinning in the 1840s.

Forge: The part of an iron plantation where water-powered hammers were used to pound pig iron into marketable forms such as bar iron (wrought iron). Some blacksmith shops were also called forges, e. g., Rodgers Forge in Baltimore County.

Founder: Skilled workman who regulated the iron furnace, prepared the molds to become “pigs,” and cast the iron onto the sand floor of the casting house.

Fourdriner: Named for the English brothers, Henry and Sealey Fourdriner, who in 1803 invented the first machine for making a continuous web of paper, revolutionizing a hand-work industry. The name still applies to such machines.

Frame: An upright machine or rack fitted with numerous spindles for winding up newly spun threads. See also water frame.

French burrs: Millstones made of separate pieces of white volcanic rock, held together by an iron rim, the material found in northern France near Paris.

Fulling mill: A mill equipped with cam-operated hammers to pound on wool cloth and full (i. e., fluff up or give body to) its fibers.

Fulling stocks: Same as falling stocks, q. v.

Furnace: In colonial times, a stone stack with brick lined interior designed to melt iron ore. In the later 19th century, furnaces had fire brick interiors and riveted iron jackets on the outside.

Fustian: A stout fabric of flax and cotton.

Garner: A wooden bin for storing wheat built into the upper floors of the mill.

Gig: A power-driven machine that roughs up woven woolen cloth with fine wire brushes to produce a thick pile.

Ginning: The separation of seeds from cotton bolls, usually performed in the cotton growing country before baling and shipping the crop.

Girts: In the interior framing of a mill, the girts are the horizontal members supporting the floor above. Girts sit on bolsters, and the bolsters sit on the upright posts.

Gries: The spelling of “grist” in the 1798 Federal direct tax list.

Gristmill: A mill that usually operated on a commission basis, no crops purchased from farmers. A custom mill.

Gudgeon: An iron journal on the end of a wooden axle or shaft, usually rotating in a bearing. One of the few iron parts in a colonial mill.

Hank: A unit of 840 yards of thread.

Head race: The channel or canal leading up to the waterwheel, sometimes fed into a head gate or into a flume.

Hematite: A hard red or grey iron ore found near the surface in Baltimore County but not used by iron makers until the 19th century.

Hessian fly: Destructive insect brought to America in the bedding of Hessian troops, a destroyer of wheat. Also just called “the fly.”

Hoist: The block and tackle lifting device on the façade of a mill. Usually sheltered by an extension of the roof called a “hood.”

Hood: The projecting part of a mill’s roof ridge used to shelter the hoisting mechanism. Sometimes called a cat’s head.

Hopper: The funnel-like, four-sided wooden chute that feeds grain to the eve of the millstone.

Horizontal mill: A tub mill, Greek Mill, Norse Mill, or Swede’s Mill in which a water wheel is parallel to the ground; the shaft is directly coupled to the upper millstone.

Hopperboy: An Oliver Evans device, a rotating rake that swept newly ground flour or meal around to allow it to cool, then swept it down a chute to a bin. Named for the live employee it replaced.

Hot blast: A forced-draft of preheated air fed into more advanced furnaces, first used in Scotland in 1828, first patented in Germany in 1832.

Hurst: A platform in a mill that contains the millstones, designed to isolate the vibrations from the rest of the building.

Husk frame: Same as “hurst.”

Ironmaster: The skilled manager of the entire iron plantation, not necessarily the owner, but a person of considerable rank.

Jenny: The 1764 invention of James Hargreaves that produced multiple (11) threads (suitable only for filling) in a spinning frame that used a moving carriage guided by a human operator. Ancestor of both the water frame and the mule. Its output was collected on bobbins. Supposedly named for Mrs. Hargreaves.

Kersey: Also called Maryland Kersey, a wool suit material. See cassinet.

Lantern gear: A squirrel cage gear or trundle formed of round wooden rods of broomstick thickness, designed to be propelled by large wooden teeth on another gear such as a wallower or master gear.

Lap: A broad flat blanket of loosely assembled cotton fiber, the output of a spreader. Served as input to the carding machine, either rolled on drums or sent directly by conveyor belts.

Lime: A tanyard vat for steeping hides in calcium hydroxide or other chemicals to loosen hair and fatty matter.

Liming: Removing hair from hides and plumping them for tanning.

Limonite: A brown or yellowish iron ore found near the surface, used in colonial furnaces; includes bog ores; the usual raw material of colonial era furnaces.

Linsey: Or linsey-woolsey, a coarse cloth with linen warp threads and wool filling. Often home-made and considered suitable for bumpkins.

Lint: Cotton fibers after their removal from the seed.

Lixivate: The process of using caustic chemicals (lixivium, made from coal ashes) to treat woolen cloth.

Merchant mill: A mill operated as a capitalistic enterprise where the miller buys entire grain crops from farmers to mill and sell to commission merchants and exporters.

Middlings: The partially ground matter after the first pass of wheat through the millstones or rollers. Same as “semolina,” i. e., “half milled.”

Middlings purifier: A sifting device to get more flour particles out of middlings. Used in the New Process and in the roller mill era.

Midget mill: A small unit that used steel rollers to grind flour; a product of the late 19th century.

Mill bill: Sharp edged, case hardened hammer used for sharpening the furrows in millstones.

Millpond: The impounded water behind a mill dam.

Millwright: A master builder capable of construction and repairing of mills and servicing the millstones.

Molinography: Writing about the subject of mills by a molinologist.

Mule: The massive, carriage-mounted, humanly pushed machine that intermittently drew out rovings and then wound up the spun fibers onto cops (or onto paper spools). Replaced by self-acting mules.

Muley saw: A water-powered sawmill with a straight, up-and-down blade set in a sash. A sash saw.

Negro cloth: Coarse hemp material with some wool or cotton content used to clothe slaves.

New Process: A system adopted in the 1870s to set the millstones slightly farther apart to grind for a maximum of middlings to regrind and re-sift at a second or third stage.

Norse mill: See horizontal mill.

Oil mill: An mill devoted to crushing vegetable oil from flax seed.

Operative: Archaic term for mill employees.

Osnaburg: Coarse, strong, plain woven cotton fabric, sometimes printed with stripes, used for bagging, sheeting, or work clothing; named for a German city.

Overshot wheel: A water wheel where the water is poured in at the top of the wheel.

Patent flour: An imprecise commercial term for flour made by improved methods of the later 19th century.

Pattern: A wooden form used to impress its shape into a sand mold which would then be filled with molten iron to solidify into the shape of the pattern. Used in the furnace casting house to make pots, stove plates, and plow parts.

Pattern: A full pattern or half pattern meant a standard mill design based on Thomas Ellicott's chapter in the 1795 Oliver Evans book.

Picker house or room: A building or room, usually sheathed in sheet iron on the inside walls, where the pickers of a woolen or cotton mill were isolated from the rest of the plant for fire safety.

Pig: A long bar of cast iron formed by pouring molten iron into rectangular molds formed in sand on the casting house floor. Pigs were not the final product but had to be reworked by further processing at a forge, a many-step, wasteful process.

Pitchback wheel: A wheel designed to turn in the direction opposite the direction of the flowing water, the water fed in near the top of the wheel.

Planing mill: A mill used for manufacturing finished lumber.

Plansifter: A late 19th century bolting apparatus invented in Budapest that sifted middlings by shaking the matter in a horizontal tray. It usually delivered its output through canvas tubes like fire hose material.

Post: An upright wooden member in the interior framing of a mill, usually separated from the overhead girts by a wooden bolster.

Post mill: A wooden windmill consisting of one room above and one below, the entire structure pivoted on a post and turned into the prevailing wind as necessary, steadied by its “tailpole.”

Power loom: Water or steam-driven weaving machine that produced cloth far faster than traditional hand and foot-powered looms. Its shuttle was propelled at high velocity by a “picker stick” or rocker arm.

Print works: A factory where white cloth was imprinted with colors by either hand-stamping on tables or by printing with rollers, especially to make calico, e. g., Rockland Print works in Baltimore County.

Privilege: A legal right to conduct a mill and back up pond water, usually secured by writs of condemnation or legally recorded agreements with neighbors.

Puddling furnace: A small, 19th century furnace designed to re-melt pig iron by an anthracite fire to convert it by stirring or puddling into wrought iron, thus eliminating the wasteful colonial stages of reworking pig iron in a finery and a chaffery.

Quern: Small, primitive, hand-powered mill with a large flat bottom stone and hand operated top stone. Very small output gained at great expenditure of energy.

Ravensduck: In America, a lighter grade of cotton sail cloth. Scottish flax sail-cloth had once been stenciled with a raven symbol. See also “Duck.”

Red Dog: Slang for a poor quality of flour.

Reduction: Also called gradual reduction, the process of making flour by several steps of grinding, sifting, and re-grinding, part of the New Process of the 1870s.

Riddle: A hand-held sifter.

Ring spinning: An improvement in winding the finished thread using a flanged metal ring rather than the wire flyer. Patented by John Thorp in 1828.

Roller: A steel roller with corrugations scribed on it to substitute for the furrows in a millstone. The key device of the Roller Process of the 1880s. The first rollers were porcelain.

Rolling and slitting mill: A water-powered works where bar iron strips were heated white hot and flattened by rollers and cut by mechanical shears into one-half-inch rods suitable for making hand-made nails. Nails had to be headed by hand, one at a time.

Roving: The stage before spinning which introduces a twist to the sliver. The intermediate product is called a roving. The process was carried out by a slubber or billy.

Run: A pair of millstones. A mill advertised with “two run of stones” would have four stones in all.

Runner: The upper millstone, the one that moves (as opposed to the bedder, which was bolted to the floor). A runner can be identified because it had a keyway in the center to mesh with the iron bracket or “cockeye” on the “spindle” that supported it from below.

Russia iron: Sheet iron with a smooth, glossy finish of protective oxide.

Salamander: An accretion of solidified iron stuck to the bottom of a furnace, so called for the salamander reptile that was supposed to be able to survive in fire. Hence the trade name of “Salamander Safe,” which was supposed to preserve business papers.

Satinet: Fabric made with cotton warp and woolen filling; fulled and finished like an all-wool cloth.

Sheave: Pronounced “shiv,” a pulley driven by belting.

Shed: The path produced by a lifting mechanism to provide a passage for the shuttle between every other row of warp threads. The shuttle inserted one row of filling through the shed on each pass from side to side.

Shipstuff: A low grade flour with unsifted bran that was suitable for baking into ship’s bread or biscuits for provisioning a sea voyage.

Shoddy: Recycled wool cloth (with a tendency to disintegrate while worn by its second owner).

Shorts: A type of middlings or a poor quality of flour.

Shuttle: The hard, wooden, bullet-shaped device with a built-in supply of thread that carries the filling back and forth through the warp within the loom.

Sliver: A soft untwisted rope of fibers produced by a carding machine by stretching out flat laps. Pronounced “sly-ver.”

Slubber: A water-powered intermediate spinning engine (also called a slubbing billy or a billy) developed from the earlier spinning jenny. The slubber stretched sliver into longer lengths before spinning the actual thread.

Smock Mill: The Dutch type of mill with tapering walls that suggested the body of a man wearing a smock or linen duster.

Slag: A waste product of smelting raked from the cinder hole. The best samples to be dug up at furnace sites have a glassy surface.

Smut: A disease that ruined wheat. A “smutter” was a separate item of machinery used to clean smut from wheat before grinding.

Sorting: A hand process wherein wool bales are opened and the fibers sorted according to the body area of the sheep, the quality and length of the fibers being different on the back, flanks, neck, etc.

Sow: The channel through which molten iron gushed from the furnace crucible to the parallel depressions in the casting house floor where the pigs were formed, once the iron cooled. The solidified sow could be broken up in several marketable lengths to ship with the pigs.

Speeder: One of the machines in the doubling process which combines slivers from several canisters into a single roving of cotton.

Spindle: The shaft that supports the upper (moving) millstone via an iron bracket.

Spinning frame: The machine that spins the final roving into yarn or thread. Same as a power frame. Outgrowth of the water frame.

Spreader: A device in the picking department that blew the picked fleece clean and produced a loose lap or blanket of cotton fibers about 2 feet wide; it wound the product onto drums or fed it directly to the carding engine on a conveyor belt.

Spur gear: A gear usually of wood with its teeth pointing out from the rim. It was usually possible to hammer on the teeth at their “roots” to push out the teeth just enough to compensate for wear on the outer diameter.

Swedes Iron: A high grade of wrought iron imported from Sweden.

Swedes mill: See horizontal mill.

Tailrace: The ditch or channel that drains away the used water from the wheel. It was undesirable to allow used water to pond up and slow the rotation of the wheel.

Tailpole: Usually a entire tree trunk used to steady a pivoting Post Mill or windmill. There was a wheel on the end near the ground to make it easy to turn the entire building into the prevailing wind. Also called “tail tree.”

Tanbark: Powdered oak or hemlock bark used in tanyard vats to cure leather.

Throstle: The final machine in the cotton spinning process which continuously drew out and twisted the rovings and collected the threads onto bobbins, which were neatly wound by the spinning of the flyer.

Ticking: A heavy striped cotton cloth suitable for mattress cloth.

Tide mill: A mill that trapped tidewater within a dam in an inlet or bay at high tide and used the accumulated water to pass back out into the estuary through the millwheel. Tide mills had to operate on a shifting schedule to take advantage of the high tide hour.

Tilt-hammer: Historically, tilt-hammers consisted of “an oscillating wooden beam pivoted at one end and carrying at the free end the upper half of a pair of dies, the lower half being carried to an anvil below. The beam is lifted by a rotating shaft carrying a series of cams, each of which raises the hammer and allows it to drop suddenly.” There are modern versions of this process.

Toll: The in-kind commission charged by a rural miller for grinding a farm family’s flour. The miller fed and fattened hogs on the toll or sold it to commission merchants.

Toll dish: A scoop the miller used to measure his share of “custom” ground flour or meal. Sometimes the miller got one-sixth of what passed through the stones.

Trundle: Same as lantern gear,

Tub mill: Same as horizontal mill.

Tumbling dam: A dam or weir designed to spill the surplus water outward to avoid scouring out its foundation. George Washington wrote about the tumbling dam at his mill at Mount Vernon. British usage is “tumbling weir.” It is usually a low dam or outfall from a canal, river, or reservoir. In 1820, Elkanah Watson, writing about the Erie Canal, defined it as a waste weir or tumbling dam about 5 feet high.

Turbine: A French invention of ca. 1848 in which the water entered a tube and passed through a finned spinning device inside an iron casing to produce useful energy. Later

manufactured at Poole & Hunt's foundry in Woodberry in Baltimore County (now Baltimore City).

Tuyre: The iron nozzle (about 4 feet long) inserted at the base of the iron furnace to feed in the iron blast. Pronounced "tweer."

Twill: Fabric woven with a diagonal rib or twill, a strong and durable material (such as green army fatigue jackets).

Undershot wheel: A wheel powered by water pushing it at or near the bottom. Used where there was not enough elevation of the terrain to run an overshot wheel.

Vat: The round wooden casing around the two millstones in a pair.

Wallower: The first gear in a windmill or water mill that is driven by the main axle.

Warp: The threads running lengthwise in cloth. The strands set up in the loom before activating the shuttle to fill in the crosswise threads.

Water frame: Richard Arkwright's 1768 cotton spinning machine that twisted, drew, and spun rovings and collected the threads on bobbins. Its inertia made water or steam power necessary. It led to the spinning frame or power frame.

Willow: One of the devices of a picker house which churned the loose cotton fleece and cleaned it of litter and dirt with an air blast. In India, the job had been done by willow wands.

Wing dam: A dam or obstruction built part way out in a river to channel water to a millrace. There were examples on the Monocacy River and the Potomac.

Wool sorters' disease: A form of pulmonary anthrax that once afflicted employees who graded wool by hand. The virus entered via breaks in the skin.

Worm: The copper coil in a rural whiskey distillery.

Worsted: Fabric made of woolen yarn combed straight and smooth while being woven. Distinct from "woolens" which are woven from yarns already roughed and crossed during previous carding and spinning steps.

Wormseed oil: A crop that was once cultivated in Frederick and Carroll Counties to distill for a medicinal oil. Fully treated in Carroll County chapter, s. v., "Wormseed Distillery Industry."

Writ of Condemnation: See *Ad Quod Damnum*.

Wrought iron: Pig iron that has been reworked (1) by a forge mill in the finery and chaffers of the colonial era, or, (2) by a 19th century paddling furnace, for processing

into workable into bars and plates. The crude bloomery process of colonial times produced about a bushel at a time of what was essentially wrought iron.

NOTE

The terms above list the vocabulary commonly found in advertising mills and encountered in historical sources. Much more detailed glossaries that include terms of art for building and maintaining mills are found in *The Mill at Philipsburg Manor Upper Mills and a Brief History of Milling* by Charles Howell and Allan Keller (Tarrytown, New York, 1977). See also D. W. Garber, *Waterwheels and Millstones: a History of Ohio Gristmills and Milling* (Columbus, Ohio, 1970). See also, Felicity L. Leung, *Grist and Flour Mills in Ontario* (Ottawa, Ontario, Canada, 1981). An excellent glossary prepared by Theodore R. Hazen is available on-line at <Pond Lilly Mill Restorations>. For iron works, see Robert B. Gordon, *American Iron 1607-1900* (Baltimore, 1996). For cloth manufacturing, see Phyllis G. Tortura and Robert S. Merkel, *Fairchild's Dictionary of Textiles*, 7th ed. (New York, 2000). Many terms in old advertisements and legal papers cannot be found in dictionaries. Many of the words in this list are rejected by the computer spell-check system.

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