

---

# The UNION STANDARD

---

Feb 2006

Vol. 14, no 2

## *The Newsletter of the 1<sup>st</sup> United States Infantry, The Regulars*

---

Typically, the commander's New Years "State of our Union" article summarizes the past year and 'drums up' the coming year's events. I'll do that only briefly before moving on.

But first, some schedule changes....Some of the events we voted for in January's drill tended to squeeze too many things into too short a time period, so we 'massaged' the schedule a little to solve that problem. We've switched the Apr 22-23 NCO School with the live fire, so plan to journey down to Ft Chadbourne that weekend and fire some lead. "The Old Forts & Missions for Restoration Assoc." group will be meeting at the fort on Sunday so we will be able to demo and maybe even let some of them fire a musket. The optional recruiting event at the Stockyards is still on Apr 29-30. The NCO School at Ft Richardson will now be on May 20<sup>th</sup>. (Don't let the NCO School name throw you, it's a scheduled unit drill for everyone, but will concentrate on NCO duties and drill.) The unit decided not to venture forth to a national event this year but instead we will concentrate on more local events and make this the 'recruiting year' to build back our strength to have a much better showing at the 2007 national event. Paul has a number of recruiting 'initiatives' up his sleeve that should make this effort successful.

2005: For the 1<sup>st</sup> US, manning Battery Robinette at Corinth was certainly an historical highlight. Falling in with the 9<sup>th</sup> TX at Ft Parker, Port Hudson, and Mill Creek Farm is always a pleasure and we are encouraged by the continuing bond between our two units. Mill Creek Farm and Jefferson were just

downright fun events. I won't go on about the other events, 13 on the list, other than some statistics, if anyone's interested: Our best attended, January drill at 27, followed by Muster and Corinth with 26, Jefferson with 25 and Mill Creek Farm with 22. As far as participation, Don Gross and Kevin have the highest number of events attended with 13 each, followed by Alan with 12, then Aaron, Paul and yours truly with 11. All in all a very successful year.

To me, this hobby is more about the people than anything else. As reenactors, I think we do a much better job recreating 'persona's' rather than recreating the



actual battles. At first, I thought about writing about some of our 'characters', but I would invariably miss someone or the article would have gone on for a dozen or more pages...good for Alan as he would not have to come up with other material, bad for the reader as it would get tiresome. Instead, I'll jot down some characteristics and let you figure out who it is! But first, let me say goodbye to some old friends. Mike Beard was posted back to HQ in Washington and the Nelson 'brothers' are off to defend the frontier in MN. You will be missed and we hope to see you in the future.

(Continued on Page 2)

---

### **Beaumont Ranch directions:**

**From Dallas** - head south on I-35E to Hwy. 67 and then head towards Cleburne. Exit south to I-35W in Alvarado and go south. Now follow the above directions below...

**From Ft. Worth**, - take I-35W south to Exit 15 (FM916 Maypearl). Go east 1½ mile to CR 202, turn right. Go 2/3 mile to CR 102, turn right, the ranch entrance is on the left.

# 1<sup>st</sup> U.S. Calendar

2006

## MARCH

4<sup>th</sup> - 5<sup>th</sup> Irish Festival, Fair Park Dallas  
17<sup>th</sup> - 19<sup>th</sup> **Beaumont Ranch**  
25<sup>th</sup> Camp Ford, Tyler Texas, Living History

## April

22<sup>nd</sup> **Live Fire – Fort Chadbourne**  
28<sup>th</sup> - 29<sup>th</sup> Fort Worth Stockyards – Frontier Forts  
Muster

## May

20<sup>th</sup> **NCO school Fort Richardson**

## June

3<sup>rd</sup> Drill (tbd)

## July

4<sup>th</sup> Old City Park , Dallas  
Living History/Recruiting  
(tbd) **Cartridge Rolling Party**

## August

(tbd) **Unit Social**

## September

22<sup>nd</sup> - 24<sup>th</sup> Battle of Atoka  
Atoka Oklahoma (Indian Territories)

## October

20<sup>th</sup> - 22<sup>nd</sup> Crockett Reenactment  
Crockett Texas

## November

11<sup>th</sup> Old City Park Dallas, or Veterans Day  
parade (tbd)

17<sup>th</sup> – 19<sup>th</sup> **Liendo Plantation**

Liendo Texas

## December

2-3 Prairie Grove – Prairie Grove Arkansas

*Note: **Bold** are scheduled maximum effort events.  
Italicized dates are available events or recruiting  
activities.*

(Continued from Page 1)

Music...now have we got music! Whether on the field with drum or bugle, there are not many units with as much talent. But then there's the camp music at night, vocal and (authentic) instrumental, can't be beat by anyone. We even have two blokes who know every word of every 70 verses of "It's A Hard Road to Richmond," to mention just one song in their repertoire. Food; no unit eats better,..... and for the most part, authentic, this side of the Mississippi. I'd match our guys with any unit on drill too, and we'd still beat 9 out'ta 10 units. catering to the reenactors' needs and Jefferson couldn't be beat with the street firing and maneuvering during each battle. One gent's planning even involves flight planning just to attend events! Our new and revised recruiting and mentoring depots are showing results, a new QM depot, and we have an updated handbook as well as an excellent website. We've got experts in rolling authentic cartridges, 'unleaded' as well as 'leaded,' as well as those who love to burn said powder. (The ATF been by yet Pete?) This year's new fish took right to drill, well, like fish to water. We got new officers and NCOs along with 'new' 1861 names and enlistment papers. We've tried a new way of running the organization too with me as the field commander and George as the NTRS president. (I gotta like that; George does all the work and I have all the fun!!) We got box makers, medal-takers, and belly-ache'rs; a few galvanizers and more than a few harmonizers. We got generals as well as ner-do-wells. We got McFuddy and we got 'the Beast.' We got guys who wear Hooter's T's as well as some who wear antlers or smurf hats. I could go on and on, but let me finish with this thought. I could 'retire' from reenacting and dearly miss it. The one thing I couldn't do is give up these characters. Every one keeps me coming back for more cold nights, sweating marches, hard ground and sore feet. Thank you all, you're the best and every one of you is a friend. Let's get together some more this year and enjoy it while it lasts, we're not getting any younger!! See ya at Beaumont Ranch.

Semper Primus,  
John  
aka Capt Geo A. Williams

## RECRUITING CORNER

You Are Our Best Hope

You're our best hope to grow the 1<sup>st</sup> US  
Infantry, the premier Federal REGULAR unit in Texas!

Here's why you should care that your unit grows:

(continued from Page 1)

(Actually, I'd bet we would beat 'em all with an hour's practice, but I don't want to appear too excited!)  
Planners and organizers....local or national level, our members know how to put on a good show. Franklin and Corinth were as good as it gets when it comes to it

- More members, when trained as Regulars, will help make you look better and make us more authentic when out in the field.
- More opportunity to meet new people who've got the same interests that you have.
- With just a little bit of enthusiasm, you can to turn around a friend/relative who seemingly would never consider reenacting.
- It's fun trying to get a new fish and watch him grow, and you can claim a very important contribution to the 1<sup>st</sup> US.

Rest assured that when you provide me with a contact, that the prospect will be aggressively pursued with polite encouragement. Efforts are under weigh now to ensure that when you recruit, your buddy will be well trained and well mentored. We are honing our process to ensure that recruiting – clothing & equipment lending – new join welcoming – and mentoring are an integral part of the front-end process of increasing the ranks of the 1<sup>st</sup> US Regular Infantry.

Materially, we got the goods and the opportunities this year to make this a most successful year. For most who made it to the drill in January, you have “our” business card, and while they're costly (\$.20/pop), they can sell the prospect you are recommending to join. While most of the material (1/2 sheet literature and business cards) will be used during recruiting events, please get with me at our next event or ask that some be dropped in the mail to you. You should have some of this material wherever you go.

Moreover, there will be a push after the battle of a reenactment to get into the crowd and ask them if they like it and encouraging them to consider the hobby and joining us.

Here are some of the recruiting events that you can plan and exploit:

- Irish Festival – 4-5 March – Fair Park, Dallas (See <http://www.ntif.org/>) Contact me if you're interested in ½ price tickets (\$7.50/day) for this and to help us out.
- Stockyards – May
- Old City Park – July & Nov

We've got an extremely exciting year ahead of us—so talk it up! ...Among relatives, friends, at church, and at civic organizations. After all, you ARE, after all, our best hope.

---

---

## Recruiting Regulations

Below are some interesting “Duties of Recruiting Officers” excerpts from the Revised Regulations for the Army of the United States, 1861. It is suggested that if anyone has grievances due to chief recruiter Paul Mattoon's supposedly underhanded or devious methods, that they then file a formal complaint with Capt. Williams (J. Bowen).

**926.** They will not allow any man to be deceived or inveighed into the service by false representations, but will in person explain the nature of the service, the length of the term, the pay, clothing, rations, and other allowances to which a soldier is entitled by law, to every man before he signs the enlistment. **(New Pvt. Gray, Zebian, Sickler & Noyes are reportedly soon expecting their first year, seven-week paid vacation.)**

**927.** If minor's present themselves, they are to be treated with great candor; the names and residences of their parents or guardians, if they have any, must be ascertained, and these will be informed of the minor's wish to enlist, that they may make their objections or give their consent. **(The orphanage signature for Pvt. Don Gross is supposedly forged.)**

**929.** Any free white male person above the age of eighteen and under thirty-five years, being at least five feet inches high, effective, able-bodied, sober **(how did McFuddy/McFarlane get in?)**, free from disease, of good character and habits, and with a competent knowledge of the English language, may be enlisted. This regulation, so far as respects the *height* and *age* of the recruit, shall not extend to musicians or to soldiers who may “*re-enlist*,” or have served honestly and faithfully a previous enlistment in the army.

**931.** No person under the age of twenty-one years is to be enlisted or re-enlisted without the written consent of his parent, guardian, or master. The recruiting officers must be very particular in ascertaining the true age of the recruit. **(So how did Pvt. Ogle get into this Army?)**

**938.** Recruiting officers will not employ private physicians without authority from the Adjutant-General's Office, for the special purpose of examining the recruits prior to their enlisting. **(Rumor has it Mattoon hired stockyard meat cutters to perform medical examinations.)**

**947.** Before recruits are sent from recruiting depots to regiments or companies, the amounts due by them to the laundress **(Miss Julie)** and sutler **(Miss Tula, well sorta)** having been verified and audited, will be entered on a roll made for the purpose, and will be paid by the

paymaster on his next visit at the post, the receipts of the laundress and sutler to the amounts paid being the voucher: Provided the recruits have a clear amount of pay due them, over and above their dues to the government, equal to the claims of the laundress and sutler....

---

## The Polite Society

Since the First U.S. just finished garrisoning Ft. Washita on February 11<sup>th</sup> of this year implies we might have had occasion to take food with or in front of the Officers' wives and/or other ladies in attendance. (*but since the editor didn't get the paper out BEFORE we went....it's all lost except for next time eh?*) All 1860's military personnel should exercise great care to employ exemplary table manners when in the presence of the more gentle sex. So, to better perfect your tableside mannerisms the following should serve as a guideline:

Nothing indicates the good breeding of a gentleman so much as his manners at table. There are a thousand little points to be observed, which, although not absolutely necessary, distinctly stamp the refined and well-bred man.

Any unpleasant peculiarity, abruptness, or coarseness of manners, is especially offensive at table. People are more easily disgusted at that time than at any other. All such acts as leaning over on one side in your chair or seat, placing your elbows on the table, ... gaping, twisting about restlessly in your seat, are to be avoided as heresies of the most infidel stamp at table.

Never *use your knife to convey* food to your mouth, *under any circumstances*; it is unnecessary, and glaringly vulgar.

Gentlemen should never wear gloves at table, unless their hands, from some cause, are not fit to be seen.

Making a noise in chewing your food, or breathing hard in eating, are unseemly habits, which will be sure to get you a bad name at table, among people of good-breeding.

Avoid picking your teeth, if possible, at table for however agreeable such a practice might be to yourself, it may be offensive to others. The habit which some have of holding one hand over the mouth, does not avoid the vulgarity of teeth-picking at table.

Never commit the vulgarity of speaking when you have any food in your mouth.

It is considered vulgar to dip a piece of bread into the preserves or gravy upon your plate and then bite it. If you desire to eat them together, it is much better to break the bread in small pieces, and convey these to your mouth with your fork.

Avoid putting bones, or the seeds of fruit upon your table-cloth. Rather place them upon the edge of your plate.

When you wish to help yourself to butter, salt, or sugar, use the butter-knife, salt-spoon and sugar-tongs; to use your own knife, spoon, fingers evinces great ignorance and ill-breeding.

- Taken from Civil War Era Etiquette: Martine's Handbook & Vulgarisms in Conversation, "Habits At Table" chapter.

---

## Beaumont Ranch Reenactment

March 18-19

Spread the word to your family, friends and neighbors that the only 2006 metroplex reenactment will be at Beaumont Ranch on March 18&19. The site is located about 30 miles south of Ft. Worth. View the ranch web site for more info and look at the Events section - [www.beaumont ranch.com/events](http://www.beaumont ranch.com/events). Contact Paul Mattoon if you wish to help recruit and George Hansen if you want to perform living history.

---

### FACES YOU SHOULD RECOGNIZE



# Colonel Carlos A. Waite Commander 1<sup>st</sup> U.S. Infantry Texas 1861

---

## Bit's and Pieces

### Old Regular Army

Over the years in the hobby we always pick up new information, sometimes information that isn't "new" just information *we* didn't know. It trickles in from outside units, as an example, our former method of always going from Right Shoulder Shift to Shoulder Arms when we "went into line" after we've heard a "By Company into Line" command. Turns out you only auto shoulder if you halt. This we learned from a Sykes Regular at Franklin (I think) who wondered what in hell we were doing going to the shoulder automatically without so much as a 'by your leave' to our officers when we formed a line of battle but didn't come to the halt.

Other information trickles in from, well, ourselves, as we read and learn more on our own. A discussion that came up recently highlighted the unit composition of Regular Army regiments with regards to company strength, (and hence regimental strength). For a long time I can recall being told that our companies were nominally rated at 100 men & officers per company for the Regular Army regiments. While that number is technically true, it doesn't actually apply to "our" adopted impression because we're "Old Regular Army" as opposed to "New Regular Army". I wasn't even aware that there were two structures of course, but reading "That Body of Brave men, the U.S. Regular Infantry and the Civil War in the West" by Mark W. Johnson provided unexpected information. It also provides a nice read on what happened to one of "our" officers – Captain Stephen D. Carpenter – but that's for another time I think.

From the book we learn that in the first half of the year of 1861 while "we" were evacuating Texas they were planning on expanding the Army back in Washington City. They decided to increase the strength of the Regular Army by about 23,000 men, to be formed into 8 new Infantry regiments (the 11<sup>th</sup> through the 18<sup>th</sup>) one new Artillery (The 5<sup>th</sup>) and one new Cavalry (*why bother? When was the last time you saw a dead cavalryman?...oh, sorry....*) (the 3<sup>rd</sup>).

These would be called the "New Army". That leaves us (1<sup>st</sup> through 10<sup>th</sup> Infantry regiments) in the "Old Army". The structure of the regiments for the New Army would be very different from those of the old. Here is where the number of 100 officers & men appears, it's the company strength for NEW regiments

based on the latest French regiments that were so much admired for their successes in the (in our period vein, *recent*) Crimean War (1853-1856).

The old regiment structure was based on the British military structure of companies that consisted of only 89 officers and men. There were 10 companies in an Old Army regiment, giving the regiment a total theoretical fighting strength of 890 men – to this you add the band, staff, etc, which works out to 978 men in the regiment (and this could be the source of the 100 man companies we used to speak of – @1000 men/10 companies, logically, but incorrectly equaling 100 man companies.) As we know with sickness, retirement, enlistment term completion, it's unlikely a regiment (New or Old) ever took the field with their full 'paper' compliment.

The New Army regiments were vastly different. They would consist of 3 Battalions, of 8 companies each, with 100 men and officers per company. Their full authorized strength would be 2,444 men, roughly 2 and a half times the size of an Old Army Regiment! The battalion structure would also be different in that only 2 of the 3 battalions were ever expected to be "in the field". It is interesting to note that a New Army *Battalion* is roughly the same, strength wise, as an Old Army *Regiment*. The 3<sup>rd</sup> battalion was purely a recruiting/depot battalion that was responsible for recruiting, training and forwarding of needed replacements to the two field battalions.

The personnel structure for an Old Army regiment is supposed to be - Regimental headquarters consisting of a colonel, lieutenant colonel, major, adjutant, quartermaster, surgeon (with rank of major), two assistant surgeons, a chaplain, sergeant major, quartermaster sergeant, commissary sergeant, hospital steward, and two principal musicians. 10 companies of infantry, each company staffed by a captain, a first lieutenant, a second lieutenant, a first sergeant, four sergeants, eight corporals, two musicians, and one wagoner. And of course the regiment is authorized to have a Band, and officer to lead it.

If you read last month's issue (*filler he means...*) you may have noted that at Little Egypt, Company A, 1<sup>st</sup> US only had 60 men and 2 officers present for duty during Mansfield's post inspection of 1860. That's about 80% of their total paper strength, if we assume that the return is not referring to the wagoner, or the musicians, or the 1<sup>st</sup> sgt as 'enlisted men'.

As for the volunteers - The Federal War Department established a volunteer infantry regimental organization with a strength that could range from 866 to 1,046 (varying in authorized strength by up to 180 infantry privates).

---

---

---

---

## Lessons from Lincoln

*“When he was in Richmond after it came into the possession of the Union forces, he looked for the home of George Pickett. “Is this where George Pickett lives?” he asked of a woman with a baby in her arms who answered his summons. She said she was Mrs. Pickett. Then he told her who he was, insisting that he came not as President, but simply “Abraham Lincoln, George’s old friend.” He took the little one in his arms, and thus did this noble conqueror restore the Union in one heart. He had known Pickett in Illinois and he obtained for him his appointment at West Point.*“

Not to rake muck, but as long as we’re getting facts straight, the above is a Civil War myth which was debunked recently in the August 2005 issue of Civil War Times. In actual fact it is more likely it was an outright creation by George Pickett’s wife, Sallie Pickett, after George’s death in 1875.

Robert F. Selcer, the author of the Civil War Times, and Pickett biographer, does allow that it was possible that Lincoln and a very young George Pickett may have crossed paths in Springfield Illinois, but points out that Lincoln was hardly in a position at that time in his life to have had any effect on the appointment process. For although he later became partners with John Stuart, the man who did secure the nomination, he was not yet at the time of Pickett’s visit to Springfield, and was certainly not capable of influencing an appointment itself. Virtually all the evidence presented for this link between Lincoln and Pickett’s appointment was provided (dare I say, “constructed”) by Sallie Pickett. Sallie spent a good deal of time marketing the story in articles for various publications and during her tours on the lecture circuit after George died.

Perhaps out of courtesy to an old woman, who died herself in 1931, there was little debunking of the myth of the much beloved Lincoln having a strong affection for a man who’s sympathies lay with the South, and who led probably the single most historic charge of the Civil War where the turning point of the war was thought by many to have been reached (personally I think Vicksburg helped, but there certainly wasn’t as much ‘glory’ in it. A siege just never seems as glorious as two armies facing each other on the open field). It certainly destroyed the myth of an unbeatable Army of Northern Virginia once and for all.

The additional aspect of Lincoln’s visit to Richmond was thrown in to provide as happy ending to a tale as

possible considering the circumstances. Lincoln probably would have let the institution of slavery remain in the States that ultimately seceded had they remained in the Union, in order to avoid the war, and he was known for his ‘forgiving’ nature, so while the story seems plausible (recall the story about his having the band play “Dixie” at the end of the war) it is almost certainly all myth.

---

---

Courtesy of Glen Haris – things worth the read!

### The Enfield Rifle

CHAMBERS'S JOURNAL, 16 APRIL 1859

In ancient times, when the bow was the weapon used by nearly every nation, the strength, as well as the skill of the archer, was a matter of the greatest importance. Kingdoms, we are told, were sometimes allotted to that son who could draw to the full extent the bow of his father.

When we observe, even in the present age of rapid progress, the difficulty that there is to make individuals move in any but old grooves, it is not surprising that there was a great struggle before the first rude firearms were preferred to the bow and arrow as weapons of war. With the latter, men were well acquainted, and were able to use them with great skill; the former were rough in construction, and the bow-men naturally looked upon them with contempt.

It is surprising, until within the last few years, how little alteration or improvement was made in the firearms used by the army. Old systems, and the non-expansive natures of those in authority, naturally retarded progress. Many of us may remember the prejudice which existed against the introduction of the Minié rifle, and the partiality which was shewn to Brown Bess. 'It did its work in the Peninsula, and you had better not make any change,' was the remark of many a veteran warrior. Brown Bess is now amongst the things which were, but are not; whilst its successor, the Minié, has also had to haul down its colours to the infallible Enfield Rifle, which may be said to wear at present the champion's belt. How long it will be before the day of the Enfield rifle is past, and 'breech-loaders' usurp its place, is amongst the mysteries of the future.

It is our present business to describe some of the wonders connected with the construction of the Enfield

rifle; and we will now ask the reader to accompany us from London to the Enfield factory.

Twelve miles from the Shoreditch station of the Eastern Counties Railway, we reach a dreary-looking station, entitled 'Ordnance Factory.' Quitting the train, and crossing the rails, we at once find ourselves in a muddy lane, on each side of which are flat meadows, separated from each other by four feet wide ditches. Here the tadpoles are sentimentally reposing at the bottom of the water, as though reflecting upon that vicious state of society which requires fifteen hundred rifles to be turned out per week from the smoky buildings in that peaceful locality. A quarter of a mile of muddy lane, three hundred yards of wooden footpath, a quarter of a mile of canal bank, and we cross the bridge which leads to the Ordnance Factory, Enfield.

Producing our credentials, we are at once handed over to a major-domo, who conducts us into a vast room filled with machinery. Through this we pass, and enter a smithy, where we are introduced to the principal, who is instructed to shew us all in his department, to pass us on to the next superintendent and so on through the various branches.

'And what do you call the various branches?' we naturally ask.

'There is the Bayonet, the Ramrod, the Lock, the Stock, the Furniture - that is, the brass-fittings, &c - and the Barrel.'

'And how many processes does each pass through?'

'The bayonet, about forty-eight; the ramrod, about thirty; the lock, about two hundred and twenty; the stock, twenty-four; the barrel, sixty-six.'

'Of how many parts is the Enfield rifle composed?'

'Of fifty-six.'

Three or four days at least would be required to examine thoroughly the machines and their results.

The bayonet first arrests attention; and we observe a stout little cylindrical chunk of iron, about four inches in length, which we are told is the first state of the bayonet. This is merely the iron, which is supplied from Sheffield, and which is to be educated into the deadly weapon, for the use of which the English soldier has ever been famous.

Heating and hammering are the earliest ordeals to which the bayonet is subjected. Heavy hammers, swung in circles by strong arms, descend with unerring precision on the required spot. One man, with a pair of iron fingers, holds and turns the metal, while the other

knocks it about. To a nervous bystander; this process is very trying; for he who holds will certainly receive the blow of the hammer on the centre of his forehead, if he does not move his head just one inch and three-fourths. The hammer approaches; the man bends back only just in time, and only just the required distance. Again he is in danger - again he escapes; and thus he has gone on, blow after blow, day after day, month after month. Talk about confidence in princes, let us see on earth more confidence than this holder places in his hammerer. We are, however, convinced that sooner or later the final catastrophe must come, and the blacksmith will be killed by his partner. It was here that we saw the water-gauge, by which the amount of iron requisite to form a bayonet is accurately tested - a tube containing a given quantity of water; into which the iron is thrust. When the water reaches the top of the gauge, the correct quantity of iron has been inserted. However irregular the iron may be in form, the right amount is sure to be thus obtained.

Our attention is now called to a curious machine behind us. This looks like some nervous infuriated monster mouth, which is armed with a row of grinders. The creature is evidently in a rabid state, for the grinders are being gnashed together with fearful rapidity, while the water runs over them. A smith boldly approaches this, holding in his hand a red-hot bar of iron, which he places between the grinders. Delight at once seizes them, for they move more rapidly than before; and instantly the bar of iron is chawed out a couple of inches longer.

The bar is then inserted in a fresh place, is again lengthened, and so on until we are shewn a stick of iron not at all unlike a bayonet. A most formidable individual then measures and inspects, gauges and tests, this piece of iron; length, breadth, weight, and colour are examined.

Should the bit be below or above gauge, below or above par, 'mulct so much' is the fate of the last workman. Each man thus has his responsibility, from which there is no escape, and for which there is the simple remedy, 'a fine.'

The finishing-room is entered from the smithy, and is about two hundred feet square. Wheels and men, cranks and levers, leather bands and iron, are moving apparently in the greatest confusion, but yet all is regulated with the accuracy of clock-work.

At one end of the room are a set of offices, in which the foremen carry on their duties. In front of these, and commanded by them, are avenues, down which the raw unfinished work is conveyed. Passing from hand to hand, from machine to machine, the bayonet, ramrod, or lock starts 'in the rough,' and returns complete, tested

as it travels between one machine and its neighbour, and again as it arrives at its destination.

Improvements are frequently being made in the various machinery, by which expensive hand-labour is saved. By means of a huge iron stamping-hammer; £1500 a year has been saved in the formation of the exterior of the lock. The filing of the trigger-guard by machinery has saved five guineas a week. If this rate of saving be continued, the Enfield rifle may soon be made for a very trifling sum.

The machine called the copying-machine is extensively used at Enfield; this was invented by an Englishman some years ago(\*), for the purpose of copying the fine lines of statuary. The Americans were the first who employed it to the purpose of gun-making. It is simply that one instrument moves round an iron model, whilst another moves in exactly a similar manner over the iron or wood which is to be cut. Thus perfect similarity of form is obtained, and a particular part of one lock will fit into the similar part of any other which has been made at this manufactory.

Arrangements are made so that the portion of work which may require the greatest time may be given the greatest number of machines or workmen. Thus each portion is finished at exactly the same time, and is brought to the workman who puts them together.

The execution of the wood-work is even more wonderful than that of the iron, not that the machines are more ingenious, but the results appear more magical, on account of the rapidity with which they are obtained. During the examination of the construction of the lock, we have gradually arrived at the conclusion that the teaching of our early youth as regards the hardness of metals must have been very false. We were formerly impressed with a belief that iron and brass were hard; this we now find was entirely a delusion. There goes a piece of brass into a machine, down comes a spike and bores a hole through it as calmly as though the brass were butter. There is another bit having bristles shaved off it far more readily than we can shave off our own bristles on a frosty morning. Here are iron, steel, and brass, in the shape of lock plates, triggers, tumblers, bridles, cocks, sight-leaves, and swivels, being stamped and cut, and scraped as though they were bits of cream-cheese. Quite a popular error it must be to consider that iron is hard - apparently nothing can be softer. So lifelike do the machines appear; and so automatically do they do their work, that we feel as the man Friday must have done when he asked the gun not to kill him; if the opportunity offered, we should much like to have a quiet talk with some of those wise machines. With these ideas we enter the stock-making department, and there we find three

machines on which is stamped 'Ames, Massachusetts' - thus shewing that our cousins across the Atlantic have contributed their share to the works at Enfield. From Italy, Belgium, and France, the walnut-wood is sent to Enfield in the rough, just outlined in the proper form, and ready to be handled by these machines. The first machine saws off pieces, and rounds ends and sides, pushing the stock away when the work is finished. The second rounds the ends from the muzzle-end half-way down to the stock; this is done on the copying principle. The third finishes what the second left undone, and these three machines leave very little to be done by hand as regards form. The excavations for the bedding of the lock and other parts are accomplished in a few minutes at separate machines.

The first state of the barrel is that of a slab of iron which weighs 10 1/4 pounds. This is welded and finished in a building separated from the main building. The first process causes this plate or slab to become a tube; it is then drawn out to the required length, the bore being kept hollow by means of a rod of iron; the breech-piece is welded on by means of a nervously excitable steam-hammer, which strikes a series of blows with uncommon rapidity. The boring is then proceeded with, many and various instruments being used. The outside is next turned, and any extra parts are taken off. The viewing then takes place. This is performed by a skilful workman, who places himself opposite a gas-lamp, or where there is a great light. To this he directs the barrel, so as to bring the light down the bore; he then slowly turns the tube, and is thus enabled at once to detect the slightest deviation from a straight line. Should any irregularities be discovered, the viewer taps the barrel with a hammer until the tube is perfectly true. The rifling of the barrel is then proceeded with. The proving is not the least important part of the process, although it is one which requires the least skill. The barrels are proved in a small room apart from the other buildings. The barrels, before being browned, are laid into stocks fitted for the purpose, and charged with 7 1/2 drams of powder and a bullet; the door of the room is closed, and the barrels are discharged by means of strings which are fastened to the triggers, and which can be pulled from the outside of the wall. Four drams are then discharged as before, and the barrels which have stood these proofs are considered sound. Sometimes there appears a flaw in the barrel, and then powder is added and charges fired, until the barrel is burst. We were informed that such a case had occurred some weeks previous to our visit, and it was not until 20 drams of powder had been used several times, that the desired result was obtained. Our informer stated that he had even then his doubts

whether the bursting was not caused in consequence of the bullet not being quite rammed home.

The browning of the barrel is a very delicate operation, and one which must be very trying to at least one of the individuals concerned, for in a room in which the thermometer must stand at about 140 degrees, a man remains upwards of twenty minutes to superintend the drying. Here it is that the mechanic is at last affected by external circumstances. The state of the weather is, in the browning, an important matter. If it should be wet, not more than half as much work can be accomplished as though it were dry. Flaws are more likely to occur during wet than during fine dry weather, and for every flaw, somebody has to be mulcted, for all is contract-work. A very small speck upon a barrel had been detected by the sharp eyes of an the examiner; a chalk-mark against it shewed that this would not be allowed to pass; and twopence-halfpenny was the loss which the man who had imperfectly done his work would suffer for this one flaw.

Upon the ringing of a bell, from twelve to fourteen hundred men and boys turn out in the open air; they fill to the ceiling the half-dozen public houses which possess a monopoly here. Crammed in rooms, seated on benches outside, on gates, rails, &c, these fourteen hundred mechanics take their rough and ready meal. Vainly do a sturdy bar-man and his three assistants attempt, by unexampled activity, to supply the demand for 'pots of arf and arf.' Time is short; in one hour must all these thirsty Vulcans supply their dried-up juices; and around the bar, from pigeon-holes of near and far, or even outside, there is a continual cry for varieties of malt. Even the throats of these men are but mortal, and at length they cry enough; and about a quarter of an hour before the period of feeding expires, a partial silence ensues, whilst the fumes of a thousand pipes are wafted over the marshes. A bell rings, and again are the 'publics' deserted, whilst footsteps alone tell of the recent crowd - the bar-keeper having, however, a substantial memento of the recent visit.

The weapon that is at length turned out is, with its bayonet, 6 feet 1/2 inch long, and weighs 9 pounds 8 ounces. The length of the barrel is 3 feet 3 inches; its weight is 4 pounds 2 ounces; and the diameter of the bore is .577 inch. The bullet is elongated, and takes three-quarters of a turn whilst in the barrel. The general figure of the bullet is cylindrical, its a front-end rounded, and its rear-end has a conical shaped cavity formed in it. The delay which was so great a drawback when the old rifle was required to be used, is now entirely done away with. The wooden plug which is now placed in the bullet instead of the iron cup, greatly diminishes the fouling. The diameter of the bullet is .568 inch; length, 1.0625; and weight, 530 grains. The

service-charge of the rifle is 2 1/2 drams, and the weight of sixty rounds of ammunition, including 75 caps, is 5 pounds 8 ounces. The rifle is sighted up to 900 yards, but its practice is good at much longer ranges. A bullet, when fired from a distance of 100 yards, would pass through twelve half-inch planks. The advance which had been made in rifled firearms placed the artillery for a time at a disadvantage; but the recent invention of Sir W. Armstrong will now place matters upon a different footing. Before any more inventions are made with either weapon, it will be necessary to fix upon the guns small telescopes, to enable the gunners to distinguish friends from enemies, before destruction is dealt out. With the aid of the Enfield rifle and the Armstrong gun, we may fairly expect to hold our own against any or all our enemies, provided that our rulers will take care neither to be caught napping nor to be lulled by false ideas of security. If England will be true to herself, she need fear no foe.

(\*) Joe Bilby of 'Civil War Guns' writes:

"The stock making machine referred to as invented by an Englishman was actually the 'Blanchard lathe' invented by an American, who was, I believe, an employee of Springfield Armory. Springfield was a pioneer of interchangeable parts for guns, although they didn't get it perfect until 1840, and Colt followed the Armory's path. Enfield and then the London Armory company followed suit in the late 1850s, after sending a team over to observe Springfield and other arms makers in the Connecticut Valley and buy equipment - hence the 'Ames' machinery found by the writer."

---

## **For Sale:**

The 1<sup>st</sup> has purchased powder and contact John Bowen if you need some –

[jbowlstus@comcast.net](mailto:jbowlstus@comcast.net)

## **E- Mail/Mailing submissions to The Union Standard**

– [d1stus@gte.net](mailto:d1stus@gte.net) or C/O Alan Prendergast, 1403 Barclay Drive, Carrollton Texas, 75007

### **Newsletter –**

contact George Hansen if you did not receive your mailed newsletter, [beast1st@comcast.net](mailto:beast1st@comcast.net) or (972) 529-5349.

### **Address/Telephone changes –**

any mailing/e-mail address changes or telephone number changes should be submitted to Blair Rudy, [brsuv1@verizon.net](mailto:brsuv1@verizon.net) - or 817-424-0027

**2006  
March**

**4<sup>th</sup> & 5<sup>th</sup> - Irish Festival, Fair Park Dallas**

**17<sup>th</sup>-19<sup>th</sup> Beaumont Ranch**

**25<sup>th</sup> Camp Ford, Tyler Texas, Living History**

**FRAZER BROTHERS**  
**The Official Sutler of the**

**1st U.S. Infantry**

**More Information at:**

**(214) 696-1865, or**

<http://www.frazerbrothers.com/>

**The Union Standard**

*Newsletter of the 1<sup>st</sup> U.S. Infantry*

1403 Barclay Drive

Carrollton Texas, 75007