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Glass*

Festival

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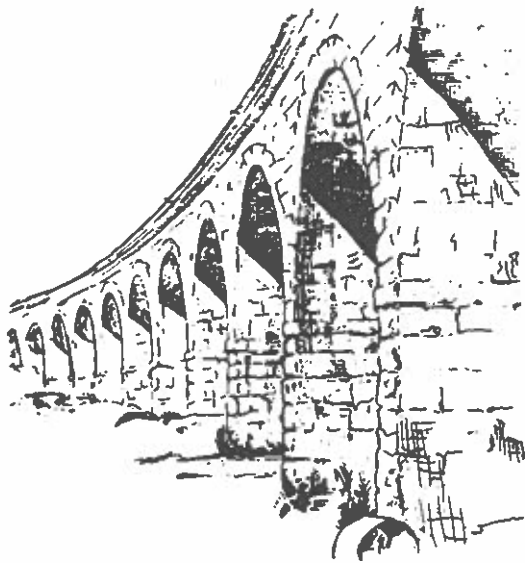


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**Visit the Museum: May thru Sept.
Tues., Wed. and Thurs. - 1 P.M. to 4 P.M.
Friday, Saturday & Sunday 1 P.M. to 5 P.M.**

Evenings by appointment only

FORWORD

The Glass Festival Committee is enthused about the prospects of the Festival this year in the City Park area. We are also excited about the 1976 Bi-Centennial and have already began planning for it. With the continued support of the citizens of Bellaire and the surrounding communities, the Committee feels certain we can attain our eventual goal of a permanent home for the Bellaire Glass and Artifact Museum.

The Museum has had a very successful year, and the entire community should be grateful for the fine work the volunteers have done. The entire staff of the Museum is volunteer, and their efforts have been tireless. I'm sure you all join me in a heartfelt "Thank You".

GLASS FESTIVAL COMMITTEE

1975 ALL AMERICAN GLASS FESTIVAL

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ED JOHN
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GLASS INDUSTRY

Bob Wheeler
Lucile Kennedy
Frank Villani

GLASS FESTIVAL SCHEDULE

SUNDAY, JULY 28	7:00 p.m.	Parade
MONDAY, JULY 29	7:00 p.m.	Concert Choir
TUESDAY, JULY 30	6:30 p.m.	Orchestra Concert AMERICAN FEDERATION OF MUSICIANS
WEDNESDAY, JULY 31	6:30 p.m.	Talent Show
THURSDAY, AUGUST 1	7:00 p.m.	Bob Gallion and Patti Powell Show
FRIDAY, AUGUST 2	2:00 p.m. to 7 p.m.	Slim Lehart and Silly Willy Show
	10:00 a.m. to Dark	Flea Market
SATURDAY, AUGUST 3	2:00 p.m. to 7 p.m.	Kenny Biggs and Jackie Smith Show
	1:00 p.m. to Dark	Flea Market

NOTES: The parade will take place in downtown Bellaire, terminating at the City Park.

All other activities except the Flea Market will take place at the City Park, North Bellaire.
The flea market will be set up in the Bellaire High School Cafeteria, adjacent to the City Park.

OTHER ACTIVITIES SCHEDULED ALL WEEK

28 - AUGUST 3	1:00 - 5:00 p.m.	Glass Museum, 49th & Jefferson St.
28 - AUGUST 1	6:00 to Closing	Local Booths and Carnival
28 - AUGUST 2	9:00 a.m. - 5:00 p.m.	Imperial Glass Hay Shed and Gift Shop
28 - AUGUST 3	1:00 to Closing	Local Booths and Carnival
28 - AUGUST 1	12:00 noon - 5:00 p.m.	Imperial Glass Hay Shed and Gift Shop
28 - AUGUST 1	9:00 a.m. - 10:00 a.m. 12:00 noon - 1:00 p.m. 2:00 p.m.	Plant Tours

Music is provided by the American Federation of Musicians through a grant from the Recording Industries arranged in cooperation with the A.F.M. Local No. 142, Wheeling, W. Va.

GLASSMAKING — It's History

The story of glass is so old it has no beginning. Its origins are lost in the mists of time and legend. Glass-making was discovered by accident in the Near East about 5,000 years before Christ. The earliest wholly glass objects are beads from Egypt dated c2500 B.C. The first glass vessels were manufactured in the reign of Amenhotep II (1448-1420 B.C.).

In the Sixth Century glass began to appear in quantity in Greece, Sicily, and Italy. With the spread of the Roman Empire, glassmaking spread from Italy north over Europe.

Glassmaking in America began at Jamestown, Virginia, in 1608. Indeed, it probably was America's first industry, for a glass factory was operating just a little more than a year after the first colonists arrived in the New World. This first venture likely came to a close about the fall of 1609, for then came the 'starving time' which all but 60 of the 500 inhabitants of Jamestown died. Relief came to the colony in the spring of 1610 but there is no evidence that the glass factory was revived at that time. Later attempts to begin a glass industry at Jamestown were failures.

It was two hundred years before the development of the glass industry began in the Wheeling area. The first glass house was built in Wheeling in 1819, but by 1835 *Martin's Gazetteer of Virginia* lists 5 glasshouses and glass-cutting works in Wheeling. Soon many small glass factories sprang up in the Ohio Valley. One of the greatest expenses of making glass is the fuel to furnish the heat to melt the raw materials. The glass industry in the Middle West because abundant coal, natural gas and fuel oil are found here. Ohio has, in addition, deposits of silica sand of good quality.

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GLASSMAKING — It's History

The **Bellaire Tribune** of 1884 lists the manufacture of glassware as this town's leading industry, its nickname, 'glass city'. The number of glass houses in Bellaire has varied over the years. In the 1880's glass factories operating were small, hand factories, usually with only one furnace capacity, employing 100 workers and reporting a weekly payroll of approximately \$1,000.00, or an annual payroll of \$50,000.00 for all the factories combined.

Today only three companies remain, of which only two are manufacturers, the third a decorating firm. The **Crystal Glass Cooperation** and the **Rodefer Gleason Corporation** together employ about 540 workers and report an annual payroll of nearly 3½ million dollars.

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THE GLASS FACTORIES OF BELLAIRE

The earliest glassworks established in the city of Bellaire was the BELMONT FLINT GLASS WORKS located at 34th & Hamilton Streets (The site of the present Kroger store) this factory was listed as organized by McKelvey but a more reliable date would seem to be 1866, as cited in *The History of the Upper Merger*, v2, published by Brant & Fuller in 1890. It was incorporated in 1869 as Barnes, Faupel & Co. The works closed about had more than 150 workers making tableware, lamps, goblets and bar goods. The works closed

Other glass houses which have operated in Bellaire are given here in alphabetical order with as much information as can be verified about them:

AETNA GLASS MANUFACTURING COMPANY. This was organized in 1879-1880. The factory was located at 25th Street, east of Union, of the river bank. R. T. DeVries was the first President, with C. H. St. John as President, and E. Bowie, Secretary.

This firm did foundry work and machine work as well as glass manufacture. This firm was the first to do really quality tableware, or fine cut and etched glass. The firm discontinued operations in 1928 and leased their furnace to the Bellaire Bottle Company.

THE BELLAIRE BOTTLE COMPANY operated from 1881 to 1928. Located behind the railroad tracks between Central Avenue and Monroe Streets, this company manufactured a wide variety of bottles, all kinds of glass. An undated catalog owned by Mr. Robert Johnston of Bellaire shows a complete line of medicine bottles, nursing bottles, ink, catsup and soda bottles, mustard and pepper jars, pomade and talcum pots, cream bottles, glass packers, decanters, ointment jars, opal boxes, Brandy, Whiskey, Cordial, Bourbon and ginger-ale bottles plus flasks for cologne and perfume, both glass and cork-stoppered.

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This company was driven out of business by the mechanization of bottle manufacture. It was Mi
ns, a glassworker of this area, who invented the automatic bottle-making machinery which revoluc
idutry in a period of about fifteen years. Owens patented his machine in 1903 while in Toledo, Ohio.

THE BELLAIRE GOBLET WORKS was organized in 1876, with W. B. Gorby, President, E. G. Mo
etary. In 1878 this factory leased the Ohio Glass Works, at 17th & Belmont Streets, which they later
ed. In 1886 it removed to Findlay, Ohio, and the works was occupied by the Lantern Globe Company
was merged with the United States Glass Company in 1891 and moved to Tiffin, Ohio. This fa
uced pressed goblets, all stem ware, in many patterns, not all of which were exclusive to their fac
s novelties were also manufactured, as was bar glassware.

THE BELLAIRE TUMBLER COMPANY operated at 28th & Water Streets. This com
manufactured glass between 1915 and 1938. In the final years of operation only decorating was done. About
omatic press was installed for making pressed items such as ash trays, small dishes, and dri
es. The company's labor force consisted of from 30 to 50 workers. Finally labor costs became so grea
ry closed.

THE BELLAIRE WINDOW GLASS COMPANY was established in 1870-71 with John Sande
ident and F. M. Sheets, Secretary. This was the pioneer window glass factory in Bellaire. The bui
rected at 19th & Union Streets in 1872. Only window glass was produced by this firm.

THE BELMONT FLINT GLASS WORKS (See above)

THE BOND GLASS COMPANY. This was a decorating house, not a glass manufacturer. It operate
7 years during the early 1920's at 26th & Washington Streets. Mr. Charles Myers was the expert g
r for this company.



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THE BUCKEYE LANTERN COMPANY. Shown in an 1882 picture of Bellaire this company was located on 10th & Union Streets. It manufactured metal lanterns and later sold out to the Dietz Lantern Company.

THE CENTURY GLASS COMPANY is listed as being in business in 1903 in McKelvey's Centennial History of Belmont County, Ohio. No further evidence of its operation has been found. Informed opinion is that it is a non-manufacturing concern.

CRYSTAL WINDOW GLASS COMPANY was organized in 1882 with R. W. Muhlman as President and J. H. Robinson as Secretary. The plant burned in 1886, was rebuilt and restarted in 1887. The factory was located on Indian Run near the present Delta Concrete site.

THE ELSON GLASS COMPANY was organized at Bellaire in 1882 by E. K. Elson and M. Sheets, with J. H. Robinson as president. The factory was constructed at Martins Ferry, Ohio.

THE ENTERPRISE ENAMEL COMPANY, organized by Dorer and Smith, is listed in McKelvey's Centennial History of Belmont County, Ohio, as in the glass business in 1903. It is not, however, listed as a manufacturer elsewhere.

THE ENTERPRISE WINDOW GLASS COMPANY was organized following a labor dispute and located at Bellaire Window Glass Company in 1883. The cooperative effort elected A. Schick and D. Cratt as President and Secretary.

THE IMPERIAL GLASS COMPANY was organized in 1901, was two years in the building, and produced glassware for shipment in 1904. The company was conceived and built by Ed. Muhleman. Its first order was from F. W. Woolworth Company and was for about 20 items, including a covered butter dish, a pickle dish and a berry bowl. Later Imperial manufactured items for McCrory, Kresge, and other retailers to the quantity. The factory also turned out enormous numbers of jelly glasses with tin lids and common products.

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lers with horsehoe bottom, star bottom, and the like. Imperial had at that time moulds for 6 ware patterns, but the lines did not sell well.

A very popular line was pressed shades for gas and electric chandeliers, which sold very well in San Francisco and the Pacific coast cities. Also popular at the time were heavy stem pressed goblets or 'road goblets'. About 1910 the manufacture of iridescent glassware was extended, new colors added, and what is called 'carnival glass' today, although it was not called that by its makers. In addition, expensive moulds to produce an imitation of heavy cut glass-ware was made and the name 'Nightingale' was given to the ware. 'Nucut' sold well at profitable prices. Much of it was bought for premiums. For example, the Grand Union Tea Company purchased about \$15,000.00 worth per month for several years. A very profitable line was that of iridescent and frosted shades in imitation "Tiffany" style.

The demand for glassware during World War I speeded the development of automatic machine glass. This could not compete with automatic production and so began to specialize in handmade and cut glass such as glass baskets, vases, bowls, jelly stands, and so forth, using the best lead glass in crystal. About this time a line of glass articles decorated with decals like chinaware was begun. Neither of these ventures was wholly successful in a commercial sense.

In 1931 Imperial introduced the 'Cape Cod' pattern. Shortly afterward blown stemware was added and the 'Candlewick' pattern.

In 1931, too, The Imperial Company was bankrupt. The company continued to operate with Mr. Earl Newton as receiver. The company was reorganized, a corporation was formed, and Mr. Earl Newton was elected president of the new corporation. He was succeeded by Mr. Carl Gustkey in 1940.

In 1940 Imperial Corporation bought the Central Glass Works of Wheeling (Est. 1860). In 1958 it acquired the moulds of the Heisey Company (est. 1895) of Newark, Ohio, and in 1960 the Cambridge Glass Company of Cambridge, Ohio.

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In January, 1973, the Imperial Glass Corporation was merged with Lenox, Inc.

LANTERN GLOBE COMPANY occupied the works vacated by the Bellaire Goblet Company in 1886. Further information is available at this time.

THE NATIONAL GLASS WORKS was organized in 1870 by James Dalzell, Francis Eckles, Robert and others. It became a joint stock company in 1873 which failed in 1877 and was then purchased by Albert and Thornton Rodefer, after which it was run as Rodefer Bros. Lamp chimneys, lantern globe specialties were manufactured.

THE RODEFER BROTHERS NATIONAL GLASS WORKS. The three Rodefer brothers purchased National Glass Works in 1877. It has been run by the same family at the same site since that time. In 1910 Albert and Thornton Rodefer bought out John Rodefer. After Albert's death Thornton operated the factory until 1910 when his son, C. M. Rodefer, succeeded him. The building burned to the ground in 1891 but was rebuilt and restarted in 1892. In 1952 the company became the Rodefer-Gleason Corporation.

In the early years the Rodefer Bros. manufactured lantern globes, lighting rod balls and vault lighting globes making up about one-third of the total production. The lightning rod balls were in great demand. Nearly 100,000 per week was shipped with which to decorate the barns of rural America. Made in silver, white, silvered (gold), and blue, their only function was to decorate the lightning rods atop buildings. Vault lighting globes remain a large part of the output of the company today, as indeed, do light bulbs of many types.

About 1880 the company began making 'blanks' for other companies to decorate. One such company was the F. Monroe Company, which purchased Rodefer blanks because the glass was capable of standing up to the tremendous heats required in firing the enamel and gold paints used in decorating. Most of the Monroe blanks were given a 'Bristol' finish by firing, a mat finish which is typical of the Monroe line. The trademark 'Crest Ware' for decorated opal wares was registered by C. F. Monroe Co. in 1898.

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According to Mr. Howard Rodefer, his company has been making glass to specification for near 100 years. None of their output appears with the Rodefer name on it, but is incorporated into parts by another manufacturer. Some examples are finders lens, which were made for Eastman Kodak Co., and flashlight lenses (about 1923) for sale by Bausch & Lomb Company.

This company has the distinction of having operated longer on the same site, at 22nd & Union Street, than any other glass industry in the United States.

Another record of sorts was that of employment of an individual. Mr. Jim Weeks was employed by Rodefer Bros. in 1877, at the age of 10 or 12 years. He worked for the company until his death 85 years later as a glass blower, assistant to Mr. Albert D. Rodefer, as superintendent, and as Vice-President.

THE SICKLES CUT GLASS COMPANY, presently located at 940 S. Belmont Street, is a decorator and manufacturer of glass. Mr. E. C. Sickles began cutting glass in 1943 at the site of the present Kroger Store. At that time he cut only Imperial glass-ware. In 1950 the shop was moved to its present location and whole retail business developed. Mr. E. C. Sickles retired January 1, 1973 and the business is now operated by Ernest M. Sickles. The company does hand cutting and specialty work.

THE STAR GLASS WORKS. This short-lived company was erected in 1872 by Col. J. H. Sullivan. It was discontinued operations due to the panic of 1873, then operated until 1875 producing as a main line lamp glass. The building was burned to the ground in 1879.

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BELLAIRE AND THE CIVIL WAR

THE DAYS) before the Stone Bridge was erected in 1872, the Central Ohio Railroad came from Columbus and stopped at the Ohio River laire, and the Northern Virginia Railroad west from the Washington, D.C., area and at Benwood, and between the two terminal s, steamboats shuttled freight and igers. Both roads at that time had B. & O. 7 in them, and eventually both came under ete control of the B. & O.

Central Ohio was extended from Cambridge laire in 1854, and in its struggling formative before construction was started, the idea of road connection between Columbus and the river was kept alive by the dogged persistent s of Col. J. H. Sullivan, who even served as is president at one point when the proposal red to be dying.

l. McKelvey, in his Centennial History of nt County 1801-1901, writes that Col.

Sullivan was connected with "every sche build, every new enterprise" in Bellaire's history, "yet today (1903) Bellaire doe associate his name with that of an avenue park". McKelvey's barb at that time may cut an official skin or two, for today ther Sullivan St., albeit not much of a street, mo an alley, running north-south for less than block, connecting Vine with Spruce St. in a loop on Brewery Hill, big enough to accom only a couple of houses.

So when the city fathers in the early part century got around finally to honoring Sullivan in this manner, it was not much honor after all. However, their intention recognize him officially may have been limi another legend concerning Col. Sullivan.

That legend has it that the Colonel was one developers of the area around the City Park called Union Square. The lots on the four si

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rk were sold on the promise that when
were constructed, the owners would have a
view looking out into the park. After all the
land had been sold, the colonel and his associates
tried to sell the park area itself for housing,
but were prevented by court action instituted by
those who had bought the surrounding lots and
did not want to be flim-flammed by the colonel.

What as it may, the colonel did have a great
deal to do with the construction of the Central Ohio
Railroad's early organization through the difficult
process of raising money to the final building of the
road. At one time, when the whole plan was
about to go down the drain, Col. Sullivan moved in
and by sheer might forced it back to the
railroad board.

Northern Virginia Railroad came to Bene-
dict before the completion of the Central Ohio to
Columbus, and its history and that of its parent
company is well designated in the book, "The
Ohio and Ohio in the Civil War", written in
1892 by Festus P. Summers when he was associate
professor of history at West Virginia University.

It is interesting to note that the
Ohio Valley's current opinion that it should be
the hub of the entire Ohio Valley has not been cor-
rected, for in his book, Prof. Summers writes
of a court action instituted in Marshall County,
West Virginia, which at that time held bonds of the
Ohio Valley, seeking to force the Northern Virginia to lay
its tracks into Wheeling instead of into Benwo-

Summers also relates that later in the same
year Wheeling tried to halt construction of a rail-
road bridge across the Ohio from Weirton to
Steubenville, again under the assumption
that Wheeling should be the center of the
universe. Neither in this nor in the Benwo-
d case was Wheeling successful in its attempt to
control events of that time.

Col. Sullivan and the men who built the Central
Ohio had no idea at that time that within a decade
the road would play a vital part in one of the
early phases of the Civil War, a phase that would
define for all time the importance of railroad
as a military strategy of conducting a war, and

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YOUR CONGRESSMAN

in which the infant city of Bellaire, by ac-
of location as the road's eastern terminus,
have an important role.

There had been a plan to bridge the Ohio and
at the Central Ohio and the Northern
ia, but the guns of Charleston firing at Fort
r also blasted that plan, and when the war
in 1861, Confederate Gen. Robert E. Lee
d Major W. W. Loring to seize the railroads
undsville and Wheeling, then part of the
f Virginia, and to organize militia units to
l the roads. Major Loring found little
thy in that part of the state west of the
ains for the Southern cause, and eventually
hole western part of Virginia broke away
he Old Dominion and formed the new state
st Virginia, in 1863.

It was done with the blessing and the active
ipation of the federal government in
ngton, which was strange, in a way, because
orth had claimed the South had no con-
onal right to secede, yet in the creation of the
of West Virginia, the North had helped the
tate to do just that.

Had Major Loring been successful in hold
valley for the Confederate States of Ameri
dividing line between the North and South
have been the Ohio River, on our front do

Despite a minority sympathy for the
which turned the state into something of a
for the Copperheads, Northerners who favor
South, Ohio from the start of the war wa
mitted strongly to the Union, and by the end
years of blood-letting, Ohio was among t
group of states which furnished the men a
materials for the Union.

Early in the war, Camp Jefferson
established on the riverbank in Bellaire,
approximate site of today's city water pl
serve as a staging area for Union troops cr
the river to join the Army of the Potomac
east, or to be transported by steamboat dow
to join the Army of the Tennessee in the west

When Gen. George McClellan was ready
Union thrust which resulted in the first be
the war at Philippi, a brigade of Ohio vol
under command of Col. James Irvine was o

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Bellaire, Ohio

p Jefferson. The 16th Ohio was funneled there to Fairmont, and the Third and Ohio Regiments crossed from the Camp to Ford on the way to join McClellan at Gettysburg. On completion of the Central Ohio Railroad, Col. Sullivan had been appointed by B. & O. to command John W. Garrett as that road's western terminus with headquarters in Bellaire, and in October 1861, with the lesson rudely learned by the First Bull Run in July that this would not be a "90-day war", Sullivan was ordered to get to Gettysburg to meet with Garrett, Gen. McClellan's Secretary of War Edwin M. Stanton to coordinate the movement of troops by rail.

The federal government was beginning to get an appreciation of the importance of railroads in the war effort. The Confederacy already had that appreciation, and Rebel forces in the northern Virginia spent considerable time and effort to block the B. & O. and the Northern Virginia to cut off the flow of men and materials to the Army of the Potomac. Cavalry units under commands of John Imboden and William E. Jones knifed through the woods at the two roads all along the western

stretches from Baltimore and Washington, and the Union countered with troops from Gen. Ambrose Burnside's Department of Ohio, moving the railroad into Bellaire for forwarding to Gen. Benj. Kelley, who was charged with the responsibility of protecting both roads.

The Civil War had started poorly for the Union but in the summer of 1863, Gen. U.S. Grant forced the surrender of Gen. John Pemberton's entire Confederate army at Vicksburg, and the next day, Gen. George Meade had defeated Lee on the bloody ridges of Gettysburg. That became the same sad story; the hopes that had been rising in that summer of big victories were dashed when Meade failed to follow Lee's battered army vigorously back into Virginia, permitting the South to escape possible destruction, and those two armies, stalemated again, faced each other inactively across the Rappahannock River.

In the west, after Vicksburg, the War Department had broken up Grant's victorious army, scattering units to occupy territory, contrary

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belief that the destruction of Southern ar-
not occupation, would lead to quicker
sh of the Union cause, and Confederate Gen.
n Bragg, alert to the opportunity, had
the Army of the Tennessee into the defense
 Chattanooga after the disastrous battle of
 Chickamauga, where only Gen. George Thomas,
 the help of Ohio troops, managed to salvage
 glory by saving Union Gen. Rosencrans'
 from utter rout.

g had drawn the noose so tightly around
 Chattanooga that Northern troops inside the town
 were slowly starving. In September of 1863, it was
 obvious that the besieged Army of the Ten-
 nessee could not be rescued, and in Washington, President
 Lincoln, War Secretary Stanton and Chief of Staff
 Henry Wager Halleck decided to send west to
 Chattanooga relief the Eleventh and Twelfth Corps
 of the Army of the Potomac, idle along the
 Rappahannock River. The two corps were placed under the
 command of Gen. Joseph Hooker, who
 had been withdrawn from the obscurity into
 which he had plunged when his army was
 defeated at Chancellorsville by the outnumbered
 Confederates under Lee and Stonewall Jackson.

The movement of the two corps would in-
volve some 20,000 troops, their arms, am-
munition, equipment, horses, mules and wagons, a major
transport of men and material never before
attempted on so grand a scale by the north
over such a long distance, 1,200 miles.

The South had done it shortly before, at
the Battle of the Clouds, when Gen. James Longstreet with 12,000 troops
moved from Virginia to Bragg in Tennessee before the battle of
Chickamauga, and although neither the number
of troops nor the distance equalled that
proposed Union movement, the South had
lost and conquered, the problem of discon-
necting railroads and tracks of varying gauges. If
successful with Longstreet was Belmont County native
Bushrod Rust Johnson, one of seven north
Carolinians serving as Generals in the Confederate army.
In the battle of Chickamauga, it was Johnson
who led Southern troops through a gap in the
Atlanta Railroad Line to put the entire army in jeopardy.

Nothing could be left to chance in the flight
of the Union troops to the relief of Chattanooga,
for the fate of the war in the west hung in the balance.

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e. If Bragg were able to shatter the Army Tennessee, the Union would have very little stop him short of the Ohio River.

eastern troops would travel from the on the B. & O. to its junction with the rn Virginia, and on the Northern Virginia to od, where they would cross the river and the Central Ohio in Bellaire for the jolting Columbus, transferring there to the cars ting Columbus with Dayton, then on to apolis before turning south through Ken- into Tennessee.

early stages of the route led through enemy y, and along the way from Virginia through 1 West Virginia, Ohio, Indiana and Ken- there existed considerable hard-core head sentiment. Espionage in the Civil is carried on for the most part by amateurs thizing with one side or the other, some of became quite adept at spying. Because of ure of the war, it was impossible to shut off tely travel through the opposing lines, and s one of the major worries of the North, that f the movement would get to Bragg in ad- Oddly, it never did.

Copperhead sentiment was strong in E: Ohio. The name came from their embl copper penny with everything cut out bi figure of the head, and they called themsel other names, one of them Sons of Liberty.

In Cadiz, a mob stormed and burned the of the Sentinel newspaper for its open espousal Southern cause, and we can remember grandmother, Maria Geary, who came to Be from Ireland in 1863, telling stories of soldiers found dead, presumably poisone Copperheads, at Camp Jefferson.

In September of 1863, Bellaire was a villa less than 1,500 souls, but the coming of the Co Ohio nine years before had brought with promise of quick growth usually attendant to terminus. The war had interfered, as all wa but the post-war period was to bear out promise; by 1900 the population had jump 9,900, multiplying by five times in only decades, and industry, particularly glass, rushed into the city, providing the jobs v brought more and more people in growing bers.

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in 1863, few if any of the city streets were . From the southern point, which now is d the vicinity of 22nd St., to the northern in the area of what is 38th St., and from St., then called Water St., to Guernsey, most dirt streets suited to the horse and wagon : of the time. The Central Ohio tracks came m the west, across McMahon's Creek from : the first house built by Jacob Davis still along the present B. & O. right of way in the valley, and as the tracks rounded the hill, split, one set going north along what is now lton St., and the other continuing east along is now 29th St., then curving northward id Union St. to a point midway between 's 33rd and 34th Sts.

om this latter set a spur ran south along the bank to the area of 29th St., serving as a fer track to pick up freight and passengers carried back and forth by busy steamboats en Bellaire and Benwood. There were it storage sheds laying along this spur in the of the 3000 and 3100 blocks as we know them . Where the first set lead north from the

split and where there was then no Hamilto freight transfer area lay to the east of tracks, and the tracks themselves were bc by the Central Ohio car shops. The rai engine house and machine shop were loc: the northern rim of the present Bellaire property.

Bellaire boys had gone a few years befc the Union Army in the first full flush of p: fervor, and now that the war was two ye and the initial feeling of glory and romar: given way to the harsh realization that were getting killed and wounded and ca those same Bellaire boys among them, the and some of the old still were going throug: Jefferson into Virginia and down the river : western war furnace. Shortly after the ele President Lincoln, his old political advers: his chief opponent in that election, Step Douglas, the Little Giant, en route to his Illinois where he was to die within a few months, stopped off in Bellaire to deliver iotic speech in which he pleaded for cc support of Lincoln's policy of keeping the together.

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the dying days of July, 1863, the war had come close to Bellaire when the Confederate Gen. John Hunt Morgan skirted the edge of Kent County in his dash through Noble County, Ohio for the National Road at Old Washington, where militia men from Bellaire joined with those from the rest of the county in response to the call.

They didn't stop Morgan; nobody got in his way, except a militia unit which went west on the National Road from St. Clairsville to meet him after he had swept through Marietta, but the militia is said to have hustled back to St. Clairsville the moment Morgan's scouts appeared on the horizon.

At that time, was Bellaire in 1863, the mercantile establishments and the saloons lining Union and West Sts., the houses scattered up and down on the hillside, some of them hanging onto the edge of the hillside, the trains huffing and puffing their funnel stacks coming in from and going out to the west, the steamboats churning back and forth up and down the Ohio, the dirt streets covered with mud from passing hooves and wheels, the air thick with dust, a town about to be inundated with a population of about 14 times its population.

The movement of the two Corps from Vandalia would encounter one of its most critical points along the 1,200-mile at the crossing of the Ohio River. The troops and their impediments would have to be ferried from the Benwood to the cars in Bellaire. Garrett, conferring with President Lincoln, Stanton and Gen. Halleck, sent to Bellaire from Baltimore a general supervisor of trains, Alexander Diffey, for help in the concentration, loading and forwarding of the Central Ohio trains.

Diffey faced the huge task of assembling at Bellaire by Saturday, Sept. 26, 1863, a total of 125 railroad cars, including 125 passenger cars and 125 freight cars.

Concerned over the Copperhead sentiment in Eastern Ohio and hoping to keep the Confederacy in Tennessee from learning too far in advance of the union movement, Gen. Halleck wired Kelley to close all of the saloons in Bellaire and Benwood for as long as the movement was going through the area. Gen. Halleck may have had another motive; he may have wanted to

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that every soldier who left Virginia made it to essee.

laire apparently was a hard-drinking town in days; in the mayoralty election of 1860, the "key issue" had been in the forefront of the campaign, so Gen. Halleck's fears may have been founded. His warning had its counterpart in "Loose Sink Ships" posters in the bars which read "Loose Sink Ships", familiar sights to soldiers of an 80 years later.

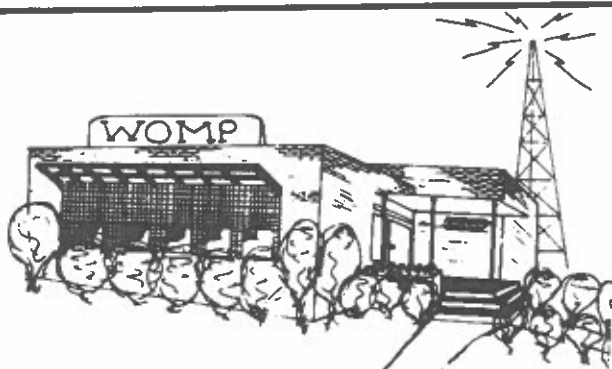
The first of the 20,000 troops were to move through Bellaire in a 12-hour period between 10 p.m. Sunday, Sept. 27, and 10 a.m. Monday, Sept. 28, according to the schedule, and there could be a jam-up. The whole movement would take 10 days to accomplish.

Following Diffey to Bellaire was the B. & O.'s general manager, John L. Wilson. When he arrived in Benwood, Wilson found that the river was running low and still falling rapidly because of a dry spell, prohibiting the use of steamboats in

transporting the men and material across the river. Wilson immediately wired Garrett in a critical situation, and Garrett fired by command to build a "superior bridge of scows" across the river. That pontoon bridge formed of scows laid side by side and held together by planking to make the roadway, was finished in less than two days, and meanwhile, pontoons were constructed hastily at rail terminal in Bellaire and Benwood to facilitate the transport.

The series of dams which controlled the river level holding it at navigable stage did not exist about until around 1913, and before then the river ran almost dry in times of drought.

The movement of the troops proceeded faster than scheduled; the first train from Washington arrived in Benwood before 11 a.m. Sunday, a half-day ahead of schedule. Before daylight Monday, 8,000 troops and several artillery batteries had trudged across the pontoon bridge through the dusty streets of Bellaire, and then aboard the Central Ohio cars, and departed for camp. Within the next ten days, the entire



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and their equipment had come and gone, the residents with thrilling memories of the wagon trains marked with the star of the Eleventh and the regimental flags snapping in the hot air, officers mounted on prancing horses, and Napoleon cannon rumbling through the

there were the closed saloons, while the thirsty soldiers cast longing glances at their locked doors and blank windows, but it is highly probable, the town being so close to the river, that many a member of the army got a nip or two from a bottled profane and sympathetic citizen, and it is probable that whiskey bottles which had their origin in the north were scattered along the Central Ohio all the way to Columbus after the trains passed on. For there was no way that even the government was going to be able to shut off the flow of booze at such a time of high excitement.

With the troops in their passing through Belmont were men whose names, by 1863, had become household words throughout the North. It was "Fighting Joe" Hooker, still a hero in the Union despite the debacle at Chancellorsville two months later he would regain some measure of his former glory in the Battle Above the Clouds on Lookout Mountain outside of Chattanooga where he was now being hurried and where his troop movement not only did what it had been designed to do, the relief of Rosecrans, but it also doing opened the way for Sherman's drive on Atlanta that sliced another great part out of the Confederacy the following year.

Hooker's name would come to mean something else in the years to follow, even up to now a slang description of a prostitute growing out of the woods goes on in his winter camp at Fredericksburg early in 1863 after he had replaced Burnside as commander of the Army of the Potomac and was refitting his army for his disastrous spring campaign at Chancellors

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ere was one-armed Gen. Oliver O. Howard, the right arm had been amputated above the elbow earlier in the war at Fair Oaks during the Seven Days Battle in front of Richmond, when Lee had lost the opportunity to end the war in 1862, and then too it was Lee who had foiled the Union. That day at Chancellorsville a year later General Jackson came suddenly out of the woods and struck the right of Hooker's line, sending Eleventh Corps into pell-mell retreat, Howard astride his horse in the midst of the fleeing troops grabbed a sword from a color bearer, stuck the flagstaff under the hump of his right arm, and tried in vain to hold the retreating troops. After the war was over, Howard would go west to fight the Indians, and they would call him "Ironpants" because he was always in the saddle almost day and night in the army charges across the dusty plains.

ere was Gen. Henry W. Slocum, who had been at Bull Run and Malvern Hill and Antietam and Chancellorsville and Gettysburg, and who commanded the Twelfth Corps at Chattanooga, and who fought with Hooker, with Sherman before Atlanta, and who ended in a huff and went home, Slocum would

be called from Vicksburg to take command of the Twentieth Corps. Like the rest of the army, he was moving now from Virginia to Tennessee, and would not return to the Army of the Potomac until the rest of the war.

There was Gen. Carl Schurz, a friend and political supporter of Lincoln, who almost made it across the Ohio from Benwood to Elyria.

When that particular section of the road was opened over which Gen. Schurz had command was beyond the reach of the military hierarchy in Washington, Gen. Schurz insisted on having his own private car, despite the overwhelming opposition for every foot of space, and he rode not over civilian rail officials who wanted to put the troops into this car. While the section was being opened route to Benwood, the word of the general's highhandness filtered back to Washington when he arrived at Benwood, there was a telegram from Gen. Halleck threatening to relieve him from command unless he straightened

And then there were the troops themselves, the men who had fought at Bull Run and Cold

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tietam and Fredericksburg and Chan-
ville and Gettysburg with relentless
and grim determination that deserved a
ate than poor generalship had brought.
my of the Potomac from which they were
ng detached was the greatest and best-
l army the world had even seen up to that
it the capability of the troops had not been
l by the intelligence of the high command,
army had fought its way time after time in
and Maryland and Pennsylvania to the
total victory, only to see its leadership
away the opportunities its blood had

re boys were with the two corps being
so swiftly through their home town that
ld have a chance for no more than a wave
ands to relatives and friends who lined by
r the route from the riverbank to the
cars. The town was empty again in early
of 1863; the clanking cars, the funnel-
omotives which had chugged in and out of
the rumbling caissons, all were gone, and
to mark their passing were the hoofprints
ist, and ruts from the cannon wheels, the

34-star flags which had hung from almost a
window in every building in the little town.

The 1,500 people who lived in Bellaire at
time would remember these troops when
read the dispatches from the west two m-
later which told of Hooker's successful attac
the Confederate left at Lookout Mountain an
wild unordered charge up Missionary Ridge v
broke the Confederate center and sent Br
army reeling back to Dalton in Georgia.
would remember the troops when they read it
of Sherman's thrust down through Ringgold
Dalton and Resaca and Allatoona Pass and
Mountain and Marietta to the very gate
Atlanta, and when they heard that Atlanta w
flames.

They would remember the Eleventh and Tw
Corps, now merged into the Twentieth C
when Sherman took his army from Atlanta t
sea, and up through the Carolinas toward G
who had encircled the last remnants of l
gallant army at Petersburg, with the en
Appamattox only days away, and if they

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e been in Washington on May 24, 1865, when
rman's western troops marched down Penn-
ania Avenue into history on the second and
day of the Grand Review.

here never was a time before, nor has there
1 since, in Bellaire to match those eleven days
ate September and early October of 1863.

oops representing a united America passed
ugh Bellaire, maybe even in greater numbers,
ar I and War II, but they sped quickly through
city in B. & O. troop trains atop the Stone
lge, high above Guernsey and Belmont and
on Sts., and if a person happened to be
ntown at that particular time, the soldiers
ld be seen through the windows of the cars,
s without flesh and blood. But in 1863, a
son could reach out and touch the blue
orms of the passing troops, shuffling route-
through the streets, and they were more the
for it.

It had been, those eleven days, a time
exciting glory for those long-ago peop
anything like it will never happen again

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final quality of our glass. Next in importance are Alkalies; namely, Soda-Ash, Potash, Nitrate of Soda, and Nitrate of Potash—all manufactured products. Of equal precedence are Limestone, Burned Lime, and Lead Oxide. In addition to these principal components, a number of other materials are used, some of which are added to the glass "batch" for the purpose of refining, others for giving the glass specific chemical or physical properties, for giving the glass opacity, brilliance or clarity, and others for creating distinct colors. In the latter group are metals or metal oxides which are used in the most concentrated and purest form. The worst trouble-makers plaguing the glass-maker are impurities of natural minerals or manufactured chemicals, particularly oxide of iron. Therefore, the purity, or in other words the quality, of all raw materials we use must be duly stressed. Not only in the selecting of raw materials, but also in shipping, storing and handling, great care is necessary.

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MIXING—Glass is melted from a mixed "batch" of raw materials consisting usually of a mixture of Silica Sand, Soda-Ash, Potash, Lime, or Lead. The raw materials are carefully weighed in right proportions and by aid of mixing devices, blended into a uniform mass. At this stage all of the raw materials are brought together and a certain amount of broken glass, or *cullet* (which is recovered from the manufacturing process), is added. The weighing and handling operation of the materials is dusty and the men performing

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his work are protected by respirators or other modern safety devices. The "batch" is transferred into the *mixing drum* which revolves much like, and resembles the commonly-
seen cement mixer. During shipping to our plant or in handling, impurities may have
found their way into the *batch*. The complete absence of "foreign matters," particularly
"tramp" metals such as rust, is important. For this reason we see that the *batch* is
carefully emptied from the *mixing drum* onto a continuous belt conveyor which carries
it over a magnet; the magnet serves to catch and withdraw foreign matter and thus aids
us in maintaining our *Imperial* color-quality. The *mixed batch* is finally dumped into a
batch cart and wheeled out into our *hot metal* room where it is to be emptied into our
pots or tanks for melting.

MELTING—Melting means *fusing* the batch at high temperatures, ranging from 2400
to 2700 degrees Fahrenheit in individual clay crucibles or *pots*, in *furnaces*, or in large
single furnaces or *tanks*. Normally between twenty and thirty hours are required to *fuse*
or melt the batch into clear sparkling glass. Glass furnaces are fueled with natural gas
or fuel oil, both of which are available in abundance in our vicinity. When the melting is

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3 H.P. TIN LIZZY

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complete and the molten mass tested (by taking out proofs for several hours to assure complete fusion), the glass is cooled down to working temperature, ranging from 1900 to 2100 degrees Fahrenheit, and our most skilled or *hot metal workers*, sometimes called *flints*, can begin to shape and process, blow or press the glass into a finished item. In most cases, large quantities of our Crystal or *clear glass* are melted in a single unit or *tank* containing over one hundred tons of glass. Colored glass, lead glass and other special kinds of glass are melted in individual *pots*, each containing approximately one ton. The melting process is an important phase of our manufacturing; during which the *batch* goes through various stages, as the *melt*, before it becomes clear glass, refined and ready for work. It boils up violently, but eventually settles down to a clear transparent mass of about honey consistency. The heat application in our *furnaces* and *tanks* is accurately controlled and scientific handling of melting is a part of our operation of which we are immensely proud.

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BLOWING—The oldest method of forming glass articles is done by the aid of an iron *blow-pipe* in the hands of a skilled *flint* (glass-worker). The molten glass is gathered by the *gatherer* on the end of a *blow-pipe*; it is then removed from the pot, somewhat cooled, carefully shaped, and the *gob* of glass is blown (by means of the mouth and lungs) into a hollow body which the gatherer hands to the *blower* for further processing. The *blower* shapes the glass bubble further, and, in most cases, blows it into a shape in the *mould*. The *glass blower*, a most experienced man, is responsible for the finished shape of such an article when it emerges from the mould. As soon as

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blown items have progressed to this point they are ready to be severed from the *blow pipe* and then placed into the *annealing Lehr*. In some cases, however, further work or finishing has to be done. For example, our sketch illustrates a blower about to place a preshaped *gob* of glass (on the end of his blow pipe) into a water pitcher mould for shaping. Then the pitcher is *stuck up*, on the bottom, to another *handling iron*. After it is detached from the blow pipe it is reheated in a small auxiliary furnace, commonly called a *glory hole*. After several minutes, the pitcher is hot enough for further processing: applying the handle. The handle is attached in the following manner: A *handle gatherer* brings a *gob* of glass to the *finisher* who sticks it on to the body of the jug, pulls it out like one would taffy, cuts off the desired length, attaches it to the top of the pitcher, and shapes it while still pliable and hot. During all this work, the glass article has to be kept at a working temperature of nearly a thousand degrees to prevent cracking because of premature cooling. At this stage and by continued reheating during the working process, many operations can be performed and additions made; fancy shapes, ornamentation, etc.

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HAND PRESSED—*Hand pressed* glassware is distinguished from *blown* glassware by the fact that both the inside and outside surfaces are formed and shaped by a mould. In pressed glassware the mould has a cavity into which glass is *pushed* by pressure, with the aid of an iron *former* or *plunger* instead of by use of air alone. We have just spoken of a pitcher. Pitchers can be made either by *blowing*, in which case the cavity is formed by air from the mouth and lungs of the workman, or by *pressing*, in which case by lever operated mechanism the glass is forced by a plunger into its final shape. Further operations, when the article is removed from the mould, are the same by either method. When an article is *pressed*, the initial *gob* of glass is *wrapped* upon and withdrawn from the furnace on the end of a solid iron rod—a *punty*—instead of a *blow pipe*, *sheared* from this gathering iron by the *presser*, and then dropped into the mould. A pressed article can be finally *hand shaped* in the same manner as a *blown* article, by a *finisher* using wooden, carbon, or other type hand tool. After the final shape is accomplished, the item is carried to and put on the endless belt of the *annealing lehr*.

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Both methods—*blowing* and *pressing*—require highly skilled workmen. In either case, the *gatherer* who brings the initial gob of glass to the *blower* or *presser* must carefully determine the needed quantity of glass which he gathers. The *blower* must understand careful and uniform distribution in blowing, and the *presser* accurate use of his press to shape the desired article with the *press mould*. The skill of the glass-worker is often handed down from grandfather to grandson, etc., and these men are most highly valued in the glass industry. Several years training are required—usually ten. The average age of our skilled *pressers* is 45 years, with the average age of *blowers* about the same. In our plant are *finishers* 35 to 70 years old. Glass *blowers* and *pressers* requires many years of diligent application to perfect their art. Glass working descendants of glass-workers' families who settled many, many years ago in our vicinity are now producing *Imperial* Quality Glassware.

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ANNEALING—*Annealing* means careful and gradual cooling; for almost any piece of glass if left to cool by itself will shatter into many pieces. Depending upon the shape and the thickness of an article, the glass is subject to varied and sometimes enormous internal and surface stresses, which are caused by unevenness in cooling. The *annealing* process tends to relieve these strains, by uniformly reheating the glass article to a temperature near 1000 degrees and then gradually cooling it down to room temperature. We anneal by the most modern methods, with *annealing lehrs* automatically controlled by precision instruments and in which the glass can be *cooled down* through a pre-determined cooling cycle. Our cycle is accurately and automatically maintained and therefore assures the utmost in uniformity of annealing. *Annealing lehrs* are bake ovens with continuous belt conveyors traveling at very *slow speeds*. The *glass pitcher* which we just made (in our description) is placed on the conveyor and slowly travels through this heated tunnel or *lehr*. Its trip through this oven may take several hours.

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POLARIZED LIGHT TESTS—Strains and stresses which are hidden inside of a blown or pressed glass article will cause it to break or *fly* and render it useless. We believe proper annealing of all glassware is of great importance. Strains which cause glass articles to break are nearly always invisible to the naked eye, but can be readily detected under Polarized Lights. *Polariscopes* are used in our plant to test the ware for internal stresses so that improperly annealed ware will be rejected before it will reach the consumer. *Polariscopes*, which are instruments specially designed for this purpose, were only recently added as a control in industrial production. They are extensively used in our modern plant.

SELECTING AND FINISHING—Should our workers unwittingly send defective ware into our *lehrs*, it is discovered at *first selection* which takes place after the ware leaves the cool end of the annealing *lehrs*. Some articles, after careful inspection, are

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sharp and ragged and has to be ground and polished to make a finished article. After this operation, the ware is re-selected and ready for wrapping and packing. The finishing process includes also a number of other operations too numerous to list, one of which is drilling of a hole in a glass article to be suspended or mounted (such as lighting bowls, prisms, or chandelier pendants). Where part of an article has to be *sawed* or cut off, a fast revolving, very sharp carborundum disc is used which cuts glass in the same manner as one would saw a piece of wood or metal.

Decorating

CUT GLASS—In this case a glass article is decorated with various patterns which are cut into the surface of the glass. The first step is to lay out and mark onto the surface of the glass a skeleton of the pattern to be cut. The surface is cut into with abrasive

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cutting wheels until the desired design or effect is achieved. In some cases this design is left in its original gray texture; in others, the cut design is polished with cork wheels or by a polishing process with acid until the whole design sparkles with the same brilliancy as the uncut surface of the glass. When the cut pattern is left in an *unpolished* gray frosted finish, it is called *gray cut*; if it is polished we talk in most cases of it as *rock crystal* cut. Our glass cutting is performed by highly skilled *glass cutters*, men and girls, who have learned the art over a period of many years. Great skill, sensitivity in touch and a perfect eye for space and proportions are necessary because many of our beautiful designs are cut into our glass entirely free-hand and without any pattern aid.

HAND PAINTING—Another method of decorating glass is by applying designs and ornamentalions with ceramic colors on the surface of the glass. The colors used for this type hand decorating, in most cases, are fine powdered glasses which, after

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application with the brush or pen, are fused into the surface of the glass at high temperatures. Our floral designs and ornaments, color bands and stripes are permanently fused into the surface of the glass to render them impervious so that the decoration becomes an integral part of the glass and can not be removed. Colors are carefully prepared and mixed with special oils to enable the glass decorators to paint beautiful flowers or carefully applied ornamental patterns and lines. In most cases, the final result (beautiful colored effects) is not visible until after the color is fused by firing onto and into the surface of the glass. The art of glass decorating is therefore difficult and complex because for most patterns the glass decorator works in shading his colors "entirely in the dark" as to its final appearance, having to visualize the final effects which will result with the careful stroke of his brush and delicate shading gained by long experience.

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ETCHING—Glass can be beautifully frosted all over by dipping the article into a solution of fluorides and hydrofluoric acid. If a floral design or a crest is to be etched onto the surface, the glass is coated inside and out with acid-resisting solution (common asphalt) leaving uncoated only that part which is to be the eventual design pattern. The glass article is then immersed in hydrofluoric acid for a period of time. The glass is removed and thoroughly washed in hot water. During the washing process the acid-resisting material is removed and the glass article emerges from the washing process with the design *silvery etched* or *eaten* into the surface of the glass. To facilitate the work and to produce intricate and beautiful designs, the image of the design is many times put onto the surface of the glass by a transfer process.

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SAND BLASTING—The surface of glass can also be frosted by *sand blasting*.

The *sand blasting* process consists of spraying an abrasive material, such as sand, onto the surface of the glass at high pressure and great velocity. A glass article can be frosted

all over by sand blasting to a silky-satin finish or to a deep rough finish, depending on the time of exposure to the blast of sand and the coarseness of the sand blasting material. With this process, by aid of *masks* we can also produce intricate patterns on the surface of glass, when either the outline of the design is carved into the glass by sand blasting or the outline of the design is left clear and the background carved away. By sand blasting, we can produce beautiful ornamentations in various depths and in various densities and shadings.

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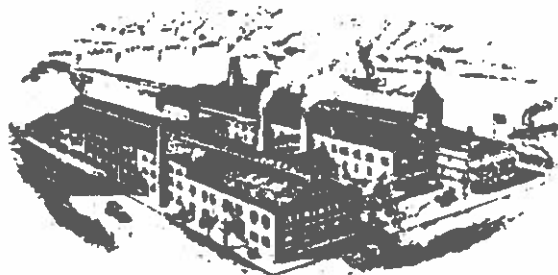
CASED GLASS—Some people consider "cased glass" as a type of "decorated" ware. It is, of course, two layers of differently colored glasses, one overlaying the other in molten state and thus becoming solidly welded together. The effects are beautiful to behold!

The ill-informed believe "cased glass" is only made abroad. Some few modern American factories produce simply magnificent examples of true casing. Oft' times the outer layer or color is "cut through" to the under layer or color for interesting decorative effects.

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Table glassware *is* strong enough for normal usage and can, *with care*, be used for hot foods as well as cold. But please remember it is *not* technically heat resisting and will not stand abrupt changes of temperature. So DON'T put anything hot in crystal that has been chilled. DO NOT put glasses that have contained ice immediately in hot water. Warm them gradually by rinsing first. And be sure to put a silver spoon in a cold crystal cup before pouring in hot liquids.

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