

BLOWLAMP NEWS

No 52

JUNE

2005

The Newsletter of the Blowlamp Society - Founded by Les Adams, August 1992

If nothing else, including Keith's letter with the last issue prompted a few of you to contact me and give your opinions in support or against what was said. I do hope that no offence was taken from the opinions voiced, I am sure that none was intended when Keith put the letter together. When I read it, I thought "hello Keith is on his soap box again", but on reading it a second time I could see his reasoning. That said, I do not intend that this topic should run for ever, suffice to say, as with all collecting these days, prices are on the increase and there is little we can do while demand for the more exotic lamps exceeds supply. (You will find some replies included with this newsletter)

MEETINGS

BELGIUM

Saturday 12th March saw another successful meeting at Lochristi, Belgium and congratulations must go to Brigitte and Willy Mouton for all their hard work in organising the event.

The venue they have found is ideal with a large hall being partly made over for display and partly for refreshments. As usual the quality of blowlamp on display was very high, with many examples on show which are rarely seen.

There was plenty of activity throughout the morning, with many exchanges and purchases being made and I think all those attending were well satisfied with their new acquisitions.

One particularly happy bunny was Michel Duval, who has a unique collection; comprising one example of as many different manufacturers as can be found and to date he has over 400 different makes. Michel described the day as being like Christmas, as he had added about 15 new names to his list.

In all about 90 collectors enjoyed the day and I hope that Brigitte and Willy will continue to build on their success.

UK SPRING MEETING

This years UK meeting moved to a new venue at The Trust Centre, Copthorne, Surrey, which is the headquarters of an historic vehicle preservation club, so it had all the makings of a good day. Andy and Vera Feast had put a lot of hard work into organising the event and the Trust Centre had on site catering facilities to make the day go smoothly. When I arrived on site I was greeted by friends from France and Belgium but apart from the hardened few, the British collectors had forgotten to come. I felt disappointed for Andy and Vera and embarrassed for the collectors from Europe who were hoping to see a much bigger display than was managed.

We really must get to the bottom of what you, the Blowlamp Society member really wants; otherwise the enthusiasm of those who organise these events will wane.

That said, I regard the day as a success, there were some nice blowlamps on display and there were plenty of opportunities to buy and exchange lamps. Graham Stubbs, who had visited from the USA earlier in the year, had left a nice display of photographs showing products of the Turner Brass Works and the 7th BTCA Convention.

THE GAS LIGHTING IMPROVEMENT COMPANY

In issue 47, I included photographs of a blowlamp I had bought at auction, manufactured by "The Gas Lighting Improvement Company", called the "SIRIUS" and apart from finding a reference to the GLICO petrol company, very little information could be found on the make.

Recently, Michel Duval sent me a copy of a German Patent Document, which confirms the date of registration as 13th November 1895, making it quite an early lamp.

Fortunately, for me, Keith Hawkins has a friend with connections, so he was able to arrange for the text to be translated which is included below.

Looking at the drawing included with the Patent, the final shape of the tank differs from that shown, but all of the other features are the same.

Royal Patent Office

Patent No 89239

Class 4 – Lighting

.....

THE GAS LIGHTING IMPROVEMENT COMPANY, LIMITED
IN LONDON

Gas Paraffin Lamp

Patented in the German Empire – 13th November 1895

.....

With the existing gas light, the burner can be set through simple rotation to an optional angle between horizontal and vertical. To this end, oil supply pipe **B** is angled at approximately 45 to the oil tank **A** and fixed to this oil supply pipe, the burner **D**, in turn, with an angle of 45 to the flue. The junction of the oil supply pipe to the oil tank is therefore made in such a way that if the flue is rotated in one or other direction at an angle of around 180 to its filling socket **E**, the burner can be in a horizontal or vertical position as shown on the gauge or in an optional in-between position, using smaller turns. Instead of turning pipe **B**, it can also be tightened with tank **A**, and burner **D** can be attached to the pipe **B**. The gas lamp described allows for an optional flame height.

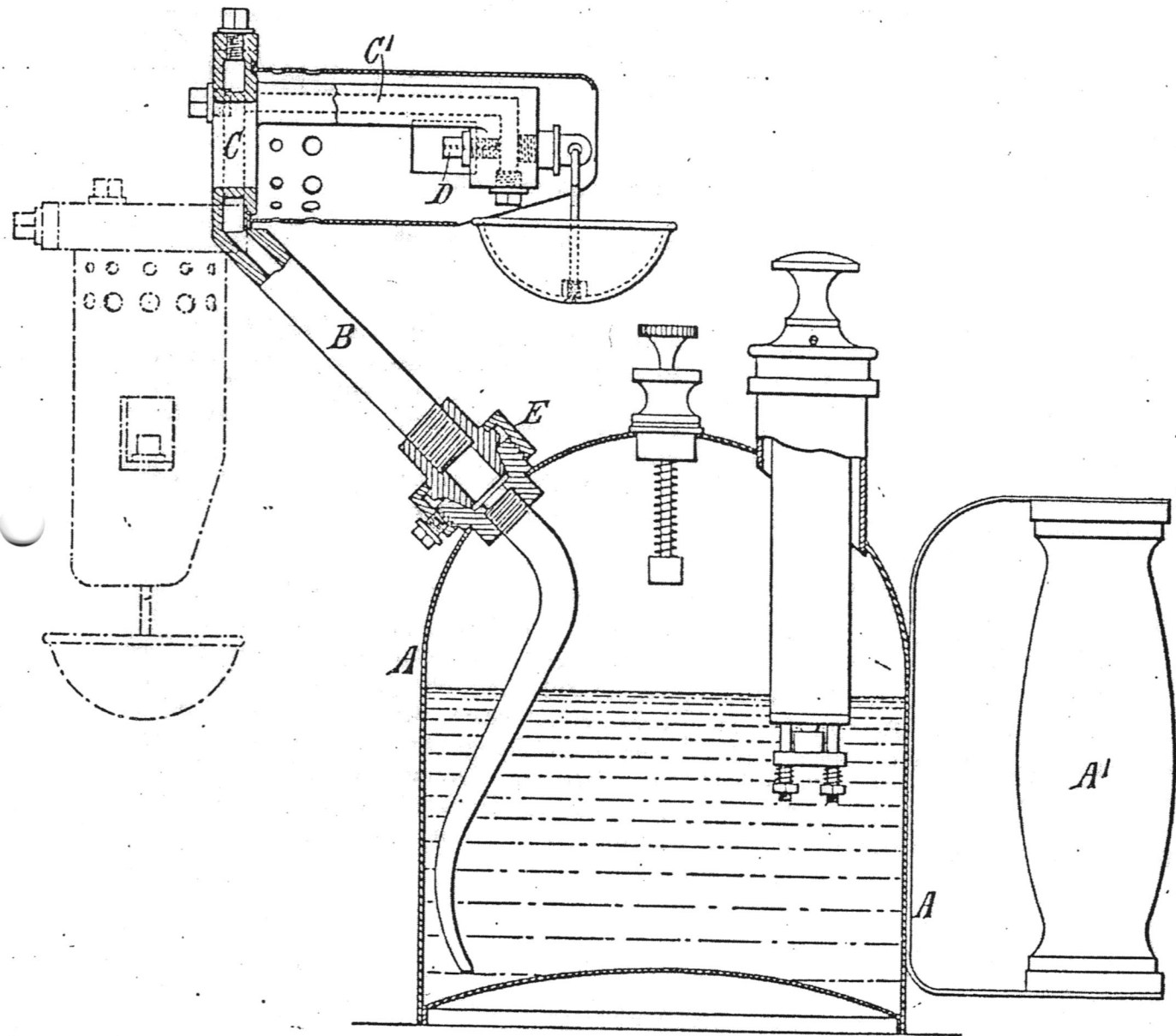
Patent Claim

Paraffin gas lamps showing that at an angle of around 45 to the burner and oil tank supply pipe **B** is angled to the oil tank **A** in such a way, the turning is set so that optional angles between horizontal and vertical can be specified.

Enclosed: 1 sheet of drawings.

THE GAS LIGHTING IMPROVEMENT COMPANY, LIMITED
IN LONDON.

Dampflampe für flüssige Kohlenwasserstoffe.



Zu der Patentschrift

№ 89239.

PHOTOG. DRUCK DER REICHSDRUCKEREI.

BLOWLAMPS TO MAKE YOUR MOUTH WATER

While trying to think of new features to include in the newsletter, I thought that there are blowlamps out there that we would all dearly like to own. With this in mind, I asked Michel Duval to nominate the 6 most desirable lamps made in France, Graham Stubbs to nominate the 6 made in the USA and I would take on the challenge of finding 6 likely candidates made in Britain. I defined "desirable" as being both unusual and attractive in appearance or the fact that they were very rare and hard to find.

I am looking for volunteers to come up with similar lists for Swedish and German blowlamps.

Michel has sent me a selection of French lamps, but they are so good, I find it impossible to narrow it down to 6. (Photographs of these lamps will follow in this newsletter.)

Graham sent me a list of 6, which I had to agree were great, but he sent me a second list of 6 which were equally as desirable, so again the list from the USA is likely to grow.

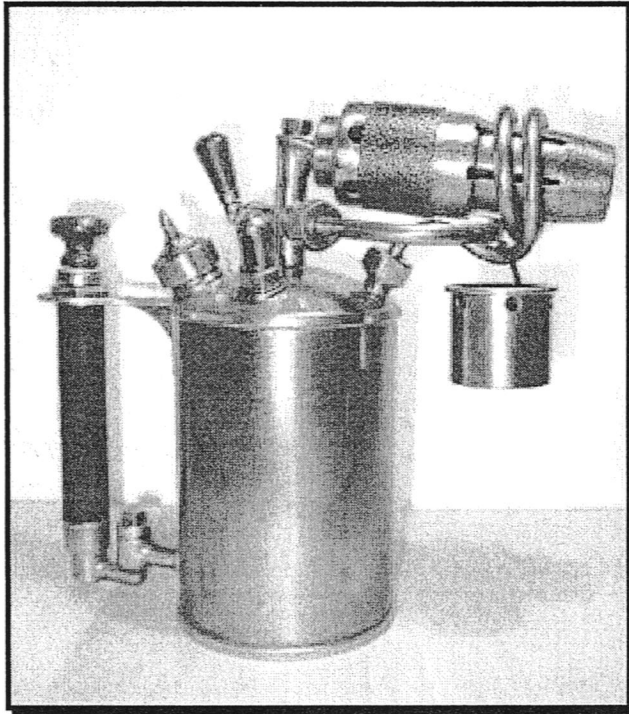
My task of finding 6 British lamps which would fall into the desirable category has proved a little more difficult, so please, anyone out there with a lamp which deserves to be included, please contact me. All I ask is for a clear photograph, against a light background and a brief description of the lamp.

THE FRENCH COLLECTION

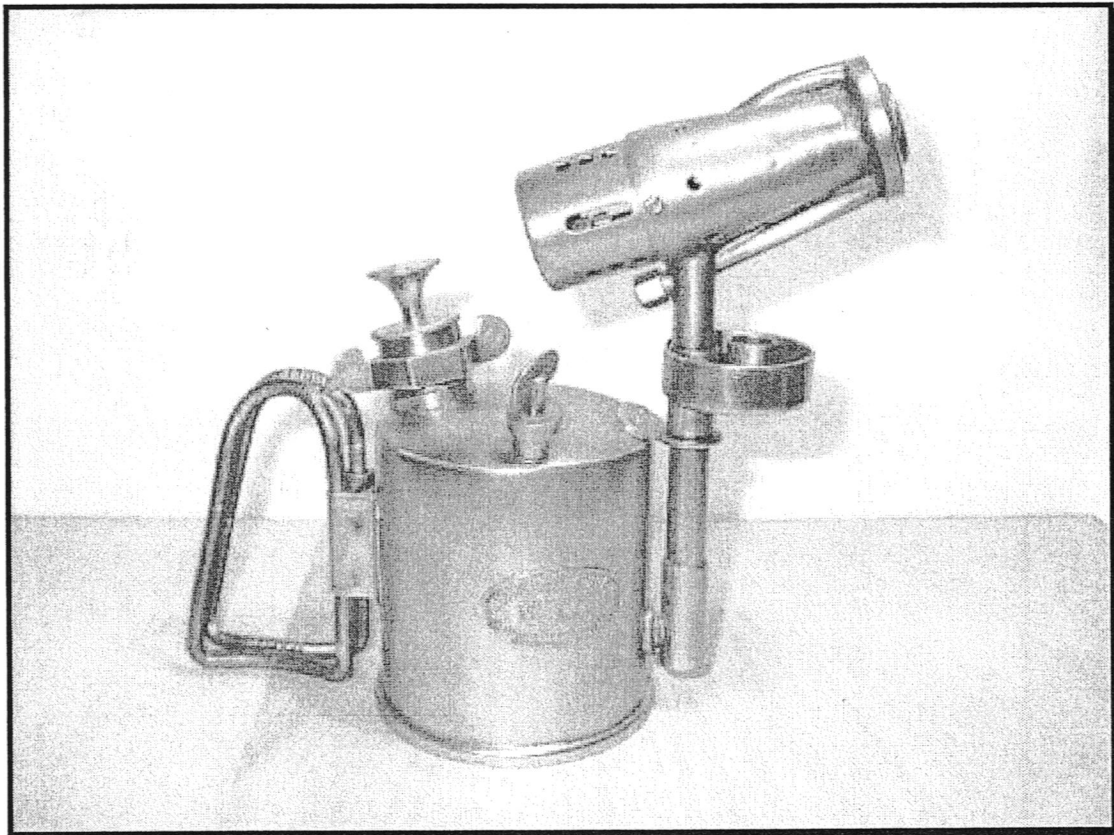


LA VITALE, manufactured by Aubert & Grollemund

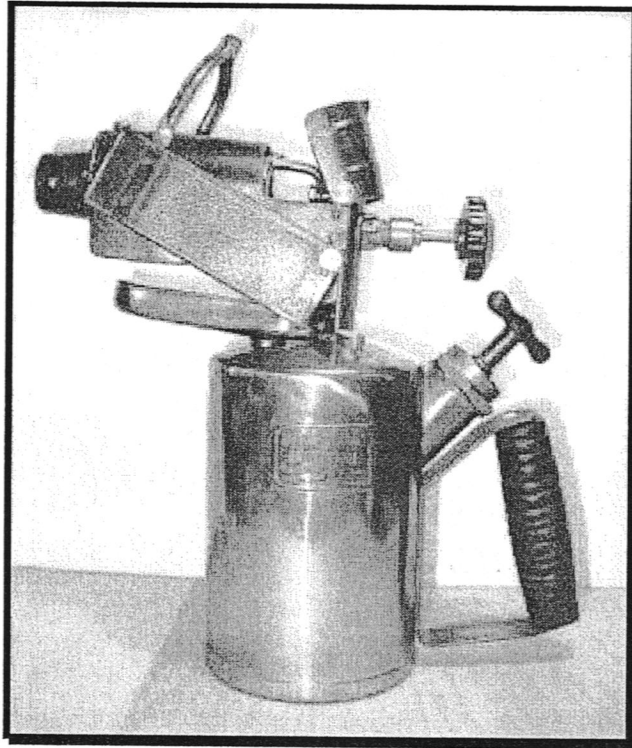
Owned by Michel Duval



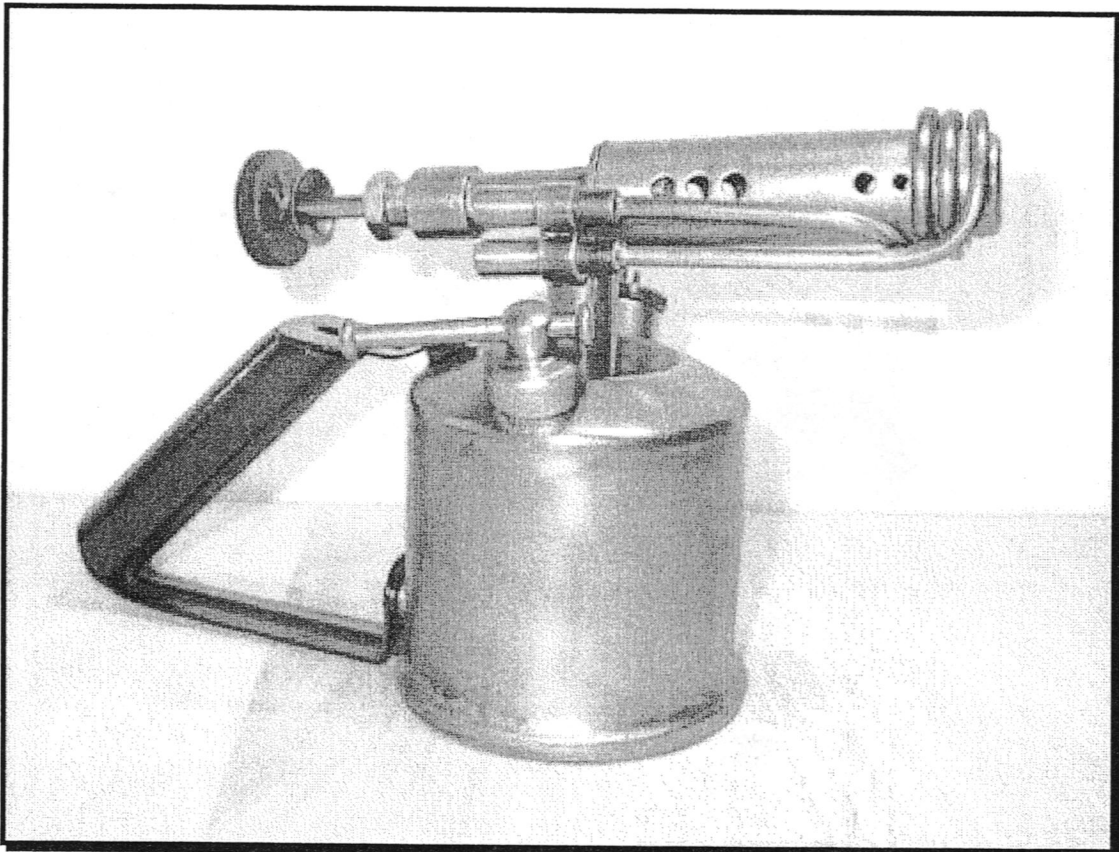
*LE VOLCAN, manufactured by E. Masson of Marseilles
Owned by Michel Duval*



*L'ARDEnte No1, manufactured by G. Forest & Cie
Owned by Michel Duval*



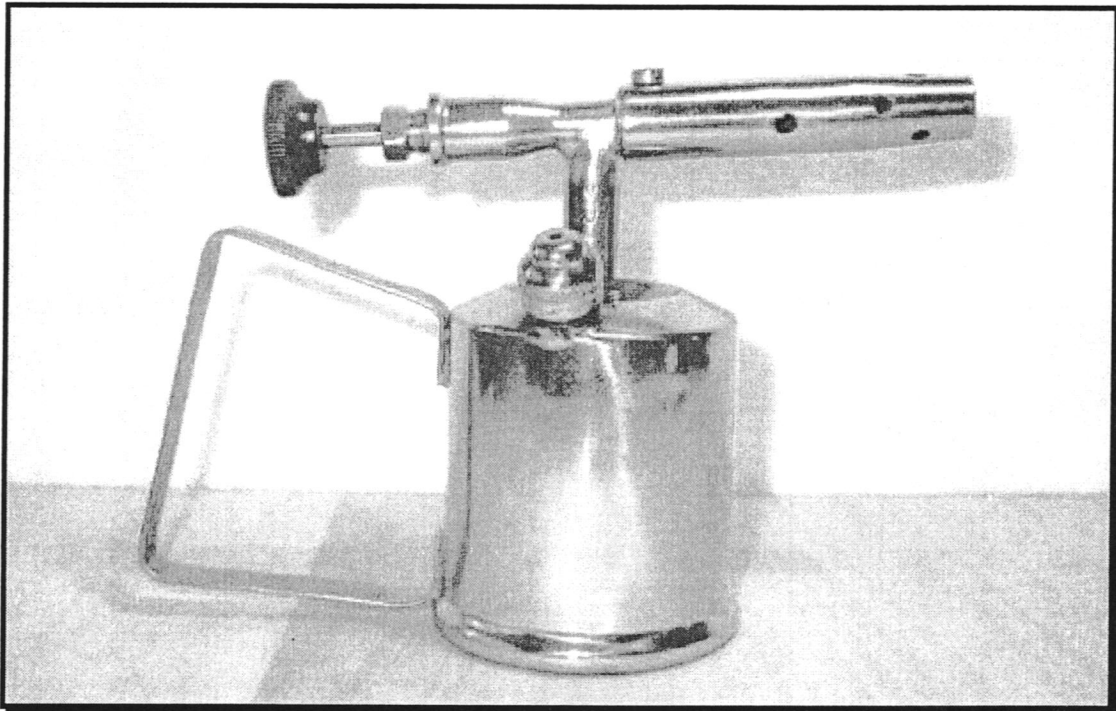
*ETNA No1, manufactured by Societe des Fours et Bruleurs Etna
Owned by Michel Duval*



*RADIA Model H – one of 3 trademarks manufactured by M. Lejeune, the others being
Canon 75 and Excelsior.
Owned by Michel Duval*



GAZ BLEU PETROLE
The only known example, owned by Robert Langlois

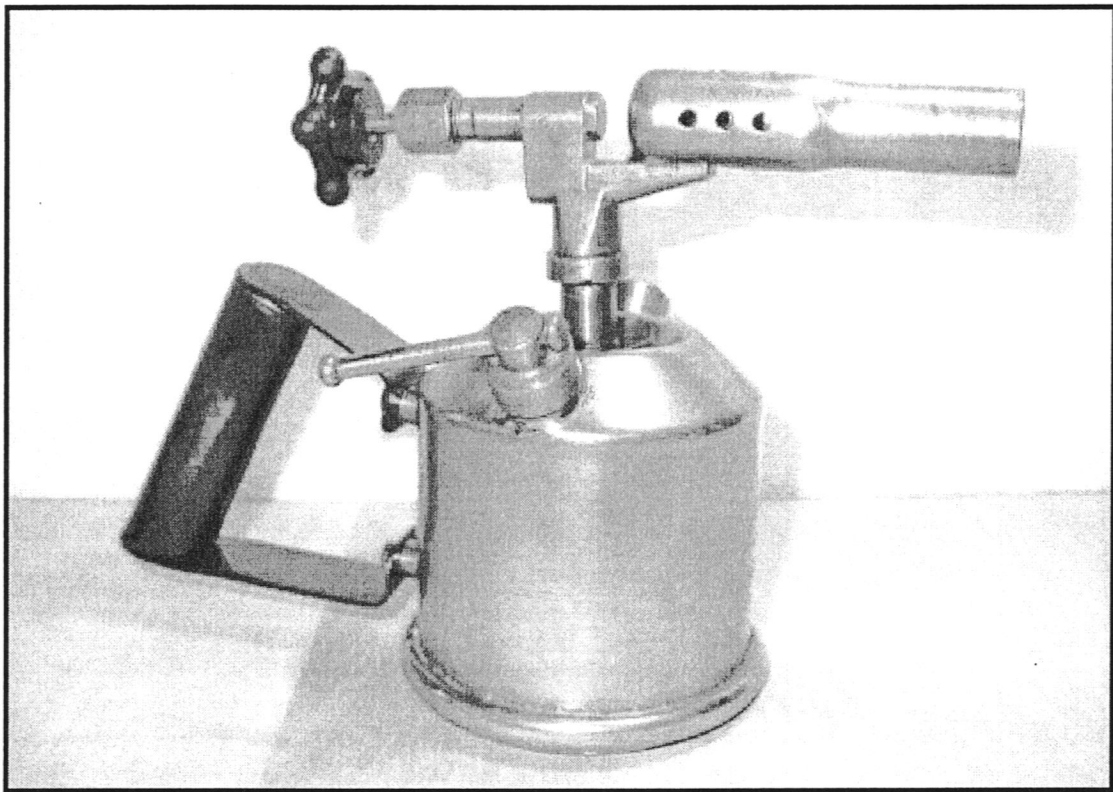


RIPPES No0
Nice simple blowlamp, hard to find. Owned by Michel Duval



PAQUELIN

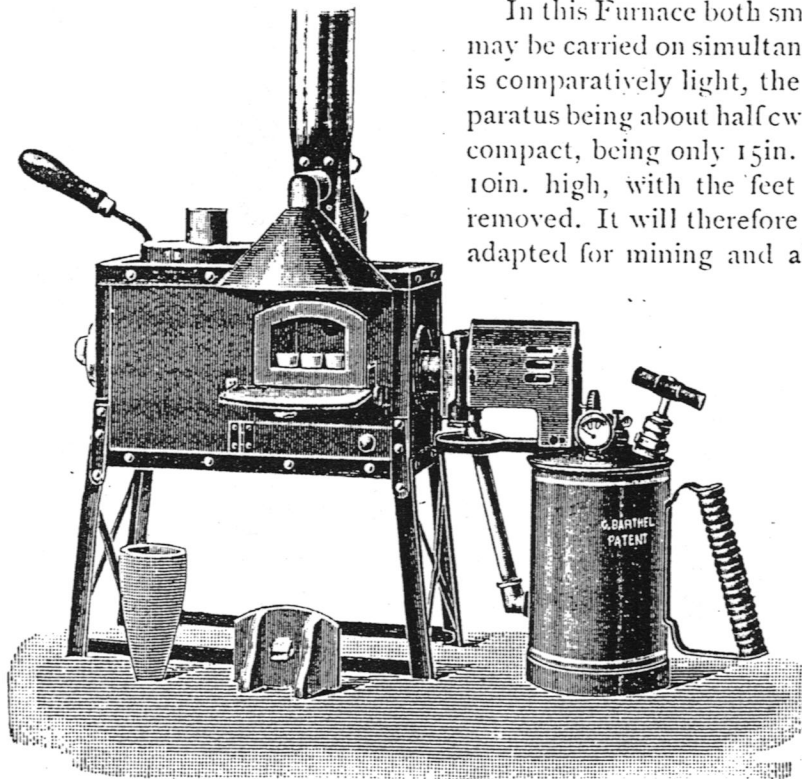
Very interesting, old blowlamp, owned by Jean-Pascal Visentin



LE SIROCCO

Made in Bordeaux, the only known example, owned by Michel Duval

THE "PROSPECTOR"
COMBINATION CRUCIBLE & MUFFLE FURNACE.



S910

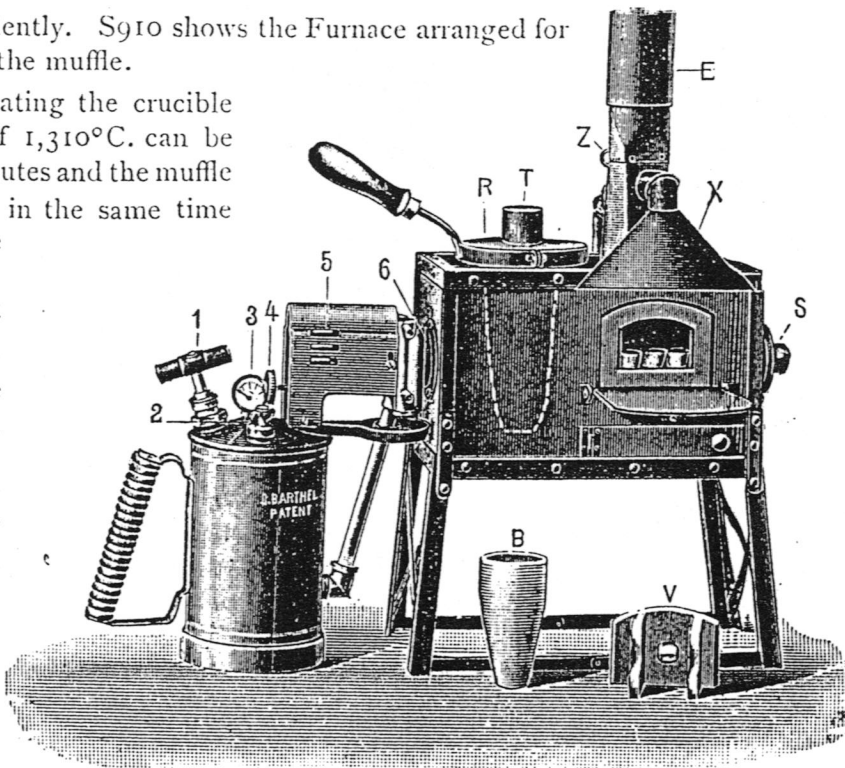
In this Furnace both smelting and cupellation may be carried on simultaneously. The Furnace is comparatively light, the weight including apparatus being about half cwt. It is also extremely compact, being only 15in. long X 9in. broad X 10in. high, with the feet folded and the pipe removed. It will therefore be found particularly adapted for mining and allied industries, more particularly as the paraffin oil blast apparatus need not necessarily be connected to a flue.

The crucible and muffle chambers are arranged side by side, and are so constructed that they may be heated simultaneously, the muffle being heated by the waste gases, or they may be

heated independently. S910 shows the Furnace arranged for directly heating the muffle.

By directly heating the crucible a temperature of 1,310°C. can be reached in 65 minutes and the muffle raised to 1,130° in the same time by utilising the waste gases.

By directly heating the muffle a temperature of 1,230°C. can be obtained in 75 minutes, but the crucible is only slightly heated by the waste gases, the temperature rising to about 500°C.



The Furnace takes a crucible 5½in. high X 3in. diameter, and the muffle 5in. long, 3¼in. broad, 2¼in. high.

Price £10 10 0

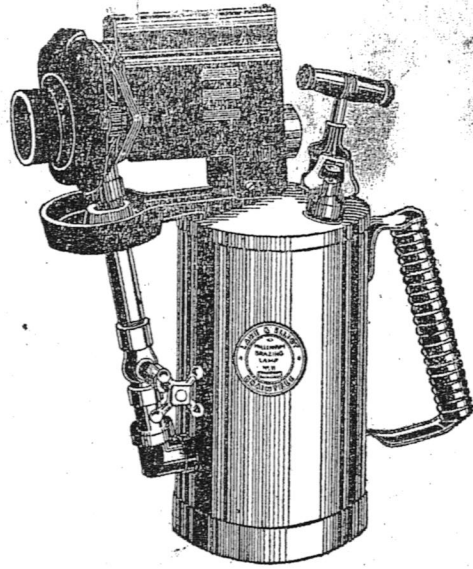
Further particulars on application.



MILLENNIUM

(No. 11)

BRAZING LAMP.



Instructions for Use.

General Remarks.—The body is of heavy gauge sheet brass. The top and base are strong stampings and the whole is carefully brazed and thoroughly tested.

The container holds the paraffin fuel and also acts as a pressure tank when air is forced in by the Pump. The gauge enables the correct pressure to be obtained for all requirements. The filler cap must be screwed tightly down at all times, and the washer renewed if worn. The filler cap is fitted with an air valve to enable the pressure to be released without taking off the cap.

The principle of working is that the burner is heated with a small quantity of ignited methylated spirit, so that when the stream of paraffin passes through, it becomes vapourized and produces a flame of intense heat.

The baffle plate in the burner is a simple yet important part. If this is missing or badly worn, the Lamp will not work.

The burner is made of best quality brass tube and is sufficiently strong for all purposes. When heated it is very fragile and the slightest blow will break it. The Lamp should therefore not be used without the protection of the hood.

The lamp is fitted with a safety pin held by a thin film of solder. If the pressure becomes too great this will blow and release the air. It should be restored by a thin film of solder before the Lamp is used again. Some users solder it heavily. In such a case it becomes nearly as strong as the Lamp and ceases to operate as a safety valve.

To Start Lamp.—Remove filler cap and fill container with good quality paraffin to within 2in. of the top. On no account use petrol, benzoline or other inflammable spirit. Replace filler cap and screw down tightly. Close oil supply valve in front of Lamp, also air valve in filler cap. Pump up to 50-lbs. pressure then open the regulator valve slightly until a small stream of paraffin comes through the nipple. This will ensure the Nipple being clean and the Vapourizer full of paraffin. Close the valve immediately and fill the spirit tray with methylated spirit and light it. When this has burned 3 or 4 minutes the Lamp will commence working by itself with the paraffin already in the vapourizer. Open the oil supply valve slightly (if open too soon or too much, unvapourized paraffin will shoot out of the nipple)

and gradually open it as the vapourizer gets hot until it gives a full flame.

If methylated spirit is not available, paraffin can be used by placing a piece of asbestos string in the spirit tray, but this causes smoke and dirt. If lighting the Lamp in a draught, place a screen round it.

To Regulate the Flame.—The flame can be regulated within certain limits by the valve, which is on the supply tube coming from the base of the Lamp to the burner. The regulation must be done slowly as the effect is not immediately shown. If only a small flame is desired lower the pressure to 15 to 20-lbs. To keep the Lamp alight with a very small flame, the flame should play on a piece of fire-brick, coke or similar substance, so that the heat is reflected on to the burner.

The Nipple.—The vapourized paraffin should shoot to the centre of the Vapourizer through the baffle plate. If it does not do so the Nipple must be cleared with the pricker supplied. It sometimes happens that a piece of loose substance gets behind the nipple, so that the pricker only pushes it back temporarily; in this case it is necessary to remove the nipple and clean it.

If the nipple is choked the flame may be directed sideways on to the burner, which it would rapidly melt, so that it is important for the jet to be clear.

The Strainer.—The Gauze strainer in the bottom of the supply tube should be examined occasionally. If dirty it should be unrolled and held in a flame until the impurities are burnt out, and then replaced.

The Tank.—This should be emptied occasionally, because most paraffin has a certain amount of dirt, water and other impurities which do not get used. If left to accumulate they will interfere with the working of the Lamp.

To Extinguish the Lamp.—Close the oil supply valve.

NEVER USE A PRESSURE ABOVE 50-LBS. FOR WORKING.

The Lamp should be Kept Clean.

BRAZING WITH BLOWLAMPS

98 METAL-JOINING PROCESSES AND OPERATIONS

Brazing Metal Parts.—Brazing is another form of hard soldering employing a less expensive but stronger alloy than silver solder. When parts are properly brazed together, the joint is practically as strong as that of the original metals. Various joints in tubes and pipes are now made by the brazing method. Thus the tubes of bicycle frames are always brazed into the lugs and socket fittings.

Copper and brass tubes are also brazed for hydraulic purposes, for the joints can be made close and strong enough to withstand water pressure.

Expensive high-speed tool steels are now hard brazed on to the iron or mild-steel shanks, in order to form the cutting edges or tips.

The alloy used for brazing is termed *Spelter* and is supplied in the granular or strip form.

There are various kinds of brazing alloys, however, consisting of copper, zinc, and tin or nickel. These have melting points ranging from 800° to 920° C. Those alloys with the *highest percentages of zinc* have the *lower melting points*, but if more than about 40 per cent. of zinc is employed the metal becomes brittle.

A good brazing alloy for high-grade work contains 63 per cent. of copper, 34 per cent. of zinc, and 3 per cent. of tin.

The higher the proportion of copper, the higher will be the melting point of the spelter.

The effect of tin in spelter is to whiten it, but tin should only be used in low percentages, for brazing iron and steel, otherwise the solder will have a deleterious effect upon these metals. It is important, for most brazing purposes, to employ an alloy having about the same composition or strength properties to those of the metals to be joined, in the case of copper and some of its alloys.

The following table gives some typical brazing solders and spelters.

BRAZING SOLDERS AND SPELTERS

Composition (percentage).				Applications.
Copper.	Zinc.	Tin.	Nickel.	
66	34	—	—	Hardest alloy; suitable for iron and steel. Hard; suitable for iron and copper.
60	40	—	—	
50	50	—	—	Ordinary spelter; suitable for brass and copper. White solders; suitable for nickel, iron, and silver.
37·5	50	—	12·5	
35·0	57	—	8·0	
57·5	25	17·5	—	White solder for brass; more fusible than spelter.

Practical Notes on Brazing.—The best flux for ordinary brazing work is borax. It is better, however, to use the fused (or calcined) borax than the ordinary type, as it is quicker in its fluxing properties. There are some good prepared fluxes of this type, known as *Brazine* and *Boron*, on the market. Compounds embodying spelter and flux are sold in cakes for convenient breaking up into pieces of suitable size. A fairly high temperature is required for brazing, so that the parts must be heated in

a muffle, furnace, or open coke hearth. For smaller work the ordinary paraffin-operated brazing lamp or a glass blowpipe is very convenient.

Figs. 50 and 51 show typical examples of brazing lamps suitable for the ordinary workshop. The former illustration shows the smaller pattern employed for light brazing (and also soft- and silver-soldering) work. Known as the "Auto" blowlamp, it burns petrol or benzoline and has a capacity of 1 pint. The nipple through which the vaporised spirit issues is automatically kept clean by means of a needle in the valve screw. This lamp gives a powerful flame, and it can be used out of doors. It measures $10\frac{1}{2} \times 8 \times 2$ inches and weighs $2\frac{3}{4}$ lb. The lamp shown in Fig. 51 is the usual pattern employed in the workshop. It has a capacity of $2\frac{1}{2}$ to 4 pints of paraffin and is started by means of methylated spirit placed in the iron cup seen below the nozzle on the left. A hand-operated pump, the barrel of which also forms the grasping handle, supplies the compressed air needed to operate this blowlamp. The latter is known as the *Marco*.

For large brazing jobs and heavy work, where a portable blowlamp is necessary, the Barthel lamp shown in Fig. 52 is particularly suitable. It is larger and more elaborate than the other types illustrated, and has such refinements as a pressure gauge, paraffin regulator with more convenient handle, and a more protected nozzle. It has a capacity, in the smaller size, of $2\frac{1}{2}$ pints and in the larger one of 5 pints.

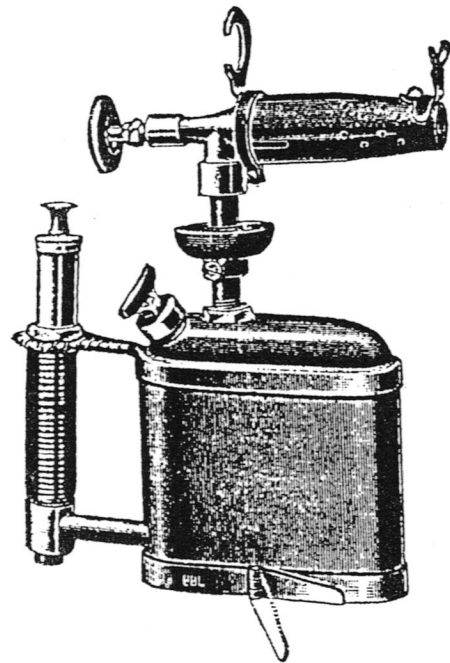


Fig. 50.—A light spirit type of blowlamp. A rest for soldering iron is provided at top.

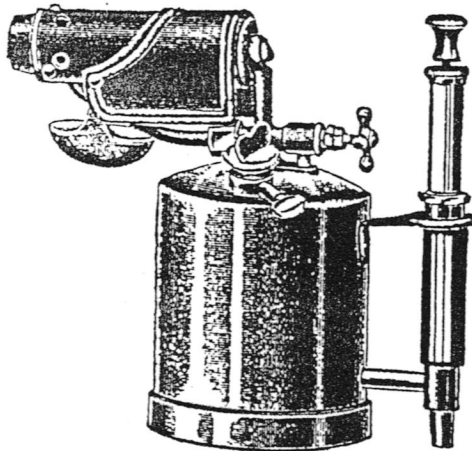


Fig. 51.—The Marco blowlamp.

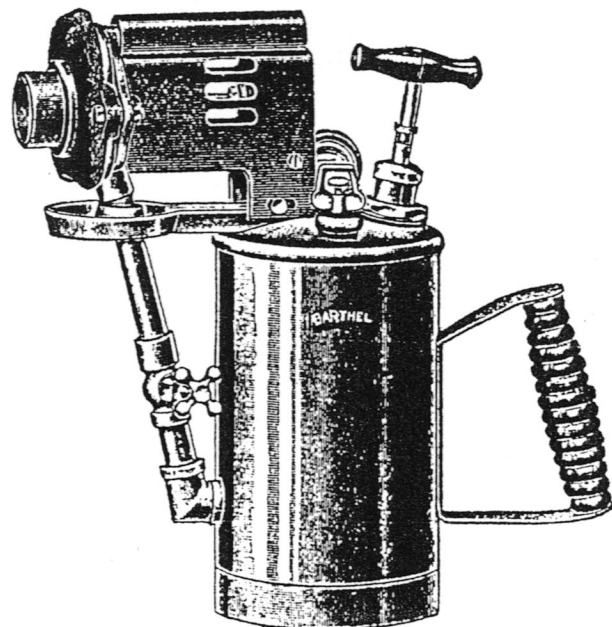


Fig. 52.—The Barthel brazing lamp.

BLOWLAMPS WITH HISTORY

Keith Hawkins has suggested this feature on blowlamps with a known history and has the following amongst his collection.

A 5 pint "HOWES & BURLEY", which spent its life in the ship building and repair workshops in Chatham Royal Dockyard.

A 2 pint paraffin "APEX" from the Cullinan prison workshop in Pretoria, South Africa.

A 2 litre "ANCHOR" brazing lamp from China, dated 1987, which was used by a special effects technician in the making of the film "Empire of the Sun".

A "HAHNEL STABIL" soldering butt, picked up just outside Tunisia in early 1943, having been discarded by the retreating "Africa Corps", by a 21 year old gunner who brewed the crew's tea with it, for the rest of the war.

A 1932 "PRIMUS 618" 6 pint brazing lamp, used until closure in the early 1960's at the Bedford lorry factory at Dunstable.

A "BERNZOMATIC" jet torch kit presented by the Chamber of Commerce in Colorado Springs, in 1976, to a friend of Keith's. A member of the Chamber of Commerce would come to your house and personally welcome you to Colorado Springs, and present you with a gift from a local supplier.

I can add two to the list from my collection:-

A 5 pint "BARTHEL DIAMANTIN" brazing lamp which was used in the Great Western Railway workshops and has a nice GWR badge on the side.

A "GOVERNOR 1916" 5 pint lamp, which was used in a quarry in Cornwall to heat the hot bulb, when starting a semi-diesel engine of an "NCK" dragline.

I also know that Max Rhodes has a nice 5 pint GOVERNOR which has an enamel British Railways badge fixed to the tank.

If any of you have blowlamps with a known history, please let me know.

RESTORATION TIPS

I am sure that we all have blowlamps in our collections with dented tanks, and I am sure many of us have made an attempt at removing the dents, with varying degrees of success.

The DIY method is OK for the skilled engineer, but for most of us I am sure we would not attempt such an exercise on a rare and expensive lamp.

John Tingle has written to me recently, with the name of a company, who have professionally restore the tanks on 2 of his lamps and have made a first rate job of them. The company are V.H.R.SILVERSMITHS (Vintage Headlamp Restoration, Limestone Cottage Lane, Wadsley Bridge, Sheffield, South Yorkshire. S6 1NJ Tel. 01142 853555)

John does not say what the costs were, but I get the feeling it might be expensive, but if it is a very special lamp, it would be worth it.

A VISIT FROM AMERICA

At the beginning of April, fellow collector and member of the Blowlamp Society, Graham Stubbs, paid us a visit while he was in England. I managed to arrange, with the help of Keith Hawkins, for a small gathering of collectors, to bring together in excess of 1000 blowlamps for Graham to see. The meeting was held at Keith's house, and most of the blowlamps were from his collection, supplemented by myself, Tom Bartlett, Ken Longden and Max Rhodes. Keith and Joan provided refreshments and everyone enjoyed the day, exchanging blowlamp stories. I am sure Graham took some happy memories back to America, along with a soldering torch, presented by Keith.



Left to right - Ken Longden, Keith Hawkins, Graham Stubbs, Tom Bartlett and Max Rhodes.

Blowlamp News is published in March, June, September and December. Any item for inclusion should be with the editor at least 4 weeks before the publication date.

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Acknowledgements – Michel Duval, Keith Hawkins and John Tingle