

# Gazetteer of operating pre-1940 breweries in England



The Brewing Industry: A Brewery History Society project  
supported by English Heritage

February 2010

Front cover: The Lees Greengate  
Brewery, Middleton Junction, Greater  
Manchester.

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Text by Lynn Pearson and Ray Anderson

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Brewery History Society, 102 Ayelands, New Ash Green, Longfield, Kent  
DA3 8JW

[www.breweryhistory.com](http://www.breweryhistory.com)

## Foreword

The Brewery History Society (BHS) was founded in 1972 to promote research into all aspects of the brewing industry, to encourage the interchange of information about breweries and brewing, and to collect photographic and other archive information about brewery history. The Society publishes a Newsletter and a quarterly journal *Brewery History*, which first appeared in 1972. It has also published a national directory and a series of county-wide surveys of historic breweries; the Society's archive is held by Birmingham Central Library. Further details of BHS activities may be found at <<http://www.breweryhistory.com>>.

The ongoing threat to the historic fabric of the English brewing industry was discussed at the conference *From Grain to Glass*, organised jointly by English Heritage (EH), the BHS and the Association for Industrial Archaeology (AIA), which took place at Swindon on 13 June 2003; the joint BHS and Victorian Society study day *From Hop to Hostelry: the brewing and licensed trades 1837-1914* (Young's Ram Brewery, Wandsworth, 25 February 2006); and during the AIA Ironbridge Working Weekend (Coalbrookdale, 29 April 2006). Following this EH agreed to support a project on 'The Brewing Industry', which was carried out between July 2007 and September 2009. Its aims were to provide up to date information on all pre-1940 operating breweries, to compile a comprehensive list of historic brewery buildings (the computerised BHS Breweries Database), to consider the future of the industry's archives, and to undertake a national assessment on the industry, in the form of a Strategy for the Historic Industrial Environment report (SHIER).

## Acknowledgements

The project steering committee comprised Jeff Sechiari (BHS Chair), Ray Anderson (BHS President), and BHS committee members Ken Smith and Mike Bone. The project researcher was Lynn Pearson, author and BHS member. Much of the groundwork was carried out by BHS members, who contributed to a survey of England's remaining brewery buildings. They included: John Arguile, David Baker, Paul Bayley, Mike Brown, Des Clarke, Neil Clarke, David Cox, Tony Crosby, George Crutcher, Geoff Dye, Philip Eley, Ray Farleigh, Robert Flood, Simon Gispert, Jenny Greenhalgh, John Hodges, Tim Holt, Peter Holtham, Ian Hornsey, Bob Inman, Malcolm James, John Janaway, Ray Kirby, Chris Marchbanks, Mary Miles, Peter Moynihan, Ken Page, Ian Peaty, Steve Peck, Pat Saunders, Mark Steeds, D. J. Taylor, Alan Walker, Jeffrey Waller, Allan Whitaker and John Williamson. The steering committee and Lynn Pearson are very grateful to all those who took part in the survey.

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Please note that all photographs are by members of the Brewery History Society unless otherwise stated. LBS = Listed Buildings System.

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## Gazetteer of operating pre-1940 breweries in England

A brewery is defined as an operating pre-1940 brewery if it has either operated on a given site before 1940 and continues to operate on that site today, or uses significant equipment manufactured before 1940.

### CAMBRIDGESHIRE

#### Wisbech

Elgood & Sons Ltd, North Brink Brewery, Wisbech PE13 1LN

Brewery listed grade II LBS 48398, 48399, 48400, 48401, 48402, 48403

BHS Breweries Database ID 19-20, 22, 24-25, 33

#### BUILDINGS

The brewery was built around 1795 by Denis Herbert of Royston, in local brown brick with slate and tile roofing; the two-storey, seven-bay main facade overlooks the river Nene. Buildings to the rear include a malting floor with large chimney. The brewery is listed grade II, as are the adjoining late eighteenth century and early nineteenth century houses, and the brewery offices. The ground floor of the offices dates from around 1800, the first and second floors being a late 19th century addition; there is a fine boardroom on the first floor.

#### PLANT

There is some pre-1940 equipment. The cast-iron underback below the mash vessel, although now containing a small stainless steel insert to catch the wort, bears the mark of the long gone 'Eagle Foundry, Wisbech' and is believed to be the hop back from the 1795 brewery. Other plant dates from the early 20th century, including (disused) open copper wort cooling trays, a malt mill, grist case (1910) and Steel's masher (1910). The copper itself is 1950s.

In 2004-5 several changes were made: the conditioning tanks, which were probably installed soon after the Second World War, were replaced by six second-hand tanks bought from a German brewery; fermenting vessels 4 and 5 were rebuilt in stainless steel, as was the hop back; and the copper racking cylinder, which had been bought at the dispersal sale of Morgan's Brewery (the Lady Bridge Brewery, Bridge Street, King's Lynn) following its closure in 1951, was replaced by a stainless steel tank bought from Cameron's, although the original post-war support frame was retained. The brewery has a capacity of 20,000 barrels per annum but produces under half of that amount. In addition to the main brewery plant there is a 10 barrel microbrewery which was installed about 1992.

#### ARCHIVE MATERIAL

Probably held at the North Brink Brewery.

#### REFERENCES

Roger Putman, 'Under the spreading chestnut tree', *Brewer & Distiller International*, 3 (5), 2007, pp65-9.

### CESHIRE

#### Burtonwood

Thomas Hardy Burtonwood Ltd, Bold Lane, Burtonwood, Warrington WA5 4TH

Brewery not listed BHS Breweries Database ID 644

#### BUILDINGS

The Burtonwood Brewery was founded in 1867, but was almost completely rebuilt on the original site in 1990. It is unclear whether any buildings of architectural or historic interest remain, although some older buildings survive at the south end of the site. These include a small block of unknown function, the brewery house and a chimney. The entire brewing operation was sold to Thomas Hardy in two elements, in 1998 and 2004; bottling ceased in March 2006 and brewing was not taking place in 2008.

#### PLANT

Equipment unknown, but the brewery was re-equipped in the 1990s and probably none of the plant is pre-1940. The brewery has a claimed capacity of c300,000 barrels per annum.

#### ARCHIVE MATERIAL

Records at the Burtonwood Brewery, see Richmond and Turton p88.

#### REFERENCES

*Burtonwood Brewery 1867-1967* (Burtonwood Brewery Co (Forshaws) Ltd, Burtonwood, 1967).

### CORNWALL

#### Helston

Blue Anchor Inn, 50 Coinagehall Street, Helston TR13 8EL

Brewery listed grade II LBS 385429 BHS Breweries Database ID 480

#### BUILDINGS

The Blue Anchor brewhouse has probably been brewing on the same site for around five centuries. This small urban brewhouse appears to be the oldest operating pub brewery in England, although the brewing kit seems to be of relatively recent date. It is one of only four surviving pre-1970 pub brewhouses to have been in more or less continuous use since they first brewed. The others are the All Nations, Madeley and the Three Tuns, Bishop's Castle, both Shropshire; and the Old Swan, Netherton, Dudley, West Midlands.

#### PLANT

The brewing equipment is small in scale and may date from before 1940, although there were improvements during the 1990s. It includes a wooden mash tun and an open cooler; it is not clear whether the latter is still in use.

#### ARCHIVE MATERIAL

None known.

#### REFERENCES

None known.

### **St Austell**

St Austell Brewery Co Ltd, 63 Trevarthian Road, St Austell PL25 4BY

Brewery not listed            BHS Breweries Database ID 468

#### BUILDINGS

The St Austell Brewery originated when Walter Hicks began brewing in the centre of St Austell in 1860, building a steam brewery on Market Square in 1869; this survives as Tregonissey House. The brewery moved to a new site on high ground, above the town, in 1893, and erected a new brewery. This 1893 brewhouse by Inskipp & Mackenzie, with its early 1900s redbrick tower, is still in use. There were additions and alterations during 1912-14. The St Austell Brewery Company was formed by a merger of Walter Hicks & Co Lt and Christopher Ellis & Son Lt of Hayle 1934.

#### PLANT

The St Austell Brewery houses what amounts to a small museum of historic brewing equipment, with plant made by many famous manufacturers including Llewellyns & James, Adlam, Nalder, Wilson of Frome and Briggs of Burton. Although output has more than doubled in the last ten years and much new equipment has been installed, in 2009 the brewery was still using its 1887 malt mill made by George Adlam and a 3.5 ton mash tun from 1913. A 2.5 ton mash vessel dating from 1893, obtained from Courage's Simonds plant (originally Crake's Tamar Brewery) in Plymouth



in 1975, was also still in use for infusion of cone hops in hot water to produce 'hop tea' for addition to the pre-clarified boiled wort. An 1893 copper was still in situ but not in use. The old fermenting vessels - 12 in number ranging from 20 to 170 barrel capacity to give a total of about 1,000 barrels - were still in place and in use. All the old wooden fermenting vessels are now lined in polypropylene and are enclosed. One of the vessels, FV 6 by Mathews & Co of London and Bristol, is an original slate vessel, and is also lined and topped. Five new enclosed 150 barrel square fermenting vessels have been installed. Brewery output is around 50,000 barrels per annum.

#### ARCHIVE MATERIAL

Records at St Austell Brewery Co Ltd, see Richmond and Turton p287.

#### REFERENCES

Liz Luck, *Brewing for Cornwall - A Family Tradition: The Story of St Austell Brewery 1851-2001* (St Austell Brewery Co Ltd, St Austell, 2001).

Roger Putman, 'Modern Warehousing west of the Tamar', *Brewer & Distiller International*, 5 (4), 2009, pp12-16.

Roger Putman, 'Cornish - and proud of it', *The Brewer International*, 1 (7), 2001, pp30-7.

## CUMBRIA

### Cockermouth

Jennings Bros plc, Castle Brewery, Cockermouth CA13 9NE

Brewery not listed      BHS Breweries Database ID 482

#### BUILDINGS

The brewery was founded at Lorton and moved to its current location in 1874. It was doubled in size in 1886, when the maltings were also expanded; the new brewery and other buildings were designed by the brewers' engineering firm of Henry Stopes (1852-1902). The extensive buildings include a landmark chimney and a substantial malthouse, now used for other purposes. The floors within the stone shell of the brewery have been removed, and the plant and buildings are supported on an internal matrix of RSJs. Jennings was taken over by Marston's plc in June 2005.



#### PLANT

Probably does not contain pre-1940 equipment. The plant is generally of stainless steel, from the 1980s and later. Brewery capacity is around 35,000 barrels per annum.

#### ARCHIVE MATERIAL

Records at Cumbria Record Office and Local Studies Library, Whitehaven (YDB 28) and the Castle Brewery, see Richmond and Turton p197.

#### REFERENCES

Roger Putman, 'Lakeland's best kept secret', *The Brewer International*, 1 (4), 2001, pp26-31.

Nigel Watson, *The Taste of the Lake District: The Story of Jennings Brothers plc* (St Matthews Press, Leyburn, 2003).

## DORSET

### Blandford St Mary

Hall & Woodhouse Ltd, Blandford St Mary, Blandford Forum DT11 9LS

Brewery not listed      BHS Breweries Database ID 80, 483

#### BUILDINGS

The firm was founded in 1777 at Ansty and acquired Neame & Trewof Blandford St Mary in 1883, operating on both sites until a new brewery was built at Blandford in 1899-1900 by the brewers' engineers Arthur Kinder & Son, then run by Harold Kinder. This was a substantial red brick block with two 25 quarter plants; the Ansty brewery closed around 1900. The firm was registered on 8th June 1898 to acquire Hall & Woodhouse of Ansty and Blandford and Godwin Brothers, Durweston. The firm, which now trades as the Badger Brewery,



intended to build a new brewery on the same site in 2007-8 and transfer all production from the 1900 brewery. However, economic considerations delayed the development, which was still under discussion in late 2008, although outline planning permission had been granted for the old brewery site. Listing applications for the old brewery have been rejected.

#### PLANT

Although the brewery was modernised soon after the Second World War, it still contains pre-1940 equipment including the original copper, installed in 1899; the mash tuns, which date from 1914; the Morton's Steel's masher - a device named after James Steel, a 19th century Glasgow brewer - which dates from around 1900; and two old wooden 120 barrel polypropylene lined and covered fermenting vessels. These items are still in normal use. Annual output is around 135,000 barrels.

## ARCHIVE MATERIAL

Records at Hall & Woodhouse Ltd and Dorset History Centre, Dorchester; see Richmond and Turton p165.

## REFERENCES

Roger Putman, 'Mr Badger brews at Blandford', *The Brewer International*, 1 (11), 2001, pp18-24.

### **Bridport**

J. C. & R. H. Palmer Ltd, The Old Brewery, West Bay Road, Bridport DT6 4JA

Brewery listed grade II LBS 403409-12 BHS Breweries Database ID 74, 669, 670, 671

#### BUILDINGS

The Old Brewery was established on the site in 1794, although a former rainwater head was dated 1833. The two-storey main block is built of stone with a thatched roof and finials in the form of barrels; the three-storey west block is also of stone. There is a tall red brick chimney stack.

#### PLANT

Contains pre-1940 equipment. At the rear of the brewery is a large (18 feet in diameter, weight 6 tons) breast undershot water wheel made by Helyear's Bridport foundry in 1879; it is still in good working order and drives a water pump. Inside the brewery is a vertical steam engine by Bram and May of Devizes, which works a water pump and drives a sack hoist. Much of the equipment in the brewery – the wood-clad 1.5 ton mash tun; the copper underback; the open copper; the unusual vertical open copper cooler for wort (no longer in use); and the wooden (polypropylene lined) round fermenting vessels - is of uncertain age but has the appearance of being pre-1940. Annual output is around 7,000 barrels.

#### ARCHIVE MATERIAL

Probably held at Palmers Old Brewery.

#### REFERENCES

Tim Heald, *Palmers: The story of a Dorset Brewer* (J. C. and R. H. Palmer, Bridport, 2008).

Roger Putman, 'Brewing on the Jurassic Coast', *The Brewer & Distiller International*, 4 (12), 2008, pp32-6.



## DURHAM

### **Hartlepool**

Camerons Brewery Ltd, Lion Brewery, Hartlepool TS24 7QS

Brewery not listed BHS Breweries Database ID 88, 392, 484

#### BUILDINGS

The Lion Brewery, which is unlisted, was built in 1892. Earlier works at the brewery include the construction of a 20 quarter brewery in 1875 by Henry Wilson & Co of the Phoenix Works, Stockton on Tees; and the addition of a new maltings in 1883 designed by the brewers' architect William Bradford. The interior of the new brewhouse, built in 1971, is lined with white Italian marble and has a mezzanine floor approached by stairs with decorative ironwork including hop flower motifs. One of the lion sculptures in painted stone, mounted on a plinth to the east of the brewery, is listed grade II (LBS 432928) and dates from around 1852 when the brewery was founded by William Waldon. The other similar but later sculptures are not listed.



#### PLANT

Probably does not contain pre-1940 equipment, but does contain the last example of the revolutionary but unsuccessful Strainmaster mash vessel left in Britain, which was installed in 1971 and is still in operation. The brewery plant, along with that of Thwaites of Blackburn, is a rare surviving example of largely intact 1960s to early 1970s brewery technology of a type that will never be installed again. There are twelve 160 barrel open square fermenters. In addition to the main brewery plant there is a 10 barrel microbrewery

installed in the old engineers store, which had once been the brewery stables. The brewery capacity is about 0.5 million barrels, although actual output is less than half of that.

#### ARCHIVE MATERIAL

Records at the Lion Brewery.

#### REFERENCES

Roger Putman, 'At the home of the Hartlepool Head, the Lion's Den and ... the monkey', *The Brewer International*, 3 (8), 2003, pp22-7.

### EAST SUSSEX

#### Lewes

Harvey & Son (Lewes) Ltd, The Bridge Wharf Brewery, 6 Cliffe High Street, Lewes BN7 2AH

Brewery listed grade II\* LBS 293022 BHS Breweries Database ID 92

#### BUILDINGS

The Bridge Wharf Brewery was rebuilt in 1881-2 for Harvey's; the architect was William Bradford and the size of the plant was 20 quarters. A four-storey tower rises above lower blocks, and there is a tall octagonal chimney; there have been many extensions and alterations. The Georgian fermenting room, cellars and vat house are still in use but house modern equipment. There is a 1985 brewhouse extension, and a new boiler house opened in 2003.

#### PLANT

May contain pre-1940 equipment; a malt mill and mash tun survive, as well as a steam engine (not in use) by Pontifex and Wood. A second brew line, traditional in layout, was installed in 1985 and the original line has a new (1999) copper, made entirely from copper. The output of the brewery is about 45,000 barrels per annum.



#### ARCHIVE MATERIAL

Records at Bridge Wharf Brewery, see Richmond and Turton p173.

#### REFERENCES

M. A. Jenner, *Harvey & Son, Bridge Wharf Brewery, Lewes: Bicentenary Year* (Harvey & Son, Lewes, 1990).

Roger Putman, 'A glass of Jenner's Sparkling Ale is good enough for me', *The Brewer & Distiler*, 1 (2), 2005, pp40-5.

### GLOUCESTERSHIRE

#### Donnington

Donnington Brewery, Upper Swell, Stow-on-the-Wold, Cheltenham GL54 1EP

Brewery listed grade II LBS 130211, 130212 BHS Breweries Database ID 128-9

#### BUILDINGS

The nineteenth century Donnington Mill and adjoining Arkell's Brewery (late 18th to early 19th century) are both built of Cotswold stone. The two-storey, four-bay brewery is rectangular in plan. Arkell's Donington Ales was established on this site in 1865. Since 2007 ownership of the brewery has been in the same hands as Arkell's Kingsdown Brewery in Swindon.

#### PLANT

Contains pre-1940 equipment. Until 1959 all power was supplied by two water wheels, which are still in use for mashing, pumping and lifting. In 2002 the oldest of the two water wheels on the end of the building acted as a standby, with the work being done by an enclosed 8 feet diameter breast shot wheel. The brewery equipment is arranged on four floors: a small Boby four roll mill (from Ruddles Brewery) on the top floor feeds a mash tun on the floor below, which is run off to an open underback on the next floor, from where the wort is pumped up to the top floor and open copper. The latter sits on the original coal fired brick plinth and feeds an open copper hotback on the mash tun floor. The brewhouse vessels are of uncertain age; the six 18 barrel fermenters are modern stainless steel.

#### ARCHIVE MATERIAL

Records at Donnington Brewery, see Richmond and Turton p48. Two mid twentieth century photographs of the brewery (one interior) held by Gloucestershire Archives, Gloucester (ref D2600/1/60-61).

#### REFERENCES

Roy Bailey, 'A legacy of love', *Beer*, 7 (2010) Spring, pp16-21.

Roger Putman, 'Britain's most picturesque brewery?', *The Brewer International*, 2 (3), 2002, pp40-4.

## GREATER LONDON

### Hounslow

Fuller, Smith and Turner plc, Griffin Brewery, Chiswick Lane South, London W4 2QB

Brewery not listed BHS Breweries Database ID 411

#### BUILDINGS

The late eighteenth century central part of the Griffin Brewery (now offices) was built as the owner's residence; the staircase and ground floor boardroom date from the eighteenth century. The brewery buildings, which are not listed, were largely rebuilt in 1979-81, although some picturesque parts remain.

#### PLANT

Probably does not contain pre-1940 equipment. Annual output is around 290,000 barrels.

#### ARCHIVE MATERIAL

Records at London Metropolitan Archives (ref ACC/0891), see Richmond and Turton p150.

#### REFERENCES

Andrew Langley, *London Pride: 150 Years of Fuller, Smith and Turner* (Good Books, Melksham, 1995).

### Richmond upon Thames

Anheuser-Busch UK, Stag Brewery, Lower Richmond Road, Mortlake, London SW14 7ET

Brewery not listed BHS Breweries Database ID 413

#### BUILDINGS

The Mortlake Brewery was founded in the 15th century, had become a substantial commercial brewery by 1765, was rebuilt in 1869 and sold to Watney's in 1889. It was renamed the Stag Brewery after the closure of Watney's Stag Brewery, Pimlico in 1959. The High Street frontage, which included the bottling hall, was built in 1869. The other significant structure is the 8 to 9 storey landmark malt house of 1903 on the river frontage, for which a listing application was being made in mid 2009. In fact this is the remains of a rather larger building - the kilns have been demolished - which has been disused since the late 1960s. Other mid 19th century and later parts of the brewery were mostly demolished during the 1970s and replaced by a modern industrial plant (1979-81) designed by Douglas Marriott Worby & Robinson. A stone relief of a stag still decorates one of the 1970s entrance buildings. The brewery is to close in 2010.



#### PLANT

Probably does not contain pre-1940 equipment.

#### ARCHIVE MATERIAL

Records at City of Westminster Archives Centre (Watney Combe Reid & Co Ltd, ref 789) and London Metropolitan Archives (ref ACC/1290, ACC/1399, ACC/2979); see Richmond and Turton p354.

#### REFERENCES

Hurford Janes, *The Red Barrel: A History of Watney Mann* (John Murray, London, 1963).

## GREATER MANCHESTER

### Cheetham

Joseph Holt Ltd, The Brewery, Empire Street, Cheetham, Manchester M3 1JD

Brewery not listed BHS Breweries Database ID 470

#### BUILDINGS

Holt's Derby Brewery in Cheetham, not far north of Victoria Station, is a functional brick-built structure dating from 1860; it was remodelled in 1890 with further work in 1901. The brewery was extended on its cramped 3 acre site in 1979 and again in 1992, with the addition of a large block. The office, with its pedimented stone doorcase, was originally the home of Joseph Holt, built for him next to the brewery.

#### PLANT

May still contain some pre-1940 equipment no longer in use, but the working plant is relatively modern with much



replacement over the last decade or so. A new 30-barrel mini-brewhouse with 4x30 barrel enclosed square fermenters was installed within the main brewery in 2002.

#### ARCHIVE MATERIAL

Records at Joseph Holt Ltd, see Richmond and Turton p185.

#### REFERENCES

Roger Putman, 'Hogsheads, hops and Holts', *The Brewer International*, 1 (6), 2001, pp26-31.

Neil Richardson, *A History of Joseph Holt* (Neil Richardson, Manchester, 1984)

Keith Sheard, 'Holts heats up', *The Brewer & Distiller International*, 3 (1), 2007, pp25-8.

Keith Sheard, 'Holt installs new 30-barrel mini brewery', *The Brewer International*, 2 (5), 2002, pp41-2.

### Middleton Junction

J. W. Lees & Co (Brewers) Ltd, Greengate Brewery, Oldham Road, Middleton Junction, Manchester M24 2AX

Brewery not listed          BHS Breweries Database ID 471

#### BUILDINGS

The Greengate Brewery is a very good example of a small, traditional brewery complex and dates from 1876 (the brewing tower) and 1883 (offices); it is brick-built with a little polychromy, and unusual carved brickwork around some windows. There is a great deal of louvred ventilation. The buildings are grouped around a yard, and the former stables are now used for various storage functions. The interior of the tower has had few alterations.



#### PLANT

Most of the brewing equipment was replaced in the 1980s and 1990s. The working plant in the brewhouse is modern; two open (lined) fermenting rounds with parachutes survive amongst modern covered stainless steel vessels. An internal heating coil from an old copper has been retained and is on display in the brewhouse, along with one of the plates from the copper, by Robert Ryder of Manchester. A mill by Robert Bobby still functions (although altered), while its predecessor is now held by the Manchester Museum of Science & Industry. Near the top of the brewing tower, in the mill room, is a step ladder in the form of two planks with footholes, fixed to the wall.

#### ARCHIVE MATERIAL

Records at Greengate Brewery, see Richmond and Turton p208.

#### REFERENCES

Michael Parsons, 'The John Lees legacy', *The Brewer International*, 4 (1), 2004, pp22-8.

### Moss Side

Hydes Brewery Ltd, 46 Moss Lane West, Manchester M15 5PH

Brewery listed grade II LBS 388335

BHS Breweries Database ID 169

#### BUILDINGS

The Anvil Brewery was built for Greatorex Brothers as the Queen's Brewery in 1861. Hydes Brewery was established about 1863 at the Crown Brewery, Audensha; the firm then moved three times before moving to the present brewery in July 1899 Hydes Anvil Brewery, of red brick with stone dressings, comprises several ranges of mostly two-storey buildings grouped around a large courtyard. The gateway has ornate piers. The complex is unusually complete and relatively unaltered, although there were some Edwardian additions and there was a major fire in 1959.

#### PLANT

Contains pre-1940 equipment. There is a pleasing timber framed, probably c1900, mill room with a Robert Boby 4-roll malt mill of similar vintage, and a single (little used) original oak (metal lined) fermenting round in the centre of the upper fermenting floor. The rest of the plant comprises Briggs 1991 brewhouse equipment and 1980s/90s fermenters. Output is about 90,000 barrels per annum.

#### ARCHIVE MATERIAL

Records at Hydes Brewery Ltd, see Richmond and Turton p191.

#### REFERENCES

Roger Putman, 'A Manchester Brewer', *The Brewer*, 86, no 1033, 2000, pp446-51.



### Moss Side

Scottish & Newcastle UK, Royal Brewery, 201 Denmark Road, Manchester M15 6LD

Brewery not listed

BHS Breweries Database ID 685

#### BUILDINGS

Founded as the Albert Brewery in 1875, it became the Red Tower Lager Brewery Ltd, Royal Brewery in 1933 and was bought by Scottish Brewers in 1956. The site has been expanded and redeveloped in successive waves since the early 1960s and it is doubtful if any significant parts of the earlier structures remain beneath the metal cladding.

#### PLANT

Does not contain pre-1940 equipment. Although the site housed the first conical fermenters to be installed in a British brewery, around 1933, these have long since gone. The current plant all dates from the 1970s and later.

#### ARCHIVE MATERIAL

Papers concerning the acquisition of the Red Tower Lager Brewery by Scottish Brewers are at the Scottish Brewing Archive, University of Glasgow Archive Services, see Richmond and Turton p289.

#### REFERENCES

Roger Putman, 'A right Royal visit', *The Brewer & Distiller International*, 3 (9), 2007, pp62-7.



### Stockport

Frederic Robinson Ltd, Unicorn Brewery, Stockport SK1 1JJ

Brewery not listed

BHS Breweries Database ID 472

#### BUILDINGS

The Unicorn Brewery stands on a central site in Stockport which has been developed and expanded by the firm since the 1860s, with a significant enlargement in 1890, a new bottling department in 1908 and new offices around 1913. The present red brick brewhouse, six storeys with a seven-storey tower, was built in

1925-9; the top of the tower displays a red unicorn in low relief on each of its four sides. The new brewhouse was equipped with the most modern plant available, supplied by Robert Morton & Co of Burton upon Trent.

#### PLANT

Contains pre-1940 equipment. Plant from the 1920s includes a Seck malt mill (secondhand when bought and complete with a set of spare rollers in their original box); one of a pair of coppers and the Steel's masher may be of similar vintage. New equipment was to be installed in the brewhouse in 2009 alongside kit dating from the 1920s, which will probably remain in situ and in use.

#### ARCHIVE MATERIAL

Some archive material is held at the Unicorn Brewery.

#### REFERENCES

Lynn F. Pearson, *The History of Robinson's Brewery* (MNC Publishing, Hale, 1997).

Roger Putman, 'Stockport Family Robinson', *The Brewer & Distiller*, 1 (8), August 2005, pp62-7.

## HERTFORDSHIRE

### Hertford

McMullen & Sons Ltd, 26 Old Cross, Hertford SG14 1RD

Brewery listed grade II LBS 461346 BHS Breweries Database ID 199

#### BUILDINGS

Brewing is currently carried out in the Whole Hop Brewery, opened in 2006 at the south-east corner of the McMullen's site, which also includes a disused brewery erected in 1984, and the 1891 Old Brewery (closed since 1995), which is listed grade II and was designed by William Bradford. This five-storey red brick tower, originally three bays but later extended to five bays, is topped by a lantern with timber louvres and an ornate ironwork crown. The main buildings have king post trussed roofs and cast iron columns. The area containing the Old Brewery and the 1984 brewery was sold to Sainsbury's in February 2007. Sainsbury's plans for a supermarket on the site, which appear to include refurbishment of the Old Brewery, were passed by East Hertfordshire Council's Development Control Committee in February 2009, after a 2008 plan for a larger store had been withdrawn. A report (Anderson, 2005) was produced recommending which items of kit should be retained, while a second report (Crosby, 2007) concentrated on the building itself.

#### PLANT

A new 20,000 barrel capacity brewery - the Whole Hop Brewery - was opened in 2006; this does not contain pre-1940 equipment. Another new brewery with lager brewing capability and a annual capacity of 100,000 barrels had been opened in 1984 and was closed in 2006; it also contained no pre-1940 equipment. The Old Brewery, which does contain pre-1940 equipment, is extant with its equipment intact but has been closed since 1995. In 2005 plant included two mash tuns (one of which is in part original), two coppers (one in part original but considerably modified) and fifteen fermenters, all but two clad in oak or pine. Six are original cylindrical c100 barrel capacity, oak-clad with iron rings and were made by Wilson & Co of Frome. These vessels have at some stage each lost their parachute skimming apparatus and gained copper linings, and more recently plastic tops and front panels. There is one much smaller circular oak fermenting tun, of around 25 barrel capacity, towards the centre of the house. This is also missing its parachute, but has not been copper lined or been given any plastic fitments. The six pine-clad square fermenters made by Briggs of Burton upon Trent and Adlam & Sons of Bristol are not original but probably pre-1940. The hoist mechanism is still in situ on the third floor. The splendid elevator is as originally placed with its Jacob's ladder of metal buckets (probably tin) on a leather belt carrying the grist from the mill to the grist case three floors above. At the time of opening, the 1891 brewery included a new mashing machine designed by one of the proprietors, comprising a vertical cast iron cylinder containing an Archimedean screw with perforated blades and a hollow spindle, which emitted liquor; however, this has not survived.

#### ARCHIVE MATERIAL

Records at McMullen & Sons Ltd, Hertford.

#### REFERENCES

'The McMullen legacy', *The Brewer & Distiller*, 2 (10), 2006, pp35-7.

'Focus on McMullen and Sons Limited', *The Brewer*, 71, no 848, 1985, pp216-8.

R. G. Anderson, *McMullen & Sons Ltd, Old Brewery, Hertford: A Survey and Assessment of Brewing Equipment* (Unpublished report, May 2005).

Tony Crosby, *McMullen & Sons Brewery, Hartham Lane, Hertford: A survey and assessment of the site and structures* (Unpublished report, June 2007).

A. J. Skipper, 'How McMullen's brought more beer to Hertford', *The Brewer's Guardian*, 113 (2), 1984, pp19-24.

## KENT

### Faversham

Shepherd Neame Ltd, 17 Court Street, Faversham ME13 7AX

Brewery not listed      BHS Breweries Database ID 422, 980

#### BUILDINGS

The brewery was founded in 1698, although brewing has been carried out on the site since at least 1570 and possibly 1520. Although many of the buildings are modern, much of the 19th century structure remains. As datestones attest, the brewhouse was built in 1864, when the firm was known as Shepherd & Mares. It also carries datestones, presumably from other buildings, reading 'SS 17(4?)8' for Samuel Shepherd and 'HS 1842' for Henry Shepherd. The central clock tower was built in 1890 (or possibly during the 1890s). The Millennium Brewhouse, an extension of the 1864 brewhouse which opened in 2000, includes two stained glass windows with beer and brewing motifs by Keith and Judy Hill of Staplehurst in Kent. The ornate office building on Court Street displays hop motif decoration on its facade. Its northern section, including the doorway, was built in 1869; it was extended in 1900 by altering the building immediately to the south in matching style. The entire combined building is listed grade II (LBS 175891).

#### PLANT

The plant includes two traditional mash tuns made of gunmetal and English oak which have a combined capacity of 300 barrels; they date from 1914 and 1916 and are still in regular use. The destoner was bought

secondhand in 1920. Two steam engines survive in working order, although they are no longer used in the brewing process. All fermentation is in modern cylindro-conical vessels and the brewery capacity is 220,000 barrels a year. The site also houses an attractive 4-barrel microbrewery formerly used at the Simonds Brewery Social Club in Reading.

#### ARCHIVE MATERIAL

Records at Shepherd Neame Ltd, see Richmond and Turton p294.

#### REFERENCES

'Focus on Shepherd Neame Ltd', *The Brewer*, 76, no 913, 1990, pp486-9.

Theo Barker, *Shepherd Neame: A story that has been brewing for 300 years* (Granta Editions, Cambridge, 1998).

Roger Putman, 'Britain's oldest brewery', *The Brewer & Distiller International*, 5 (1), 2009, pp34-9.



## LANCASHIRE

### **Blackburn**

Daniel Thwaites plc, Star Brewery, PO Box 50, Syke Street, Blackburn BB1 5BU

Brewery not listed            BHS Breweries Database ID 583

#### BUILDINGS

The brewery occupies a large site on Penny Street in Blackburn. The tall, flat-roofed 1966 brewhouse tower is surrounded by lower, shed-like structures. There appears to be little of architectural interest.

#### PLANT

The Star Brewery probably does not contain pre-1940 equipment, but it does have the first external calandria to be installed (during the 1960s) in a British brewery. The brewery, along with Camerons of Hartlepool, is a surviving example of largely intact 1960s to early 1970s brewery technology of a type which will never be installed again. The Briggs brewhouse comprises a mash mixer with a Steel's masher, two mash tuns, two coppers, two hop separators and two whirlpools. The brewery houses 23 open stainless fermenting vessels (10 of which are Yorkshire squares) ranging in size from 60 to 360 barrels. In addition there are 22 conical vessels. Brewed volume is around 275,000 barrels a year and about another 150,000 barrels of other brewers' beers are packaged under contract.

#### ARCHIVE MATERIAL

Records at Star Brewery, see Richmond and Turton p332.

#### REFERENCES

Roger Putman, 'A taste of Lancashire', *The Brewer International*, 3 (10), 2003, pp18-23.

Jehanne Wake, *Thwaites: The Life and Times of Daniel Thwaites Brewery, 1807-2007* (Scotforth Books, Lancaster, 2007).

### **Burnley**

Moorhouse's Brewery (Burnley) Ltd, The Brewery, Moorhouse Street, Burnley BB11 5EN

Brewery not listed            BHS Breweries Database ID 797

#### BUILDINGS

The firm was established in 1865 as a mineral water manufacturer. Moorhouse's moved to their present site in 1870, building new premises which incorporated stables. For much of its existence the firm produced special beers for use in the manufacture of shandy and so-called non-intoxicating 'hop bitters'. Production of traditional ale began in 1978. The brewery is a small, two-storey building.

#### PLANT

Some equipment dates from around 1900. One open copper brewing kettle was originally used in a jam factory in the 1930s.

#### ARCHIVE MATERIAL

None known.

#### REFERENCES

Michael Parsons, 'Moorhouse's Brewery', *The Brewer*, 84 (1005), August 1998, pp357-8.

## LINCOLNSHIRE

### **Stamford**

Melbourn Brothers, All Saints Brewery, All Saints Street, Stamford PE9 2PA

Brewery listed grade II    LBS 193456            BHS Breweries Database ID 234

#### BUILDINGS

Melbourn Brothers was established in 1825 and moved to the All Saints Brewery, which was already a successful common brewery, in 1869. Following a large fire in 1876 the brewery was rebuilt and fitted with steam operated equipment; brewing then continued until 1974. It was restored in the 1990s, reopened in 1994 and now produces fruit beers. The brewery is owned by Samuel Smith of Tadcaster. The complex of brewery buildings, with its tower and prominent chimney, is grouped around a central courtyard.

#### PLANT

Historic equipment includes a 1910 steam engine and 1876 mash tun.

#### ARCHIVE MATERIAL

None known.

#### REFERENCES

Michael Jackson, 'The ghost in the glass', *Independent*, 8 May 1999.

Martin Smith, *Stamford Pubs and Breweries* (Spiegl Press, Stamford, 2006).

## Wainfleet

George Bateman & Son Ltd, Salem Bridge Brewery, Wainfleet PE24 4JE  
Brewery listed grade II LBS 420243 BHS Breweries Database ID 231

### BUILDINGS

George Bateman began brewing in Wainfleet in 1872 or 1873, buying the present site - the Salem Bridge Brewery - in 1876; he was brewing there by 1880. The mainly 19th century premises include a six-storey brick-built tower mill with a castellated tower topped by a large weathervane in the shape of a beer bottle. The tower mill was purchased in 1918 and used initially as a bottling shed.

### PLANT

Historic brewing equipment includes a mash tun of 1898 and a 1923 riveted concave bottom copper. Stainless steel open square fermenters were introduced in 1952, replacing the former carriage cask system. Other changes to equipment and buildings were completed by 1955. A new brewhouse, equipped with new and secondhand plant, was opened in 2002 but the vessels from the former brewhouse are still in use, although for seasonal brews only. Annual output is around 25,000 barrels.

### ARCHIVE MATERIAL

Records at Salem Bridge Brewery, see Richmond and Turton p60.

### REFERENCES

Steve Andrews, 'George Bateman and Son: Lincolnshire's last brewery', *Brewery History*, Part 1, 115, Summer 2004, pp7-25; Part 2, 116, Autumn 2004, pp2-17; Part 3, 117, Winter 2004, pp2-26.  
Roger Putman, 'Ten out of ten to Bateman's', *The Brewer International*, 2 (8), 2002, pp32-6.

## MERSEYSIDE

### Liverpool

Robert Cain Brewery, Stanhope Street, Liverpool L8 5XJ  
Brewery listed grade II LBS 359562 BHS Breweries Database ID 238

### BUILDINGS

Cain's Mersey Brewery was developed in several stages. The rear section was begun for the brewer Robert Cain around 1875, with work by brewers' engineers Gregory & Haynes of Salford in 1879, an addition designed by the architect James Redford in 1887 (including a 100 quarter plant by Thomas Ryder & Co of Manchester), and another new plant by Ryder & Co in 1893. The elaborate five-storey front section, with its red brick and Ruabon terracotta facade, was built in 1896-1902; the architect may have been Walter W. Thomas, who designed several pubs for Cain's. The end result is a series of decorative towers stepping upward towards a tall stack, this central block being divided from the street on two sides by substantial, lower, arcaded ranges with heavily ornamented cornices, much roof ventilation and lavish fenestration.

The Grapes Inn (the brewery tap) on the street corner was embellished with terracotta roundels and grape motifs. The terracotta is heavy with Cain's monogram and symbols, hops above five crosses, and a gazelle. The brewery was sold to Higson's in 1923, and the new owners changed the terracotta work to include their name; this can easily be seen from the side elevation where plain bricks have been substituted for the previous lettering. The interior of the front section (completed 1902) was faced throughout with glazed bricks, all now overpainted apart from those in the top floor hop store, where there is white glazed brickwork with a pale blue dado and arched openings picked out in brown.

The brewery closed in 1990 but reopened under new ownership soon afterwards before again running into difficulties, passing to the Danish Brewing Group and reverting to its pre-Higson's name of Robert Cain & Co Ltd in January 1992. The Danes in turn pulled out at the end of 2001. Cains was bought by the Dusanj brothers in September 2002. The company went into administration in August 2008 but reappeared less than two months later as the DRC Beer Company (Dusanj Robert Cains) with the same ownership. It continues to be known publicly as the Robert Cain Brewery.



## PLANT

Probably does not contain pre-1940 equipment. The Huppmann brewhouse plant dates from 1982. Fermenters are either covered stainless steel squares for ales or conicals for lagers. Brewery capacity has been quoted as approaching 400,000 barrels a year but output is less than half of that.

## ARCHIVE MATERIAL

Records at Merseyside Record Office, Liverpool (Walker-Cain Ltd, ref M380PWK) and Robert Cain & Co Ltd, see Richmond and Turton p180.

## REFERENCES

Norman Cook, *Higson's Brewery 1780-1980* (Higson's Brewery Ltd, Liverpool, 1980).

Roger Putman, 'The Cain scrutiny', *The Brewer International*, 3 (12), 2003, pp22-7.

Christopher Routledge, *Cain's: The story of Liverpool in a pint* (Liverpool University Press, Liverpool, 2008).

## NORTH YORKSHIRE

### Masham

Black Sheep Brewery plc, Wellgarth, Masham, Ripon HG4 4EN

Brewery not listed          BHS Breweries Database ID 486

## BUILDINGS

Brewing began in 1992 when the Black Sheep Brewery was established in the unlisted stone-built maltings of the former Lightfoot's Wellgarth Brewery. This substantial building, later used as a grain store, lies within Masham Conservation Area. It is a landmark structure standing high above the river Ure

## PLANT

Contains some equipment sourced from defunct breweries. The brewing copper, mash tun and hop back came as a matched set from the former Hartley's Brewery at Ulverston in Cumbria; they had been supplied by Ramsden of London in 1948. Three Yorkshire square fermenting vessels came from Hardy's & Hansons at Kimberley, near Nottingham, and later three more from the former Darley's Brewery at Thorne near Doncaster. These are fabricated from slate and are pre-1940. New fermentation capacity in stainless steel - all Yorkshire squares in principle of operation but uniquely actually round - were added in 1995 and have been joined by a second mash tun, copper and hop back. The new stainless steel copper is housed inside a 1947 copper (made of copper) which may be viewed from the visitors' gallery. Annual output is around 70,000 barrels.



## ARCHIVE MATERIAL

None known.

## REFERENCES

Tony Duckworth, 'Keeping it simple at the Black Sheep Brewery', *The Brewer*, 86, no 1025, 2000, pp160-3.

Roger Putman, 'A'ewe-nique' experience', *The Brewer & Distiller International*, 3 (1), 2007, pp26-31.

### Masham

T. & R. Theakston Ltd, The Brewery, Masham, Ripon HG4 4YD

Brewery not listed          BHS Breweries Database ID 477

## BUILDINGS

Robert Theakston took on the Black Bull pub at Masham in 1827. He began to brew at the pub, building a brewhouse to the rear in 1840; these buildings are now the brewery's visitor centre. The present brewery was built in 1870-5; it is a small stone-built tower complex standing within Masham Conservation Area.

## PLANT

The brewery no longer has a steam engine, but its original belts, wheels and gears still drive the 1913 malt mill by Porteus of Leeds. There may be other pre-1940 equipment. The brewery continues to employ a craft cooper.

## ARCHIVE MATERIAL

Records at T. & R. Theakston Ltd.

## REFERENCES

None known.



### **Tadcaster**

Molson Coors Brewing Company (UK) Ltd, Tower Brewery, Station Road, Tadcaster LS24 9JR  
Brewery not listed            BHS Breweries Database ID 689

#### **BUILDINGS**

This is a modern brewery on the site of Tadcaster Tower Brewery. Almost all the Molson Coors Tower Brewery buildings date from the mid 1960s, although the base of its original 1883 tower - last used for brewing in 1966 - is still thought to be in place; it formed part of the boiler house in the 1990s.

#### **PLANT**

No pre-1940 equipment.

#### **ARCHIVE MATERIAL**

Probably with Molson Coors.

#### **REFERENCES**

Will Swales, *The History of the Tower Brewery Tadcaster* (Bass Brewers Ltd, 1991).

### **Tadcaster**

Scottish & Newcastle UK, John Smith's Brewery, High Street, Tadcaster LS24 9SA  
Brewery listed grade II    LBS 326015, 326022-6  
BHS Breweries Database ID 256-9, 262, 818

#### **BUILDINGS**

John Smith's Brewery (listed grade II in six sections) was designed by the brewers' architects Scamell & Colyer of London and built in 1882-3. It comprises a series of interconnected ranges of buildings up to seven storeys in height in golden Yorkshire sandstone, with an octagonal-plan chimney around 65 metres in height. There is much elaborate ironwork ornament. The brewery stands within Tadcaster Conservation Area.

#### **PLANT**

The original equipment installed in 1883 included two 40 quarter mash tuns, coppers heated by open fires, and two large open copper coolers; the fermenting room housed 173 slate squares. New brewhouse vessels were installed in 1937. There was much capital investment following 1970 when the firm became part of Courage Ltd. A new brewhouse and canning plant opened in 1977, and a lager brewery was added in 1979. The brewhouse equipment was again renewed in the 1980s and was extended after the brewery became part of Scottish & Newcastle in 1995, since when £50 million has been spent on increasing capacity; the plant brews around 2.75 million barrels a year. The slate fermenting squares were last used in 1975, but two of them have been preserved behind a glass screen. Some slate vessels also remain in a low headroom space beneath the floor which once housed the Yorkshire squares; what their function was is unclear. All other fermentation vessels are conicals, the stainless steel Yorkshire squares having been removed in the 1980s.

#### **ARCHIVE MATERIAL**

Records at John Smith's Brewery, see Richmond and Turton p304.

#### **REFERENCES**

Michael Parsons, 'John Smith's Brewery Tadcaster', *The Brewer*, 84, 1988, no 1007, pp427-31.

Roger Putman, 'John Smith's is 250', *The Brewer & Distiller International*, 5 (2), 2009, pp32-7.

### **Tadcaster**

Samuel Smith Old Brewery (Tadcaster), High Street, Tadcaster LS24 9SB  
Brewery not listed            BHS Breweries Database ID 478

#### **BUILDINGS**

The Old Brewery comprises a substantial collection of mostly brick buildings of varying ages lying within Tadcaster Conservation Area. The main tower - perhaps dating from around 1900 - is six storeys in height, with some stone dressings; it is topped by an ornate weathervane. A tall, black circular cross-section chimney stands to the rear, while adjacent are several lower brick ranges.



#### PLANT

Contains pre-1940 equipment: there is at least one old copper, wood and copper mash tuns, and fermenting takes place in slate squares. There is also a (probably) Victorian control console. The original well, sunk in 1758, is still in use.

#### ARCHIVE MATERIAL

None known.

#### REFERENCES

None known.

#### OXFORDSHIRE

##### Hook Norton

Hook Norton Brewery Co Ltd, The Brewery, Hook Norton, Banbury OX15 5NY

Brewery listed grade II LBS 244021-4 BHS Breweries Database ID 281-3, 292

#### BUILDINGS

The brewery was established on the site around 1850 and a three-storey tower brewery erected about 1872. The present brewery, which incorporates the earlier structure, was built in 1898-9 and designed by brewers' architect Wiliam Bradford of London; it is a typical example of his ornate decorative style with the emphasis on mock timbering - as in the sack hoist housing - and triangular dormers. The brewery comprises a single-storey copper house, the brewhouse tower (part six storey and part four storey), and a four-storey fermenting house. There is also a stable block (1894), offices (1896) and a malthouse, with other ranges to the rear of the brewery. Currently the brewery is listed grade II in four sections: brewhouse, stables, offices and malthouse. Given the almost unchanged nature of the brewhouse, it would appear to be at least on a par with what is at present the only II\* listed operational brewhouse, at Harvey's Bridge Wharf Brewery in Lewes (East Sussex).

#### PLANT

Contains pre-1940 equipment; there is also a museum containing much old equipment from the brewery. The 25 hp steam engine, supplied by Buxton & Thornley of Burton upon Trent, was installed in 1899 and is still in daily use, as are the original Buxton & Thornley water pumps. There is a Steel's masher (c1900), a 1900 Waygood lift, and a grist mill supplied by Nalder & Nalder of Wantage in 1900. The latter was already outmoded when it was installed and is the only surviving example of its type in a British brewery; the malt is screened immediately prior to milling and separated into large and small grains which are sent to two pairs of rollers set at different gaps. There is an even older stone grinding malt mill from the 1872 brewery in the corner of the mill room. A copper coolship, in use until 2004, survives in one of the pyramid roofs of the brewhouse. The 80 barrel open copper was heated directly by a coal fire until the 1970s and is fed by an underback which is split into two compartments; the latter would have allowed wort to be fed to different coppers and permitted retention of last runnings of wort for flushing of the coppers as they were emptied, as a guard against charring from the direct firing. Two plastic lined round wooden fermenters survive amongst later stainless steel additions. Annual output is around 20,000 barrels.

#### ARCHIVE MATERIAL

Records at Hook Norton Brewery, see Richmond and Turton p186; and at Oxfordshire Record Office (not listed online).

#### REFERENCES

David Eddershaw, *A Country Brewery: Hook Norton 1849-1999* (Hook Norton Brewery Company, Hook Norton, 1999).

Roger Putman, 'Hooked on steam', *The Brewer International*, 3 (6), 2003, pp38-42.



## Witney

Wychwood Brewery Ltd and Brakspear Brewing Co, Eagle Maltings, The Crofts, Witney OX28 4DP  
Brewery not listed BHS Breweries Database ID 485

### BUILDINGS

The Clinch's Brewery (closed 1961) site was bought in 1983 and the Eagle Brewery - renamed Wychwood in 1990 - started in the cellar of the maltings building. Wychwood Brewery took on the brewing of Brakspear beers in 2002, following the closure of Brakspear's Henley brewery. Wychwood and Brakspear were bought by Marston's plc in March 2007.

### PLANT

The original Brakspear fermenting vessels and copper dome were installed at the Witney site in 2004. The present copper comprises the upper part of the original Brakspear's vessel (made from copper and said to date from 1774) with a new bottom section. The Brakspear Fermenting Room houses six 75-barrel square fermenters, with two further wood-clad 40 barrel circular collection vessels placed above them. This arrangement allows the use of the dropping system once common in British breweries but now seldom seen, with the fermenting wort in the two smaller vessels 'dropped' after some 15 hours to a single larger vessel below to continue fermentation.

### ARCHIVE MATERIAL

Brakspear records are held at the Oxfordshire Record Office (not listed online); see Richmond and Turton p79.

### REFERENCES

Roger Putman, 'A refreshing alternative', *The Brewer International*, 4 (7), 2004, pp9-13.

Francis Sheppard, *Brakspear's Brewery, Henley-on-Thames* (Brakspear, Henley-on-Thames, 1979).

## SHROPSHIRE

### Bishop's Castle

John Roberts Brewing Co Ltd, Three Tuns Brewery, 16 Market Square, Bishop's Castle SY9 5BN  
Brewery listed grade II LBS 256980 BHS Breweries Database ID 293

### BUILDINGS

Brewing was first carried out on the site in the 17th century. The brewery and adjoining store (where brewing used to take place) next to the Three Tuns Inn are listed grade II. The three-storey tower brewery was built between 1880 and 1888 by the John Roberts family, and is a rare survival of a small working rural brewery. The Roberts continued brewing until the 1970s, but several periods of closure followed until the pub and brewery were taken over by a group of local residents in 1996. In January 2003 the brewery was bought by the John Roberts Brewing Co Ltd. It is one of only four surviving pre-1970 pub brewhouses to have been in more or less continuous



use since they first brewed. The others are the Blue Anchor, Helston, Cornwall; All Nations, Madeley, Shropshire; and the Old Swan, Netherton, Dudley, West Midlands.

### PLANT

Most of the original fittings still remained in the early 21st century, including grit hoppers and a liquor tank in the attic, the mash tank on the second floor, the rare open copper cooler on the first floor, and fermenting vats on the ground floor. The boiler was coal-fired until the mid 1990s. However, a new five-ton brewing kettle was installed in March 2009, part of upgrading plans carried out in 2008-9 which cost over £250,000; the fate of the original plant is unclear.

### ARCHIVE MATERIAL

None known.

### REFERENCES

None known.

## **Madeley**

Worfield Brewing Co, All Nations Brewhouse, 20 Coalport Road, Madeley TF7 5DP

Brewery listed grade II LBS 361862 BHS Breweries Database ID 605

### **BUILDINGS**

The All Nations Inn is dated 1789. It is one of only four surviving pre-1970 pub brewhouses to have been in more or less continuous use since they first brewed. The others are the Blue Anchor, Helston, Cornwall; the Three Tuns, Bishop's Castle, Shropshire; and the Old Swan, Netherton, Dudley, West Midlands. The pub closed around 2000 but reopened in 2003, when Worfield Brewing arranged with the new owners to brew at the pub.

### **PLANT**

The copper was originally coal-fired. The very basic kit, of unknown date, that was remaining in 2000 has been incorporated with newer equipment brought in by Worfield. It is now a ten-barrel plant.

### **ARCHIVE MATERIAL**

None known.

### **REFERENCES**

None known.

## **STAFFORDSHIRE**

### **Burton upon Trent**

Molson Coors Brewing Company (UK) Ltd

Burton Brewery, 137 High Street, Burton upon Trent DE14 1JZ and White Shield Brewery, Horninglow Street, Burton upon Trent DE14 1YQ

Brewery listed grade II

LBS 272977, 272979, 272983, 272988, 273036, 273037, 273042, 273065

BHS Breweries Database ID 316, 321-3, 325-6, 607, 886

### **BUILDINGS**

Bass, Ratcliff & Gretton Lt was founded in 1777 by William Bass. The original brewery, eventually known as the Bass Old Brewery, grew up to the east of the High Street and was reconstructed in 1884-5; it was demolished in 1971, although the water tower (1866, listed grade II) and offices (listed grade II) remain. The second (Middle) Brewery was built on the north side of Station Street in 1853-8 - its brewhouse was demolished in 1960 - and the third (New) Brewery on the south side of Station Street in 1863-4. The firm merged with Worthington & Co Ltd in 1927, then with Mitchells & Butlers Ltd in 1961, forming Bass, Mitchells & Butlers Ltd. Bass



Charrington Ltd was created in 1967 in a merger with Charrington United Breweries. The company was bought by Interbrew in 2000 and sold to Coors, now Molson Coors Brewing Company (UK) Ltd, in 2002.

The Coors estate includes part of the site of the former Allsopp's New Brewery (1859-60, listed grade II). It was designed by architects Hunt & Stephenson of Westminster in combination with consultant engineer Robert Davison and the firm's own engineers, and was said to be the largest brewery in the world at the time. The main block is in use as offices and completely separate from the Coors site, but a new brewery was built to the north-east in 1963. There is also a recent brewhouse and associated plant, along with a large (60 barrel) model or pilot brewery with a 1950s copper-vee-seled brewhouse in the former Allsopp's building; this was known as the Samuel Allsopp Brewery in the 1990s when it produced a range of seasonal beers for sale, but is now disused. The fine Ind Coope brewhouse and water tower complex, and associated offices (all listed grade II) are part of the Coors estate. Erected in 1854-6 with additions of 1896-8, these buildings are now used for storage and as offices. The elegant entrance block of c1865 is known as the Guildhall and provides space for corporate hospitality.

Currently, brewing operations at Molson Coors Burton Brewery take place on part of the Allsopp's New Brewery site, and on the neighbouring Bass New and Middle Brewery sites. The old Bass brewery end of the 117 acre site is now officially known as 'Burton South' with the Ind Coope/Allsopp end designated

'Burton North', even though the breweries are actually east and west of each other. The total capacity is around 6 million barrels. The Middle Brewery was developed for industrial-scale brewing from the 1960s onward and there have been many demolitions and alterations, especially in 2002-3 following the acquisition by Coors. The dramatic concrete bridge crossing Station Street carries wort and services between the Middle and New breweries. Despite its grade II listing (still available online as LBS 273036), much of the New Brewery was demolished in 1984-5. However, it still retains some original buildings, although a new brewery was added in the 1960s. The stone gate piers (listed grade II, LBS 273037) have been moved to another part of the site, apparently for safety reasons.

Coors is also responsible for the White Shield Brewery, a microbrewery housed in the former Coors Visitor Centre (closed June 2008, previously Bass Museum of Brewing). The Visitor Centre occupied what was originally the Bass Middle Brewery joiner's shop (1866, listed grade II) and other nearby buildings; it is to be reopened as the National Brewery Centre in April 2010. Production of White Shield is to be moved to the Burton North site, with the White Shield Brewery vessels being retained as an exhibit at the National Brewery Centre, which will also have its own working 30-barrel brewing plant.

#### PLANT

The Bass Middle Brewery site is thought to retain some pre-1940 equipment and the Samuel Allsopp brewery retains a single wooden copper-lined 19th century fermenting round. The White Shield Brewery was built in 1920, although some elements date back to the 1850s - there are two rarely used copper fermenting vessels with 1853 on the dip plate - as the plant originally formed the experimental brewery at the Mitchells & Butlers Cape Hill Brewery, Smethwick. The plant includes a Steel's masher, a copper mash tun, a steam copper, a vertical cooler and open fermenting squares. The Coors Visitor Centre collection included many historic items, such as a 1905 steam engine made by Robey & Co of Lincoln, a 19th century copper from the New Brewery, a 1889 Hansen pure culture yeast propagator and a complete union fermentation set.

#### ARCHIVE MATERIAL

Records were still at Molson Coors Brewing Company (UK) Ltd and Coors Visitor Centre (see Richmond and Turton p58) in July 2009. The Allied Breweries, Allsopp's and Ind Coope records formerly held at Allied Breweries in Burton were transferred to the Coors Visitor Centre in 2003, see Richmond and Turton pp41,43,191. Following the closure of the Visitor Centre in June 2008, it was thought that these archives might be moved to the Staffordshire and Stoke-on-Trent Archive Service, but it appears (in early 2010) that they will remain at what is to be the National Brewery Centre, due to open in April 2010.

#### REFERENCES

Pete Brown, 'Shield of Dreams', *Beer*, 7 (2010) Spring, pp6-13.

Colin C. Owen, *'The Greatest Brewery in the World': A History of Bass, Ratcliff & Gretton* (Derbyshire Record Society, Chesterfield, 1992).

Roger Putman, 'Inside Britain's biggest brewery', *The Brewer International*, 3 (5), 2003, pp58-67.

Roger Putman, 'White Shield's coming home', *The Brewer International*, 1 (3), 2001, pp26-31.

#### Burton upon Trent

Marston, Thompson & Evershed, Marston's Brewery, Shobnall Road, Burton upon Trent DE14 2BW  
Brewery listed grade II LBS 273031, 273061, 273062

BHS Breweries Database ID 313, 314, 328

#### BUILDINGS

Marston's Brewery was built in 1875 for Mann, Crossman & Paulin as the Albion Brewery, a large pale ale brewery; Martin & Rawlings of Nottingham were responsible for the buildings, plant and machinery. The



site is over 30 acres. The frontage separated from the road by Shobnall Brook includes workers' cottages, and office buildings partly built in 1875. This was subsequently developed, possibly around 1900, by building a bridge housing a panelled boardroom over the main gate, a worker's cottage and large house originally accommodating the head brewer. The southern boundary on the Trent and Mersey Canal has a remaining girder from the rail bridge which linked the brewery to the Midland Railway via the Bass Shobnall siding. An original locomotive shed remains and the layout of various railway lines is discernible following loading docks and accessing key delivery and despatch points. Some track remains under tarmac in the yard areas. The sports field to the north has seven wells, two linked by underground tunnel possibly constructed in 1875. Other wells on the site from 1875 include a 1000 feet bore tube, and an engine house of c1900. The brewery was bought by what is now Marston's plc (then Wolverhampton & Dudley) in 1999.

The central brewing tower and remaining chimney is of red brick and varies between two and four storeys in height. The four-storey area houses brewhouse plant dating from between 1875 and the 1980s, which is now largely disused. The original two-storey hop store, wort collection, fermenting and cask racking areas, with floors and original remaining wooden framed union set removed, now houses a modern brewhouse upgraded in 2004 after consultation with English Heritage. Fragments of other buildings of between 1873 and the 1920s include parts of the original coopers shop, cask washing shed, cask ales stores (cellar infilled), stables (now used as coopers shop), engineers shops and wines and spirits store (now open plan offices). Other remaining pre-1920 buildings are used for beer conditioning and bottling, including the cellar, and now incorporate the visitors centre.



#### PLANT

The site retains the last working examples of union sets, which are required for the Burton Union fermentation system. The 2004 development of the brewhouse involved the removal of much equipment from the fermenting end of the brewery block, including 27 wood and cast iron stainless lined collection vessels; 16 fermenting vessels of varying sizes and vintages, including some obtained from the old Charrington's brewery in Burton in the 1920s; and a 140-barrel double union fermentation set. The latter was placed in storage awaiting promised re-erection as an exhibit at a later date; however, its current status is unknown. In 2006 there were no plans to remove the old, and now unused, brewhouse equipment which includes a copper (made from copper) complete with a coal firing hearth, together with other pre-1940 plant. The new brewhouse equipment is 1985 vintage stainless steel transferred from the former Mansfield brewery. The main fermentation room, Union Room Number 1, comprises 28 enclosed squares from which fermenting wort is transferred after some 36 hours into six 100-barrel union sets for cleansing. A set comprises 26 unlined wooden casks, in two rows of 13. Another room, the Alpin Room (1990), contains a further four 120-barrel union sets.

#### ARCHIVE MATERIAL

Records at Marston's Brewery, see Richmond and Turton p228.

#### REFERENCES

Khadija Buckland and Eric Fower, *A Brewer of Pedigree: A celebration of Marston's, its people and beers* (M. W. F. Hurdle, Derby, 1999).

Roger Putman, 'A brewer of Pedigree', *The Brewer & Distiller*, 2 (2), 2006, pp20-1.

#### SUFFOLK

##### **Bury St Edmunds**

Greene King plc, Westgate Brewery, Bury St Edmunds IP33 1QT

Brewery listed grade II LBS 466793, 466794, 467712, 467713, 467714

BHS Breweries Database ID 332-4, 904-5, 907

#### BUILDINGS

Greene King occupies a central site in Bury St Edmunds, the oldest part of the brewery complex being the 16th and 17th century outbuildings on the corner of Westgate and St Mary's Square. The brewhouse is a six-storey neo-georgian red brick pile built in 1936-9. The design was by the London brewery engineer Mark Jennings in combination with Greene King's head brewer, Colonel B. E. Oliver, and the firm's usual suppliers, Adlam's of Bristol and Briggs of Burton upon Trent. In 1980 Greene King added a racking plant designed by Michael Hopkins Associates. Its concrete floor is raised on piling above the water meadows on

which the plant stands, allowing flood water to pass safely beneath. The building is clad in silver-coloured coated steel. A new bottling hall was built in 2007.

#### PLANT

The brewhouse is said to retain most of its original 1939 brewing machinery. In 1996 the maltings still contained the first drum malting plant installed by the local engineering firm Robert Boby. An old copper is set into the pavement outside the brewhouse, which has modern stainless steel vessels as well as copper vessels dating from early 1939; there were later additions to plant by Morgans of Norwich, and transferred from Morland's of Abingdon (taken over in 1999). The brewhouse now houses two 4-roll Boby mills serving three mash tuns, which feed four coppers. In 2005-6 the mash tuns were rebuilt and fitted with stainless steel wedge-wire bases and modern control equipment. The original geometry of all three vessels has been maintained (although the new ones are somewhat larger) and they have been clad with copper and fitted with new copper domes for aesthetic reasons. The vessels were supplied and fabricated on site by the Scottish firm Forsyth's of Rothes. Fermentation is predominantly in modern conical vessels. Smaller round lined wooden vessels of uncertain age are used for fermentation and maturation of 'old ales'.



#### ARCHIVE MATERIAL

Records at Westgate Brewery, see Richmond and Turton p159. Bedfordshire and Luton Archives and Record Service, Bedford, holds the Greene King (Biggleswade) Archive, ref GK. There are also photographs (mainly) of Biggleswade pubs (ref X758); see also ref Z50/16. Suffolk Record Office, Bury St Edmunds Branch, has photographs of brewery, including interior, taken 1950-1 (ref K564/1-272, see also ref K960/3).

#### REFERENCES

*A Modern Brewery* (Greene King & Sons Ltd, Bury St Edmunds, 1954).

John Bexon, 'New mash tuns at Greene King as well', *The Brewer & Distiller*, 2 (7), July 2006, pp28-30.

Ian Hornsey, 'Inside one of Britain's new super regionals', *The Brewer & Distiller International*, 3 (8), 2007, pp33-6.

Ken Page, *Greene King, Biggleswade Brewery 1764-1984* (Biggleswade, 1984).

Richard G. Wilson, *Greene King: A Business and Family History* (Bodley Head and Jonathan Cape, London, 1983).

### Southwold

Adnams plc, Sole Bay Brewery, East Green, Southwold IP18 6JW

Brewery not listed            BHS Breweries Database ID 335, 902, 903

#### BUILDINGS

The unlisted Adnams Sole Bay Brewery in Southwold was rebuilt in 1897 for Adnams by the London firm of brewers' architects and engineers Inskipp & Mackenzie. They incorporated most of the older building in the new work, and enlarged the brewhouse. There have been several alterations since, most recently to allow for the introduction of the Huppmann brewhouse. Two houses associated with the brewery are listed grade II (LBS 484764). The firm's environmentally friendly distribution centre (2005-6) used hemp, lime and chalk blocks in the construction of the walls, the roof being a carpet of fleshy plants and grass.



#### PLANT

Probably does not contain pre-1940 equipment, as all significant operational plant has been replaced in the last decade. In 2001, nine 250-barrel enclosed square stainless steel Briggs fermenting vessels were installed in the old bottling stores across the road from the brewhouse. A further ten similar vessels (1 x 90, 2 x 170 and 7 x 250 barrels) followed by 2007. All old fermentation vessels were removed, with the three most unusual ones 'sausage shaped copper fermenters' retained for installation as attractions in Adnams' shops. In 2007-8 a new stainless steel Huppmann brewhouse was installed in the old, now vacated, fermentation house. The new plant required the walls of the brewery frontage to be raised by about a metre. The two

coppers from the old brewhouse have been retained in situ for the moment but are unlikely to remain. They came from Bedford's Charles Wells brewery when it moved to its new site in 1976. The coppers are 65 barrels and 100 barrels, the latter being made by Llewellins & James of Bristol, probably around 1960. Brewery capacity is 140,000 barrels a year. Two large copper fermentation vessels, dating from 1925 and in use until the 1980s, now form part of the furniture in the Adnams Cellar & Kitchen Store, built on the site of the old distribution centre in Southwold's Victoria Street.

ARCHIVE MATERIAL

Records at Sole Bay Brewery, see Richmond and Turton p38.

REFERENCES

Roger Putman, 'Energy saving from the coast', *The Brewer & Distiller International*, 3 (8), 2007, pp26-31.

Roger Putman, 'Sun, seaweed and new fermenters at Sole Bay', *The Brewer International*, 1 (8), 2001, pp24-9.

John Winter, 'Racking in Suffolk', *Architectural Review*, 169, March 1981, pp146-50.



WEST MIDLANDS

**Dudley**

Daniel Batham & Son Ltd, Delph Brewery, Delph Road, Brierley Hill DY5 2TN

Brewery not listed          BHS Breweries Database ID 473

BUILDINGS

The Bathams began home brewing about 1867, moving to the Vine in Brierley Hill in 1905 and building the Delph Brewery there soon afterward. It is a classic small Black Country brewery.

PLANT

May contain pre-1940 equipment. The 4-roll Boby mill was obtained from Gray & Sons of Chelmsford when the brewery closed in 1974. Mashing is carried out with the now seldom seen Maitland masher for mixing grist and liquor, together with a traditional wooden hand mashing paddle in the mash tun. The copper is direct fired by gas. There are six plastic-lined open wooden fermenters of uncertain age in use. Hogsheads (54 gallon casks) are used for racking; only Holts of Manchester do likewise in the UK. The rest of the equipment is 1980s-90s. Produces about 7,000 barrels a year.

ARCHIVE MATERIAL

None known.

REFERENCES

Joseph McKenna, *Black Country Breweries* (Tempus Publishing, Stroud, 2005), see pp81-3.

Roger Putman, 'Brewing behind The Bull', *The Brewer & Distiller*, 1 (9), 2005, pp62-7.

**Dudley**

Holden's Hopden Brewery Ltd, George Street, Woodsetton, Dudley DY1 4LW

Brewery not listed          BHS Breweries Database ID 474

BUILDINGS

Holden's of Woodsetton was established in 1920 at the Park Inn, a home-brew house. Behind the pub was a malthouse which they bought in 1939 and converted to the Hopden Brewery, installing new brewing plant. In 1961-2 the brewery was rebuilt and enlarged.

PLANT

May contain pre-1940 equipment, although the brewery was re-equipped during the 1960s. The output is about 8,000 barrels a year.

ARCHIVE MATERIAL

None known.

REFERENCES

Joseph McKenna, *Black Country Breweries* (Tempus Publishing, Stroud, 2005) see pp18-19, 93-4.

**Dudley**

Old Swan Public House, 89 Halesowen Road, Netherton, Dudley DY2 9PY

Brewery listed grade II    LBS 487069    BHS Breweries Database ID 606

#### BUILDINGS

The Old Swan public house and brewhouse were built in 1863. Known as Ma Pardoe's for many years, brewing ceased around 1990 then resumed later, but was not brewing in mid-2008. The current brewing status is unknown. It is one of only four surviving pre-1970 pub brewhouses to have been in more or less continuous use since they first brewed. The others are the Blue Anchor, Helston, Cornwall; and the All Nations, Madeley and the Three Tuns, Bishop's Castle, both Shropshire.

#### PLANT

May contain pre-1940 equipment. In 2003 the brewhouse retained its full complement of equipment, including a wooden mash tun of uncertain age. The fermenting vessels appear to be relatively modern. Annual output is around 1,200 barrels.

#### ARCHIVE MATERIAL

None known.

#### REFERENCES

Joseph McKenna, *Black Country Breweries* (Tempus Publishing, Stroud, 2005) see pp103-4.

### Dudley

Sarah Hughes Brewery, Beacon Hotel, 129 Bilston Street, Sedgley, Dudley DY3 1JE

Brewery not listed      BHS Breweries Database ID 475

#### BUILDINGS

The Sarah Hughes Brewery is a small tower brewery which was established in 1921 but ceased brewing in 1958. Brewing was resumed in 1987, when the original plant, including a grist case and open-topped copper, was restored and an extra floor added to the brewhouse.

#### PLANT

Contains pre-1940 equipment; there is an original grist case and an open-topped copper dating from around 1930. Output is about 1,000 barrels a year.

#### ARCHIVE MATERIAL

None known.

#### REFERENCES

Joseph McKenna, *Black Country Breweries* (Tempus Publishing, Stroud, 2005) see pp94-6.



### Walsall

Highgate Brewery Ltd, Sandymount Road, Walsall WS1 3AP

Brewery listed grade II    LBS 219143      BHS Breweries Database ID 349

#### BUILDINGS

The red brick brewery was built in 1895-9, and has additions of 1919 and later alterations. It was bought by Mitchells & Butlers in 1939; there was a management buyout in 1995 from Bass; and it was bought by the Aston Manor Brewery Co Ltd in 2000. From July 2007 Highgate Brewery was owned by Global Star, a Smethwick-based pub company, who bought the brewery from Aston Manor. The business was renamed Highgate & Davenport's Brewery but went into administration in September 2009, and was then sold to property developers; however, brewing was still continuing normally in early 2010. The photograph on the Images of England website purporting to be the



Highgate Brewery is actually a pub, the Market Tavern on Walsall's High Street, well down the hill from the brewery itself. The pub still bears large-scale lettering reading 'Highgate Brewery Stores'.

#### PLANT

The brewery retains its original planning and many traditional vessels including well water tank (1900), hot liquor tanks (1930s), malt hopper (1920), original malt screen with willow springs (1899), German belt-driven Seck mill acquired secondhand in 1922, two Briggs copper coppers (1952-7), modified hop back

(1955), jack back (1952), wort receiver (1948), paraflow (1970), and fermenting vessels (1905-62, mostly relined with copper, stainless steel or polypropylene). There are 6 square fermenters on one floor and a further 12 vessels (4 round and 8 square) on the floor below; an arrangement which indicates that the 6 were originally collection vessels for operation of the dropping system. All of the fermenters are open and of 80 barrels capacity. The two mash tuns are the original cast iron vessels but have been clad in stainless steel following leakage. Collecting vessels by Pottertons of Birmingham are no longer in use. The coppers were originally open and heated by coal; they are now closed and steam-heated. The original open copper coolship has been fitted with a top and is now used as a header tank for the paraflow heat exchangers. Three fermenting vessels built in the 1920s-30s have no lining and are not in use. Output is about 25,000 barrels a year.

#### ARCHIVE MATERIAL

Copy records for Walsall Highgate Brewery are at Walsall Local History Centre, ref 52/1-7. Staffordshire and Stoke-on-Trent Archive Service (Staffordshire County Record Office) holds Highgate Brewery material from the Birmingham and Midland Counties Wholesale Brewers Association, ref D3163/1/4/1. There were also records at Coors Brewers Ltd and Coors Visitor Centre, see Richmond and Turton p178. Following the closure of the Visitor Centre in June 2008, it was thought that these archives might be moved to the Staffordshire and Stoke-on-Trent Archive Service, but it appears (in early 2010) that they will remain at what is to be the National Brewery Centre, due to open in April 2010.

#### REFERENCES

K. J. Lloyd, *The Highgate Brewery* (Black Country Society, Kingswinford, 1982).

Joseph McKenna, *Black Country Breweries* (Tempus Publishing, Stroud, 2005) see pp92-3.

Roger Putman, 'Say hello to Highgate', *The Brewer International*, 4 (4), 2004, pp28-33.

### **Wolverhampton**

Banks's Brewery, Park Brewery, Bath Road, Wolverhampton WV1 4JT

Brewery not listed            BHS Breweries Database ID 476

#### BUILDINGS

Banks's - now part of Marston's plc - began brewing at the Park Brewery in 1875; the present brewery mostly dates from the mid to late twentieth century.

#### PLANT

May contain pre-1940 equipment; the brewery's five mash tuns are of traditional domed copper-topped design and there are two older coppers and associated hop backs (probably 1950s) still in place but no longer in use. There are over 100 fermenters which are a mixture of open plastic-lined wooden and cast iron rounds and later open (1963) and closed stainless steel squares; all of them are 125 barrels capacity. In addition, the Park Brewery and Arkells of Swindon contain the only surviving swinging valentine mash run off devices left in the UK, although it is doubtful if they are pre-war. Two 500 barrel Briggs combined copper/whirlpools installed in 1997 are housed in a room finished in tiles depicting brewing activities. Brewery capacity is about 700,000 barrels a year.

#### ARCHIVE MATERIAL

None known.

#### REFERENCES

Roger Putman, 'Home of the bostin' good pint', *The Brewer International*, 4 (8), 2004, pp20-5.

### WEST YORKSHIRE

#### **Keighley**

Timothy Taylor & Co Ltd, Knowle Spring Brewery, Keighley BD21 1AW

Brewery not listed            BHS Breweries Database ID 479

#### BUILDINGS

The Knowle Spring Brewery was built soon after mid 1863, when plans for building on the site were approved by Keighley Local Board of Health. The brewery was enlarged in 1911, the extension being built alongside the original brewery tower; the architects were John Haggas & Sons of Keighley. A new brewhouse, standing next to the 1911 structure, was opened in 1991 and an extension - to allow an increase in fermenting capacity - was added in 2003.

#### PLANT

May contain pre-1940 equipment. A paraflow replaced the refrigerator in the 1960s. The 1991 brewhouse was equipped with stainless steel vessels acquired from the defunct Oldham Brewery, which closed in 1988; further improvements to equipment have been made since 1991. Stainless steel squares are currently in use. In 2003 four new fermenters were added, increasing brewing capacity by a third. Made by Bibby's of

Halifax, the fermenters were the same as those installed in 2000, in that they can be used for fermentation as in traditional open fermenting vessels, or for storage as in normal maturation tanks.

ARCHIVE MATERIAL

None known.

REFERENCES

Malcolm Toft, Robert Clayton, Tony Halstead and Simon Miles, *Timothy Taylor: 150 years of brewing excellence 1858-2008* (Granta Editions, Cambridge, 2008).

## Leeds

Carlsberg UK Ltd, The Brewery, 21 Hunslet Road, Leeds LS10 1JQ

Brewery not listed          BHS Breweries Database ID 603

BUILDINGS

Tetley's merged to form Tetley Walker in 1960, joined with Ind Coope and Ansells a year later to form a company which took the name Allied Breweries in 1962, and amalgamated with Carlsberg in 1993; Tetley's Brewery is to be closed in 2011. The firm originated in 1792 as the brewery of William Sykes, which was taken on in 1822 by Joshua Tetley, who bought Sykes's business and leased the brewery buildings. The



company Joshua Tetley & Son was created in 1839 when Joshua's son Francis William Tetley was brought into the firm as a partner. F. W. Tetley expanded the business, building the New Brewery in 1852-5. It was designed by the Scottish architect George Corson (1829-1910), who practised in Leeds with his brother from 1849. Tetley's bought the lease on the Sykes section of the growing site in 1864, allowing even further expansion; Corson, along with local builder William Nicholson, carried out major works at the brewery during 1864-74. By 1866 a new hop store, fermenting room and cellars were almost complete and the huge Crown Point Maltings (demolished 1972) had been built. The firm continued to buy up nearby property as it became available. In 1894 some of the last remaining buildings of the Sykes brewery - a gate and some buildings in the yard - were demolished to make way for a new four-storey bottling store. There were extensions to the central brewery block in 1905 and to the bottling plant in 1913.

The red brick office block fronting the brewery, with its handsome wood-panelled interior and splendid art deco lift, was built in 1931. From the 1950s there were many improvements to the brewery, including two new fermenting rooms (1961 and 1964), a completely new brewhouse (1967), a new office block (Huntsman House, 1968) and a keg and packaging plant (1975). The current brewhouse was built in 1989. Aside from its modern plant, on display is a disused brewing copper (1966), the last to be made in copper by Briggs of Burton upon Trent. Behind it is a large unsigned mural depicting hop picking. All fermenting now takes place in stainless steel Yorkshire squares and conical vessels; the slate Yorkshire squares, dating from about the 1880s, were broken up and removed in autumn 2008.

It has generally been thought that all traces of the 1864-74 brewery have disappeared. The Pevsner *Leeds* (Susan Wrathmell, 2005) refers to 'major new buildings on this site of 1864-72 by George Corson, now

replaced' echoing Derek Linstrum's view in his *West Yorkshire: Architects and Architecture* (1978). However, this is not the case, and much of Corson's central block of 1864-74 survives, although altered. Several drawings of it appeared in the report of Alfred Barnard's visit to the brewery in 1889. Today, the blocked arches of the central block can clearly be seen to the rear of the 1931 office block; two or more storeys have been added above them. The cellars, supported by cast iron columns, are about 200 metres in length and extend eastward behind the 1931 offices. The barrel-vaulted cellars were in operation until 1976, after which they were partly in service as a visitor centre, and are now used for storage. With closure of the brewery imminent, a full survey of the Tetley's Brewery site is required to determine exactly what else remains from the various building programmes.

#### PLANT

Probably does not contain pre-1940 equipment. The open slate Yorkshire Square fermenters, dating from about the 1880s, were being broken up and removed during September 2008. There are two blocks of stainless steel Yorkshire squares in use in the brewery: 48 x 270 barrel vessels installed in 1961 and 19 x 540 barrel enclosed vessels from 1996. Current output (in 2009) is probably below 600,000 barrels but has been significantly higher.

#### ARCHIVE MATERIAL

The West Yorkshire Archive Service, Leeds, holds the Joshua Tetley & Son collection (WYL756) and there may also be material at the Leeds brewery. See Richmond and Turton p326.

#### REFERENCES

Paul Buttrick, 'Gearing up for the fans - New packaging lines at Carlsberg Leeds', *The Brewer & Distiller*, 2 (10), October 2006, pp25-8.

John Chartres, 'Joshua Tetley & Son, 1890s to 1990s: a century in the tied trade', pp112-44 in John Chartres and Katrina Honeyman (eds), *Leeds city business 1893-1993: essays marking the centenary of the incorporation* (Leeds University Press, Leeds, 1993).

Clifford Lackey, *Quality pays: The story of Joshua Tetley & Son* (Springwood Books, Ascot, 1985).

### Wakefield

H. B. Clark & Co (Successors) Ltd, Westgate Brewery, 136 Westgate, Wakefield WF2 9SW

Brewery not listed            BHS Breweries Database ID 732

#### BUILDINGS

Clark's Westgate Brewery in Wakefield was founded in 1906, ceased to brew during the 1960s and 1970s, but began brewing again in 1982. It is based in functional red brick buildings to the rear of listed 18th century houses on Westgate.

#### PLANT

Equipment unknown. This may be a microbrewery plant operating in their own 1906 premises. Annual output is around 1,500 barrels.

#### ARCHIVE MATERIAL

Records at Wakefield Learning and Local Studies Library, Balne Lane, Wakefield WF2 0DQ and West Yorkshire Archive Service, Newstead Road, Wakefield WF1 2DE; see Richmond and Turton p104.

#### REFERENCES

None known.

### WILTSHIRE

#### Devizes

Wadworth & Co Ltd, Northgate Brewery, Devizes SN10 1JW

Brewery listed grade II    LBS 433519            BHS Breweries Database ID 365

#### BUILDINGS

Henry Alfred Wadworth (1852-1929) bought the Northgate Brewery, Devizes, in 1875; it still stands to the rear of 3-8 Northgate Street. He designed and built a new brewery - Wadworth's Northgate Brewery - on a site close to the original in 1885. It is a large red brick structure, up to six storeys in height, occupying a corner site in the town centre; lower buildings extend for nine bays along Northgate Street. There is an ornate ironwork crown and a tall, square brick chimney.

#### PLANT

Contains pre-1940 equipment, including some of the original plant installed in 1885, for instance the open copper. There is also a steam engine, installed by George Adlam & Sons of Bristol around 1900 and restored in 2004. Fermentation



is carried out in conical vessels and open or covered squares dating from 1974 or later. A new copper house was completed in June 2009, occupying a building thought to date from 1926 which was previously used as offices and stores. The new plant, three wood-clad vessels, may be seen by visitors through a large ground floor window. The old copper house, containing an 1885 open copper (with a steam coil fitted in the 1930s), an enclosed 1945 copper and a 1970s hop back, has been taken out of regular service. However, the intention is to refurbish the old copper house, retaining the vessels, and use the open copper for occasional seasonal brews. Annual output is around 60,000 barrels.

#### ARCHIVE MATERIAL

Wiltshire and Swindon History Centre, Chippenham, holds Wadworth & Co Ltd records, ref 2816. Records at Northgate Brewery, see Richmond and Turton p346.

#### REFERENCES

Roger Putman, 'Handmade in Devizes', *The Brewer International*, 3 (7), 2003, pp30-6.

Brian Yorston and Colin Oke, 'New Copper House for Wadworth', *Brewer & Distiller International*, 5 (8), 2009, pp37-9.

### Swindon

Arkell's Brewery Ltd, Kingsdown Brewery, Upper Stratton, Swindon SN2 7RU  
Brewery listed grade II LBS 318560 BHS Breweries Database ID 382

#### BUILDINGS

Arkell's was founded in 1843, present Kingsdown Brewery being built in 1861. The brewhouse is a square-plan, three storey, three bay block with a linked fermenting room. In the centre of the first floor facade is a panel reading 'Kingsdown Steam Brewery 1861'. The tall chimney at the rear was built in 1937.

#### PLANT

Contains pre-1940 equipment. The Seck malt mill dates from 1908. Driving power in the brewery is still supplied through a system dating from 1910, although the steam engine (located on the ground floor and now in the visitors bar) has been replaced by electric power. In addition, Arkells and Marston's Park Brewery, Wolverhampton, contain the only surviving swinging valentine mash run off devices left in the UK, although it is doubtful if they are pre-war. There are seven fermentation vessels of 550 barrels total capacity made from three different materials: copper, aluminium and stainless steel; their ages are unknown. Annual output is around 10,000 barrels.



#### ARCHIVE MATERIAL

Records at Kingsdown Brewery.

#### REFERENCES

Roger Putman, 'Kingsdown on the up', *The Brewer International*, 2 (7), 2002, pp14-19.

## Appendix 1

### Major operating post-1940 breweries

#### BEDFORDSHIRE

##### Bedford

Wells and Young's Brewing Co, Bedford Brewery, Havelock Street, Bedford MK40 4LU

Brewery not listed          BHS Breweries Database ID 684

##### BUILDINGS

The Wells family has brewed in Bedford since 1876. The Bedford Brewery opened in 1976 on a 17 acre brownfield site and has since been developed haphazardly as production has increased. Wells and Young's was created in 2006, when Young's of the Ram Brewery, Wandsworth, transferred production to Bedford. The modern production plant from the Ram Brewery has either been transferred to Bedford, sold or scrapped.

##### PLANT

There is no pre-1940 equipment at the Bedford Brewery, which has a brewing capacity of around 500,000 barrels a year. The historic Ram Brewery plant remains at the old brewery site in Wandsworth; it is hoped that it will become part of a brewing museum.

##### ARCHIVE MATERIAL

The Charles Wells Archive (WL) is held by Bedfordshire and Luton Archives and Record Service. Richmond and Turton (p358) state that there is also material at the Bedford Brewery. The Young's records which were held at the Ram Brewery are now with Young & Co at their new Wandsworth offices.

##### REFERENCES

Roger Putman, 'Awesome Wells', *Brewer International*, 4 (10), 2004, pp24-9.

#### BERKSHIRE

##### Reading

Scottish & Newcastle UK, Berkshire Brewery, Imperial Way, Reading RG2 0PN

Brewery not listed          BHS Breweries Database ID 604

##### BUILDINGS

The Berkshire Brewery, formerly owned by Courage, was opened in 1979. The new brewhouse and related buildings were all designed by Courage's in-house architects and engineers. The brewhouse, with its glass curtain walls and arched concrete colonnade, is a striking structure which can be seen from the nearby motorway; it is of some architectural merit. Scottish & Newcastle UK became part of Heineken in April 2008. The brewery is to close in 2010.

##### PLANT

No pre-1940 equipment. Apart from an increase in bottling and canning capacity, there has been little change in the brewery's plant since 1979. Annual capacity is about 3.5 million barrels.

##### ARCHIVE MATERIAL

The records of Courage & Co are held by London Metropolitan Archives, see Richmond and Turton pp116-8.

##### REFERENCES

'Here for the beer', *Building*, 3 October 1980, vol 239, p11.

Michael Parsons, '25th birthday at Berkshire', *Brewer & Distiller*, 1 (6), 2005, pp22-9.

John Pudney, *A Draught of Contentment: The Story of the Courage Group* (New English Library, London, 1971).

#### HAMPSHIRE

##### Alton

Molson Coors Brewing Company (UK) Ltd, Alton Brewery, Lower Turk Street, Alton GU34 2PS

Brewery not listed          BHS Breweries Database ID 686

##### BUILDINGS

The brewery opened in 1963 for the production of Harp Lager and was the first entirely new brewery to be built in Britain since Guinness Park Royal (Brent, London) in 1936. The brewery is a large steel, glass and concrete structure with little to commend it.

##### PLANT

There is no pre-1940 equipment. Contains a mothballed set of open and closed stainless steel fermentation vessels which date from the brewery's opening; the rest of the equipment is of later date.

#### ARCHIVE MATERIAL

Nothing specific known. Harp Lager was brewed by a changing consortium of brewers including Scottish & Newcastle, Guinness and Bass.

#### REFERENCES

'Now Brewing - Harp Lager: First post war brewery built in Britain', *The Brewers' Journal*, 89 (7), 1963, pp398-406.

#### LANCASHIRE

##### **Preston**

InBev UK, Samlesbury Brewery, Cuerdale Lane, Samlesbury, Preston PR5 0XD

Brewery not listed          BHS Breweries Database ID 688

#### BUILDINGS

The brewery, a vast modern shed at its heart, was built by Whitbread and opened in 1972 on a greenfield site just outside Preston.

#### PLANT

No pre-1940 equipment. The brewery was originally equipped with a 20 ton Strainmaster mash vessel (the largest such vessel in Europe) but the technology was flawed and it was stripped out in 1987 and replaced with lauter tuns. Brewery capacity is around 2 million barrels.

#### ARCHIVE MATERIAL

The Lancashire Record Office at Preston holds two menus for a 1999 production line launch dinner (DDX 1873 acc 8614); at the time this was the fastest bottling line in northern Europe.

#### REFERENCES

Nick Redman, *Samlesbury Brewery: 25 years of success 1972-1997* (Whitbread, London, 1997).

#### LEICESTERSHIRE

##### **Narborough**

Everards Brewery Ltd, Castle Acres, Narborough LE19 1BY

Brewery not listed          BHS Breweries Database ID 731

#### BUILDINGS

The Everard family began brewing in 1849. The current brewery was developed on the flood plain of the river Soar close to motorway links on the site of a farm purchased in 1979. The prefabricated brewery building, a huge shed, was opened in 1982 and expanded in 1990.

#### PLANT

Does not contain any pre-1940 equipment. Output is around 50,000 barrels per annum.

#### ARCHIVE MATERIAL

Records at Everards Brewery Ltd, Castle Acres, see Richmond and Turton p138.

#### REFERENCES

Christine Brooke and Fergus Sutherland, *Excellence through Independence: The First 150 Years of Everards Brewery 1849-1999* (Everards Brewery Ltd, Narborough, 1999).

Roger Putman, 'Everards Brewery', *The Brewer International*, 1 (1), 2001, pp24-8.

#### NORTHAMPTONSHIRE

##### **Northampton**

Carlsberg UK Ltd, 140 Bridge Street, Northampton NN1 1PZ

Brewery not listed          BHS Breweries Database ID 427

#### BUILDINGS

The Danish company Carlsberg Breweries put up a ziggurat-style brewery during 1971-73 at the former Phipps Northampton Brewery site which had been acquired by Watney Mann, Carlsberg's partners in the venture, in 1960. Carlsberg produced the brief and brought in Danish architect Knud Munk to design the new riverside plant, with Ove Arup & Partners as engineers and management consultants. The brewery's most unusual feature is the stepped glass wall making up the southern facade of the concrete and steel brewhouse, through which its gleaming plant may be seen. The brewhouse and adjoining energy centre front a long, low shed to the rear, containing the fermenting hall, with associated bottling plant and stores. Huge geometric forms - pale concrete malt silos, a tank farm and a tall, dark chimney - rear up alongside. The brewhouse and adjoining energy centre in particular merit consideration for listing as a late 20th century interpretation of the traditional brewhouse tower.

## PLANT

There is no pre-1940 equipment. The brewery was modernised between 1998 and 2004 with removal of all significant 1970s brewhouse equipment, including the replacement of lauter tuns with mash filters at a cost of £8.5 million. All fermentation is in conical vessels, with the six largest at 4,250 barrels probably the biggest in Britain. Brewery output is about 3 million barrels a year.

## ARCHIVE MATERIAL

Richmond and Turton p265 gives the location of the Phipps Northampton Brewery records as Northamptonshire Record Office, but they do not appear in the online listing.

## REFERENCES

'Carlsberg Brewery, Northampton', *Architects' Journal*, 160, 13 November 1974, pp1151-72.

Roger Putman, 'The Viking longship gets a refit', *The Brewer International*, 3 (3), 2003, pp20-5.

## TYNE AND WEAR

### Gateshead

Federation Brewery, Lancaster Road, Dunston, Gateshead NE11 9JR

Brewery not listed      BHS Breweries Database ID 708

## BUILDINGS

The Federation Brewery, a dull modern shed, was opened in 1980 by the Northern Clubs Federation Brewery Ltd to replace its Hanover Street Brewery in central Newcastle where the company, founded in 1919, had brewed since 1931. It was bought by Scottish & Newcastle UK in 2004 and became part of Heineken in April 2008 when the latter was taken over. The brewery is due to close in 2010. Has a capacity of around 1.5 million barrels.



## PLANT

There is no pre-1940 equipment. The conical fermentation vessels are unusual because of their short 1:1 aspect ratio, which was chosen to mimic that of the fermenting squares in the old brewery.

## ARCHIVE MATERIAL

Records at Federation Brewery, see Richmond and Turton p256.

## REFERENCES

Brian R. Bennison, *The Economic and Social Origins of the Northern Clubs Federation Brewery: Early Twentieth Century Co-op Brewing* (School of Economics, Newcastle upon Tyne Polytechnic, 1985).

Ted Elkins, *So They Brewed Their Own Beer: The history of the Northern Clubs and Federation Brewery Ltd* (Northern Clubs Federation Brewery Ltd, Newcastle upon Tyne, 1970).

Roger Putman, 'What's going on at the Fed?', *The Brewer*, 86, no 1028, 2000, pp295-300.

## Appendix 2

### Operating microbreweries occupying pre-1940 brewery premises

The premises are not listed unless otherwise stated.

#### BRISTOL

##### **Bristol**

Bristol Beer Factory, The Old Brewery, Durnford Street, Ashton Bristol BS3 2AW  
Brew in part of the former Ashton Gate Brewing Company premises, which closed in 1933.

#### CUMBRIA

##### **Brampton**

Geltsdale Brewery Ltd, Old Brewery Yard, Craw Hill,  
Brampton CA8 1TR  
In part of Brampton's Old Brewery, which dates back to 1785.



#### DEVON

##### **Newton Abbot**

Teignworthy Brewery Ltd, The Maltings, Teignworthy, Newton Abbot TQ12 4AA  
Located in part of Tuckers Maltings (listed grade II, LBS 464543), designed by William Bradford.

#### DORSET

##### **Weymouth**

Dorset Brewing Company, Hope Square, Weymouth DT4 8TR  
At The Brewers Quay development, in the former Hope Brewery.

#### GLOUCESTERSHIRE

##### **Stanway**

Stanway Brewery, Stanway, Cheltenham GL54 5PQ  
At the brewhouse in Stanway House (listed grade I, LBS 134908); only known plant in England to use wood-fired coppers for all its production.

##### **Uley**

Uley Brewery Ltd, The Old Brewery, 31 The Street, Uley GL11 5TB  
Samuel Price founded the brewery by 1830, and the brewhouse is dated S. Price 1833. Brewing ceased during the early 1900s, but after many years the derelict premises were restored and Uley Brewery opened in 1985.

##### **Wickwar**

Wickwar Brewing Co Ltd, Old Brewery, Station Road, Wickwar GL12 8NB  
The Wickwar Brewing Co was established in 1990 in the cooper's shop of the former Arnold, Perrett & Co Brewery; since 2004 its home has been the original brewery building. The firm which became Arnold, Perrett was established in 1820, but its brewhouse was built in the mid 19th century after the first building was demolished to make way for the railway. It was rebuilt in 1891-2 after a fire, and during the mid 1920s production changed from beer to cider with the building being converted to hold huge storage tanks. These were enlarged following the war, and by 1960 were being described as some of the largest reinforced tanks in the country. Cider making continued until well into the second half of the 20th century. The brewery is locally listed. The records of Arnold, Perrett & Co Ltd are at Gloucestershire Record Office, see Richmond and Turton p49.

#### GREATER MANCHESTER

##### **Dukinfield**

Shaws Brewery, The Old Stables, Park Road, Dukinfield SK16 5LX  
In the stables of William Shaw's Tame Valley Brewery, established around 1856 and closed in 1941.

## **Heywood**

Phoenix Brewery, Green Lane, Heywood, Manchester OL10 2EP

The Oak Brewery was established in 1982 at Ellesmere Port, and moved to the disused Phoenix Brewery (built 1897) in 1991, adopting the brewery's name. Restoration of the brewery is taking place.

## **Uppermill**

Church Inn and Saddleworth Brewery, Church Lane, Uppermill, Oldham OL3 6DW

In a brewhouse that had been closed since around 1880.

## **Wigan**

All Gates Brewery Ltd, The Old Brewery, Brewery Yard, off Wallgate, Wigan WN1 1JQ

In an old tower brewery; two walls are grade II listed (LBS 484996).

## LEICESTERSHIRE

### **Cavendish Bridge**

Shardlow Brewing Co Ltd, The Old Brewery Stables, British Waterways Yard, Cavendish Bridge, DE72 2HL

Site associated with brewing since 1819; is in Leicestershire.

## NORTHAMPTONSHIRE

### **Northampton**

Frog Island Brewery, The Maltings, Westbridge, St James Road, Northampton NN5 5HS

In a malthouse built by Thomas Manning's Castle Brewery, founded 1878 and acquired by Phipps in 1933. The Castle Brewery stood nearby on Black Lion Hill.

## SHROPSHIRE

### **Ludlow**

Ludlow Brewing Co Ltd, Kingsley Garage, 105 Corve Street, Ludlow SY8 1DJ

In a 250 year old building that was once a malthouse (listed grade II, LBS 389891).

## SOMERSET

### **Wiveliscombe**

Exmoor Ales Ltd, Golden Hill Brewery, Wiveliscombe TA4 2NY

At the old Hancock's Brewery, which closed in 1959.

## STAFFORDSHIRE

### **Burton upon Trent**

Black Hole Brewery Ltd, Unit 63, Imex Business Park, Shobnall Road, Burton upon Trent DE14 2AU

Brew in the former Ind Coope bottling stores and maltings.

### **Burton upon Trent**

Tower Brewery, Old Water Tower, Walsitch Maltings, Glensyl Way, Burton upon Trent DE14 1LX

In a converted, formerly derelict, water tower (engine house) of Thomas Salt's maltings.

## **Milford**

Shugborough Brewery, Shugborough Estate, Milford ST17 0XB

In the original brewhouse on the estate (listed grade II, LBS 445183, or grade II\*, LBS 445184, depending in which outbuildings the brewery stands).

## **Stone**

Limestone Brewery, The Old Brewery, Mount Road, Stone ST15 8LL

Founded 2008, works from the former Bent's Brewery (initially Montgomery's New Brewery) which was closed by Bass Charrington in 1968. The buildings were then subdivided and used as part of an industrial estate. Limestone now brew in what appears to be the former fermenting room.

## SUFFOLK

### Ipswich

Cliff Quay Brewery, Cliff Quay, Cliff Road Ipswich IP3 0BS

Thomas Cobbold began brewing in Ipswich in 1746. Over the years the brewery, on Cliff Quay, grew in size and complexity until it needed rebuilding.

This was carried out by Cobbold's own workmen during 1894-6 to a design by William Bradford, although parts of the original brewery were retained, and a Bradford-designed extension was added in 1904. In 1957 the firm merged with Tollemache's Breweries of Ipswich to form Tollemache & Cobbold Ltd (known as Tolly Cobbold); the Cliff Quay Brewery (listed grade II, LBS 428671) was expanded during 1959-61. The firm was acquired by Ellerman Shipping Lines in 1977, then sold to the Barclay brothers in 1983. Brewing ceased in 1989 but restarted in 1991 after a management buy-out. The adjacent grade II listed Cliff House, an 18th century house once home to members of the Cobbold family, was converted to the brewery tap in 1992. Brewing ceased again in 2003. After investment in restoration and new plant by the nearby Earl Soham Brewery, brewing started again in February 2009 as the separate Cliff Quay Brewery, a microbrewery within the old brewery.



The list description refers to a copper brewing vessel of 1746 (actually brought to Ipswich in 1746 having previously been at Cobbold's Harwich brewery) and a small horizontal steam engine by E. R. and F. Turner of Ipswich, although most other equipment was replaced during the 20th century. The copper vessel was being used for priming in 1973 and was referred to as being 'in first-rate condition'. (See [www.derelict.co.uk/reports/brewery](http://www.derelict.co.uk/reports/brewery) for photographs of the remaining kit.) The records of Tollemache & Cobbold are at Suffolk Record Office (HA231). See also Michael Jacobson, *The Cliff Brewery 1723-1973* (Tollemache & Cobbold, Ipswich, 1973); and Robert Malster, *250 Years of Brewing in Ipswich: The story of Tollemache and Cobbold's Cliff Brewery, 1746-1996* (Malthouse Press, Ipswich, 1996).

## WEST MIDLANDS

### Dudley

Black Country Ales, Old Bulls Head, 1 Redhall Road, Lower Gornal, Dudley DY3 2NU

Plant is in part of the pub's original tower brewery dating from around 1900. Brewing took place on the site from 1834 until just after the Second World War. Oak vessels installed in 1900 have been refurbished and are now used for production.

## WEST YORKSHIRE

### Holmfirth

The Nook Brewhouse, Riverside, 7b Victoria Square, Holmfirth HD9 2DN

The stone brewhouse, which stands at the rear of the Nook public house, was built in 2009 on the foundations of a previous brewhouse said to date back to 1752.

### Linthwaite

Linfit Brewery, Sair Inn, 139 Lane Top, Linthwaite, Huddersfield HD7 5SG

In a 19th century brew-pub.

### Wakefield

Fernandes Brewery, 5 Avison Yard, Kirkgate, Wakefield WF1 1UA

Housed in a 19th century malthouse.

Back cover: An internal heating coil from an old copper, on display at the Lees Greengate Brewery, Middleton Junction, Greater Manchester.



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