Come of the Striking Features of the Cannon Factory.

POWERFULLY IMPRESSIVE MACHINERY.

Cranes Whose Capacity Has Never Been Tested-The Giant Lathes-Some Death-Dealing Monsters Described.

WASHINGTON, May 1. - | Correspondence of THE BEE. - Making the blg guns for the navy and equipping the new cruisers and men of-war which are being launched now are impressive spectacles.

A more impressive spectacle could not easily be found than to behold a ponderous machine, weighing forty or lifty tons, clasp in Its embrace a mass of steel, weighing fortyfive tons, twirl it about as gently as a feather, and trim it to within one hundred thousandth of an inch of the required thickness.

Even more impressive it is to beheld a giant crane handle as a baby would a plaything a tremendous gun that could shatter the armored sides of the Dulilo twirling it in the air and posing it in position as if it were as airy and fragile as a soap bubble,

Very strange, also, it is to twirl in your hand In a rope sling a conical projectile loaded with explosives enough to smash the tall lower, the Washington monument, into

These are but a few examples of the asfounding things that any visitor to the Washington navy yard may see for himself nowadays. If a sojourner in any of the countries of Europe were to approach a gun factory. without an official permit and a property accredited escort he would be met at the very threshold by a bayonet with a man behind it trained to kill. In our capital any one who thooses can walk unchallenged past the sentry at the entrance to the Washington navy yard, and can ramble at will through an establishment which within the last two years has grown to be one of the largest and best has grown to be one of the largest and best equipped of its kind in the world. He may note every process, he may admire and inquire into the perfection of every detail, he may narrowly scrutinize everything, from the roughest easting to the huge rifled weapon of destruction ready to be mounted in the sponson of one of our new cruisers. The only restriction he will encounter are two painted sures which recore with great two painted sures which recore with great two painted signs which recur with great frequency and which warn him: "No Ped-flers Admitted" and "Do Not Talk to the

If the inquiring visitor beneither a pedaler por given to asking impertment questions he may wander at will through the plant de-voted to the manufacture of implements of destruction.

The talk, absurd as it really was, of the possibility that Italy might send some of her roughal fleets from the Mediterranean to New York or New Orleans had about it a New York of New Orleans had about it a ring of suggestiveness that caused comment upon the naval possibilities of the situation all over the world. It was shown that we have but one ironciad, the Miantonomeh, at all fit to cope with any of Italy's floating batteries, against whose tonnage and armament our new cruisers would be but egg.

shells. It was shown, however, that we could bring to bear against an invading float order. shells. It was shown, however, that we could bring to bear against an invading fleet ordnance whose quality and quantity has been unsuspected by the general public. An English naval expert who recently visited this country, was quoted in a London dispatch as stating that while our navy might still be light, our ordnance had already grown to formidable proportions, and that any invader might well dread to encounter its missiles.

An illustration of how the facilities for gun manufacture at Washington have grown may be found in the fact that two years ago it would have required six months from the time the castings were furnished to complete

time the castings were furnished to complete a 6-inch breech-loading rifle. The same gun could now be completed in fifty day. Three months would now be required to make an 8-inch gun, five months to finish a 10-inch, while the country of the coun while the manufacture of a 12-in would probably require seven mouths. No 12-inch gun has yet ever been completed. One is now at the factory nearly finished, and two others are under way. The following table shows in compact form the work now under way in the yard here:

CALIBIES.	ordings	empleted	nder
	ordered	guns	construction
4-Inch 6-Inch 6-Inch 16-Inch 1	35 4 128 35 25 8 12	4 22 77 10 6	12 25 4 5 2

The story of a great gun is for these rea-sons of interest to the whole country. After a tube for a gun has been forged it must be inspected and tested before it is received at the gun factory. From each forging several places are cut to which heads are screwed to fit the holders of the testing machine. These pinces are can to which heads are screwed to fit the holders of the testing machine. These test pieces are stretched until they are broken, and their physical condition carefully roted. For example the steel for a tube must have a tensile strength of from seventy thousand to eighty thousand pounds; for a jacket from seventy thousand to eighty thousand to eighty thousand pounds, and for a hoop from ninety thousand pounds, and for a hoop from ninety thousand to a hundred thousand pounds. The meaning of these terms will appear later on. Such has been the development in the making of steel caused by these requirements that the American steel now exceeds in quality the best article of British manufacture which we formerly used in making American guns. When broken this British steel betrays fine needlo points throughout its texture, a symptom of disintegration. The American steel is so though in fibre that sometimes a lathe in turning the tabe for a gan will cut a thread of steel a thousandth part of an inch in thickness and 200 feet long without a broak. Throughout the shops are what appear to be couls of sliver rope, but which are really the turnings from making the rough borings of the gans. urnings from making the rough borings of

coils of siliour rope, but which are really the turnings from making the rough borings of the gans.

Imagine a building covering five across of ground, tsuch are about the dimensions of the main gan shop where the forgings are brought together. Buildings of the navy yard. When the forging nerive there are gants ready to he in them. The three giants are monstrong cranes, one of them can pick up 110 tons another forty tons and the third lifteen tone. Away ap under the roof on a platform stands a bine shirted mechanic who by the tone of his hand can send one of these cranes traveling from one end of the shop to another and at the same time send the hoisting apparatus traveling along the crane transversely across the shop, while the hare block is being raised or lowered.

Let us accompany one of these tubes from the moment of its arrival in the shop. It is first touched by the fringes of one of the gint cranes and lifted from the carte a lathe. There it must be bored and its exterior pared off to exact dimensions. This is a work of the utmost block. Over in one conner of the room is a machine to adjust gauges. This machine can adjust the gange one one hundred thousanth of an inch. The tube, which is the basis of the whole gun, must be bored so that it will be exactly fitted by the projectile, and its exterior must be of just such a diameter that the jacket which is to encircle it, will not ship over it.

The first step in building up the gar is putting on the jacket. The jacket has been as accurately machined as was the tube and is now carried by this same giant crane to the shrinking pit. Here it is slowly beated by furnaces adapted to its slow muit it is expanded by the finace of heat which will molt solder but not lead. Meanwhile the tube has been placed in the pit, breech end up, and the jacket when heated is raised by the granes and slipped over the tube. The greatest needy of adjustment is here required, for should the jacket vache handwhere on the tube save just exactly where it belongs, it might stick fast

jacket firmly on the gun at the point first, for were the water turned on the entire jacket at once it is quite as likely that the jacket would shrink away from the tube or shrink unevenly as that it would shrink toward the breech, which is indispensible. When it has been properly shrunk at the breech and gradually cooled until it has entirely shrunk on at the tube and has become to on at the tube and has become to all intents and purposes a portion of the tube itself, which it encircles with a grip, literally "of steel." At this stage of its manufacture the original tube of

the gun projects far beyond its thick jacket which now surrounds it near the breeth. Successive bands of steel shorter and thinner than the first jacket are each accurately bored and trimmed and slipped over the tube toward the muzzle. These smaller bands are technically called hoops. Over them again other hoops are slipped in such a way that each hoop covers the joint between those within it thus locking the whole structure together by successive bands of shrunken steel, the aggregate compression exerted by these bands upon the inner tube is of course enormous. It needs to be enormous, for when in action the circular chamber sur-rounded by all this metal will be subjected to pressure of many thousand pounds to the

After all this is done much yet remains to complete the weapon. The tube with its en-velopes has now become a ponderous mass, yet the lathe holds it as firmly and twirls it as gracefully as when it was but a single core of steel. The most accurate part of the work is still to be done—what is technically known as the compressing chamber, which is that part of the breech which contains the ojectile and the explosive charge, must lished and rounded with the utmost nice polished and rounded with the utmost nicety. This is especially true of the inch or two of this chamber just forward of the breech mechanism. An error here of the thickness of a hair night result in the escape of gas, the bursting of a run, the loss of life and the pessible destruction of the anip. The workmen who finish this part of the interior are skilled and trusted. In another part of the shop the mechanism used to close and lock the breech is being made. Its material is the finest and hardest steel. Its parts are too combicated for anything but a technical description. Their enormous weight and great size do not prevent their having all the exactness in every part that characterizes the wheels of the finest watch. The different parts of the breech mechanism are all fitted parts of the breech mechanism are all fitted upon standard guns so that they may be sent when ordered to a cruiser in any part of the

While this is being done, the great gr While this is being done, the great gun itself is receiving its finishing touches. Of these the most delicate and important is the rifling. This means the cutting of spiral growes along the bere of the gun, so as to give the projectile that whiring motion which insures accuracy of flight and a flat trajectory. The machine which does the wora is a marvel of ingenuity and a miracle of mathematical accuracy. It must be remembered that these grooves must be cut on the interior of the length of the bore, that their spiral twists as first graduated as one turn in 180 calibres, must graduatly inthat their spiral twists as first graduated as one turn in 180 calibres, must gradually increase as it approaches the muzzle to one turn in twenty-five calibres; and that the grooves must be absolutely parallel while infinitesimally decreasing in wiith as they approach the muzzle. These problems, which to the layman may well seem impossible, have all been overcome. to the layman may well seem impossible, have all been overcome by that marvellous instrument known as the rifting machine. Four grooves are cut at a time. The long rod, on which are the cutting tools, is held stationary while the huge gan slowly turns as the rifting is done. The slightest error in this delicate operation would entirely rain the implement upon which so much time and labor have all

world, with the absolute certainty that they

upon which so much time and labor have already been expended. To obtain some idea of the money alone which is at risk during this delicate operation, it may be stated that the total cost of one of these monsters of destruction is estimated at 75 cents a pound— for instance, a 12-inch gun weighs forty-seven tons, or 94,000 pounds, which amounts to nearly \$75,000.

nearly \$15,000.

Finally, the crane transfers the nearly completed gun to another lathe, where its exterior is polished, the angles of its hoop and jacket rounded, its trumions screwed on, or in case of the heavier guns, grooves cut for the saddle straps. Finally its sights are adjusted,

As a last step the gun is shipped to the proving grounds at Indian Head, about twelve miles down the Potomac. Before it is finally accepted, the gun must successfully stand five rounds with service charges with stand five rounds with service charges in the standard standar out showing the slightest expansion or de-terioration. Not until then is the steel of which the gun is composed paid for by the government. The name of the navy yard, the number of the gun, and the date of its final construction are the gun. final construction are then engraved upon it, and with its carriage it is sent to the cruiser 

The conical projectiles are also turned here and fitted with copper bands, which, projectand fitted with copper bands, which, projecting slightly beyond the surface of the projectile, take the rifling and give the projectile its rotary motion. In still another part of the yard the hollow projectiles are filled with their explosive charges. When loaded, painted and packed for shipment the last step in preparations to repel an invader has been taken.

PERRY S. HEATH.

All for Sister.

How much money have I got in my bank! Forty-five cents, stranger—only want five cents more. What will I do then, stranger! Why, you see, sister has such a terrible cough, and people say it will be bad on her if she don't get better soon, and the folks tell me Haller's sure cough syrup will cure it right up; so you see-five cents? Thank you,

Auction Sale of Desirable City Property.

The west thirty-two feet of lot eleven, in block seven, of Patrick's second addi-tion, with the house thereon, will be sold at sheriff's sale May 5, at 10 o'clock a. m., at the east door of the Douglas county court house, Omaha, Neb. S. A. GOLDSMITH, Mortgagee.

For stealing a wedding ring about to be worn by his sister Robert Lafferty of Phila-delibita was held in \$500 ball.

The Paxton Hotel Fire Did not effect the hotel proper in any way so as to interfere with the operation of the house. Only the annex was dam-aged and guests have been cared for

without the interruption of a single day. Last year 4,590 books were published in this country and one-quarter of them were works of fiction

A Pure Cream of Tartar Powder. Superior to every other known, Used in Millions of Homes-

40 Years the Standard. Delicious Cake and Pastry, Light Flaky Biscuit, Griddle Cakes, Palatable and Wholesome.

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ANNOUNCEMENTS.

Remembering the recent success of Hoyt's latest comedy, "A Texas Steer," here, the patrons of the Boyd who love genuine comedy will be pleased to learn that the piece is to be played again on Thursday by identically the some company as presented it in February. The company is now returning from a tour of the Pacific coast, where the business was phenomenally large. They closed a week's engagement at the Marquam Grand opera house in Portland last Saturday night and open a long run at the Park theatre Brooklyn, on next Monday evening, Omaha being the only stop the company will make between. The local management is endeavoring to get the "Texas Steer" company here for a matinee performance Thursday afternoon, and if they arrive in time one will be given, which, with the evening performance, will give the patrons of the Boyd a chance of witnessing the great comedy twice again this

John L. Sullivan, the great world's cham-pion, is coming to Omaha next Saturday in a new role—that of a dramatic actor. For the last seven months John L. has been playing the part of James Daly, the blacksmith, in Duncan B. Harrison's sensational drama, "Hopest Hearts and Willing Hands," and has attained great proficiency in the part, Mr. Sullivan and company will be at the Boyd for two performances on Saturday next.

The sale of seats for the Willard Spenser comic opera company, which begins an en-gagement at Boyd's opera house this even ing, has been very large and that popular or ganization will likely repeat their former suc-cess here. Mr. Spenser is at present in the city and will in person-direct the perform city and will in person direct the performances. There are fifty-two people in the company this season including Miss Tellula Evans, Miss Jennie Goldthwaite, Miss Alrec Hosmer, Mr. Will Mandeville, Mr. George Lyding, Mr. Joseph Mealey and Mr. Arthur Pacie. "The Little Tycoon" engagement will be the event of the present season of the year.

The Little Tycoon company fifty-two in all arrived from Denver by special train

We desire issues of the MORNING BEE of November 3 and December 2 for our files. Anyone having a copy of either of these mumbers will confer a favor upon this office by mailing them to Robert Hunter, Bee office.

Resented the Term "Rubby." One night in 1879 the court stenogcapher for the Black Hills district was returning from a visit to the states and I of the Garter is in Great Britain. the road agents halted the coach, recalls a correspondent of the Express Gazette. He was a very small man, and in order to enjoy a talk with the driver had climbed to the seat next to that digniary. His feet would not reach the footboard of the boot, so to prevent any sudden lurch of the coach from unsenting him, the friendly driver had passed a red surcingle around his chest under

his arms and buckled it at the back of the seat. When the "Halt!" wa given the short stenographer was noticed by the robber, who demanded mail sacks and treasure box as wo

to call this "Nover mind getting down, Bubby"-a favorite expression used when addressing a young boy in the west-"we ain't making war on kids, so you can stay where you are." This offended the dignity of the court official, who resent the remark by answering: "If I had a gun I would show you that I am no kid." "Well, then," was the robber's real." robber's reply, "It that is so just hand down your watch and money, and be lively about it, too." This demand was quickly complied with, for the glisten-ing barrel of a heavy revolver, in the hands of the road agent, pointed directly at the little fellow's breast, was a powerful persuader. Several months afterwards this watch was the means of convicting one of that gang and sending him to the penitentiary.

Remember that it only requires \$10 eash payment to secure a \$325 lot in Pot ter & George Co.'s addition, East Omaha, Abstract of title given with every lot sold. Potter & George Co. southwest corner 16th and Farnam.

Order of the Canvas Patch.

Some queer distinctions were made in the early mining days in California, writes E. G. Waite in the Century. One Sunday, going to the butcher's booth, I found a customer ahead of me, who in pired if he could not have a piece of iver which was hanging on a tree in plain sight. "Don't know if you can or not," said

"I'd like to know why. I've been trading with you all along, and never asked for liver before; but I wantsome

variety now. "Stand around and let me look at you. No, you can't have any liver."
"Well, why?"

"There ain't enough to go round. have to have some rule about givin' it out, and I have decided that no miner can have a scrap of liver from me unless ie wears a can vas patch on the seat of his pants.

The canvas patch was a badge of pre-cedence as well recognized in our camp on the Trinity as the star of the Order

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WHITE SHIRTS

They are not worth fifty cents, but are worth thirty-five to forty. We find that when a man will pay that price he'll invariably go a little more and buy a fifty center. When any article in our stock don't sell as it should, we've got a happy way of making it. We mark 'er down, way down at once. These shirts haven't sold well. To-day we put the whole lot, about a hundred dozen, all in one pile, and you can take your pick for three days

### AT 250 EACH.

At the same time we will offer a hundred dozen splendid unlaundered shirts, made of New York Mills muslin, linen bands and bosom, reinforced front and back, worth 78c. at

#### CENTS EACH

We will also offer in our shirt department, over two hundred dozen. handsome fancy Shirts, in all the new cloths, in Madras, Zephyrs, Penangs, Ducks, Flannels. Outing Cloths, Jerseys, Stockinettes, Silk Mixed and pure Silks; In a handsome line of colors, in all sizes, with nonshrinkable neck bands, with soft or stiff collars and cuffs, "just" as you like 'em' at a range of prices from 35c to \$3.50.

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\$2.50 \$3.00 3.50

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Beginning Monday we will offer several large lines of boys' all wool cheviot suits made in the best manner at the popular prices, \$2.00, \$2.50, \$3.00, \$3.50, less than the actual cost of manufacturing. The sizes are 4 to 14 years. Come early. We guarantee the values; they are just as represented. See samples in our show windows.

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50c will be the price this week on boys' all wool cheviot pants, all sizes.

50c will be the price of our finest braids in boys' straw hats, the latest styles. 50c will be the price for boys' hats in fine crush goods, all shades.

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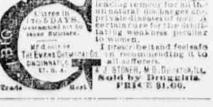
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