

# MAKING PEACE-MAKERS

Working Night and Day at Uncle Sam's Factory.

## HOW THEY ARE BUILT

Fitting on the Jacket Most Difficult Part of the Work—Importance of Good Guns—Their Enormous Cost—They Are the Best Guarantees of Peace.

The late Alfred Nobel, who invented dynamite and manufactured cannon and founded the famous "Peace Prize," said once:

"The greatest peacemakers are the greatest guns."

Whatever may be thought of the wisdom of the policy, the Nobel "peacemakers" are being made in Washington in large numbers, and the process is interesting.

Our great Capitol at Washington is 750 feet long. There are orators, law-makers and statesmen meet. Our great gun shop at Washington, down in the old Navy-Yard, is nearly 200 feet longer. There army and navy officers meet—not to make laws concerning peace, but to look over guns which are sure to promote it, if Alfred Nobel was right. Peace at the cannon's mouth gets more ground space than peace at the orator's.

There are forty-seven acres given up to the making of guns, big and little, from the standard twelve-inch to that devilish little spitfire—quite as dangerous to human life—the one-pounder.

Here, day after day, 5,000 men toil in eight-hour shifts, twenty-four hours a day, turning out guns for the warships of Uncle Sam. Experts say that it is the finest gun shop in the world—not excepting even that of the Krupp in Germany.

And Secretary Moody once reported that it requires practically as much time to manufacture the armament of a battle-ship as to build the vessel. Under these circumstances it is easily comprehensible that with the contracts given out for two improved Dreadnoughts of 20,000 tons, the gun factory at Washington is now busy for twenty-four hours a day.

The material used for building is what is known as the navy-yard as open hearth nickel steel, fluid-compressed, forged, oil-tempered and annealed. Nickel steel is found more serviceable, as being more ductile and more elastic and of greater tensile strength than carbon steel.

When this material comes from the great steel companies it is rough-bored, and turned, the tubes within one inch of the finished dimensions and all other parts within a quarter of an inch. These great forgings are at once carefully weighed and minutely examined. Measurements are taken to discover whether they will work out to finished dimensions.

The lathe is the imperial tool for the making of a great gun—a "peacemaker." No. 1 lathe is the prize piece of the gun shop. It is capable of turning or boring a gun of 18-inch bore or less, and can turn a gun 57 feet long and bore for 51 feet. On this lathe, which has a bed of 128 feet 3 1/2 inches, the gigantic monarch, the 16-inch gun, capable of hurling a ton of steel a distance of twelve miles can be easily made.

The processes of building up a big gun, and, for that matter, the smaller guns as well, are the boring of the jacket, the turning of the tube, the shrinking of the jacket upon it, and the subsequent turning of the exterior, followed one by one by the shrinking on of the hoops. Each hoop is turned after it is shrunk on. Then follows the boring of the built-up guns, with the finishing of the powder-chamber, the cutting of the thread for the screw bore, the rifling of the gun and the attachment of the breech mechanism.

But shrinking on the great jacket of a mighty gun—a peacemaker, if you will—is the greatest work of art. It is an event. All the workmen gather to see it done.

It takes from thirty to thirty-six hours to heat up a large jacket, which may weigh as much as 34,000 pounds. At the signal of the foreman the big overhead cranes wheel over the pit. The smaller one lifts the lid of the furnace and swings it to one side. Then the great 110-ton crane comes into position, its great shackle is lowered rapidly, and the men, every one of whom is automatically perfect in his special duties, with iron rods adjust the chains.

At the motion of the foreman—he merely tips upward the fingers of his outstretched hand—the great jacket with a mighty humming and rattling of the crane, begins to rise out of the furnace. When it is once clear, it is swabbed out with wet swabs on long poles. Then the crane-man, with his eyes riveted on the foreman, moves the crane slowly with its dangling 16-ton burden until the jacket is exactly over the gun tube, which has been placed upright in the pit.

How much does a peacemaker cost? Well, Uncle Sam spends \$55,000 for a twelve-inch gun; \$25,000 for an eight-inch and \$13,000 for a six-inch.

There comes light—New York Times.

## THE GREATEST POLITICIAN.

How King Edward Has Earned the Title of "Peacemaker."

When King Edward began to play world politics no one can tell; yet the great statesmen of the earth have learned that he is master of the game. King Edward had few opportunities to play before he ascended the throne of Great Britain. As Prince of Wales it formally had been his part merely to smile and shake hands; as for taking any part in the great world game, his royal mother and her Ministers would have frowned upon any suggestion of such a thing. But in seven years he has made his personality so powerfully felt that to-day he is the arbiter of the peace of Europe, Asia and Africa, and has not a little influence upon that of America.

When Edward ascended the throne about seven years ago he found England isolated and proud of her isolation. Tradition made France her



KING EDWARD VII.

enemy, business was rapidly causing hostility between her and Germany. Russia was feared as an Atlantic rival, South Africa was suffering from the resentment due to defeat in war.

Edward's first striking play in the great international game was the alliance with Japan, a move so startling that the world could scarcely credit it at first. Its effect was to safeguard British interests in Asia to checkmate the covetous plans of Germany in the Far East and to put up a barrier before Russian aggression.

France, the ancient enemy, was the next nation to be courted. Edward knew that France and England had no real occasions for animosity, no places where their interests clashed. He knew that he personally had always been highly popular with the French people. Germany, a more recent enemy of France, was a menace to British interests in the Mediterranean and also to those of France in northern Africa. The opportunity was ripe and by personal talks with the statesmen then ruling France King Edward brought about an entente which is virtually an alliance. France gained by this a respite from any fear of German aggression, a fear which had recently become almost intense, and also the support of England in her plans in northern Africa, while England gained a powerful ally in the event of trouble with Germany. Again, France and Russia were allies and France could be of great value to England in persuading Russia to restrain her scheming for Asiatic dominion.

Italy, tired of the expense entailed by her alliance with Germany, was also courted by Edward VII, and largely through his influence was induced to enter into close compact with France and Great Britain. Edward's alliance with Japan and his understanding with Russia barred any extension of German influence in Asia; his alliance with France and his amicable relations with Spain and Italy made him master of the Mediterranean. Germany was and is having plenty of trouble of her own in her African possessions, and was not likely to want to extend her dominions there, while the United States could be relied upon to enforce the Monroe doctrine against any German aggression in America. So Germany was isolated effectually.

The Kaiser and his people were, however, chafing over this complete frustration of all their designs. Edward in his wisdom realized that his imperial nephew was the only present menace to European peace, but he also felt that it would not be difficult to win Germany over, for, after all, except in trade, there were no really important points of difference between Germany and England. The Kaiser had certain designs in the near East, designs that interfered only slightly with British policy and that Britain could afford to allow to be carried to fruition. And this is just what Edward agreed to do. He arranged a meeting with the Kaiser and the reports of what took place between them agree in asserting that a thorough understanding was arrived at, and that all important points of friction were smoothed away.

Thus it is that one man has by his own personal influence done more toward hastening the era of universal brotherhood than the representatives of the nations have succeeded in doing at their Hague conferences.

# TRAINING AT MULDOON'S

Obedience To His Rigid System is Everything.

## RULE "DO IT OR LEAVE"

Doctor's Medicine Not His Kind—Depew Wanted Gentle Speech—His Method Is to Curb a Man's Will and Bring Him Up to Good Physical Condition.

"It's a pity publicity has come to Prof. Muldoon so late in his life, for it will do him little good now, although, at that, he may live to a ripe old age," said a well-known Pittsburger to a party of friends recently as he outlined the course of treatment he received during eight weeks he spent in training at the Retreat and the same as was adhered to by Secretary Root and Chauncey Depew while they were there.

"We used to have to get up in a jump when we heard the rap at the door at 6 o'clock, and we soon had lots of fun racing down to the training room to see who could be first. Then for 40 minutes we would throw the 'medicine' balls before breakfast. I found something out my first morning there. I had prided myself on being a good ball player when I was a youngster, and the ball-throwing at Muldoon's looked like child play. I went into it heartily enough, but at the end of five minutes I told the professor I could not throw another time. He said I could and should go right on, for I was doing fine. At the end of 10 minutes I gave out completely and told him so. He saw I had enough, and allowed me to stop for that morning. When the running came I took on the baseball running spirit of my former days, but when about 10 feet from the end down I sprained

"You're not as young as you got to be," was all the sympathy I got from Muldoon.

"He was a stickler for system. His rigid form was everything, and if anyone didn't want to obey it he was quickly told to go pack his trunk and get out. If you don't want to do this, go pack your clothes and get out of here. You can do as you please at home, and don't have to pay me \$50 a week to do it, either," was his word, which was law. He has since raised the fee to \$60, I have read, but it was \$50 a week, and pay about \$80 for a Muldoon clothing outfit to train in, when I was there a few years ago. All his rules had to be obeyed to the letter. There were many very little things. One was that one of the two bath towels was to be folded exactly in the center to stand on. The other towel being used for drying. One morning a young man, I think he was from New York, came in for the first time, and didn't pay attention to folding the towel correctly. He had his attention called to it, and had to fold it right before he went on.

"One of the rules was that a fellow had to stand to put on his stockings. One of the men sat down to do it one day. 'Stand up,' came the order from Muldoon. No attention. 'You stand up, I say,' continued the professor. 'Say, you,' continued the professor. 'Say, you pull that sock on in a hurry, pack your trunk and leave.' That was what the fellow did. Some of his friends intervened, but Muldoon would have nothing to do with him.

"Medicine was not allowed. 'If you're under the doctor's care, don't give me your money,' was Muldoon's word. After dinner the first evening I was there, I asked one of the waiters for a glass. 'What for?' he asked. 'I want to take some medicine,' I replied. 'You can't have the glass; professor don't allow anybody to take medicine here,' the fellow informed me. A few minutes later Muldoon asked, 'Got any medicine in your trunk?' 'Yes, some my physician gave me,' I told him. 'Well, throw it away; we don't use that kind of medicine here.'

"That was Muldoon. If you thought you had come to his place to have a good time and do as you please, you were mistaken. If you thought you would be recognized for something worth while and somebody in particular, as you might be in your public or business experience you were mistaken again. It is said Senator Depew went there to take training, and that the first evening he was there he was doing something that wasn't according to the Muldoon rule. 'Stop that,' came from the professor, Depew paid no attention. 'Hey, you; stop that, I say,' with still no attention from the venerable senator. When Depew ventured that Muldoon had been speaking to him, he asked, 'Is that the way you address gentlemen?' It was, I remember a southerner, a worthy citizen of Richmond, who thought the same as Depew about addressing gentlemen, and who, like most of us, used to 'cuss' Muldoon to a finish. After a fellow got used to the thing, however, it became easier to understand.

Muldoon simply curbed a man's will and gave him such physical training as built up his system to normal condition.

## INSURANCE MEN NOW EXILES.

Broken in Health and Spirit Many Have Disappeared.

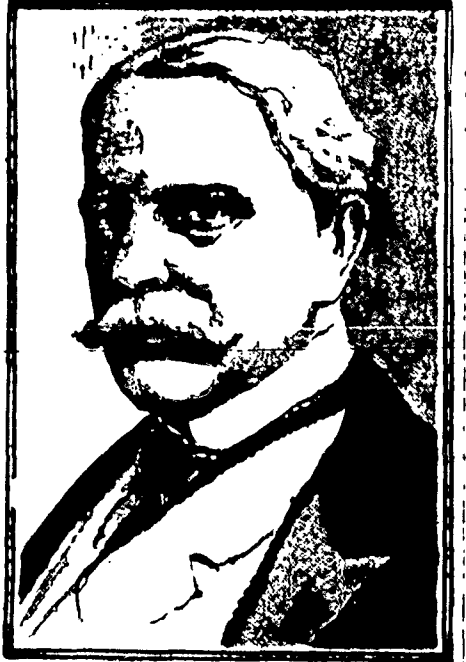
With scarcely an exception the men who, before the disclosures of the Armstrong Committee, were prominent figures in the management of the three great insurance companies have dropped into oblivion. Their names are now seldom heard, so complete has been the eclipse. Many of them, their reputations blasted by the insurance revelations, have gone into exile in foreign countries; others, with wrecked health, are passing equally miserable days.

Ask those who were the former intimates of these men where they may be found and the inevitable reply will be that they do not know. No one seems to bother to keep in touch with them and so far as the exiles are concerned they seem more than contented to be ignored.

A well known insurance man was asked a few days ago if he had heard anything lately from Alexander, McCurdy, Hyde or any other of the insurance wizards who, only two years ago, were in the habit of being freely consulted about anything pertaining to insurance.

"No," was the reply. "they have all dropped out of sight. We never hear a word from them, never anything about them. It is as though they never lived except, of course, for the reputation they have left. The hardest job a man could have is to round up those men who directed things in the three companies before the Armstrong Committee got to work."

Of the insurance presidents, Richard A. McCurdy former head of the Mutual Life has managed to keep his whereabouts most profoundly secret. McCurdy resigned from the company Nov. 29, 1905 while it was under fire. He gave up a salary of \$150,000 a year sold his magnificent estate at Morristown and went abroad. He has not returned. It is said that he is established with his family in a quiet retreat in the outskirts of Paris, but McCurdy has never communicated with his friends here, and nobody is certain just where he is. McCurdy's health was shattered when he left this country, and physicians declared that he had not



JAMES W. ALEXANDER.

many years to live. Worry had undermined his constitution.

James W. Alexander, after his resignation from the presidency of the Equitable, suffered a complete breakdown in body and mind and was taken to a sanitarium. Later he went to Europe, but his health did not improve. Recently he was reported to be in Shanghai, still under rigid care of his physicians, but gradually failing.

Chauncey M. Depew, who received a retainer of \$20,000 a year from the Equitable and had to resign as a director, is seldom heard from. While once the stellar attraction as a post prandial orator and storyteller at famous banquets, his presence is no longer in demand.

George Burnham former vice-president of the Mutual, who was sent to Sing Sing to serve a sentence of two years on the charge of forgery, was granted a new trial by a higher court after he had been in prison for a few months.

Andrew Hamilton, who acted as legislative agent for the New York Life, and left the country to avoid appearing as a witness before the Armstrong investigators, is now in Paris.

Andrew C. Fields, legislative agent for the Mutual, whose "House of Mirth" at Albany figured in the developments of the insurance scandal is a pitiable wreck and hobbies painfully about on crutches. He is living out of town away from his former associates.

Others, who have become lost to the insurance world since the Armstrong probe and are no longer seen in their old haunts are Robert H. McCurdy, son of the former Mutual President, and Louis A. Thiebaud, son-in-law of Richard A. McCurdy, who together made nearly \$3,000,000 in commissions out of the company. Thiebaud was general agent of the Mutual.

## SUPERSTITIOUS MAN.

The Fear of Ghosts Is Very Deep-Rooted.

Deep down in the heart of man there abides a firm belief in the power of the dead to walk the earth and affright, if such be their pleasure, the souls of the living. Wise folks, versed in the sciences and fortified in mind against faith in sight that deavors of the supernatural, laugh ideas of the kind to scorn, yet hardly one of them will dare to walk along through a graveyard in the night, or if one be found so bold he will surely hasten his footsteps, unable wholly to subdue the fear of sheeted spectres which may rise from the grass-grown graves or emerge from the moonlit tombs and follow on, for, strangely enough, the dead, if not actually hostile to the living, are esteemed dangerous and dreadful to encounter.

It used to be the fashion to sweep away all such notions by saying that they had their origin in the childhood of the race and that they sprang from fear of the unknown. This unquestionably was the easiest way to dispose of them, but was it fair? The subject possesses intense interest for a great majority of mankind, and, though the existence of ghosts is unproved, there is undeniably a vast deal of testimony in their behalf that deserves serious and respectful consideration. Fortunately within the last few years the attitude of science toward the problem has altogether changed, and, actuated by a new spirit of inquiry, the wise men have been engaged, thoughtfully and without prejudice, in studying it out.

While it cannot be said that any final and definite conclusions have as yet been reached, an immense amount of evidence has been sifted—enough to show pretty conclusively, for one point, that the traditional spectre of the Cook lane school, with clanking chain and attributes disagreeably suggestive of the grave, has no basis in fact. On the other hand, there are certain phantoms, altogether different in their characteristics, in whose behalf a mass of testimony is adduced far greater than would be required to establish complete proof in any ordinary case in a court of law. Nothing short of absolute demonstration in such a matter can be satisfactory, but the evidence in question certainly staggers incredulity.

Our fear of phantoms appears to spring from a dread of the unknown, the mysterious and the intangible. That it is a groundless terror is proved by the fact that in many thousands of cases of alleged spectral appearances subjected during the last few years to painstaking investigation not a single instance has been found in which an injury was inflicted by the ghost upon the person or persons to whom it presented itself. So that, even if we are to accept apparitions as veritable, we ought to regard them with curiosity rather than with apprehension, and instead of trying to avoid such supernatural visitors we should eagerly seek an opportunity to be haunted for the sake of observing for ourselves phenomena so intensely interesting.—Lippincott's Magazine.

## THE NEW SHORT RIFLE.

British Government Has an Improved Weapon of Defense.

Considerable attention has been given by the Government, says The London Express, to the development of the new short rifle in order to overcome the defects of that arm. The result is the invention of a new mark of the short Lee-Enfield, which is likely to equal the long rifle for every kind of practice, including the deliberate work of competitive matches. Hitherto the short rifle has not been used in matches, even by the army experts.

The new rifle, 20 of which have been made at Enfield, is of the same pattern and length as the first short pattern, but the sighting, charging, etc., are so vastly superior as to make the rifle almost new in actual value. Experts have tried the arm, and the unanimous opinion is that it is an ideal combination of lightness and accuracy—the best in the world.

The foresight is a rectangle, and the backsight is shaped as a U. This gives a straight line formed by the foresight over the backsight, and is both simple and handy for rapid aiming. The hood on the foresight is cut down like a wide U, with the points turned outwards instead of inwards; and the soldier will thus have a clear sight and will not mistake the point of the hood for the foresight in rapid aiming, as he is now liable to do.

The backsight, for practical, rapid work, can be moved with the left thumb whilst the rifle is at the shoulder and the aim on the object. For target work the sight can be moved to minutes. The cap of the backsight is at right angles, and is checked to prevent the sun reflecting on it. The magazine can be taken out and carried in the pocket, and the charger-guide is solid, as in the Mauser. This is an excellent point. There is also a safety catch of a much-improved kind, and the "pull-off" is divided, so that the final pull of the trigger is only two pounds, thus preventing a man "pulling" his rifle off the target with a hard re-lease. The pull through and oil bottle of the old rifle have been added, and the arm so simplified that it can readily be understood and used by the recruit.

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