

Superior Woman Wanted. 47
 Wars 48
 Robert C. Morey, Monroe, N.H.

BUTTER MAKING
 By Arthur J. Pond
 Richford, Vt.

As I attempt to write an article about butter making I will be mentioning my maternal grandfather, William Coburn Cramton, who to me would have been a typical butter-making farmer of his era. He died in 1922 when I was twelve years old, but I can remember his dairy well, also his making butter and peddling it. He paid for his farm around the turn of the century by this process.

He had a route one week in Enosburg Falls and the next week in Richford. Both villages were seven miles distant from his farm near East Berkshire. His trip was made by horse and buggy or sleigh. After he died my uncle Homer Cramton carried on in the same way until he finally sold the farm-separated cream to the Maple Hills Creamery at East Berkshire, Vt.

Most butter was made from sour or ripened cream as the butter itself wouldn't turn rancid as quickly if the cream were properly soured first. Twice a week was the usual churning time of the average butter maker. The cream was kept as cold as possible for two or three days, then warmed up to turn or ripen. When the cream was in the souring process one wouldn't want to add fresh cream to the batch or it would cause the butter to be streaked. I remember him using a wooden paddle a lot to stir the fresh cream, when after separating the milk, new cream was added, also after the cream started souring.

Cream wouldn't want to be kept too long and get bitter as it would make butter with an off flavor. The universal churn used that I remember best was the barrel type manufactured by the Samson Power and Thresher Company of East Berkshire. Some people considered that the barrel type churn was one of the best types to use as the fall of the cream from one end of the churn to the other, as the churn was being turned by hand or sometimes horsepower, was ideal as a natural way to separate the globules of butter from the buttermilk.

I can still hear the ker-chug of the cream as the

churn rotated. Just before the butter came the cream would swell and stick a little to the churn, and there was silence for a moment, after which you would suddenly hear a ker-chug and a ker-splash as the balls of butter formed and separated themselves from the buttermilk. Sometimes during the process the churn had to be vented to let out gas or air. This was done by pulling a plug out of a hole in the top of the churn, the same hole that the buttermilk was drawn from.

After the butter came, the buttermilk was drawn off and the butter rinsed with ice water or very cold pure spring water, to wash out the buttermilk left. Then the butter was placed on a butterbrake, where it was worked by turning a crank that ran sort of a roller over it, the salt added, worked in, and some moisture worked out. The old-fashioned formula was an ounce of salt to the pound of butter, which would be rather salty according to today's standards.

Of course the expression "churn gain" came from butter making. For instance, if one had a dairy producing 400 pounds a day of 5% milk, according to the Babcock test, the result would be 20 pounds of butterfat. The average churn gain, including the salt and moisture, was about 15%; thereby one should have about 23 pounds of butter. If butterfat and butter sold at the same price, a little extra profit came from the churn gain.

Several years ago one summer, the price of butter rose two or three cents, and a certain lady from South Richford brought her butter to town to sell or trade. Someone asked her if she weren't doing quite well making butter that summer? She replied that she would be doing right smart, if it warn't for having to buy the salt.

It was aggravating in the fall and winter when the cows were stripping, to have the butter a long time coming. It was also disconcerting to have the butter come too quickly or soft, due to churning, when the cream was too warm. One could rinse it with ice cold water, to make the butter a little firmer, but the butter would always be a little soft at room temperature. I think the ideal temperature to churn was around 60 degrees, give or take a little according to the season.

One operation that I recollect was that just

before the butter was placed on the butterbrake, the proverbial teakettle full of steaming hot water was poured over the brake, wooden paddles and butter mold. This was done not just for sanitary reasons, but, as I remember, if it were done immediately before the butter was worked and handled, it wouldn't stick to the wooden utensils.

I can't remember it, but at one time my grandfather put his butter in tubs. My mother told me when he filled orders for his customers to use all winter, he liked to make their butter in October, when the cows were in the fall feed or rowan. Another reason for the ounce of salt to the pound of butter was to help preserve it all winter, kept mostly on cellar bottoms.

I knew of a few extra-good butter makers who never used a thermometer. In the summer, when they ripened the cream, they might keep it in the cream jugs or cans on the cellar bottom, and in the winter in back of the parlor heater. It seemed to be instinctive to them just what to do, and their butter would churn out firm and of a good flavor.

The farmer who made and peddled premier butter received a few cents a pound extra, over what ordinary creamery butter sold for. The butter maker that did that processed his own cream into butter, and also created his own market. He was a producer, processor and salesman combined.

My old friend George Farmer told me that when he was a boy living with Jed Weightman, in the latter part of the nineteenth century, up Richford Center way, Jed and a neighbor were talking politics. George told me just who the candidates were, running for president, but I have forgotten. Jed told his neighbor that if the wrong candidate were elected the bottom would drop right out of the price of butter. The neighbor replied: "It won't make a bit of difference, one will eat as much butter as the other."

My grandfather was a pioneer milking a winter dairy, so that he could supply his butter customers all winter. For his day he had a reputation of being a high grain feeder. One rule of the thumb he had was when a hundred pounds of butter would buy a ton of grain, it

was profitable to feed it. I can remember the four-quart measure he used, feeding it full twice a day, making a total day's feed of eight quarts of grain. Another rule of the thumb was when his dairy was producing one pound of butter a day for each cow milking, he considered it good production. That would be sort of small today.

I can remember when I was real small, sitting on a bench in front of Will Rublee's store in East Berkshire, hearing men talking, saying that Cobe Cramton burned his cows out by feeding so much grain. Actually they were all used up by the time they were ten or twelve years old.

My father told me of working for a farmer ninety years ago, when my dad was seventeen years old. The farmer was Horatio Gates and his farm was located in the edge of Enosburg on a hill outside of East Berkshire. He made sweet cream butter, not salted as much, and no doubt was shipped on butter day from East Berkshire by refrigerator car to the cities, where there was probably a Jewish trade, for no doubt a premium price. I imagine anyone had to be extra careful churning sweet cream. My dad told me Mr. Gates would churn anytime, day or night, when the cream was just right, whether due to the temperature or other reasons I don't know.

My dad also worked for his brother in a country store in East Berkshire and used to tell about how one day a week the farmers would bring their butter to be shipped by rail to the cities. The buyer had some sort of glass rod which he inserted in the tubs of butter to judge its quality. It could be of too high moisture content, streaked, or poor quality of salt used, etc. Those whose butter didn't meet proper specifications had to take a lower price.

A great boon to farmers that didn't make the highest grade butter was when the old Franklin County Cooperative (later United Farmers) and the Maple Hills Creamery started taking farm-separated cream. I never witnessed churning in either of the creameries, but both had a reputation of producing better-than-average creamery butter.

East Berkshire is located on the Central Vermont Railway, which made it a shipping point for all kinds of farm produce, including wood products from Montgomery, such as butter tubs. East Berkshire lay where the Trout River from Montgomery emptied into the Missisquoi River, being in a valley that served all of Berkshire, Montgomery and parts of Richford and Enosburg, where it was advantageous geographically.

I can't remember the butter tub days but do recall collect butter and cream being shipped by train from the creameries until fluid milk took over.

Two popular butter makers, seen on the streets of Richford with their horse and buggy or sleigh, were Ed Coons and Melvin Galer. They continued until well towards the Forties.

As a boy in my teens I can remember Nate Duba supplying a meat market in Richford with butter and dressed pork. Nate was the son-in-law of Mr. Gates, who made the sweet cream butter.

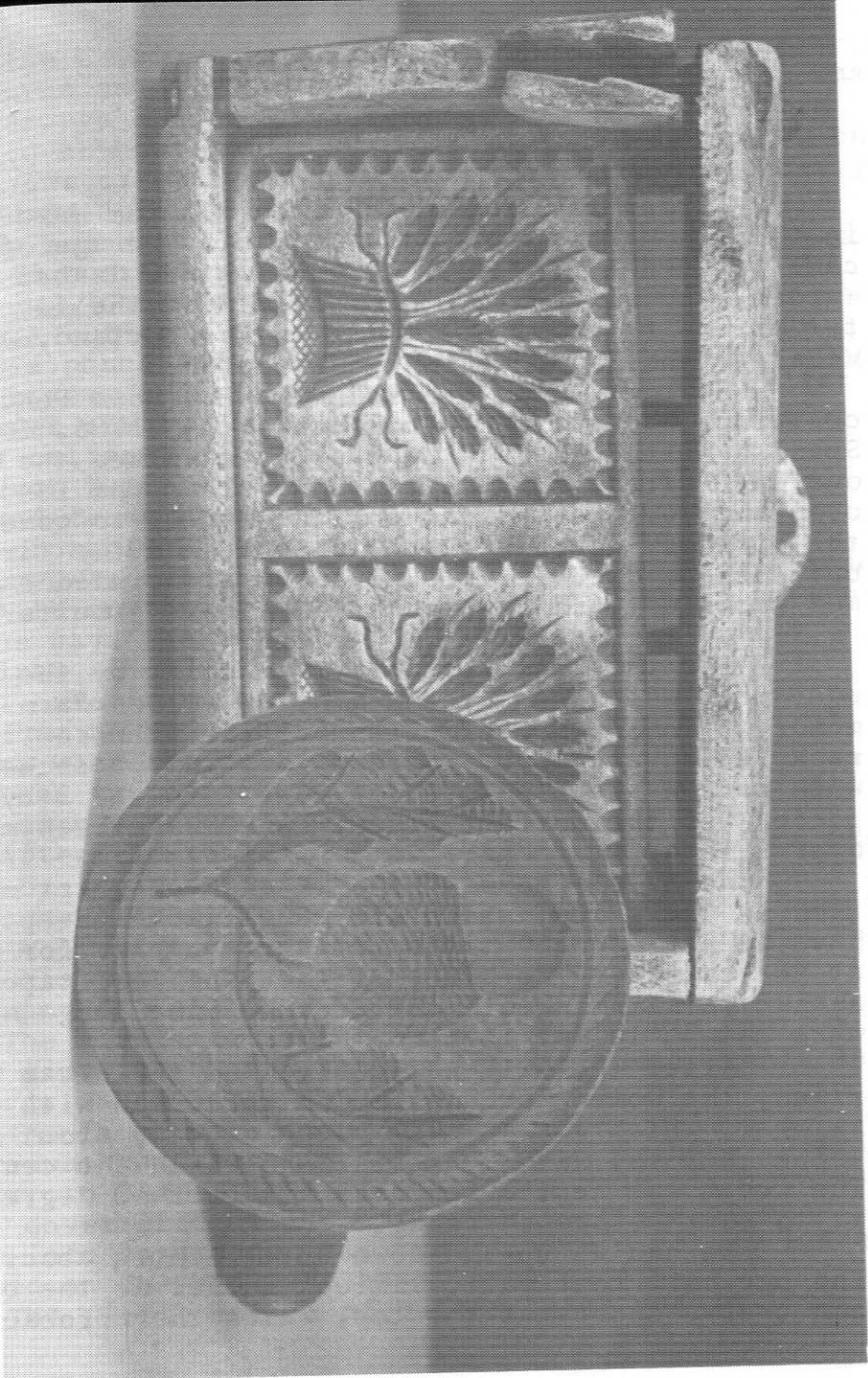
Back in Prohibition days there was a certain gentleman in Richford that ran a taxi. He carried people to Abercorn, Quebec, to imbibe of their favorite beverages. Butter was a lot cheaper in Canada and to supplement his income he smuggled a little butter. Also he kept two cows on his small holdings. Even with modern breeding and feeding, no two cows ever produced as much butter as his two did.

When I was seven years old visiting my grandmother a while, sometimes for supper she would make toast from homemade bread, toasted over the coals of a hardwood fire. She would smother the toast with homemade butter, along with a glass of rich Jersey milk, a treat I have never forgotten.

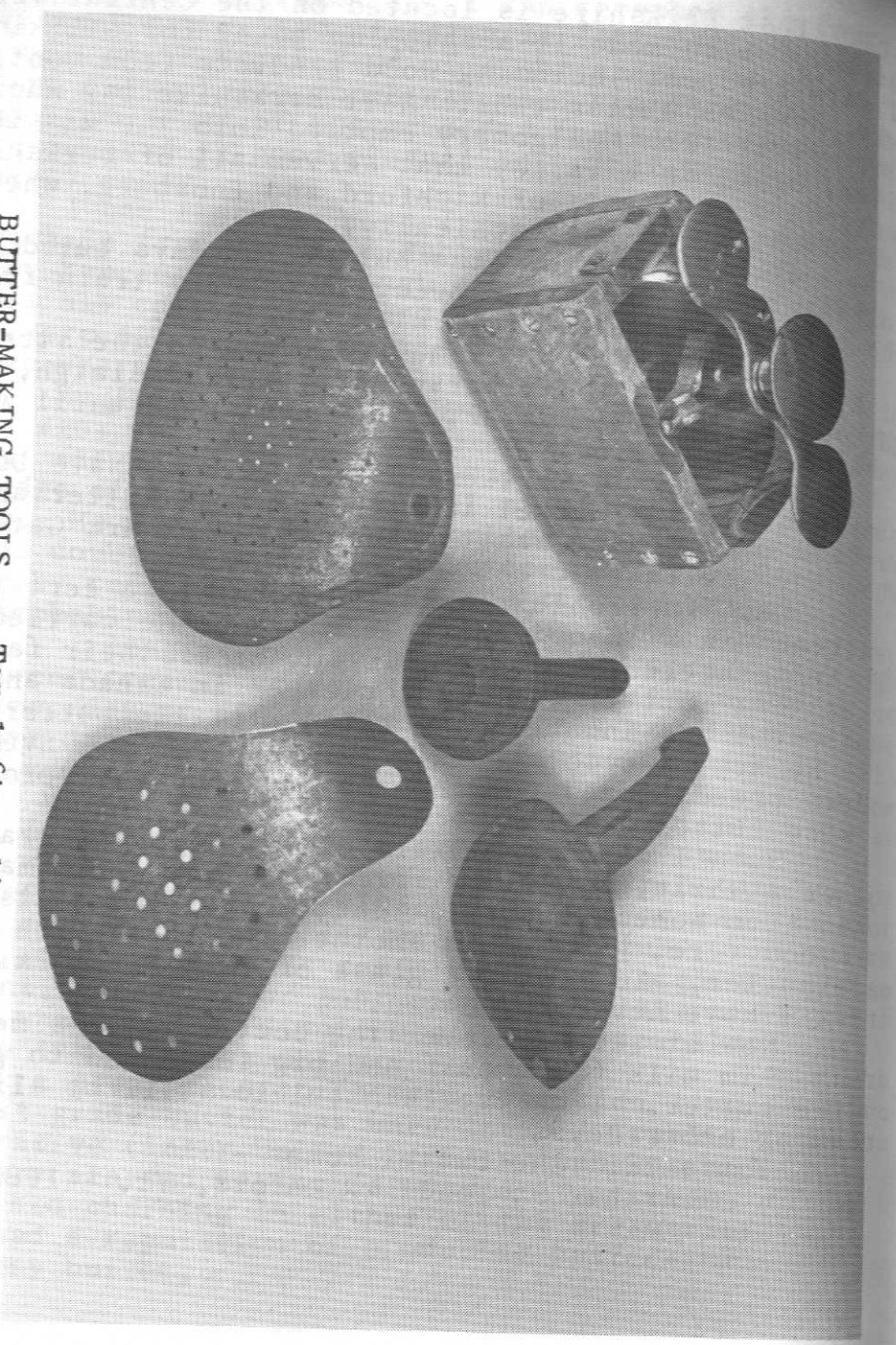
Now at seventy-seven the doctor advises me to drink skim milk (once calf and pig food) and to go easy on the butter. I can be thankful to still be alive and dream of other days.

Yours till the butter comes -

Arthur J. Pond - Richford, Vt. - 1986



The butter one-pound press in previous photo also stamped the blocks with a distinctive design, as did the smaller ball stamp.



BUTTER-MAKING TOOLS -- Top left, adjustable butter measure; top center and right, wooden butter stamp and butter worker; bottom, tin cream skimmers.

MAKING BUTTER AT WARDEN FARM

By Robert L. Warden

Barnet, Vt.

May 1985

Warden farm was started by William Warden, born in 1736 in Murdistown, Scotland. At the age of 48, he came to Barnet, Vermont, with his wife, Isabel Laird Warden, and six children. They stayed the first winter with a friend they had known in Scotland, John McLaren, who had come ten years before.

He bought one hundred acres on Ross Pond in the center of Barnet township, January 19, 1785, for 95 Spanish Mill Dollars. He must have walked the two and one-half miles from McLaren's to clear the land for a crop and build a shelter for the family to come to in the spring. We do not know when he had the first cows, but when he died in 1810 his estate included cattle and machinery, so he probably was making butter.

For this information, I am going by the old equipment which we have on hand at Warden Farm and my memory. In our house cellar are the milk cooling racks which are about 10 feet long and 20 inches wide with narrow slats notched on edge into the 3-by-4 end pieces for the bottom. These racks have been made over into apple racks.

We have some of the six- and ten-quart milk pans used in the 1860s, which are three inches deep. They have been used many times for chicken pies for suppers at the church. The sides of the pans were tapered to assist in skimming off the cream. Some large milk pans were bought in May 1876 for \$30.

After the milk had cooled and the cream had risen, the women would skim off the cream with a skimmer, which was an oval piece of tin, about six inches across, with many small holes in the center. The cream was kept a few days at about 60 degrees for it to sour before churning.

We had an up-and-down butter churn about three and one-half feet tall, sixteen inches at the bottom and twelve inches at the top, which they probably used.

We have the Lackie up-and-down churn which was smaller. These churns had a cross plunger on a handle, which was run up through a hole in the cover. It took from ten minutes to an hour for the butter to come, depending on how well one cared for the cream. One entry in a diary says, "Churned in three minutes."

My mother's family, the Lackies, made butter, cheese and buttermilk cheese. One entry in mother's diary says, "Churned sweet cream at 40 degrees."

The butter was salted, a little less than one ounce to a pound, so it could be stored and packed in tubs or boxes, and stored in a cool part of the cellar which never changed much from 50 degrees. Many homes had root cellars.

Much butter was purchased by the local storekeeper and teams would take the loads of produce to market, probably Boston, before the railroad came through, which was a six-week trip for oxen with a load of supplies on the way back, with overnights at taverns along the way. We have a sled which we expect made some trips.

I have it secondhand that an old man made the remark that he made the trip many times and missed it very much when the railroad came through about 1850. It had been the happiest days of his life, meeting his friends at the taverns and in Boston.

After the railroad came through some produce was shipped by individual farmers to commission merchants in Boston. My father, Horace Warden, had a cousin, Erskine Warden, who was a commission merchant in Boston, to whom he sent his butter in tubs in 1877, receiving 17 to 40 cents a pound.

The first mention of butter trunks was in 1895; at that time the butter was put in one-pound prints and wrapped in waxed paper and shipped in 24- or 32-pound butter trunks which were returned to the producer. These trunks had trays to hold prints. We have several of these old butter trunks; most were made of brown ash lumber, dovetailed at the corners with trays of one-quarter-inch basswood. All trunks have a return address stenciled on the end. We have the stencils.

The first mention of butter color was in 1894;

it cost seventy-five cents, but we do not know for what amount. June butter is naturally yellow when the grass was lush. Other times of year, they added coloring made from dandelion blossoms. You used only a small spoonful in the churn.

November 10, 1890, my father installed a Barden Creamery, to separate the cream. I have the flyer advertising it. That creamery is one of the things I should have kept, but did not seem to have room to keep everything. It was a wood tank painted yellow with green trim, lined with galvanized iron on legs for a pail to set under. The water tank was about five feet by thirty inches by two feet deep. It had ten cans for milk, nine inches across by twenty inches high. Each would hold three to four gallons of milk. The bottom was a funnel with a draw-off faucet down through the bottom of the water tank. We have brass float plugs which would float at the cream-skim milk level, to shut off when the skim milk had been drawn. The cover of the tank had a screened vent.

Other types of cans for separating the milk in a water tank had flat bottoms that you could set in the water tanks and take out to draw off the skim milk through a faucet. These had a sight glass in the side to watch the cream level go down. The Lackie family had some of these. I got some from sister Mary and Bill Warrell's farm where George Richardson farmed in the 1890s. I gave one to the Barnet Historical Society.

October 1894, Dad installed a centrifugal cream separator. A little later he installed a dog, sheep or calf power to turn the separator. I remember the operation. We still have the calf power and I have seen two others. It took a calf or sheep weighing 100 pounds or more. I remember one- and two-horse powers for sawing wood.

We used the United States cream separator until January 1916 when he bought a DeLaval #17 electric cream separator of Harry Carr of St. Johnsbury, Vermont, which we used until about 1930, when we started to ship milk.

Dad did ship milk to Boston on the milk train a few months, about 1911. The forty-quart cans of milk had to be delivered to the East Barnet milk platform

to meet the milk train by 9 a.m. seven days a week, and the empty cans had to be picked up. You needed three sets of cans. Dad soon got sick of that and went back to making butter.

When I took over the farm in 1923 we were still making butter and selling it at the local store. We were using a barrel butter churn bought September 15, 1879, also a butter worker bought May 15, 1880. We still have this equipment, even the one-pound butter print which has a W on each quarter. Dad bought it in October 1903 from Jim Smith at West Barnet for \$1.75. I sold cream to a local butter plant a few years in the late 1920s.

April 19, 1890, a Barnet Creamery meeting was held. I expect they were making plans for a butter plant, as in 1891 Dad delivered 14,177 pounds of cream which tested 22.25% butterfat, which equaled 3,094 pounds of butterfat at 17 to 26½ cents per pound, equals \$693.10 for his year's production. Butter plants were built in every village or community from then on by groups of farmers or an individual. Farmers would take their milk each morning to the creamery where it was separated and they could take their skim milk and buttermilk back home to feed calves and pigs. The butter maker would test the milk for fat content and you got paid for the butterfat each month.

Some separated at home and took the cream only twice a week; then they needed ice to cool the cream; that meant cutting ice and storing it in an icehouse in the winter. Dad built an icehouse in January 1891.

Sometimes a team would pick up cream from several farms in an area twice a week. Most of these butter creameries had a butter print to mark their own product and maybe a print to mark butter for a special customer.

Passumpsic Creamery converted the old church at the head of Church Street, which was abandoned when they built the new church in 1895. We have a three-gallon cream can of Passumpsic Creamery with a wooden plug. Dwight Gould was manager and sold the entire production at Springfield, Massachusetts. Pliney Douse was butter

maker. Albott Granger and Mark Bruce worked there. Lewella Gould Denio wrapped butter at the plant. Before 1920, Turner Center Company owned the plant for a few years. Sometime Parkers built a new plant near the Passumpsic railroad station. From 1920 to 1931 Stuart Milk Company operated it as a milk plant. The farmers were not satisfied and struck for better conditions. New England Dairies handled their milk and the plant was closed for good.

East Barnet Creamery was built by the brook just north of the village. James Moore was manager. Charles Parker was butter maker the last it was operated. Dad took cream there for a while. I remember taking cream there a few times as a boy.

McIndoes brick creamery, with a slate roof, was built in 1908. It still stands between the railroad and the river.

West Barnet Mountain View Creamery is now used to make glass objects. In 1934 it was bought by Caledonia County Cooperative Association and made over into a milk plant with Albert Achilles as manager. Olie Exley had been butter maker and continued on as main operator of the milk plant. Nick Bishop and Ted Conent worked there. Henry Bradley did some repair work. Harold Somers was manager for awhile. O. W. Baker, who had set up Trout Brook Creamery at Concord, Vermont, with trucks delivering milk to Boston, was manager at West Barnet one year.

About 1937 they installed cheese-making equipment storing the cheese at Darling Farm in East Burke.

At one time about 200 farmers were sending milk to the plant. I hauled my own and some neighbors' milk for seven years with a pickup truck. Several large trucks picked up milk from farms as far away as St. Johnsbury, Monroe, N.H., and Groton. I think we got up to about 21,000 pounds of milk a day.

Dudley Fitzgerald had five trucks, 100 or 200 cans each, making the round trips to Boston each day. Ed Strobridge, Joe Trigilio and John Ashford were some of the drivers delivering milk and cream to many milk-

delivering retailers. Later George McLure contracted for the trucking job and built a garage by the creamery. At that time there were about 270 small retailers around Boston. One operator had six one-horse delivery wagons, peddling milk daily to stores and homes. He told me that a horse soon learned his route so the driver could deliver more milk to homes than with a truck. Presently, in the 1980s, there are no home deliveries and only a few companies handling milk around Boston.

I was president of Caledonia County Cooperative several years. Stanley Beal, Emma Bradley, Francis Emmons and Mary Main were bookkeepers. The cooperative joined Vermont Dairy Cooperative with headquarters in Bradford, with Dwight Beebe as manager, which was later sold to Whiting Milk Company. They went bankrupt, making a hardship for many farmers. William Nutter lost \$3,000. New England Milk Producers Association reimbursed their members.

About 1959, bulk milk tanks at the farm were the coming thing, with easier and faster handling of milk. Bulk tank trucks picked up all milk at the farms, delivering it to reloading stations where it was pumped directly into huge trailer trucks to be delivered to markets, so the local butter plants are all closed.

The Barnet Creamery plant was sold to H. P. Hood and Sons Company. They built a new milk plant near the railroad track where the milk could be pumped directly into tank cars for delivery to their plant in Boston.

Cabot Farmers Cooperative is the only milk manufacturing plant operating in the area. They deliver much milk to southern New England markets, make butter, cheese, yogurt, dips and other specialties from about 1,200 farmers, with a fleet of trucks delivering products throughout the northeastern United States, and do business by mail order.

South Peacham Creamery Association built a butter plant about 1900. It was a farmers' group. John Somers was the butter maker at one time. About 1930, Fred McPhee was manager. This plant was changed to ship milk about 1930, then sold to a new England Milk Producers Association and was soon closed.

North Ryegate farmers built a butter plant with Quincy Whitehill as manager. We have some of his correspondence.

George Milligan, grandfather of my wife, Marjorie Milligan, worked for Fowler Ford in a woodworking shop at South Peacham, Vermont, in the 1880s. Later he bought the shop. They made butter prints, shipping trunks, tubs, boxes, window sash and blinds. Marjorie's father, George, as a boy carried the butter prints three miles to the Bickford farm, where the women carved the designs on them. After making numerous trips, he told his father that if he had the tools he could do the carving rather than carry them three miles each way. They got the tools and he self-taught himself. About 1900, he married and worked at Roy Brothers' croquet factory at East Barnet. They made prints and he carved them for about 25 years.

Then he moved to Massachusetts, working in a garden furniture factory, and still carved prints for Roy Brothers. In 1933, the family moved to New Hampshire and he set up a little shop to make the prints and print boxes himself.

In 1939, he came to live with Marjorie and me, bringing his shop machinery, and set it up in our garage. He had a homemade table saw fixed up to dovetail the corners of the print boxes, a turning lathe, planer, and his tool chest which he had made when he was only 17, of cherry lumber, using brass tacks to make the initials to mark it.

We still have this equipment and tools, also a box of rubbings, which he took off of the prints he had made to record the patterns which he had carved. He carved some prints in Old English letters. He made prints for Cabot Farmers Cooperative Creamery of Cabot, Vermont, Plymouth Creamery of St. Johnsbury, Vermont, Turnbulls Creamery of Orleans, Vermont, H. P. Hood and Sons, and many others, also some farmers. One farmer gave his print back to Marjorie for a keepsake. It is the only one we have that we are sure he made.

At our home he obtained his wood for prints from our woodpile. He would usually pick a straight-grain,

and dried maple block and then saw off the slices the thickness that he wanted, about one inch thick, so he could carve on the end grain, and store them in a box of green sawdust so they would not dry out and season-crack.

To make a print he would cut the block to size, one-half pound or one pound, sometimes about 6 by 10 inches for a print for 24 small individual patties for a restaurant. This block he would soak in a pan of water before carving it. He also made a print box of wet wood.

A butter print and box must be kept wet. Sometimes someone would complain that their print was cracking or warping. They had not kept it wet. Our butter print at Warden Farm was always stored in brine in an earthen jar under the cellar stairs. Last year I put it in a pail of damp sawdust to let it slowly dry out and not season-crack.

The diaries of my father, Horace J. Warden, from 1869 to 1923 contain many entries about butter making. In 1869 and 1870 he sold butter at 40 cents a pound, but in 1871, at 34 cents a pound. Other entries:

1872: sold 1,172 pounds of butter. 1873: butter 40-48 cents a pound. 1874: sold 29 tubs of butter, 1,535 one-half pounds at 40 cents a pound for \$614.20.

1875: bought 58 new tubs at 50 cents each. Sold 1,671 one-half pounds at 31 cents for \$520.03, also 534 pounds for \$149.36.

1876: sold 2 tubs of butter. April 17, butter was worth 37½ cents a pound. May 15, butter was worth 25 cents a pound. May, bought large milk pans for \$30 total. November, sold 42 tubs of butter which was 1,410 pounds of butter. March to June they sent 695 one-half pounds of butter.

1877: May 28, sent 6 tubs of butter for \$68.80. October, sent 36 tubs of butter to Erskine Warden in Boston. November, sent 3 tubs of butter to Erskine Warden at 26 and 27 cents. April 9 to June 11 they made 20 tubs of butter -- 678 pounds.

1878: April 10, churned for the first time using

the large milk pans.

1879: February, got ice (probably cut ice at the pond) RLW. September 15, got barrel churn at the fair. March 31 to June 9 they made 17 tubs of butter -- 632 pounds.

1880: March 15, got butter worker. October 9, bought 11 butter tubs at 25 cents each. (Sometimes he bought both spring and summer butter tubs at different prices.) March 26 to June 7 they made 16 tubs of butter -- 551 pounds. It would be about 34 pounds per tub.

1890: November 10, got Barden Creamery. April 19, a Barnet Creamery meeting. November 17, took cream to Barnet Creamery.

1891: shipped 14,177 pounds of cream which tested 22.75% which equals 3,094 pounds of butterfat. It brought 17 to 26 cents a pound, equal to \$693.10 for the year.

1892: took a load of ice to Barnet Creamery. February 16, he churned 150 pounds of cream and got 36 pounds of butter. Sold 11,799 pounds of cream which was 2,832 pounds of butterfat for an average price of 22 2/3 cents a pound, equal to \$638.54.

1893: 15,876 pounds of cream, 3,597 pounds of butterfat, average price 24.2 cents per pound, equals \$770.90.

October 1892 to October 1893, 17 cows freshened.

1894: churning. June 13, commenced to use ice. October 13, commenced to use new United States separator. January to July 21, sold to Barnet creamery 2,500 pounds of butterfat at 17 to 26 cents a pound for a total of \$505.95. July to December, 1,960 pounds of butterfat at 22 to 26 cents a pound for a total of \$434.67. Bought butter color for 75 cents and 5 pounds of butter paper.

1895: bought three butter trunks. Sold 4,792 pounds of butter for a total \$1,045.40.

1896: sold 4,600 pounds of butter at 16 to 25 cents a pound for a total of \$845.

1898: sold 4,877 pounds of butter at 14 to 23 cents for \$919.63.

1899: sent 5,478 pounds of butter for \$147.99.

1900: sold 5,449 pounds of butter at 18 to 26

cents a pound for a total of \$1,283.56.

1902: sold 3,204 pounds at 21 to 28 cents for a total of \$637.80.

1903: January to September they shipped cream to Barnet. October, they bought a new butter stamp for \$1.75.

Horace Warden's April 1, 1878, diary entry is: "Churned the first time." I remember Aunt Mary Warden, my father's sister, saying that as a girl she milked the farrow cow in the winter. Most animal life have their young in the spring. Cows are the same, naturally freshening in March or April, so farmers produced butter mostly March to December, sometimes milking a farrow cow that had not got bred to have milk for the family through the winter.

Having the cows freshen in the spring made a flush of butter in the fast grass-growing season. This depressed the price of butter, as you will notice in the diary entries and the variation in butter prices throughout the year. I think there was a slow change made in the 1890s when the butter plants were built to produce butter on a year-round basis. Presently, in the 1980s, there is a special effort to produce milk in the fall months.

Most farmers have had a high day in June and a low production in November, making a problem for milk plants to manufacture the surplus into butter and cheese in the overloaded facilities in June that were not needed in November.

My father's diaries go to 1923. He passed away in February 1923 and I left high school and stayed home to operate the farm at only 16 years of age. I continued to make butter a few years, then took cream to Mountain View Creamery at West Barnet, most of the time until it was changed over to Caledonia Cooperative Association in 1934. I had shipped a few months to H. P. Hood and Company, also to South Peacham Creamery.

My memories of butter-making:

In caring for the cream when I was a boy, we used large pails with screen-vented covers, about six-gallon pails, to hold the cream while it was souring. We still have several of these pails. They sat on a low bench in the pantry by the back window in the summer and, in the winter, behind the dining room stove with a thermometer in the cream to keep track of the temperature, of about 60 degrees. One or two days a week was a churning day. The room we call the back room was the milk room or churning room.

The churning day was a busy day. In winter the door was open from the kitchen to the milk room while the family was eating breakfast. The old black kitchen stove was a great heater, so it would heat both rooms easily. On a very cold day we might churn in the kitchen, but the barrel churn had to be taken apart to move. The cream had to be at least two days old to be ready to churn. Up to three of the big pails of cream were put into the churn and the cover locked on. Most of the time one person could turn the churn end over end. There was a second crank that could be put on the other side to help out. The butter would come in little globules, soon collecting into a large ball, then you could hear and feel the butter thump as you turned the churn. It was then ready to open up and draw off the buttermilk. When partly through churning, you opened up the churn and put in a little butter coloring.

After the buttermilk was drawn off you put in some 60 degree water to wash the butter in the churn, then the kitchen table was brought near the churn and the butter worker put on it and the butter was transferred from the churn to the butter worker with the wooden butter scoop. The butter worker was about 28 by 48 inches with 5-inch sides with a gear raceway on each side for the paddle roller with grears to travel the length of the worker. This worked the water out of the butter.

Then you spread the butter out thin, which you had weighed, and sprinkled with the salt, which you had weighed according to the formula which was written on

the plaster on the wall, less than one ounce to a pound. Next you folded the butter and ran the worker paddle roller over it until the salt was worked in. Then the butter was spread out the thickness of the butter prints, ready to use the butter print and box, transferring each one-pound print to a sheet of butter paper to be wrapped and placed in the butter trunk. The butter print had brass adjustment screws to be sure each print contained a pound of butter. After washing everything with hot water, the butter print was put back in the brine in the earthen jar under the cellar stairs.

I have production records of Warden Farm from 1923 to 1976, when I retired from farming. Most years at least one-third of the milk check went to pay for grain from the Midwest for the cows.

(Editor's note: These production records are too long to include in this account. They show a pretty steady increase in production and income over the years. In 1931, 17,619 pounds of cream brought in \$1,704.98; in 1934, 161,655 pounds of milk brought \$3,143.28; in 1941, 142,068 pounds of milk earned \$3,917.62; in 1951, 207,286 pounds, \$10,981.41; 1961, 318,333 pounds, \$17,316.13; 1971, 317,523, \$23,939.02.)

Butter making at Moses Roy Farm: (notes provided by Earle Judkins from Moses and Ernest Roy diaries)

Moses Roy bought the farm, stock and tools, November 8, 1887, of his father, Alexander Roy, about one and one-half miles southwest of Barnet Center Church, and built the barn over the next year. The buildings can be seen from the church. August 1890 he installed a Barden Creamery in the milk room in the cellar of the house. This is the same year that Horace Warden installed one. Earle Judkins thinks this might have included a swing churn and a hand-operated butter worker.

September 15, 1892: Moses Roy bought a steam boiler and engine and used it to fill silo.

January 4, 1893: He set it up in the house cellar to operate the butter churn.

June 26: He set up a new milk separator, probably a centrifugal cream separator.

December 1896: He installed a new butter worker. Earle thinks it was a power-operated butter worker. About that time, Earle thinks, they purchased milk testing equipment.

1902: Installed a new butter churn, made by his brothers' the Roy Brothers factory at East Barnet of lumber from the farm, maybe using the hardware from the old churn. David Warden has this churn.

September 8, 1906: Started going to the creamery.
December 8, 1906: Started using a milking machine with a vacuum pump in the house cellar, operated by the steam engine with a one-inch pipe to the cow stable.

1910: He sold the cows so he stopped using the steam boiler and milking machine.

1917: Installed a milking machine with an electric motor.

1922: Purchased a Sharples milking machine.

1926: Cut ice with an Ottawa wood-cutting saw.

Moses Roy made shipments of butter two times a week to customers in Massachusetts.

Charles Goss bought the Lucius Brock farm near Barnet Center in about 1908. He made butter many years, milking up to 40 cows and at times making 200 pounds of butter per week. They used the DeLaval #17 separator and electric-powered barrel churn.

They made butter through World War II when the price of butter was frozen at 50 cents a pound. At that time we were receiving about \$4 per hundredweight for milk and not having the extra work. He felt that he needed to keep the goodness of the skim milk and butter-milk on the farm. He kept many hogs to feed it to.

Farm women of the 1800s were responsible for not only the health, upbringing, clothing and feeding of their large families, but also for helping with maple sugaring, spring planting, haying, harvesting, butchering, and care of the livestock. But if you were to look at a list of arts and crafts they exhibited at the fairs, you would see that they found time for a variety of hobbies!

Mother told me that although great-grandmother Katrina and grandmother Martha enjoyed a number of these hobbies, they especially liked to traipse the cool, green woodlands, fragrant with ferns and balsam, and sunlit meadows, bright with daisies and clover. Great-grandmother gathered spring greens, or fall roots and barks for medicine, while grandmother poked about for moth and butterfly eggs, larvae and pupae. (Mother said that Grandma was somewhat of an authority on Lepidoptera.)

Great-grandmother Katrina died in 1919, and in 1925, when I was four, Grandma and Grandpa sold the farm (in East Richford, Vt.) to my mother and father and joined the exodus from the farms to the cities, taking with them the other daughters, Hilda, Evelyn and Katie.

This was the Jazz Age. In the cities people found not only air pollution and constant noise from factories and cars, but also sharp "fellas" with hip flasks, flashy cars, and all-night petting parties; "flappers" with shingled hair, powder and paint, and scandalous skirts showing their knees; confession magazines, lurid movies, chain smoking, and cocktail parties.

On weekends and vacations everybody was packed into the family car and whisked to the countryside to get away from it all!

Collecting Lepidoptera became the "in-thing." Mama said it was common to see both "flappers" and their "fellas," decked out in "knickers," "panamas"