kilns, the hissing machinery and the busy men all unite in telling you that you have reached Kiehline's brickyards." The plant was in a 15-acre tract of clay land and had a daily capacity of 35,000 bricks. It was started in 1869.

John Nonnemacher and Bros. had a new plant at Twelfth and Liberty streets with a daily capacity of 40,000 brick and a 14-acre tract of clay land.

All of these have long ceased operations.

In 1924 the writer described the brick plants of Allentown in the report on the Mineral Resources of the Allentown Quadrangle.*

C. C. Sensenbach operated a brickyard west of Aineyville in South Allentown from 1890 to 1913. The clay, which contained few glacial boulders, was underlain by fine sand, some of which was mixed with the clay. The plant was operated from April to October each year and made daily 15,000 to 18,000 bricks.

On the south side of Little Lehigh Creek near the Eighth Street bridge in South Allentown Mr. Kiehline made brick for more than 25 years. The clay, which contained very few pebbles, ranged in thickness from 4 to 11 feet. It was underlain by rotten limestone, which sometimes became mixed with the clay and caused the bricks to crack while burning.

The Ochs & Frey Brick Co. had two pits in operation near the south end of the Eighth Street bridge in South Allentown until about 1916 and later one pit about a quarter of a mile to the southwest, beyond the Fairview Cemetery. The four kilns of this company had a combined capacity of 870,000 bricks. The clay in the old pits ranged in thickness from 2 to 12 feet and was overlain by about 6 inches of soil. A layer of gravel and sand separated the clay from the underlying limestone. In the pit last worked the clay ranged from 3 to 13 feet in thickness. An electric shovel was used in the digging.

The Ed. G. Mattern brickyard, at Tenth and Tilghman streets, Allentown, was operated for about 60 years. The company ceased operations about 1916 and the site is now occupied by residences. In that time the clay was removed from a large area in northwest Allentown. The clay in most places ranges from 3 to 7 feet in thickness although in a few places it is 12 feet thick. The three kilns had a combined capacity of 500,000 bricks.

Frederick Bros.' brickyard at Fifteenth and Allen streets, Allentown, operated three kilns that had a combined capacity of 700,000 bricks. The clay formerly used was the ordinary residual type obtained from pits near the plant. It ranged from 3 to 12 feet in thickness, was overlain by a foot of loam and underlain by rotten limestone. The clay contained few glacial boulders. The clay last used was taken from an old mud-dam deposit north of the fair grounds at 19th and Tilghman streets. The old iron mine which furnished the clay is now filled. Layers of sand are interbedded with the clay. The clay was dug by steam shovel.

Swoyer Bros. Brick Co. plant, the largest in Allentown, was at Madison and Allen streets. There were six kilns, each of which had a capacity of 305,000 bricks, and the yard was well equipped with