

PLANT MANAGER REPORTS

1974
The Christmas Season with its many extra activities is upon us again. Undoubtedly, everyone is looking forward to a period of rest and relaxation which is well deserved after our busy season.

With only a few more days left in our calendar year, I take this opportunity to thank every member of our personnel at the Amherstburg Plant for their loyalty and cooperation during the past year. We were fortunate to see our business volume increase in 1974 and we hope that this trend will continue in 1975.

The extra volume meant a strain on the people in the Bottling, Case Bond, Maturing and Office, but everyone in these areas put in their special effort allowing us to meet the heavy bottling demands of the fall season. We have also seen a growth in the other departments; the Distillery had a very successful year with an increased average daily output and excellent results with the rye flavouring program. The service departments did their utmost to provide proper maintenance, power and excellent guard and yard services to keep the other departments operating efficiently. I am therefore glad to report to you that in general, it has been a good year for this plant.

I would like to take this opportunity to wish our employees, their families and the Retirees a very Merry Christmas. May the New Year bring you happiness, good health and prosperity.

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On November 27th we were honoured with a visit from Mr. Charles Bronfman and Mr. Mel Griffin, who flew in from Montreal to spend the entire day at Amherstburg touring our plant facilities. It was also a pleasure to have Father Martin with us, a good friend of Mr. Charles, who joined the visitors for this event. In spite of the busiest time of the year, all departments made a favourable impression on our visiting executives.

Before lunch the Distillery, Boiler House and the Dumping buildings were toured and the afternoon program took in the Bottling, Case Bond and Quality Department followed by a short meeting of the members of the Union Committee with Mr. Charles and Mr. Griffin.

I was very pleased to hear the favourable comments from our visitors afterwards, and I am gladly passing on their congratulations to the people in all departments who worked so hard on the improvement of the plant appearance in a relatively short time.

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To our surprise winter has arrived in the Sun Parlour of Canada. Not too long ago one would feel out of place driving around with snow tires, but after the experience of December 1st and 2nd, when this area was blanketed by a 14" snow fall, one would tend to change his mind. Heavy winds made conditions worse, causing large snow drifts which were blocking off many roads and streets. There was virtually no traffic on Highway 18 between Windsor and Amherstburg on Monday, December 2nd.

Approximately 150 people were absent during this day, but fortunately we had a small work force available in every department, allowing limited operations. Special recognition should be given to our Security Guards, the Boiler House personnel and Distillery Operators who kept all the shifts covered.

Sunday and Monday were two busy days for Tom Purdie, who directed the snow removal operations effectively, which allowed normal plant operations to resume on Tuesday, December 3rd.

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PRODUCTION

A. Markies reports that the Distillery was able to exceed their quota of Rye flavouring produced for the Calendar Year. In order not to have any flavouring mashes left over during the shutdown, the Distillery is now running completely on a corn base whisky mash bill until January. There will be only a limited interruption in the mashing/distillation program, as we are planning to hold over a total of 11 fermenters during the shutdown which allows us to resume normal operations immediately on January 2nd.

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MATURING

The Maturing Department is experiencing an extra heavy work load in December. In addition to the normal blending requirements for V.O. & Crown Royal, they have to receive and process part blends from other locations for our 1975 formulas. In return, this plant has to ship out part blend requirements to the other plants, also as part of their blending requirements for next year. Walter Jonke had to bring in an extra crew and the department also had to work overtime at night and Saturdays to meet his schedules.

Warehouse "J" is virtually completed and ready for operation. Some minor modifications will have to be made to the lighting system and the fire doors have to be installed yet. We have seen the arrival of barrel pallets and once the stock of pallets is adequate and the barrel palletizer being manufactured by the General Maintenance Department is completed, we will start the palletizing operation.

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BOTTLING

The Bottling Department is still operating on a four line basis to meet heavy shipping requirements in December. November 1974 was the second largest shipping month ever for this plant as we handled 427,900 cases. Of this volume, much was shipped in the latter part of the month, which put an extra burden on the Shipping Department. Congratulations to Bob Bondy, Larry Delmore, Leo Deslippe, Lou Jaber, Jim Paquette and their crews for this fine effort.

On Monday, December 9th, we ran for the first time a new package, namely, 4/5 pts. Crown Royal on Line #4. The run was quite smooth for a new package and was a reflection of the good work by Harold Moor and the Bottling Maintenance crew who were in on Sunday, to make this first line change and get the new parts ready for operation.

The new member in the management group is Pat Cahill, a recent graduate from St. Clair College who joined us on November 20th and works in the Bottling Maintenance Department. Welcome Pat, and success in your new assignment!

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ENGINEERING

The plant maintenance department had to cope with many call-ins lately in order to repair several breakdowns in the Dry House. One of the major repairs was a cracked shaft on the north dryer, followed by a few conveyor breakages which had to be repaired at night or on week-ends. We hope that these problems are of a temporary nature and that some of them will be rectified during the brief Christmas Shutdown.

Miladin Ristic, Clair Fox, Ian Smith and Guy Williams have been working on the barrel palletizer to be used in Warehouse "J". The unit is a replica of the machine developed in the Beupre plant some time ago. It is well built and appears to be functioning as required, based on the few tests run already in the Machine Shop.

The recent posting for an Apprentice Electrician was awarded to Bernie Drouillard, who will start his apprentice program on January 13th, 1975. We congratulate Bernie and hope that he will be successful in his apprentice program.

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RAILWAY HEARING

Frank Lacey and I have been attending the last railway hearing held on December 3rd and 4th on the application of the Penn-Central to bring in a new railway spur into the back of our property. The issue has been well covered in the local press and yielded some opposition from the Harrow Farmers, which is understandable. The hearings have been going on since 1968 and everyone is anxious to get a decision from the Railway Transportation Commission in Ottawa. Our main concern is that we want to be assured of rail service to our plant in the future and know when the entrance in the back of our property will materialize so that we can incorporate the new track into the master plan for the land we purchased, north and south of William Street. The indications of Judge Magee were that a final decision would be made by the Transportation Commission in Ottawa early in January 1975.

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PLANT TOURS

We were "hosts" to two plant tours this month - 15 Calvert Retirees and 18 Members of the Industrial Management Clubs of Canada. In addition, Messrs. E. Michalosky and E. Sangoi, Bottling Operators, from our Waterloo Plant were also here on a one day visit on October 28th. As well, there were 15 other visitors during the month.

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RETIREEES

The Retirees took a tour of the plant on November 21st. Included in the tour group were Mary Bobich's sister Mrs. Warren and Helena Autin's brother Morris Autin.

On October 26th, a bus tour was taken to Indian River and Mackinaw Bridge. The Retirees found the autumn colours very beautiful at this time of year.

We were sorry to hear that Edna Fawdry broke her arm and also of the sudden death of her son-in-law Gorden Martin.

Mrs. Jack Jones visited her brother Charles Nemeth in hospital in Toronto.

The winning tickets for the 50 - 50 Draw were won by Fortunata Vacilotto (Oct.) and Don Laing (Nov.).

Norma Allen & Mr. and Mrs. Lornie Hurst arrived home early November 20th from a southern tour of Atlanta, Georgia; Memphis, Tennessee; Pensacola, Florida; Corbin, Kentucky.

On their vacation last month, Mr. Jack Jones and his wife visited Retiree Eino Sepala in New Port Richey, Fla. where they had Thanksgiving breakfast with him. Jack reports that Mr. Sepala, who is now 84 and in good health, wishes to be remembered to all his friends at the plant.

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The Calvert of Canada Retirees held their annual Christmas party at the K of C Hall on Thursday, December 12th. This was the best turn out yet with approximately 60 attending including Retirees from the B-M and Golden Age Clubs.

This was the first Retirees Christmas party that our Plant Manager, Mr. M. Breshamer, had the pleasure of attending and he was accompanied by Messrs. F. Lacey, D. Laing and J. Sherlock. The Union was represented by Local 73 President - J. Beneteau and Messrs. E. McCaffrey, P. Coyle and D. Scanlan.

After an excellent meal, the group was entertained by the Amherstburg Public School Concert Band, (under the direction of Jack Jones Jr.), and also the Golden Age Sweethearts Choir.

We again take this opportunity of wishing the Retirees all the very best for the Holiday Season and New Year.

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PERSONAL

OUR CONGRATULATIONS TO -

Mr. J. Marsh on behalf of the Amherstburg Echo on their 100th anniversary October 20, 1974.

Mrs. L. Gosselin and her husband, Andre, on the birth of their 2nd son, Mark, who was born on November 11th.

Retiree - Stationary Engineer, Mr. Bill Nattress and his wife on their 55th Wedding Anniversary to be celebrated on Jan. 21/75.

Excise Officer-Les Dixon on his Lottery win of \$5,000 last month.

OUR CONDOLENCES TO -

Switchboard Operator, Mrs. S. Munro, on the death of her brother W. Muir on October 30th.

Retiree, Mrs. Florence Mayville, on the death of her mother Mrs. Stella St. John on October 27th. Mrs. St. John worked here for many years in the old Bottling Room.

Maturing Clerk, Ben Schinkel, on the death of his father-in-law Ralph Vandervinne December 5th.

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Dan Shaw of Maturing reports an excellent month of training by the Emergency Health Services of Ontario, which was held in November at Camp Borden, Ontario.

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WINDSOR ESSEX COUNTY UNITED WAY

Dear Fellow Employees:

This is to say a sincere "thank you" for the way you supported the 1974 United Fund Campaign.

The results were outstanding, and thanks to your support, our in-plant canvass has topped all previous results for the fourth consecutive year.

A total of Six Thousand Two Hundred and Nineteen Dollars (\$6,219.00) has been raised in cash and payroll deductions through the generosity of Union and Staff employees of Calvert of Canada Limited.

This amount, as in previous years, is "matched" by Calvert of Canada Ltd. making a total of Twelve Thousand Four Hundred and Thirty-Eight Dollars (\$12,438.00).

These dollars, administered through the agencies of the United Fund, will benefit and assist citizens of Essex County less fortunate than we and many a silent "thanks" will echo as a result of your generosity and thoughtfulness.

A special personal "thanks" to Management, to Locals 73 - 156 - 772 and their executive personnel, to the Shop Stewards and Stewardesses, and to all plant personnel who personally conducted the canvass throughout the plant, and to the people who gave so generously.

By your time, effort and financial support, you have once again proven that people working together in a common cause of helping their fellow man can accomplish so much.

Once again "THANKS".

F.M. Lacey, Co-Chairman
J. Beneteau, Co-Chairman
Essex County United Fund
Calvert of Canada Limited

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NEW EMPLOYEES

Welcome to the following new employees who started with us since our last issue -

Patrick Cahill
Timothy Stocker
Leo Potvin
Wayne Vigneux
John Pohanka
Marinko Marijan
Ernie Bellefleur
Gary Bezair
Grant Gibb
Francis Drouillard
Robert Long
Gary Triolet

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GET WELL WISHES

Get Well Wishes to the following employees who were sick as of December 16, 1974 -

Alice Dufour
Marie Cote
Phyllis Fattore
Sylvia Drouillard
Judy Reaume
Tom White
Henry Thelland
Francis Dufour
Vince Brunet

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BIRTHDAY WISHES

HAPPY BIRTHDAY TO -	December 2	Brian Ferguson	16	Jeanette Faucher
	3	Richard Tofflemire	17	Cecilia Meloche
	5	Fortunata Vacilotto	18	Aldo Iannucci
	6	Howard Parker	20	Jeanette Dupuis
		Francis Colley		Reg Davis
	7	Thomas Shaw	21	Tom Bondy
	8	Edna Coyle	25	Jim Turner
		Sylvia Drouillard	26	Yvonne Dufour
		Tom Marshall	27	Mary Annette Pare
	10	Larry Renaud	28	Stella Luciw
	12	Mae Stocker		Laura Gignac
	14	Gilbert Dufour		
	16	Amedee Chappus		

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HAPPY ANNIVERSARY to Jim and Edna Coyle who will be celebrating their 30th Wedding Anniversary on December 30th.

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SAFETY

DEPARTMENTAL SAFETY PERFORMANCE RECORD

Jan. - Nov. 1974

DEPARTMENT	LOST TIME ACCIDENTS		TOTAL DAYS LOST		MEDICAL AID	
	MONTH	JAN. 1 TO DATE 1974	MONTH	JAN. 1 TO DATE 1974	MONTH	JAN. 1 TO DATE 1974
DISTILLERY	0	0	0	0	0	0
MATURING	1	8	21	143	0	4
BOTTLING	1	5	1	98	3	11
MAINTENANCE	1	4	2	149	0	7
OFFICE	0	0	0	0	0	0
SERVICE	0	0	0	0	0	0
TOTAL	3	17	24	390	3	22

SAFETY - FOR KIDS' SAKE - (contributed by Wayne Marshall)

Particularly at this time of year, with toys being bought for the youngsters, it is most important to bear in mind the safety of our children.

WHEN BUYING TOYS - Choose toys with care. Keep in mind the child's age, interests and skill level. Look for quality design and construction in all toys for all ages. Make sure that all directions or instructions are clear - to you, and, more importantly, to the child. Plastic wrappings on toys should be discarded at once before they become deadly playthings. Be a label reader. Look for age recommendations, such as "Not recommended for children under 3". Look for other safety labels including: "Non-toxic" on painted toys, "Flame retardant/Flame resistant" on fabric products and "Washable/hygienic materials" on stuffed toys and dolls.

WHEN MAINTAINING TOYS - Check all toys periodically for breakage and potential hazards. A dangerous toy should be thrown away or repaired immediately. Edges on wooden toys that might have become sharp or surfaces covered with splinters should be sanded smooth. Use only paint labeled non-toxic to repaint toys and toy boxes. Examine all outdoor toys regularly for rust or weak or sharp parts that could become hazardous.

WHEN STORING TOYS - Teach children to put their toys safely away on shelves or in a toy chest after playing to prevent falls and other injuries. Toy boxes, too, should be checked for safety. Use a toy chest that has a lightweight lid that can be opened easily from within. For extra safety, be sure there are ventilation holes for fresh air. Watch for sharp edges that could cut and hinges that could pinch or squeeze. See that toys used outdoors are stored after play - rain or dew can rust or damage a variety of toys and toy parts creating hazards.

SHARP EDGES - Toys of brittle plastic or glass can easily be broken, exposing dangerous sharp cutting edges. Wooden, metal and plastic toys sometimes have sharp edges due to poor construction.

SMALL PARTS - Tiny toys and toys with small removable parts can be swallowed or become lodged in a child's windpipe, ears or nose. The squeakers in some squeeze toys can be removed and possibly swallowed. The seams of poorly constructed stuffed dolls or animals can break open and release small pellets that also can be swallowed or inhaled.

LOUD NOISES - Toy caps and some noise-making guns and other toys can produce sounds at noise levels that can damage hearing. The law requires the following label on boxes of caps producing noise above a certain level: "WARNING - Do not fire closer than one foot to the ear. Do not use indoors."

SHARP POINTS - Broken toys can expose dangerous prongs and knife-sharp points. Pins and staples on dolls' clothes, hair and accessories can easily puncture an unsuspecting child. Even a teddy bear or stuffed toy can have barbed eyes or wired limbs which can cut or stab.

PROPELLED OBJECTS - Projectiles - guided missiles and similar flying toys - can be turned into weapons and can injure eyes in particular. Children should never be permitted to play with adult lawn darts or other hobby or sporting equipment that have sharp points. Arrows or darts used by children should have soft cork tips, rubber suction cups or other protective tips intended to prevent injury.

WRONG TOY FOR THE WRONG AGE - Toys that may be safe for older children can be extremely dangerous in the hands of little ones.

ELECTRIC TOYS - Electric toys that are improperly constructed, wired or misused can shock or burn. Electric toys must meet mandatory requirements for maximum surface temperatures, electrical construction and prominent warning labels. Electric toys with heating elements are recommended only for children over eight years old. Children should be taught to use electric toys cautiously and under adult supervision.

YOUR RESPONSIBILITY - Protecting children from unsafe toys is the responsibility of everyone. Careful toy selection and proper supervision of children at play is still - and always will be - the best way to protect children from toy-related injuries.

It is the wish of our plant Safety Committee that all Employees have a **VERY PLEASANT AND SAFE CHRISTMAS AND NEW YEAR.**

WHAT YOU ALWAYS WANTED TO KNOW ABOUT LIQUEURS

Leroux Liqueurs

In a very short time the Holiday Season will be in full swing. It is during this festive season that close to 40% of all liqueur sales occur. With this in mind, we have accumulated some information that may be of use to you during the busy days ahead.

Vodka is presently the fastest growing segment of the liquor market. Surprisingly, liqueurs are a close second. In our Fiscal year of 1974, liqueurs increased 25.6% to just under 1,000,000 cases nationally. Domestic liqueurs enjoyed the largest portion of this growth, increasing by 26.4%. Leroux fared very well gaining in share and increasing in case sales by 33.2%.

Liqueurs have been with us for thousands of years. Historically, they were primarily used for medicinal purposes. Through time their role has altered, to where today they are consumed as palate pleasers or after-meal digestives.

There are three basic classes of liqueurs:

1. Plant or Herb Liqueurs - these may be made from a recipe involving a few herbs predominating in odour and taste (example: Creme de Menthe Green), or from a large number of equally important herbs (example: Chartreuse).
2. Fruit Liqueurs - these derive their flavour from the various fruits used in their distillation process (example: Cherry Brandy).
3. Peel and Rind Liqueurs - these derive their flavour from the peel, rind, pit or skin of various fruits, mainly citrus (example: Triple Sec).

The production of liqueurs involves the combining of distilled spirit with different flavouring ingredients. The flavours of the various ingredients are extracted by one of three means:

1. Distillation - a method similar to gin distillation where flavours are added to the distilled spirit.
2. Maceration - where the flavour ingredient is steeped in distilled spirit.
3. Percolation - as one would percolate coffee.

The method used depends on the type of material involved. There are literally thousands of ingredients that could be used; indeed, any vegetation whose aroma, natural oil and basic flavour can be extracted may be used. The finished liqueur is obtained by blending a spirit base, sweetening agent and flavouring ingredients. On completion the blend is held in oak casks, tanks, or vats for varying lengths of time to "marry" the flavours prior to bottling.

Listed below are the 8 Leroux products, with a short explanation on each.

Leroux Creme de Menthe Green is produced by combining distilled spirit, sugar and mint extract. Coloring ingredients are added to the resulting solution. It is then reduced to bottle strength with water.

Leroux Creme de Menthe White is produced in a similar manner to Leroux Creme de Menthe Green. Many people believe that Green Creme de Menthes are produced by adding coloring to a White Creme de Menthe. This is not the case with Leroux products. Leroux blenders use different sugar bases for our two Creme de Menthes, resulting in different flavours and specific gravities. This is visually demonstrated in a pousse-cafe, where the lighter Leroux Creme de Menthe White floats on top of the Leroux Creme de Menthe Green.

Leroux Apricot Brandy and Leroux Cherry Brandy are produced by combining distilled spirit, sugar base and several complex fruit extracts. The brandy is added as a component in the flavour make-up of the product.

Leroux Cherry Whisky is produced in a similar manner to Leroux Cherry Brandy. It differs from Leroux Cherry Brandy in that the major flavouring component is a whisky instead of a brandy. Leroux Cherry Whisky is darker in colour but lighter in specific gravity than Leroux Cherry Brandy.

Leroux Creme de Cafe is the newest addition to the Leroux family. It is produced by combining distilled spirit, sugar and several different flavouring components including Demerara rums, Jamaican rums, brandy, vanilla and cinnamon. The coffee flavour is derived from coffee extracts and various coffee bean types.

Leroux Triple Sec is produced by combining sugar and spirit with distillates and extracts of Jaffa orange, grapefruit and lemon. Leroux Triple Sec probably best demonstrates the Leroux blender's quest for only the best of ingredients. Rather than use just any oranges, Leroux blenders demand that only select Jaffa oranges from Israel be used in the production of Leroux Triple Sec. This increases the cost but also ensures unbeatable quality.

As is the case with Leroux Creme de Cafe, Leroux Triple Sec is competing in a flavour category that is dominated by a premium priced import - Cointreau. Cointreau is a brand name for a Triple Sec just as V.O. is a brand name for a rye.

Leroux Kummel is probably the least known product in the Leroux family. Sold only in Alberta and the Yukon, it is produced by combining distilled spirit, sugar and caraway seed extract. The resulting product is clear in colour and distinctive in flavour. Kummel is a product of German origin. The caraway plant is native to northern Europe and is a cousin of the dill. It grows wild and may even be found along the roadsides in Germany. Caraway seeds are very aromatic and are used for other purposes, probably the best known use is on top of loaves of rye bread.

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ODE TO A DEPARTMENT HEAD

by
Poet Laureate G. Jeffrey

T'was just before Xmas
and all through the Plant

Gord Freeman was starting
to rave and to rant.

His Planner was so busy
He was using his head

While Gerry was using his
desk as a bed.

Roger the Actor was limping around

While Lloyd, as is usual
couldn't be found.

Jim Coyle was smoking,
and starting to cough.

When Art gave to Gord a cheerful
TAKE OFF.

Buck called from the Case Bond
and started to tell,
How he was related to old Ma Bell.

When there in the background
in the midst of a lull,
Came the terrible and frightening screech of a gull.

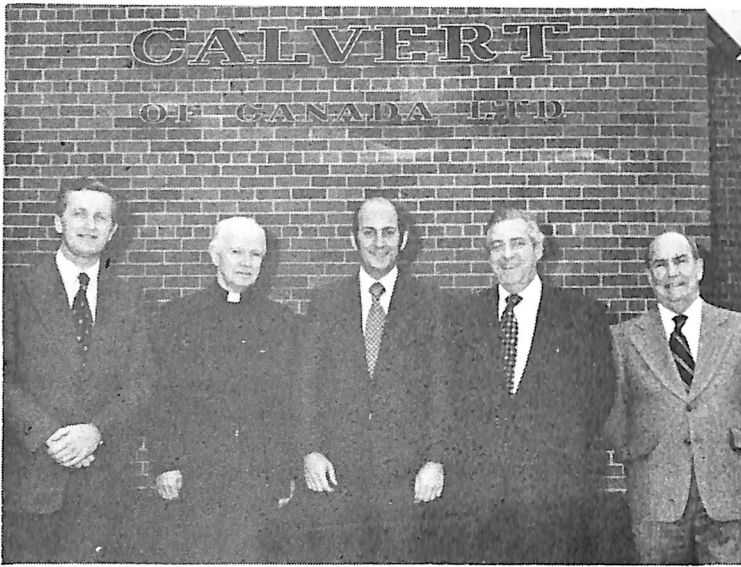
All through the Case Bond
The noise it did carry
Then someone discovered
That it only was Larry.

From out in the back
Came Walter's Pride
The railroad yard face of
Old Jim McBride.

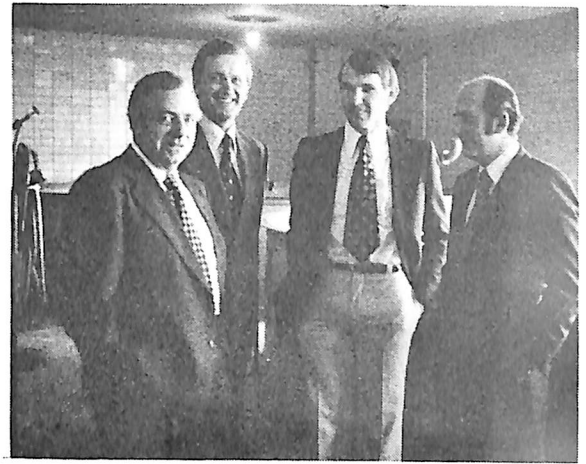
He went into the warehouse
To look for a gang,
When out of the rack with
a terrible bang
Came a barrel of whisky
So close you could see, that
it frightened poor Jim, and
he said "GOLLY GEE".

So we come to the end of this story so bright.

A Merry Noel and to all a good-night.



Plant Mgr. M. Breshamer, Father Martin,
Mr. Charles, Mr. Griffin & Mr. F. Lacey.



With Distiller A. Markies.



At the Xmas Wrap Line.



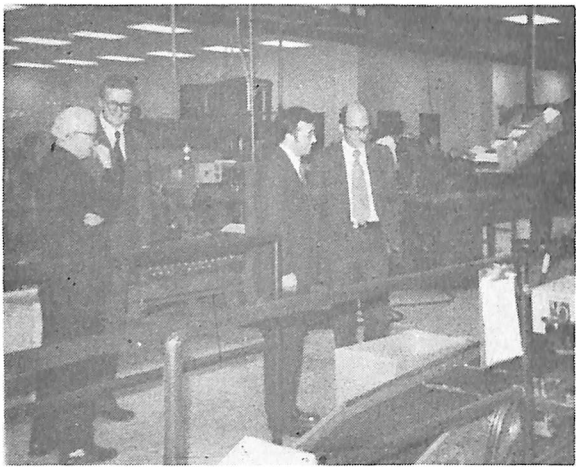
With Bottling Superintendent
G. Freeman.



Discussing Shipping Documentation with
Assistant Foreman J. Paquette.



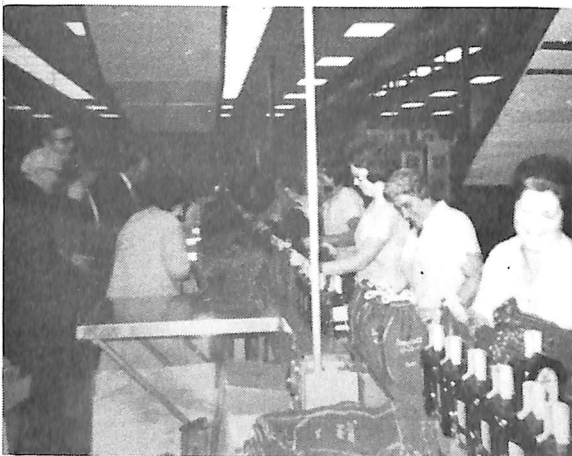
Bottling Mechanic Ted Kuzniar in the
foreground with Mr. Griffin.



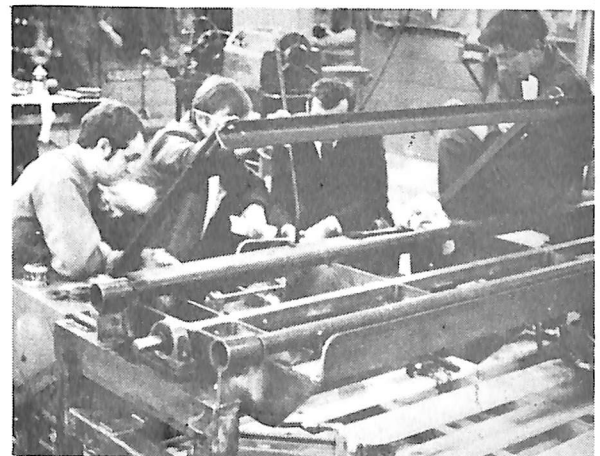
Father Martin having a look at
Line 2.



Mr. Charles & Gord Freeman at
Xmas Cartoner.



Close up of Line 4 with
Mrs. C. Chouinard & Forelady
Mrs. J. Sprague.



Our new barrel "tipper-upper"
(palletizer) being fabricated by
General Maintenance.



New Bottling Maintenance P.M.C.
Pat Cahill.



Aftermath of Sunday's snow storm
December 1, 1974.



SCENES FROM THE RETIREES CHRISTMAS PARTY - DECEMBER 12, 1974



Now we believe those fish stories
of Gord Marshall's!



St. Clair College Homecoming
Queen Denise Laing, daughter
of Bill Laing.