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**ARCHAEOLOGICAL SOLUTIONS LTD**

**THE KILN AT READS BRICKWORKS  
ALDEBURGH  
SUFFOLK**

**HISTORIC BUILDING RECORDING  
AND MONITORING**

**Level 2/3**

Authors: Lisa Smith BA Kathren Henry	
NGR: TM 449 569	Report No. 4378
District: Suffolk Coastal DC	Site Code: ADB199
Approved: Claire Halpin	Project No. 4398
MIFA	Date: 25 July 2013
Signed:	

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<b>OASIS SUMMARY SHEET</b>			
Project name	<i>The Kiln at Reads Brickworks, Aldeburgh, Suffolk. Historic Building Recording and Monitoring</i>		
<p><b>Summary</b></p> <p><i>In May 2013 Archaeological Solutions Limited (AS) carried out a historic building recording and monitoring on a 19<sup>th</sup> century kiln at Reads Brickworks, Aldeburgh, Suffolk (NGR TM 449 569). The work was required to comply with a planning condition attached to planning approval for a proposed residential development, based on advice from Suffolk County Council AS-CT prior to the structures demolition.</i></p> <p><i>In November 2012 the entire site was the subject of a heritage asset statement which identified several buildings relating to the production of brick including the main factory, four updraught kilns, a small office and various storage buildings. Two buildings remain from the 19<sup>th</sup> century including a disused 'Suffolk'-type kiln and the small office building. All other buildings appear to be of 20<sup>th</sup> century date though the storage building may incorporate fragments of older structures.</i></p> <p><i>A more detailed study of the 19<sup>th</sup> kiln revealed a remarkably well preserved example of a 'Suffolk'-type kiln complete with thick robust walls enclosing a lattice brickwork floor. Beneath three arched fire tunnels extend the width of the kiln given access from arched apertures piercing the wall on the south. External retaining walls extend to the south once forming a crude roofed shelter enclosing the stoking side of the kiln. Other fixtures and fittings including external doors hung on chains and fire rakes also survive.</i></p>			
Project dates (fieldwork)	<i>2<sup>nd</sup>, 9<sup>th</sup> &amp; 30<sup>th</sup> May 2013</i>		
Previous work (Y/N/?)	<i>Y</i>	Future work (Y/N/?)	<i>N</i>
P. number	<i>4398</i>	Site code	<i>ADB199</i>
Type of project	<i>Historic building recording and monitoring</i>		
Site status	<i>n/a</i>		
Current land use	<i>Derelict brickworks now used as a builders yard</i>		
Planned development	<i>Demolition of the buildings prior to redevelopment for housing</i>		
Main features (+dates)	<i>19<sup>th</sup> – 20<sup>th</sup> century Brickworks</i>		
Significant finds (+dates)	<i>n/a</i>		
<b>Project location</b>			
County/ District/ Parish	<i>Suffolk</i>	<i>Suffolk Coastal</i>	<i>Aldeburgh</i>
HER for area	<i>Suffolk Historic Environment Record (SHER)</i>		
Post code (if known)	<i>-</i>		
Area of site	<i>c.40,000m<sup>2</sup></i>		
NGR	<i>TM 449 569</i>		
Height AOD (max)	<i>c.5/10m AOD</i>		
<b>Project creators</b>			
Brief issued by	<i>Abby Antrobus (SCC AS-CT)</i>		
Project supervisor/s (PO)	<i>Archaeological Solutions Ltd</i>		
Funded by	<i>MS Oakes Securities Ltd</i>		
Full title	<i>The Kiln at Reads Brickworks, Aldeburgh, Suffolk. Historic Building Recording and Monitoring</i>		
Authors	<i>Smith, L. Henry, K.</i>		
Report no.	<i>4378</i>		
Date (of report)	<i>July 2013</i>		

## THE KILN AT READS BRICKWORKS ALDEBURGH, SUFFOLK

### HISTORIC BUILDING RECORDING AND MONITORING

#### **SUMMARY**

*In May 2013 Archaeological Solutions Limited (AS) carried out a series of visits in order to conduct historic building monitoring and recording on a 19<sup>th</sup> century kiln at Reads Brickworks, Aldeburgh, Suffolk (NGR TM 449 569). The work was required to comply with a planning condition attached to planning approval for a proposed residential development, based on advice from Suffolk County Council AS-CT prior to the structures demolition.*

*In November 2012 the entire site was the subject of a heritage asset statement which identified several buildings relating to the production of brick including the main factory, four updraught kilns, a small office and various storage buildings. Two buildings remain from the 19<sup>th</sup> century including a disused 'Suffolk'-type kiln and the small office building. All other buildings appear to be of 20<sup>th</sup> century date though the storage building may incorporate fragments of older structures.*

*A more detailed study of the 19<sup>th</sup> kiln revealed a remarkably well preserved example of a 'Suffolk'-type kiln complete with thick robust walls enclosing a lattice brickwork floor. Beneath, three arched fire tunnels extend the width of the kiln given access from arched apertures piercing the wall on the south. External retaining walls extend to the south once forming a crude roofed shelter enclosing the stoking side of the kiln. Other fixtures and fittings including external doors hung on chains and fire rakes also survive.*

#### **1 INTRODUCTION**

1.1 In May 2013 Archaeological Solutions Limited (AS) carried out a series of visits in order to conduct historic building monitoring and recording on a 19<sup>th</sup> century kiln at Reads Brickworks, Aldeburgh, Suffolk (NGR TM 449 569; Figs. 1-2). The work was required to comply with a planning condition attached to approval for a proposed residential development (Suffolk Coastal DC Approval Ref. C/12/2573), based on advice from Suffolk County Council AS-CT, prior to and during the structure's demolition.

1.2 The work was conducted according to a written scheme of investigation (dated 26<sup>th</sup> April 2013) prepared by AS in response to a brief issued by Abby Antrobus of the Suffolk County Council Archaeological Service Conservation Team (SCC AS-CT, dated 23<sup>rd</sup> April 2013), approved by SCC AS-CT. The project conformed to the English Heritage document *Understanding Historic Buildings; A guide to good recording practice, 2006* and also conformed to the Institute for Archaeologists' (IFA) *Standard and Guidance for the Archaeological Investigation and Recording of Standing Buildings or*

*Structures* (revised 2008). The level of recording was conducted to Level 2/3 as defined in the RCHME/EH documents. The project also adhered to the document *Standards for Field Archaeology in the East of England* (Gurney 2003). It also followed the Institute for Archaeologists (IfA) *Code of Conduct* and *Standard and Guidance for an Archaeological Watching Brief* (revised 2008).

1.3 Historic buildings have their own importance for study. As noted in the East Anglian regional research frameworks, structures of the Industrial Age (1750-1960) face a high rate of loss (due to renovation, conversion and redundancy).

1.4 The principal objectives of the historic building recording included:

- The archaeological recording of the existing standing structure (Suffolk-type kiln) subject to the planning application, with additional recording/research undertaken as necessary to place the findings in the context of the buildings as a whole and as a group.

1.5 This was to be carried out prior to alteration, and specifically aim to provide a detailed understanding of the nature of the kiln, and to serve as an addendum to the existing survey of the brickworks. Further monitoring was also to be carried out during demolition in order to augment the record as required.

1.6 A heritage assessment of the site was conducted in November 2012 the results of which, along with the historical record of the site can be found in the following report:

Prosser, L. *et al.* 2012 *'Reads Brickworks, Aldeburgh, Suffolk Heritage asset statement.'* Archaeological Solutions Report No. 4189.

### *Planning context*

1.7 The National Planning Policy Framework (NPPF 2012) states that those parts of the historic environment that have significance because of their historic, archaeological, architectural or artistic interest are heritage assets. The NPPF aims to deliver sustainable development by ensuring that policies and decisions that concern the historic environment recognise that heritage assets are a non-renewable resource, take account of the wider social, cultural, economic and environmental benefits of heritage conservation, and recognise that intelligently managed change may sometimes be necessary if heritage assets are to be maintained for the long term. The NPPF requires applications to describe the significance of any heritage asset, including its setting that may be affected in proportion to the asset's importance and the potential impact of the proposal.

1.8 The NPPF aims to conserve England's heritage assets in a manner appropriate to their significance, with substantial harm to designated heritage

assets (i.e. listed buildings, scheduled monuments) only permitted in exceptional circumstances when the public benefit of a proposal outweighs the conservation of the asset. The effect of proposals on non-designated heritage assets must be balanced against the scale of loss and significance of the asset, but non-designated heritage assets of demonstrably equivalent significance may be considered subject to the same policies as those that are designated. The NPPF states that opportunities to capture evidence from the historic environment, to record and advance the understanding of heritage assets and to make this publicly available is a requirement of development management. This opportunity should be taken in a manner proportionate to the significance of a heritage asset and to impact of the proposal, particularly where a heritage asset is to be lost.

## **2 DESCRIPTION OF THE SITE (Figs. 1-2)**

2.1 Aldeburgh is small town located on the east coast of Suffolk, on the northern side of the estuary of the river Alde. The town lies c.6km south of Leiston and c.30km north-east of Ipswich.

2.2 Read's Brickworks lies on the western periphery of the town, to the south of the main road (A1094) as it enters Aldeburgh from the west. An unmetalled track gives access to the site, past the old clay workings to the north-east. The meandering course of the river passes c.200m to the south-west of the site and from where bricks were once despatched from a jetty.

## **3 METHODOLOGY**

3.1 The site was visited on 2<sup>nd</sup>, 9<sup>th</sup>, & 30<sup>th</sup> May in order to compile descriptions of the building and undertake the photographic work, prior to and during demolition. The written description, analysis and photographic survey were carried out by Lisa Smith while the drawing work was completed by Kathren Henry. Floor plans, sections and elevations are included with annotations (Figs. 3).

3.2 The photographic recording was conducted using medium format (4.5cm x 6cm) black and white film and included all external views and general internal shots. This utilised a Zenza Bronica ETRS camera and Ilford HP5 IOS 400 120mm film. Colour photographs were taken using a Canon 1000D (10 megapixels) digital camera, duplicating the black and white photography. Where necessary, architectural detail was captured using 35mm black and white film and supplementary colour photography used 35mm Ektachrome colour transparency. External lighting and weather conditions were good at the time of the survey. A scale was used wherever possible, and a flash was employed for internal shots. A pictorial index of the digital photography and selected colour plates are included below together with location plots (Fig. 3).

## 4 THE BUILDING (Fig. 3)

### *Exterior*

4.1 As described in the original report the kiln stands neglected and in a ruinous condition, now surrounded by the demolished remains of the brickworks (Plate 1). The above-ground remains suggest a typical 'Suffolk'-type kiln however the functional aspects of its construction were an unknown quantity until now, its excavation and subsequent demolition providing an opportunity to investigate the extent of its survival.

4.2 The removal of fencing has allowed a closer inspection of the structure which comprises four robust walls approximately 1.3m thick, buttressed on the north for extra support (Plate 2). The brickwork is laid in English-bond bonded by a flinty lime mortar, capped by a single course in soldier-bond with overburnt headers and stretchers throughout. The damaged south-western corner reveals a shallow rounded frog to the bricks. The outer face of the brickwork to the soldier-course is bevelled. The condition of the brickwork is poor being heavily patched and repaired across all façades and partially collapsed in the south-western corner, the upper courses disturbed by vegetation. The south side in particular has undergone accelerated decay in the form of cracks throughout with heavy spalling to the brickwork and in places continuous episodes of extreme heat have caused the walls to bow.

4.3 There is a single point of access on the west via a doorway or wicket off-set to the south given a semi-circular arched head framed to either side by queen closers (Plate 3). As expected the kiln is without a roof; a make-shift one would be constructed with each new firing.

4.4 Excavations along the southern side of the building revealed most information. The wall descends four metres below the current ground surface to the base of the structure in two offsets to a brick paviour floor where three semi-circular arched apertures give access to internal fire tunnels running across the kiln (Plate 4). The central aperture is best preserved with a decorative upper arch in yellow brickwork while the eastern example has partially collapsed. Within each aperture a series of cast-iron rails supported on lateral members survive and would have carried the fuel pushed into the body of the kiln by long rake-like implements, a number of which were left *in situ* after the disuse of the kiln (Plate 5&6). The channels below the rails would then catch the spent remnants of the fire. At high level hooks embedded in the brickwork above each of the archways carried heavy cast-iron doors on chains to be raised and lowered as necessary. One example was found during the excavations (Plate 7).

4.5 Retaining walls at the eastern and western end of the building extend five metres to the south, the eastern wall having a stubby buttress to the rear and returning to the east for a short section. Evidence of a pitched roof can be seen on the interior of the eastern wall suggesting that this side of the kiln was probably partially enclosed (Plate 8). Squared timbers and corrugated



sheeting unearthed during the excavation are likely to have formed the roof structure.

### *Interior*

4.6 Internally, the firing chamber is formed of four walls all of which are blank apart from the western wall which as mentioned above is pierced by the wicket. All show signs of bowing both vertically and horizontally and there are severe signs of decay to the southern elevation where the mortar is almost completely eroded and the brickwork has become white through the effects of heat. The removal of large quantities of rubbish revealed the kiln floor almost two metres below the wicket formed of a network of vents (12½" x 8½" or 318mm x 216mm) comprising of a lattice of brickwork five courses deep (Plate 9). Beneath, larger vents formed in the same fashion are built directly above the three firing tunnels and here the majority of the brickwork is heavily vitrified clearly displaying the intense effects of the heating process.

4.7 The arched apertures seen on the exterior of the south wall continue to the interior where they are much larger in size giving way to three fire tunnels. The fire tunnels are constructed with pointed 'Gothic'-style arches alternating in a series of ribs with gaps approximately a headers width creating a venting system to the floors above whilst dealing with the huge weight of a fully loaded kiln (Plate 10). They extend the full width of the kiln where they are capped by the northern wall. The cast-iron rails and channels below also continue along the length of the tunnels.

## **5 DISCUSSION**

5.1 The 19<sup>th</sup> century brick kiln at Reads Brickworks, unremarkable above ground has upon excavation been exposed as an excellent example of a 'Suffolk'-type kiln, a substantial structure preserving most if not all of its functional attributes. The structure has been built into the natural slope of the ground which falls away to the south, the earthen banks providing support to robust walls on the north, west and east against the forces of the heating process and helping contain the heat within the kiln.

5.2 The building is purely functional in appearance with slight decorative touches given to the arched apertures on the south. The firing chamber is almost entirely blank the walls bearing the scars of repeated firings warped and eroded and generally in a poor condition. The green or unfired bricks would have been loaded into the centre of the kiln via the doorway or wicket on the west approximately two metres above the kiln floor which features a pattern of vents allowing air flow from below. Rejected and damaged bricks would be packed between the unfired bricks and kiln walls for protection against the fiercest of the heat and to help ensure an even firing. In some cases a make shift roof was used to seal the kiln.

5.3 Firing of the kiln took place from the south where external retaining walls spanned by an ephemeral roof structure formed a shelter around three semi-circular arched apertures giving access to the fire tunnels. The fuel was pushed into the tunnels on cast-iron grates or rails by long rakes which may also have been used to clear the ash from the channels below. Cast-iron doors hung on chains enclosing the tunnels on the south. The heat then permeated the kiln via a series of vented floors directly above the tunnels baking the green bricks within the firing chamber.

5.4 The kiln is clearly shown on the OS map of 1882 (Prosser *et al.* 2011) where it stands with a second example as part of Hallfarm Brickworks. A tramway extending from the brickworks to the jetty was used to transport the fired bricks to the river where they were taken by boat to various destinations. A third kiln had been constructed by 1904 indicating growth in production and by 1968 the site has been significantly upgraded. However the earlier kiln is still in existence at this time while its counterparts have been demolished. The kiln is still visible on the map of 1991, but likely went out of use with the construction of the new updraught kilns in the mid-20<sup>th</sup> century and so was not subject to upgrading or alteration. This has resulted in the fine preservation of the kiln structure which includes a number of fixtures and fittings not commonly seen to survive.

## **DEPOSITION OF THE ARCHIVE**

The requirements for archive storage will be agreed with the Suffolk HER and the archive deposited there. It will be deposited within three months of the conclusion of the fieldwork.

## **ACKNOWLEDGEMENTS**

Archaeological Solutions would like to thank MS Oakes Securities for funding the works, and Paul Robinson Partnership (UK) LLP for their assistance.

AS is pleased to acknowledge the advice and input of Ms Abby Antrobus of the Suffolk County Council Archaeological Service Conservation.

## **BIBLIOGRAPHY**

English Heritage's '*Understanding historic buildings: a guide to good recording practice*' (2006)

Herne, J. '*Brickmaking in Bunwell*' Bunwell Heritage Group (2011)

Institute for Archaeologists' '*Standard and guidance for the archaeological investigation and recording of standing buildings or structures*' (IfA 2008).

Prosser, L. et al. 2012 '*Reads Brickworks, Aldeburgh, Suffolk Heritage asset statement.*' Archaeological Solutions Report No. 4189.

## APPENDIX 1 HER SUMMARY SHEET

<b>Site name and address:</b>	The Kiln at Reads Brickworks, Aldeburgh, Suffolk.
<b>County:</b> Suffolk	<b>District:</b> Suffolk Coastal
<b>Village/Town:</b> Aldeburgh	<b>Parish:</b> Aldeburgh
<b>Planning application reference:</b>	C/12/2573
<b>Client name/address/tel:</b>	MS Oakes Securities Ltd
<b>Nature of application:</b>	Construction of residential properties
<b>Present land use:</b>	Demolished brickworks
<b>Size of application area:</b>	<b>Size of area investigated</b>
<b>NGR (8 figures):</b>	TM 449 569
<b>Site Code:</b>	ADB199
<b>Site director/Organization:</b>	Archaeological Solutions
<b>Type of work:</b>	Historic recording and monitoring
<b>Date of work:</b>	May 2013
<b>Location of finds/Curating museum:</b>	Suffolk HER
<b>Related SMR Nos:</b>	<b>Periods represented:</b> 19 <sup>th</sup> century
<b>Relevant previous summaries/reports:</b>	Prosser, L. et al. 2012 <i>'Reads Brickworks, Aldeburgh, Suffolk Heritage asset statement.'</i> Archaeological Solutions Report No. 4189.
<b>Summary of fieldwork results:</b>	<p>In May 2013 Archaeological Solutions Limited (AS) carried out a historic building recording and monitoring on a 19<sup>th</sup> century kiln at Reads Brickworks, Aldeburgh, Suffolk (NGR TM 449 569). The work was required to comply with a planning condition attached to planning approval for the proposed residential development, based on advice from Suffolk County Council AS-CT prior to the structures demolition.</p> <p>In November 2012 the entire site was the subject of a heritage asset statement which identified several buildings relating to the production of brick including the main factory, four updraught kilns, a small office and various storage buildings. Two buildings remain from the 19<sup>th</sup> century including a disused 'Suffolk'-type kiln and the small office building. All other buildings appear to be of 20<sup>th</sup> century date though the storage building may incorporate fragments of older structures.</p> <p>A more detailed study of the 19<sup>th</sup> kiln revealed a remarkably well preserved example of a 'Suffolk'-type kiln complete with thick robust walls enclosing a lattice brickwork floor. Beneath, three arched fire tunnels extend the width of the kiln given access from arched apertures piercing the wall on the south. External retaining walls extend to the south once forming a crude roofed shelter enclosing the stoking side of the kiln. Other fixtures and fittings including external doors hung on chains and fire rakes also survive.</p>
<b>Author of summary:</b> Lisa Smith	<b>Date of Summary:</b> July 2013

## APPENDIX 2      ARCHAEOLOGICAL SOLUTIONS BUILDING RECORDING ARCHIVE FORM

Site Details							
<b>Site Name:</b> Reads brickworks, Aldeburgh, Suffolk				<b>NGR:</b> TM 449 569			
<b>County:</b> Suffolk				<b>Museum Collecting Area:</b> Suffolk HER			
<b>Site Code:</b> ADB199				<b>Project Number:</b> 4398			
<b>Date of Work:</b> July 2013				<b>Related Work:</b>			
Brief/s				Specification/s			
Date		Present		Date		Present	
23 <sup>rd</sup> April 2013		No		26th April 2013		Yes	
Site Records (Description)							
Notes taken on site (3 pages A4)							
Site Drawings (Give Details of Formats & Size)							
Plans and elevations 1 sheets A4 – annotated 1 x A3 sheet of draft film 2 x A4 sheets of draft film 2 x irregular sheets of draft film							
Architect's Drawings:							
n/a							
Digital Drawings							
Printouts of Drawings			Printouts of Data			Digital Data	
In report						Digital photographs and drawings in digital format on CD	
Reports							
Report No		Report Type				Present	
4378		Historic Recording and Monitoring				Yes	
Site Photographs							
Black & White Contact Prints					Colour Slides		
Film No	Film Type	Negs	Negs Present	Contacts Present	Film No	Negs	Present
1	120mm	11-15	Yes	Yes	1	7-36	Yes
2	120mm	1-15	Yes	Yes	2	1-17	Yes
3	120mm	1-15	Yes	Yes			
4	120mm	1-15	Yes	Yes			
5	120mm	1-15	Yes	Yes			
Photographic Location Plans Present? (Give Details)							
In report and separate printouts in archive folder							
Digital Photographs (Give Details):							
Digital photography. Index and selected plates printed in report. Separate printout of index included in archive folder and digitally on CD							

## PLATES



Plate 1 19<sup>th</sup> century Suffolk kiln, taken from the north-west (DP 1)



Plate 2 Battered northern end of eastern elevation, taken from the east (DP 5)



Plate 3 Central wicket, internal construction, western elevation, taken from the north-west (DP 13)



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Plate 5 View through central arched aperture piercing the southern elevation with grille covered channel below, taken from the north (DP 30)



Plate 6 Fire rakes, found within the fire tunnels (DP 49)





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PHOTOGRAPHIC INDEX



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*19<sup>th</sup> century Suffolk kiln, taken from the north-west*



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*19<sup>th</sup> century Suffolk kiln, taken from the south-west*



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*Eastern and southern elevations, taken from the south-east*



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*Eastern elevation, taken from the north-east*



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*Battered northern end of eastern, elevation taken from the east*



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*Southern elevation, taken from the south-west*



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*Southern elevation, taken from the south-west*



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*Battered northern elevation, taken from the north-west*



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*Battered northern end of western elevation, taken from the west*



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*Western elevation with central wicket, taken from the north-west*



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*Decayed south-western corner, taken from the south-west*



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*Central wicket, western elevation, taken from the west*



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*Central wicket, internal construction, western elevation, taken from the north-west*



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*Eastern elevation, kiln interior, taken from the west*



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*Western elevation with central wicket, kiln interior, taken from the east*



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*Western and northern elevations, kiln interior, taken from the south-east*



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*Bowing of western elevation, kiln interior, taken from the south*



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*Commencement of demolition works, taken from the north-east*



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*Demolition of the western and northern elevations, taken from the south-west*



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*Northern elevation showing battered element as a later addition, taken from the south-west*



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*Demolition of the eastern elevation, taken from the west*



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*Complete demolition of above ground portions of the kiln walls, taken from the north-east*



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*Removal of detritus from the kiln interior, taken from the north-west*



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*Kiln floor constructed in brick forming a pattern of ventilation apertures, taken from the east*



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*Detail of brick kiln floor, taken from the east*



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*Lower level brickwork with larger apertures situated directly above fire tunnels, taken from the south*



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*Large apertures within the brickwork make-up of the kiln floor, taken from the east*



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*Western elevation revealed after partial removal of the kiln floor, taken from the east*



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*Central arched aperture piercing the southern elevation with grille covered channel below, taken from the north*



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*View through central arched aperture piercing the southern elevation with grille covered channel below, taken from the north*



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*Pointed arched fire tunnels extending beneath the kiln floor, taken from the south-west*



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*Three semi-circular arched apertures piercing the southern elevation, taken from the north-west*



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*Detailed view of central arched aperture with grille and channel below, taken from the north*



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*Detailed view of pointed arched aperture extending beneath the kiln floor, taken from the south*



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*Arched aperture piercing the external face of the southern elevation now blocked with rubbish, taken from the north*



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*Channel extending the length of the kiln beneath each of the fire tunnels bridged by a series of iron struts forming a grille, taken from the west*





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*Fire tunnel construction, taken from the south*



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*Fire tunnel construction, taken from the south*



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*Vitrification of the brickwork within the central fire tunnel, taken from the south*



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*Removal of the internal floors and fire tunnels from the interior of the kiln, taken from the south-west*



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*Three arched fire holes piercing the southern elevation, taken from the north*



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*Blank northern elevation with evidence of the lower channels extending across the kiln base, taken from the south-west*



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*Excavation immediately to the south of the kiln, taken from the south-east*



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*Excavation to the south of the kiln, taken from the north-east*



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*External southern elevation showing central aperture with white brick decorative arch and chain above to raise and lower a door, taken from the south-east*



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*Southern elevation and retaining wall extending to the south, taken from the south-west*



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*Retaining wall extending southwards before returning eastwards, taken from the east*



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*Fire rakes, found within the fire tunnels.*



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*Fire rakes, found within the fire tunnels*



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*Kiln excavated to the depth of the sand natural taken from the north*



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*Eastern retaining wall extending south before returning to the east, taken from the south-east*



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*Kiln and southern retaining wall, taken from the south-east*



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*Heavy metal door hung on a chain used to cover one of the archways*



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*Detail of heavy metal door hung on a chain used to cover one of the archways*



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*Detail of rear of heavy metal door hung on a chain used to cover one of the archways*



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*Excavation to the exterior of the kiln, taken from the south-east*



57

*Western retaining wall extending to the south, taken from the east*



58

*Handles and long stems of the fire rakes*



59

*Detail of handles and long stems of the fire rakes*



60

*The remains of the roof line along the eastern retaining wall, taken from the south-west*



61

*External archways along the south wall of the kiln, taken from the south-west*



62

*External archways along the south wall of the kiln, taken from the south*



63

*Area to the rear of the kiln, taken from the south-west*



64

*Remains of the 19<sup>th</sup> century 'Suffolk' kiln, taken from the south-east*



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**Fig. 1 Site location plan**  
 Scale 1:25,000 at A4

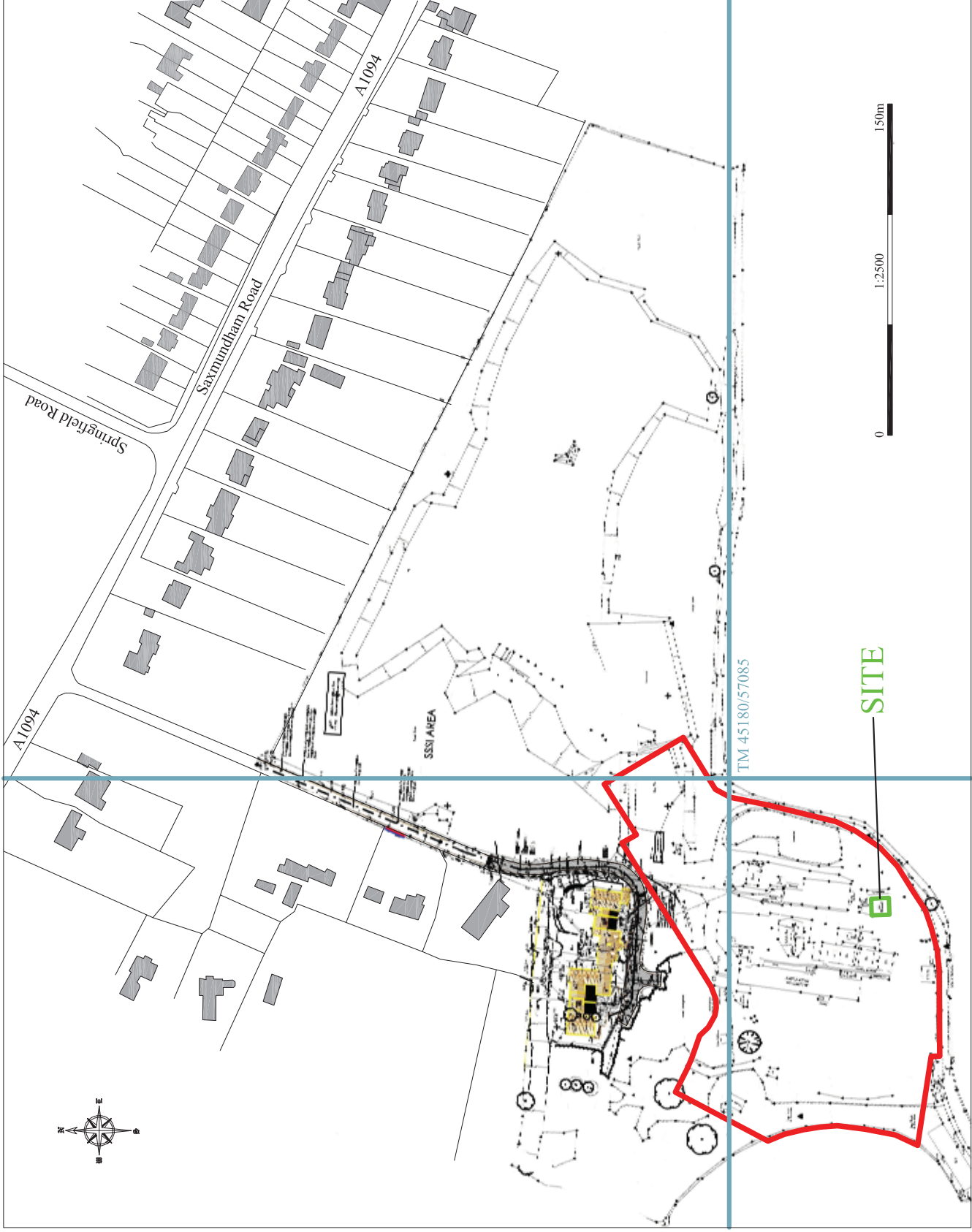
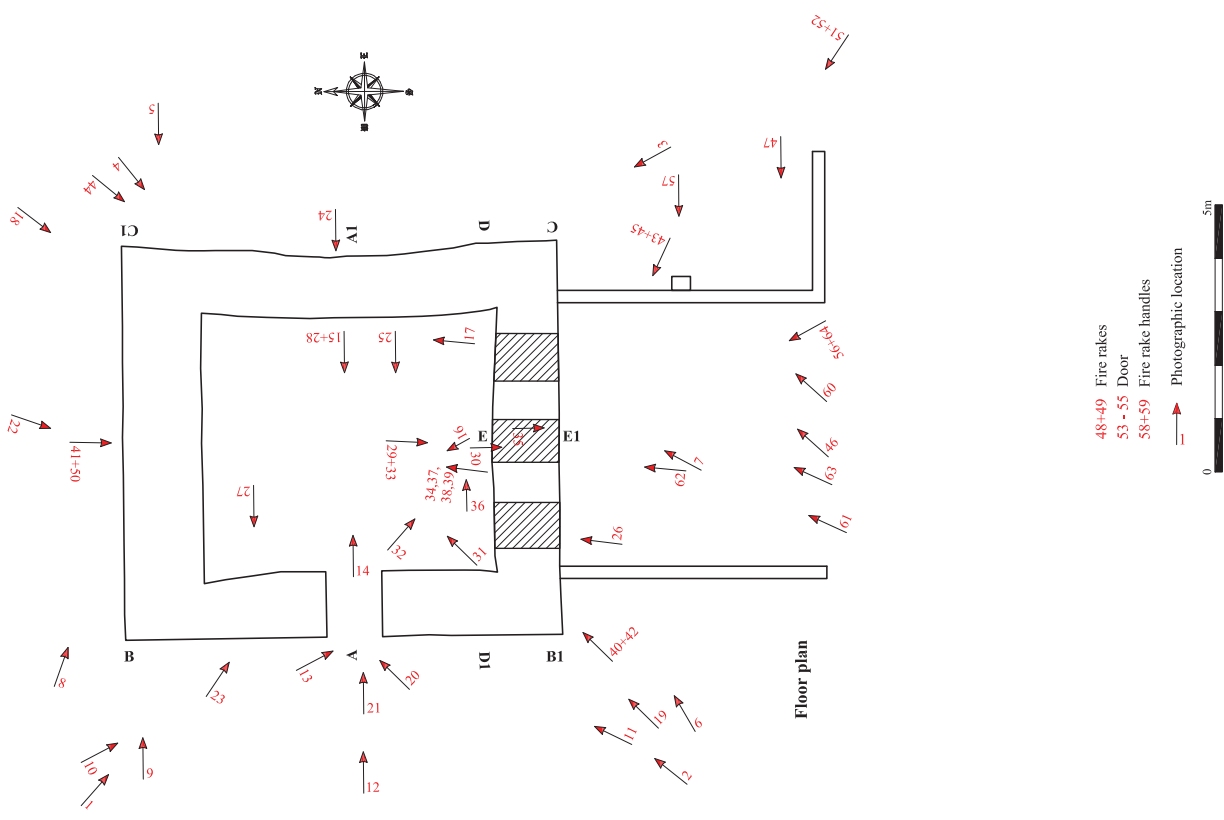
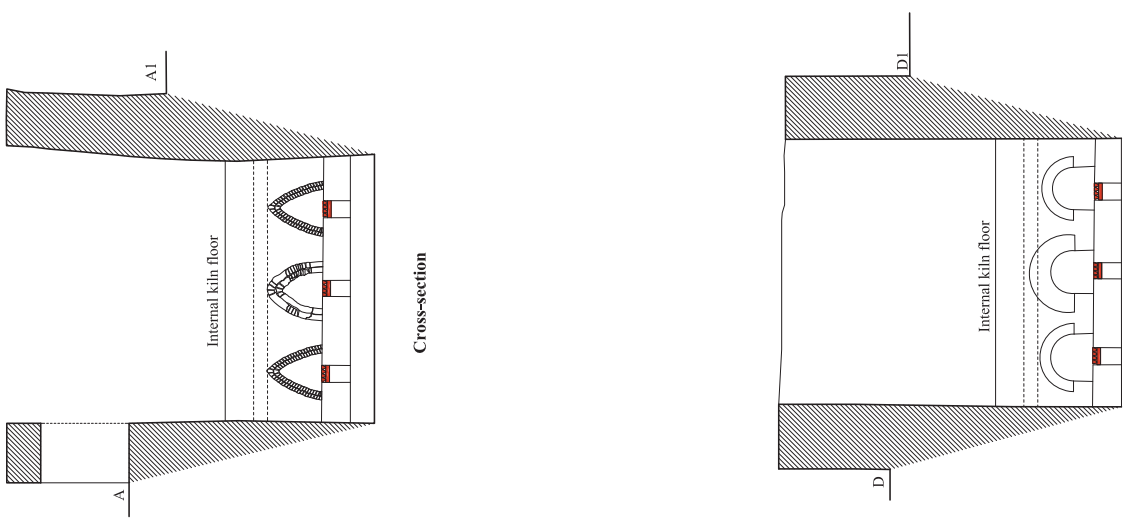
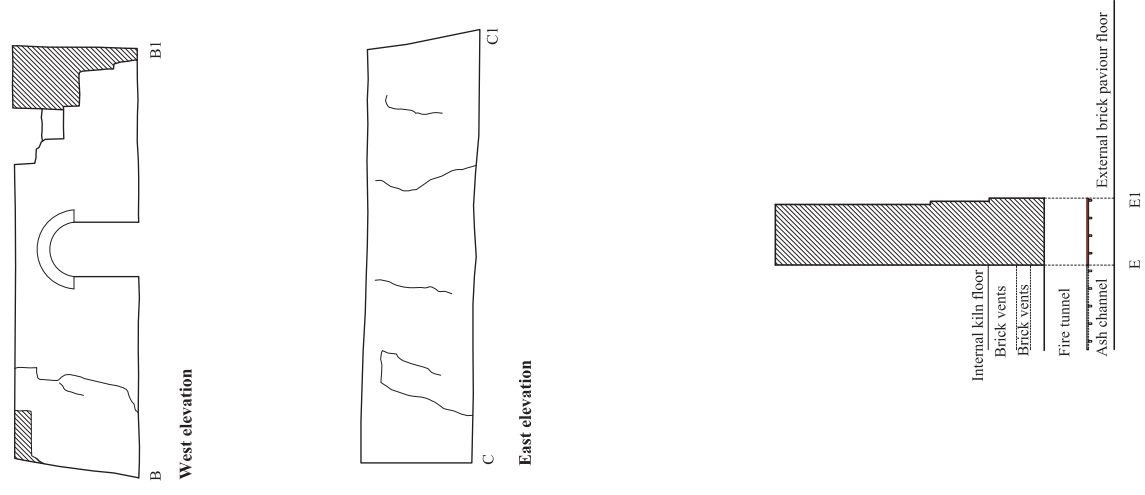


Fig. 2 Detailed site location

Scale 1:2500 at A4



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**Fig. 3 Disused kiln**  
 Scale 1:100 at A3