Hall Grey Architects

ROWNTREE COCOA WORKS YORK
HISTORIC BUILDING REPORT

Rowntree Cocoa Works Factory
Historic Building Report

CONTENTS

1.0 SUMMARY

1.1 Status of the buildings and the site

1.1.1 Due to the changing nature of confectionery manufacture and the leaner, competitive environment, within which Nestle UK, and the Rowntree works have to operate, the older buildings on the site have potentially outgrown their useful manufacturing life and as such are at risk of obsolescence. The information provided within this report has been generated to identify built elements of the site, that whilst not of national or regional importance, either historically or architecturally, are associated with the local area and the Cocoa Works in particular and should, where possible be retained.

1.1.2 New functions have to be found for these buildings if they are to remain; allowing them to evolve and metamorphose to new, vibrant uses that will, in the longer term, guarantee not only the security of the more significant buildings' form and fabric for future generations to enjoy, but at the same time, will secure the prospects of the factory site for employment and capital investment as the only remaining confectionery manufacturing base in York.

1.1.3 The location of the site falls outside the conservation areas of adjacent New Earswick, Clifton, Heworth and Huntingdon. None of the buildings at the Cocoa Works factory are listed as being of architectural or historical value nationally, regionally or locally.

1.1.4 Part of the site to the north east has been identified as an area of potential Zone 2 Flood Risk (a low to medium annual risk of up to 1% from the River Foss).

1.1.5 The Cocoa Works site is located outside the City of York designated Air Quality Management Area.

1.1.6 None of the trees on the site are covered by Tree Preservation Orders. Potential for expansion of the site in a northerly direction is restricted by the designation of green wedge areas between the site's northern boundary and New Earswick.

1.1.7 It must be understood that any works to demolish, change use class orders or carry out alterations to the external fabric will be subject to Town and Country Planning consent which cannot be presumed to be granted.

1.2 Development potentials and restrictions

1.2.1 The best use for a building is obviously the use for which the building was originally designed or a functionally similar use, and continuation of that use should be considered when the future of a building is being assessed.

1.2.2 Not all original uses will be viable or even appropriate, however, due to changes over time. The older buildings at the Cocoa Works complex have changed manufacturing functions successfully through their time, but the point has been reached where manufacturing processes have automated and developed to an extent that the viability of operating within these buildings is brought into question.

1.2.3 The restricted headroom within the multi storey buildings severely restricts the installation of plant and equipment to production lines. The vertical manufacturing process has been superseded by single level, automated functions producing high volume and capable of flexibility to match the sales market. The physical restrictions of the multi storey buildings are at odds with this corporate philosophy.

1.2.4 There are opportunities for further manufacturing development within the site between the Kit Kat 4 and Kit Kat 5 lines, to the east of the finished goods stores and potentially to the north of Kit Kat 4 if the old maintenance workshops and store buildings were demolished and replaced.

1.2.5 The southern end of the site is a tight knit complex of older buildings, which, more than likely, would have to be demolished wholesale to free up potential manufacturing space with satisfactory vehicular access and movement.

1.2.6 Opportunities exist to release the outdated, intensively developed south area of the site and concentrate manufacturing to the newer buildings to the north of the former Gum Department.

1.2.7 In considering the future development of the Cocoa Works complex, the planning authority has indicated its intention to be mindful of the need to allow alternative uses for parts of the site to maintain the viability of the manufacturing base.

2.0 BACKGROUND

2.1 Purpose and history of the document

2.1.1 This historic buildings report has been prepared by Hall Grey Architects on behalf of Nestle UK in response to a request from the local planning authority following discussions about potential redevelopment of part of the Haxby Road site in York, commonly referred to as the Rowntree's Cocoa Works.

2.1.2 The report was commissioned to establish an understanding of the Haxby Road site, the buildings on the site, adjacent buildings bounding the site, owned or previously owned by Nestle Rowntree and external landscaping which comprise the factory, with a view to assessing and defining the significance of the fabric and location, and to identify key buildings on the site which may have a bearing on the future development of the complex.

2.1.3 The report traces the development of the site as an integrated complex and shows how that context has changed during the course of time identifying key buildings, which may have been altered, demolished or remain. Any key buildings remaining are assessed in terms of their architectural and historic significance.

2.2 Scope of the Report

2.2.1 A limited number of historical arrangement drawings have been located; however, a considerable amount of documentary evidence exists in the form of photographs, annual reports, articles in the Cocoa Works Magazine (CWM) published from 1902 to 1970 and books about the Rowntree family and the growth of the confectionery business at the Haxby Road site.

2.2.2 This document brings together segments of the available information and makes an assessment of the factory itself and buildings on the site. The physical fabric has been inspected to assist in the understanding of the historical development of the site.

2.2.3 The vast majority of company records are archived at the Borthwick Institute of Historical Research located within the University of York campus at Heslington. Nestles UK deposited most records with the Institute in 1992; prior to that the records were retained at the Haxby Road factory itself, head office of Rowntree & Co, Rowntree Mackintosh and previously Rowntree Plc. A second tranche of records were deposited at the Institute in 1996 and were transferred from the company's Norwich factory which was originally under the ownership of John Mackintosh & Sons Ltd. Similarly a number of drawings relating to projects undertaken at the Haxby Road site have recently been deposited with the York City Archive Department by John Dosser & Associates (Consulting Engineers) of York and these are currently in the process of being catalogued and archived.

2.3 Adoption of the Report

2.3.1 York City Council has requested a buildings evaluation of the early buildings on the site, the purpose of which is to inform debate about future proposals for the site including demolition or alteration of the buildings. It is recommended that the

report will become a guidance document for the future development and management of the Haxby Road site.

2.3.2 The options for future development, demolition and alteration will be judged against the information presented in the report. Specific proposals will be subject to the customary statutory controls and published Government policy guidance.

2.4 Ownership of the Site

2.4.1 The site is wholly within the ownership of Nestle UK, the United Kingdom subsidiary of Nestle SA, the Swiss based food and beverage company.

2.5 Management Context

2.5.1 The site is located within the jurisdiction of York City Council, which is responsible for control of planning matters; land-use planning issues, access needs and conservation and enhancement of the built environment. Issues within the site therefore need to be considered within the context of the Statutory Development Plan for York comprising of the Regional Spatial Strategy for Yorkshire and the Humber adopted in December 2004 and covering the period to 2016 and the North Yorkshire County Structure Plan, Alteration No 3 adopted in October 1995, which provides policies for the period 1995-2006. In determining planning applications, the Council also uses non-statutory and emerging plans. The City of York draft Local Plan was adopted for development control purposes in April 2005.

2.6 Introduction to the asset

2.6.1 The City of York, capital of the north and second city of the realm, is the administrative hub of Yorkshire.

2.6.2 The history of this city can be traced back to AD71 when it began as a fortress, built by the Roman 9th Legion for a campaign against the Brigantes tribe. It grew into an important city, named Eboracum and here Constantine the Great was made Roman Emperor in AD306.

2.6.3 It was the Vikings who gave York its name, derived from Jorvik or Yorwik during their brief but flourishing reign. Norman rule was to last longer and it was the Normans who made the city a vital centre of government, commerce and religion for the north. The Norman development of the city prepared it well for the important part it was to play in the reigns of the Plantagenet Kings and, in 1485 when this era ended and the Tudor age began, York was already at its zenith.

2.6.4 It was not until the 18th century, when it became a fashionable resort and centre, that there was any marked change in the city's outward character. Georgian elegance added to its architectural attractions and in the following century, the city flourished as the development of the railway marked the start of a new era of growth and prosperity with York as an important hub for the north/south flow of goods carried on the railways.

2.6.5 It was not unusual in this period for Quaker families to become successful businessmen. Quakers were not allowed into Oxford or Cambridge Universities until 1871 and many turned their talents to the world of industry, banking and

commerce, with great success. Some prominent Quakers were at the forefront of the Industrial Revolution, which began in Britain in the nineteenth century. In manufacturing, Josiah Wedgwood, George Cadbury and Joseph Rowntree all became successful.

2.6.6 Drinking chocolate and eating chocolate became affordable to the population in the mid 1800's and factories started producing cocoa at locations around the country as the drinks and confectionery became popular to the masses.

2.6.7 Close links existed between the Rowntree and Cadbury families; in working life there was commercial rivalry, whilst outside the confines of work, Joseph Rowntree and George Cadbury, both from strongly rooted Quaker families collaborated on many political, religious and charitable projects.

2.6.8 The development of Cadburys and Nestle Rowntree follow similar paths, both companies moved from undersized premises in their respective city to greenfield sites where they could develop new factories with much improved amenities for the workers; both George Cadbury and Joseph Rowntree were paternalistic employers attempting to improve the quality of their employees lives, both set up garden villages and trusts to provide better quality housing for their white and blue collar workers and George Cadbury spent some time during his early life working at the grocery shop of Joseph Rowntree senior to gain experience before starting to build up Cadbury Bros. into one of the country's leading chocolate and cocoa manufacturers.

2.6.9 The history of Rowntrees as a cocoa and confectionery began in a small factory in York and has grown to a multi national business with the Haxby Road site at its core since 1890.

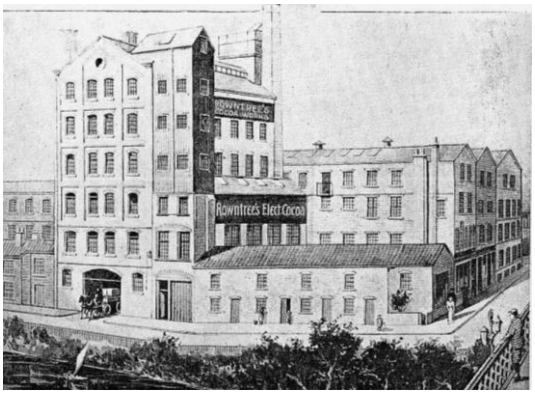
3.0 UNDERSTANDING

3.1 A Brief History of the Site

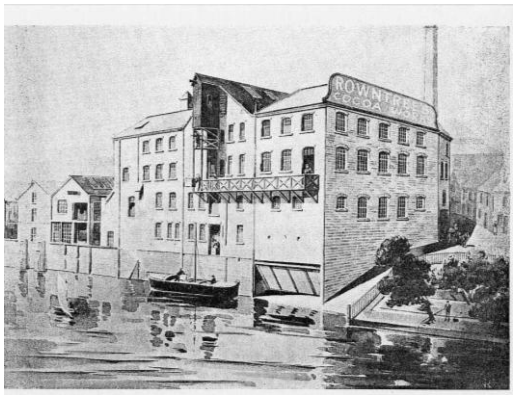
3.1.1 The main Cocoa works factory site bounded by the redundant Foss Island Branch railway line to the south (currently a cycle route), Wiggington Road to the west, Haxby Road to the east and sports fields and agricultural land to the north currently occupies 71 acres and includes 48 buildings with car and lorry parking.

3.1.2 The site is historically linked to the manufacture of confectionery and cocoa in particular, being the main manufacturing site for Nestle Rowntree and its previous companies in York since 1907.

3.1.3 The history of Nestle Rowntree and the Cocoa Works begins when Henry Isaac Rowntree acquired a cocoa, chocolate and chicory workshop at the back of Castlegate from Tuke, Waller and Copsie in 1862. Larger premises consisting of an old iron foundry and several cottages at Tanners Moat were purchased in about 1864, but output from the factory and the numbers of people employed were very small; the company only just being viable and a going concern.



The Tanners Moat factory 1895



The North Street factory 1895

3.1.4 In 1869 Joseph Rowntree, Henry's brother joined the firm and a partnership was formed under the title H.I. Rowntree & Co. with Joseph Rowntree responsible for the accounts and Henry for production; with this arrangement sales and profits slowly increased.

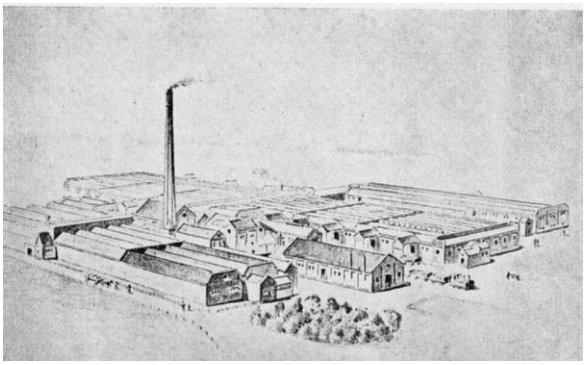
3.1.5 The event, which brought about the change in fortunes of the company, was the arrival of a Frenchman, Claude Gaget in 1879 with a sample of gum. Until this date the manufacture of gum had been almost exclusively limited to France; the Rowntree factory started producing fruit pastilles and gums and Rowntree's "Crystallized Gum Pastilles" became a great success.

3.1.6 The company's success as a cocoa and chocolate business, as elsewhere at Cadbury's in Birmingham and Fry's in Bristol, depended upon the mastery of the 'Van Houten' process in the manufacture of cocoa butter and cocoa powder. Joseph Rowntree engaged Cornelius Hollander, a Dutch man, who claimed to have knowledge of the process for extraction of the cocoa butter from the roasted nib of the nut; and despite misgivings, a lack of belief from Rowntree that Hollander was capable of developing the process, and a court case, the work of

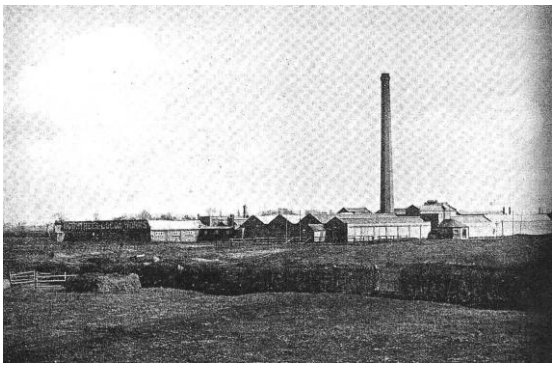
Hollander ultimately led to the development of Rowntree's famous 'Elect Cocoa' launched in 1887.

3.1.7 The success of 'Elect Cocoa' boosted sales and required additional manufacturing space. Accommodation was added at the premises in North Street, purchased by the company in 1882, but space remained a problem and in 1890, Joseph Rowntree purchased 29 acres of agricultural land at Haxby Road, approximately two miles from the city, for the construction of new manufacturing premises. Building work commenced with the Fruit Room and Gum Departments, essential for the production of Rowntree's 'Crystallised Gum Pastilles' whilst cocoa production continued at the Rowntree sites within the city.

3.1.8 By 1895, the Haxby Road site had been developed with a series of simple, single storey, brick buildings with pitched roofs including the Gum Department, Packing Sheds, the Hay and Straw Shed, the Cake Rooms and an amenity block. Part of the site was utilised for growing a significant amount of fruit for use in the Fruit Department and a private railway line was constructed to join up with the North East Railway Company's Foss Island Branch Line to move goods around the site and later as the main distribution vehicle.



The Cocoa Works factory 1895 viewed from Haxby Road



The Cocoa Works factory 1895 viewed from Wiggington Road

3.1.9 The company expanded rapidly; the workforce numbering no more than 100 people in 1880 had grown to over 4,000 in 1910 and more than 6,000 by 1920 with the buildings occupying 15 acres. Further land was acquired for development, both to the north and east of the original site; in 1979, the site occupied 149 acres, 71 acres of that allocated to the factory and car parks, 55 acres of agricultural land and 23 acres of sports fields.

3.1.10 Development continued apace until the late 1930's with the predominant buildings being large, multi storey blocks, constructed in reinforced concrete or built with steel frames and both clad in traditional materials of brick with ashlar York stone dressings where appropriate.

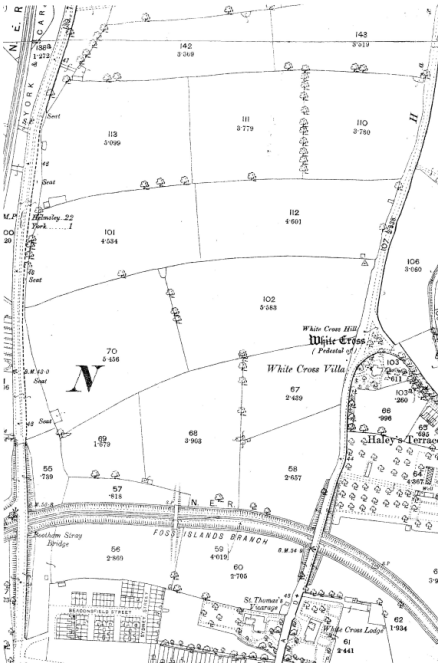
3.1.11 A period of consolidation on the York site and acquisition of companies both in the UK and abroad followed as Rowntrees established a global network of manufacturing bases. Rowntree & Co Ltd merged with John Mackintosh & Sons Ltd in 1969 and the newly merged company invested in a number of new build factories in Castleford, Leicester, Fawdon and Dublin which were more ideally suited to automation and up to date manufacturing processes.

3.1.12 The next phase of major building development on the site has occurred since the mid 1980's with a series of new, large single storey buildings housing production lines and warehousing.

3.1.13 Rowntree Plc and was bought out by Nestle SA in 1988. Since that time, the York site has seen more than £225 million invested in new manufacturing plant including a £14m cocoa processing plant, £15.5m Polo Mint plant, £18m chocolate making plant, £28m Kit Kat plant and £7m of automated plant for Aero bar production.

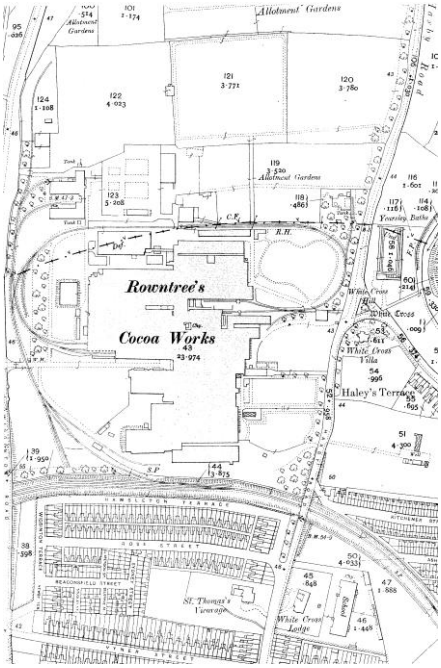
An aerial view of the Cocoa Works factory 2006 viewed from the south

3.1.14 An overview of the site's development is given in the following map extracts, the date for each plan being based on available map evidence. This is followed by plans showing the age of buildings on the site and concludes with the reference to building numbers on the site. Some of these are derived historically from the original buildings and functions and can be traced back to the insurance schedules of the Haxby Road factory written in the period 1891 – 1897.



1890

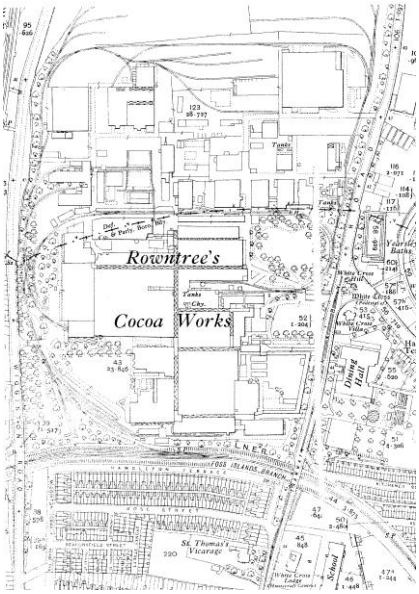
The site, 29 acres of agricultural land (the southernmost factory estate) was purchased by Joseph Rowntree and conveyed to Rowntree & Co in 1897. A further 31 acres to the west side of Haxby Road was conveyed from Earl de Grey in 1899.



1907

By 1895 the site had been developed with the first manufacturing departments, the Fruit Room and the Gum Department. Rapid expansion took place and in 1907 Rowntree & Co had transferred all of their manufacturing to the Cocoa Works site. The multi storey Elect Block, Melangeur Block and Almond Block are evident to the west and south of the factory development

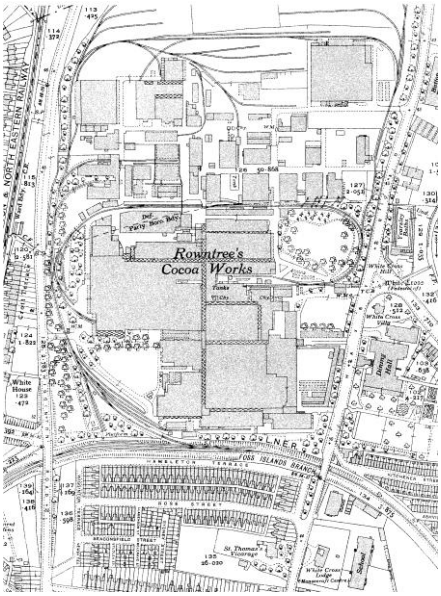
The housing stock in the area had also increased significantly within a period of less than 20 years.



1931

The multi storey extension to the Almond Block has been erected; the Bonded Warehouse to the north west of the site is completed together with a new Gum Warehouse, new Extract Warehouse and large-scale extensions to the Packing and Store area and to the Cream Department. To the north east of the site the new Card Box Mill can be identified.

The 1913 Dining Block has been erected to the east side of Haxby Road.

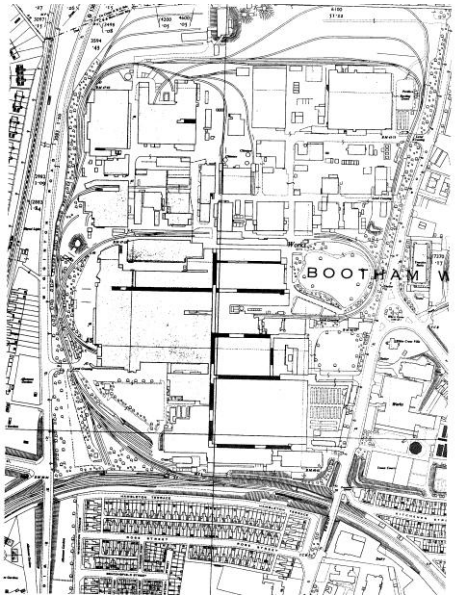


1937

The multi storey Cream Block and extension are completed; consolidation is taking place on site.

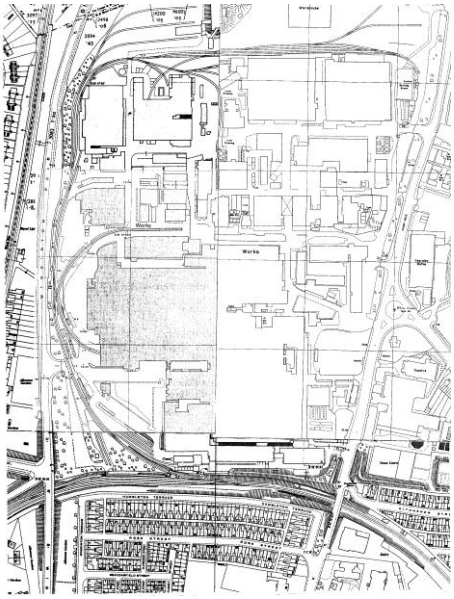
The new Thompson Boiler House is erected.

The Joseph Rowntree theatre is built to the north of the Dining Block



1961

Little further development takes place on site during the 40's – 60's whilst the company embarks on a series of mergers, incorporations and acquisitions, the most notable being the merger with John Mackintosh & Sons Ltd to create the newly named Rowntree Mackintosh.



1985

The Cocoa Works site remains the HQ for Rowntree Mackintosh.
New buildings include the office block and extensions built on the former rose gardens to the east of the Starch Department, new Mould Wash building and warehousing to the north east of the site.
The rail network although indicated is no longer used for distribution.
The first factory building to the north of the track is built on part of the sports ground.

2004

Large areas of the site have been cleared and buildings demolished to make way for new production facilities for Kit Kat, Polo, cocoa processing plant, the Product Technical Centre and finished goods stores.
The Dining Block is sold to Nuffield Hospital.

Dating of buildings on the site (see over for building references)

The core of the original factory remains but has been altered significantly both internally and externally with the removal and replacement of roof structures etc. The main access corridors – the main corridor, gum corridor, south corridor, mechanics corridor, central corridor and stove corridor established when the factory was first built are still used as main access routes

YORK SITE BUILDING NUMBERS

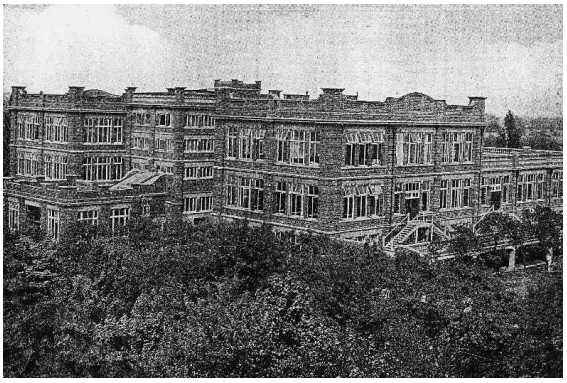
No.	Origin	Present Function
1	Almond Block (AB)	Matchmaker, Assortment and Chocolate manufacture
2	Almond Block Ext (ABX)	Aero, Assortments & Chocolate manufacture
3	Kit Kat 1 & Yorkie	Milky Bar manufacture
4	Cream Ground floor	Aero Bubbles (Microlite) manufacture
5	North & South bays	Milky Bar & Yorkie manufacture
6	Labs/Offices	Factory Offices
7	No 6 Aero (Square Range)	Square Range (Munchies)
9	Labs	Diner 2 (catering) and Factory Quality laboratory
10	New Square Range Plant	Square Range Ingredients areas ((gnd) and offices (1st)
11	CCSA/Dawson Wash	Aero Drop Zone (Goods-in, Finished-out)
17	Builders' Store	Builder's Store
25	Vice Versa, Kit Kat Offices	Smarties manufacture, Diner 1 (catering), Factory offices
26	HR 23	HR23 Technical Maintenance Store
27	No 3 Kit Kat Wafer	No 3 Kit Kat Wafer
28	No 3 Kit Kat Mould/Pkg	No 3 Kit Kat Mould/Pkg
29	Landing Stage	Landing Stage (50% of Factory goods in/out)
30	WROB	Wigginton Road Office – Nestlé Rowntree HQ
31	General Offices	Bear Pit catering, offices and meeting rooms
34	Melangeur	Melangeur chocolate manufacture
39	Dining/Conference Complex	Nuffield Hospital (not Nestlé)
43	No 5 Sub Station	No longer exists, sub-station now in BK95
49	Bulk Sugar (with Melangeur)	Bulk Sugar (with Melangeur)
51	Midland Bank	Vacant
52	Assortments	Assortments Amenities (changing & showers)
53	Loco Sheds	Waste Handling facility
57	Engineering Workshops	Factory workshops
58	Card Box	Vacant storage space & Computer Room 3
61	Post Office	Post Office
64	Theatre	Theatre – leased to the Joseph Rowntree Theatre Group
65		
66	Social Block	Group Facilities offices
67	NCX (Nut Cluster Extension)	5th Floor Aero, 4th Floor Aero, 3rd Drifter, 2nd Assortments
67A	Flour Store	Communications contractors office & store
69	Smarties Block	Smarties Block
71	11 & 12 Store	HR11/12 Packaging and Ingredients store
72	NGD	Nestlé Distribution Garage
73	Pensions Office	Group Quality Central Laboratory
75	Elect Cocoa building	Elect Chocolate manufacturing
76	Joseph Rowntree Memorial Library	Joseph Rowntree Memorial Library
77	Mould Wash	Mould Wash
78	Sheet Metal	Group Facilities workshop
80	No 4 Kit Kat	No 4 Kit Kat
85	Rose Lawn Offices	Rose Lawn (temporary) Offices
86	HROB & Generator	Haxby Road Office – Corporate Functions
87	Product Technology Centre (PTC)	Product Technology Centre (PTC)
89	White Cross Villa	Not Nestlé owned
90	CF1 (cricket field 1) Store	Nestlé Group Distribution finished goods storage
91	CF2&4 Store	Nestlé Group Distribution finished goods storage
92	Cocoa	Cocoa Bean processing leased to Cargill
93	Flavour	Employee Sales Shop
94	CHP Plant	Combined Heat & Power generation plant
95	Intake Sub	Electrical intake substation and No.5 sub-station
96	Polo	Polo sugar manufacturing
97	No 5 Kit Kat	No 5 Kit Kat
99	Mille Crux Bungalow and Pavilion	Pensioner bungalow and sports amenities

3.2 Other buildings associated with the factory outside the site

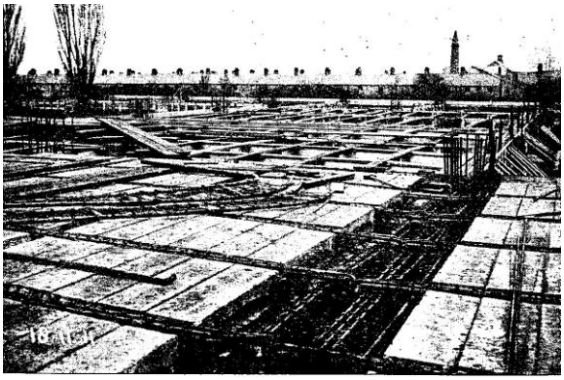
3.2.1 There are three important stand alone buildings adjacent to the Cocoa Works that were originally built for the benefit of the factory employees and are now either in different ownership or are not being run by the company; these buildings are Yearsley Swimming Baths (1909), the Dining Block (1913) and the Joseph Rowntree Theatre (1935) all located on the east side of Haxby Road facing the main factory site.

3.2.2 Yearsley Swimming Baths was originally built as an open air bathing facility by Rowntree & Co and was gifted to the City of York in 1909. The swimming pool and changing facilities have since been enclosed and although currently the baths are being operated by the city council; they have been the subject of speculation regarding their future.

3.2.3 The Dining Block was designed by W J Swain, the company architect in 1913 and was built by Rowntree's in house building department incorporating a reinforced concrete frame using the cross-braced or Lattice Truss system patented by the architect. The spans of main beams, which at the time, were about the largest in the country for the length of floor slab, were 48 feet. The heavy main beams are curved from the caps of the pillars to enable very wide spans at enormous strength to be achieved. Between the main beams hollow concrete blocks were installed as the floor construction to deaden impact sound. The block was built to provide dining, gymnasium and school facilities for the workers and replaced a much smaller building on the main factory site. The building was purchased from Nestle UK in the early 2000's and re-opened as the York Nuffield Hospital in 2004.



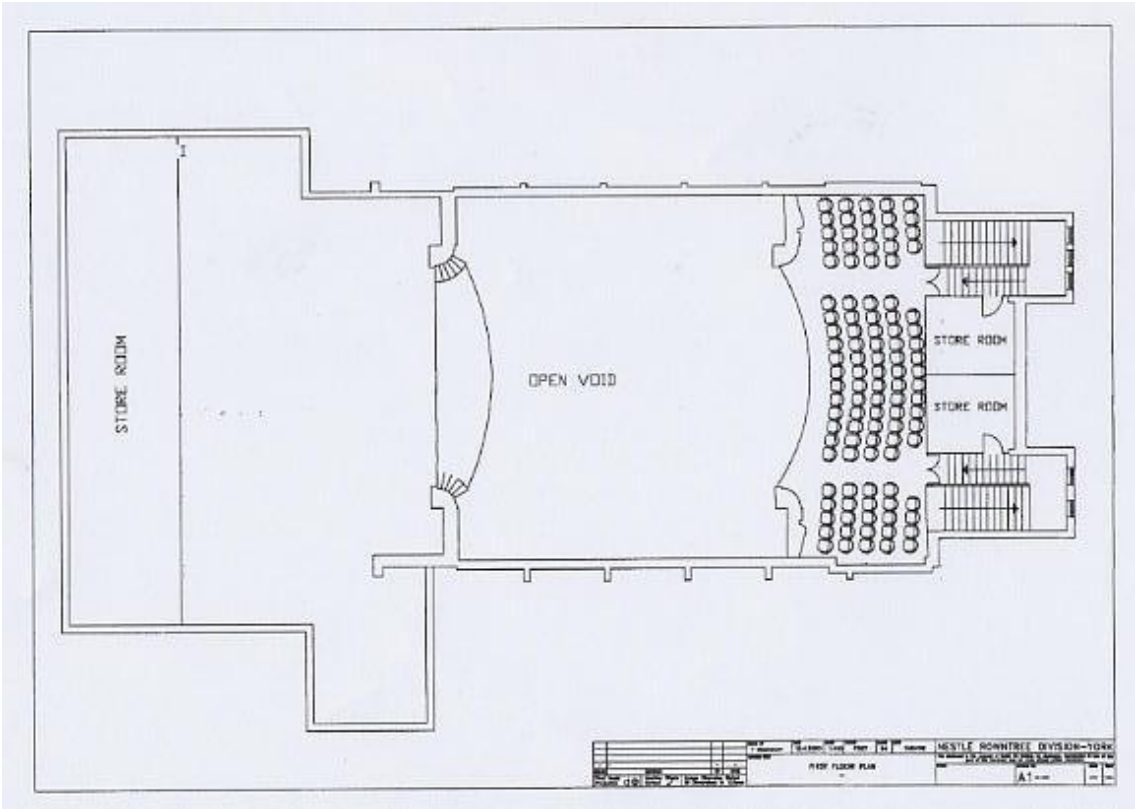
The Dining Block after completion in 1913

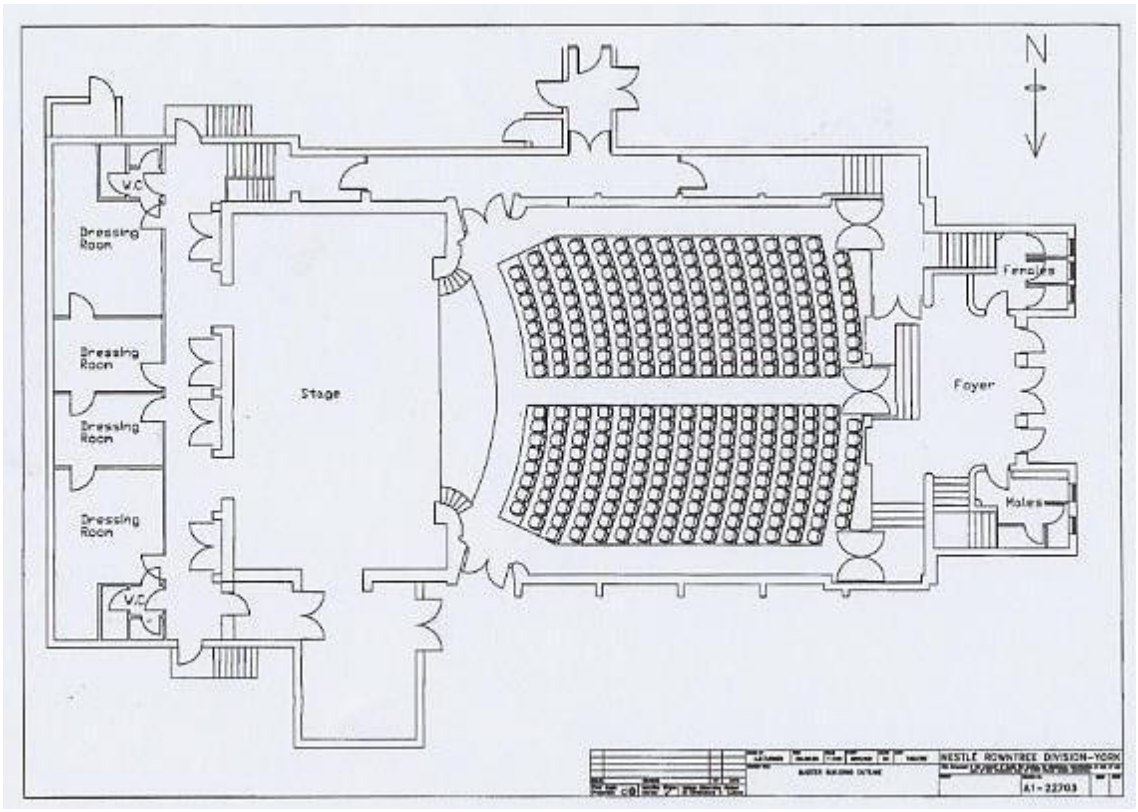


The Dining Block under construction showing the hollow block floor

3.2.4 The theatre was built as a facility for the staff of the Rowntree's factory and is the only building originally part of the factory development, which is listed (Grade II). A copy of the listing appears in the Appendix at the end of this report.

3.2.5 The theatre is leased out by Nestle Rowntree to the Joseph Rowntree Theatre Ltd, a company with charitable stautus, which provides the venue for amateur and professional theatre, dance, music and other stage based events. The theatre is under the control of a management board, with all the staff being volunteers. Theatretech – Theatre Design consultants based in London, upgraded the internal seating arrangements and fire exit provisions in 2004.





The Joseph Rowntree Theatre ground and first floor plans prior to alteration of the seating arrangements carried out in 2004
Photographs and listing description included in Appendix

3.2.6 Although not directly connected with the factory, in that the accommodation was not constructed exclusively for the factory workers, mention should be made of New Earswick garden village that was built and initially funded by Joseph Rowntree and lies in close proximity to the factory site.

3.2.7 Rowntree's major concern was to find ways of reducing poverty, in 1863 he produced a statistical study on the links between crime and poverty, two years later he produced a second study, 'Pauperism in England and Wales'. As a means of providing practical help, Joseph Rowntree purchased 123 acres at New Earswick in 1901 to provide better housing for people on low incomes.

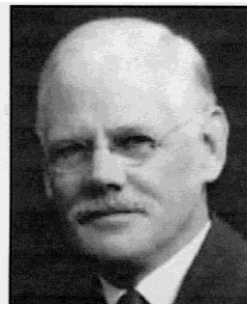
3.2.8 The planner Raymond Unwin and the architect Barry Parker were commissioned to produce an overall plan for a new 'garden' village and the detailed designs for its first houses. They were to go on to design the garden cities of Letchworth and Welwyn.

3.2.9 The building of New Earswick was an attempt to create a balanced village community where, although rents were to be kept low, they should still represent a modest commercial return on the capital invested. Houses there were to be open to any working people, not just Rowntree employees and there was to be a mix of white collar and blue-collar workers. The village was to be a demonstration of good practice. At Joseph Rowntree's insistence, houses had gardens with fruit trees planted and enough ground to grow vegetables.

3.2.10 The Joseph Rowntree Village Trust was established in 1904 to administer New Earswick. In 1959 the trusts objectives were broadened to cover research and development and in 1990 the organisation was renamed the Joseph Rowntree Foundation. Two other organisations were also founded in 1904, the Joseph Rowntree Charitable Trust and the Joseph Rowntree Reform Trust Ltd, all three trusts are still active today.

3.3 The Rowntree family businessmen and benevolence

Joseph Rowntree



Benjamin Seebohm Rowntree

3.3.1 Joseph Rowntree (1836-1925) was a Quaker and a successful businessman with strong social convictions allied to his religious beliefs. He joined his father's grocery business in The Pavement, York at the age of 14 after only 5 years of schooling. His tasks included the mixing of blends for tea and coffee and as part of his education in the business a period of time was spent in London under apprenticeship. It was here that he developed an interest in politics and regularly attended debates at the House of Commons. Rowntree returned from London to

work for this father, but in 1869 he left to join his brother, Henry, who owned the Cocoa, Chocolate and Chicory Works in York.

3.3.2 The limited company of Rowntree & Co was incorporated in March 1897. The assets of H I Rowntree & Co (of which Joseph Rowntree was at that time the sole owner) were transferred to the new company.

3.3.3 Joseph Rowntree included many family members within the Rowntree organisation; John Wilhelm was taken into partnership in 1889 and was involved with the general conduct of the business specialising in cocoa and cake chocolate; Arnold Stephenson set up the Gum Department in 1892, moved to sales and took charge of selling and advertising in 1897; Francis Henry joined the company in 1893 and co-managed the Engineering Department; Theodore Hotham joined in 1891 and became the first company secretary; Benjamin Seebohm Rowntree took over as Chairman in 1923 and was the last family member to hold the position in the Rowntree Company.

3.3.4 When Rowntree & Co opened the new factory on the outskirts of York in 1891, Joseph Rowntree ensured that it provided excellent facilities for his employees, with open, well lit and well ventilated accommodation; allied to the improvement in working conditions he also pursued enlightened employment policies. Influenced by the book 'Poverty, A Study of Town Life' written by his son, Benjamin Seebohm Rowntree, which identified appalling statistics of dark, overcrowded, insanitary housing conditions, Joseph Rowntree attempted to improve the quality of his employee's lives and pioneered many social welfare schemes and developments in industrial relations.

3.3.5 A company doctor and dentist were appointed to the permanent staff before 1906 and by 1919 a full time optician had also been employed to provide free services for the workforce.

3.3.6 In 1906 Joseph Rowntree donated £10,000 to establish a Pension Fund for his workers and before 1919 holiday with pay had been introduced and the working hours reduced to 44 hours per week. A factory library and theatre were provided and free education at the Day Continuation School was available for all workers under the age of seventeen.

3.3.7 Benjamin Seebohm Rowntree (1871-1954) was the third child of Joseph Rowntree and was appointed as a director in 1897. Like his father, he believed that it was his duty to help the poor and disadvantaged and inspired by his father's studies he carried out his own investigations into poverty in York. Seebohm Rowntree's conclusions were adopted by the government of the day and a series of reforms, influenced by him, were introduced including the Old Age Pensions Act and the National Insurance Act.

3.3.8 Benjamin Seebohm Rowntree believed that healthy and well-fed workers were also efficient workers and working closely with his father, he was involved with the reforms at the Rowntree's factory. Seebohm argued that employers who refused to pay decent wages should be put out of business as their existence was bad for the 'nation's economy and humanity'. Rowntree's work on social reform it was claimed made him the 'Einstein of the Welfare State'

3.4 The Architects of buildings on the factory site

3.4.1 Frederick Rowntree

Fred Rowntree was born in 1860 in Scarborough, the son of John Rowntree. His cousin, also John Rowntree, was a tea and coffee merchant and café owner in Scarborough and his uncle, William Rowntree, was a prosperous draper. The family were Quakers and were related to the chocolate manufacturers.

3.4.2 Frederick Rowntree was educated at Bootham School, York and was articled to Charles A Bury of Scarborough from 1876 to 1880; thereafter he was an assistant to Edward Burgess in London and a clerk of works in Leicestershire until 1885 when he set up an independent practice in Scarborough. He moved office to London in 1890, but in the same year entered into partnership with Malcolm Stark in Glasgow. The reason for the move to Glasgow is not clear, but the Rowntrees had Glasgow connections and Frederick Rowntree had married Mary Gray of the family of Gray, Dunn & Co (biscuit manufacturers) from Glasgow, who were also Quakers.

3.4.3 In 1900, the partnership of Stark and Rowntree was dissolved, after a long succession of near misses in national competitions and health problems had resulted in Stark descending into alcoholism. Rowntree relocated his practice to Hammersmith, London taking his sons, Colin and Douglas Woodville into partnership in 1912, the year he won the competition for the West China University at Chegtu, Szechuan.

3.4.4 During the First World War, Frederick Rowntree joined forces with Charles Spooner (1862-1938) and Arthur Joseph Penty (1875-1937) to form an enterprise in connection with the 'Friends War Victims Relief Committee' employing Belgian refugees in the prefabrication of buildings for re-erection in Belgium after the war.

3.4.5 Frederick Rowntree's work was predominately carried out in Glasgow, Yorkshire or southeast England. In the early days of his practice, apart from a number of competition entries, projects were generally involved with ecclesiastical buildings, schools or municipal building projects, later, when the practice had relocated to London, a large number of the commissions were for individual houses or country residences.

3.4.6 Very little of Frederick Rowntree's work was generated through industrial architecture and indeed apart from the involvement with the development of the Rowntree Cocoa factory site, the architect's projects were restricted to extensions and alterations to the factory of Gray, Dunn & Co. the biscuit company run by his wife's family.

3.4.7 Frederick Rowntree was architect for the Fruit Room and Gum Department (1891) at the Haxby Road site; the first buildings to be erected for the new factory and subsequent extensions, the Elect Block (1903) and the J R Memorial Library (1927)

3.4.8 Frederick Rowntree died in 1927.

3.4.9 W H Brown

W H Brown was the company architect for Rowntree & Co Ltd during the period following the initial development of the single storey buildings on the site; he was a member of the Manchester Society of Architects and also had a structural engineering background.

3.4.10 W H Brown was responsible for the design and erection of two important buildings on the site, the Melangeur Block Extension (1906) and the Almond Block (1907) built using Hennibique's Patent Ferro-Concrete system for foundations, columns, beams, floors and staircases.

3.4.11 W J Swain

W J Swain was appointed architect to the Cocoa Works in 1908. In 1910 he commenced the erection of the Almond Block Extension at the factory utilising a reinforced concrete frame construction patented by him, the cross brace or Lattice truss system, which was then adopted on a number of contracts for new buildings around the site.

The construction of the lattice truss before covering with concrete

3.4.12 Following the erection of the Almond Block Extension, he was further responsible for the design and erection of the New Dining Block (1913), the Office Block (1914), the Office Block extension (1916), the Packing Room extension (1915), the Engineering Workshops (1921), the Bonded Warehouse (1921), the Card Box Mill (1921), the new Gum Warehouse (1923), the Extract Blocks and the Extract Warehouse, and supervised the building work for the Joseph Rowntree Village Trust.

3.4.13 W J Swain left the York factory site in 1930 and relocated to the company's London offices where he continued to be available as Consulting Architect to the Rowntree's companies and also became Architect and Manager to one of their associated companies, Proprietary Buildings Ltd

3.4.14 W J Swain was succeeded by S Scarr as head of the building department at the Haxby Road site, but the period of intense growth had passed and through the 1930's up to the early 1990's very little substantial development took place on the site, the most significant building works being the extension to the Cream Packing department (1936), the Cream extension and Gum Department extension (1938) and the new Office Block (1970).

3.4.15 W J Swain died in 1936.

3.4.16 SDA Jackson & Calvert

Jackson and Calvert were formed in 1932 and operate from an office based in Harrogate. During the 1990's the practice was employed by Nestle UK to design some of the most recent large buildings on the Haxby Road factory site including the new Elect Block (1990) and the Kit Kat 5 block (1991).

3.4.17 Within the past decade the company have been absorbed into the SDA Partnership, a multi disciplinary practice in the UK covering architecture, project management, interior design and graphic design. SDA experienced rapid growth through the mid 1990's due to a series of mergers and acquisitions and the company now employs 100 staff in five offices within the UK, Eire and USA.

3.4.18 The headquarters of the organisation is based in Leeds with other offices at Harrogate (SDA Jackson & Calvert), London, Cork and California.

4.0 SIGNIFICANCE

4.1 Introduction

4.1.1 In order to develop policies for the site, it is necessary to establish and make judgements about precisely how and why the site and its component parts are significant.

4.2 What is significance

4.2.1 The significance of any site is to a large extent embodied in its fabric, the bricks and mortar, of which it is built, and can express itself in three main ways.

4.2.2 The first is the way in which the fabric can be read like a book. By studying the layout and design of the buildings, the history of their changing uses can be charted.

4.2.3 Secondly, the site can remind us of people, events and activities that cannot be seen today. The names of the buildings, their historic numbering and activities link the manufacturing processes of today to the past, and an age when production was labour intensive. Although we cannot see the original machinery or the stations for the overlookers, we know that this was how the buildings were used.

4.2.4 Thirdly, the site stirs our senses and imagination. The drama of the skyline approaching the site from the City of York and the south reminds us that for many years, York and the confectionery industry have been synonymous and that the manufacture of chocolate and confectionery, has, in the past given employment to a significant percentage of the city's working population. Rowntree's Cocoa Works factory is the last vestige of that once great, industrial period in York.

4.3 Key themes of significance

4.3.1 **The Victorian Era 1837 – 1900**
The introduction of Elect Cocoa in 1887 brought about a change in fortunes for the company and an expansion in trade.

- The Haxby Road site was purchased and the factory constructed to designs by Fred Rowntree, a respected architect and distant relative to the Rowntree family
- Rowntree & Co began transferring operations from various sites in the city to one purpose built factory site
- The Rowntree family were aware of the insanitary conditions and poverty that many of their workers endured at home and set out to provide good facilities at work
- Main vehicle access in to the site was from Wiggington Road with a footpath from Haxby Road

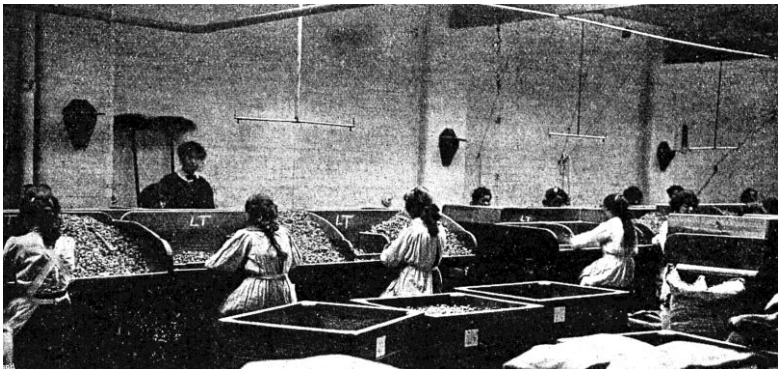
Buildings erected on the site during the period 1890 – 1900 were as follows:

1890 – 1892 FRUIT ROOM and GUM DEPARTMENT
Consisting of fruit, pulping and bottling rooms, starch and boiling rooms for gum, boiler house, warehouse, dining room, experimenting room and time office.

1895 ALMOND ROOM

1896 – 1898 MELANGEUR ROOM, OFFICE BLOCK, CREAM BOILING ROOM, BOX ROOM and CLEAR GUM DEPARTMENT
Consisting of storeroom, sugar room, almond paste room, joiners shop, packing room, loading room, melangeur room, extraction room and cool room.

The main corridor 1893 with patent glazed rooflights



The Gum Sorting Room

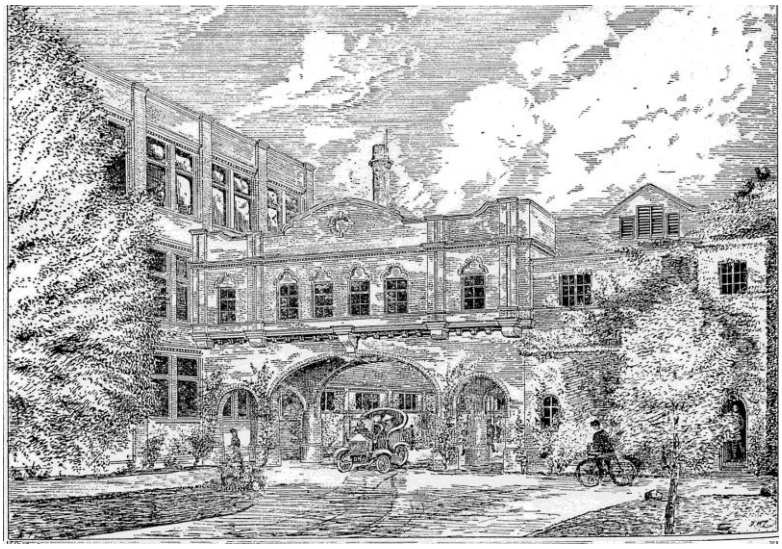
The buildings erected on the site during this period formed the backbone of Rowntree & Co. success as a gum and pastille manufacturer.

- Buildings were generally single storey with duo pitched roofs and of no notable architectural style

- Few of the buildings remain on the site, those that do, have generally been adapted to suit the changes in manufacturing techniques through the development of process engineering

- Buildings remaining from this period are obscured by later dated multi-storey factory block extensions, which envelop the older single storey development.

- The only remaining building from this era that has not been significantly altered externally and can be viewed from the site perimeter is the two storey Office Block. The entrance/west elevation of the building is visible but the building is built up against on the other three sides.



The two storey Main Office Block can be seen to the right, one of the few remaining buildings from the 19th Century that can be seen

- The interior of the office block with a central double height space and first floor concourse has recently been refurbished. The existing first floor layout of directors' offices remains and original features including the panelled pine doors and architraves to the offices and the ground floor panelling and ventilation ducts are still evident.

4.3.2 **The Edwardian Era 1901 – 1918**

The transfer of all production in York to the Haxby Road site took place in 1907 and the business was expanding rapidly with employment doubling in 5 years. The most notable buildings that define the Cocoa Works site were largely a product of this period as the company quickly grew to embrace and adopt modern construction methods.

- The Elect Block, subsequently demolished, was very advanced; being a prototype for multi storey steel framed buildings with a sprinkler system installed for fire prevention.

- Rowntree's in house architects and building department became responsible for the design and construction of new buildings on the site.

- The architects, WH Brown and WJ Swain both had previous experience of reinforced concrete construction and embraced that technology using licensed contractors in the early 1900's to provide the reinforced concrete frames. Whilst not at the cutting edge of this technology, the use of reinforced concrete for multi storey buildings was in its infancy in the UK.

- Rowntree & Co was a pioneer of social reform and industrial relations. As well as providing welfare and educational facilities at the factory the company also introduced a number of worker benefits including a pension scheme and holidays with pay.

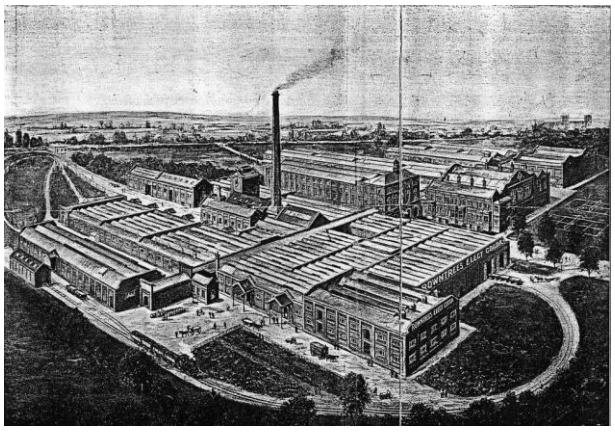
- The company's works magazine, CWM, was set up to inform employees of news and developments.

- Joseph Rowntree began the development of the garden village of New Earswick for workers, not exclusively from Rowntree, on low incomes. The Joseph Rowntree Village Trust was set up.

The main buildings erected on the site during the period 1901 – 1918 were as follows:

1900 – 1902	WOOD and CARD BOX MILL
1903	ELECT BLOCK
1904	CREAM ROOM BLOCK
1906	NEW MELANGEUR BLOCK
1907	ALMOND BLOCK
1909	BOX STORES rebuilt
1911	CREAM ROOM EXTENSION and ALMOND BLOCK EXTENSION
1913	NEW DINING BLOCK (off factory site)
1914	OFFICE BLOCK
1915	CREAM ROOM EXTENSION

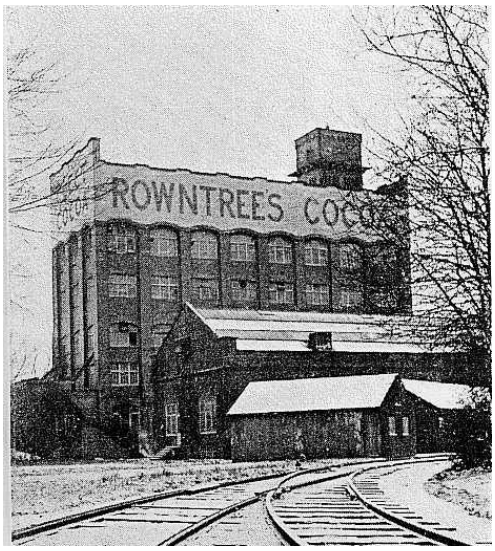
A number of alterations, additions and demolitions also took place during the period; these were of a minor nature.

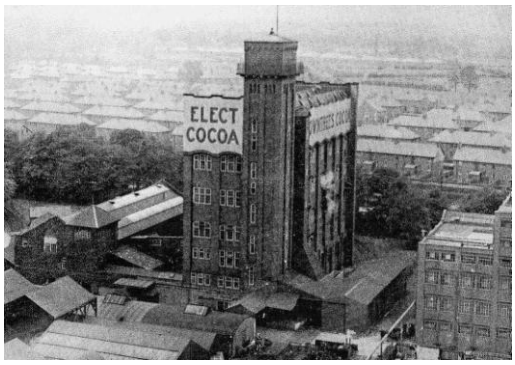


Birds eye view of the factory in 1900, the Gum Department and Packing Department can be seen in the foreground with the Main Office Block and Moulded Chocolate Department behind the boiler house chimney

From 1907 a range of cocoas, chocolate confectionery and fruit sweets were manufactured on the site, which utilised very different processes. Three distinct production centres developed, i) Elect cocoa manufacture to the north west of the site ii) pastille and gum manufacture to the central area of the site and iii) moulded chocolate/confectionery manufacture to the south and east of the site all linked to the packing, stores and warehousing areas by a series of internal corridors and external railway tracks.

- A number of the buildings constructed during this period have been demolished most notably the Elect Block designed by Fred Rowntree and constructed as a multi storey steel framed building and the Wood and Card Box Mill





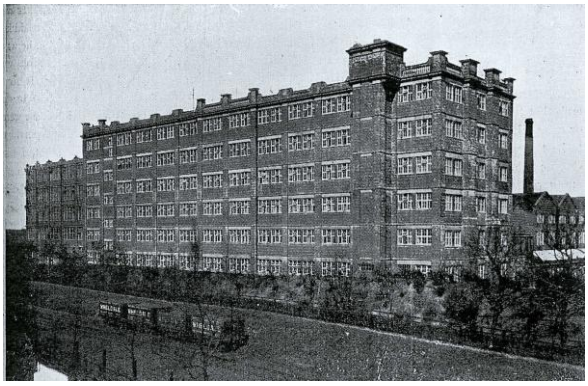
The Elect Block completed in 1903 to designs by Fred Rowntree. The tank at the top of the tower serves a sprinkler system for fire protection.
The steel frame can be clearly seen as brickwork external walls are constructed.

- The new Dining Block designed by W J Swain and built by Rowntree's in house building department using Swain's patented ferro-concrete system is not on the factory site and was purchased by the Nuffield Hospital and re-opened in 2004 as a fully functional hospital.

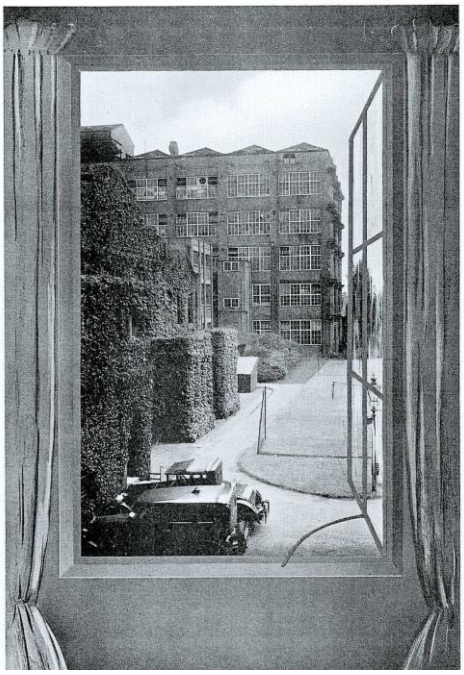
- The Melangeur Block and Almond Block including extension are the most significant buildings from this era in terms of their mass, construction and site location.

- The blocks are multi-storey, a significant move away from the single storey development of the site prior to this period, and form an enclosure to the

factory site on its southern boundary fronting the former Foss Branch Line and Hambleton Terrace.

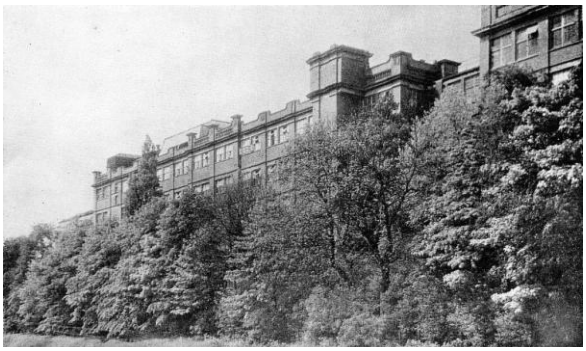


The Melangeur Block completed in 1906 to the extreme left with the new Almond Block finished in 1907.
Both buildings were constructed using patented reinforced concrete frames



The rear of the Melangeur Block completed in 1906 viewed from the Office Block built over the loading platforms.

The rear of the Almond Block with the Cream Room extension completed in 1915 in the foreground



The Almond Block and to the near right the Almond Block extension completed in 1911.
Trees around the perimeter of the site screen the lower floors.

- Production in these buildings involved goods being loaded in at the top floor and the manufacturing processes cascading downwards. In the Melangeur building the cocoa ‘cake’ produced from the roasting, winnowing and grinding of the beans, was mixed with sugar, cocoa butter, milk, vegetable fats and flavourings in melangeur machines which mixed the chocolate ingredients and helped to make the chocolate smooth; the chocolate was then tempered and moulded or used for coating.

- Fire risk and explosion was always a potential hazard and the buildings were designed to reduce the problem. The development of the Hennibique

system for reinforced concrete towards the end of the 19th century provided an ideal construction method for the confectionery industry with thin concrete slabs capable of taking large loadings and withstanding fire.

The 1907 Almond Block designed by W H Brown, the frame and structural elements built by Yorkshire Hennibique Contracting Co Ltd.

The 1914 Office Block designed by W J Swain and built by the Rowntree building department using Swain's patented cross brace or Lattice Truss system.

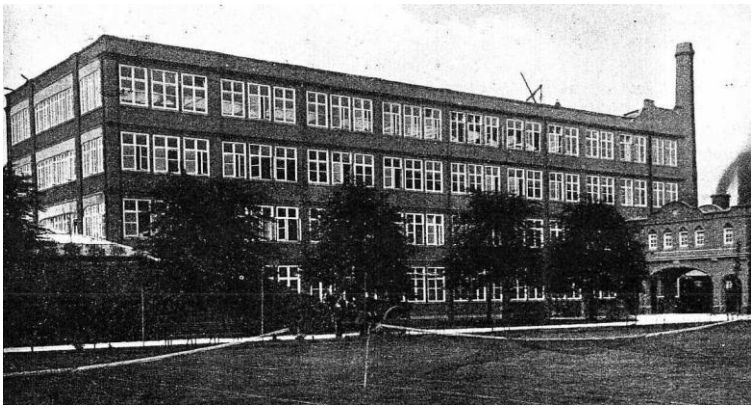
- *" It has been proved that ferro-concrete buildings are the best known class of construction to withstand both fire and earthquakes, because they are monolithic; so that there is no need for any of the employees at the Cocoa Works to be panic-stricken should ever a fire occur. Neither the floors nor staircases could give way under any heat that could be developed with the stock we hold."* W J Swain

- *"History invariably repeats itself, and having passed through what has been termed 'The Steel Age' we return to the 'Concrete Age' ……..."it is only within the last 15 years or so that its (ferro-concrete) true value was discovered for constructional purposes when combined with certain percentages of steel"* W J Swain

- *"Since we started doing this class of work with our own staff of York workmen, it has delighted me to see how enthusiastic they are, and how they vie with each other in getting the best results, which can at once be traced when we strike the wood sheeting. Some merriment was caused when we made the official test of the ground floor of the last large block of buildings, known as the Almond Block Extension……..There is little doubt that this class of construction will be even more extensively used in the future, as it is the best known fire-resisting construction, and has the advantage over all other building materials, that it increases in strength year by year.* W J Swain

- *"Our new starch stoves, which have just been completed on the roof of the old ones, give a good example of what we can do with ferro-concrete"* W J Swain

- *"Rowntrees is almost as famous for concrete as it is for Elect Cocoa"* W J Swain



The 1914 Office Block designed by W J Swain and built using his patented Lattice Truss system reinforced concrete frame.

4.3.3 Post Edwardian Era – Nestle acquisition

The growth of the business necessitated a new company structure, which was introduced in the 1920's. Rowntree was a marketing pioneer and its commercial success was the direct result of applied marketing methods and major advances in product development, branding and advertising. Numerous products, still well known today were introduced from the 1930's onwards.

- The company established a strong sales force and began the global acquisition and incorporation of companies abroad, which gathered a pace after the Second World War.

- The Second World War and the rationing of foodstuffs including chocolate affected the company and its performance.

- After a flourish of building work in the 1930's, significant investment in buildings for manufacture and production was curtailed until the late 1980's.

- Following the retirement of W J Swain in 1930, the company lost its pioneering attitude towards construction.

- The merger of Rowntree and John Mackintosh & Sons created multi-location manufacturing facilities and diversification into new product markets for Rowntree. Rowntree Mackintosh retained the York site as it's HQ but began a period of investment in new factories on greenfield sites around the UK. Manufacturing techniques had altered from the labour intense ways of the pre war eras and economic production lines were horizontal rather than the vertical systems developed in the multi storey blocks on the York site.

- The company wins a number of Queen's Awards for Export from early 1970s.

- The City intensified the pressure for better performance when the company became publicly quoted. Rowntrees had drifted into various non-core businesses which all demanded resourcing and there was a history of in

house activities – box making, tin making, printing, mould manufacture, engineering which were not really company competencies. Whilst being great marketers, the company had become a high cost business.

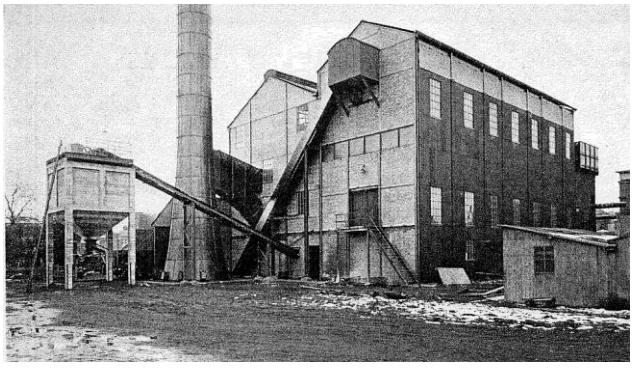
- Several peripheral businesses sold (moulds, engineering) in the mid 80's and the company starts to reduce employee numbers in over manned factories.

- Distribution by rail stopped.

Buildings erected on the site during the period 1919 – 1999 were as follows:

1921	ENGINEERING WORKSHOPS, BONDED WAREHOUSE and NEW CARD BOX MILL Consisting of erecting shop, tinsmiths, blacksmiths, stores and experimental room
1923	NEW GUM WAREHOUSE
1927	JR MEMORIAL LIBRARY
1932	THOMPSON BOILER HOUSE
1935	JOSEPH ROWNTREE THEATRE (off factory site)
1936	MOULDED CHOCOLATE BLOCK and CREAM PACKING EXTENSION
1938	CREAM BLOCK and GUM EXTENSION
1955	OFFICE BLOCK EXTENSION and RESEARCH LAB.
1957	MACHINERY STORE EXTENSION
1961	EXTENSION TO THOMPSON BOILER HOUSE
1962	MOULD WASH PLANT
1967	MILK PLANT EXTENSION
1968	OFFICE BLOCK
1969	OFFICE BLOCK
1978	OFFICE BLOCK EXTENSION
1985	AUTOMATED WAREHOUSE
1986	KIT KAT 4 PLANT

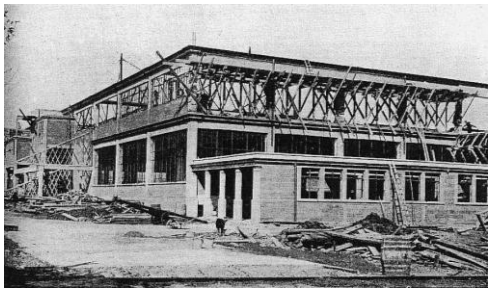
A number of the older buildings on the site have been demolished to make way for the new, larger, single storey production lines and warehousing. Buildings demolished include the Bonded Warehouse, the Gum Warehouse and extension, the Thompson Boiler House and extension and various small stores.



The Thompson Boiler House built in 1932 to replace the boiler house located near to the Moulded Chocolate Department. The boiler house was subsequently demolished to make way for the Kit Kat 5 building in 1991.

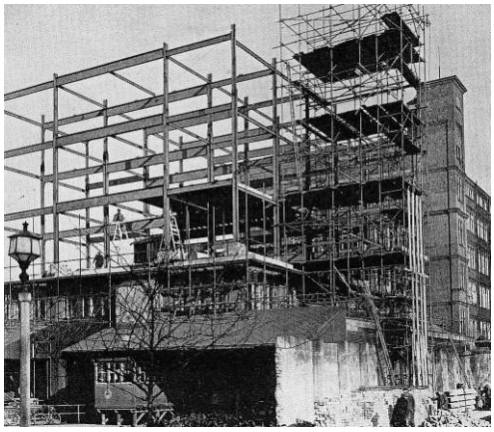
- Buildings of interest from this era include the multi-storey Cream Block and extension, the JR Memorial Library, the Card Box Mill and the Joseph Rowntree Theatre, the only listed building that was part of Rowntree's buildings portfolio.

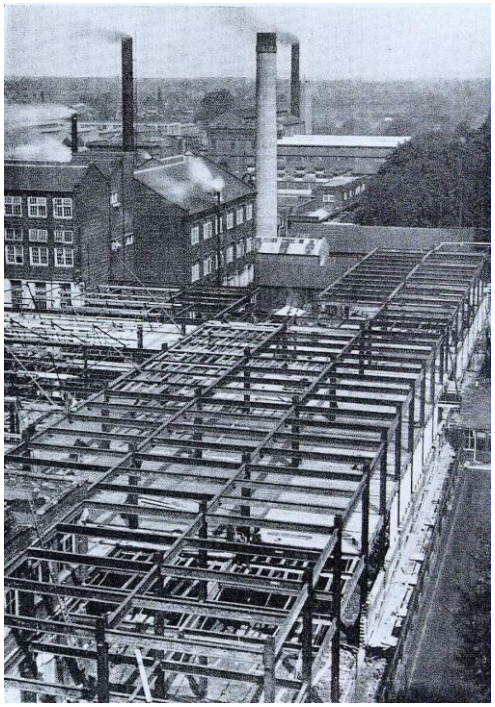
- The Gum Warehouse and Card Box Mill were the last buildings on the site designed by W J Swain using reinforced concrete. The Gum Warehouse was subsequently demolished to make way for the construction of the Kit Kat 5 building.



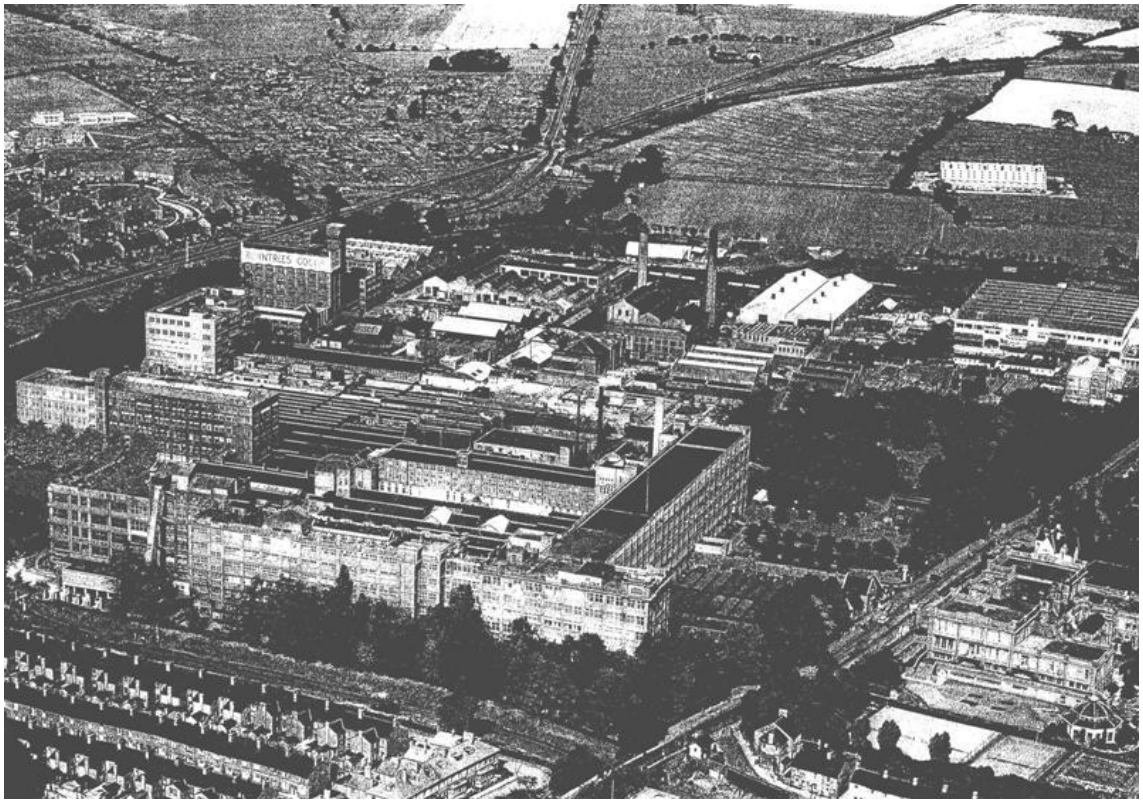
The Card Box Mill, one of the last reinforced concrete buildings to be erected on site.
The building was well lit with patent glazed north lights and large expanses of windows.
The numbers of staff employed in the Card Box Mill were more than employees on the Cocoa Works site in 1892.

- The Cream Block and extension and Office Block extension are erected with steel frames enveloped in traditional masonry construction.





The Office Block extension (above) and the Cream Block multi storey extension are built using steel frames, the first major buildings on site to be erected following the retirement of W J Swain.



Aerial views of the Haxby Road factory in 1956 (top picture) and 1963 (bottom picture)

4.3.4 **The Nestle developments 1988 – onwards**

Nestle SA buys out Rowntree Plc and the management principles are radically overhauled, hierarchies are condensed and the structure is moulded to a leaner, flatter system that can react quickly and adapt to variations in the production requirements.

- Nestle invest large amounts of capital in new single storey production facilities, warehousing and automation. To achieve space on the site for the new buildings a number of the old departments are demolished and areas cleared.

- Automation alters the work patterns and the number of employees reduces dramatically from 10,000 in 1995.

- The Haxby Road factory is competing, not only with external competitors for market share, but also with sister factories that make similar products. The factory develops its niche in its ability to handle complexity and large volumes.

A significant amount of invested has occurred at the Cocoa Works since the company was bought out by Nestle, this has included investment in new production facilities and processing lines, buildings erected have included:

1990	NEW ELECT BLOCK
1991	COCOA BEAN PROCESSING PLANT and PRODUCT TECHNOLOGY CENTRE
1992	POLO MINT PLANT
1993	KIT KAT 5 PLANT

Production techniques have changed with the introduction of automated lines, the use of labour intensive manufacture is outdated. Automation makes the lines run faster and gives the company ability to handle complexity and large volumes to make the factory competitive with sister factories within the Nestle group and other manufacturers.

- Location of new development on the site is ad hoc and is governed by available space

- There is no generic pattern or theme to the design of the new buildings

- Scope for any further production development is limited to extension to new facilities unless older buildings are removed.

- Production is automated and no longer labour intensive

- The multi storey older buildings on the site are no longer viable for confectionery manufacture; the options are i) to retain and find a new use or ii) demolish and free up space for potential production facilities

4.4 Significance of individual buildings or groups of buildings

4.4.1 The buildings on the site have been assessed for their significance. The following plan illustrates the significance and what this value level means in the national and local context.

4.4.2 The levels of significance are broadly categorised as follows:

Outstanding Interest
These buildings are of value in the national context and are fundamental to the history of York and its importance as a centre for confectionery manufacture. Very high sensitivity to fabric alteration or removal.

Great Interest
These buildings are of value in the regional context and are an important part in the history of York and its importance as a centre for confectionery manufacture. High sensitivity to fabric alteration or removal.

Some Interest
These buildings are of local value and form part of the character of the area. Sensitive alteration to building fabric; justification for removal.

Neutral Interest
These buildings are of value only in the context of the site.
Flexible approach to alteration or removal.

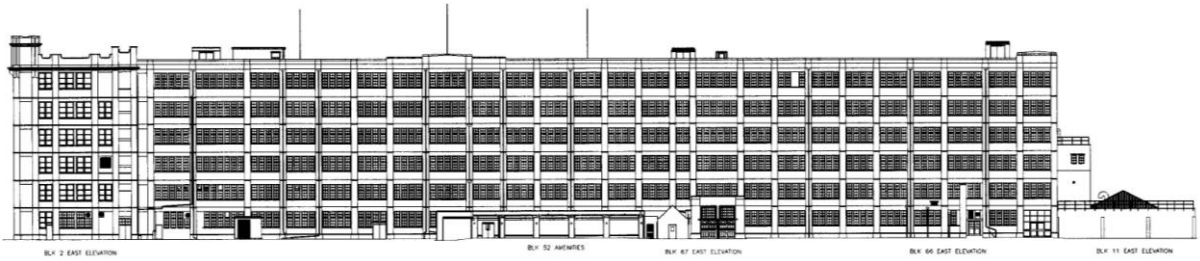
Unless identified, buildings on the site are of no particular significance

Significance of buildings on the site

4.4.3 There are no buildings within the factory complex that are significant, either nationally or regionally in terms of their architectural style or their historic interest. The most notable buildings on the site, of some interest, are predominately the substantial, multi storey blocks, which form a distinctive landmark that defines the Cocoa Works when approaching from York. The buildings, the Almond Block (1907), the Almond Block Extension (1910), the Melangeur Extension (1906) and the new Cream Block and Extension (1936 & 1938) are of importance because of their prominent positions and grouping.

The south elevation indicating the Melangeur Block to the left and the Almond Block and Extension to the right. The decorative link between the Melangeur Block and Almond Block was destroyed by fire in 1992

The south elevation to the disused Foss Branch Line and overlooking Hambleton Terrace as it is currently with the gap where the factory fire destroyed the section of building in 1992



The east elevation to Haxby Road indicating the end of the Almond Block Extension to the left and the Cream Block. The Amenity building at the front is a later addition.

4.4.4 Buildings of neutral interest identified have been recognised for their site importance. Areas of the former Gum Department, Packing and Loading Departments, Cream and Experimental Offices are all early phases of the factory buildings that can be identified back to about 1900. The building forms and roofscapes are recognisable from early bird's eye views or photographs. No. 4 Extract, the current Post Office, is highlighted as one of the few stand alone buildings little changed externally since its construction and the Card Box Mill is recognised as the last reinforced concrete building erected on the site by W J Swain, the most prolific of all Rowntree's architects. The Administration Office Block (1914) built over the loading platforms is a dominant building, built using Swain's patented reinforced concrete frame system, but is of little interest other than for its form of construction.

4.4.5 Also identified as buildings of neutral interest are the former two storey Office Block, built between 1896-98, one of the first buildings on the site, which although recently refurbished at ground floor level as 'The Bear Pit' still retains the first floor office layout used by the first directors and the J R Memorial Library, a small single storey building with two storey mid section, fronting directly on to Haxby Road, which is the only building left on the Cocoa Works site which can be confidently attributed to Fred Rowntree.

4.4.6 Until the latter part of the 19th century there was no knowledge of reinforcing principles for concrete and satisfactory methods of calculation were only developed towards the end of the century. An American, T. Hyatt, carried out experiments on reinforced concrete beams and was amongst the first to understand the basic principles of reinforced concrete construction; he published his discoveries in London in 1877, but his patents did not receive much attention.

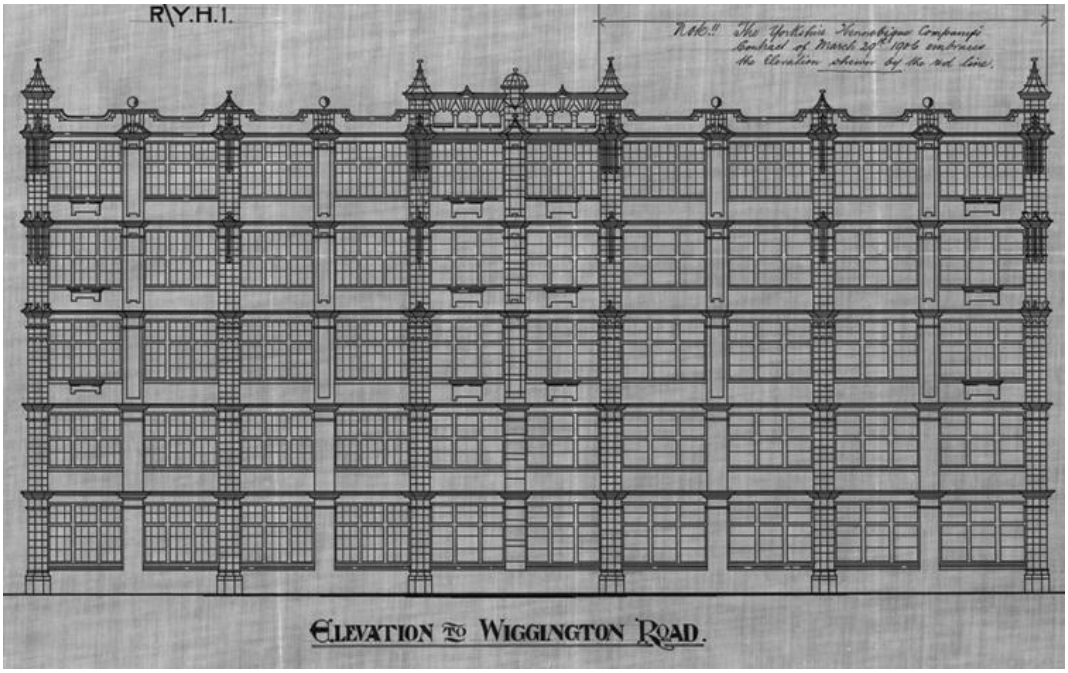
4.4.7 It was not until engineers such as Francois Hennibique (1824 –1921) constructed the first building with a complete reinforced concrete frame; and set up a branch office in London in 1897 under the charge of L G Mouchel and Partners Ltd, to design structures on the Hennibique system of patents that interest in reinforced concrete buildings in the United Kingdom grew.

4.4.8 At the beginning of the 20th century, most reinforced concrete work was carried out by specialist firms of this sort, as the architects and structural engineers had not acquired sufficient theoretical and practical knowledge of the new method of construction to enable them to prepare designs with confidence; such systems were adopted for the Melangeur Block and the Almond Block. These buildings were at the forefront of industrial multi storey architecture of the era. By the time the Almond Block Extension was constructed, Rowntree's architect W J Swain was sufficiently competent to design the reinforced concrete frame and had patented his own reinforced concrete frame design.

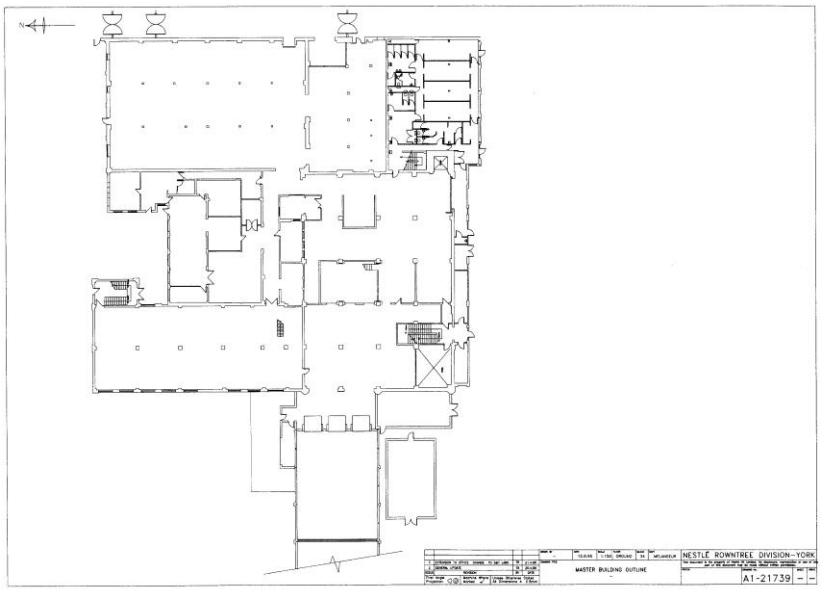
4.4.9 The new Melangeur Block 1906

Built in 1906 using a patented, licensed reinforced concrete frame by the Yorkshire Hennibique Contracting Co Ltd. A sixth floor was added in 1962

The ground floor of the block is dedicated to servicing with an abundance of pipework evident



The first phase of the proposed Melangeur Block (4 bays) was constructed as the note on the drawing, the remaining 6 bays that would have extended the elevation up to the Main Office Block were never constructed and a series of poorly designed extensions were built in the 1970's



Ground floor plan of the Melangeur Block (Building 34) The service corridor at ground floor level obscures the original building frontage; extensions to the west elevation have altered the ground floor arrangement

West and south elevations of the Melangeur Block. The later extensions can be seen to the left of the original block.

The Melangeur Block built for the melangeur processing of chocolate and still used for that purpose. The building was constructed and completed in 1906 to designs by the Rowntree company architect, W H Brown.

The building was originally designed with 10 equal bays to the Wiggington Road elevation, which would have terminated at a junction with the Main Office Block, but was reduced in size to a 4 bay building to this elevation prior to commencement of construction. The building is 75 feet long, 115 feet wide and was originally 75 feet high. It was designed such that an additional floor could be added and in 1962 a further floor was added. The block is multi storey with 6 floors above ground and a basement.

The floors, beams, stanchions and lintels were all constructed in the Hennibique system of reinforced concrete by the Yorkshire Hennibique Contracting Co Ltd. Floor thicknesses, varying between 5 inches thick for the ground floor slab to 4 inches for the fourth floor slab are capable of bearing superimposed loads of 7.5 cwt/sqft and 3 cwt/sqft respectively. The floors are supported on a grid of reinforced concrete columns laid out at approximately 20 feet centres

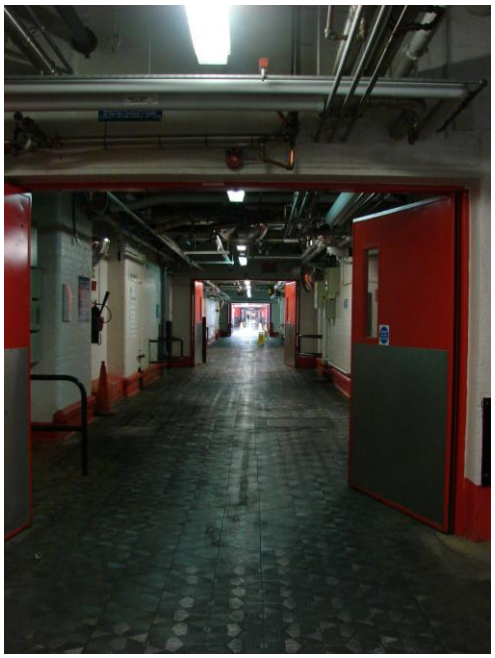
The building is loosely designed in the Renaissance style with walls constructed of Castleford smooth red bricks built in English Garden Wall bond with York stone ashlar dressings and mouldings and an asphalt roof finish laid on a reinforced concrete roof deck behind a brick parapet. The elevational treatment to Wiggington Road is more decorative with an alternating pattern of brick angled pilasters and projecting brick piers with brick relief panels, above the second floor to the four bays. A moulded stone projecting stringcourse runs continuously above plain lintels at each floor level of the original building. The brick angled pilasters have dressed ashlar block courses located immediately above the level of the adjacent window cill and an intermediate stone block course. Decorative moulded stone intermediate capital details with fluted sections and 3 tympanum heads are built into the pilasters at the third and fourth stages. The decorative stone mouldings to the pilasters at the fifth stage are fluted only. First to fourth floors have symmetrically arranged patterns of 3 windows to each bay with brick mullions between and 6 over 9 lights. The sixth floor is of simpler design with a small projecting coping. The south elevation is plainer with bays divided into a pattern of 4 windows with stone mullions between. The moulded stone projecting stringcourse runs continuous with the same detail to the Wigginton Road elevation. The window pattern reflects that on the west elevation. At ground level on the south elevation, an extension joins the building to the adjacent ablutions area. Extensions have been added at ground level and adjoining the building to the Wiggington Road elevation. At the rear, extensions join the block to further buildings that were formerly separate.

Brickwork repairs and repointing have been carried out to large areas of the west elevation. Many of the original windows are still in place, but some have been removed to accommodate services requirements. Horizontal and vertical cable trays are attached to the building to all elevations.

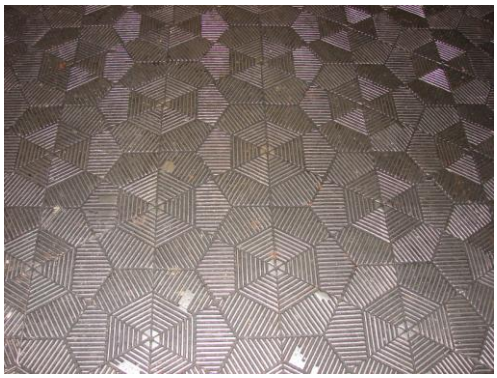
The two staircases, one at each end of the building, are constructed in reinforced concrete and the fireproof construction was originally lined with white glazed tiles with honey brown mouldings and plinth. A hoist abuts the staircase at the east end of the building.

4.4.10 The new Almond Block and extension 1907 – 1911

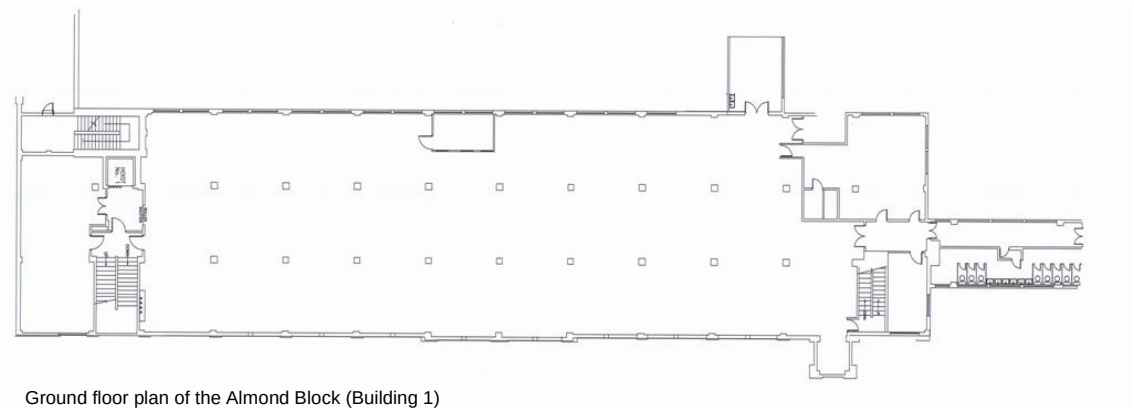
Built in 1907 using a patented, licensed reinforced concrete frame by the Yorkshire Hennibique Contracting Co Ltd. The extension was built in 1911 using Swain's patented reinforced concrete frame design.



The main corridor today, not strikingly different from the view of the corridor in 1893 still used as one of the main thoroughfares of the factory for the transportation of materials and product.

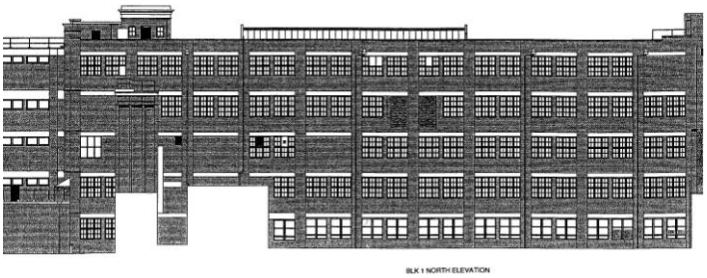


The steel plate tiled floors are taken up and replaced as part of a continual maintenance programme. Timber floors are still retained within the main production areas of the older factory buildings.

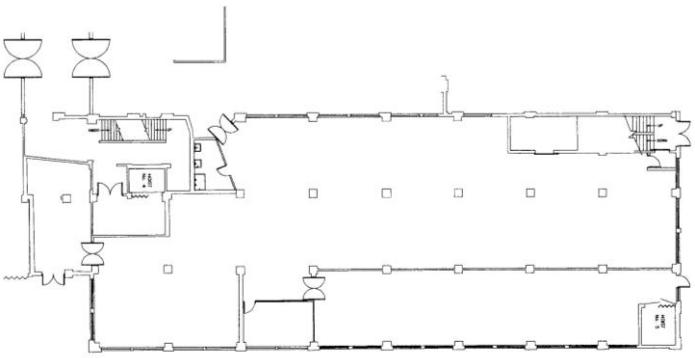


Ground floor plan of the Almond Block (Building 1)

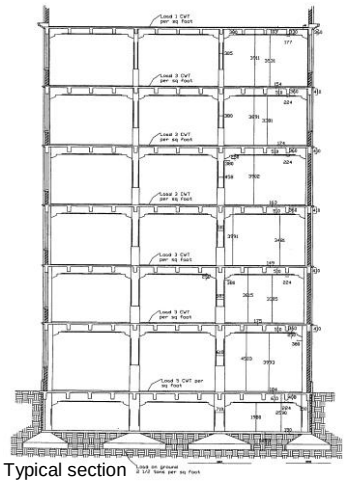
The Almond Block south elevation, access to the main corridor is through the set of double doors to the left hand side of the building



North elevation of the Almond Block, the ground floor abuts single storey areas of the factory

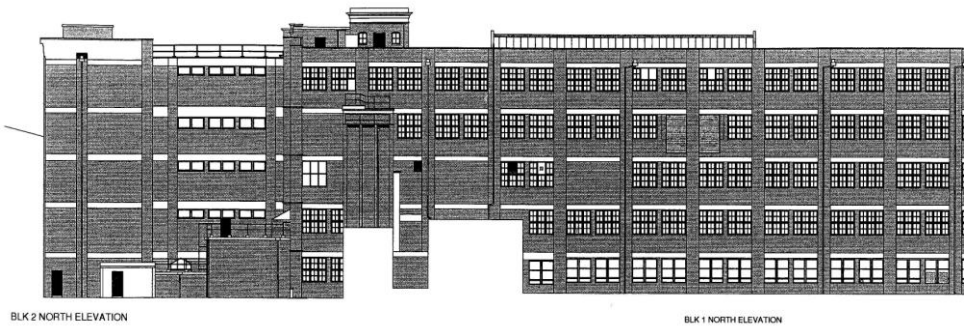


Ground floor plan of the Almond Block extension (Building 2)



Typical section

The Almond Block extension south elevation and below the north elevation



In 1907 the new Almond Block was under construction and by 1911, the extension to the Almond Block, designed by W J Swain was also underway. The original building is 240 feet long, 60 feet wide and 90 feet high. The extension building is slightly shorter in length at 200 feet. Although the buildings were originally designed for the

Like the Melangeur Block, the buildings were designed such that an additional floor could be added although this has not happened. The block is multi storey with 6 floors above ground and a cellar.

The floors, beams, stanchions, lintels and two bridge links of the Almond Block were all constructed in the Hennibique system by the Yorkshire Hennibique Contracting Co Ltd, the other construction works were undertaken by Rowntree's own building department. Floors generally are about 7 inches thick and are capable of taking loads up to 3 cwt/sqft. The building is connected to the old Almond Room on the ground floor by the main corridor and to the Melangeur block by a new corridor; a new corridor links the building to the Cream Room.

The Almond Block extension, whilst similar in dimensions and external appearance, was designed using Swain's patented Lattice Truss reinforced concrete frame system, which gives a slightly different appearance at the splayed column and frame connection. Both buildings use reinforced concrete columns, laid out in a grid at approximately 20 feet centres, which reduce in size as the building increases in height.

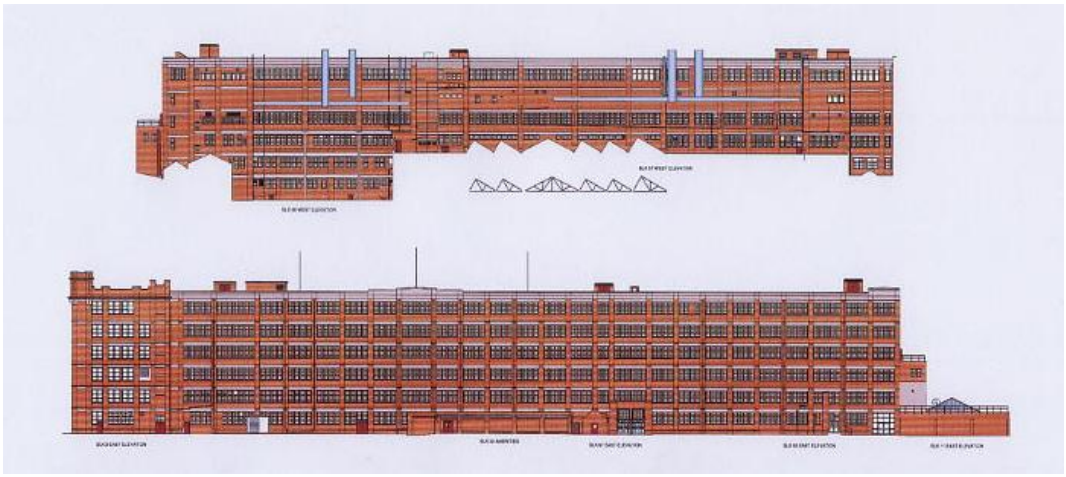
The buildings are plain in design with walls constructed of Castleford smooth red bricks laid in English Garden Wall bond with York stone dressings to the main south elevation. The elevational treatment is a series of projecting brick piers with brick infill panels. A moulded stone stringcourse runs continuously above plain lintels at each floor level. Simply moulded stone capitals and a moulded stone cornice complete the building at roof level below the brick parapet with stone projecting copings. The north elevations at the rear are plainer. The second to fifth floors of the Almond Block have symmetrically arranged two light mullioned and transomed windows, many of which are the originals installed. Opening fanlights and casements are arranged in each window and these were fitted with patented improvement casement sashes to allow the glass to be cleaned from inside and providing ventilation without draughts. The windows to the extension are of much simpler design and would appear to later replacements.

Each building has two staircases; one at each end, formed in reinforced concrete and the fireproof construction was originally lined with white glazed tiles with honey brown mouldings and plinth. The buildings have two electric hoists installed. The fire alarm system installed in the Almond Block was the largest single block installation in the country at the time with 152 detectors consisting of 7ft-6in steel bars with copper wire connected to terminals at each end, suspended in the middle of the wire is a sealed tube of mercury, a sudden rise in temperature expands the wire bringing down the contact points and sending a coded ring to the block fire board and a local board on the exact floor.

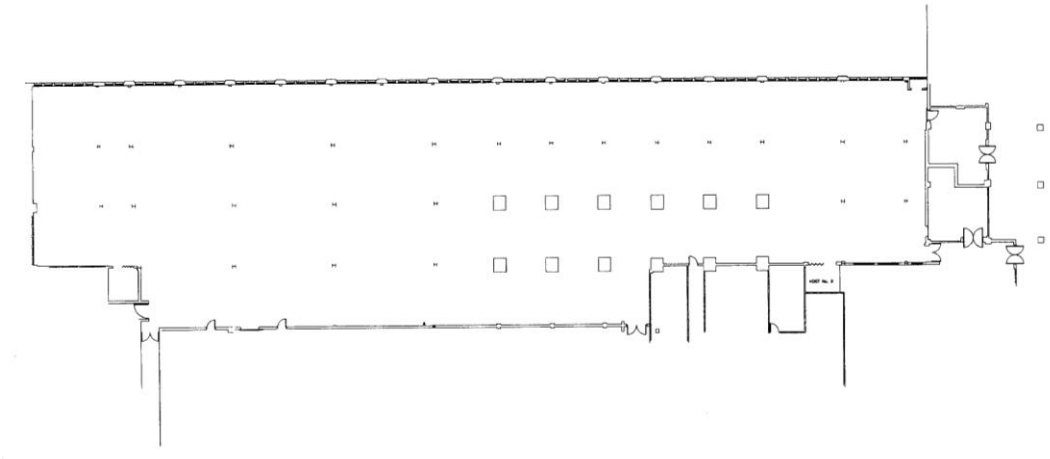
Armoured fire doors are installed to all openings. Special attention was made to the sanitary arrangements and all fittings were of the latest design.

4.4.11 The Cream Block and extension 1936 – 1938

The east elevation of the Cream Block and extension facing Haxby Road. A later dated single storey amenity block has been built in the position of the original entrance



Elevations of the Cream Block and extension



Ground floor plan of the Cream Block (Building 67)

The Cream Block and extension were built during the periods 1936 – 1938. The buildings are of a steel framed construction with red brick walls and exposed concrete lintels running between a series of slightly projecting brick piers, with a concrete roof and parapet. The steel frame grid is asymmetric with a central section set out at larger grid spacing. The buildings abut the two storey Cream Block (building 4) to the rear.

The building is 435 feet long overall, 60 feet wide and 85 feet high, built with 6 floors above ground. To the rear of the building are two projecting staircase and hoist towers. The formerly central entrance front of the Cream Block (building 67) is now offset because of the extension (building 66) built up over the former Employment Block. A large double set of doors provides access for personnel where building 66 abuts the Cream Block. A later replacement entrance door has been installed to the northern end of the front elevation and is of a modern detail. The main entrance to the Cream Block has been lost by the addition of the amenity building at ground floor level.

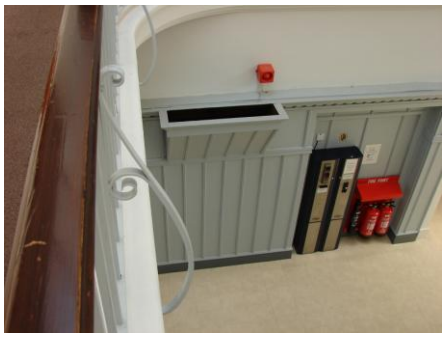
The building is plain in design and utilitarian with no significant architectural features. The block has symmetrically arranged two light transomed windows set between brick mullions to the Haxby Road elevation. To the rear the window pattern alters to suit function. Many of the windows are those originally installed with side hung opening casements.

Brickwork repairs and repointing have been carried out to some small areas to the front elevation. There are no major servicing intrusions to the front elevation, but the rear is punctured by large vents and has attached service ducting running horizontally across the building.

4.4.12 Buildings of neutral significance

4.4.12.1 The General Office (Building 31)

The General Office building constructed in 1896 originally providing accommodation for the directors. The building ventilation system provides ducted air from outside to a series of termination at ground floor level within the panelling.



The General Office building was one of the first buildings constructed at the Cocoa Works site in 1896. The two-storey building, originally built to provide office accommodation for the administrative staff and directors of Rowntree & Co, is now used as an informal catering area with meeting rooms and offices at first floor level.

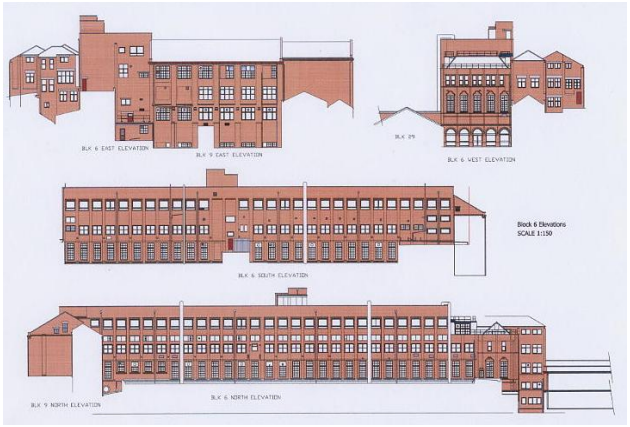
The building is designed as a central double height space with a circulation balcony overlooking the ground floor and two storey parallel side wings housing individual offices at first floor. The building is built with loadbearing red Castleford brick masonry construction in English Garden Wall bond with a raised decorative, scrolled, gabled front entrance brick parapet with York stone dressings concealing a duo pitch slated roof with lead cored roll ridge and patent glazing inset within the slating. The two side wings have duo pitch gables with stone copings and slated roofs. Decorative cast iron rainwater hoppers collecting water from the valley gutters are stamped '1896'

The elevation fronting Wiggington Road has a bullnose brick stringcourse immediately below the first floor window cill level and a lead covered corbelled brick with projecting bullnose courses, which runs continuous above the ground floor window heads. There are two square projecting bays to the right of the main entrance; the right hand bay is two storeys high and has been raised after the original construction. To the left of the main entrance, a projecting block with wooden entrance door and lead covered flat canopy provides staircase access to the first floor. The centrally located front entrance doors are approached up a temporary ramp built over the original steps.

The central building has 3 large symmetrical timber fixed small paned leaded lights with transoms and mullions; the central window has stained glass panels. Other fenestration is a mix of original small paned timber windows and modern replacements. Extensions join the office block to further buildings to the rear and side.

Internally, the ground floor walls are timber panelled with angled ventilation ducts, housed within the panels, terminating at high level. The balcony has simple cast iron spindles with scrolled brackets and a timber handrail. Six panel pine doors with matching architraves and frames lead off to the office rooms.

4.4.12.2 Factory Offices and Quality Control Labs (Buildings 6 & 9)



The original uses of the buildings is uncertain, but the west elevation of Building 6 can be clearly identified on birds eye views of the factory in 1900, Building 9 is of later construction

The actual dates of construction and original uses of this group of buildings are uncertain, however, the building that forms the west end of building 06 can be clearly identified in birds eye view drawings of the factory site in 1900. Likewise the remaining section of building 06 is also visible on the same view making this building one of the earliest on the site. Building 09 is of slightly later construction, but can be seen in early 1900's photographs.

The buildings are constructed with loadbearing red brick masonry construction in English bond with duo pitched slated roofs. The original double duo pitched roofs to the main section of Building 06 have been removed and replaced with a flat roof behind a brick parapet some time after 1956. The buildings are multi storey and are abutted by various other buildings and extensions.

The west facade of Building 06 is divided into 5 bays with large, arched topped window and door openings at ground floor; doors and windows in these openings are all modern replacements. At first floor level, the windows are small paned lights set into square headed openings with decorative brickwork over; the windows at this level may be original; at second floor the openings are plain, square with brick mullions dividing the openings. A brick corbelled stringcourse runs around the building above the ground floor windows and similar bullnose details run immediately below the window cills at first and second floor levels. The north and south elevations of Building 06 are plain in design and utilitarian with no significant architectural features having a regular pattern of square headed windows set between brick piers; most of the windows are modern replacements. These elevations have large service ducts running vertically attached to the building.

4.4.12.3 Wiggington Road Office Block (Building 30)

South elevations of WROB with detail of front entrance and first floor plan of building

The first part of the office block was built over part of the loading bays in 1914 to accommodate the growing number of administrative staff and the engineering and marketing departments. The building was designed by W J Swain.

The first phase of the building was 178 feet long and 64 feet wide constructed utilising a reinforced concrete frame system over the extension to the loading platform. The grid spacing of the columns along the elevation varied from 15 feet at the east end of the block to 20 feet at the west and this may have been due to building over the existing platform. The building was extended in 1916 with the introduction of further sanitary facilities and was further extended in 1955 to the building that is seen today. The final phase of the building was constructed using a steel frame with the columns encased; the grid for this section of the building is 15 feet east/west and up to 27 feet north/south. The block is multi storey with 6 floors above the ground.

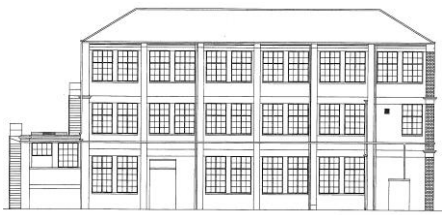
Access to the offices was originally made from the staircase at the north west corner of the General Office (Building 31) connected by a bridge spanning the main drive. A reinforced concrete staircase from the building led down to the railway platform. The first phase building has floors constructed of reinforced hollow concrete blocks similar to the Dining Block to deaden sound.

The building is plain in design and utilitarian with no significant architectural features. The triple duo pitched roofs to the original block have been removed and replaced with a flat roof set behind a brick parapet. The extensions are constructed with flat roofs. Walls are constructed in red bricks with corbelled brick string courses and exposed concrete lintels over window openings. A two storey main entrance area was built as part of the 1955 extension with the ground floor semi circular roof supported off 10 circular brick columns set on chamfered painted concrete bases. The main entrance screen and doors are recessed below the projecting roof and balcony.

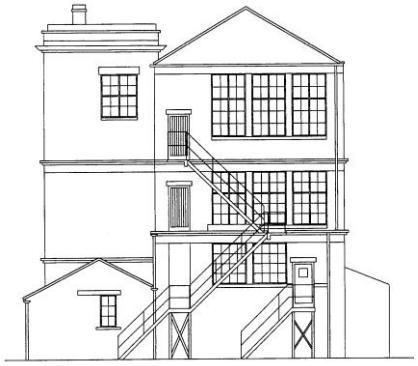
Windows are divided into six sections with transoms and a central mullion, the middle lights being side hung casement openers. Most of the original windows still remain in tact.

4.4.12.4 Post Office (Building 61)

East elevation



West elevation

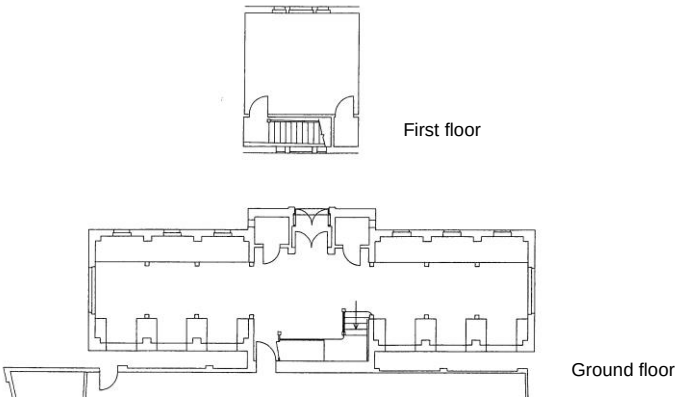


North elevation

South elevation

This building has not been reviewed, but was originally built as Extract Building 4 and is currently used as the company post office. The building is stand alone and has not been significantly altered externally since its construction. The building was designed during the period when W J Swain was the company architect and it is assumed was built utilising a reinforced concrete frame with reinforced concrete floors and lintels, the whole enveloped in brickwork. The small roof is duo pitched with hipped ends. The small paned windows are assumed to be original. A later external staircase has been added to provide an escape route in case of fire.

4.4.12.5 Joseph Rowntree Library (Building 76)



The Joseph Rowntree Library was built to commemorate the life of Joseph Rowntree, previously the company library had been housed within the factory and this provided an opportunity for a small, purpose built building. The library was designed by Fred Rowntree and completed just before his death in 1927. The building is a small brick built construction approximately 70 feet long and 20 feet wide with a projecting front entrance on to Haxby Road with a set of double panelled timber doors. From the rear, a personnel door provides access to the subway, which crosses below the road.

The building has a duo pitched roof with raised central section finished in slate. Windows are small paned and are original.

The ground floor houses a series of book shelves and provides access to the small area of first floor located over the entrance area via a timber staircase with timber panelling and handrail. The building has been recently refurbished internally.

4.4.12.6 Card Box Mill (Building 58)

This building has not been reviewed, but is one of the last buildings designed by W J Swain, on the Cocoa Works site, in 1921 and is constructed utilising a reinforced concrete frame. The building has large areas of fenestration to the elevations and a roof consisting of a series of duo pitched north lights with patent glazing providing further light into the internal space. The main entrance is on the south elevation and is covered by a patent glazed canopy supported off a series of columns.

The building is currently vacant.

4.5 Townscape and landscape

4.5.1 Site location

The site lies approximately two miles to the north of the city centre sandwiched between the residential areas of Clifton to the west, Huntingdon and Heworth to the east with the garden village of New Earswick to the north.

The site is bounded to the west by Wiggington Road, the York Line railway running to the coast at Scarborough and post war semi-detached social housing, to the north by the company sports fields, to the east by Haxby Road and former Rowntree amenities buildings including the Dining Block, J R Theatre, Yearsley swimming baths, sports fields and some small, recent infill housing backing on to the River Foss and to the south the tight-knit terraces of Victorian and Edwardian housing.

4.5.2 Site description

The site boundaries are well defined and provide a strong framework for any future development. The mature trees immediately within the site perimeters to the south, west and east give the impression of a landscaped setting for the factory complex but in reality landscaping within the site has been eroded since the 1960's by the loss of the Rose Lawn, the bowling green, extensive tree planted areas to the east of the site and a predominant landscaped area to the south west corner between the former factory railway link and the Fosse Branch Line which has been taken up by car parking. None of the trees on site are subject to a tree preservation order. The site is very much an industrial setting with large areas of lorry and car parking and hardstanding.

Within the site, buildings are set out in a rectilinear manner, the dense massing of the earlier factory development to the south of the site transforming to large, singular function buildings to the north. Trees to the site perimeter screen the lower building masses and hide the clutter of the industrial site. The buildings do not present a strong, unified composition; the site has expanded ad hoc utilising free land to the north rather than evolved with a cohesive plan in mind. There is no shared architectural language, even amongst the older buildings on the site; the buildings are utilitarian and designed to satisfy process requirements with

little flamboyance. Alterations, extensions and demolitions have been carried out purely for industrial purposes. Patrick Nuttgens had previously expressed his opinion that the Cocoa Works site possessed no buildings of quality unlike the Terry's factory to the south of the city of York.

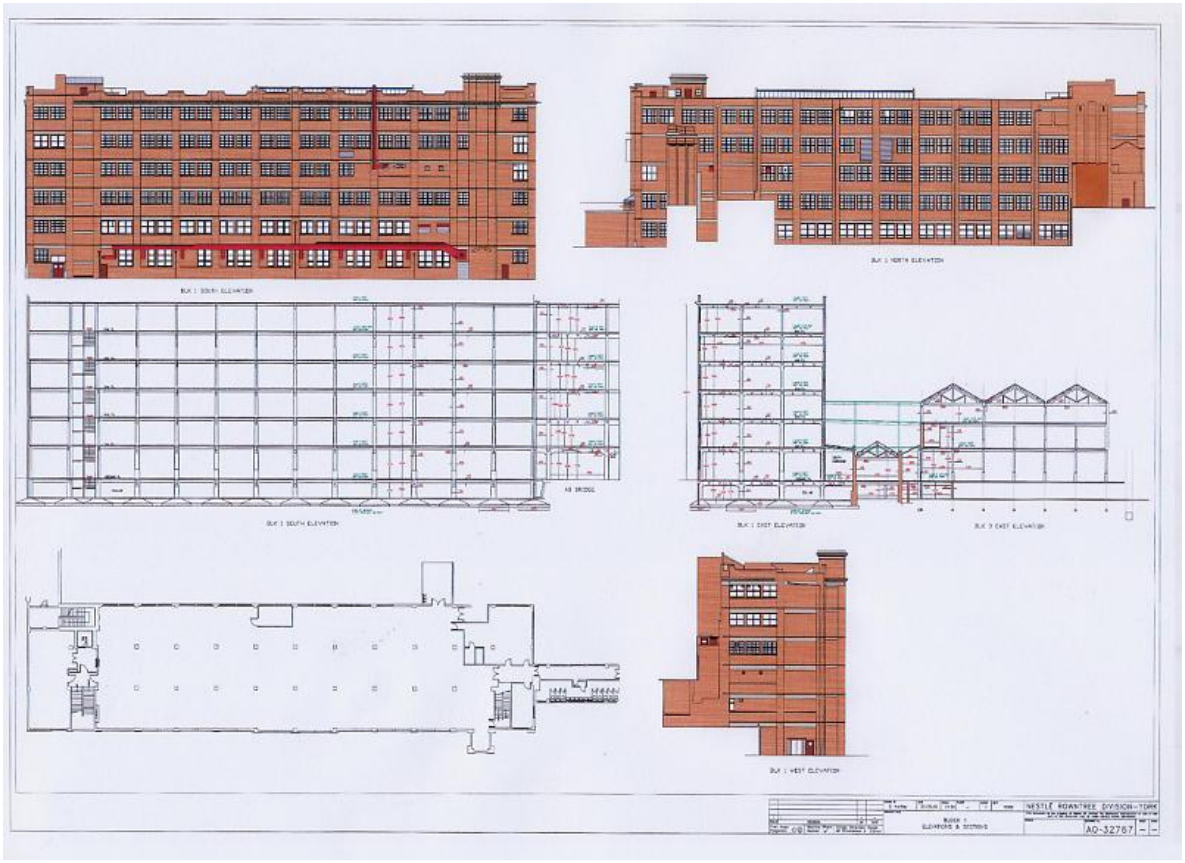
There are a number of entrances in to the site. The main visitor entrance is off Haxby Road outside the 1970's Office Block and is insignificant, other entrances off Haxby Road afford access to individual buildings or have been closed. Off Wiggington Road, the southern entrance provides general access whilst the wide northern entrance provides access for lorries to the distribution areas and parking.

4.5.3 **Site views**

The height and mass of the multi-storey 1900-1930's buildings are visible from the south east approach via Haxby Road from the city. Views are of the top storeys of the Almond Blocks and Cream Blocks sitting above a wooded fringe of trees set relatively close up to the buildings on the southern boundary. This sense of enclosure diminishes as the space opens out to provide an impressive setting for the Cream Block before the 1970's office development impedes views of the factory and the inside of the complex reveals itself only through the breaks in the trees at the entrances off Haxby Road.

From the south west, the Office Block and former Gum Department rise above the tree lining, but there is no impression of enclosure. Glimpses into the site through hedges and trees suggest a large factory development and this is confirmed at the main goods entrance where the wide access provides views across the complex.

From the north, the views are experienced at much closer quarters. From within a relatively rural, village setting one happens upon the factory rather than being aware of it.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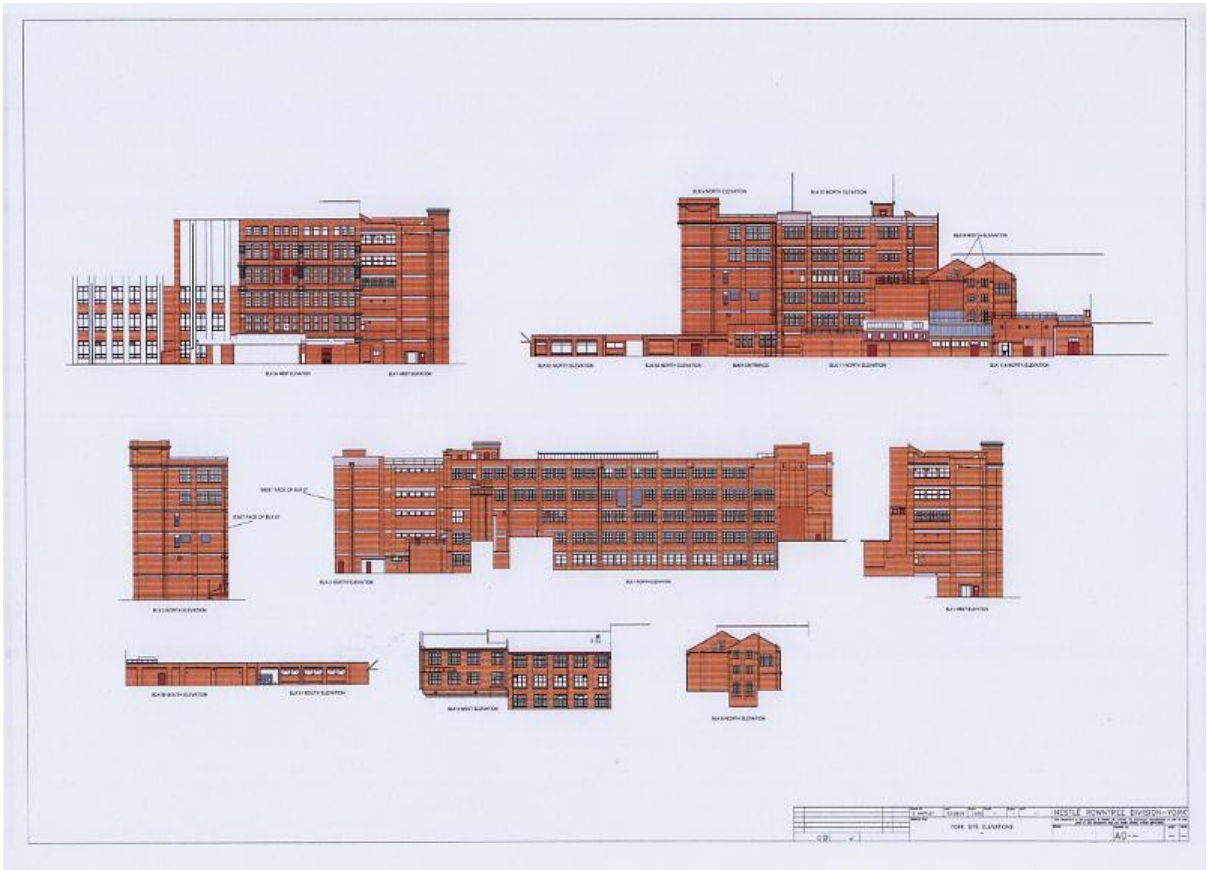
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