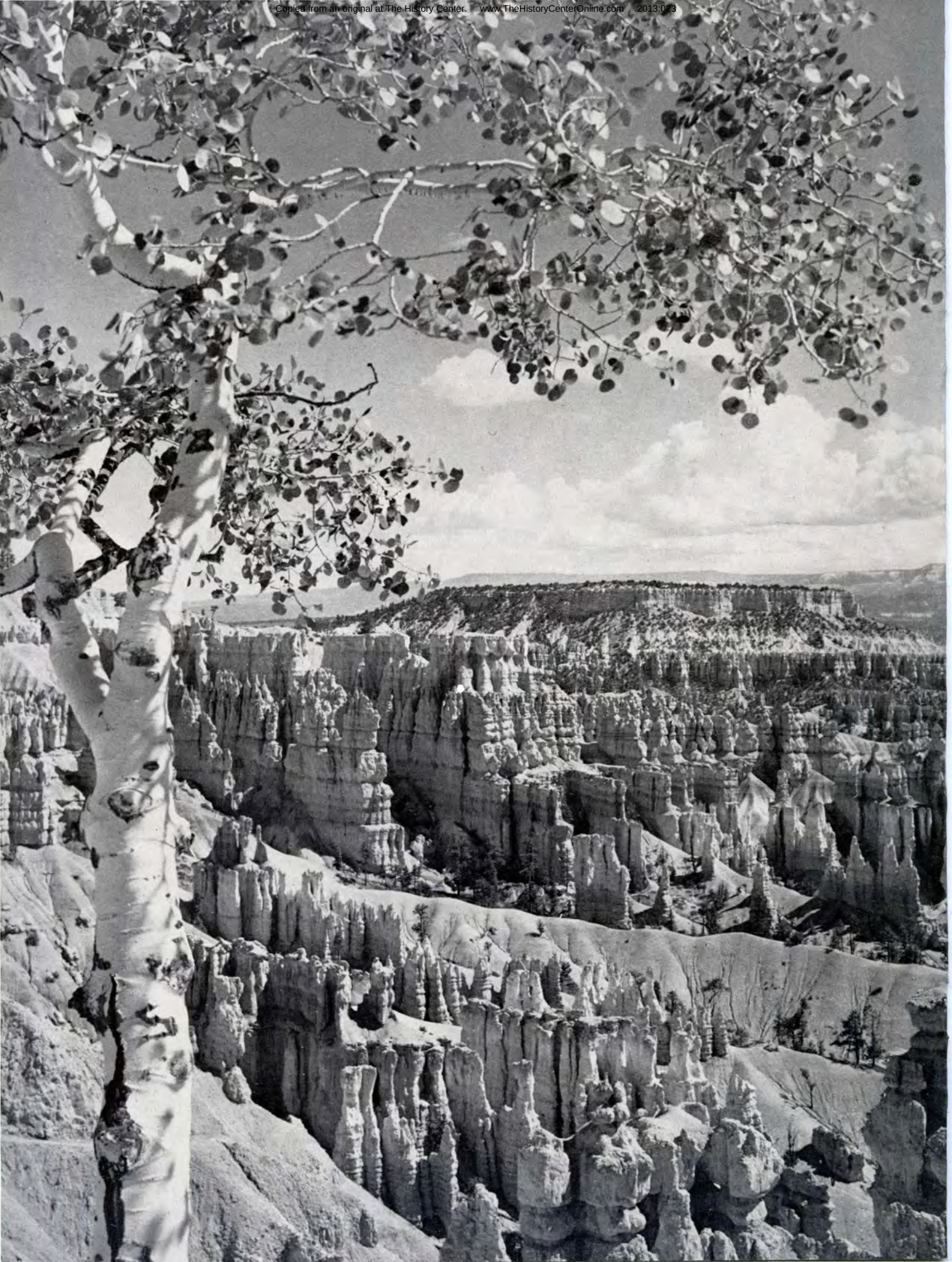
The Lufkin Line

VOLUME XXVIII . . . NUMBER 3



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Virginia R. Allen, Editor

THE Lufkin LINE

MAY-JUNE, 1953
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GULF COAST NUMBER

In This Issue

Happiness is a rebound from hard work. One of the follies of man is to assume that he can enjoy mere emotion. As well try to eat beauty. Happiness must be tricked. She loves to see men work. She loves sweat, weariness, self-sacrifice. She will not be found in the palaces, but lurking in cornfields and factories and hovering over littered desks. She crowns the unconscious head of the busy child.

—David Grayson

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For three days, fishermen from many states compete in the Tarpon Rodeo. Results seem best around off-shore drilling rigs.

GRAND ISLE
Louisiana Playground

By J. NORMAN HEARD

A PIRATE'S lair for more than a century, Grand Isle on the Gulf has in recent years become a Mecca for bathers, boatmen, fishermen, and naturalists. Located less than three hours drive from downtown New Orleans, the island is seven miles long and a mile and a half wide. It is the most flourishing resort along Louisiana's two hundred miles of coastline.

Grand Isle's first claim to fame resulted from her suitability as a hideout for pirates. Henry Morgan, the redoubtable English buccaneer who sacked old Panama City and maintained a threat to New World Spanish settlements used Grand Isle as a headquarters. From this strategic base he shipped stolen slave cargoes to the New Orleans market.

In 1811, almost one hundred years after Morgan's departure, the island served as headquarters for an even more celebrated corsair, Jean Lafitte. Commanding a dozen ships, Lafitte raided in the Gulf and Caribbean, then retreated through floating prairies that baffled pursuers to dispose of his spoils to planters and merchants in New Orleans. Each time American authorities attempted to capture the pirates, the quarry vanished into the watery wildness of bayous and swamps to landward of Grand Isle. When Governor Claiborne of Louisiana placed a $500 price on Lafitte's head the outlaw retaliated by assigning a $5,000 price to the governor's head.

During the War of 1812, Lafitte proved himself to be as staunch a patriot as a pirate by allying his men with Andy Jackson's forces. They played an important role in repulsing the Red Coats at the Battle of New Orleans. President Madison pardoned the pirates of past crimes, but a majority, including Lafitte, returned to outlawry almost immediately.

One of the leaders, Nez Coupe (Split Nose) Chighizola, built a home on Grand Isle which still

Still standing at Grand Isle, the home of Nez Coupe, Jean Lafitte's lieutenant, attracts many visitors.

stands. Near the house is a hollow tree in which Jean Lafitte secreted messages for his lieutenant. Nez Coupe reputedly suffered his disfigurement in a knife duel with another pirate over a beautiful woman captive who watched in horror from the stake to which she was chained.

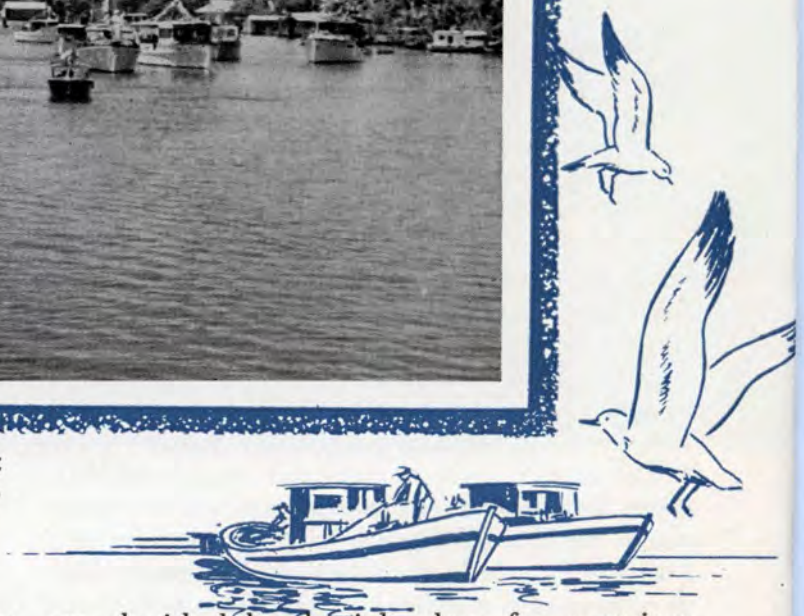
The single highway approach to Grand Isle enters the Cheniere Caminada country a few miles above the island. Once a sizeable settlement, Cheniere Caminada was wiped off the map in 1893 by a hurricane and tidal wave which smashed the Louisiana coast and swept up the bayous, killing 1,500 people. Today the region inland from the Grand Isle causeway is a sparsely settled, water-soaked waste.

The 1893 storm was indirectly responsible for bringing the bell of the Grand Isle Catholic Church to its present location. This 700-pound bell was originally mounted at the Cheniere Caminada church. It is constructed of gold and silver contributed by parishioners, much of it reputedly Lafitte's loot. The hurricane demolished a part of the church and the bell imbedded itself in the sand. Some of the survivors moved to Westwego, taking their cherished bell with them. There, despite many protests, a decision was made to assign it to an inland city church. The bell was to be transported by ox cart, but on the first night of the journey it mysteriously disappeared. Years later when a church was built at Grand Isle the bell was unearthed from a Westwego cemetery. Today it is mounted just across Caminada Bay from its first resting place.

Never has a Gulf hurricane been more vividly depicted than in Lafcadio Hearn's narrative, *Chita.* This gripping story relates the catastrophe of Last Island, but many readers associated the locale with Grand Isle and gave the infant resort a wide berth. Until improved communications and weather

After a two-hour battle, Mrs. Charles Buison of New Orleans successfully landed the 1952 Rodeo winner.

These two boys brought in the redfish while their grandfather lost his catch because of light tackle.



Yachts and cruisers parade down Bayou Barataria to Grand Isle where celebrations precede fishing.

forecasts made hurricane warnings possible days in advance, this fear was an important factor in retarding the island's development. It led to the expression by folklorist Harnett Kane that Grand Isle survived despite hell, highwater and Hearn.

Today a Coast Guard station is located on Grand Isle and a mile across Barataria Pass on Grand Terre Island, a lighthouse is maintained. Grand Terre is also the site of the ruins of Fort Livingstone. Occupied in 1862 by Confederates, the fort fell a year later to Federal forces. The storm which wiped out Cheniere Caminada partially demolished the fort and fiddler crabs now scurry around the crumbling walls and rusted cannon.

The 550 present-day Grand Islanders are a mixture of French, Portuguese, Spanish and Filipinos. The language is a French-Spanish patois. Until recently, the only contact with the mainland was a twice-weekly mailboat. Now, an excellent highway and bridge make travel easy, but many of the inhabitants have never been off the island.

Grand Islanders live in cottages of two and three rooms, encircled by lovely gardens. Palms, yucca and ferns grow in abundance and inland lanes are almost roofed over by elder, chinaberry, and oleander. The island's oak trees lean toward the mainland, forced into grotesque shapes by the constant pressure of the sea breeze. These oaks are cherished by the islanders for a curious reason—they will anchor a drifting man during the hurricane's fury. The inhabitants of Cheniere Caminada had used most of their trees for firewood before the disaster of 1893 struck, but one woman saved herself by knotting her hair around a stout limb.

The favorite recreation of Grand Isle's permanent residents is the dance. The children accomplish the graceful but strenuous routine almost as soon as they learn to walk. Dances frequently have lasted through Saturday night, then recessed for Mass and a few hours sleep before resuming for another all-night session.

Principal occupations of island citizens are fishing, trapping, and truck farming. Products are sent to New Orleans by the same routes that the pirates followed in smuggling goods to market. Until recently a major industry was the raising of terrapins. The island's terrapin farm, probably the world's largest, fattened as many as 25,000 diamond-backs a year until changing tastes put an end to the market.

Rapidly becoming the leading industry is the tourist trade. Extending for miles along the beach are tourist courts, hotels, private beach cottages, and night clubs. For sale at many places are lamps, tables, bowls, and curios shaped from the drift-

wood which accumulates along the shore.

Seven miles of Grand Isle beach slopes gently into the Gulf. The sand has a golden color caused by the backsweep of the Mississippi River current colliding with the Gulf waters. Surf bathing is said to be the world's safest, and water skiing is just beginning to come into its own as a Grand Isle sport.

Naturalists as well as sportsmen, make Grand Isle a center of operations, for ideal facilities exist for study of fish and bird life. Each April enormous flocks of ducks, geese, and other migratory birds use the island as their first resting place on the return from the tropics. The Gulf waters abound with fish, and Marine biology courses are offered during the summer at the Elinor Behre Field Laboratory, established by the Louisiana State University.

There is no limited "season" for fishing at Grand Isle. A great many fish species, including the delicious red snapper, are hooked by sportsmen the year around. During the winter pompano, sheepshead, and silver trout abound. In the spring, cobia and jack crevalle make their appearance and by May, Spanish mackerel and tarpon provide plenty of fight for the angler. During the summer fishing is at its best and as many as thirty tarpon strikes for a boat in a single day are not unusual. Fishing is particularly good around the drilling rigs offshore. Surf fishing, too, is excellent during the summer and fall.

Highlight of the Grand Isle year is the annual three-day tarpon rodeo. This festival was inaugurated in 1928 with perhaps a dozen boats and less than fifty fishermen participating. Each year the rodeo has been a greater success and the July, 1952, rodeo had an entry list of 1,750.

Festivities began on July 23 at Lafitte, Louisiana, on historic Bayou Barataria, when a fleet of yachts and cruisers strung out down the bayou in parade formation. Upon their arrival at Grand Isle some four hours later, the sportsmen were treated to a shrimp and crab boil. Comradrie and good fellowship prevailed as distinguished lawmakers rubbed shoulders with bare-footed native fishermen. Bull sessions on the docks, dances in the pavilions, and parties aboard private yachts lasted far into the night.

On July 24, three days of frenzied fishing began as crowds lined the beach to watch the catches brought in to the weighing stand. Although the contest is known as the Tarpon Rodeo, eleven other species of fish are eligible for awards. Prizes are given for the four largest fish taken in each of the following species: tarpon, cobia, Spanish mackerel, king mackerel, dolphin, bonito, jackfish, redfish, speckled trout, sheepshead, jewfish, and tripletail. In addition to the forty-eight awards for individual catches, a prize is given to the best all around fisherman. Last year the winner was Jack Brown of Grand Isle. The award for the largest tarpon, a 104 pounder, went to Mrs. Charles Buisson of New Orleans.

The Tarpon Rodeo has put Grand Isle on sportsmen's maps throughout the land and with thousands of new visitors each year a bright future for the resort is assured.

First day's catch at Bayou Riguad includes many species, all eligible as Rodeo entries.

The 700-lb. bell in this church is said to be made from fabulous gold and silver loot of Jean Lafitte.

SNAPSHOTS with the Lufkin Cameraman

WES HORTMAN, left, and CHESTER NENNY, Gulf Refining Co., Natchez, Miss.

O. A. FLETCHER, left, and N. S. ROBERTS, Stanolind Oil & Gas Co., Pollard Field, Alabama.

JACK JACKSON, left, and K. M. VAUGHN, Sun Oil Co., Brookhaven, Miss.

J. D. DRISKILL, left, and WOODY MALESKY, Gulf Oil Corp., Beaumont, Texas.

C. R. CLAUSE, Magnolia Petroleum Co., Lake Charles, La.

G. A. HALL, left, IKE ROSENLIEB, center, and R. D. McNEESE. Sohio Petroleum Co., Tinsley Field, Miss.

C. G. GLASSCOCK, JR., and MISS HAZEL SPEED, Glasscock Drilling Co., Corpus Christi, Texas.

ED KINNEBREW, The California Co., Brookhaven, Miss.

BILL HODGES, Sun Oil Co., Beaumont, Texas.

Standing, left to right: BUDDY DuPERIOR, Mathieson Chemical Co., Lake Charles, La., and E. P. TROUT, vice-president, Lufkin Foundry. Seated in back of swamp buggy is DR. J. C. CLEMENT of Lufkin. These two Lufkin fellows were taken for a real duck hunt at Roy Mannus Hunting Lodge at High Island, La. They reported that no one with false teeth could ride the swamp buggy on dry land because of the roughness, but that it was very pleasant going in water and mud. They didn't report how many ducks they killed!

GEORGE FUEL, Sun Oil Co., Beaumont, Texas.

BILL DRUSHEL, The Texas Company, Dayton, Texas.

EARL W. HARTER, The California Co., Harvey, La.

BERT GUNTHER, The California Co., Harvey, La.

A. D. AITKEN, Shell Oil Co., Lake Charles, La.

Left to right: CHUCK KALTEYER, Houston; JERRY FUNDERBURK, Houston; J. P. WEATHERLY, JR., Segno, Texas; and J. W. CLARK, JR., Thompsons, Texas, all with Gulf Oil Corp.

JOHN BROWN, left, A. L. GEORGE, center, and H. S. CHAMPAGNE, Humble Oil & Refining Co., Bayou Sale, La.

Right: JACK CAIN, The Texas Company, New Iberia, La.

Left: J. T. PAYTON, The Texas Company, Dayton, Texas.

Left to right: FRANK JACOBS, The California Co., Brookhaven, Miss.; F. M. ELLENZ, The Texas Company, New Iberia, La.; VAL GALLIA, Lufkin's Brookhaven representative; J. L. HORTON, The California Co., Natchez, Miss.; and L. A. LITTLE, Lufkin's vice-president in charge of sales.

RANDY BRYANT, Gulf Oil Corp., Houston, Texas.

FRED SHERRON, left, and H. H. HEAD, Gulf Oil Corp., Beaumont, Texas.

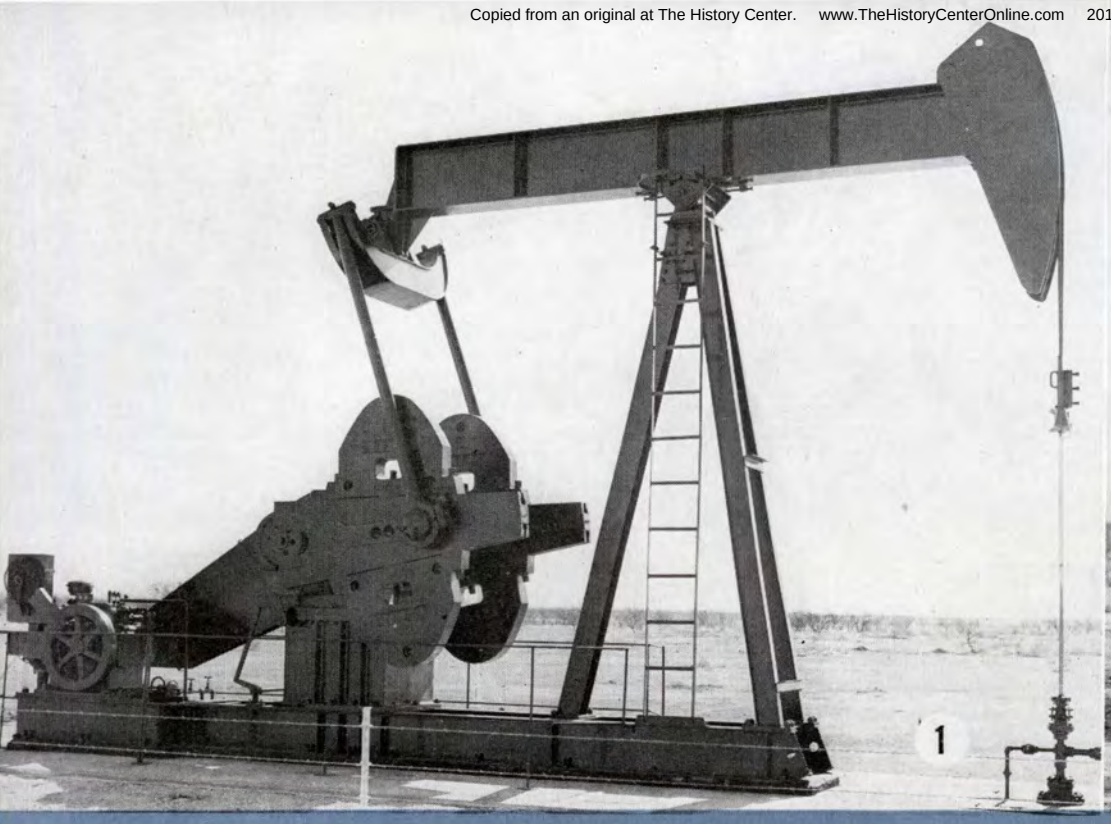
BOB COULTER, Carter Oil Co., Jackson, Miss.

C. R. McGUFFIN, Carter Oil Co., Catahoula Lake, La.

JAMES BLANCHARD, JR., Superior Oil Co., Bayou Blue, La.

HOWARD HUMPHREY, The Texas Company, Dayton, Texas.

DAVE DAWSON, Gulf Oil Corp., Houston, Texas.



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LUFKIN

INSTALLATIONS

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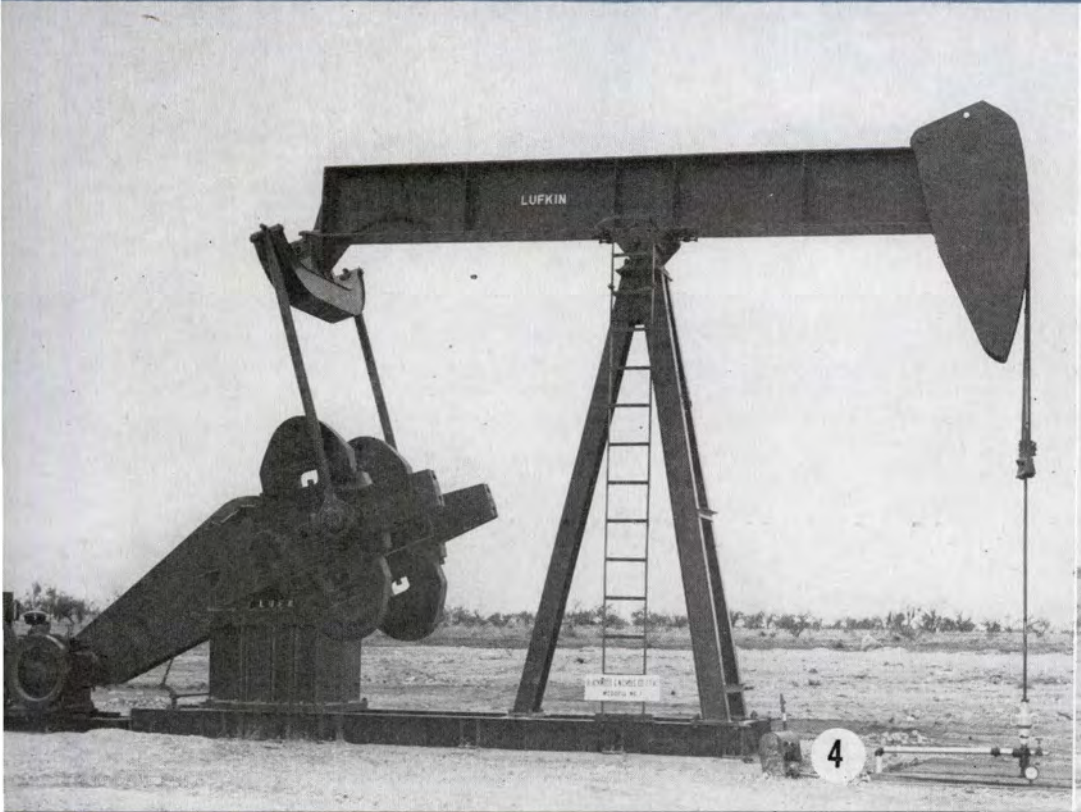

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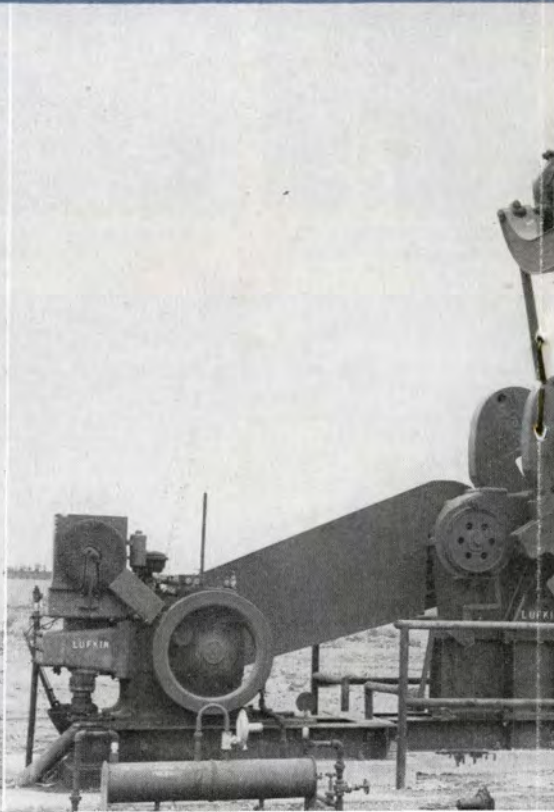


2

3

LUFKIN TC-1-35B Unit with LUFKIN H-333 Gas Engine, American Republics Corporation, Midland, Texas.

LUFKIN TC-33B-22G Unit, Standard Oil Company, Imperial, Texas.

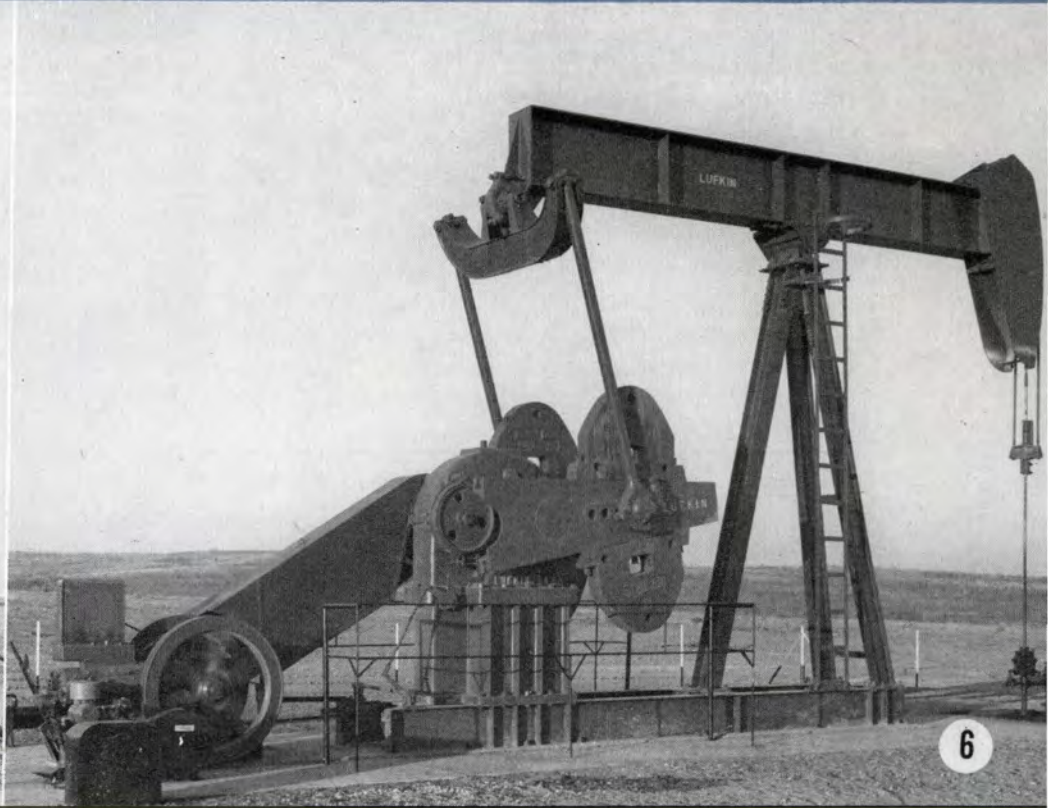
LUFKIN TC-2AL-36A Unit with LUFKIN GSDH Gas Engine, Amerada Petroleum Corp., Big Spring, Texas.

4 LUFKIN TC-OAL-41C Unit with LUFKIN H-333 Gas Engine, Blackwood and Nichols, Weddell Field near Big Spring.

5 LUFKIN TC-33AL-22G Unit with LUFKIN H-333 Gas Engine, Seaboard Oil Company, Spraberry Field near Midland.

6 LUFKIN TC-OAL-54C Unit, The Texas Company, Snyder, Texas.

5



6

DUCTILE IRON Gears

By BAYO HOPPER
Chief Engineer, Lufkin Foundry & Machine Co.

PERHAPS the most remarkable development in the gray iron foundry industry during the twentieth century has been the introduction of nodular iron, commonly referred to as spheroidal or ductile iron.[1] The announcement of this development was first made in 1948,[2] and first commercial production was poured in 1949.[3]

Ductile iron is produced by the accurate addition of magnesium to controlled gray iron in the molten state. A relatively simple procedure is followed to convert this gray iron into a spheroidal graphite or ductile iron having high tensile strength, capable of 2% to 10% elongation as cast and possessing a straight line proportionality of stress to strain to a high proportional limit with a tensile modulus of elasticity of 25,000,000 pounds per square inch.

The most common method of producing ductile iron is in the cupola, but any type of melting medium may be used with good results.

The molding practice is essentially the same for ductile iron as for cast iron. The casting shrinkage is approximately the same as for cast iron so that patterns made for cast iron or malleable are satisfactory for ductile iron.

Figure 1 illustrates the typical microstructure of ordinary cast iron with its free carbon in the form of thin flakes. These flakes form a multitude of discontinuities and notches in the matrix, and since the graphite has no tensile strength to hold the particles of iron together, the cast iron has relatively low tensile capacity.

The effect of the addition of magnesium to a suitable base cast iron is shown in Figure 2. This illustrates the typical microstructure of ductile iron in which the free carbon has been collected into the form of spheroids or nodules. It is not known why the free graphite assumes the form of spheroids in the presence of appropriate quantities of magnesium, but it is certain that the material will not possess its superior strength and appreciable elongation unless the nodules or spheroids are formed.

Although ductile iron can be produced in any high class gray iron foundry, it must be emphasized that satisfactory results will not be obtained consistently without very precise control over metallurgy and cupola operation.

Figure 1

[1] International Nickel Co., Inc. Patents 2,485,760, 2,485,761.

[2] By International Nickel Co., at American Foundrymen's Society, Annual Meeting, May 7, 1948, Philadelphia.

[3] Cooper-Bessemer Corp., Grove City, Pa., Feb. 5, 1949.

Figure 2

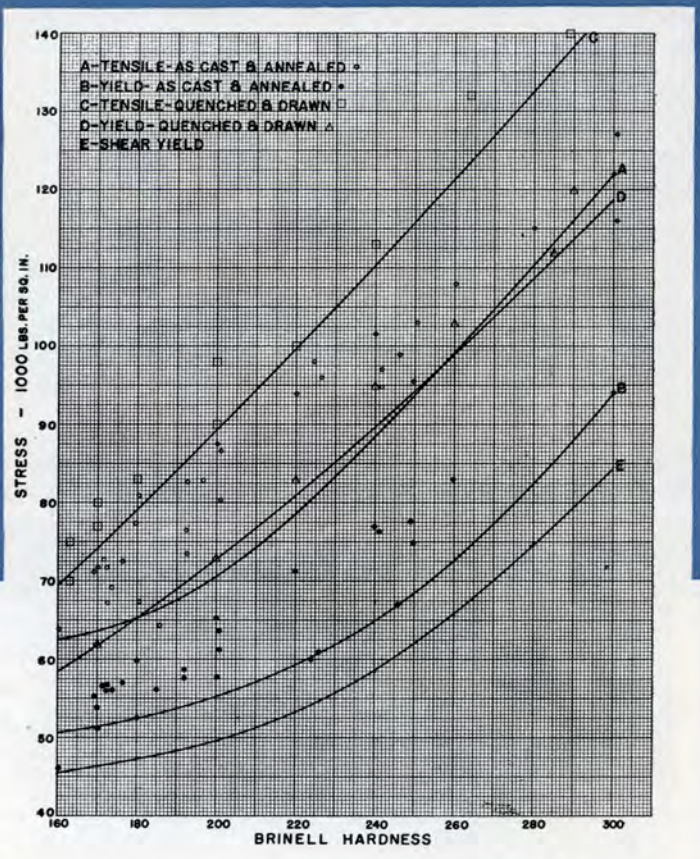


Figure 3

At Lufkin our practice is to hold the chemical composition within the following range:

Carbon	3.5% — 3.8%
Silicon	2.5% — 3.0%
Manganese	.4% Max.
Phos.	.1% Max.
Sulphur	.04% Max.
Magnesium	.05% — .08%

Sulphur present in the bath will combine with magnesium until the sulphur content is reduced to about .015%. For the amount of sulphur present in the base iron in excess of this amount, an additional amount of magnesium must be added to the extent of one part of magnesium for each part of sulphur to be removed.

The retained magnesium content must be maintained as high as .05% in order for the free carbon to form in the shape of spheroids. With the magnesium as low as .04%, the graphite will be only partially in the shape of spheroids with the remainder in the form of flakes. The tensile strength will be lowered proportionately with the reduction in the amount of spheroidal graphite.

There is a fairly definite relationship existing between strength and hardness of ductile iron. In Figure 3, Curve A represents minimum tensile strength of as-cast and annealed ductile iron as it varied with hardness.

This curve is drawn through the lower range of the points which are representative of extensive tests and are shown here by the small circles. The points plotted cover values obtained from test bars cut from keel blocks and from castings.

It will be noted that the curve tends to flatten at the lower range of hardness. It increases from 65,000 psi at 180 Brinell up to 122,000 psi at 300 Brinell.

Curve B represents minimum values which may reasonably be expected for tensile yield from the same as-cast and annealed material. This curve is drawn through the lower range of the test results shown here by the solid dots. It will be noted that the tensile yield increases from 52,500 psi at 180 Brinell to 94,000 psi at 300 Brinell.

In the as-cast condition high strength and high hardness can be obtained but ductility will generally be low. Without close control of analysis, ductility can be negligible, or perhaps even zero. Annealing will reduce the strength and hardness, but elongation in the neighborhood of 20% or better can be obtained.

Ductile iron can be quenched and drawn for strength improvement and for control of hardness. With the chemical analysis maintained within the prescribed range, a fairly consistent relationship exists between tensile, yield and hardness. Dependable minimum values for this relationship are shown by Figure 3 in which Curve C shows the variation of tensile strength with hardness. It will be noted that this curve follows almost a straight line from 79,000 psi at 180 Brinell up to 140,000 psi at 293 Brinell where the curve leaves the chart.

This article is taken from a paper prepared by Mr. Hopper for presentation at the 36th Annual Meeting of the American Gear Manufacturers Association, June 2-4, 1952, in Hot Springs, Va.

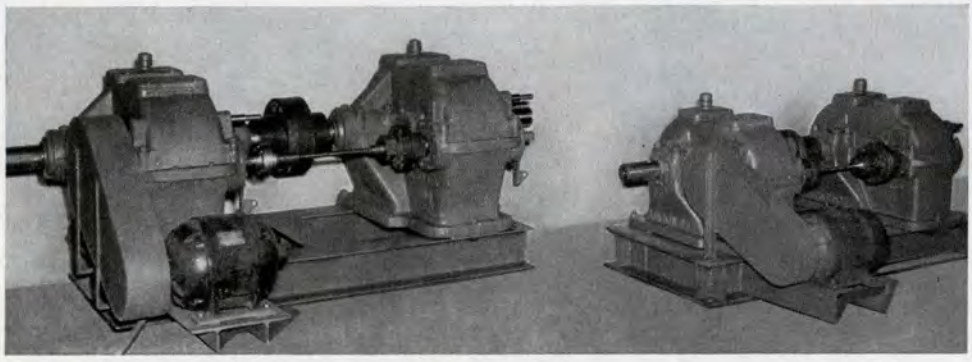


Figure 4

The yield for quenched and drawn ductile iron, Curve D, follows a similar pattern from 65,000 psi at 180 Brinell to 118,500 psi at 300 Brinell.

Lufkin has been producing ductile iron in its gray iron foundry since 1950. In production, its use has been confined to those parts previously made of malleable iron and medium carbon steel. In addition, considerable experimental work and testing has been done in connection with the use of ductile iron as a gear material for the standard type commercial gear reducer and for oil field pumping unit gear reducers.

TESTS

Several sets of ductile iron gears were tested in the four reducers shown in Figure 4. These were tied together in pairs and maintained under controlled load conditions by torque coupling.

These test reducers were double reduction continuous tooth herringbone gear type with ratios of 29.4 and 29.2. They are our standard oil field pumping unit reducers, sizes 114D and 40D. The gears have fairly coarse pitch since they are designed for heavy duty pumping operation at fairly slow speeds.

Ductile iron gears of different hardnesses were tested and in some instances production steel gears were placed in the second gear box for comparison.

After making a number of gear tests, including those to be illustrated here, a tentative rating was established for ductile iron gears. This rating was based on the results of our tests. It is mentioned here to point out that in the following exhibits when we mention the ductile iron gear rating, we mean the tentative rating which we determined after the tests reported here were concluded.

Figure 5 shows an annealed 179 Brinell ductile iron gear in the 40D gear box. It is 4⅜″ face, 5 D. P. and approximately 17″ diameter. Based on the rating which we established for ductile iron gears, this gear had a capacity of 7.74 horsepower at its running speed of 18.55 RPM with 5.25 ratio. At the time this photograph was taken, the gear had operated for 1213 hours at a load of 11.8 horsepower which we consider to be more than 50% overload. The gear teeth had a slightly roughened or coarse-lapped surface, but there was no destructive pitting nor scoring.

In Figure 6 a quenched and drawn 269 Brinell gear is shown which we rated 40.6 horsepower at 28.3 RPM. This gear is in the 114D gear box and is approximately 24″ diameter, 5¾″ face, 3½ D. P., in contact with its pinion at a ratio of 5½:1.

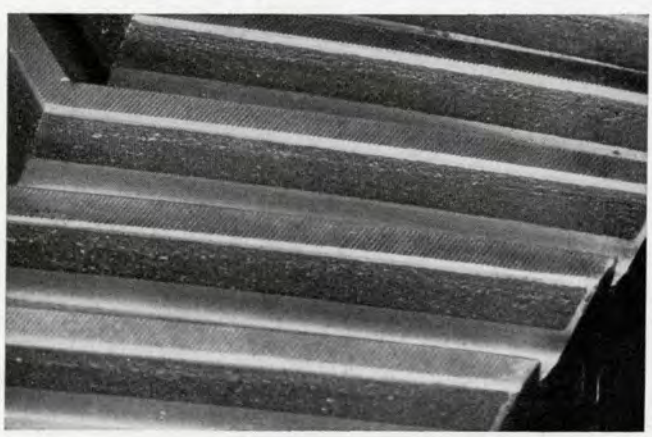


Figure 5

Figure 6

This gear set had operated at a slight overload for 7500 hours at the time the photograph was made. The teeth were in perfect condition with no sign whatever of any surface distress. This gear is typical of many similar gears which were tested at various hardnesses and were found to be in excellent condition after carrying their rated loads for extended periods.

The high speed gear of another 114D gear set is shown in Figure 7. It is 255 Brinell, approximately 17″ diameter, 3″ face, 6 D. P. and 5.32 ratio. It had carried approximately its rated load for 1050 hours at the time the photograph was taken. The teeth were in near perfect condition with no evidence of serious surface distress. This example is typical of several such gears which showed evidence of sufficient capacity to carry our rating for extended or indefinite periods.

The ductile iron gear shown in Figure 8 was installed in one of our standard S126 commercial speed reducers driving the cupola blower in our foundry. This gear is annealed with a hardness of 156 Brinell, 20″ diameter, 6″ face, 6 D. P. and in contact with a 245 Brinell pinion at 5:1 ratio. Based on our rating, it had a capacity of 71.6 horsepower at 180 RPM. Its actual operating load was 98 horsepower, which is an overload of 37%. Actually, a reducer would normally be selected for this application on the basis of 1.25 Service Factor. This means that the calculated capacity should have been 123 horsepower, and on this basis, the gear was 72% overloaded.

This gear was in operation for ten months, or over 1500 hours actual running time, before being replaced with a lower ratio gear set for faster blower operation. It will be noted that the gear teeth are in perfect condition, except for minor pits at the left end of both helices.

In Figure 9 the dynamometer card taken at the polished rod of an oil well pumping unit is shown. This card is unusual because of the extremely sharp drop in the rod load at the center of the down stroke, due to the "fluid pound." This results in the entire peak load of lifting the counterbalance cranks being instantaneously applied to the gear teeth at the middle of the down stroke where the torque arm is the greatest. The torque on the slow speed gear for the entire cycle at different angles of crank position is shown by Figure 10. This illustrates the magnitude of the peak torque and the instantaneous nature of its application.

The gear reducer driving this pumping unit is equipped with ductile iron gears which we would rate at 32,300 inch pounds peak torque. The peak torque load reaches 60,000 inch pounds, or an overload of 86%. This unit has been in operation

Figure 7

Figure 8

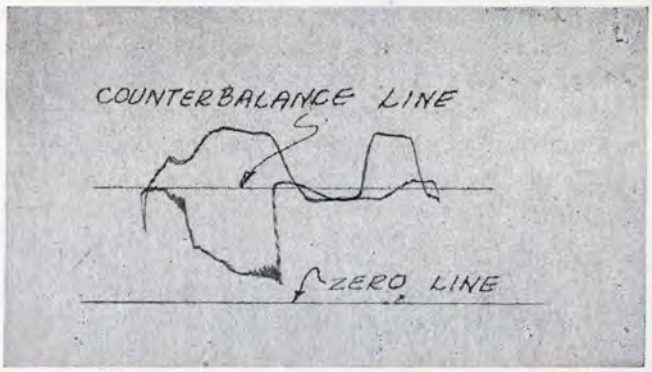


Figure 9

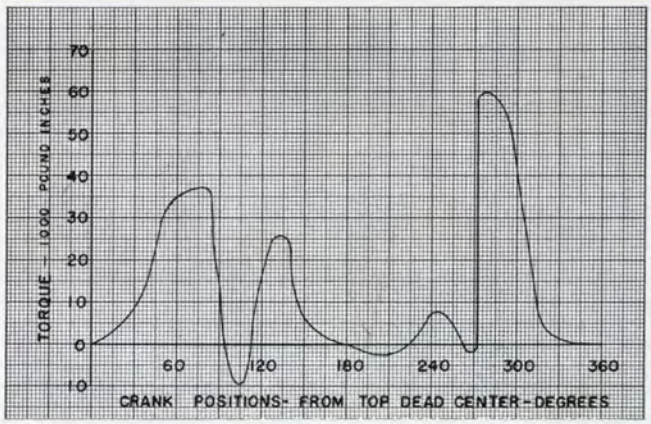


Figure 10

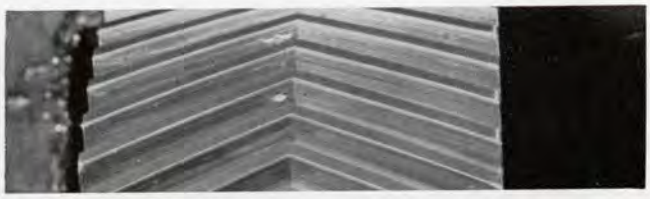


Figure 11

continuously for sixteen months. It is evident that the nature of the loading is such that this impact load hits the same three or four teeth every rotation of the gear which is at the rate of 23 RPM. Figure 11 shows these particular teeth on the slow speed gear. It will be observed that the damage to the teeth consists only of pits of appreciable size on alternate teeth just to the left of the apex.

We have three additional pumping unit reducers, two 114D and one 40D, equipped with ductile iron gears. Two of these are operating at about 40% above their peak torque capacities and have been doing so for over 10,000 hours or almost fifteen months. There is no evidence of distress of any kind on the tooth surfaces of these gear sets.

We have made no calculations of beam strength for ductile iron gears. The experience reported with the pumping units has convinced us that for the gear proportions and operating conditions normally encountered in our type of commercial speed reducer and oil field pumping unit reducer, tooth breakage will not be a problem.

On the basis of a mathematical analysis similar to that which was originally employed in determining the AGMA and API ratings on steel herringbone gears, modified somewhat by the experience gained through the tests reported here, the K_r curves of Figure 12 were established. These curves, together with the F_i curve and the formula for D_s published in API Standard 11E, were employed in calculating the ductile iron gear ratings mentioned previously for the test gears.

The new K_r curves will limit the loading of ductile iron gears at 180 Brinell to approximately 10% below that for steel and at 300 Brinell to approximately 22% below steel.

Some experimenting was done with varying the relative hardness between the gear and pinion. There was evidence to indicate that tooth surface conditions improved with pinion hardness. It was concluded, however, that the hardness differential currently employed for steel gears should be maintained for ductile iron gears in contact with steel pinions.

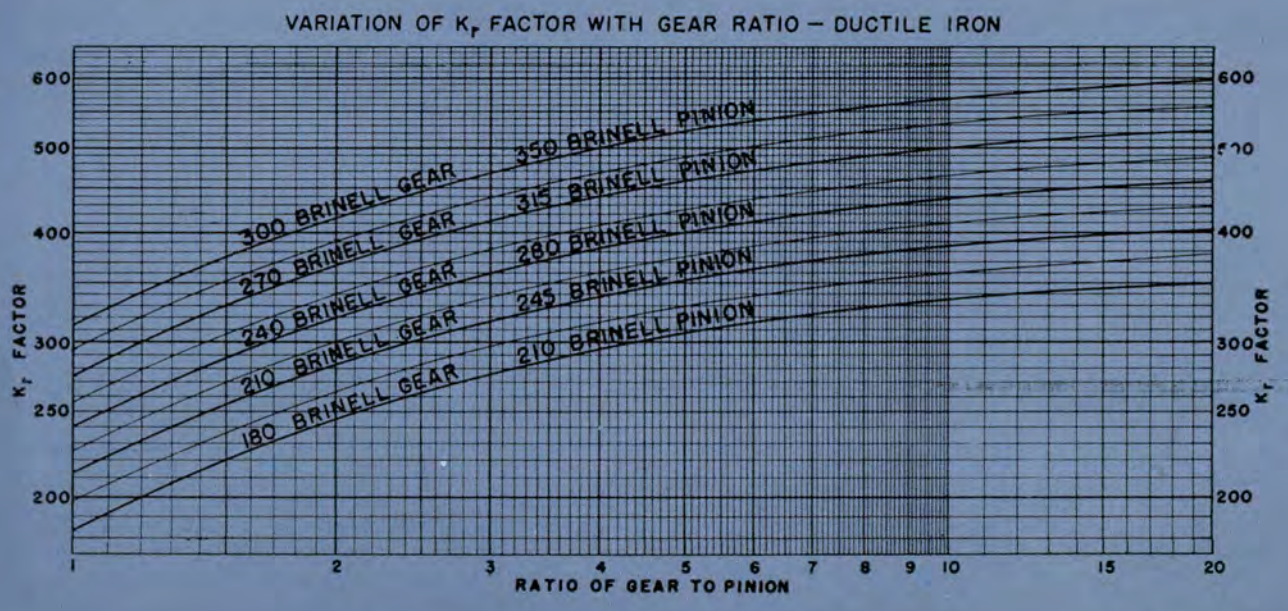
We believe that for the type of gearing and gear reducers covered by these tests, the capacities established by these K_r values will result in gear sets which will give service comparable to steel gears selected on the basis of their K_r values. As a matter of fact, we obtained considerable evidence to substantiate the belief that properly controlled ductile iron gears accurately manufactured and assembled might carry the full rating currently being used by API for the rating of steel gears.

It is not our intention to promote the idea that ductile iron is, therefore, going to replace steel as a gear material. Neither is it our thought, incidentally, that ductile iron is going to replace malleable iron in the general run of castings.

It is our plan to employ the K_r curves established here in the selection of any ductile iron gears we may have opportunity to install.

In order to establish a definite rating on any new gear material a large volume of experimental test data and field experience is essential. With the encouragement derived from the results obtained thus far in the application of ductile iron as a gear material, Lufkin intends to continue its experiments along the lines reported here.

Figure 12



The RUSSELL GLENN Story

The first load of milk to West Texas was hauled by Glenn in a second-hand truck.

THE Russell Glenn Distributing Company of Odessa, Texas, began a milk distributing company with one second-hand Ford truck in August, 1947. Today, the Company operates a fleet of nine diesel and one gasoline trucks over the western half of the state, covering more than 200,000 miles per year.

This business which has mushroomed in a little more than five years was begun, so to speak, on a shoestring.

According to owner Russell Glenn, he borrowed money to buy his first truck and his first load of milk. He began operations when he learned that there was a lack of milk in West Texas comparable to that found in Dallas and other East Texas cities.

Following his first delivery, he found that the demand exceeded his best expectations. Soon, he was delivering more milk in a week than he had anticipated delivering in one month.

With the phenomenal demand, he experienced a transportation problem. He was forced to rent additional transportation equipment. By 1951, he was able to purchase his needed facilities to eliminate the rental problem.

His sales outlet now is from Abilene on the east to El Paso on the west and as far north as Plainview. He hauls approximately 12,000 quarts of milk per load averaging more than 360,000 quarts per week.

One of the fleet of diesel trucks operated by Glenn through West Texas, averaging 200,000 miles yearly.

What's a Fourth of July picture without a pretty girl? Here's Virginia Gibson, Warner Bros. star.

Paramount's Virginia Hall, left, and Mary Murphy are ready to start the holiday with a bang.

Shapely Geraldine Knapp, Paramount's starlet, seen in "The Lemon Drop Kid" with Bob Hope.

Vivacious Yvonne De Carlo, star of Paramount's "Hurricane Smith," relaxes on set at Malibu.

Grandmother was a diabetic patient, and, although put on a strict diet, she would not play the game, and was "cheating" all the time. After numerous violations, she was sent to the hospital.

Owing to the crowded condition of the hospital, the only available room was in the Maternity Ward. After she had been there a few days, her little granddaughter paid her a visit and was lolling in front of her grandmother's room when some visitors walked past. "What are you doing here, little girl?"

"I'm visiting my grandmother."

"Grandmother!" said one of the visitors in astonishment. "What is she doing here?'

"Oh," said the youngster, "she's been cheating again."

Two women were recently discussing the possibility of another war.

"If there's another one, they'll be over here bombing before you know it and we'll be blown into maternity."

"You're right," said her friend, "and with the blackouts we'll never know who did it."

Back in the days before the horseless carriage, a young man and a young lady got married. Their honeymoon was to be spent at a rather distant place, so it was decided that the first night would be spent in the home of the bride's parents.

After supper when the newlyweds had retired to their room, the bride handed the young man the Bible and asked that he read a passage of Scripture.

To this he replied, "Well, ain't never done it before, but guess I can."

After he had completed reading the Bible, his young bride asked that they have a prayer. The groom said, "Ain't never done it before, but guess I can."

So . . . next morning at the breakfast table, our young hero told his bride's parents and her grandmother that he had done something the night before that he had never done before.

The blushing bride said: "Yes, and we're going to do it every night as long as we live."

Grandma just rolled her eyes and gave them a sympathetic look.

The husband who knows where his wife keeps her nickels has nothing on the husband who knows where the maid's quarters are.

A pessimist is one who thinks that all women are immoral. An optimist is one who merely hopes so.

The county fair in western Kansas had as its chief attraction the grand champion bull, and a farmer from Great Bend had made the trip with his whole family just to see the bull.

At the entrance, however, he discovered that he and his wife and his five oldest children would have to pay fifty cents each and the other seven children twenty-five cents. The farmer began to argue loudly and finally the manager came and asked what was the matter.

"We've traveled nigh on to a hundred miles," said the farmer, "to see that champion bull, but I'm danged if I can afford $5.25 to get in."

"Are all those children yours?" the manager asked.

"They sure are," replied the farmer.

"Let 'em in free," the manager told the gatekeeper. Then he turned to the farmer. "We want the bull to see you."

Remember the four Chinese sisters: Tu-Young-Tu, Tu-Dum-Tu, No-Yen-Tu and Sum-Fun-Tu?

The most believable golf story of the year appeared on the sports page of a Florida newspaper recently. It read: "At this point the gallery deserted the defending champion to watch Miss Blank, whose shorts were dropping on the green with astonishing regularity."

Her head is just as vacant as the breakfast room in a hotel in Niagara Falls.

She said: "This is my first job with a circus. Will you please tell me what to do to keep from making mistakes?"

"Yes," said he, "Don't ever undress in front of the bearded lady."

A girl can win a husband by exhibiting a generous nature or by exhibiting how generous nature has been with her.

Girdles can be best removed by a strong yank or a big jerk.

The only thing prettier than a peach on a limb is a limb on a peach.

The skinflint wondered, after an evening with a pretty chick, why she went "cheap, cheap."

The woman refused to buy a nightgown after the clerk charged her sales tax. Afraid the tax would be raised.

Kit: "Is my dress too short?"

Kat: "Well, dearie, it all depends on which end you're trying to show."

Gal: "I wonder what came over that nice-looking fellow over there. He kissed me, then turned pale and walked away."

Sal: "Maybe he saw me come in. I'm his wife."

He took her auto-riding. She was a little angel and walked back. He took her boat-riding. She was a little angel and swam back. He took her airplane-riding—the little devil!

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