

'SAVED BY THE BELL'

The Resurrection of the Whitechapel Bell Foundry



Supplement to the June 2018 Document

Focusing on the Raycliff Whitechapel LLP
Planning Submission

PA/19/00008/A1

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Plaques on the wall above the old blacksmith's shop, honouring the lives of foundry workers over the centuries. Their bells still ring out through London.
A final board, marking the death of the bell foundry, now reads:

“Whitechapel Bell Foundry, 1570-2017”.

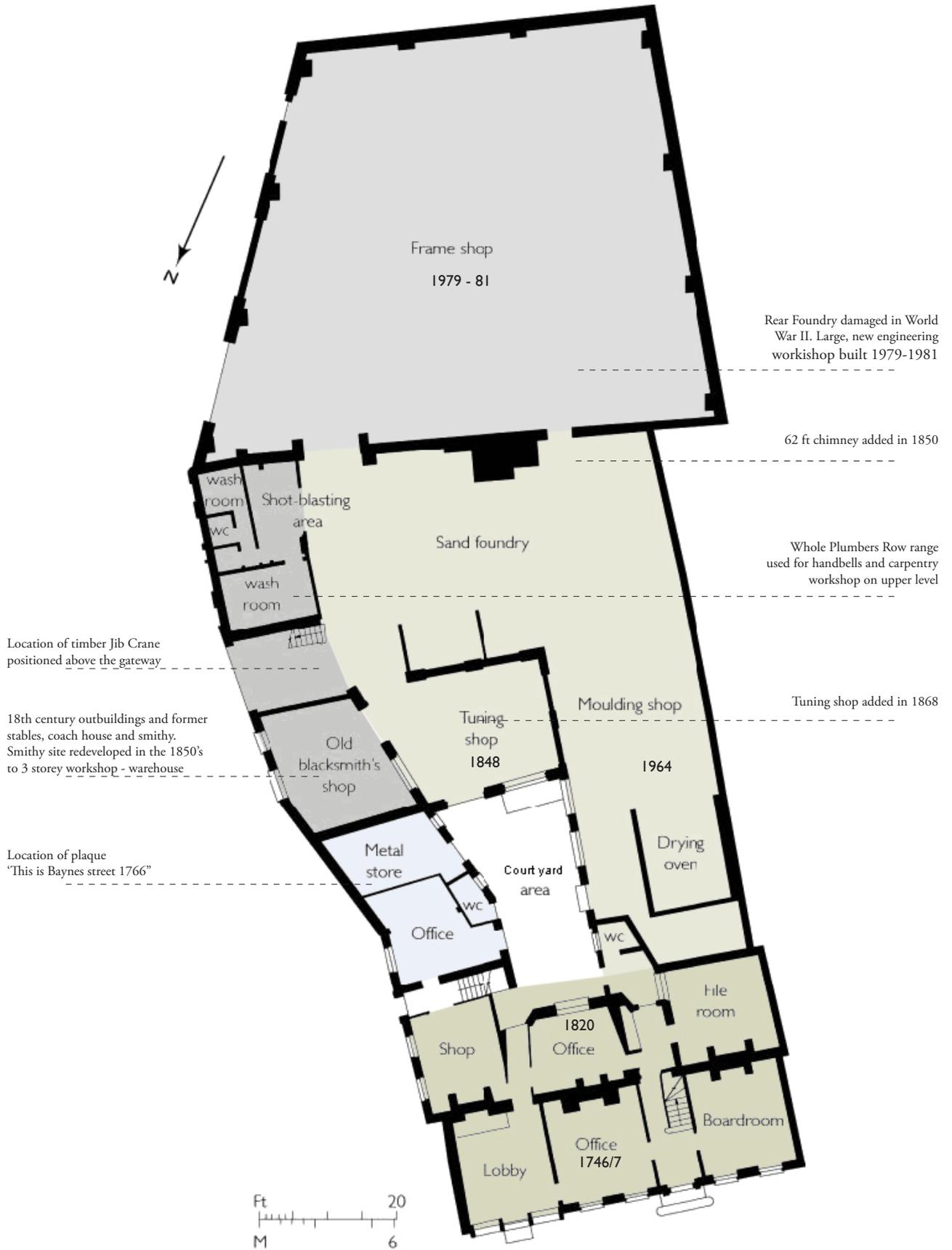


Memorial plaques in the Bell Foundry carpentry workshop honouring former workers.

BACKGROUND

In June 2017 the historic Whitechapel Foundry was acquired and the use of these Grade 2* buildings for the making of bells, such as Big Ben, the Liberty Bell and the Bow Bells, ceased. Despite its unique and profound importance, campaigns in the national press, and enormous emotional public outcry, the WBF was sold and closed.

The new owner, Raycliff Whitechapel LLP, has submitted a planning application which seeks to secure a Change of Use and development of the site as a 100-bed hotel, private members club, restaurant, bar, café and shop, with desk-sharing work spaces. As a sop to the planners and general public, the proposal contains reference to a 'viable and sustainable working bell foundry'. However, this is a deceptive description; the proposed activity is not of a scale to be a viable industry. The founding activity on site in the Raycliff Whitechapel proposal has been reduced by nearly 90%, to a small shop and studio for the casting of hand bells in a corner of the restaurant and cafe. By reducing the founding activity to window dressing and entertainment for customers of the restaurant, bar and café, means the essential heritage activity of the site has been lost. This is not surprising as the continuation of genuine foundry activities on the site is incompatible with the operation of a hotel, bar, restaurant and other leisure activities.



BACKGROUND

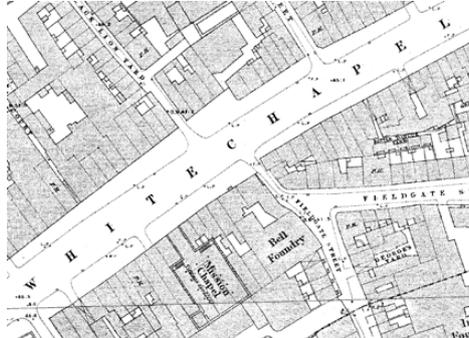


The Whitechapel Bell Foundry is a cultural heritage site in the heart of London, in the borough of Tower Hamlets, of worldwide importance. This renowned foundry has been based in Whitechapel since the reign of Elizabeth I; producing such bells as Big Ben, the Liberty Bell, Bow Bells and the Bells of St Clements. Until very recently, it was Britain's oldest manufacturing company, a working community and a repository of invaluable craft skills.

The United Kingdom Historic Building Preservation Trust (UKHBPT), an independent charity under the founding patronage of The Prince of Wales, has teamed up with Factum Foundation, a UK and Spanish registered not-for-profit organisation dedicated to the documentation and preservation of cultural heritage through the application of new technologies together with craft skills.

Through this partnership, the WBF can again become a viable foundry that specialises in bells but can also produce special edition artworks in bronze and other materials. Factum Foundation, with the UKHBPT, will refurbish, reequip and renovate the foundry that has housed the WBF premises since 1739. This will be done preserving the Grade II* listed buildings, intact and serving their original purpose. The aim is to revive the Foundry and bring bell casting into the 21st century. An important part of the initiative is the creation of a centre for the study of historic casting as well as the development of apprenticeships and educational schemes. State-of-the-art equipment will be employed to record the shape and sound of bells throughout the UK to build a publicly accessible archive and research centre.

BACKGROUND



*Map of Whitechapel
dating from 1870*

An accompanying document, 'Saved By The Bell! The Resurrection of The Whitechapel Bell Foundry', contains a brief history of the site, a description of Factum Foundation and what a 21st century foundry consists of (with specific projects for the WBF); a profile of the UKHBPT, drawings and photographs of the existing buildings, diagrammatic layouts of the proposed new foundry and associated programme, it includes practice profiles of the architects Skene Catling de la Peña and Purcell, statements by Max Fordham and EHRW engineers, Nigel Barker-Mills Heritage Consultancy and Lichfields Planning and Development Consultancy; and their professional profiles. This document is supported by an appendix which contains the Building Listing, further historic material and a public petition that collected 10,000 signatures in three weeks.

It should be noted that all consultants have made their contributions on a pro-bono basis in recognition of the profound importance of this building and the heritage it represents.

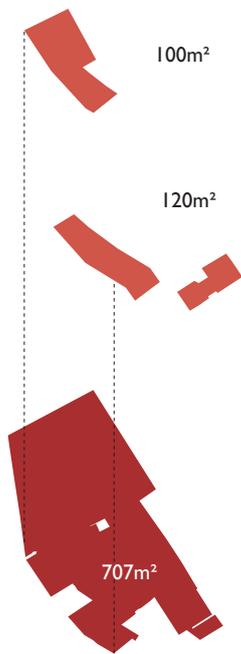
Factum - UKHBPT has attempted to find a solution where the ongoing heritage use is maintained on the site in a sustainable and meaningful way. The Raycliff Whitechapel LLP scheme proposes reducing the area of the building devoted to founding by nearly 90%. A hand-bell workshop adjacent to the restaurant / café areas is simply window dressing to make a commercial hotel and restaurant development more palatable to the public and planners, and must be called out for what it is. UKHBPT offered to buy the Foundry as an ongoing concern from the former owners, the Hughes family, before it was closed. This offer was turned down. Since then, and despite several attempts by Factum - UKHBPT to come to a positive solution with Raycliffe Whitechapel LLP, the new owners are unfortunately unwilling to participate in the continuation of a genuine working foundry on the site, or to sell the property to allow this to happen.

An economically viable, environmentally and socially sustainable working foundry can operate from the site of the Whitechapel Bell Foundry. To that end, it is imperative that planning and change of use is not granted to develop the site for any other purpose.

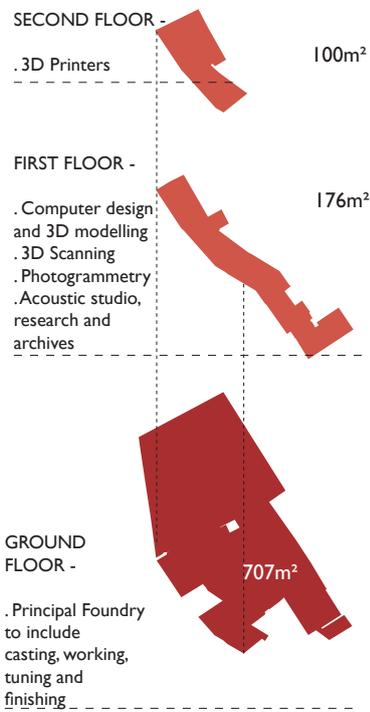
WHITECHAPEL BELL FOUNDRY

Comparison of Working Foundry Areas

THE FORMER WHITECHAPEL BELL FOUNDRY

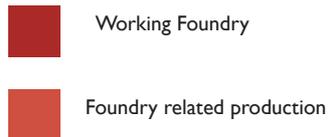


FACTUM - UKHBPT PROPOSAL



RAYCLIFF WHITECHAPEL LLP PROPOSAL

This represents an 88% reduction in the working foundry



The Raycliff Whitechapel LLP proposal was measured from The Proposal, First Floor/Mezzanine, in the Bell Foundry Design and Access Statement prepared by 31/44 Architects, December 2018. It forms part of the Raycliff Whitechapel LLP Planning Application.

EXECUTIVE SUMMARY

The Foundry is world famous and bells have been made in Whitechapel since the reign of Elizabeth I. The Foundry is the UK's oldest continuous manufacturing business and is one of London's and the UK's finest cultural and heritage assets.

Factum Foundation and the UKHBPT have formed a partnership to continue the foundry business at the Whitechapel site. Factum Foundation is committed to the application of technology to the preservation of heritage while Factum Arte is a leading producer of works of art for artists.

INTRODUCTION

Purpose : The Raycliff Whitechapel LLP planning proposal PA/19/00008/A1 has 180 reports and drawings. The aim of this document is to extract the salient points and clarify and correct certain statements and assumptions. It provides clearly legible diagrammatic comparisons between the Raycliff Whitechapel LLP and the Factum-UKHBPT proposals, and the Whitechapel Bell foundry.

- In March 2017 the UKHBPT approached Alan Hughes, the then owner of the Whitechapel Bell Foundry, with a proposal to ensure the continuation of founding on this historic site, recorded in a letter to the Times on March 21, 2017.
- June 2017, the historic Whitechapel Foundry was acquired by Raycliff Whitechapel LLP
- June 2018, the proposal by Factum – UKHBPT, professional consultants and advisors, 'Saved by the Bell! The Resurrection of the Whitechapel Bell Foundry', was made public.
- January 2, 2019 , Raycliff Whitechapel LLP, submitted a planning application which seeks to secure change of use and development of the site as a '4-5 star' 108-bed hotel, private members club, restaurant, bar, café and shop, with desk-sharing work spaces. It is described as, a 'reinstatement of a foundry'.

I OVERVIEW OF PROPOSED USES

- A new 108 room hotel with ancillary members and guest space, A3 café, A3/4 restaurant and bars at ground floor, B1 Workspace, Interpretation space, Ancillary shop, Ancillary Education
- As a "quality offer, equivalent to around 4/5 stars rating, aimed at lifestyle (sic) market", and with private "members and guests" areas, this is not a scheme to serve the current local community.
- The café will be operated in partnership with The Major Food Group (MFG), a New York based hospitality company that, according to its website, "is very passionate about New York". It is hard to see how this luxury brand is suited to serve the local community, or the best interests of the historic Whitechapel Bell Foundry
- The café and other public areas on the ground floor in the Historic Foundry "will act as a 'living museum'" and the forecourt to the bell themed boutique hotel.
- There is no indication of how 'at market rents' for desk sharing space will be applied against 'below market rents'.
- "Suitable learning opportunities will be offered". By replacing the Bell Foundry with a café, hotel, restaurants, bars, a shop and flexible desk-sharing work space, the subject of any education programme will no longer exist in any meaningful form.
- The mezzanine "may provide spaces for school children to watch a film." The Raycliffe Whitechapel

LLP proposes to replace a genuine working foundry with a film of a genuine working foundry.

2 KEY PLANNING ISSUES

- Existing Employment Use: There is no evidence of a “marketing exercise where the site was actively marketed (for 12 months)”. The only evidence given to support change of use is provided by Alan Hughes, where there would seem to be a direct conflict of interest.
- The financial value of the site as a bell foundry site is negligible. The value of the same site as a ‘4-5 star’ boutique hotel, private members club, restaurants, bars, café and desk sharing space is substantial.
- “The principal factors that contributed to the Hughes decision to relocate are summarised in a viability appraisal prepared by Quartet”. This does not appear to be uploaded onto the LBTH planning portal as part of the Raycliff Whitechapel LLP planning proposal.
- It is claimed that the buildings are not suitable for Bell Founding, despite being purpose built and having functioned in this role for nearly 300 years
- Arthur Hughes became foundry manager in 1884, and his descendants ran the business from 1968, through its decline, before selling it in 2017. There have been many owners at the Bell Foundry site, operating under different names. The name ‘Whitechapel Bells’ is not the issue; Big Ben was a Mears and Stainbank bell. The continuity of a genuine Bell Foundry on this historic site is the critical issue for the preservation of our cultural heritage.
- The Hughes’ decision to license the Whitechapel Tower Bells to Westley will not impact the Factum-UKHBPT proposal.
- Site and building unsuitability: The Quartet viability appraisal used to justify the “site and building unsuitability” is not included as an appendix to the Planning Statement, and does not appear to be uploaded onto the LBTH planning portal as part of the Raycliff Whitechapel LLP planning proposal.
- Changing neighbourhood: the air quality and environmental aspects of the Factum-UKHBPT proposal are addressed by their environmental engineer, Dr. Neil Smith, Director, Max Fordham LLP Building Services Consulting Engineers. That the Hughes stripped out the original founding equipment before the sale was a regrettable heritage loss, but one that allows for upgrading equipment to meet 21st C environmental standards.

3 EXISTING EMPLOYMENT USE

- The bell and foundry market is not finite, nor does it need to be fragile. It can be grown to sustain the foundry activities not only in the listed premises at Whitechapel, but also to ensure that a steady flow of work is directed to other foundries with capacity to make larger bells, in the LBTH and beyond.
- The Mayor has highlighted the need for more, not less, industry and production in London. This is reflected in new planning and zoning legislation.
- The Mayor’s Office has identified the ‘Thames Estuary Corridor’ as a key creative production zone. It begins in Whitechapel and includes the Whitechapel Bell Foundry.
- The Mayor’s initiative proposes “an art foundry of 40 – 50 employees, a centre for creation and experimentation using the latest equipment and, state-of-the art facilities offering art casting, milling, scanning, digital mould-making and 3D printing”.
- The Whitechapel Vision Rejuvenation Prospectus produced by The London Borough of Tower Hamlets identifies the Whitechapel as “the birthplace of invention and innovation, typified by the world’s oldest business enterprise at the Whitechapel Bell Foundry”
- The Factum-UKHBPT’s proposal’s primary target is to connect bell-making and artist related found-

ry activities to new markets: in China, America and Europe

- Listed context and adaptation: the Bell Foundry buildings are best suited to Bell Founding; Raycliff's suggestion that upgrading them to a 21st C viable working foundry would cause 'harm'. Harm would be caused by turning them into a hotel, café restaurants and other leisure uses.

- There is a confusion between artists' studios and landlord-owned commercial desk sharing space.

It is precisely the development and intense commercialisation of properties like the Whitechapel Bell Foundry that forces artists out of their studio space, leading to the "sharp decline in artists studios and maker spaces" across London as identified by the LBTH and GLA.

4 OCCUPANTS AND OPERATIONAL HOURS

- The proposed increase in occupants on the site (from under 30 to many hundreds) which is to operate 24 hours a day, with multiple alcohol licenses operating in the hotel, café, restaurants, bars, private members' club, and event spaces, makes a very unconvincing argument that there will be no disruption to neighbours, who include the nearby mosque.

5 SUMMARY OF CONSULTATION

- Some of the statements about the re-employment of former Whitechapel Bell Foundry workers are untrue and misleading. E.g. that seven former Whitechapel Bell Foundry employees are employed by the Hughes'

- The outcome of the Public Consultation has been carefully edited to remove any negative feedback.

- E.g. The East End Preservation Society (listed as of unknown opinion) set up a petition on Change.org to "Save The Whitechapel Bell Foundry", directed to Tower Hamlets Council, Mayor of London and Minister of Culture and Sport. To date, there have been 12,522 signatures.

- Historic England were not made aware that there was a UKHBPT proposal to keep bell founding alive at the historic site when they gave their advice.

- There has been no consultation with the neighbouring mosque.

The UKHBPT is Britain's preeminent industrial heritage charity owning assets such as Middleport Pottery in Stoke, the oldest working Victorian Pottery.

As the successful Middleport Pottery so admirably demonstrates it's not so much the buildings that are important but what goes on within them and which activities give pride and employment back to the local community. Without its reason for being as a genuine foundry the Whitechapel buildings will become a mere hollow shell and its National and International importance lost for ever.

INTRODUCTION

In March 2017 the United Kingdom Historic Building Preservation Trust (UKHBPT) approached Alan Hughes, the then owner of the Whitechapel Bell Foundry, with a proposal to ensure the continuation of founding on this historic site. The UKHBPT offer was reiterated in a letter published in the Times on March 21, 2017. In April 2017, Dan Cruickshank and representatives of leading heritage groups delivered a petition of more than 10,000 signatures to Karen Bradley, Secretary of State for Culture and Sport.

In June 2017, the historic Whitechapel Foundry was acquired by Raycliff Whitechapel LLP, and the use of these Grade 2* buildings for the making of bells, such as Big Ben, the Liberty Bell and the Bow Bells, ceased. Despite the historic listing, the original equipment was stripped out in anticipation of the commercial redevelopment of the buildings.

In June 2018, a proposal by Factum Foundation and UKHBPT, 'Saved by the Bell! The Resurrection of the Whitechapel Bell Foundry', was made public. This was prepared by Factum and UKHBPT, architects Skene Catling de la Peña and Purcell, structural engineers, eHRW, services engineers, Max Fordham, heritage consultant Dr. Nigel Barker Mills, and planning consultants, Lichfields. The Factum - UKHBPT proposal sets out a different future for the building which would see the continuation of a genuine, viable foundry with the resultant employment, skills retention, life and vitality.

In June and September 2018, Raycliff Whitechapel LLP held public consultations around their hotel scheme proposals, during which the immense strength of feeling towards the historic foundry, and resistance to another boutique hotel, was made clear. On January 2, 2019, Raycliff Whitechapel LLP, submitted a planning application which seeks to secure change of use and development of the site as a '4-5 star' 108-bed hotel, private members club, restaurant, bar, café and shop, with desk-sharing work spaces. As a caveat to the planners and general public, the proposal is described first and foremost as the 'reinstatement of a foundry'. It contains references to a 'viable and sustainable working bell foundry'. However, this is misleading; the proposed activity on site is not of a scale to be a viable industry.

The founding activity on site in the Raycliff Whitechapel proposal has been reduced by nearly 90%, to a small shop and studio for the casting of hand bells, three days a week, in a corner of the restaurant and café. By reducing the founding activity to window dressing and entertainment for customers of the restaurant, bar and café means the essential heritage activity of the site has been lost. This is not surprising as the continuation of genuine foundry activities on the site is incompatible with the operation of a hotel, bar, restaurant and other leisure activities.

PURPOSE

The planning proposal PA/19/00008/A1 is accompanied by approximately 180 reports and drawings that can be overwhelming to the non-professional and professional alike. This document aims to extract the salient points, and to clarify and correct certain statements and assumptions made in the Raycliff Whitechapel LLP planning proposal. This document makes direct and clearly legible diagrammatic comparisons between the Raycliff Whitechapel LLP and the Factum-UKHBPT proposals, and between these and the original foundry. This is not an architectural critique of the Raycliffe Whitechapel proposal. The aim is for the reader to fully understand what is being proposed as the basis for making an informed decision about the future of the Whitechapel Bell Foundry: bell foundry, or bell-themed luxury hotel and leisure development.

This document is to accompany the 'Saved by the Bell! The Resurrection of the Whitechapel Bell Foundry' proposal, which contains detailed descriptions of how a 21st century bell foundry would operate, statements of support by artists, architectural historians and Nigel Taylor, the former Tower Bell Manager at the Whitechapel Bell Foundry. Change of use would not be necessary for the Factum - UKHBPT proposal. Bells have been made in Whitechapel since 1571 and London should not countenance this cultural asset-stripping, and the loss of such valuable national and international heritage.



*Shopfront at the east end of
32-34 Whitechapel Road
in 2010.
Courtesy of Historic England
Archive, Derek Kendall.*

RAYCLIFF WHITECHAPEL LLP

PLANNING APPLICATION SUMMARY

Application Reference: PA/19/00008/A1

“Internal alterations including reinstatement of a foundry (B2 use) and ancillary uses; refurbishment of spaces to provide new workshops and workspace (B1 use), with cafe (A3 use) in listed old foundry.

External alterations to raise roof of hayloft building and create new link building. Demolition of unlisted 1980s building and wall to the rear. Erection of building along Plumbers Row and Fieldgate Street with hotel (C1 use) with ancillary members and guest uses in part 5, 6 and 7 storeys with x2 levels of basement, with restaurant/bar (A3/4 uses) at ground and mezzanine level and additional workspace (B1 use) on ground and first floors. Roof plant, pool, photovoltaics, waste storage, cycle parking, public realm improvements and associated works.”

PLANNING CONSENTS REQUIRED

P. 2 - Planning Statement

LISTED BUILDING CONSENT | It is assumed that all of the proposed physical works to the Historic Foundry as outlined in this submission require listed building consent.

This excludes any works to the 1980s building (and car park site), which do not form part of the listing.

PLANNING PERMISSION | Planning permission is required for the demolition of the 1980s building and boundary wall and the erection of the new hotel and restaurant/office building.

It is also required for external changes to the Historic Foundry, including the adaptation of the link building; roof works; and other external changes to windows and doors that have an external impact.

PART OF THE OLD FOUNDRY (243m²) requires a change of use from B2 industrial to A3 use to accommodate the proposed café.

THE REMAINING HISTORIC FOUNDRY will comprise of a mix of B2 and B1 uses.

Under Schedule 2 Part 3, Class I of the General Permitted Development Order, development consisting of a change of use of a building from any use falling within Class B2 (general industrial) to a use for any purpose falling within Class B1 (business) is permitted. The existing Historic Foundry building does not, therefore, require planning permission for the existing use to be converted from B2 use to B1. As physical changes are proposed, the uses are described in detail within Section 4.

FROM THE RAYCLIFF WHITECHAPEL LLP PLANNING STATEMENT AND FACTUM - UKHBPT OBSERVATIONS

This section is to clarify key issues surrounding the Whitechapel Bell Foundry. It addresses (and corrects where necessary) statements, assumptions and key points made in the Raycliff Whitechapel LLP PA/19/00008/A1 Planning Statement.

Excerpts below (in red) are from the Bell Foundry Planning Statement, Prepared by The Planning Lab, December 2018

Clarifications in black.

OVERVIEW OF PROPOSED USES

p.15 of Planning Statement

1.1 A NEW 108 ROOM HOTEL WITH ANCILLARY MEMBERS AND GUEST SPACE | This is partially located on the land that has an extant planning permission for a 4 storey, 34 room hotel block and 5 storey residential/office use. The hotel will be a quality offer, equivalent to around 4/5 stars rating, aimed at lifestyle market, which is in demand in the Borough and in London as a whole. The members and guests areas will be located on the upper floors, and will provide approximately 60-80 covers. It is expected that these will be run by the hotel operator, or by MFG in conjunction with the primary hotel use.

P. 16 - Planning Statement

1.1.1 As a “quality offer, equivalent to around 4/5 stars rating, aimed at lifestyle (sic) market”, and with private “members and guests” areas: this is not a scheme to serve the current local community.

1.2 A3 CAFÉ | The café will be accessible. Brought forward in partnership with The Major Food Group (MFG). A new glazed screen will separate the café space from the working foundry - an opportunity to watch the activity in the foundry whilst having a coffee or eating lunch. The café will be opened for use for events in the evenings. It is envisaged that there will be a mix of private events alongside other public events accessible to all. It is anticipated that the café will provide for approximately 50 covers.

P. 16 - Planning Statement

1.2.1 The Major Food Group (MFG) is a US based hospitality company, which currently operates eighteen restaurants in sites from Hong Kong to Las Vegas. They are, “very passionate about New York”, according to their web site. It is hard to see how this luxury food brand is best suited to serve either the (current) local population, or the best interests of the historic Whitechapel Bell Foundry.

1.3 A3/4 RESTAURANT AND BARS AT GROUND FLOOR | The publicly accessible bar and restaurant uses at ground and mezzanine level of the hotel will be run by MFG, the same operators as the Historic Foundry café. It will be informally organised and will accessible to anyone, not just hotel visitors (similar to how The Ned, in the City, or Ace Hotel in LBTH, operates). It can be used in conjunction with the historic spaces next door – through a link adjacent to the reception area. It also provides a space where anyone in the community can socialise and/or have informal business meetings, or work independently on a laptop. Approximately 170-210 covers will be provided at ground and mezzanine level.

P. 16 - Planning Statement

1.3.1 The developer claims that the addition of 50 covers in the café, 170-210 covers provided at ground and mezzanine level, an unmentioned number in the 108-bedroom hotel operating 24 hours a day with associated restaurant, bar and members' spaces, will not add any noise or disruption to the site or neighbours.

1.4 **BI WORKSPACE** | Additional B1 floorspace will be provided at ground floor and first floor level on an area of the site that already has permission for a 5 storey building for B1 office use and 9 residential flats above.

P. 16 - Planning Statement

The operators of Anatole Notes will also be managing and securing individual tenancies for the workspaces, mainly within the front range, which are not suitable for messy activities with more typical 'desk based' work envisaged. "These spaces will also include space at and below market rents".

P. 15 - Planning Statement

1.4.1 There is no indication of how this will function, or of how 'at market rents' will be applied against 'below market rents'. These levels of rent are not defined, nor are numbers of proposed beneficiaries. How would this be monitored / maintained in future? This appears to be a cynical way to maximise the income from the listed buildings to Whitechapel Road. Artists need genuine studio space, not the (highly profitable) "more typical 'desk based' work envisaged" i.e. desk-sharing, flexible work spaces.

OTHER USE/ANCILLARY PROGRAMME PROPOSALS

1.5 **INTERPRETATION SPACE** | The café and other public areas on the ground floor in the Historic Foundry will act as a 'living museum' that will be further enhanced through the reintroduction of loose equipment including dies, cast iron copes and moulds and other decorative presses. Items owned by the Westley's and/or the Hughes (currently stored in Stoke) have been documented by the team with many planned to be returned to the site. Raycliff has also purchased many of the original bells, (including the main carillon in the courtyard), and may commission new ones.

P. 17 - Planning Statement

1.5.1 The café and other public areas on the ground floor in the Historic Foundry "will act as a 'living museum'" and the forecourt to the 'bell themed boutique hotel.'

1.6 **ANCILLARY SHOP** | An ancillary foundry shop will be located in the front of the Historic Foundry building (within the former interpretation space that was used by the Hughes to display bell foundry historical information). The shop will sell small hand bells made by the Hughes.

P. 17 - Planning Statement

1.6.1 Exit through the gift shop.

1.7 **ANCILLARY EDUCATION** | Education programmes are inherent in the existing operations of AB, the Westleys and the operators of Anatole Notes. There is a strong commitment from all of these parties to devise suitable learning opportunities for members of the public, other professionals and school children in association with the businesses and activity on site.

P. 17 - Planning Statement

1.7.1 Unfortunately, by the nature of replacing the Bell Foundry with a café, hotel, restaurants, bars, a shop

and flexible desk-sharing work space, the subject of these education programmes will no longer exist in any meaningful form.

1.8 It is initially conceived that the mezzanine overlooking the foundry and/or the room in the front range, along Whitechapel Road may provide spaces for school children to watch a film and learn about Whitechapel Bell Foundry and other artistic/manufacturing techniques.

P. 17 - Planning Statement

1.8.1 The mezzanine “**may** provide spaces for school children to watch a film.” The Raycliffe Whitechapel

KEY PLANNING ISSUES

p.25 of Planning Statement

2.1 EXISTING EMPLOYMENT USE

Under Part 1 and 2 of Policy DM15 of the MDD, development should not result in the loss of active and viable employment uses, **unless it can be shown through a marketing exercise that the site has been actively marketed (for 12 months), or that the site is unsuitable for continued employment use due to its location, viability accessibility, size and condition.** Development that displaces an existing business can also be required to find suitable replacement accommodation within the borough, **unless it can be shown that the needs of the business are better met elsewhere.**

A similar policy is proposed in the emerging LBTH policy framework (Draft Policy EMP3) requiring marketing, or evidence of the use of the site being unsuitable or unviable for continued employment use; or demonstration that the benefits of the alternative outweigh the benefits of the employment use.

2.1.1 There was no “**marketing exercise where the site was actively marketed (for 12 months)**”. On the contrary, the Hughes, the then owners, were directly approached by UKHBPT who offered to continue the foundry business on its historic site. The continued use on its historic Whitechapel site and the rarity of the activity were the reasons for listing:

2.1.2 From the Whitechapel Bell Foundry List Entry Summary & History

“Historic interest: for the national cultural and industrial significance as the mid C18th site of a specialised industry known to have been located elsewhere in Whitechapel since the medieval period, where well-known bells including Big Ben and the Liberty Bell, were cast.”

2.1.3 The financial value of the site as a bell foundry site is negligible. The value of the same site as a ‘4-5 star’ boutique hotel, private members club, restaurants, bars, café and desk sharing space is substantial. Although the Hughes’ may not be the greatest beneficiary in the transactions to date, the decision was made to sell the site to a property developer rather than to the UKHBPT as an ongoing concern as a bell foundry.

2.1.4 The only proof of lack of viability of bell founding on this site has been provided by the Hughes. As there is a direct conflict of interest between the continuation of the site as a heritage asset, and the Hughes’ personal financial interests, an independent assessment must be called for.

2.2 The decision to relocate the existing operations and Bell Foundry business was made completely independently by the Hughes family after years of struggling against economic pressure and the unsuitability of this

site for the on-going large scale production of bells. The sale of the site and deeds were transferred in June 2017. The premises were vacated and the Hughes settled their affairs on site and made plans for the relocation of the business. The former Bell Foundry business continues with Whitechapel Bells made on sites where the business needs are better met (as summarised in **Appendix A**).

In the context of Policy DM15 (and Draft Policy EMP3) there is no active and viable employment use against which a 'loss of use' can be justified, since the Whitechapel Bell Foundry business would not have continued on this site regardless of Raycliff's purchase of the site and redevelopment plans. The production of Whitechapel Bells is also under strict patents and licences, which means that it would not be possible for an alternative operator to take up production of Whitechapel Bells on this site without the express permission of the Hughes (the Westley's are licenced to produce Whitechapel Tower Bells).

P. 25 - Planning Statement

2.2.1 The “**unsuitably [sic] of this site for the on-going large scale production of bells**”. Given that this is a collection of buildings that evolved over 300 years specifically for the purpose of making bells, it is difficult to see how the site would now be unsuitable for that purpose. Furthermore, it has been evaluated by Factum-UKHBPT with the conclusion that it is highly suitable for a 21st C foundry that would secure the heritage activity in-situ and its long-term future.

2.2.2 The bells produced at this foundry were made under many different ownerships and names since Elizabethan times. There have been many guardians of this unique piece of cultural heritage. The name is not the important issue; Big Ben was a Mears and Stainbank bell. The Hughes family ran the business from 1968, through its decline, before selling it in 2017.

2.2.3 From the Whitechapel Bell Foundry List Entry Summary & History

“The foundry originated with either Robert Doddes in 1567 or Robert Mot in 1572.... In 1716, the foundry, ran by Richard Phelps, made the great clock bell for St Paul's Cathedral.... His successor, Thomas Lester, moved the foundry to the current site, which had previously been occupied by the Artichoke Inn... Charles and George Mears ran the foundry from 1844-1859; Big Ben was cast here in 1858. From 1865, George Mears and Robert Stainbank ran the foundry **trading as Mears and Stainbank until 1968**. Arthur Hughes became foundry manager in 1884, and his descendants ran the business from **1968 to 2017**.”

2.3 “The production of Whitechapel Bells is also under strict patents and licences, which means that it would not be possible for an alternative operator to take up production of Whitechapel Bells on this site without the express permission of the Hughes (the Westley's are licenced to produce Whitechapel Tower Bells).”

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2.3.1 “Can Bells be patented? - Bells have been patented in the past, but not by any of the more modern foundries. It is difficult to patent a profile unless you adhere rigidly to it, and founders have varied their profiles. Bellfounders and hangers have patented fittings, such as self-aligning plain-bearings, but this is not relevant to [Factum-UKHBPT].”

“Can alloys be patented? - Bellfounders use much the same alloy so this would be well-nigh impossible. If a founder found a magic additive, then perhaps a patent could be applied for. The only rights will be to the Whitechapel logo and Westleys have ceased using this.”

Nigel Taylor, former Tower Bell Production Manager at the Whitechapel Bell Foundry

2.4 SITE AND BUILDING UNSUITABILITY | There were many reasons why the site at Whitechapel was no longer suitable for large scale bell manufacturing across the whole of the historic site and 1980s building. Some of the principal factors that contributed to the Hughes decision to relocate are summarised in a **viability appraisal prepared by Quartet**: this highlights the market conditions and unsuitability of the location, the unviability and issues with accessibility, size and condition of the premises.

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2.4.1 The Quartet viability appraisal is not included as an appendix to the Planning Statement, and does not appear to be uploaded onto the LBTH planning portal as part of the Raycliff Whitechapel LLP planning proposal.

2.5 Of note there is declining demand with insufficient work to require the full use of a site the size the Bell Foundry, let alone maintain the upkeep and reinvest in the fabric of the listed buildings, pay employees and other associated running costs and licences.

P. 25 - Planning Statement

2.5.1 The Factum-UKHBPT proposal is for a 21st C foundry. Through this partnership, the WBF can again become a viable foundry that specialises in bells but can also produce special edition artworks in bronze and other materials. This proposal is detailed both in this document, and at greater depth in, 'Saved by the Bell! The Resurrection of the Whitechapel Bell Foundry'.

2.6 SIZE, LAYOUT + CONDITION | A detailed conditions survey for the site undertaken by MFA confirms that the buildings on site fail to meet basic environmental performance standards. Works required to maintain the building's future stability and upkeep are identified in the proposals section on pg 9 and in the DAS. The incremental backlog of repairs that had been built up over many years mean that it will take a significant sum of money (extending into millions) to bring the building back into any use. The future use must, therefore, take account of this and must be sustainable to facilitate the investment that is going to be required to keep the buildings in use in the long-term.

P. 25 - Planning Statement

2.6.1 The buildings have functioned as a foundry since the 1740s. The Factum-UKHBPT proposal has been informed by professional advice including that of architects who specialise in historic buildings, structural and services engineers, planning and conservation consultants regarding the work and associated costs needed for restoring and - where necessary - upgrading, the existing buildings. Statements from the team – leaders in their respective fields – are found in, 'Saved by the Bell! The Resurrection of the Whitechapel Bell Foundry'. Nigel Taylor, former Tower Bell Production Manager at the Whitechapel Bell Foundry, who worked in the buildings for 40 years, has contributed to the overview of necessary repairs and upgrades necessary for the building to continue working as a 21st C foundry.

2.6.2 The environmental performance requirements for a 'quality offer 4-5 star hotel, restaurant, bar and café', are obviously very different to those of an B2 foundry site, and would require a completely different scale of financial investment.

2.7 Changing neighbourhood | It is also no longer suitable to continue a large scale B2 'general industrial' use in the context of the local area, which includes residential uses in close proximity to the site. The scale of continued B2 foundry use, as proposed by the Westley's and AB Fine Art Foundry is considered the maximum without causing wider impacts that may have a negative impact on the environment and living conditions of existing surrounding occupants. Air Quality impacts are an important consideration – in the context of

the Mayor's major drive to improve air quality across London. B1 light industrial and office uses are widely accepted as being more appropriate than B2 uses in residential areas. These are incorporated as part of the proposed scheme. LBTH has also designated Local Industrial Locations (LILs) where industrial uses are generally directed.

P. 25 - Planning Statement

2.7.1 The Factum-UKHBPT proposal for the site is not for 'general industrial' use, but the highly specific bell and art founding with associated 3D scanning, recording, educational and archival uses.

2.7.2 Air Quality impacts are an important consideration. While the Hughes' stripping out of the original founding equipment before the foundry was sold was a very regrettable heritage loss, it will allow for the upgrading of equipment to meet contemporary needs, and beyond.

2.7.3 The Factum-UKBHPT approach has been outlined by Dr. Neil Smith, Director Max Fordham LLP Building Services Consulting Engineers, "the Whitechapel Bell Foundry rejuvenation provides an opportunity to apply best practice sustainable design that carefully balances the energy and environmental performance required by the London Plan, with the heritage, cultural and economic needs of the existing foundry."

"The provision of new modern furnaces would allow waste process heat from the bell manufacturing to generate domestic hot water and space heating for the new archive/research centre, craft studios and worker accommodation. The waste heat can also be used for electricity generation through thermo-electric modules attached to the furnace flues. The heat generated in the furnace workshops has the potential through space planning to drive summer ventilation via convection of other parts of the foundry support spaces, such as the frame shop, and studios. Similar methods were regularly used in Victorian times, including the houses of parliament. Also such careful organisation of spaces around the furnace areas can be used to buffer the heat flow to outside."

EXISTING EMPLOYMENT USE

p.26 of Planning Statement

3.1 The following section outlines the other proposed replacement employment uses and partnerships formed ... this includes other established world class British founders, the Westley Group, who are licenced by the Hughes to produce Whitechapel Tower Bells. Alongside AB Fine Art, The Westleys will continue the tradition of making and producing, including bell and other art founding, in a viable and sustainable way, whilst also not competing with what remains of the fragile UK bell market (or other foundry businesses operating in LBTH).

3.1.1 The bell and foundry market is not finite, nor does it need to be fragile. It can be grown to sustain the foundry activities not only in the listed premises at Whitechapel, but also to ensure that a steady flow of work is directed to other foundries with capacity to make larger bells, in the LBTH and beyond. There are at least six foundries in London, and the Mayor has highlighted the need for more, not less, industry and production in London. The Mayor's Office has identified the "Thames Estuary Production Corridor" as a key creative production corridor. It begins in Whitechapel and includes the Whitechapel Bell Foundry. The initiative proposes "an art foundry of 40 – 50 employees, a centre for creation and experimentation using the latest equipment and, state-of-the art facilities offering art casting, milling, scanning, digital mould-making and 3D printing".

The Whitechapel Vision Rejuvenation Prospectus produced by The London Borough of Tower Hamlets identifies the Whitechapel as “the birthplace of invention and innovation, typified by the world’s oldest business enterprise at the Whitechapel Bell Foundry”

3.1.2 The Factum-UKHBPT’s proposal’s primary target is to connect bell-making and artist related foundry activities to new markets: in China, America and with many private individuals who are unclear about how to commission bells. As just one example, The Historic Charleston Foundation, South Carolina, US, has a network of 101 churches in its catchment with a significant number of bells made in Whitechapel. They are one of the supporters of the Factum-UKHBPT campaign and will assist in opening conservation markets in the US.

The 3D scanning and acoustic recording of bells around the country is aimed at long-term preservation but will also act as a diagnostic method for analysing the condition of bells.

3.2 LISTED CONTEXT AND ADAPTATION | The incremental growth and the nature of the former use has shaped the interior of the buildings over time. This coupled with the listed status of the Historic Foundry is an important consideration for any change or adaptation of the building – this was a major obstacle for the Hughes who had tried unsuccessfully to progress a number of adaptations over the years. Due to the current condition, size and layout of the listed building, accommodating an alternative B2 industrial use across the whole site, with its own specialist functions and requirements may be harmful. Inappropriate adaptation or heavy industrial use would be wholly damaging to the listed building and have a fundamental impact on the buildings character.

P. 26 - Planning Statement

3.2.1 The Bell Foundry buildings have been adapted over time to the very specific function of Bell Making. This is a fundamental part of their value in cultural heritage terms, and why the building is Grade II* listed. It is the loss of this activity and the Raycliff Whitechapel LLP’s proposal to replace it with a 108-bedroom hotel, restaurant and bars, with a café taking over the historic foundry that is harmful. By continuing bell founding - the original intended function - on the site, the buildings are ideally suited to accommodate Factum-UKHBPT’s proposal.

3.2.2 From the Whitechapel Bell Foundry – List Entry Summary & History:

“Reasons for Listing:

* Architectural interest: a distinctive, cohesive complex of domestic and industrial buildings spanning nearly 300 years of occupation including the dignified residence of the foundry owner at nos.32-34 Whitechapel Road, no.2 Fieldgate Street and the industrial ranges to the rear;

* Interiors: distinctive for the mid-C18th plan-form, and the mid-C18th and early-C19th shop fittings, wall panelling, chimney pieces, stairs, ironmongery and joinery in nos.32 and 34 Whitechapel Road, industrial workshops containing specialist bell-founding equipment, and the timber crane on the Plumbers Row frontage”

3.3 When the Bell Foundry was closed the majority of unlisted foundry equipment was sold and was removed from the site (under the supervision of the Hughes family and with the agreement of LBTH and HE). Much of it was relocated to other working foundries and continues to be in use. Any new or reinstated foundry use requires the purchase and reinstatement of all equipment (including furnaces). The addition of new industrial equipment in the historic spaces for a new B2 industrial use (which are by their nature practical and dirty spaces) in itself may harm the character and significance of the listed building. Much of the surviving equip-

ment may also need to be removed – and there is no guarantee that it could be cared for in the context of an unrelated industrial use, including other founding processes. It would also be a lost opportunity to provide public access to the historic site.

P. 26 - Planning Statement

In line with LBTH Policy DM15 (and Draft Policy EMP3), it has been demonstrated above why the unique bell foundry use could not continue across the whole site. The business' needs have been better accommodated elsewhere. It was not an active and viable use and was unsuitable for continued use as a bell foundry alone – or another generic large B2 industrial use, which could be more harmful to the local environment and its historic character, which is so intrinsically linked to bells.

P. 26 - Planning Statement

3.3.1 As above, it has not been demonstrated why the bell foundry use could not continue across the whole site on the Whitechapel Road. The site was not advertised. An offer was made to the Bell Foundry owner by the UKHBPT before the sale and was rejected. The only evidence to support these claims has been provided by the former owner who stood to gain financially by selling the empty site for development as a hotel, with a direct conflict of interests.

3.4 Under Schedule 2 Part 3, Class I of the Town and Country (General Permitted Development Order) development consisting of a change of use of a building from any use falling within Class B2 (general industrial) to a use for any purpose falling within Class B1 (business) is permitted. The existing foundry buildings do not, therefore, require planning permission for the existing use to be converted from B2 use to B1. Nonetheless, the proposals overall meet the objectives of Policy DM15 of the MDD, which supports the upgrading and redevelopment of employment sites within the CAZ and outside of spatial policy areas, such as the Bell Foundry site.

These will seek to directly target the sharp decline in artists' studios and maker spaces in London in accordance with LBTH and GLA's objectives. This includes genuinely affordable workspace within the Historic Foundry and other space that will be available to rent at and below market rents. These uses will be delivered alongside ancillary education, interpretation and other significant community benefits that will have long last and far reaching consequences for Whitechapel.

3.4.1 There seems to be a confusion between artists' studios and landlord-owned commercial desk sharing space. It is precisely the development and intense commercialisation of properties like the Whitechapel Bell Foundry that forces artists out of their studio space in the first place, leading to the "sharp decline in artists studios and maker spaces" across London as identified above by the LBTH and GLA.

3.5 Raycliff has formed partnerships with respected local organisations that are leaders in their fields to develop and deliver the final creative employment uses and selected tenants. As identified in Section 4, this includes AB Fine Art Foundry, who are already based in LBTH; the Westley Group, who will continue the production of Whitechapel Bells under licence, maintaining this important historic link to the site. Other confirmed partnerships with Anatole Notes (also with current studios in LBTH) and Studiomakers will deliver valued affordable maker and artist space, and creative office space to meet the strong demand identified.

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3.5.1 The Hughes family may have sold or licensed what remained of their business to AB Fine Art Foundry and the Westley Group. However, the cultural heritage value of the Bell Foundry lies in the continuity of bell founding on the historic Whitechapel Road site. A hotel, restaurant, bars and cafes cannot coexist with a

genuine foundry on this site.

3.6 SIGNIFICANT NEW JOBS GENERATED | Over 120 FTE new jobs are anticipated to be created in the new hotel within the retail elements of the scheme alone.

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3.6.1 Local jobs for the new hotel, retail and catering elements of the proposal will mean, almost exclusively, low paid, unskilled work. Through the Section 106 agreement, Raycliffe Whitechapel LLP are committed to advertise 20% of total jobs locally.

“The Council expect 20% of total jobs created in the construction and end user phases to be advertised to local residents through the Council’s job-brokerage service.”

OPERATIONAL HOURS

p.18 of Planning Statment

4.1 The final opening times are still to be established for the site as a whole. However, (subject to securing the appropriate alcohol licence), it is envisaged that:

- **HOTEL** | The hotel and ancillary areas will be a 24 hour operation, as is standard practice for most hotels in central London.
- **RESTAURANT AND BAR USES** | It is likely that the restaurants and bars on the ground floor of the new development will close to the general public at around midnight.
- **Café, interpretation and events spaces** | The café is likely to open to the public daily from around 8am and will also close at around midnight. The later closing time is more likely to apply if there is an event being held within the space.
- **OFFICE AND WORKSPACES** | The studios and workspaces will mostly operate in line with standard working hours during the day, but access will be required on a flexible basis to align with creative processes and/or particular tenant deadlines. It is likely that cleaning will also take place in the late evenings and early mornings.
- **FOUNDRY** | The foundry operations will predominately be a day time operation. It is anticipated that casting practices will take place approximately 3 days a week. The remainder of the time the space will be used for other refinement techniques and teaching. It is also envisaged that the equipment will be able to be used by other tenants within the building with the agreement of AB and The Westley Group.

4.1.1 The proposed increase in occupants on the site (from under 30 to many hundreds) which is to operate 24 hours a day, with multiple alcohol licenses operating in the café, restaurants, bars, private members’ club, hotel and event spaces, makes a very unconvincing argument that there will be no disruption to neighbours, who include the nearby mosque.

SUMMARY OF CONSULTATION

p.47 of Planning Statement

5.1 [Historic England] HE also attended the first number of meetings, whilst the initial heritage-led approach for the Historic Foundry was being devised, and the proposed uses were being considered. Initial correspondence from HE confirmed that they accepted that the foundry was no longer in operation and an alternative use for the site would be sought. HE welcomed the broad approach to development, and welcomed the potential for much increased public access.

5.1.1 Historic England were not made aware of the fact that the Hughes' – before selling to the current owner - were approached by UKHBPT with a proposal to keep bell founding alive at the historic site. The continual operation of a genuine Bell Founding operation, in-situ, is where the heritage value of the site lies. In the absence of the knowledge that the foundry could continue to operate as it has done on this site but with the viability and life introduced with 21st C techniques, makes the HE advice contained within the planning document obsolete. Their correspondence ends in May 2018. The Factum-UKHBPT proposal was made public in June 2018.

5.1.2 An excerpt from the statement made by the conservation consultant to Factum-UKHBPT, Dr. Nigel Barker-Mills in *'Saved by the Bell! The Resurrection of the Whitechapel Bell Foundry'*. Dr. Nigel Barker-Mills was Planning Director for the London Region until 2016, leading a team of 40 specialist Inspectors and advisors including architects, planners and surveyors providing the statutory advice and grant assistance across the capital. He retired from English Heritage (now Historic England, HE), in 2016.

“Following an approach by the Factum foundation setting out the campaign and proposals for the regeneration of the Bell Foundry, founded upon once again casting in metal, we were happy to provide heritage expertise pro-bono for such a worthwhile and in heritage terms, vital, project.”

“The Proposals and their impact upon significance

The proposals being developed for the complex by UKHBPT and the Factum Foundation for the future use of the complex are based upon a good understanding of the outstanding heritage interest of this site. The proposal to re-introduce bell casting, and repair, but using C21st techniques, provides a direct link back to the original purpose of the site and re-instates the golden thread of bell founding that has been an essential part of the identity of Whitechapel. It was the purpose for which the complex was created and on the evidence of the scheme as developed so far, will not cause any harm or raise any substantial issues for the surviving historic fabric or architectural interest of the buildings.

The proposal for the centre for the study of historic bell casting will enhance the historic significance of the heritage asset by increasing the understanding and appreciation of its original purpose. The proposed use will be an appropriate response to the historic character of the complex and the additional opportunities presented through apprenticeships and heritage education will also enhance its cultural value. The recognition that there is a need for a new chapter for the foundry, but one that respects and responds to its unique heritage and cultural value underpins the proposals. Securing the future of the building in this manner would be a heritage benefit by enabling the heritage asset to survive and continue to illustrate the long history of manufacturing on this site. But importantly it would also be a wider public benefit for the local, national and international communities for whom this unique site has great value.”

5.2 OTHER GROUPS AND NEIGHBOURS

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5.2 SPITALFIELDS TRUST AND EAST END PRESERVATION SOCIETY | EEPS provided little direct feedback, however, The Spitalfields Trust were very interested in design details, and were very enthusiastic about the restoration of letting across the parapet on Whitechapel Road. They stated that they did not want the interiors to be bland, and supported “interesting historic paint schemes”.

5.2.1 The outcome of public consultation has been edited to the point of being misleading. For instance, “EEPS provided little direct feedback”. The East End Preservation Society set up a petition on Change.org to “Save The Whitechapel Bell Foundry”, directed to Tower Hamlets Council, Mayor of London and Minister of Culture and Sport. “We the undersigned wish to publicly register our very serious concern about the imminent loss of the Whitechapel Bell Foundry. We are very concerned that we will lose not only specialized jobs and skills, but that this type of business and trade is part of the historic essence of our towns and cities. How is Britain allowing this national treasure to slip through our fingers?”. To date, there have been 12,522 signatures.

<https://www.change.org/p/the-east-end-preservation-society-save-the-whitechapel-bell-foundry>

5.3 UKHBPT | The charity, UKHBPT wish to bring forward a proposal to develop the Bell Foundry site itself and wish to see a foundry reinstated across the whole site. It does not have any ownership rights and no legal means of implementing its own scheme. Raycliff and its professional design team has met with this group on numerous occasions and have offered them the opportunity to present ideas to incorporate into the scheme, providing it can be demonstrated that there is a sound viable and sustainable plan to support any ideas. This has not been forthcoming, and as has been demonstrated, there are many reasons why this is not a viable proposition here. Nonetheless, Raycliff has developed its proposals with the Hughes (the former owners of the site, who have relocated their business elsewhere) and formed local partnerships with world leading expertise in founding and historic links to Whitechapel Bells. They will bring this forward in conjunction with a sound commercial plan that will secure the future of the Historic Foundry building for generations to come.

5.3.1 The UKHBPT did willingly meet with Raycliff and its professional design team to see whether it would be possible to continue a genuine foundry on the site in collaboration with the Raycliff Whitechapel LLP. Raycliff made it clear that they were unwilling to reduce, or relocate from the historic foundry, the café and events spaces, and thereby to allow sufficient space for genuine founding activity to take place on the site. They have, however, since the first public consultations, superficially incorporated many of the activities and intentions described in the Factum-UKHBPT proposal into their planning application, PA/19/00008/A1.

APPENDIX A | CURRENT BELL BUSINESS OPERATIONS P. 52 - PLANNING STATEMENT

THE BELLS OF WHITECHAPEL LTD: A newly formed company owned by the Hughes based in Bromley, now make a range of small handbells, clock and presentation bells and their accessories. It also undertakes repairs of existing small bells. The pattern equipment and tooling for the manufacture of these items remains in the ownership of Whitechapel Bell Foundry Ltd. **7 former employees of the Whitechapel Bell Foundry remain involved in this production to run the sales office, others mould the bells at another foundry site [the Meybrey Reliance Foundry], and Whitechapel Handbells tune and fit the bells in their workshops.** The small furnace previously at Whitechapel Bell Foundry continues to be used to cast these bells. All skills

and items required to manufacture this range of bells have therefore been successfully transferred to continue exactly as they were at the Whitechapel Road site. Customers / repeat business from former clients includes:

- The Royal Household
- Network Rail (overhead warning bells);
- The Met and London Ambulance Service (commemorative bells as part of retirement packages);
- Lindley Company (engraved handbells/gifts)

P. 52 - Planning Statement

Some of the statements about the re-employment of former Whitechapel Bell Foundry workers may be misleading. “Seven former employees of the Whitechapel Bell Foundry remain involved in this production to run the sales office, others mould the bells at another foundry site [the Meybrey Reliance Foundry]”.

PLANNING USE OF THE EXISTING FOUNDRY

LAWFUL PLANNING USE

P. 8 - Planning Statement

The primary use and purpose of the former Bell Foundry building was to manufacture bells. The use class of the building is deemed to be a B2 ‘General Industrial Use’. This is reflective and concurrent with the operations on site, which included the full range of bell manufacturing and related sales activities: the casting of tower bells and smaller hand bells; tuning, polishing, carpentry and framing repairs), and is taken as the existing use of the building. A range of ancillary uses also supported the main function and production element.

This included:

- **OFFICE/ADMINISTRATION FUNCTIONS AND SALES** directly related to the main production use were all undertaken on site.
- **A SMALL ANCILLARY DISPLAY AND INTERPRETATION SPACE** was also provided in the front range, along Whitechapel Road.
- **VISITOR TOURS** were provided with approximately 22 pre-arranged visitor tours of the building per year (with 35 people per tour). Tours were also given to visitors who walked in off the street. Tours were guided by the Hughes family who ran them every other Saturday afternoon when the foundry was not operational. It was too hazardous to do this otherwise.
- **LIVING ACCOMMODATION** was within various parts of the front range across no. 32 and 34 and occupied by the family running the foundry and/or other associated worker (foremen) who had a functional requirement to be on site. A residential use has never been lawfully established as a separate planning unit in its own right. Of note, the living areas have changed quite regularly over the years, many becoming interspersed with the business operations. Bills, such as electricity/gas and water are also linked to the wider business and not able to be separated out.

Overall, the former Bell Foundry incorporated approximately 872m² of workshops and production space (i.e B2 employment generating space), alongside 575m² of space ancillary to the primary B2 use as summarised above). Currently the site is mostly vacant. Live in guardians are temporarily living across a small part of the site to ensure that it is not neglected, or subject to vandalism or inappropriate use during this period.

THE WHITECHAPEL VISION REJUVENATION PROSPECTUS

In the *Whitechapel Vision Rejuvenation Prospectus* of 2015, Tower Hamlets Council identified the worldwide importance of the Whitechapel Bell Foundry. Factum - UKHBPT offers the opportunity to introduce innovation and education at a world class level through the continued operation of the world's oldest business on site. This should not be lost and replaced with yet another hotel, bar and restaurant.

“No more was Whitechapel at the centre of national attention than during the tragic murders committed by Jack the Ripper, the Siege of Sidney Street by Winston Churchill and the Second World War bombing of the East End. However, Whitechapel is also the birthplace of **invention** and **innovation**, typified by the world's oldest business enterprise at the **Whitechapel Bell Foundry**.”



WBF



WBF

The Spatial Concept

- Core Retail
- Mixed Leisure/ Retail
- Cultural, Community and Creative Quarter
- Med-City Campus
- Civic Hub
- Living
- Education
- ★ High Street Gateway
- ↔ Key Route

The Whitechapel Bell Foundry lies within the Cultural, Community and Creative Quarter of Tower Hamlet's Whitechapel Vision along its key route on the Whitechapel Road.

THAMES ESTUARY PRODUCTION CORRIDOR

The mayor's office has identified a key creative production corridor. It begins in Whitechapel, and includes Whitechapel Bell Foundry. Rather than constructing a new craft facility modeled on a Swiss organisation, the site and ingredients are already in place.

“Our vision for the world's largest creative production corridor is bold. It will position London and the South East as a world leader for the creative industries on a scale never seen before” - Sadiq Khan

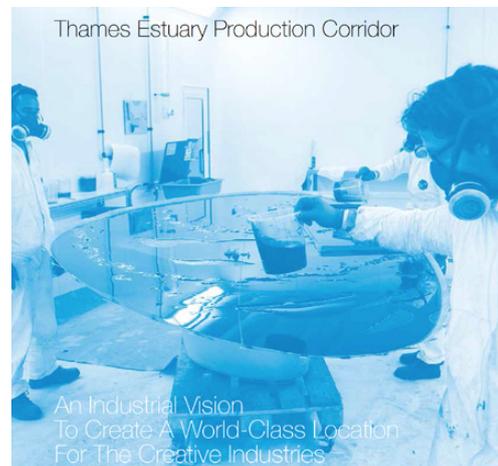
“The Estuary's manufacturing legacy provides a unique opportunity for new industry. A skilled local workforce – from fabricators to metalworkers - already exists.”

“The UK Commission for Employment and Skills predicts 1.2 million new workers will be needed in the sector over the next decade. Yet there are significant risks to creative infrastructure posed by rising land values, rents, business rates and skills shortages.”

EXAMPLE

The Kunstgiesserei, Switzerland

“This Swiss art foundry is an example of a large-scale craft facility and has 40-50 employees. International artists are attracted to this European centre for research and experimentation to develop ideas using the latest equipment and technologies. State-of-the-art facilities offer art casting, milling, scanning, digital mould-building and 3D printing.”



Case Study: International Art Foundry



“World class pieces for the Fourth Plinth often have to be built elsewhere in Europe, **because more space is given to consuming products and not enough to making them.**”

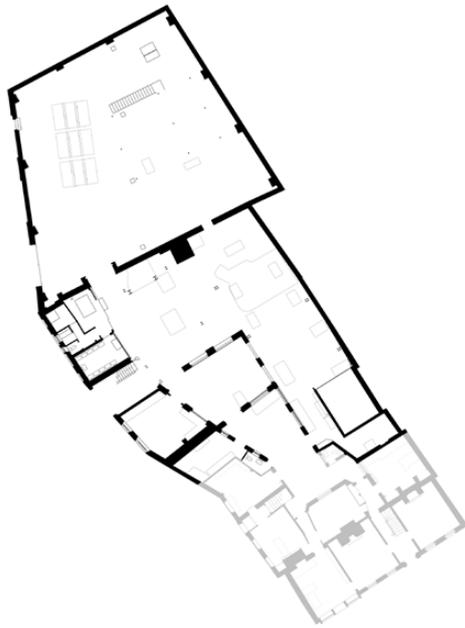
FACTUM - UKHBPT GROUND FLOOR

The existing ground floor entrance lobby will continue to provide public access to the site. The 18th century buildings on Whitechapel Street will also house office and admin, with some exhibition and demonstration spaces. The existing foundry spaces, will remain as foundry spaces where large scale casting, finishing and tuning will take place.



- Foundry - 707 m²
- Office, meeting and admin - 76 m²
- Public access - 61.5 m²

FACTUM - UKHBPT
GROUND FLOOR
 The Foundry



Factum Arte works with a cluster of specialist foundries who use state-of-the-art output methods including high resolution CNC milling and 3D printing in wax, resin and a range of materials to produce complex forms for casting in different materials. Computer aided flow models and shrinkage projections are transforming the foundry arts. Innovation always goes hand in hand with experience and Factum foundry has been in close dialogue with Nigel Taylor who worked at the WBF for 40 years and will return to work with the new foundry, reinstated as the bell foundry manager. Adam Lowe, founder of the Factum Foundation has also met with the previous owners and stressed that the goal is to be inclusive as the foundry is revitalized. The merging of the past and future of foundry work, as well as connecting fine art and industrial casting will present many educational and employment opportunities and provide a vital resource in Whitechapel with international potential.



Casting bells at Whitechapel in 1997 with the traditional loam and greensand method



CNC milling aluminium.



Centrifugal Casting.

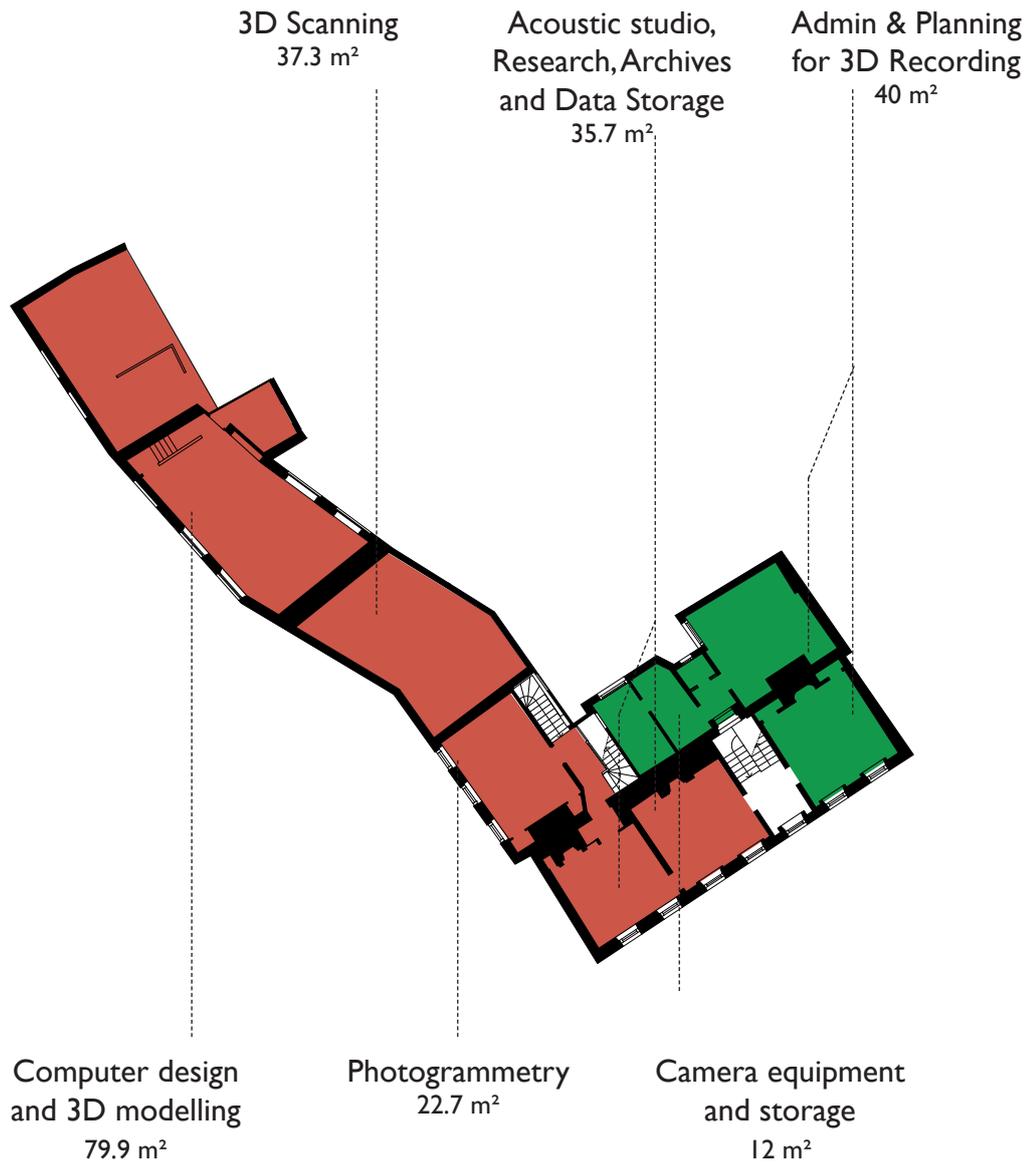


The head of Marina Abramovic cast in salt.

FACTUM - UKHBPT PROPOSAL

FIRST FLOOR

In order to thrive as a working, forward-looking enterprise, the Whitechapel Bell Foundry will diversify and update its bell casting techniques and materials while integrating the latest technology in 3D recording and output methods, acoustic recording and multispectral photography. These new modes of production and design will be housed in the upper floors of the Bell Foundry.



Foundry related production- 176 m²

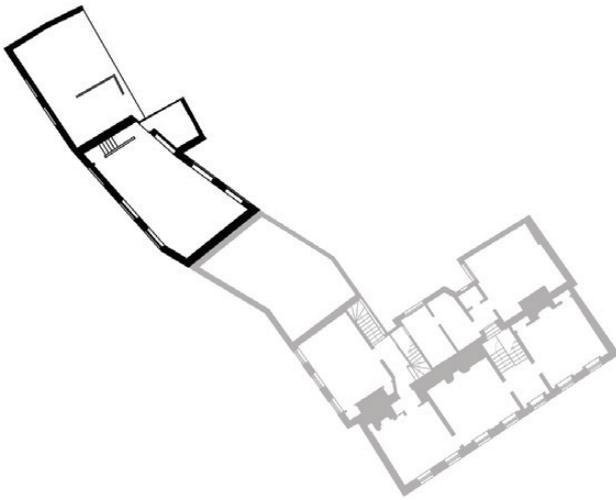


Foundry related office, meeting and admin - 57.1 m²

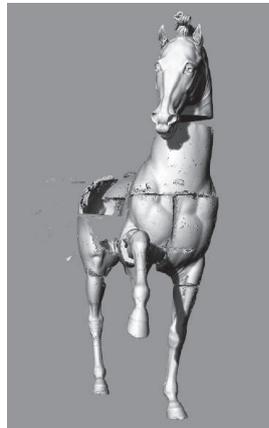
FACTUM - UKHBPT PROPOSAL

FIRST FLOOR

Computer design and 3D modelling



Computer design and 3D modeling will allow for the production of complex and intricate forms casting. This area will also form an integral part in the process of preservation and restoration. Factum Foundation is committed to using new technology in innovative ways to demonstrate the difference between preservation and restoration. The preservation of cultural objects can use an experimental approach to non-contact digital restoration as a powerful tool to educate a diverse audience about the problems of preserving the articulate evidence of the past.

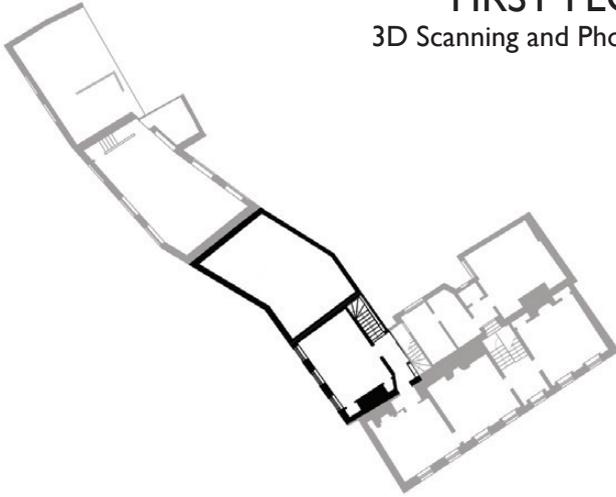


Left to right:
Canova's horse reconstruction
process by Factum Arte.
Neutron scan.

FACTUM - UKHBPT

FIRST FLOOR

3D Scanning and Photogrammetry

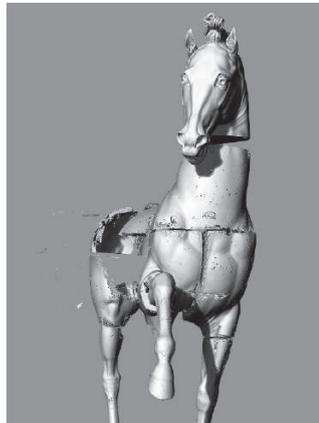


3D scanning is becoming an integral part of foundry work around the world. Objects are scanned in three-dimensions, at high-resolution, they are then 3D printed or CNC milled in preparation for moulding and casting. Factum Arte already employ this technique in conjunction with foundries in Spain and the UK, producing works of art and facsimiles of enormous complexity. Some of this work will be transferred to the new foundry.

From the Veronica Scanner; that catches fine surface detail, to the Lucida Scanner that obtains high resolution recordings of low relief objects, Factum employs a vast array of scanning technologies that allow for a broad depth of information to be captured and recorded. Many of the technologies, including the Veronica and Lucida Scanners, were designed in-house.

The use of 3D scanning in bell-founding would bring this traditional craft into the 21st century. Scanning and 3D modelling technologies also provide an efficient method of producing new bells and making commemorative bells of different sizes.

Scanning technologies will be used to record existing bells, capturing their shape and decorative pattern with scientific accuracy. If these recordings are carried out alongside acoustic recording the result will be an archive for condition monitoring, preservation and the careful study of this crucial part of our cultural heritage.



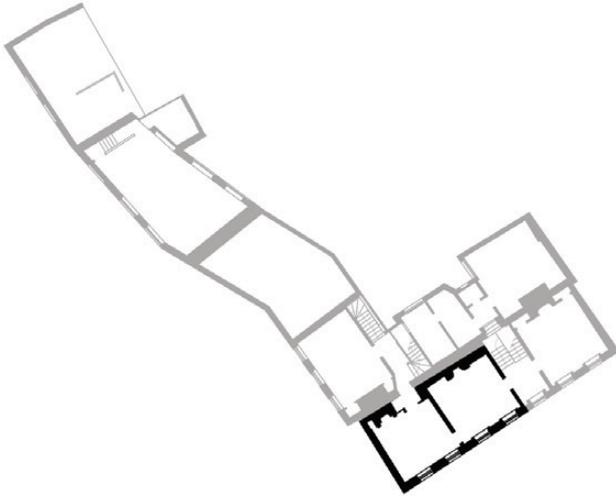
Right

Canova's horse reconstruction process by Factum Arte

FACTUM - UKHBPT

FIRST FLOOR

Acoustic studio, Research, Archives and
Data Storage



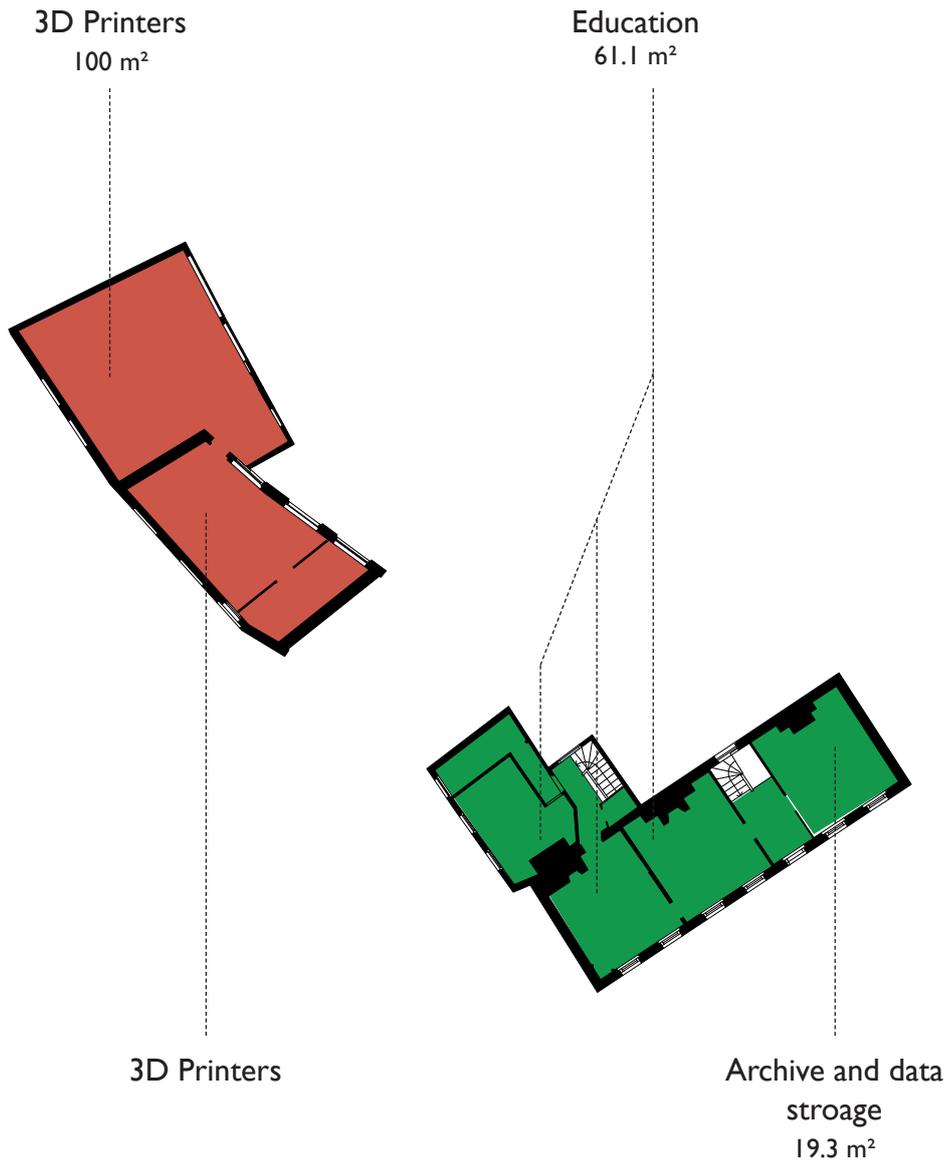
Digital preservation of existing bells will be an important part of the new foundry.

The 3D and acoustic recording of existing bells around the country will become the basis for a campanology archive at the WBF – an archive of this kind is sorely lacking in the UK, which has long been a centre of bell-making and bellringing. Factum Foundation's unique 3D scanning and training skills will establish a small full-time team who will be able to systematically record all the bells in the country. This will take many years but will be the type of project that can support the work on Art UK and the Public Catalogue Foundation. Lidar scanning, white light scanning and photogrammetry will be used to record the shape and decoration of each bell. Working with the sound engineer Nathaniel Mann and the acoustics team at Max Fordham, a sound archive will accompany the 3D recording.



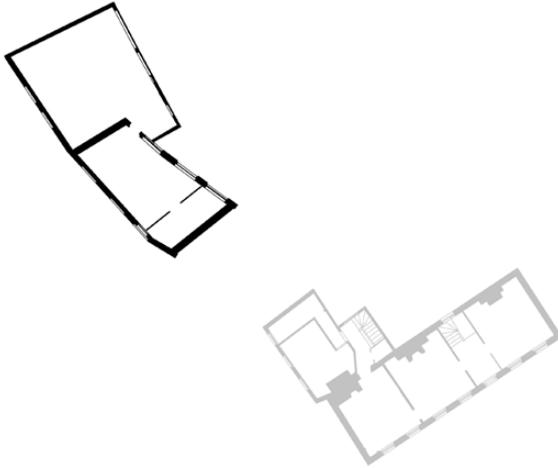
Bells at St. Mary's
Church, Lübeck.

FACTUM - UKHBPT SECOND FLOOR



- Foundry related production - 100 m²
- Office, meeting, admin and education - 107 m²

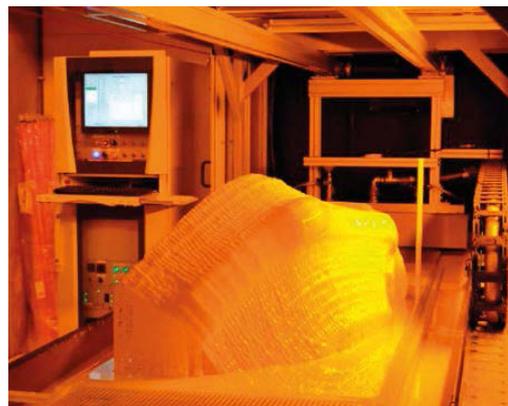
FACTUM - UKHBPT
SECOND FLOOR
3D Printers



Factum Arte works with a cluster of specialist foundries which use state of the art output methods, 3D printing in wax, resin and a range of materials to produce complex forms for casting in different materials.

Nigel Taylor (an ex-employee of the WBF) aims to start a fundraising campaign with other foundries to draw attention to the great bells of the past and create a range of scale replicas appealing to different audiences.

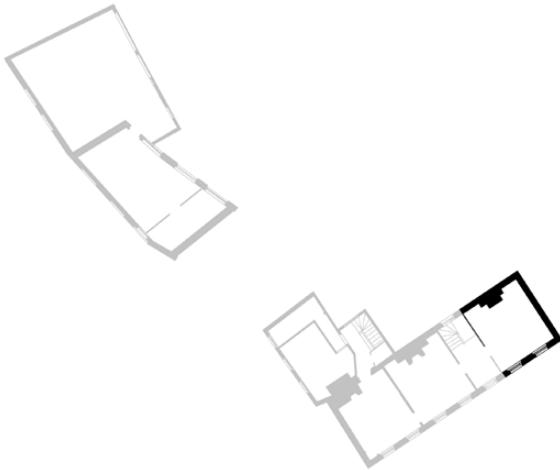
The original patterns are not available, so new patterns will be manufactured utilising computer aided design and 3D printing to create accurate scale models. These could include the Liberty Bell, Big-Ben, The Olympic Bell, The Lutine Bell. These commemorative bells can be manufactured alongside other specialist castings.



Above:
3D printed miniature for
the Magic FLute opera set
produced by Factum

Materialising with a SLS
printer.

FACTUM - UKHBPT
SECOND FLOOR
Archive and data storage



The archiving process that will be in place at the Whitechapel Bell Foundry systematically recording the countries bells will be bolstered by the expertise brought by Factum's involvement in ARCHiVe.

In October 2018, Factum Foundation, Fondazione Giorgio Cini, and the Digital Humanities Laboratory of Ecole Polytechnique Fédérale de Lausanne (DHLAB-EPFL) launched ARCHiVe - Analysis and Recording of Cultural Heritage in Venice, a new initiative dedicated to the use, study and transmission of cultural heritage through digital technologies.

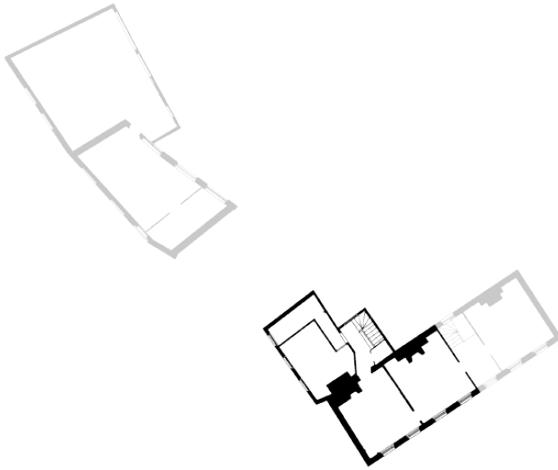
The three partners share the belief that digital conservation is leading to a deeper understanding of works of art and cultural heritage. Hence, it is an epoch-shaping opportunity bound to have a big impact on both research and education. Within this vision, research independence is a key value for guaranteeing the unconditioned progress of science and scholarship and the availability of the results of free and unrestricted research for the benefit of society.



Above:
The Replica 360 Recto/Verso scanner at
ARCHiVe

Image of the Cellini Bell being recorded using
photogrammetry

FACTUM - UKHBPT SECOND FLOOR Education



As well as being a centre for innovation and creation, the Foundry will also become a place of education.

Factum Arte has been aiming to share its process of digital recording and data capturing with the hope of expanding and enhancing techniques of preservation and conservation.

ARCHiVe, based in Venice and which Factum is heavily involved in includes a workshop and educational space dedicated to research for technology in the digital preservation of cultural heritage and archives.

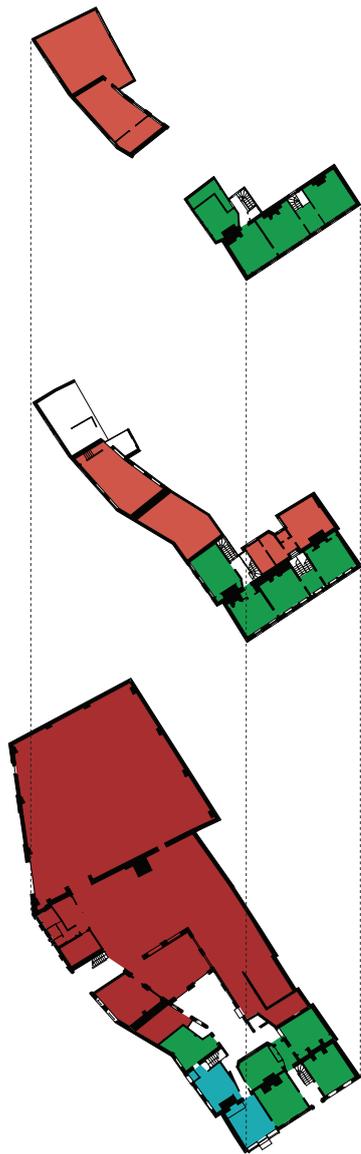
ARCHiVe focuses on transferring skills and technologies through specialised training programmes. This approach ensures local guardianship and has the potential to generate income at a local level. These training programmes take a step further compared to any other classical educational programmes as they are a hub gathering people from many different boards such as the growing community of electronic engineers, software writers, IT specialists, archivists, cataloguers, conservators and students from a wide range of disciplines.

Around the same time of ARCHiVe's opening in October of 2018, Factum Arte carried out a training programme in the culturally rich area of Al-Ula, Saudi Arabia, teaching locals how to record cultural heritage in 3D using photogrammetry. This demonstrated how preservation of cultural heritage can be taught in a matter of days, allowing this valuable skill set to be shared and passed on.



Above:
The Replica 360 Recto/Verso scanner at
ARCHiVe

The classroom at the Shaden Resort.

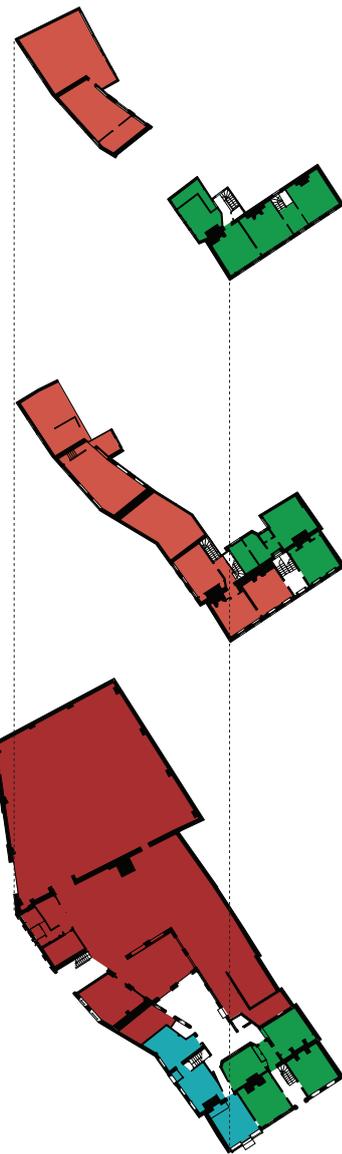
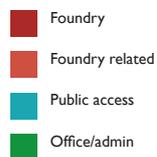


Whitechapel Bell Foundry

Foundry - 55.7%

Foundry related production - 17.7%

(Percentages of total building floor area)

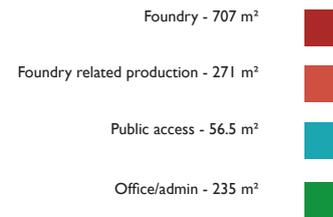


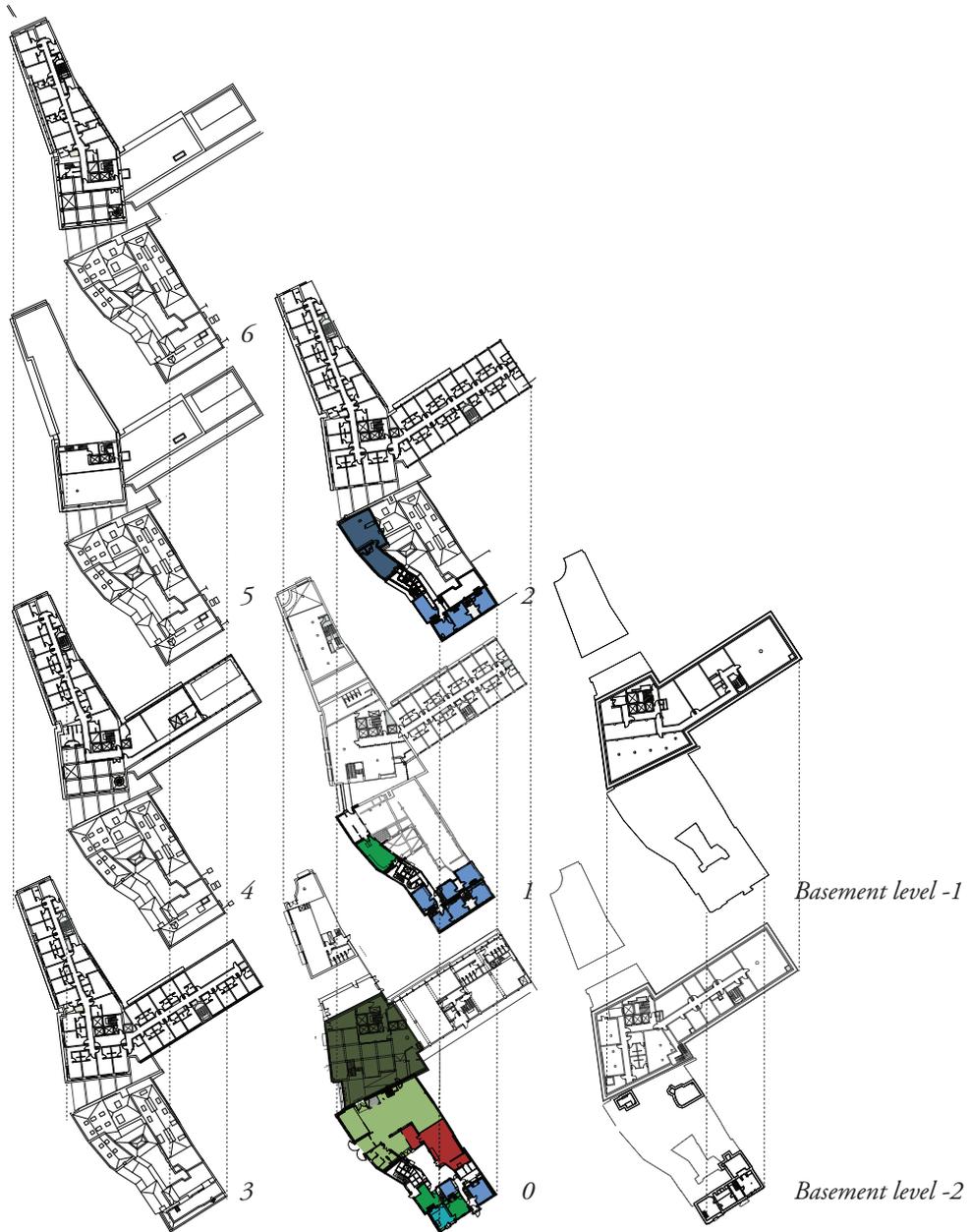
UKHBPT - Factum Proposal

Foundry - 55.7%

Foundry related production - 21.34%

(Percentages of total building floor area)





The Raycliff Whitechapel LLP Proposal

Foundry - 6.7%

Foundry related production - 0%

(Percentages of total building floor area)



Drawings taken from the Raycliff Whitechapel LLP Planning Application December 2018.

(PA/19/00008/A1)

HERITAGE VALUE WITHIN ALAN BAXTER REPORT

84% of the cafe lies in an area of significant and highly significant heritage value.

The foundry is being removed from areas of highest historical significance and replaced with cafe, while **34%** of the diminished foundry is in an area of neutral significance, altered in the 1960s.



Information taken from The Bell Foundry Heritage Statement, Alan Baxter Ltd, December 2018.
It forms part of the Raycliff Whitechapel LLP Planning Application, PA/19/00008/A1

RISK TO HERITAGE



AREA AT RISK

Area of significant heritage value, part of the Bell Foundry's construction during the 1800s. Having a two-storey basement directly adjacent and a six-storey structure above will put this area at risk. The need for significant structural change will be inevitable.

Information taken from The Bell Foundry Heritage Statement, Alan Baxter Ltd, December 2018.
It forms part of the Raycliff Whitechapel LLP Planning Application, PA/19/00008/A1

(PA/19/00008/A1)

STAFF STATEMENTS

Nigel Taylor

“The closure of The Whitechapel Bell foundry in June, 2017, ended, for now at least, almost six hundred years of bell founding in the Whitechapel area. My part in the foundry’s history was relatively small; forty years, but in that time, I learnt every process of designing and manufacturing church bells, becoming Tower Bell Production Manager. The techniques used during the period I was employed at the foundry were modifications of ancient techniques. I implemented a number of alterations and improvements to our casting methods. By 2012, sand and clay quarries were increasingly being given over to landfill, so sourcing appropriate traditional materials became ever more difficult and we were considering alternatives. When the foundry closed, its former owners sold all the moulding equipment and a vast amount of industrial history was lost.

We will need to totally re-equip the premises, but this presents the opportunity to obtain modern equipment and to employ state-of-the-art moulding and casting techniques which produce a consistently higher quality than that attained with the traditional methods. Before this happens the poor condition of the fabric of the existing buildings needs to be addressed. The foundry roof requires repair/replacement and the walls require damp-proofing. The electrics require modernisation, especially the fuse boxes. The extraction system needs completely rethinking in order to create a foundry that meets C21st standards. The former oil-fired furnaces can be replaced by modern, low-emission furnaces that are better for the environment and tend to produce castings with lower contamination and higher quality. A modern plant to process resin-bonded sand (which is far stronger than the previous ‘greensand’ moulding) will be installed along with vacuum casting and centrifugal casting systems. The foundry will require improved lighting, modern workbenches and an organised pattern storage area. A digital studio and 3D printing and CNC milling area will be required. A complete plan of the different uses will be prepared. The intention is to create a vital new foundry and training/archive/educational centre within the existing buildings without altering the fabric of the listed buildings. There is ample space for a shop to sell products manufactured on the premises. The offices can be adapted for website design, internet sales, social media, computer based work and a communications department to advertise the re-vitalised foundry and its services.

There are two foundries still casting large bells in the UK; the Westley Group in Stoke-on-Trent and Taylor’s of Loughborough. The bell foundry community is small and everyone knows each other. I have been work-

STAFF STATEMENTS

Nigel Taylor

ing with the Westley Group and introduced modern casting techniques to produce high quality castings. We are proposing to use similar techniques in the modernisation of the Whitechapel Bell Foundry. It is now not realistic to cast large bells on site in Whitechapel and we will develop a collaborative approach sharing the new work that will result from the application of technology to the recording existing bells and the revival of interest in bell making. We aim to launch a fundraising campaign to draw attention to the great bells of the past and create a range of scale replicas appealing to different audiences. The supportive public response to the closure of the bell foundry has been incredibly positive!

The original patterns are not available, so new patterns will be manufactured utilising computer aided design and 3D printing to create accurate scale models. These could include the Liberty Bell, Big-Ben, The Olympic Bell, The Lutine Bell. These commemorative bells can be manufactured alongside other specialist castings. Historical research into casting techniques, small-scale fine art castings and an innovative approach to bell-foundry work presents a wonderful opportunity for education. This will focus on schools, visits for the general public and apprenticeships. These apprenticeships will aim to take bell casting into its next phase. They will teach: investment casting (lost wax, ceramic shell and other innovations), moulding, alloys, casting techniques and fettling the castings. But they will also focus on digital scanning, processing and output technologies. A CNC (Computer Numerical Control) machine can be programmed to accurately work the surface of the casting to a given profile. The tuning of bells is another skill in its own right. Unlike piano tuning, there is no college course available to teach bell tuning. Apprenticeships are no longer commonplace in London's east end, so the former foundry site could become an invaluable employer and teaching centre.

I am willing to pass on my skills and knowledge, acquired over 40 years of bell foundry work, to the next generation. I am committed to the re-employment and retraining of former employees at the WBF. I welcome the chance to share my knowledge of the history of bells and the bell community and develop existing international connections. Working with a not-for-profit organisation like Factum Foundation, committed to the application of technology to the preservation of crafts skills, is exciting. This approach to the revitalisation of the Whitechapel Bell Foundry will keep the production of bells on this site for the foreseeable future.”

Statement by Nigel Taylor, former Tower Bell Production Manager at the Whitechapel Bell Foundry where he worked for 40 years

STATEMENTS BY SUPPORTING ORGANISATIONS AND INDIVIDUALS

“The re-established Whitechapel Bell Foundry would add significantly to the creative offer in East London. As the V&A East establishes a substantial presence at Stratford and the Queen Elizabeth Olympic Park and develops particular links with the adjacent boroughs, we would welcome the opportunity to promote the Whitechapel-based art and bell foundry. Combining traditional skills with innovative technology and the offer of apprenticeship and further training in this specialized field will enhance the interpretation of the V&A’s important collection of works of art in bronze. Continuing the centuries-old tradition of bell founding in London with its global outreach will enrich the cultural presence and attract national, regional and international interest.”

Dr Tristram Hunt
Director V&A Museum

“The Foundry at Whitechapel is world-famous for casting bells since the reign of Elizabeth I. It is the UK’s oldest continuous manufacturing business and one of our finest cultural and heritage assets. The Trust’s proposal to retain it as a working foundry, in a revitalised way suitable for the 21stC, will retain and create important creative skills vital to the future of the UK economy. It is a proposal I fully support.

Apart from the cultural and heritage loss to the nation should this site be redeveloped as the current private owner intends, his proposal would do little for the residents of Whitechapel. Instead, as the Trust proposes, we need to retain a business that keeps and creates valuable skilled manufacturing jobs. It will also be an exciting new visitor destination for London.

Bells, including some of the world’s most famous bells, have been made on this site since 1571. London should never countenance the loss of such an iconic national and international business.”

John McDonnell
Shadow Chancellor



*Top: Bell mould and bell templates, 2016.
Photographs by John Claridge.*

*Bottom: Bells in the courtyard, 1991.
Photograph by Carlotta Luke.*

*Back cover:
Bell tuning, 1991. Photograph by Carlotta
Luke.*



FACTVM
FOUNDATION
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IN CONSERVATION



MIDDLEPORT POTTERY
UNITED KINGDOM HISTORIC BUILDING PRESERVATION TRUST