Building Recording (Level 2)

Photographic Record (Volume 2)

Former Nestlé Factory Canteen Building, Nestles Avenue, Hayes

March 2026

1. Introduction

1.1 This Photographic Record (Volume 2) forms part of the Building Recording for the former Nestlé Factory Canteen Building, Nestles Avenue, Hayes and has been prepared by Turley Heritage. This forms part of a Level 2 Building Recording, with a Written Record (Volume 1) accompanying this Photographic Record (Volume 2). The photography was undertaken on 10th February 2026 between 10am and 1pm. The recording conditions were generally clear.

1.2 The detailed contents of the Photographic Record for the former Canteen Building are set out below:

- General views of the former Canteen Building within its immediate context;
- The former Canteen Building's external appearance, covering its external elevations, indicating the impression of its size, shape, and relationship to surrounding buildings, and setting;
- The overall appearance of the principal rooms and circulation areas; and
- Any external or internal detail, structural or decorative, relevant to the former Canteen Building's design, development, and use.

1.3 External and internal photographs are provided alongside this document as part of the submitted Building Recording (as JPG and CR2 files). Photographs are linked back to accompanying diagrams and architectural plans (**Sections 2-3**), with appropriate referencing and numbering to identify the approximate location and orientation of the photographs taken. Full survey drawings for the former Canteen Building are included at ***Appendix 3*** of the Written Record (Volume 1).

1.4 The 2018 MOLA Standing Building Survey report is included at ***Appendix 1*** of this document as relevant context, from which interior photographs of the first floor have been taken for completeness, as access to this part of the building was unavailable due to health and safety risks. It is noted that many parts of the 2018 report are outdated and no longer relevant at this stage. However, this document is appended in full as useful context in relation to the Site.

2. External Photography (E1-E45)


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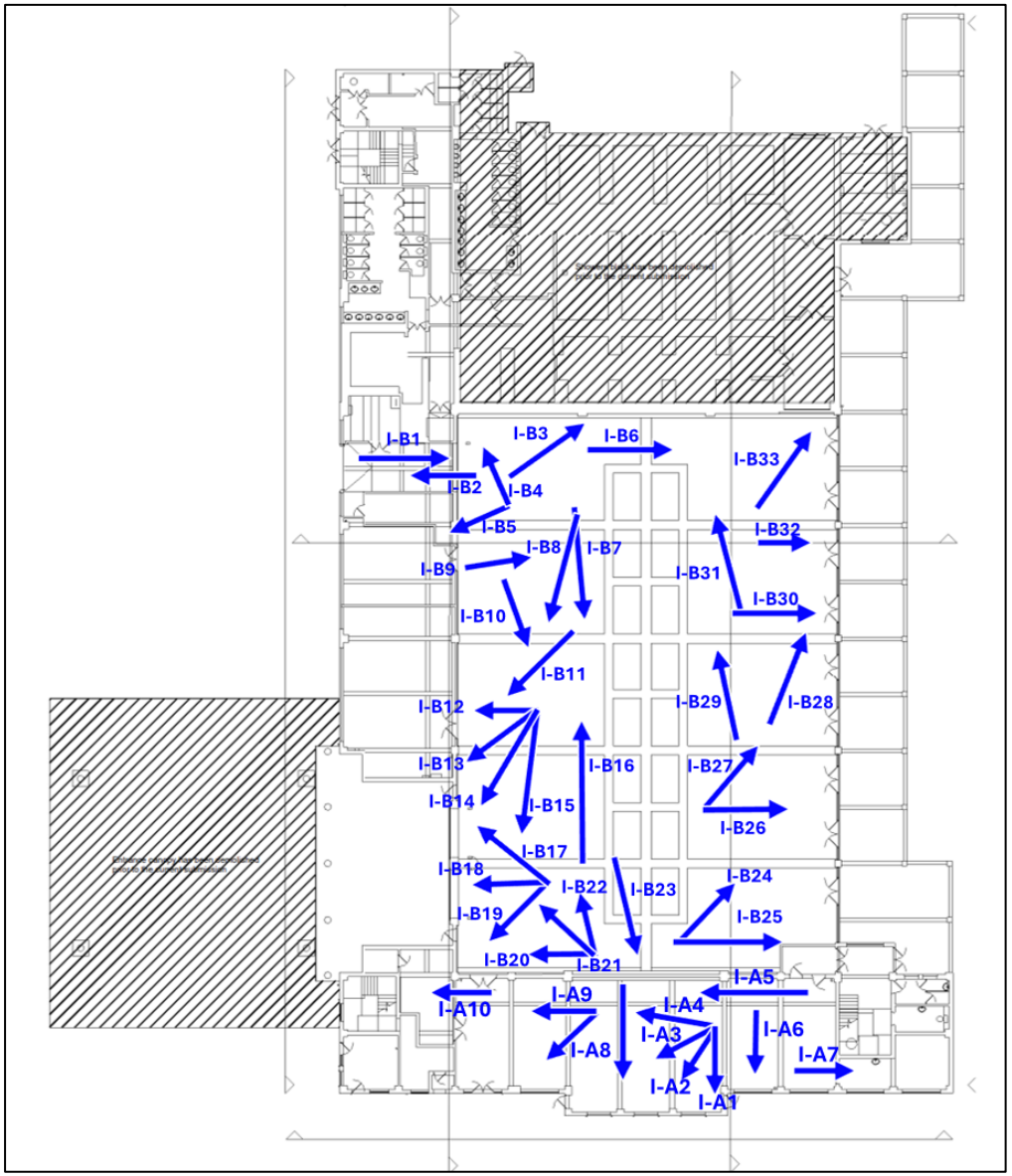
3. Internal Photography

Ground Floor (I-A1 – I-A10; I-B1 – I-B33)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First Floor (taken from MOLA Standing Building Survey, 2018: Fig. 75 – Fig. 84)

Fig 75 First floor landing at the south-east corner stairwell, looking east

Fig 76 First floor office area in the south wing, looking west

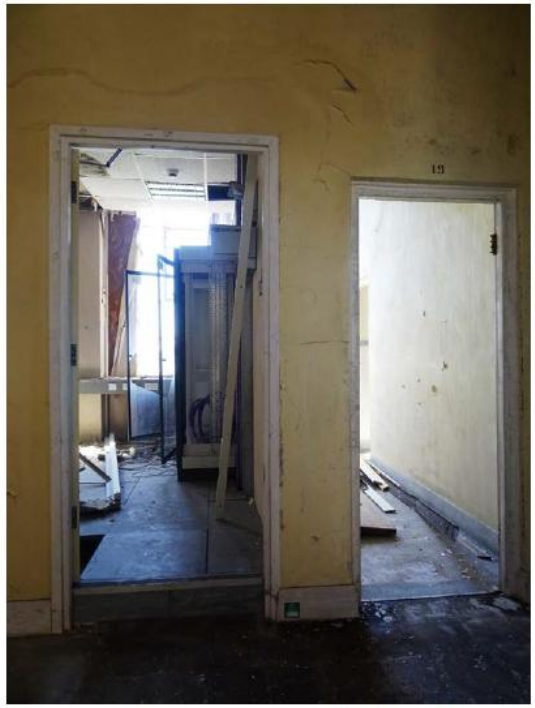

Fig 77 Doors to the computer server room and the WC at the south-west corner on the first floor

Fig 78 Main staircase at the south-west corner of the building

Fig 79 South end (left) and a central portion (right) of the north-south running corridor on the first floor of the west wing.

Fig 80 Southern end office room on the first floor of the west wing, looking south-east

Fig 81 One of the first-floor office rooms in the west wing with herringbone wood parquet flooring

Fig 82 Northern end of the corridor on the first floor, looking north

Fig 83 Goods lift accessed from the corridor on the first floor

Fig 84 Female WC in the northern end of the west wing on the first floor

Appendix 1: MOLA Standing Building Survey, 2018

Former Nestlé Factory
Nestlés Avenue
Hayes
UB3 4RF

Site Code NHY18
National Grid Reference 510094 179227
OASIS reference molas1-317671

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25 May 2018

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Report on a standing building survey

Sign-off History:

Issue No.	Date:	Prepared by:	Checked/ Approved by:	Reason for Issue:
1	25.05.2018	Azizul Karim (Senior Archaeologist)	Stewart Hoad (Project Manager)	First issue

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Summary

This report presents the findings of a Standing Building Survey at the former Nestlé factory site at Nestlés Avenue, Hayes, UB3 4RF, undertaken by MOLA (Museum of London Archaeology).

The building recording survey was commissioned from MOLA by Barratt London and was required as a mitigation strategy for the proposed development on the site. The fieldwork took place in April 2018.

The site comprises an area approximately 12.3ha in extent at the former Nestlé factory site and headquarters. Between 1912 and 1914, Sandow's Cocoa Factory was constructed on the site for the production of 'Sandow's Health and Strength Cocoa'. In 1916 the factory, as well as Sandow's Cocoa Company, was bought by The Peter Cailler Kohler Company (PCK), a chocolate making company. Finally, in 1929, the site was acquired by Nestlé who bought PCK. In 1949, the Hayes site became the Nestlé UK headquarters. In the latter part of the 20th Century, particularly the 1970s, the site experienced significant changes with the expansion of the factory and additional buildings.

Contents

List of illustrations

1 Introduction

1.1 Site background

1.1.1 This document is the report on a historic building recording survey at the Former Nestlé Factory site at Nestlé's Avenue, Hayes, UB3 4RF. MOLA was commissioned to do the survey by Barratt London and as a planning requirement for the proposed development on the site.

1.1.2 The site comprises an area of approximately 12.3ha at the former Nestlé Factory site and is bounded to the north by the Grand Union Canal and the Great Western Railway. North Hyde Gardens and Nestlé's Avenue define the eastern and southern boundaries of the site respectively. To the west is a trading estate located off of Nestlé's Avenue. The centre of the site lies at National Grid reference 510094 179227. Modern pavement level near to the site lies at approximately 30m OD.

1.1.3 The site is located within the Botwell, Nestlé Hayes Conservation Area, which was first designated by LBH on 19th June 1988. This designation was partly in response to demolition on the site, which was considered to affect its character, which was perceived as being special. The boundary of the development site roughly coordinates with that of the conservation area and comprises the whole of the former Nestlé factory site, north of Nestlés Avenue.

1.1.4 There are four locally listed buildings on the site which form part of the former Nestlé Factory as highlighted in Fig 2. These are as follows (see Fig 2):

- Nestlé Works (Nestlé UK Ltd) which is described as the 1930s factory by Wallis Gilbert, hereafter referred as Main Factory Building
- Nestlé Works: former canteen (Nestlé UK Ltd) hereafter referred to as Former Canteen
- Nestlé Works gates/railings (Nestlé UK Ltd), hereafter referred Gates and Railings
- Nestlé Works: lodge (Nestlé UK Ltd) hereafter referred as the Lodge

1.2 Planning Background

1.2.1 The development scheme entails the demolition of all the existing buildings on the site and the construction of 25 residential dwellings with associated works, including landscaping and open space.

1.2.2 The site is being developed to include a variety of residential and commercial uses. The development application (ref: 1331/APP/2017/1883) includes Condition No 10 to which this standing building survey relates. The condition requires:

> ***Condition 10 Heritage Assets Recording***
>
> Prior to the commencement of development and any works of demolition:
> *(i) A Written Scheme of Investigation/WSI (in accordance with Historic England's Best Practice Guidance), setting out the scope, approach and phasing of the buildings and site recording, shall be submitted to and approved in writing by the Local Planning Authority. The record will be to agreed Historic England recording*

levels and standards. This should include a detailed record of the whole site and all locally listed buildings at agreed stages before and during demolition;
(ii) The record prior to demolition (for both residential and industrial land ownerships) will be submitted for informal review and comment prior to formal submission to discharge the condition and agreed in writing by the Local Planning Authority before the commencement of demolition;
(iii) The phased recording throughout the demolition process will be in accordance with the agreed demolition strategy and the WSI;
(iv)The completed recording document will be submitted to the Local Planning Authority for final approval prior to the commencement of development and new construction in accordance with the WSI.

Reason

To safeguard the special architectural and/or historic interest of the conservation area and buildings in accordance with Policy BE8 and BE12 Hillingdon Local Plan: Part Two Saved UDP Policies (November 2012).

1.3 The scope of the survey

1.3.1 The extent of the historic building recording work was set out in the Written Scheme of Investigation (WSI) (MOLA, 2018). The investigation and the report represent the strategy necessary to discharge the 'Heritage Assets Recording' condition attached to the Planning Consent for the redevelopment at the site.

1.3.2 All work was carried out in accordance with Historic England specifications in *Understanding historic buildings: a guide to good recording practice* (Historic England, 2016) and other applicable standards and guidance (e.g. CIFA Standard and guidance for archaeological investigation of standing buildings or structures, 2014).

1.3.3 The field survey took place before the commencement of the proposed demolition of the buildings on the site.

1.4 Organisation of the report and conventions used

1.4.1 The report is organised in line with the scope of the WSI (MOLA, 2018) providing a descriptive and analytical, written account and a photographic record of the existing buildings on the site. Only a selected number of photographs have been presented in the report. However, all photographs were taken on the site and a list of their description and archive identifier will be archived together.

1.4.2 Orientations of the buildings are simplified for the sake of the ease of description in the text. However, all maps and plans in the report show true orientations of the building with north arrows. Measurements may be given in both metric and imperial measurements where appropriate.

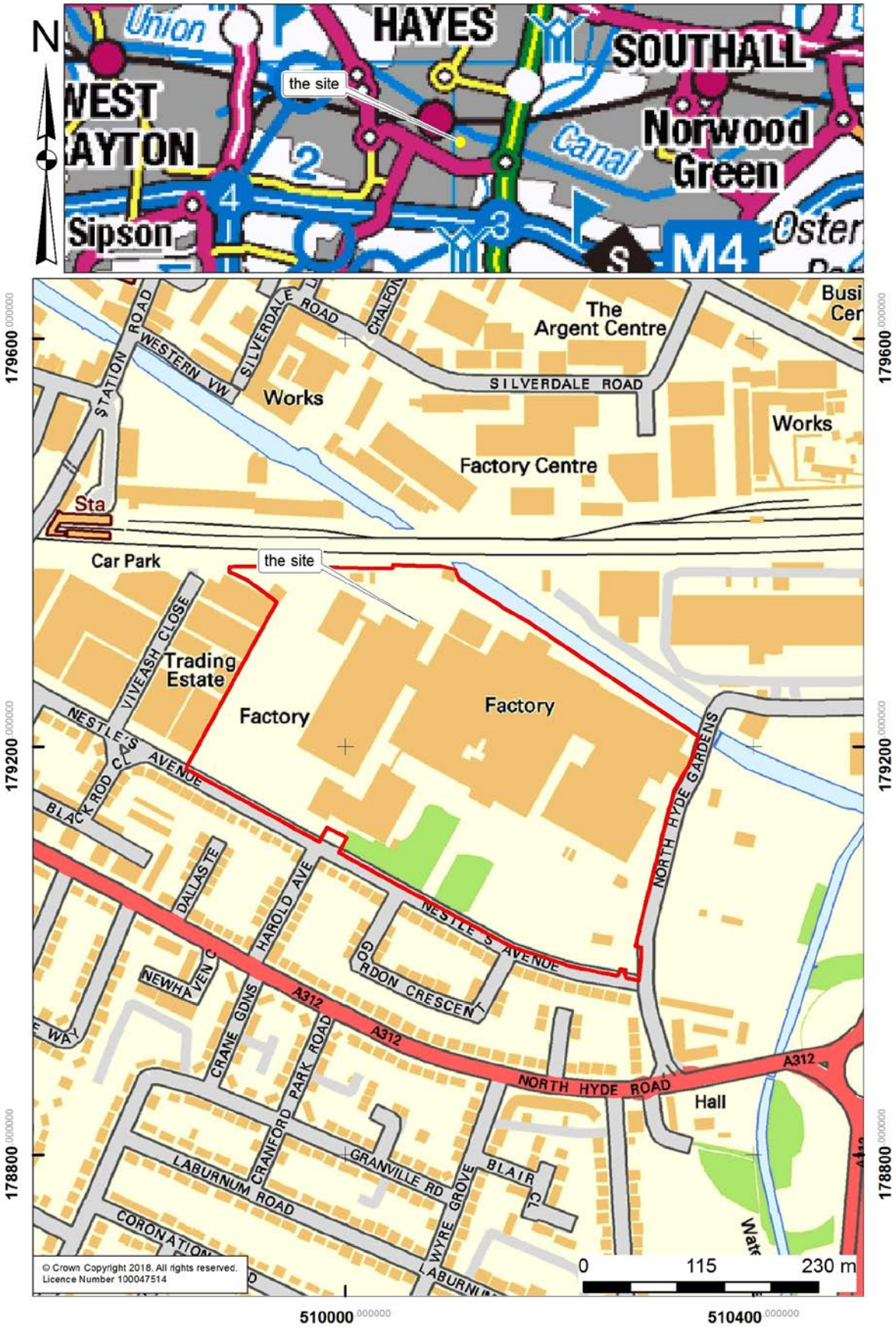

Fig 1 Site location plan

Fig 2 The structures on the site referred to in the text

1.5 A brief summary of the buildings

1.5.1 A brief description of the locally listed assets on site is as follows:

1.5.2 **Main Factory Building**: 1920s factory building designed by Wallis Gilbert & Partners. It is a currently the largest building on site, three to four storeys high and located at the northwest corner of the site. It contained the main factory and storage facilities. The building is a 'Truss Concrete' construction also known as Truscon, with a flat concrete roof and large glazed panels. The building is of local architectural interest as an early example of this Truscon method of construction which was applied to a fairly innovative layout incorporating open light wells and courtyards to ensure a healthy internal environment for the factory workers with plenty of natural light (CgMs, 2017). The south elevation of the building was complemented with an Art Deco inspired entrance tower containing foyer and the main stairwell. Its pronounced appearance provides a focal point from the main entrance gate at Nestlé's Avenue.

1.5.3 **Former Canteen**: The Former Canteen building was constructed in 1954 following the establishment of the Hayes site as the Nestlé UK headquarters. It is a large amenity building located on the western side of the site fronting on to the former main entrance to the site. It is a reinforced concrete building designed to conform to the Truscon style main factory building. It comprises a large single storey double-height hall with a two-storey wing along the west.

1.5.4 **Lodge**: The Domestic Revival style lodge building was constructed as purpose-built caretakers' houses, originally containing two units. It is a two storey brick building with an attic level plus basement located at the south-eastern verge of the site. It is believed that it was constructed at the same time as the Main factory extension in the early 1920s (CgMs, 2017).

1.5.5 **Gates and Railings**: Both entrances to the site from Nestlé's Avenue have decorative metal piers, gates and railings. These are linked to the metal railings that run along the north side of Nestlés Avenue. The railings have concrete bases with metal and concrete columns with additional support of decoratively curved outriggers. It is believed that they were originally designed to form part of the Nestlé Headquarters in Vevey, Switzerland but were brought to the Hayes site circa 1950 following the establishment of the site as its UK headquarters (CgMs, 2017).

1.6 Historic Building Recording methodology

Research aims

1.6.1 The overall objectives of the standing building recording elements of the project were stated in Condition 10 of the planning decision notice which stated the that the built heritage recording should ensure "*to safeguard the special architectural and/or historic interest of the conservation area and buildings in accordance with Policy BE8 and BE12 Hillingdon Local Plan: Part Two Saved UDP Policies (November 2012)".*

1.6.2 The specific objectives and research aims of the standing building recording were defined fully in the WSI (MOLA, 2018). The recording of the buildings conforms to the standards described in the Historic England guidance document *Understanding Historic Buildings* (Historic England, 2016). This was to provide a descriptive and analytical record of the buildings and document their interior and exterior fabric.

1.6.3 Thus the historic building recording had the following main components:

- To undertake a comprehensive photographic record of the buildings, including detailed and general shots within its setting where this can be safely done.
- To investigate and describe the fabric of the structures before the start of the proposed works, with the aim of elucidating their use and architectural history, and to record and analyse the resulting evidence for this history using applicable archaeological methods.
- To make a detailed record of the buildings in their present condition, by means of photography and annotation of the scale plan drawings supplied by the client.
- To annotate supplied scale drawings of the plans and elevations of the buildings.
- To carry out a study of the available documentary sources for the history of the site, as well as the buildings to a level of detail appropriate to the scope of the investigation.
- To report the results in a suitable form reconstructing on paper the successive major builds and episodes of construction evident in the fabric of the building, and also evident in available documentary sources.
- To produce orthogonal rectified images of the prominent elevations of the buildings
- To publish a summary and register the report through the Archaeology Data Service's OASIS data collection form, with London Borough of Hillingdon and with the LAARC (London Archaeological Archive and Research Centre).

Survey methodology

1.6.4 In addition to the Historic England and CIfA guidance referred to above, the historic building recording was carried out in accordance with the site-specific WSI (MOLA, 2018).

Physical investigation

1.6.5 A physical investigation of the buildings was carried out on site prior to the proposed intervention to the original fabric of the building. This aspect of the investigation was aimed at elucidating significant details regarding fabric, function, or the elements, methods/order of construction and development.

Written records

1.6.6 Handwritten descriptive notes were produced on-site to record the findings of the physical investigation. The notes recorded details such the fabric, form and function of the structure, along with evidence of any alterations and development over time.

Drawn records

1.6.7 The scope of the project did not require MOLA archaeologists to produce scale drawings. MOLA was supplied with measured survey drawings of floor plans, produced by Nestlé in March 2005. These drawings were checked and annotated

on site with information relating to the historical significance of features. Finally, drawings were updated and annotated conforming to the Historic England guidance for presentation of a historic building survey in CAD (English Heritage, 2005).

Photographic records

1.6.8 A comprehensive photographic record of the buildings was made during the investigation. Photographs were taken using a 12-megapixel high definition digital camera. Both interior and exterior of the buildings, where safely accessible, were photographed including general and perspective views to give an overall impression of its appearance and setting.

1.6.9 Only a selected number of the photographs taken on-site have been presented in this report. However, all photographs were taken on the site and a list of their description and archive identifier will be archived.

Documentary research

1.6.10 A detailed historic background was portrayed in the Heritage Statement produced by CgMs (CgMs, 2017) A further documentary archive research was carried out to give an account of the history and development of the building. Documentary sources for the history of the buildings were consulted to provide evidence for dates of construction and significant modifications, along with any information on the activities undertaken in the building during its use.

2 Historical background of the site

2.1.1 The Botwell, Nestlé Hayes Conservation Area contains the former Nestlé factory site and headquarters to the north of Nestlé's Avenue. The site was open land until the early 20th century with the Grand Union Canal (formerly the Grand Junction canal) establishing the northeast boundary from 1807. By the 1860s, the Great Western Railway line formed part of the northern boundary (Fig 3) (Turley Heritage 2017).

Fig 3 1920 OS map showing the site area c.1898 and Hayes Station (top left) opened in 1868.

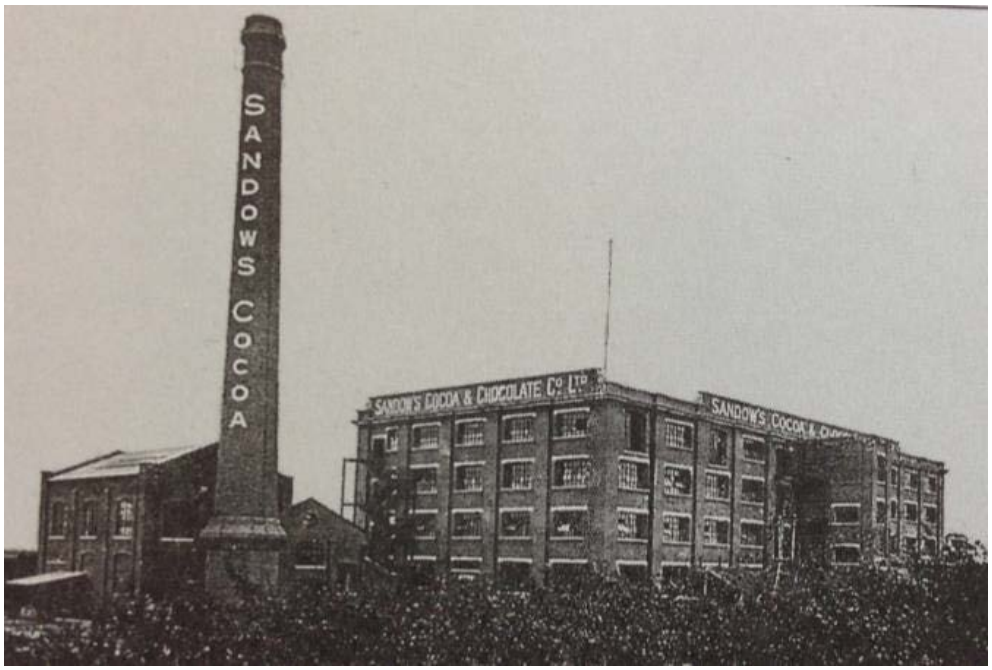

Fig 4 Original Sandow buildings c.1916 (Turley Heritage 2017)

2.1.2 The first buildings on the site were completed in 1914 by Eugen Sandow (Fig 4) and can first be seen in the plan outlined in red on the 1919 map (

2.1.3 Fig 7). However, the site was commandeered by the British Government early on in the First World War. The Sandow's Cocoa Factory was constructed on the site for the production of 'Sandow's Health and Strength Cocoa'. The company was founded in 1911 by Eugen Sandow (born Friedrich Wilhelm Müller in 1867), a strongman and very famous Victorian, considered to be the founding father of modern bodybuilding (Fig 5). Sandow believed cocoa was the source of his strength and although he was famous for his creation of the Grecian Ideal body type he also had other business interests. Sandow appeared in a short Kinetoscope film in 1894 which was part of the very first commercial motion picture exhibition in history. In addition to his filmmaking, in 1909 at his own expense, he provided training for aspiring Territorial Army recruits to help them meet the Army's entrance standards for physical fitness.

Fig 5 Eugen Sandow c.1894 (photographer unknown)

2.1.4 Eugen Sandow's cocoa company was initially established in 1911 in a Georgian property on Old Kent Road, Middlesex. In 1912 the site at Hayes was chosen for the creation of a larger factory, mainly for its position close to both the canal and the railway (Turley Heritage, 2017; CgMs, 2017). The move was likely an attempt to keep up with market competitors, in particular, Rountree which was later taken over by Nestlé (Nestlé Archive 2014).

2.1.5 The original factory buildings built by Sandow were finished in 1914 and consisted of two solidly built brick buildings, one the main factory building made up of four storeys with 'Sandow's Cocoa & Chocolate Co. Ltd' signage painted at the roof line, and the other an engine house consisting of two storeys with a towering smokestack and letters spelling out 'Sandow's Cocoa' vertically applied (Fig 4). The buildings were in full view from both the canal and the railway. Unfortunately, with the outbreak of the First World War, Sandow, as a German citizen, was prohibited from trading in England and subsequently, the factory closed.

2.1.6 In 1915 during the second year of WWI, the land on which the site sits and the surrounding area to the south was purchased by the British Government (CgMs 2017). The site was used to build a National Filling Factory or NFF No. 7, one of approximately 218 munitions factory sites built by the Ministry of Munitions in England during the First World War (Historic England). The munitions factories were built to expand the production of munitions due to a shortage of reliable ammunition being sent to the front lines. The site in Hayes was selected for its vicinity to London and the Great Western Railway, as well as the Grand Union Canal. It was also convenient to two important routes in and out of London, the Uxbridge road in the north and the Bath road to the south (Collier 2014). The National Filling Factories generally undertook fuse filling, Gaines modification, installation of detonators and further small parts as well as larger filling jobs (Collier 2014).

2.1.7 The munitions filling factory at Hayes was quite large, involving 397 buildings, covering some 200 acres (Fig 6 the area of the munitions site). The NFFs were arranged by so-called clean and dirty areas, for example, the Hayes factory was divided into five areas, outside of each area were stores used for inward bound goods or finished munitions ready for dispatch. These storage areas were located next to and at the same height as the railway tracks. The stores were considered the dirty areas of the factory.

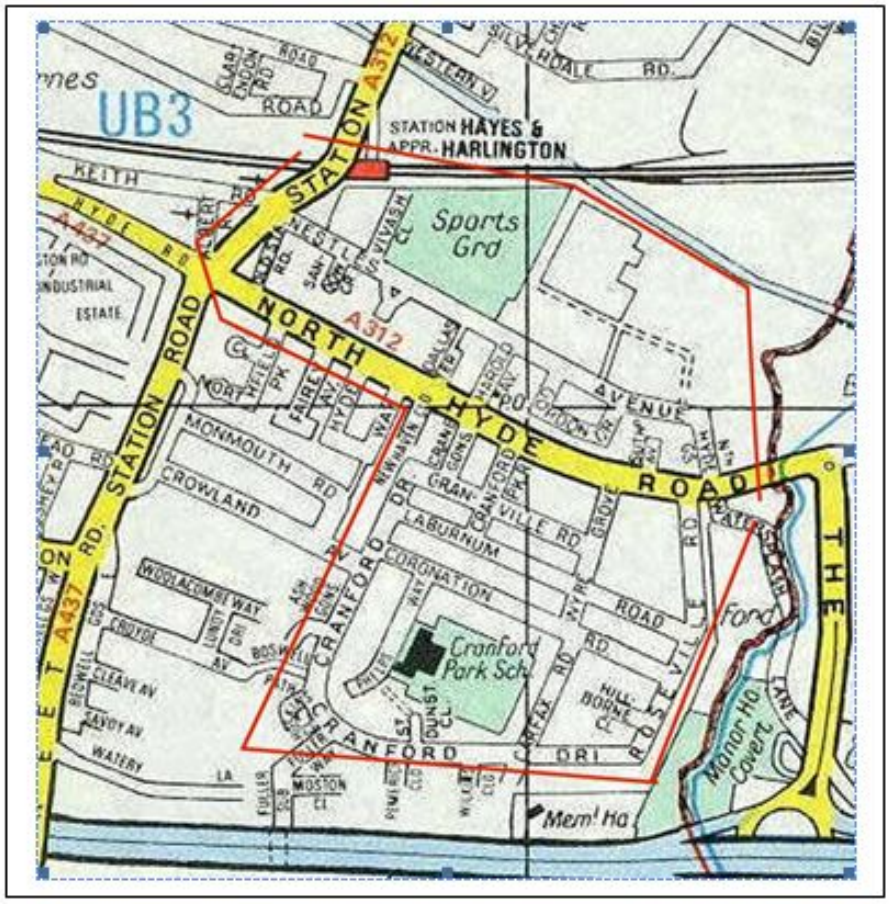

Fig 6 Area of the munitions factory outlined in red (Turley Heritage 2017)

2.1.8 Activities which took place at NFF No. 7 were the filling and assembly of quick firing ammunition (QF ammunition) and the filling of larger shells with melted amatol. The amatol filling took place in specialized buildings, but most of the other activities took place in many small timber-framed sheds, huts or shops, usually a standardized 15'x40' allowing for flexibility of use (Fig 8).

2.1.9 The timber-framed buildings or workshops were spaced at regular intervals of 75' to prevent destruction and injury in the event of an accidental explosion. Most of the workers at the NFFs were young women and as well as the dangers of explosion; the work was risky in terms of exposure to contaminants. The huts were linked by raised timber 'clean-ways' which were elevated about three feet off the ground by concrete platforms or posts. These timber clean ways had narrow gauge rail tracks running along them which aided in the safe transport of materials around the site. Clean areas could not be accessed without passing through a 'shifting house' where workers donned protective clothing and shoes and once a person stepped into a clean area, it was only allowed that they moved about in clean areas and did not step off the raised walkways onto the ground or they risked disciplinary action (Fig 7). The munitions filling factory was in use until 1918 when it was gradually phased out of use with only a small number of staff being present on site by the start of 1919.

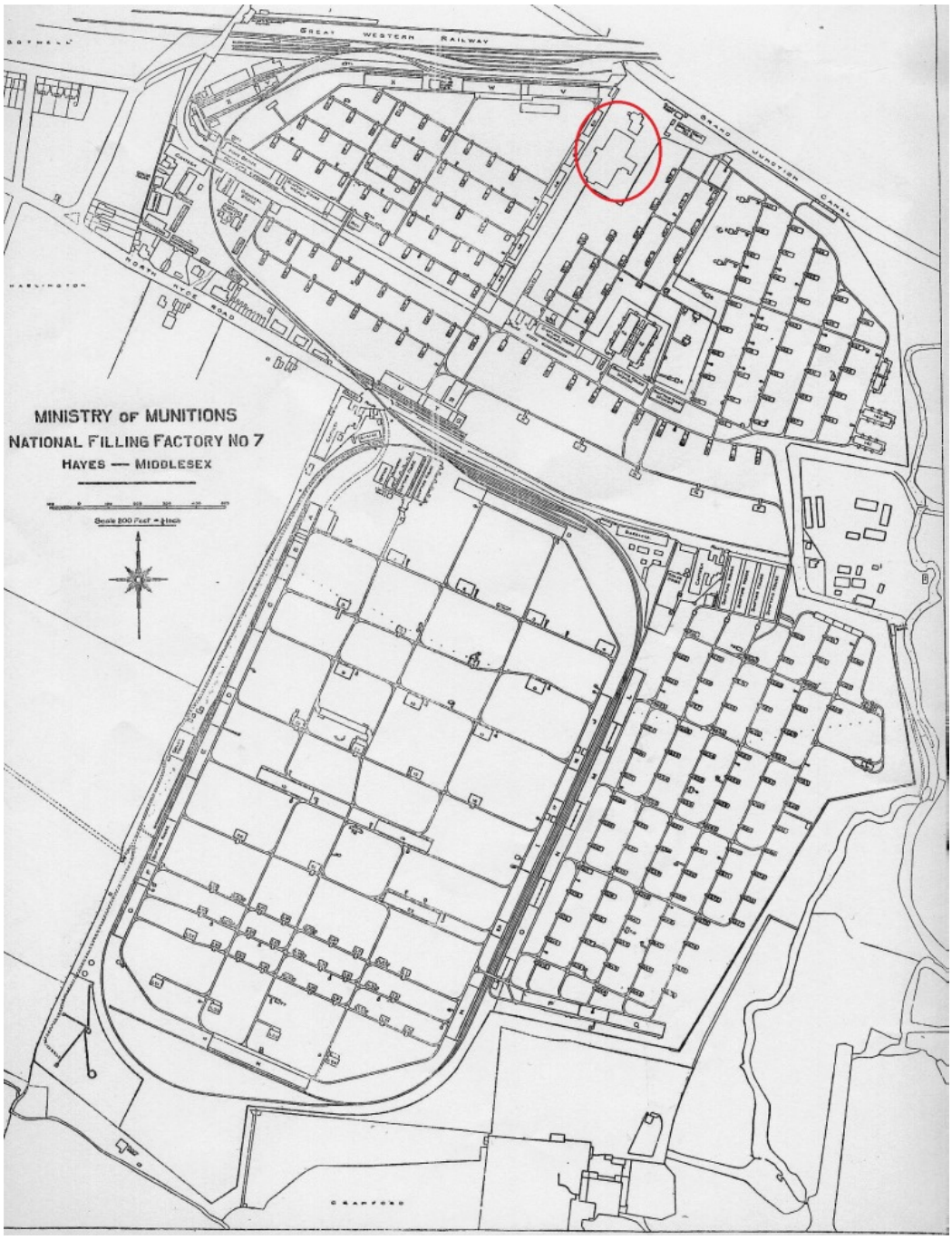

Fig 7 1919 Plan of NFF No.7, Sandow buildings circled in red (Collier 2014)

Fig 8 NFF No.7 sheds, cleanways and railway tracks (Collier 2014)

2.1.10 In 1916 the site had been purchased by Peter, Callier, and Kohler (PCK) Swiss chocolate makers from Vevey Switzerland whose company was formed from Peter Kohler in 1911. Daniel Peter was the son-in-law to Francois-Louis Callier, also a chocolate maker from Vevey which was home to seven chocolate factories in the early 19th century. The Callier family continued to run their chocolate business after Francois-Louis' death in 1852. By 1867 Peter was producing chocolate under the name Peter-Callier. In 1875 Daniel Peter was believed to have invented milk chocolate (Nestlé Archive, 2018; Gentle, 2018). In 1904 Daniel Peter and Charles-Amédée Kohler founded the company Société Générale Suisse de Chocolats Peter et Kohler Réunis. Peter, Callier & Kohler's relationship to Nestlé began in c. 1905 when Nestlé launched milk chocolate produced by Peter & Kohler internationally. In 1911 Peter & Kohler merged with Callier to form Peter, Callier, Kohler Chocolates Suisses S.A.

2.1.11 After WWI ended, the area of the site reverted back to the possession of Peter Callier Kohler. The factory continued production and was known as Hayes Cocoa, Ltd. In 1919 PCK decided to expand the original factory building and appointed the Truscon Concrete Steel Company in collaboration with Architects Wallis Gilbert and Partners to design and build the extension, the outline of which is shown on the 1935 OS map of the site area (Fig 9).

2.1.12 The two companies designed a "four storey square-shaped arrangement with four inner courtyards to allow natural light into the factory interiors, set around the existing factory buildings" (Turley Heritage, 2017) (Fig 10). The construction and materials used were the Kahn System of Reinforced Concrete which was groundbreaking technology at the time, invented by American Julius Kahn. In addition, the design of the new extension was part of an overall move toward improving the environment of factories in the US and Europe. The idea of 'Garden Factories' was reflected in both the design of new factory buildings and their surrounding landscapes. In principle, the idea was that 'better grounds make better factories' (Cady, 1947).

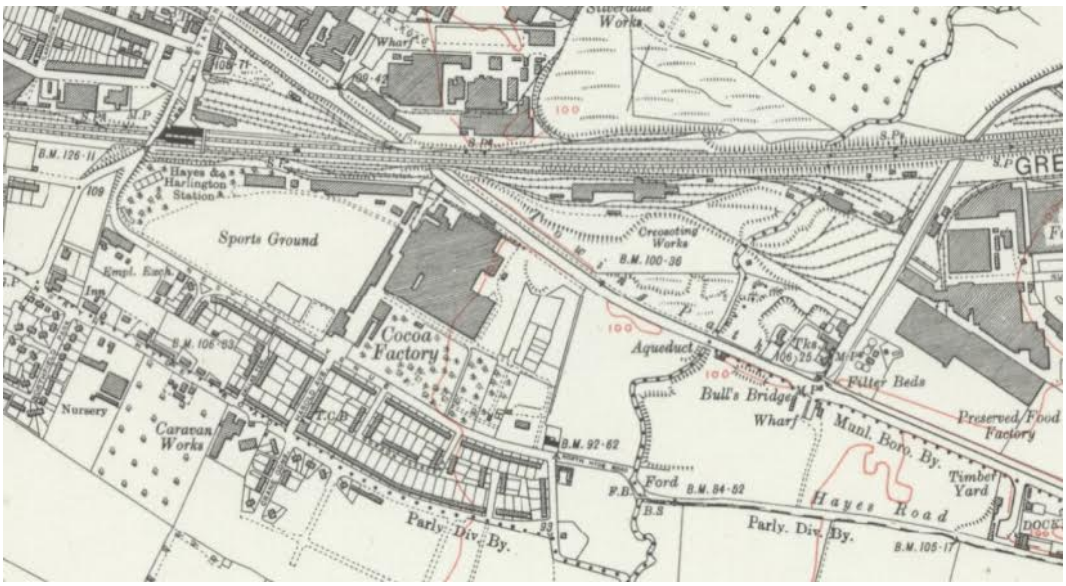

Fig 9 1935 OS map showing the factory extension

Fig 10 1930s view of the factory from the north-west with the extension (Turley Heritage 2017)

2.1.13 In 1929, Nestlé purchased PCK and the Hayes site. Nestlé originally produced and marketed condensed milk and infant formula but later milk chocolate out of Vevey, Switzerland. Nestlé altered the site considerably over the years: most of the munitions factory structures had been removed by 1932, an additional storey was added to the east side of the factory (Fig 11), and the grounds contained landscaped athletic fields, including tennis courts and a bowling green (Turley Heritage 2017).

Fig 11 The Main factory building in the 1930s from the southeast (Britain from Above)

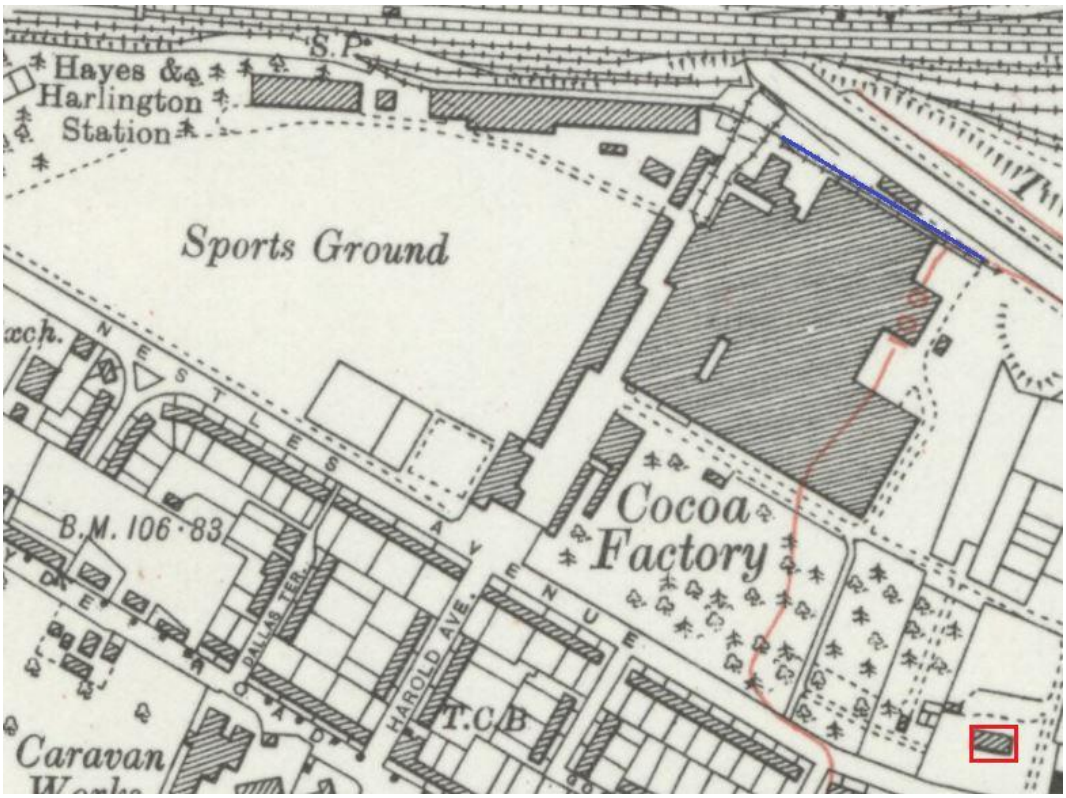

Fig 12 1935 OS map: the addition of the Lodge in red outline and the railway siding in blue.

2.1.14 By the time of the 1935 OS, the lodge (outlined in red) had been constructed on the grounds at the southeast boundary of the site and the area was partitioned into smaller plots. Along the northern boundary the railway sidings have been expanded (Fig 12).

2.1.15 In 1949 Nestlé Hayes was the company's UK headquarters, and by 1954 the new canteen building located in front of the south elevation of the main factory building had been added to the site as had further landscaping to enhance the view of the factory from Nestlé's Avenue in the south. By the 1960s the factory complex was extended and included the removal of several buildings next to the athletic fields and their replacement by three large industrial units. In addition, there was an extension of the northeast corner of the main building (Turley Heritage, CgMs 2017) (Fig 13).

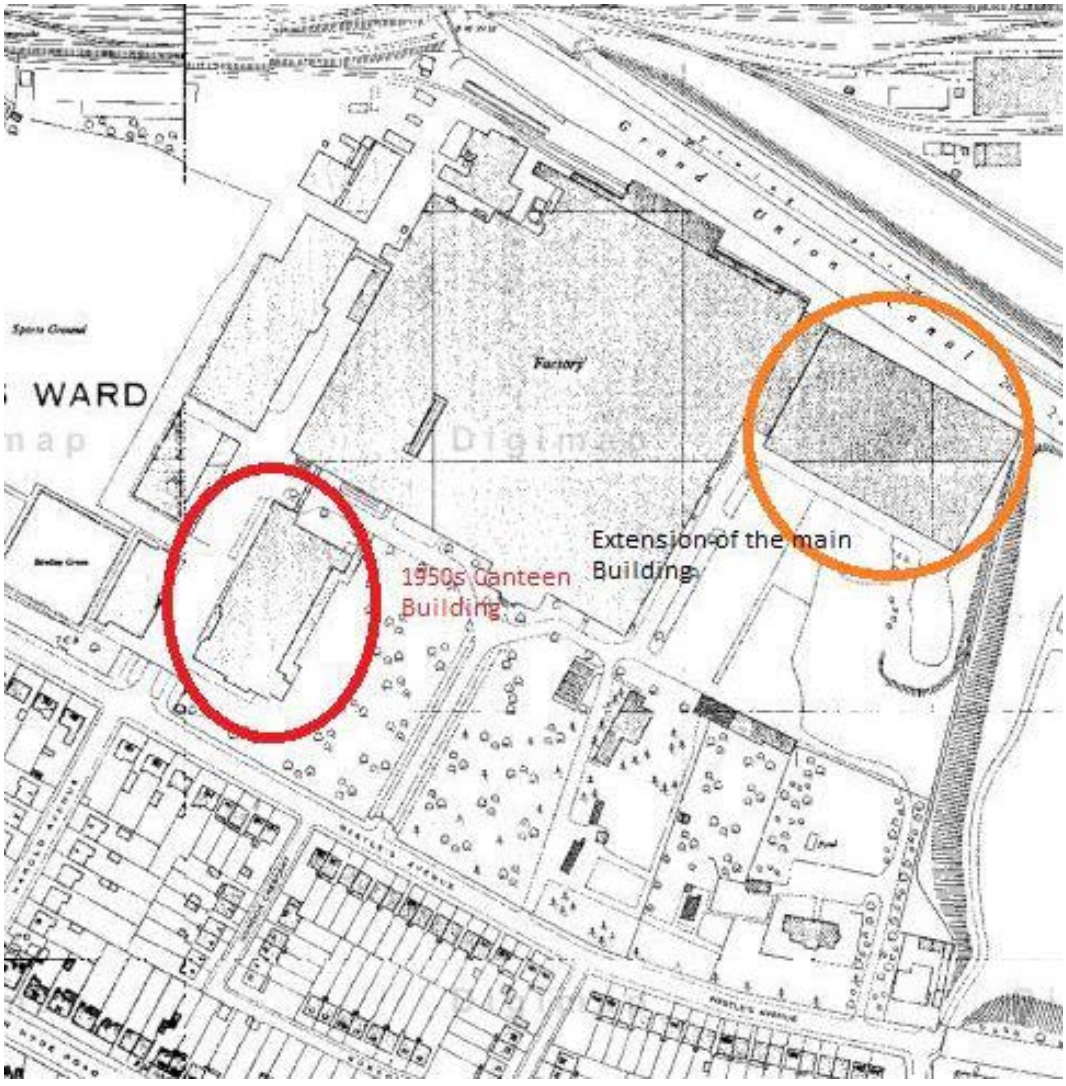

Fig 13 1960s Ordnance Survey map with the 1950s Canteen Building circled in red and the northeast extension to the Main Factory Building circled in orange (Edina Digimap)

2.1.16 The factory was extended again by 1975 with more additions to the northwest and east, and the railway sidings had disappeared along with the warehouses which were replaced by a paved area (Turley Heritage, CgMs 2017). There were no major changes to the site during the 1980s and 90s but by 2013 the northwest boundary athletic field was replaced by another industrial structure and a loading yard, and in the southeast corner of the site beside the Lodge, buildings had been replaced by a large parking lot.

3 Description of the buildings

3.1 Introduction

3.1.1 The site comprises an area approximately 12.3ha in extent containing four large and two small factory buildings, a former canteen that has been used as a warehouse in recent past, a former squash court and a lodge. It also has a large car park in the south-east corner. In this section of the report, the most significant buildings and their architectural features have been described. Please refer to the site layout (Fig 2) for the location of the buildings. Plans of the buildings described below are appended at the back of this report.

3.2 Main Factory Building

Introduction and layout

3.2.1 The following description of the Main Factory Building should be read in conjunction with the plans and elevation drawings of the building in Appendix 1. The majority of the building was accessible. However, a number of areas were not accessible due to health and safety concerns, which have been marked in the plan drawings. According to the listing information the main factory building originally had a cantilevered canopy to the rear. However, this feature of the building was not observed in the present survey thus probably removed.

Fig 14 Main factory building, looking north-west

3.2.2 The main factory building is architecturally austere and straightforward. It is effectively a composite structure and the largest building on the site. Currently, it is a one-to-four storey tall building with roughly square shape in plan. The original building was much smaller, and the present extent of it is the result of several

additions and extensions carried out throughout the 20th century.

3.2.3 The building was constructed in the 1920s (designed in 1919 and completed by 1921). It was designed by Truscon (originally Trussed Concrete Steel Company) in collaboration with Wallis Gilbert & Partners. It was constructed using the Truscon system, which uses prefabricated elements in reinforced concrete structures which prevents cracking and allows the structure to carry heavier loads.

3.2.4 The layout of the building incorporated open light wells and courtyards to ensure a healthy internal environment for the factory workers, with plenty of natural light. The building has been described as the inter-war "factory in a garden" style. This was also reflected in the landscaping across the site. The original layout of the building has been greatly altered through time during many additions. However, the "factory in a garden" character has been retained.

3.2.5 The north-west corner of the factory contains an earlier building constructed in 1912. It is of load-bearing brick wall construction with brick jack-arched floors and is supported on steel beams running east-west. The beams are supported on steel columns with brackets at their capitals. It is 'L' shaped in plan and faces west.

Exterior

Entrance Tower

3.2.6 The main entrance to the building projects out from the south elevation in the form of a tower containing the foyer, the main staircase and a lift shaft. This element of the building was added later but and an exact date of its construction is not known. However, according to the heritage statement review of available archival documentation has confirmed that it was likely constructed between 1954 and 1963 (Fig 15).

Fig 15 Main entrance tower

3.2.7 The entrance tower has a distinguishing Art Deco inspired appearance, and it complements the architectural character of the factory building. Its pronounced vertical outlook provides a focal point to the site from Nestlé's Avenue. The entrance tower and the gate that leads to it from Nestlé's Avenue were incorporated when the site was established as Nestlé's UK headquarters, and it clearly illustrated the sites increased importance.

3.2.8 The tower is a five-storey tall reinforced concrete structure. The base of the tower at its ground level is much wider than its span from the first floor upwards. On the ground floor, it contains the main entrance hallway with a lobby area on the east while the west end had two rooms. From the first floor upward it contains the staircase and a twin lift shaft. However, a toilet block has been built on top of the east side of the ground floor lobby which detracts from its symmetry. The toilet block appeared to be a later addition to the tower.

Main Building exterior

3.2.9 The external elevations of the building have a relatively plain and repetitive appearance. Both south and west elevations of the building are formed of equal bays of multi-pane windows with crittall style metal glazing on all floors.

3.2.10 The south facing (front) elevation of the building comprises a three storey section at the west end (Fig 16), while the central section is four storeys high with the entrance tower added in the mid-20th century as described above; the east end of the south elevation is formed of the single storey range that was also added as part of the extension of the factory.

Fig 16 Central section of the south elevation of the main factory building

3.2.11 The west end of the elevation contains a projected bay housing a staircase that provided access to the first and second floor and is possibly a modern addition to the building. Further west of the south elevation is a steel fire escape staircase that provided access to all three floors and up to the rooftop (Fig 18).

3.2.12 The large central section of the south elevation conforms to the general appearance of the building. On the ground level, there is a fork-lift truck entrance and a pedestrian entrance in this section.

Fig 17 Single storey east section of the south elevation

3.2.13 The single storey east end of the elevation is formed of the reinforced concrete extension of the main factory. Its design complemented the existing exterior of the building, having a similar bay formation with each bay having large multi-pane windows. However, the windows in this section have been observed with louvred glass sections. It has a pedestrian entrance doorway approximately in the centre accessed by steps as well as a concrete ramp. The east end of the extension is two storeys high; there are no features in the first-floor level (Fig 17).

Fig 18 West end of south elevation with a steel fire escape staircase and the modern stair tower

3.2.14 West elevation of the building also has the general bay formation of multi-pane windows with crittall style metal glazing on all floors. The 1920s Truscon building in this elevation is three storeys high with a number of loading bays and pedestrian entrances on the ground level. The north end of the west elevation is formed by the earlier building with distinctive red brick plinth. The openings in the earlier building have concrete mouldings. There is a projecting stairwell at the north end of the 1920s building, and a loading bay has been added to the 1912 further north on the west elevation (Fig 19, Fig 20).

Fig 19 Central section of the west elevation

Fig 20 Loading platforms have been added to the north end of the west elevation. Loading bays have been formed by inserting openings in the older part of the factory

Fig 21 Central section of the east elevation

Fig 22 Single storey section of the factory building, view from the roof of the four storey section

3.2.15 The east elevation of the building is formed of the single storey section of the factory above which the four-storey central building, as well as the industrial M roof, was visible. The two storey section at the south end of the elevation has a large Nestlé insignia on the first-floor level whilst the north end of the east elevation has a large canopy. The canopy is formed of reinforced concrete trusses where the elements are rebate jointed. The canopy is covered in corrugated asbestos sheets with a row of skylights. There are loading doors located within the area covered by the canopy. Presumably, this section functioned as a loading bay (Fig 21, Fig 22, Fig 23, Fig 24).

Fig 23 The canopy at the north end of the east elevation, looking north-west

Fig 24 Loading bay covered in a canopy at the northern end of the east elevation

3.2.16 The north facing rear elevation of the building comprises a two-storey section to the east while the rest of the elevation is three to four storeys high. Apart from a lift shaft bay the north elevation also formed of bays with multi-pane crittall style windows on all floors. However, windows in this elevation are not as large as those in the other façade s. A wide concrete platform with protective handrail

runs along this section of the elevation. A number of double doors and goods lift door are accessed from the platform. Whilst the two storey section of the elevation has no fenestration in the first-floor level and intermittent bays of windows on the ground level. It has a large loading bay located approximately in the centre of the double-storied eastern section of the elevation (Fig 25, Fig 26).

Fig 25 West end of the north facing rear elevation of the factory building

Fig 26 East end of the north elevation of the factory building

Interior

3.2.17 The main entrance to the factory building is through the entrance tower. It has a large heavy brass double door that swings inward and outwards and leads into a hallway and a lobby area to the east. The hallway and lobby have a terrazzo tiled floor. The stairwell walls on the ground floor originally had a rubbed concrete finish, but it has been covered in plasterboard. The foyer area has fixed glazing above dado height with central pivoting panes. There is a wooden dado rail running below the glazing panes (Fig 27, Fig 28).

Fig 27 internal view of the main entrance door

Fig 28 Interior of the entrance lobby looking east

3.2.18 The stairwell has a terrazzo concrete dressed dado. Above the dado level, it is lined with wallpaper. It originally had a brass handrail fixed on to the wall. The handrail has been removed prior to the survey, and only the brass is fixing brackets were observed.

3.2.19 Due to the extended size of the building the internal areas of the building have been numbered for the ease of reference in the description. Please refer to the area numbers in the plans in Appendix 1.

Ground Floor

3.2.20 The south side of the ground floor interior is mainly open with partitioned rooms which appeared to be mostly for storage and in the original layout. Large open space along the south and east side of the building GF17 is also used as storage area. GF1, GF2, GF3 and GF17 has the red tiled floor. The eastern side of the building is single-storied with a reinforced concrete industrial roof with clearstories. Along the east end on the ground floor, there are four small rooms GF4 to GF7 which functioned as laboratories (Fig 29).

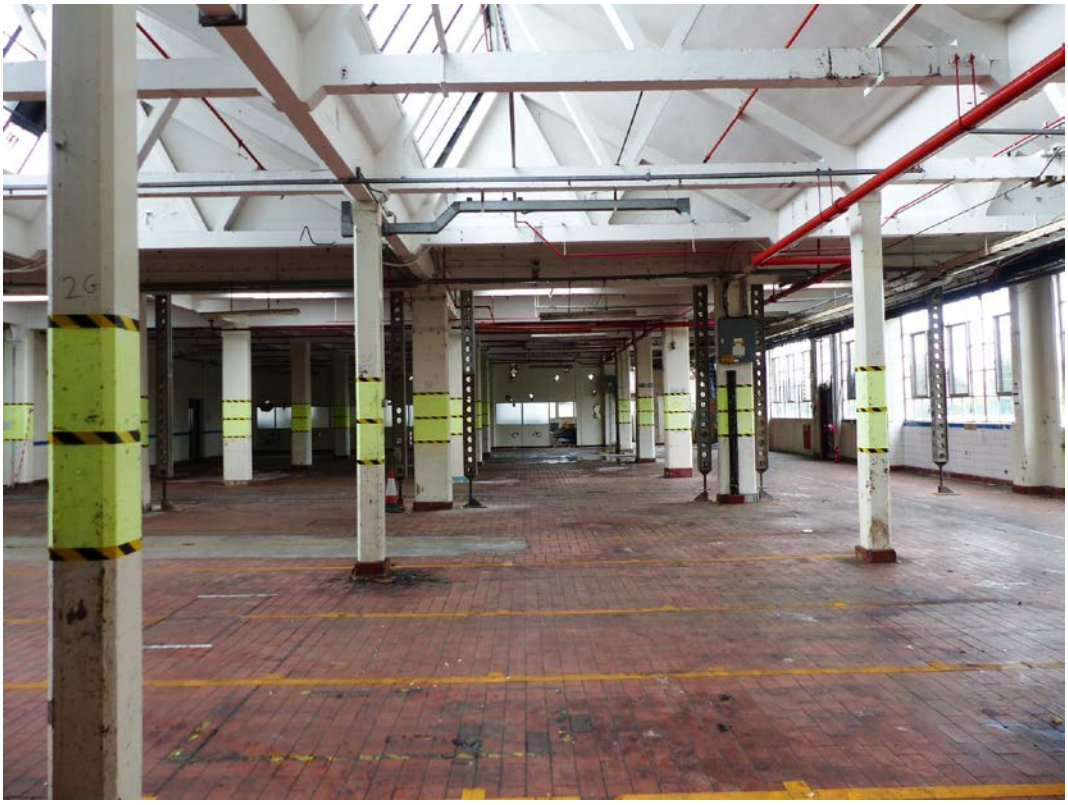

Fig 29 Ground floor storage area within the single storey east section, looking east

3.2.21 Area GF2 is accessible from the south through a forklift truck entrance. The red tiled floor of this area was observed with a number of plinths which were presumably installed for the placement of plant and machinery. A double door in the north wall provided access to a storage area that has been inserted into the light well (GF9) (Fig 31). It is constructed of steel framing and corrugated steel sheet walls with a shallow steel roof and has a red tiled floor. The south-west corner area on ground floor, GF1, has a steel mesh-enclosed area which likely functioned as a storage area. Currently, there are hundreds of used motors stored in this area (Fig 30). A staircase raised from GF1 provided access on to the first floor while it has a pedestrian entrance from the south and a loading bay at the north-west corner (Fig 32).

Fig 30 Storage area in the south-west corner of ground floor GF1, looking north-west

Fig 31 Inserted steel storage area with tiled floor accessed from GF1

Fig 32 A staircase from GF1 provided access up to the first floor, looking north-

Fig 33 Loading bay at the south-west corner of GF1

3.2.22 Area GF8 along the west side of the ground floor is a large storage area with steel shelves. This area is accessible through a vehicle entrance as well as a pedestrian entrance from the west. The shelving has been used to store workshop tools and parts. It has a painted concrete floor. The east end of the area has been extended into the original light well (GF9) with a steel corrugated lean-to roof and large multi-pane windows to the east. The original external wall to the light-well has been removed however scarring from the walls are evident on the floor (Fig 34).

Fig 34 Interior of GF8, looking west

3.2.23 From GF8 a double door leads on to a small hallway from where the light well is accessible through a small door. The hallway also faces a small counter opening. The hallway also leads onto a long westward running corridor that has external access from west of the building. It is possible that in the original layout GF8 and GF18 was a single volume of space before the corridor was formed by inserting two side walls of modern breeze blocks. Further north a double door leads onto the east-west running corridor and fork-lift route. The hallway provides access to a lift shaft and a staircase (Fig 35).

3.2.24 Room GF18 is a large area and functioned as the entrance of a fork-lift route. The northern part of GF18 is located within the original 1912 construction with a large fork-lift entrance from the west (Fig 37). The room also contains a plant room along the west side and a switch room at the east end. This room, as well as the fork-lift route to the east, currently has a concrete rendered floor however through some damaged areas the original floor was observed. The original floor surface was formed of triangular steel plates (Fig 36). Further east is room GF20, also located within the earlier building. It has a jack-arched brick ceiling. Room GF20 to GF23 are all large volume spaces which functioned as Tote Bin Storage areas (Fig 38, Fig 40).

Fig 35 Staircase and goods lift next to GF18

Fig 36 Steel triangular blocks formed the forklift route

Fig 37 Southern part of GF18, looking west

Fig 38 Interior of GF20, looking east

3.2.25 GF21 is located within a single story section with an industrial M roof, possibly constructed within an original light as well. A double door from GF21 provided access into GF25 which has been used as a workshop and located within the light well of the original building. It has a concrete floor and steel framed industrial

roof with skylights (Fig 39). GF27 is a large wide area containing fork-lift route with an external entrance from the west. The floor of this area was also formed of triangular steel plates.

Fig 39 Interior of GF25

Fig 40 Tote Bin Store, GF22, looking north-west

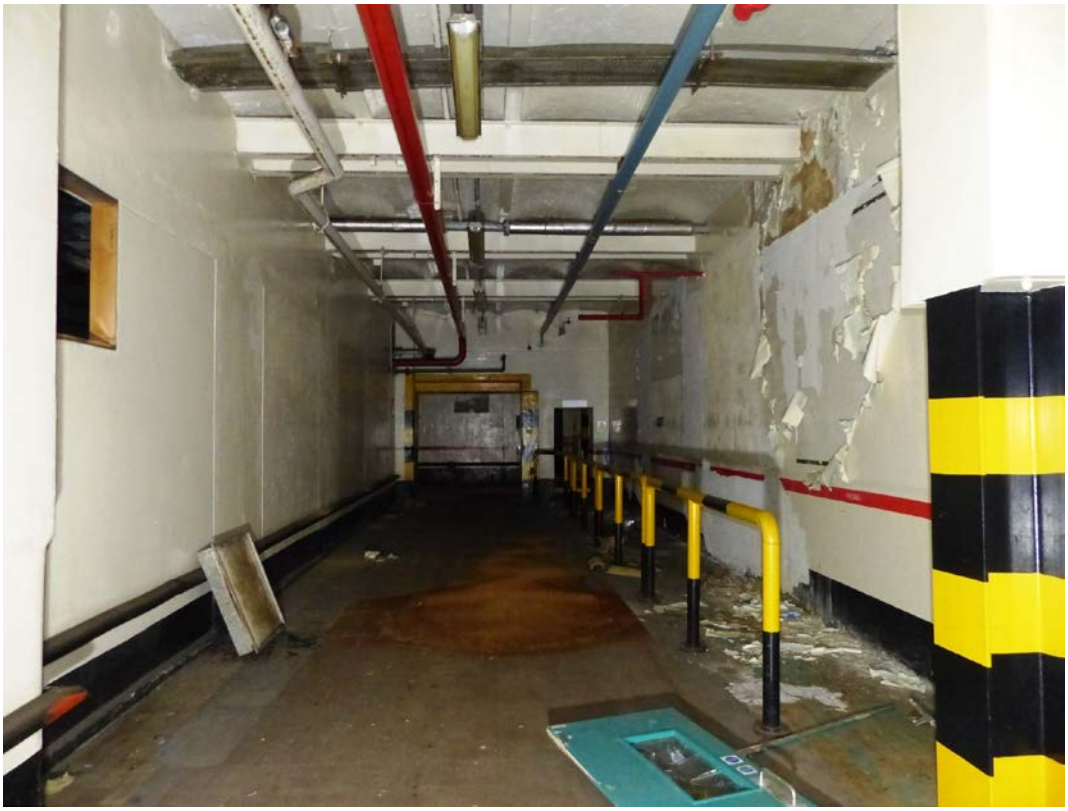

Fig 41 GF28, looking east

3.2.26 Room G34 is mainly a large open room possibly for storage. It has asbestos tiled flooring and windows to the east (Fig 42). The north end of the area contains a laboratory section with two small chambers (Fig 43). G35 is a large storage area with brick wall to the north separating it from two plant rooms in the north-east corner on the ground floor (Fig 44). This area was not accessible due to hazardous toxic chemicals. A westward running corridor from G35 leads onto a wider fork lift route inside the factory which runs all the way to the north.

Fig 42 Room GF34, looking south-east

Fig 43 Laboratory area in the north-east corner of GF34

Fig 44 Room G35, looking north-west

Fig 45 Room GF39

3.2.27 The north-west corner of the ground floor, GF39, contains a processing area with the red tiled floor. The reinforced concrete columns in the area have similar red tiled dressed plinths. Steel machinery are fixed onto both the columns and the floor. A number of drainage channels have also been observed running through the floor (Fig 45).

3.2.28 Along the north side of the ground floor runs a forklift circulation route that provides access to the loading bays at the rear of the building. This area has multi-pane clerestory windows to the north. On the south side of the fork-lift route there is a protected pedestrian route that provided access to a number of large plant rooms (GF44, GF45). Another central forklift route runs south from it which provides access to the large storage rooms GF32, GF33 and ends in GF17. This route also has a protected pedestrian route running along its path up to GF17 (Fig 46, Fig 47).

Fig 46 Fork-lift route along the north end of the ground floor, looking east

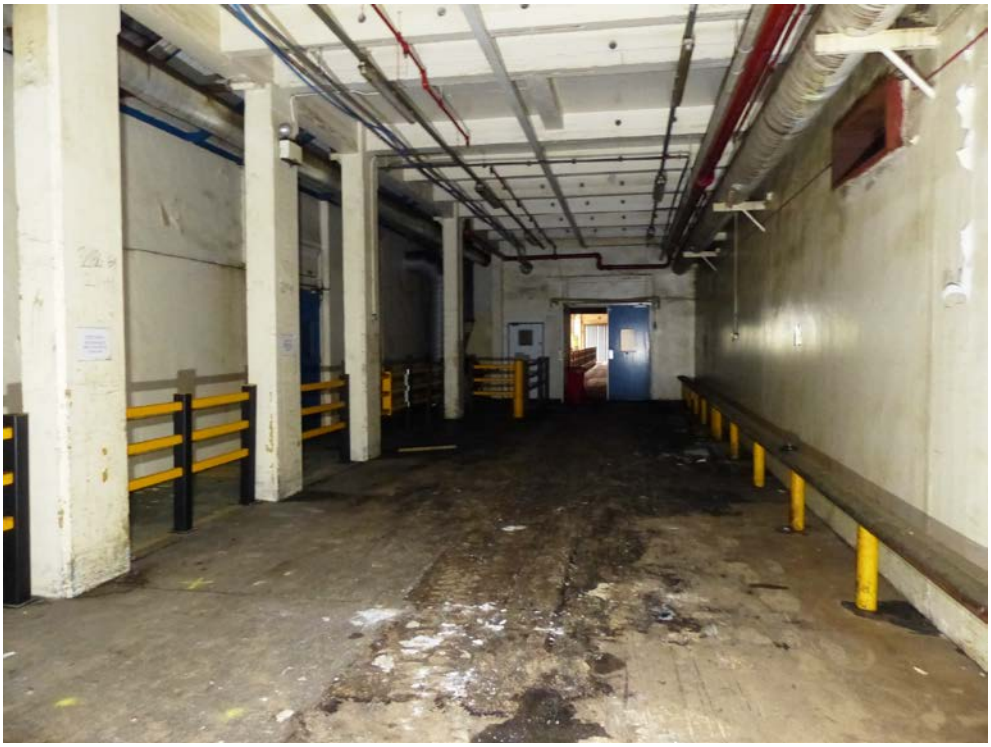

Fig 47 North-south running central fork-lift route, looking south

First Floor

3.2.29 The internal layout of the first floor consists of a mixture of open and closed office space, workshop areas, storage and coffee bean processing areas and leisure areas such as the staff gym.

3.2.30 Rooms 1F1 to 1F15 are located on the south side of the first floor. Notable in this area are rooms 1F4 to 1F8 which contain the staff gym and recreation areas (1F4 – 1F7) as well as the staff shop, cafeteria, and the commercial grade kitchen and food preparation areas (1F8) (Fig 48). This area is located toward the centre of the first floor between the two southerly light wells.

3.2.31 The access from the main entrance stairway on the south elevation enters into a large open plan office space (room 1F15) with fourteen smaller glass partitioned rooms, eight in the north area and six along the south side. This area of the first floor had dropped ceilings with evidence of carpet tiles on the floors. The rooms to the south overlooking the 1950s former Canteen consist of a conference room and the factory manager's office, a printing and stationary room, a cloakroom and two smaller office spaces. These rooms are numbered 1F14, 1F13, 1F12 and 1F11 respectively. The remainder of the partitioned rooms are all very similar in size and unremarkable in character and were not numbered. In addition, 1F10, formerly a plant room is located inside this room. The east windows overlook the roof of the eastern extension of the ground floor.

3.2.32 The rooms along the west elevation include 1F18-1F30. Rooms 1F18-1F20, inclusive, were the male and female locker rooms, showers and toilets. These rooms were accessed through separate entrances at both the north and south ends. Directly north of this area, evidence of the original 1914 Sandow factory building can be seen in the change to vaulted ceilings, brick walls and rounded support pillars. In addition, this part of the building received less natural light due to the nature of its construction (Fig 49).

Fig 48 Staff shop and cafeteria, room 1F8 looking north-east.

Fig 49 Evidence of the original 1914 Sandow building looking west; the doors to room 1F32 can be seen in the left of the photograph.

Fig 50 Room 1F49 looking west

3.2.33 From the locker rooms the remainder of the west side can be accessed through a long hallway. Leading off this hallway are several variable sized storage rooms and offices, these are numbered 1F21-1F33. At the north end, this hallway turns east (right) toward rooms 1F39-1F44. To the south and north of the hallway a

series of very large rooms, containing coffee roasting and drying equipment, are located along the north end of the building (1F45 – 1F52) (Fig 50). These large rooms have red tiled floors and variable levels. Heading east through these rooms are large storage rooms 1F51-1F52 which were used for storing green coffee beans.

Fig 51 Room 1F49 looking west

Fig 52 Room 1F61, machine storage looking north-east

3.2.34 Moving south through room 1F50, along the east elevation of the building, rooms 1F55 – 1F61 can be accessed (Fig 52). These rooms include storage, plant rooms, electrical workshops and office spaces.

Second Floor

3.2.35 The internal layout of the second floor is formed of mainly large storage areas in the south-west and in the centre; plants and processing areas at the north end and office and conference rooms in the south-east corner.

3.2.36 From the main stairwell, the second-floor lift lobby leads onto two double doors, of which the eastern one provided access into Boardrooms (2F8 and 2F9) (Fig 53), and the western door leads on to a corridor that provided access into the rest of the floor. The boardroom has a modern interior with carpeted floor and suspended ceiling.

Fig 53 Interior of the board room on the second floor, looking north-east

3.2.37 The wide corridor leads into the conference rooms at its north end (2F17). The conference rooms have aluminium glazed partition walls, carpeted floor, suspended ceiling. On the west side of the corridor was a large office area, 2F6, with storage shelves. From the north end of the corridor another narrow corridor runs west providing access to further office areas to the west and north. 2F5 is a large office area which functioned as the Accounts Office.

3.2.38 The north running corridor provided access to the large open area with linoleum covered floor. The north-west corner of the room has a chamfered side with clerestory windows. The north-east corner of the room has a goods lift shaft. The north wall of this room originally had a double door which is blocked now.

3.2.39 The central area and the west end of the second floor contain large storage areas. These are mainly single volume spaces only interrupted by the concrete columns. The storage areas generally have concrete floors some of which are marked with bays. The interior of the areas are generally well lit with natural light coming from large windows to the exterior and from the light wells (Fig 54).

Fig 54 Large storage areas on the second floor

3.2.40 The north end of the second floor contains a number of chocolate and coffee processing areas as well as a large open space for storage and a fork-lift route (Fig 55). Room 2F25 along the east side of the second floor contains a number of coffee and chocolate processing chambers (Fig 56).

Fig 55 Processing areas along the fork-lift route on the second floor at the north end of the building

Fig 56 Coffee and chocolate processing plants on the second floor 2F25

Third Floor

3.2.41 The third floor of the factory building covers a smaller extent than the second floor, as the south-west corner of the building does not have a third-floor level. The north-east section on the third floor contains some processing areas while the central section contains small office areas. The south-east section contained office and storage areas (Fig 57). The third floor of the earlier building in the north-west corner contained a museum, a library and some other services.

3.2.42 The office rooms in the central section are connected by a north-south corridor providing access to all areas in this section of the building. The corridor also connects to the north-west side via a covered walkway at its south end. The covered walkway from the central section leads into the third floor of the earlier building in the north-west corner (Fig 58, Fig 59, Fig 60).

Fig 57 Storage areas in the south-east section of the third floor (3F9), looking north-west

3.2.43 The office rooms generally had carpeted floors and wooden skirting at the base of the walls. Large crittall windows to the east and west provided natural light into the rooms. This section also contains a workshop room and laboratory area. The north end of the central section contains a storage area.

Fig 58 Covered walkway providing access to the older part of the building on the third floor

Fig 59 Interior of the covered walkway

Fig 60 A north-south running corridor through the central section of third floor containing small office rooms

3.2.44 The north and north-east section of the building was not accessible from the south-east and west side, but from a staircase from second-floor level. The north-east section contains food production areas (Fig 61). Large plant and processing units were observed in this section of the third floor. There is a small office area plus control room in this section, from which the plant and processing units were controlled and monitored (Fig 62). Further north, along the north end of the third floor, there is a large open area containing plant and machinery, installed on slightly raised plinths (Fig 63).

Fig 61 Food production area in the north-east corner of the third floor, looking north

Fig 62 Food production control room and office in the north-west section of the third floor.

Fig 63 Plant and machinery along the north end of the third floor

3.3 Former canteen

Introduction and layout

3.3.1 The Former Canteen building at the Nestlé Works is a one to two storey reinforced concrete structure, located along the former main entrance way from Nestlé's Avenue. The building was constructed in 1954 following the establishment of the Hayes site as the Nestlé UK headquarters (Fig 64).

3.3.2 The Former Canteen is a large amenity building containing an open double storey hall with two-storey office areas along the south and west sides and a single storey colonnade along the east side of the building. Compared to its construction date, the building presents a Streamline Modern style of office canteen which is late Art Deco architecture that complements the 1920s factory building. In recent times the building was used as a warehouse with very slight modifications to its original fabric.

Fig 64 Former canteen building, view from the Main Factory roof, looking south-west

Exterior

3.3.3 The building has two principal façade s, the south and west elevations. Both of these elevations are visible from Nestlé's Avenue and west elevation fronts onto the former main entrance to the south. These two main façade s present good detailing in the late Art Deco style, complementing the exterior of the already existing main factory building (Fig 65, Fig 66).

3.3.4 The main hall of the canteen building has a large shallow double pitched roof. The construction of the roof structure was not observed, however in keeping with the period of construction it is possibly of steel fink trusses. The external covering of the roof is formed of corrugated asbestos sheets with skylights of translucent sheets. Two rows of skylights run along the ridge of the roof of either pitch.

3.3.5 The two-storey office wings along the south and west side of the building have a flat concrete roof. The single storey colonnade also has a flat reinforced concrete

roof which is accessible from the south-east corner stairwell and has metal edge protection railings.

3.3.6 The south elevation of the building has three sections, formed of four bays on either side of a slightly advanced central section. The central section has three bays. Both ground and first floor have large multi-paned windows constructed of crittall style metal glazing. The piers between the window openings are not dressed with light green glazed tiles as seen in the west elevation, but the window openings are taller.

Fig 65 South facing elevation of the former canteen, looking north-west

3.3.7 The west elevation of the canteen forms the west wing, and there is a loading bay under a large canopy. The entire elevation features bays of large multi-pane clerestory windows on both levels, separated by sections dressed with mint-green tiles. The windows are made of crittall style metal glazing. On both levels, the windows openings have precast concrete sill bands, slightly projecting with drip-moulds on the soffit of the projection to throw off rainwater. Similarly, the lintel of the windows on both levels have projecting plat bands, also constructed of precast concrete with drip mould. Both plat band and sill bands have a sloping top face (Fig 66, Fig 67).

Fig 66 West elevation of the Former Canteen, looking south-east

Fig 67 South end of the west elevation with a large steel canopy

3.3.8 The northern bay of the west elevation has a different appearance with narrower window openings, and the entire bay is 0.23m advanced, containing two sets of large double doors. Window and door openings in the northern bays have projecting concrete surrounds. The two double doors in the bay are made of aluminium glazing and appeared to be replacements.

3.3.9 The south end of the west elevation contains a large canopy above a loading bay. The loading bay and the canopy appeared to be inserted features and were probably added in the 1980s. The loading bay has a double stepped recess containing two large vehicle entrances. There are also two pedestrian entrances either side of the vehicle entrances. Further south the elevation contains a gated office, accessed by a set of timber frame double doors with flanking fixed-light windows. The southern flank window is blocked and has a concrete surround. In front of the bay is a stone and tile paved surface protected with a waist-high steel fence. Along the base of the west elevation, the building has a low concrete plinth, painted in black (Fig 67).

3.3.10 The north facing rear elevation of the former canteen building comprises the north end of the two-storey west wing. The upper section of the gable of the main hall, at the north end of the colonnade has a projecting porch. There is also a low single-storey section built against the north elevation of the main hall, which contains plant and utility services. This central section is set back from the colonnade and the west wing, forming a recessed garden area. The north end of the west wing has a plain façade with no fenestration or openings. However at ground level, scars of a former door and a window were observed (Fig 68, Fig 69).

Fig 68 West end of the north elevation, looking south-west

3.3.11 The single storey service area to the north end of the main hall has five sets of windows to the north spaced at regular intervals. These aluminium glazed windows appeared later compared with the age of the building. These also have sloping, externally projecting sills formed of two courses of black tiles. This elevation also contains a number of plant room doors at ground level and a plinth similar to that seen in the west elevation. The plant doors have louvred vents. Further east of the elevation contains the simple entrance porch of the colonnade (Fig 69).

Fig 69 East end of the north elevation, looking south

3.3.12 The east elevation of the building is comprised of the single storey colonnade, east elevation of the two-storey south wing and the east pitch of the main hall roof. The colonnade has a series of reinforced concrete columns along the east side of the building supporting the concrete roof. Within the colonnade, the east elevation of the main hall is articulated in five bays separated with reinforced concrete columns. Each bay has large crittall style metal glazing frames with two sets of double doors with a louvred window above the doors. All bays have a similar span, apart from the southernmost bay which is slightly smaller and contains only one set of doors (Fig 70).

Fig 70 East elevation of the main hall and the interior of the colonnade, looking south-west

3.3.13 The northern end of the east elevation is formed of the single-story section containing plant rooms and utility services. It has no fenestration to the east, but a large louvred panel vent to the south faces the colonnade. A door from the north end provided access to the central amenities office.

3.3.14 The south end of the east elevation is formed of the two storey office wing along the south end of the building. It has no windows to the east but a large double door on the ground floor. It also has a large metal glazed window to the north facing into the colonnade.

Interior

3.3.15 The former canteen building has a simple internal layout formed of the two office wings along the south and west side of the main hall, a colonnade along the east and plant and utility blocks at the north end. Due to environmental health and safety hazards, the majority of the ground floor including the main hall was inaccessible during the present survey (Fig 71).

Fig 71 Interior of the main hall of the former canteen, looking south-west

3.3.16 Three corners of the building contain stairwells; among these, the south-west corner stairwell contains the main staircase. Two lesser staircases are located in the north-west and south-east corner of the building. All three staircases are reinforced concrete structures cantilevered from the walls. Among these, the south-eastern and north-western staircase each have three flights with two mezzanine landings, whereas the main staircase has five flights with three mezzanine landings. All staircases have uniform bannisters formed of steel spindles supporting wooden handrails (Fig 72, Fig 75, Fig 78).

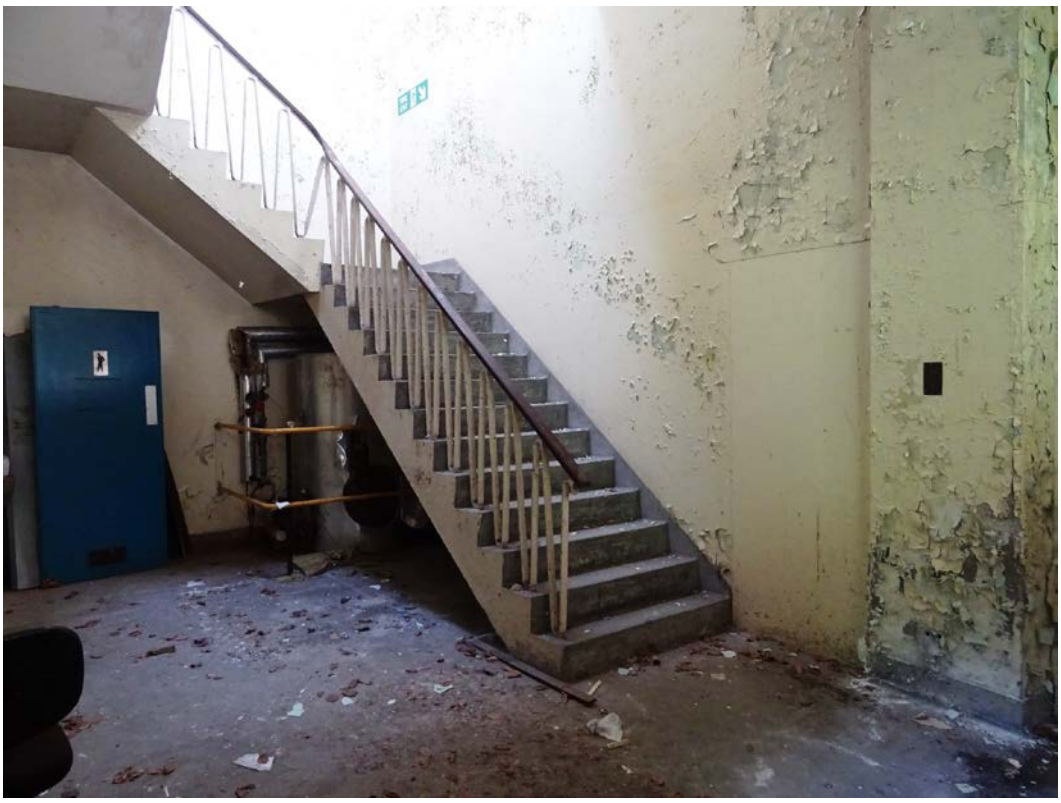

Fig 72 South-east corner staircase, looking south-west

Fig 73 The main office area in the south wing on the ground floor, looking east

3.3.17 Main access to the building is from the south-west corner. On the ground floor, the south wing contains a large office area with external entrance from the south

and two fire-exits at both ends of the projecting central section of the south wing. The main office area in the south wing on the ground floor has an open plan layout with a kitchen area at the east end (Fig 73, Fig 74). It has a concrete floor and a possible bricked up wide opening to the main hall area in its north wall. The west end of the south wing on the ground floor was inaccessible at the time of the survey. A pedestrian entrance from the south, at the west end, provides access into the main stairwell through a narrow corridor whilst the north-west stairwell is accessible through a double metal glazing crittall door from the west.

Fig 74 Kitchen area at the east end of the south wing, looking east

3.3.18 The south-east corner stairwell was accessed through an external double door south of the colonnade. Two separate male and female WCs located at the south-east corner of the building was accessible from the stairwell. Another set of double doors provided access to the main hall area and also into the south wing.

3.3.19 On first floor level, the south-east stairwell provided access into the rooms at the east end of the south wing, the rooftop patio above the colonnade and into the main office areas in the south wing to the west. The door to the east was not accessible during the survey. As a result of the two south-east corner rooms. The roof patio is accessible through a large crittall style metal glazed patio door (Fig 75).

3.3.20 The south wing office area has a large interior space mainly open plan with a number of cabins formed of modern partition walls with clerestories. It has a suspended ceiling and carpeted floor. The south wing office had a 1980s interior and was in a very dilapidated condition. The west end of the office area leads into the south-west corner stairwell leaving a computer server room and a WC in the south-west corner. The computer server room has a modern interior with a steel waffle floor (Fig 76, Fig 77).

Fig 75 First floor landing at the south-east corner stairwell, looking east

Fig 76 First floor office area in the south wing, looking west

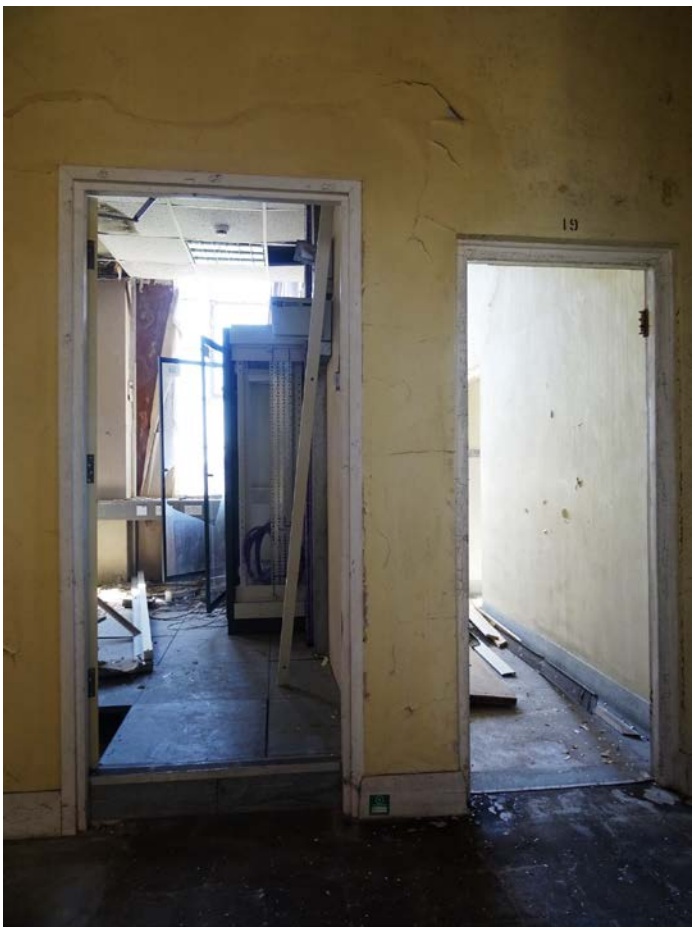

Fig 77 Doors to the computer server room and the WC at the south-west corner on the first floor

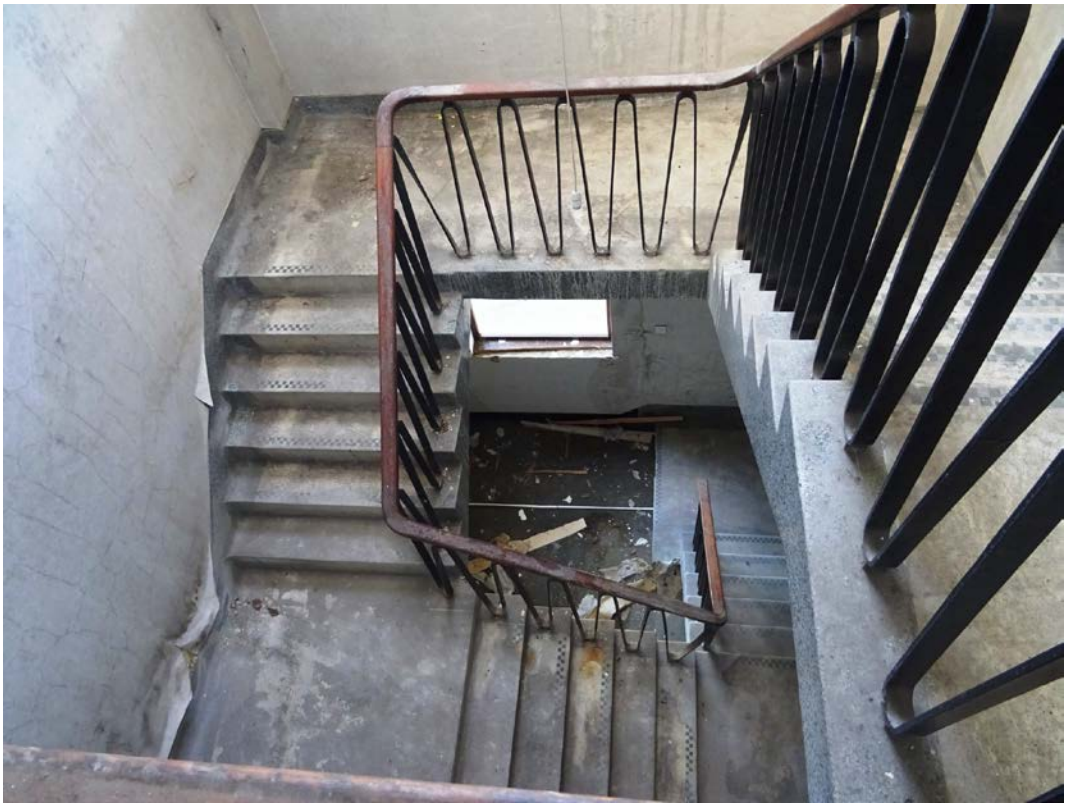

Fig 78 Main staircase at the south-west corner of the building

3.3.21 From the south-west corner stairwell, a long northward running corridor provided access to the offices in the west wing. The west wing has a series of offices with windows to the west and all accessed from the long corridor. The corridor is well lit with clerestory windows to the east. These are smaller than those in the west and south elevations of the building. The clerestory windows in the southern half of the corridor are at a higher level clearing the Main Hall. The northernmost two windows are large. Of these the northern one provides light in a female WC. The second window from the north in the corridor accommodated a later inserted door possibly to access a service gantry that has since been removed (Fig 79).

Fig 79 South end (left) and a central portion (right) of the north-south running corridor on the first floor of the west wing.

3.3.22 The office rooms within the west wing have been modified. Originally these rooms had wooden parquet flooring in a herringbone pattern. These were all covered in carpets. Herringbone parquet flooring was observed in a number of rooms where the carpet has been removed (Fig 80, Fig 81).

Fig 80 Southern end office room on the first floor of the west wing, looking south-east

Fig 81 One of the first-floor office rooms in the west wing with herringbone wood parquet flooring

Fig 82 Northern end of the corridor on the first floor, looking north

Fig 83 Goods lift accessed from the corridor on the first floor

3.3.23 At the northern end of the first floor, there is a large female WC with the original interior. The door into the WC leads into a common area with a hand basin; the remainder of the toilet area, with cubicles and the mirrored washing area, are separated by a glazed metal screen. The interior of the WC including the cubicles have a terrazzo tile floor and wall dressing as seen in the south-west staircase (Fig 82, Fig 84).

Fig 84 Female WC in the northern end of the west wing on the first floor

3.3.24 Both first and second-floor windows are uniform in design. They are made of crittall style metal frame with clear glazing. The internal doors and frames also have simple geometric profiles. All double door frames were observed with slightly projecting architrave, however the single door frames do not have this feature (Fig 85).

3.3.25 The colonnade is open to the east and has a projecting entrance with a canopy to the north. It has concrete tile flooring formed of 12-inch square precast concrete slabs. The colonnade floor also features a drain with metal grates along the Main Hall. The ceiling of the colonnade was never rendered, and it bears marks of the centring structure.

Fig 85 External door from the north-west stairwell

3.4 The Lodge

Introduction

3.4.1 The lodge building is located at the south-east corner of the site visually separated from the main factory buildings by the wooded area running along the southern verge of the site. Much of the wooded area, however, has been replaced with a large car park presumably during the mid-20th-century expansion of the site. It is believed that the lodge building was constructed in 1919 as part of an initial extension of the site. There is no concrete evidence to confirm the date of its construction though its design and form appears synonymous with this period.

Fig 86 The lodge, looking north-west

3.4.2 It is a two storey building with an attic level plus basement. The basement level of the building has been reported as being flooded during the time of the survey and due to health and safety concerns the basement was not accessed. The building is rectangular in plan and has an east-west orientation. The lodge building is constructed of load-bearing walls of red bricks laid in Flemish and also in Stretcher bond. The building is designed in a good quality Domestic Revival style with an Arts & Crafts style projecting main entrance bay into the south (Fig 86).

3.4.3 The Lodge was originally built as a dual-unit residential house, but later converted to a single house. Architecturally, the building also does not conform to the design and features with the main factory, presumably due to its original domestic use and possibly also to match the residential houses on Nestlés Avenue.

Exterior

3.4.4 The lodge has a high double pitched tiled roof with two cross gables and four sets of dormers. The ridge of the roof runs east-west with the pitches falling north and south. The north pitch of the roof has a steeper angle than the south pitch, and it has a longer fall. The cross gable to the south has a better projection as it covers the entrance bay to the south. However, the two dormers in the south pitch are located much higher, and they are smaller than those in the north pitch.

The roof has noticeably flared overhanging eaves with timber boarded soffits.

3.4.5 Both end gables of the building feature a projecting brick chimney breast with minimum frilling of brickwork corbelling outwards. The parapet of the chimney stacks are formed of yellow bricks and the pots are not visible.

East

3.4.6 The east facing elevation of the lodge building has a symmetric appearance formed of a plain brick façade with a projecting brick chimney in the middle. The bricks chimney has wider projections at the ground and first floor level with independent tiled capping. There are two identical small window openings in the brick gable, placed either side of the chimney at second floor (attic) level.

Fig 87 North and west facing elevation of the Lodge, looking south-east

West

3.4.7 The west elevation also has an exterior projecting brick chimney identical to that seen in the east elevation (Fig 87). Also seen in the east elevation are two small window openings in the brick gable, at either side of the chimney, providing natural light into the attic level. At first floor level, there is slight projecting brickwork observed with slate capping presumably containing flues from the first-floor fireplaces. There are two windows to the west at first-floor level.

3.4.8 The west elevation originally had a symmetric appearance until the construction of a single storey extension to the west. The extension was constructed with load-bearing brick walls to north, south and the west sides. The extended section was covered in a lean-to roof. Efforts have been made to give an impression of a cat-slide roof to match the Arts and Crafts style of the building.

3.4.9 The extension did not cover the entire span of the west elevation. It contained an external entrance from the west accessed by a modern ramp and canopy formed of steel frame and translucent corrugated sheets.

South

3.4.10 South elevation of the building forms its main façade fronting on to Nestlés Avenue though the building is quite set back from the street and only partly visible due to trees and vegetation (Fig 88).

Fig 88 South elevation of the lodge, looking north-east

Fig 89 The main entrance bay in the south elevation of the lodge, front (left) and side (right) views

3.4.11 The original façade, prior to the ground level extension to the west, has a symmetric appearance with a projecting entrance bay at the middle. Both bays have one large bay window at the ground floor level with independent tiled bay-roofs, one four-light window on the first floor and a dormer in the attic with hipped-roofs.

3.4.12 The projecting entrance bay was constructed as structurally independent of the building, although internally integrated, and its gable roof is integral to the main roof structure. It is effectively a timber-framed structure with brick-infilled external walls; all timber elements of the framing are visible externally as well as internally (Fig 89, Fig 89). The south façade of the entrance bay has a herringbone pattern brick-infill with a mix of red and dark bricks.

3.4.13 The entrance bay contains an external doorway to the south with a wide top-pivoting transom and flanking windows at ground floor level, while on the first floor it has five sets of windows facing south. There are two miniature windows in the gable of the bay. Both the ground and first floors of the entrance bay have identical side windows to the east and west. The central bay does not have a plinth along its base as seen in the rest of the exterior of the building

Fig 90 Projecting out wooden pegs and wedge lock

3.4.14 An interesting feature of the timber-framed bay is that all timber elements of the frame have traditional mortise and tenon joints with double wooden pegs. The pegs have square profile ends thicker than the inserted rounded portion, and the ends are projecting out of the joint prominently. Similar fashion has been noticed in the roof bargeboard joint. The bargeboards in the gable are wedge locked to the roof structure, and the wedge lock elements stick out quite prominently (Fig 90).

North

3.4.15 The north elevation has a near symmetric appearance formed of a central bay with a gable and two slightly advanced side bays. The central bay contains two separate external entrance doorways within a recessed porch. Presumably, these two doorways provided access into two separate units in the original layout. The doors were also observed with two different property addresses. However, as the internal layout has been modified to convert it into a single unit, one of the doors has been blocked (Fig 91).

Fig 91 North elevation of the Lodge, looking south-west

3.4.16 The entrance recess is formed by the support of a large timber beam, but it is not located in the centre of the bay. It has chamfered openings and a 9-inch square red tiled floor, with blue engineering brick edging. To the west of the porch, there are two small clerestory windows (Fig 92).

Fig 92 Entrance doorways from north

3.4.17 The central bay has a four-part window on the first floor and a small light within the gable providing light for the attic level. The gable has a red brick-dentilled frieze (Fig 91).

3.4.18 Above both side, bays are timber-framed dormer windows projecting from the main roof. These allow light into the first-floor level; there are windows at ground level too. The ground floor window in the west bay is larger than that in the east bay. The entire north elevation features the general concrete rendered plinth. Along the base of the west and the central bay, there are two basements light-well areas with very low edge protection.

Windows

3.4.19 All of the windows in the main building are almost flush with the exterior of the building. These are mostly steel casement glazed windows with irregular bull's-eye panes. Occasionally the bulls-eye panes have been noticed with ripple effects. The window openings generally have brick lintels formed of a course of bricks on their ends also known as soldier course. The window sills are formed of a course of bricks on their edges also known as rowlocks. Below the rowlocks are two slightly projected courses of tiles to direct rainwater away from the brick wall.

3.4.20 The timber-framed dormer windows and the two bay windows to the south, however, have timber lintels with boxed-fascia. These windows, as well as those in the projecting entrance bay in the south elevation, have projecting wooden sills. Both basement window openings to the north are seen through the light wells and have modern UPVC double glazing.

3.4.21 The steel casement window frames were observed with a manufacturers mark "HOPES". Hope's Windows was founded in 1912 and was originally known as International Casement Company. However, the trademark "HOPES" was not established until 1932 when the International Casement merged with Henry Hope & Sons, Inc., a major manufacturer of metal components. This contradicts the established construction date of the building purported as being in 1919. It is possible that the existing windows are replacements, however no physical evidence was observed to suggest that these were not the originals. In addition to this, the building was not shown in the 1919 Plan of NFF No.7 (Fig 7) and first appeared on the 1935 OS map (Fig 9).

Interior

Ground Floor

3.4.22 The interior of the Lodge building was accessed from the north through the entrance door within a recessed porch. It leads into an entrance hall containing the impressive oak staircase. The existing timber wooden staircase is designed in late Arts and Crafts style and is probably the most significant internal feature of the building (Fig 93). The staircase and entrance area has a tiled floor formed of 9-inch square red floor tiles. The western of the two doors has a fully glazed patio style door but timber boarded from outside (Fig 94).

3.4.23 The staircase has square profile oak newel posts and a wood panelled bannister with ellipses and moulded handrail. Balcony protection and caps also have same panelling. The soffit of the stair flights is also timber panelled. The banisters end on the second to last tread which has rounded ends and bullnose capping. The starting step is wider and also has bullnose capping.

Fig 93 The entrance hall and staircase on the ground floor, looking south-west

Fig 94 Internal view of the entrance doorways looking north

3.4.24 The ground floor of the lodge contains three large rooms to the south, a kitchen, lobby, services and utility rooms along the north side. The main internal circulation of the building is provided from the lobby. It provides access to a kitchen (G4) located in the north-east corner, two large rooms G9 and G2. A hallway runs westward from the lobby provided access into a small WC (G7), G6- which was possibly originally a kitchen, and the extension further to the west containing a laundry/ironing room, staircase to the basement, and a toilet. The hallway also leads up to an external doorway to the west (Fig 95).

Fig 95 External door to the west from the ground floor hallway, looking west

3.4.25 The front entrance of the building from the south leads into a small lobby (G1). This area was not accessible during the survey because of loose asbestos floor tiles. Room G2 is accessed from G1 and functioned as a reception area. It has a door to a small balcony area, into the projecting bay to the south. Two windows are flanking the glazed door to the south providing natural light into G2. It had oak floor boards covered in thick carpet. Room G2 has large double oak panelled doors to the east and north leading in to G3 and G5 (Fig 96).

Fig 96 Room G2. Note double timber doors to the stairwell and to room G5, looking north-east

Fig 97 Door and flanking windows to the south from room G2, looking south

3.4.26 Room G5 is located in the south-east corner of the building. It has a large bay window containing steel 5-part casements within a timber frame. The window has an internal laminate wood sill. The north-east corner of the room has a large Arts and Crafts style fireplace, and next to it there is a blocked window to the south.

G5 also has a timber boarded floor with a thick carpet. The north wall of this room is a thin stud wall that formed the kitchen, G4, which appeared to be a later insertion. Perhaps G5 and G4 were originally one large room with the fireplace in the middle of the east wall (Fig 98, Fig 99).

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Fig 98 Room G5, looking south

Fig 99 Fireplace in G5, looking east

3.4.27 The kitchen has a 1980s interior with laminate MDF kitchen cabinets. It has a large window to the north bringing ample natural light. The kitchen has a linoleum covered floor, white laminated worktops and the walls are dressed in white glazed tiles. The north-west corner of the kitchen also has a boiler cabinet (Fig 100).

Fig 100 Interior of the kitchen (G4), looking east

Fig 101 Room G9, looking north-east

Fig 102 Staircase leading to the basement

Fig 103 male WC on the ground floor (G7)

Fig 104 Room G6, looking south-west. Note door to the former pantry on the right

3.4.28 Room G9 (Fig 101) is located in the south-west corner of the ground floor. It is accessed from the stairwell lobby (G3). The interior is well lit by a large bay window to the south, identical to that seen in room G5. It has a timber boarded floor covered with carpet.

3.4.29 Room G7 is accessed from the ground floor hallway through a semi-circular arch way (Fig 103). It contains a small male WC and shares a part of a four-part window to the north. Another portion of the window provides natural light into room G6 which is also accessible from the westward running hallway. G6 has a red tiled floor like G3 and the hallway. It is possible that this was originally a kitchen with a pantry in the north-west corner.

3.4.30 Further west is the staircase leading to the basement through a door from the hallway (Fig 102). To the south within the ground floor extension is a laundry/ironing room with a double casement window to the south. It has asbestos tiled flooring. An old iron was also noticed in the room. In the north-west corner of the building within the ground floor extension is a small WC (G10) (Fig 106) with windows to north and west.

Fig 105 The ironing room (G8), looking south-west

Fig 106 Small WC in the north-west corner (G10)

First Floor

3.4.31 The first floor of the lodge has five bedrooms, two toilets and a storage room all accessed from the stairwell landing and the hallway running west. The Staircase has a much wider fascia with four shallow ogee arches with decorative carvings. However, the southern arch has been removed (Fig 107).

3.4.32 All rooms on the first floor apart from the south-east corner room (1F3) are accessible from the landing and hallway. Room 1F3 has doorways room 1F2 and 1F4. The internal partitions are formed of wooden stud walls and plaster boards. All rooms on the first floor have timber boarded floor with later added carpets and wooden skirting throughout.

Fig 107 First floor landing, looking west

Fig 108 North-east corner bedroom on the first floor (1F2), looking north-west

Fig 109 South-east corner bedroom on the first floor of the lodge, looking south-east

3.4.33 The first-floor landing (1F1) has a four-part window to the north and a carpeted floor. All the doors and the skirting visible from the landing have clear varnished oak trim conforming to the appearance of the staircase. Room 1F2 to the north-east corner has triple casement window in a dormer. This room also has an inserted boiler cupboard with vents in the north-west corner. A heavy metal safe was also seen in the room (Fig 108).

3.4.34 The south-east corner room on the first floor (1F3, Fig 109) has a five-part combination window of casements and awnings. A similar five-part window to the south at the west end, however, internally shared by room 1F7 and 1F6 (Fig 111). The partition wall between 1F6 and 1F7 did not appear to be inserted. The small area in the projecting entrance bay on the first floor, room 1F5 is very well lit by five windows to the south and one at each side. It is accessed from room 1F4 through a folding door. As well as the glazed door, two fixed light windows, either side of the door bring natural light into room 1F4 (Fig 110).

3.4.35 In the north-west corner on the first floor, there are two toilets and a storage room, all accessed from the west end of the hallway. A three-part window to the north is shared by the toilets whilst the north-west corner one has a window to the west as well. Interior of both toilets is dressed in glazed tiles. All windows on the first floor have internally projected sills made of oak trimmed chipboard.

Fig 110 Room 1F4, looking south-west

Fig 111 South-west corner room on the first floor (1F7), looking south. Note east wall abuts window to the south

Second floor / Attic

3.4.36 The attic level of the building formed the second floor, accessed by a single flight of the wooden staircase. The staircase leads into a large room and has a panelled timber protection to the staircase (Fig 112).

Fig 112 Second floor landing of the staircase, protected with timber panelled railing

3.4.37 The second floor contains three large rooms along the centre of the building with eave storages on both north and south sides of the rooms. The staircase providing access to the second floor leads into the central room (2F1). It has chamfered ceilings on north and south sides of the room reflecting the slope of the roof pitches. It has a carpeted softwood timber board floor with the floorboards running north to south. Both the east and west end rooms on the second-floor level are accessed through this room. There are two alcoves to the north and south projecting from room 2F1 with low headroom. The south alcove is located within the projecting main entrance bay and has two small windows to bring natural light in whilst to the north a small window in the north gable provide natural light into this small space. Both alcoves have access doors into the eave storage spaces (Fig 113).

Fig 113 South (left) and northern (right) alcoves in 2F1

3.4.38 Two north-south running timber-stud walls to the east and west of 2F1 formed the two end rooms on the second floor. The interior of these rooms is similar to room 2F1. Both have softwood timber boarded floors covered in carpet, and the floorboards run north to south. However, the west end room, 2F2 has a slightly (80mm) higher floor level.

Fig 114 Common rafter timber boarded roof construction was visible through a hatch in the ceiling of room 2F2

3.4.39 Both rooms have identical dormer windows to the south, with pairs of windows to the sides, providing natural light (Fig 115, Fig 116). They both have access doors into the eaves storage spaces along the north and south sides of the rooms. Room 2F2 also has a hatch to access the roof space. The timber boarded roof construction was visible through it (Fig 114). A number of floorboards were loose in the east end room, 2F3, through which the floor construction was observed. The floorboards are 1-inch thick and 6-inch wide throughout the second-floor rooms. These are nailed onto east-west running floor joists, which had a general scantling of 11-inch thickness and 2-inch width. Floor joists are spaced 10-inch apart on average. The eaves spaces, however, have been observed with similar but separate floor structures. In both end rooms, the dormer window recesses to the south have 6-inch higher floor levels (Fig 116).

Fig 115 Interior of the east end room (2F3) on the second floor of the lodge, looking east

Fig 116 Dormer window recess to the south in room 2F3, looking south-east

3.5 Gates and Railings

3.5.1 For the purposes of this report, the Gates referred to the two main cast and wrought iron gates located on Nestlé's Avenue. The first gate is located toward the southwest end of the site and formerly known as Staff 'A' Gate or the Beverage Division Gate, and the second gate is the former Main Gate entrance toward the centre of the south boundary of the site, leading to the 1960 built Main Factory Building (Fig 117). Railings refer to the cast iron fencing located and running the length of the south side of the site. Neither of the main gates could be accessed directly at the time of the Buildings Archaeologists' visit to the site due to security fencing and other measures in place to protect the site, so it was not possible to get exact measurements of each feature. A closer inspection was carried out by the MOLA Heritage Team at a later date and further details are included in the Protection Method Statement & Schedule of Repairs and Management Plan for the railings.

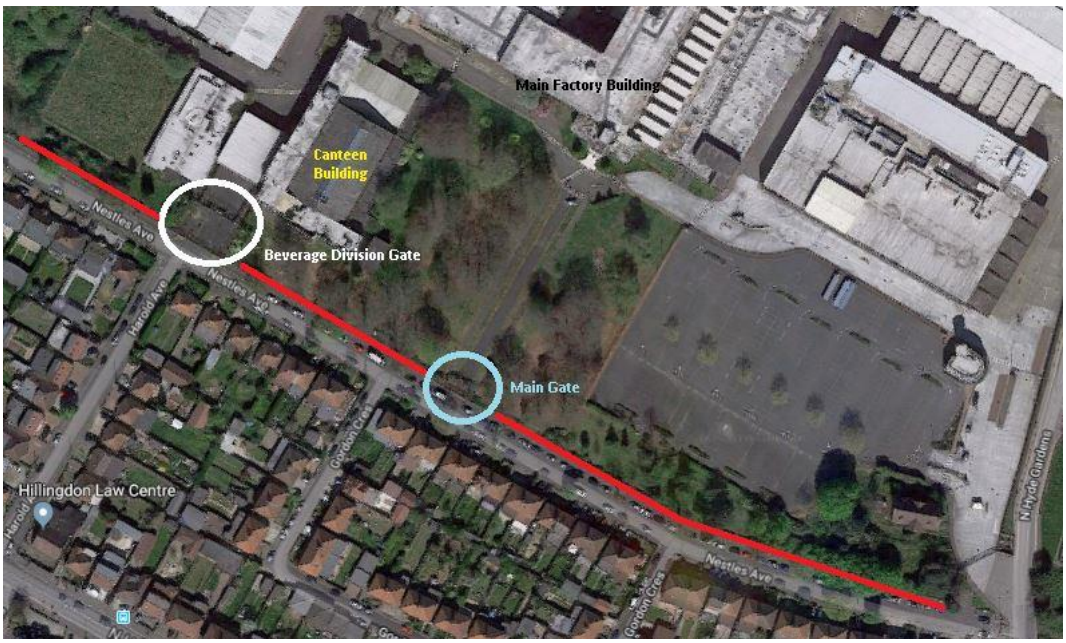

Fig 117 Location of the Gates and Railings along Nestlé's Avenue: the Beverage Division Gate circled in white, the Main Gates circled in blue and the railings indicated in red.

Gates

3.5.2 The Beverage Division gate assemblage (Fig 118) consists of a central vehicle entrance with two pedestrian gates located on either side oriented in a straight east-west line across the entrance. Between the vehicle gate and the pedestrian gates, there are areas measuring approximately 4.125m of fixed type 'A' railings (see railing description below). The pedestrian gates are approximately 1.5m wide not including a 0.75m section of type 'A' railing to the side of each gate, one 0.75m section at the east end and the other at the west end. The gate posts or piers of the pedestrian gates are concrete post type 'A' as described below in the Railings section. The vehicle gate is approximately 5.70m wide, and its characteristics are the same as railing type 'A', with two additional lower rails, between which there is iron lattice-work with straight pickets in the bottom horizontal section (Fig 118).

3.5.3 All of the gate piers at the Beverage gate have lamps extending from the tops. The vehicle gate piers are formed of very ornate hollow ironwork which can be

said to resemble an Ionic style column. The capitals begin with an abacus and volute, below which are both egg and bead motifs, followed by a leaf and rope festoon or garland (Fig 119). The shaft of the piers is decorated hollow flute and fillet style with beading which repeats down to the bottom of the pier. The main piers are supported by concrete plinths and behind the main piers to the vehicle gate are flat support piers or pilasters with iron outriggers, also anchored into a concrete plinth. The support piers retain many of the same ornamental features of the main piers with the addition of some skeuomorphic ribbon ornamentation.

Fig 118 the Beverage Division Gate as seen from the south (Photo Maggie Cox, MOLA)

Fig 119 Beverage Gate pier detail seen from the northwest

3.5.4 The Main Gate assemblage gives a more formal impression and consists of a central section for vehicle entry (Fig 120) measuring approximately 3m east-west which, like the Beverage Gate, is flanked by two pedestrian entrances. There is curved fixed type 'A' fence sections between the vehicle gates and the pedestrian gates (Fig 121). The central section of the gate has type 'A' characteristics apart from the lower sections which have decorative rosettes (Fig 122) and below the rosettes, iron latticework. Starting from the south (street) side there two sets of pilasters on the east and west sides which are less ornate and consist of hipped capitals below which beading and simple scroll detail can be seen followed by hollow flutes and fillets with bead detail at the bottom. Following on, there are two ornate piers before the inward curving plinth leading to the central vehicle gates and then piers on the east and west sides of the central gate. The two ornate piers have the same detail as described in the Beverage Gate piers in Fig 119 (see above) with the addition of hipped capitals and acorn finials in place of lamps (Fig 123). Atop the curved plinths are fixed sections of fence type 'A' as described in the Railings section below (Fig 121). The piers directly flanking the vehicle gate are hollow ironwork comprised of four pilasters (as described above) welded together and topped with hipped capitals (Fig 120Fig 121).

Fig 120 The Main Gate central section from the south (Photo Maggie Cox, MOLA)

Fig 121 Curved section of Main Gate, east side, showing pier types 1 and 2, from the south.

Fig 122 Main Gate rosette detail from the south

Fig 123 Acorn finial detail in Main Gate seen from the north-east.

Railings

Fig 124 A section of the fence/railing, looking east (Photo Maggie Cox, MOLA)

3.5.5 For the purposes of the MOLA Standing Building Survey, the fencing was divided into sections 1 through 8, with section 1 starting from the west. The section number changed as physical elements of the fence changed. Examples of elements which constituted changes were the existence of a base plinth, changes to the type of finial, changes in the rails of the fencing and the height of the fence (Fig 124). There were four types of railings recorded: A, B, C and D.

3.5.6 The elements of **Type A** are, from top to bottom: an unusual variation of triad spear style finials, top and bottom rails which have projecting rounded parts with collars below, where the vertical pickets pass through them. The bottom of the pickets has a rounded, tapered element below which there is a frame rail which is bolted directly to the concrete plinth. These elements stabilise the pickets and fence sections along with iron outriggers which run at approximately every 1.84m on the north side of the railings (Fig 125, Fig 126).

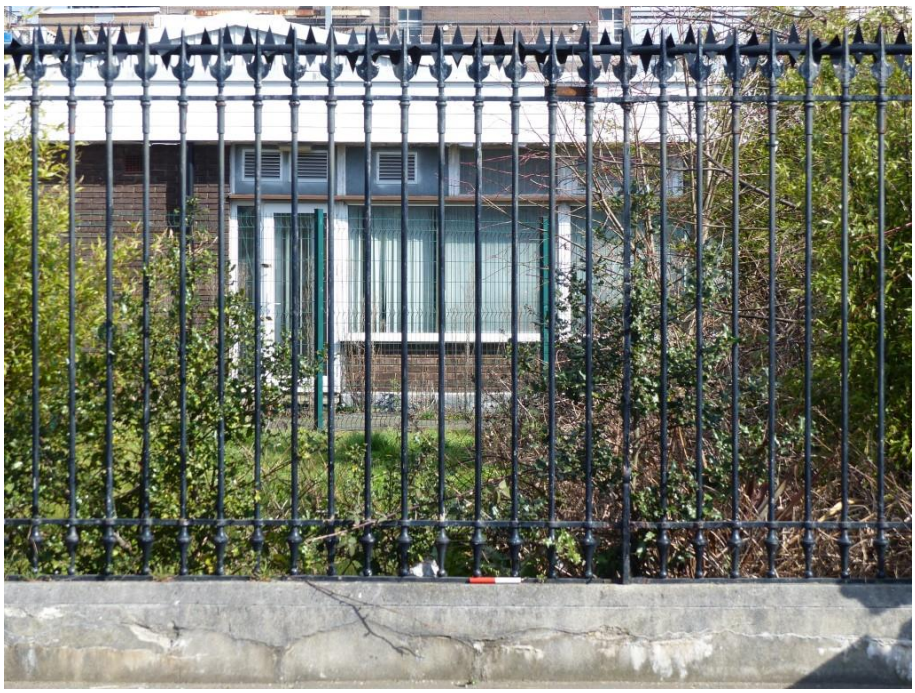

Fig 125 Railing Type A, looking north

Fig 126 Railing Type, A finial detail, looking north

3.5.7 Railing **Type B** also has the same triad style finials, and the top rail has the same projecting rounded detail where the pickets go through the top rail. Type B pickets do not have a collar where they exit the top rail (Fig 129). Type B also does not have the bottom rail segment seen in Type A, but has the frame rail and is secured directly to the concrete plinth (Fig 130).

Fig 127 Scrolled outriggers, looking north

Fig 128 Scrolled outrigger detail, looking south

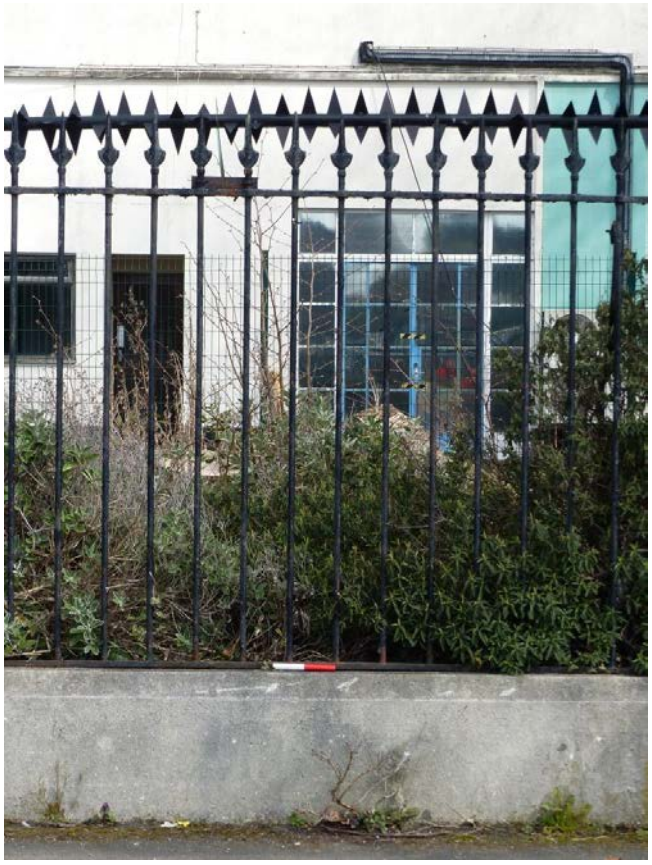

Fig 129 Railing Type B, looking north toward the Canteen

Fig 130 Railing Type B frame rail detail, looking north

3.5.8 Railing **Type C** has the same triad style finials as A and B. However the top rail does not have the rounded projecting detail or the collar under the top rail (Fig 131), which can be seen on Type A. This may be due to it being later repair or replacement or that it is some distance from the main entrance and so not necessarily as decorative.

Fig 131 Railing Type C detail, looking north-east

3.5.9 Railing **Type D** is quite different at the top from railing types A, B and C in that it has two top rails attached at approximately 180mm wide intervals by single short pickets welded onto the rail, and very different finials, commonly seen on later built fences (Fig 132, Fig 133, Fig 134). The finial style is known as a quad flair finial. Where fence Type D occurs, it appears to be a recent repair supported by an image captured from a 2014 Google earth survey for Street View which shows that it was not there at the time the images were recorded (Fig 135). In addition, there is scarring along the original top rail where the original triad style finials were once attached (Fig 134). The lower frame rail sits directly on top of the plinth with no lower rail detail as with Types B and C.

Fig 132 Railing Type D, looking north-west

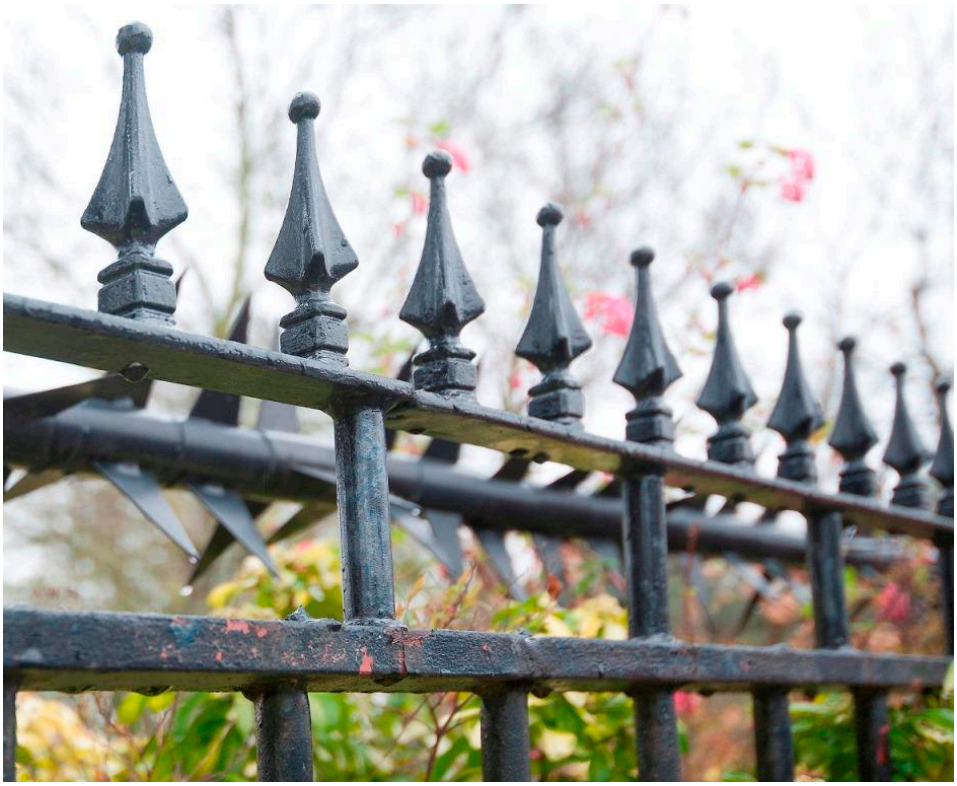

Fig 133 Railing Type D detail, looking north-east

Fig 134 Railing Type D detail, looking north

Fig 135 2014 Google Street View, railing Type D from the south showing absent finials

3.5.10 Post types A, B and C were recorded along with the railings and in addition to the posts recorded at the Gates. Post type A is a large concrete pillar approximately 2.28 meters tall with shallow recessed 'panels' on all sides. It is bevelled or chamfered at the top and above the base which measures 570mm (Fig 136). The post type B pillar is formed of solid cast iron elements which include an acorn finial and a plain post capital with fluting detail on the square vertical shaft (Fig 137). Post type C can be found only on the west end of the railings and the Beverage Gate and in railing type A. It is topped with the triad finial and is a flat baluster (flat with shaped sides). Although difficult to discern an example can be seen in (Fig 138).

Fig 136 Post Type A, looking north

Fig 137 Post Type B, looking north

Fig 138 Post Type C, the central vertical member seen from the south

3.6 Other structures and hard standing features on site

3.6.1 The 12.3ha former site of Nestlé factory contains a number of factories and associated buildings as well as hard-standing features apart from those mentioned previously. The majority of these have been added in the mid-20th century particularly in the 1970s when the site experienced significant change through the ad-hoc extension of the factory building and introduction of large sheds, reducing its visual relationship with the canal.

Fig 139 Factory entrance from North Hyde Gardens.

Fig 140 Entrance gatehouse and security office building. Note weighbridge installed in the road (left), view from the north (right)

Fig 141 Car park in the south-east section of the site, looking north-west separating the lodge from the factory area

Fig 142 Entrance path leading to the factory entrance from Nestlés Avenue

Fig 143 Squash court next to the former canteen building, looking north-west

Fig 144 Later added factory building located on the east side of the site with a cantilevered canopy, looking south

Fig 145 Loading bay with modern steel canopy between the two large factory buildings in the north-east corner of the site.

Fig 146 Industrial ventilation bay at the northern verge of the site along the canal

Fig 147 A large late 20th-century factory building located at the north-west corner of the site, looking west

Fig 148 Large late 20th-century factory building located west of the main factory building, looking south

Fig 149 A modern high-level steel framed walkway connecting the two late 20th-century factory buildings at the north-west corner of the site.

Fig 150 A couple of large tanks along the north-west boundary of the site along the canal, looking north

Fig 151 Large concrete surfaced car park at the west end of the site, looking north-east

Fig 152 The factory buildings as seen from the canal path

4 Conclusion

4.1 Historic Building Recording

4.1.1 The historic building survey of the buildings at the site of former Nestlé Factory conformed to the standards specified by Historic England. Both exterior and interior of the buildings except the inaccessible areas were surveyed, photographed to enable the documentation of various construction and architectural details. Historic background of the development of the site was portrayed through readily available information and limited documentary archive research.

4.1.2 Note: within the limitations imposed by dealing with historical material and maps, the information in this document is, to the best knowledge of the author and MOLA, correct at the time of writing. Further archaeological investigation or more information about the standing structures may require changes to all or parts of the document.

4.2 Publication

4.2.1 Given the potential of the material, it is suggested that a summary of results of the Standing Building Recording project, possibly including figures or photographs, should appear in relevant academic journals.

4.3 Archive schedule

4.3.1 The site archive of original records will be deposited in accordance with the site-specific WSI (MOLA, 2018) the LAARC (London Archaeological Archive and Research Centre) of Museum of London within 12 months of the end of the survey. These will be stored under the site code NHY18.

5 Acknowledgements

5.1.1 Museum of London Archaeology (MOLA) wishes to thank BDW Trading Limited for commissioning this report. In addition, MOLA wishes to thank Tetra Consulting for arranging the site access. The authors are grateful to the Client for providing the plans of the buildings.

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7 OASIS archaeological report form

7.1 OASIS ID: molas1-317671

Project details	
Project name	Former Nestlé Factory, Hayes
Short description of the project	Standing building recording was carried out at the former Nestlé Factory, Hayes UB3 4RF prior to development by SEGRO PLC and BDW Trading, Ltd. during March and April 2018. The site is comprised of approximately eight buildings and the Gates and Railings which run along the south border of the site, the Main Factory and original Sandow Building, and the Canteen, which were recorded to Historic England (HE) Level 4. In addition, the Caretakers Lodge was recorded at an HE Level 3. The remaining buildings are standard modern industrial style buildings and were recorded at an HE Level 1. The earliest building on the site is the former Sandow Cocoa factory building, completed in 1914 which was incorporated into the Main Factory building beginning in the 1920s and continued after Nestlé took over the site in 1929.
Project dates	Start: 05-03-2018
Previous/future work	No / Not known
Any associated project reference codes	NHY18 - Site code
Type of project	Building Recording
Site status	Conservation Area
Current Land use	Industry and Commerce 1 - Industrial
Monument type	BUILDINGS Modern
Project location	
Country	England
Site location	GREATER LONDON HILLINGDON HAYES Former Nestlé Factory Hayes
Postcode	UB3 4RF
Study area	12.3 Hectares
Site coordinates	TQ 10094 79227 51.500753321515 -0.413697883444 51 30 02 N 000 24 49 W Point
Project creators	
Name of Organisation	Standing Building Recording
Project brief originator	MOLA
Project design originator	MOLA
Project director/manager	S. Hoad

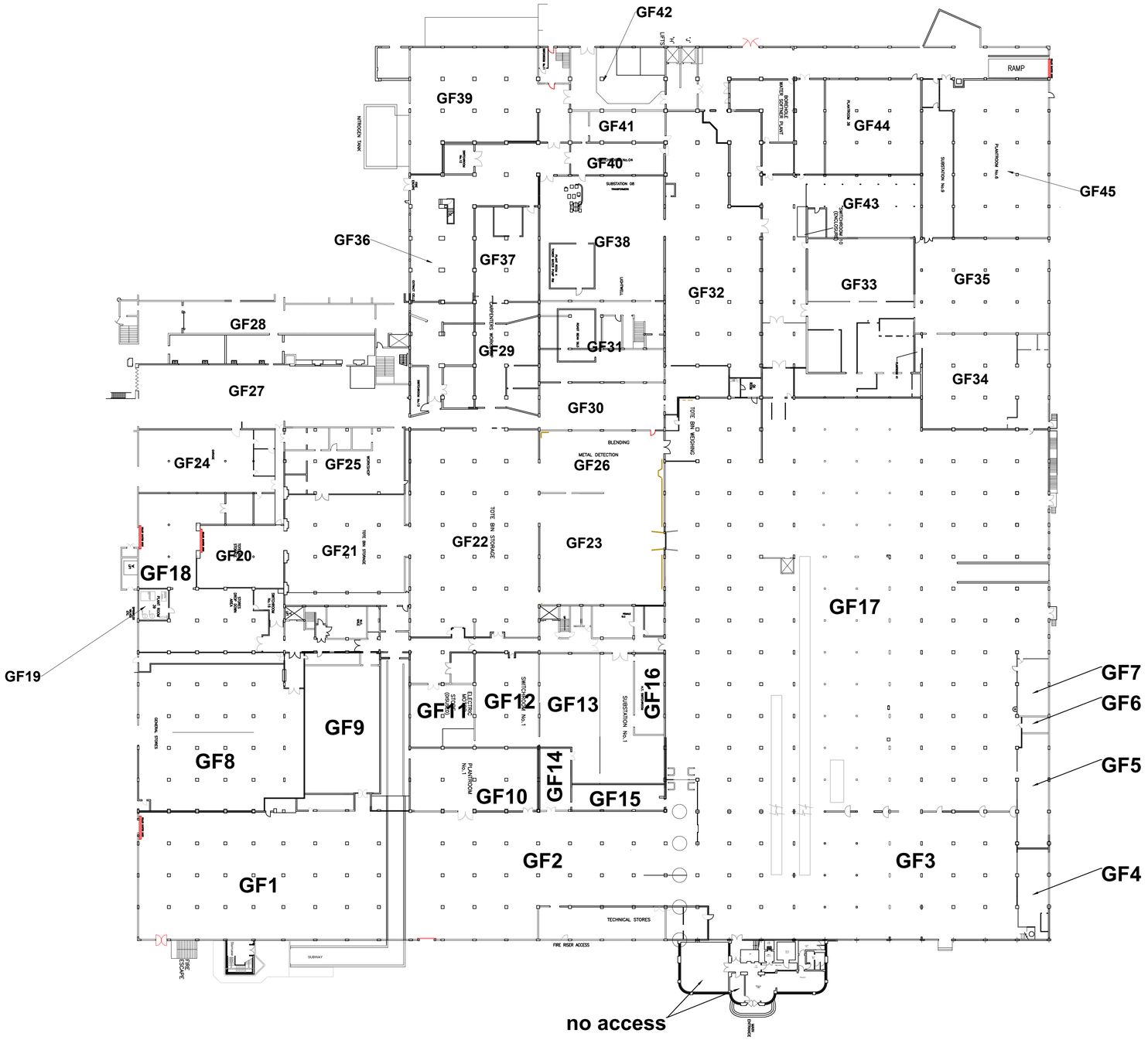
Project supervisor	Azizul Karim
Type of sponsor/funding body	Commercial developer
Name of sponsor/funding body	SEGRO PLC and BDW Trading, Limited (Barratt London)

Project archives

Digital Media available	''Images raster / digital photography''
Paper Archive recipient	LAARC
Paper Media available	''Drawing'',''Notebook - Excavation',' Research',' General Notes'',''Plan'',''Report'',''Section'',''Survey ''

Entered by	Brigid Geist (bgeist@mola.org.uk)
Entered on	21 May 2018

Appendix 1: Plans and Elevations



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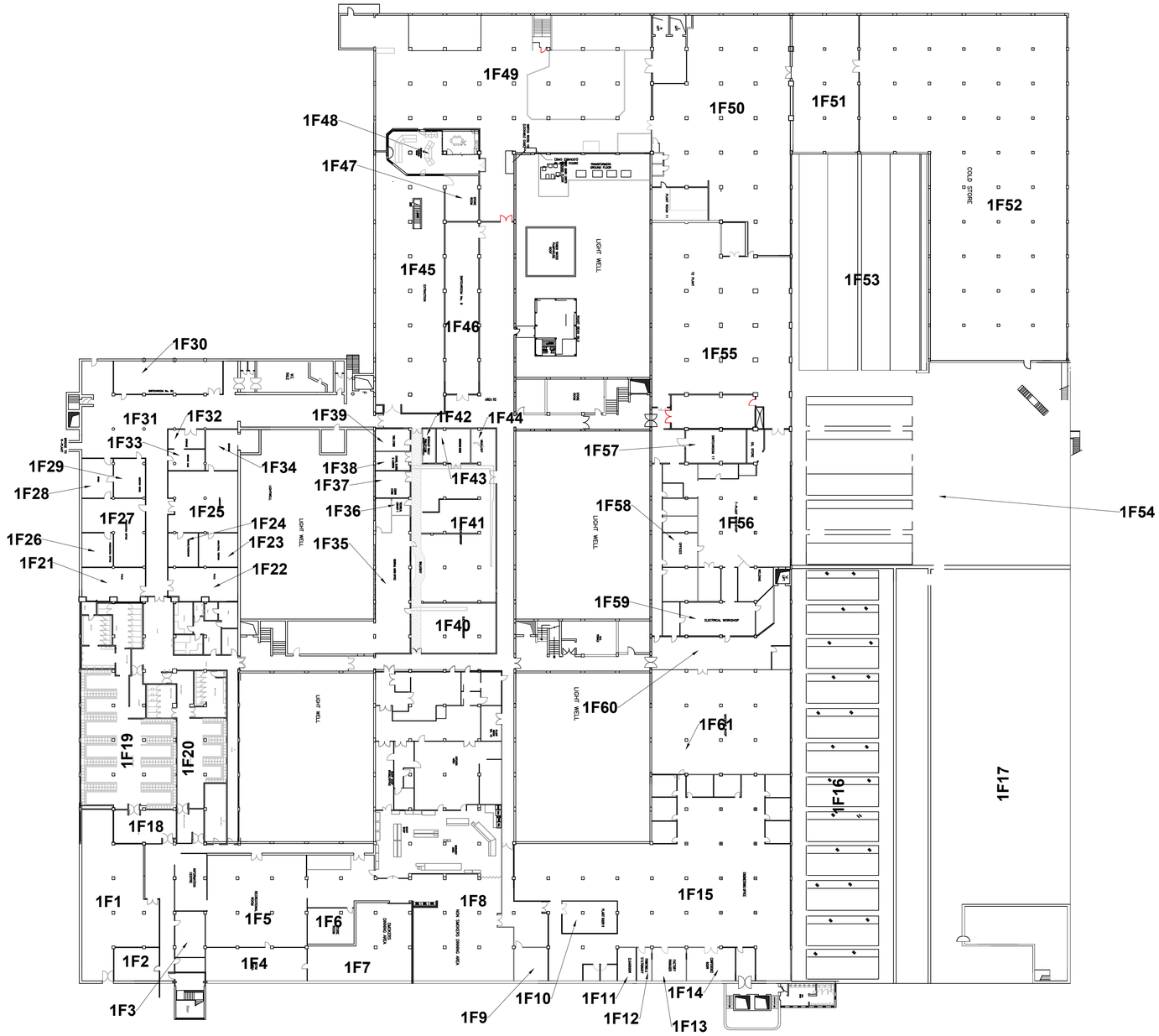

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First Floor Plan of Main Factory Building

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CLIENT:
SEGRO

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March 2005

SURVEY BY:
NESTLE

DRAWING STATUS:
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DRAWING SCALE: **1:500 on A1**

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PROJECT DIRECTORY:
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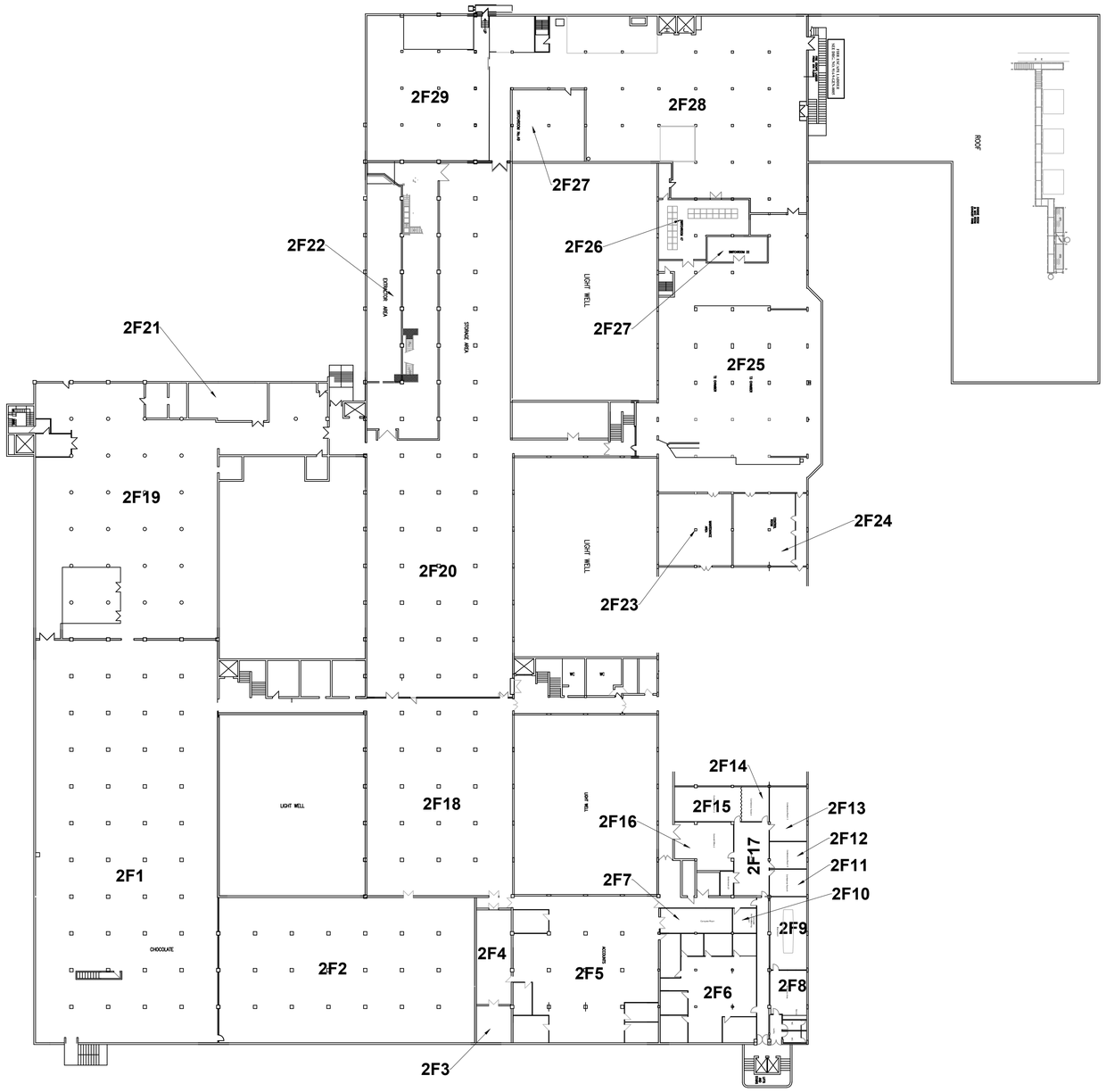

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Second Floor Plan of Main Factory Building

PROJECT NAME:
Former Nestle Factory

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CLIENT:
SEGRO

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SURVEY BY:
NESTLE

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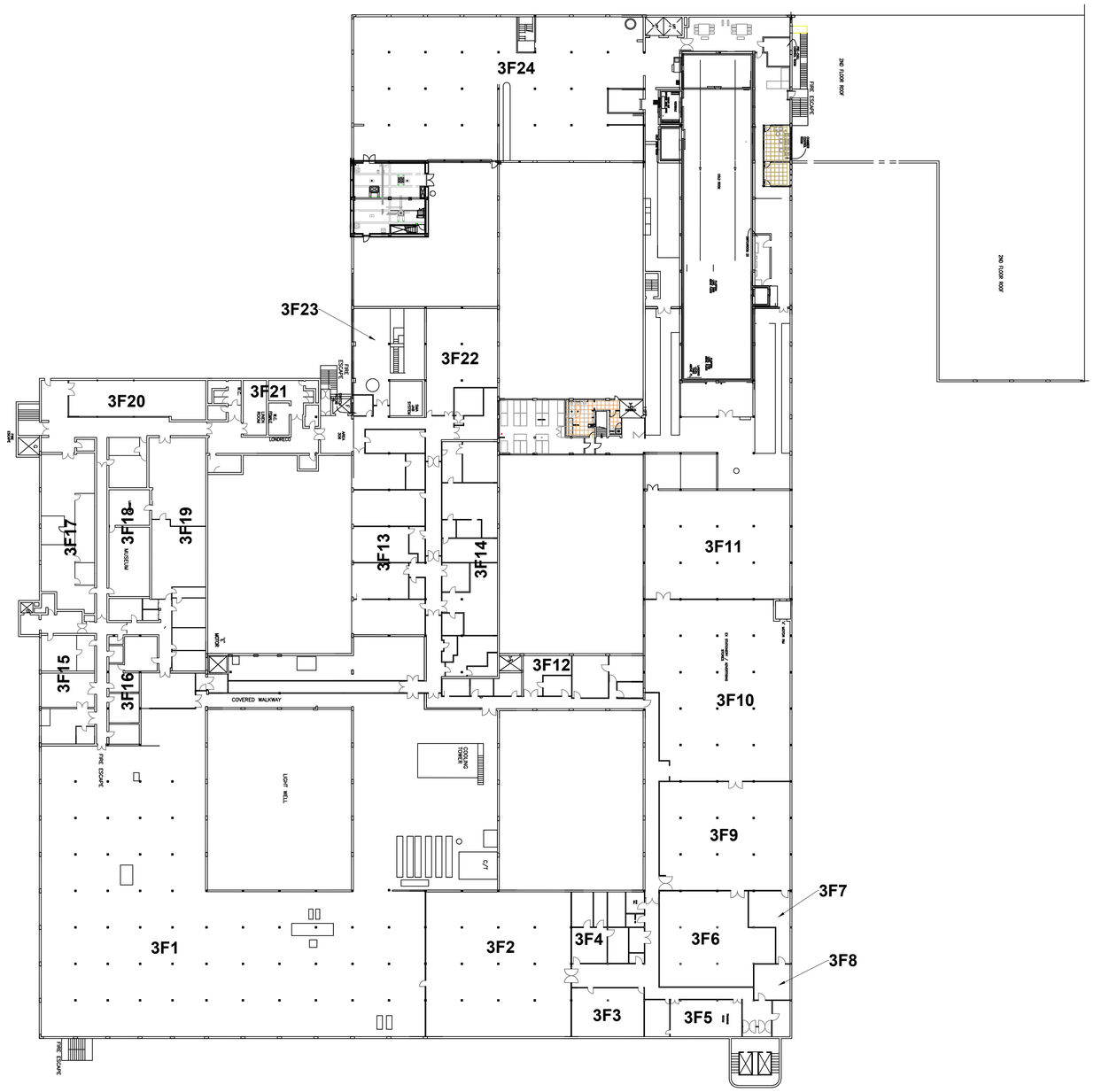

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Former Nestle Factory

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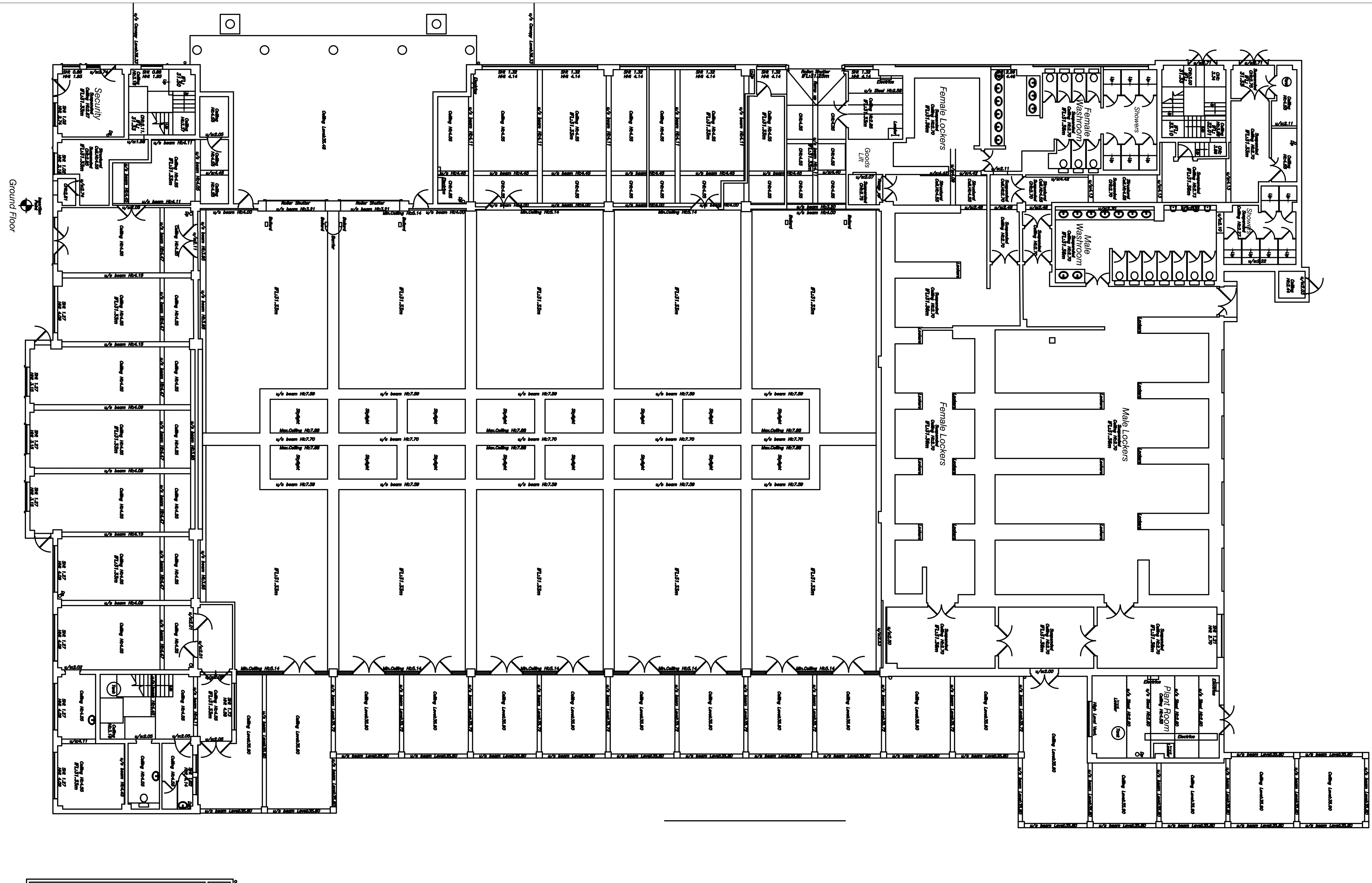

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Former Nestle Factory

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CLIENT:
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SURVEY DATE:
APRIL 2015

SURVEY BY:
GREENHATCH GROUP

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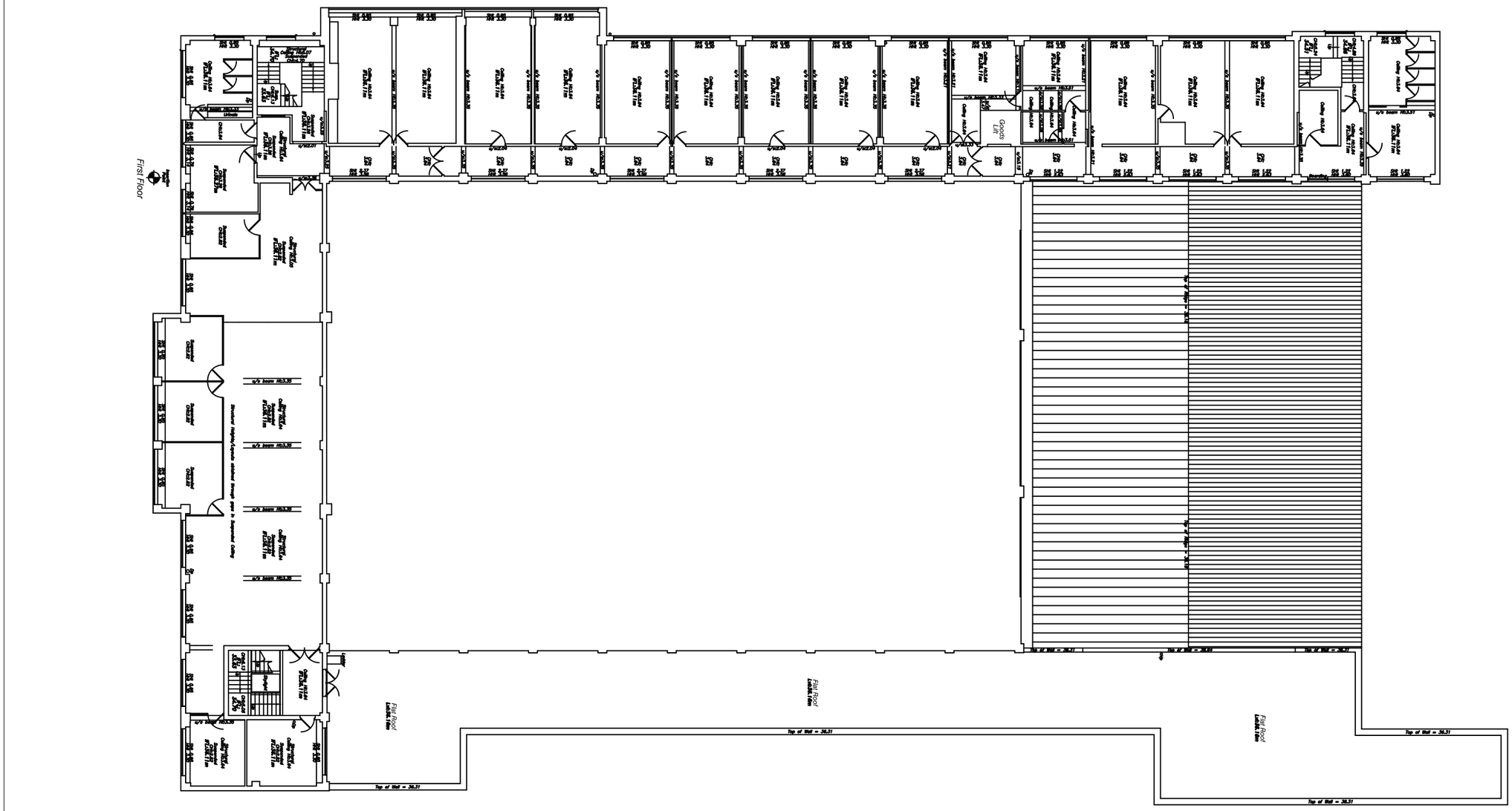

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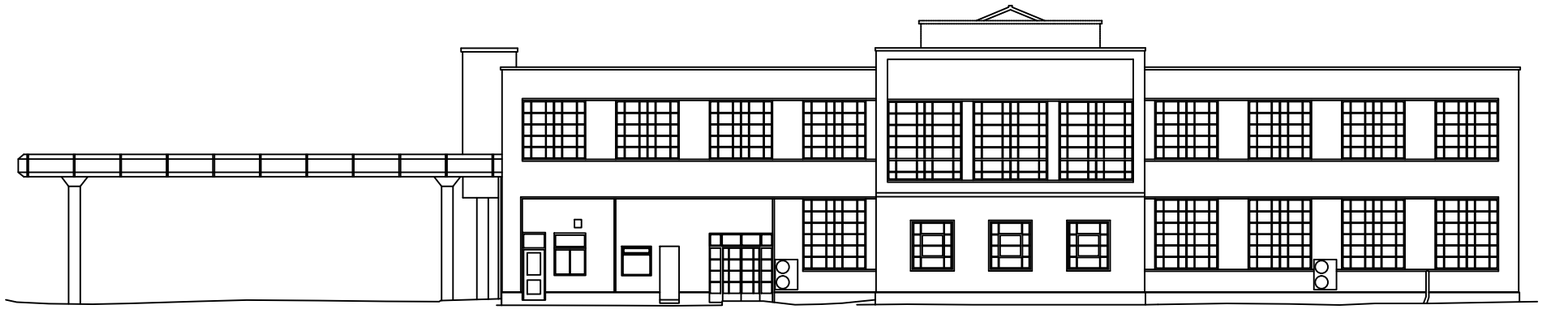

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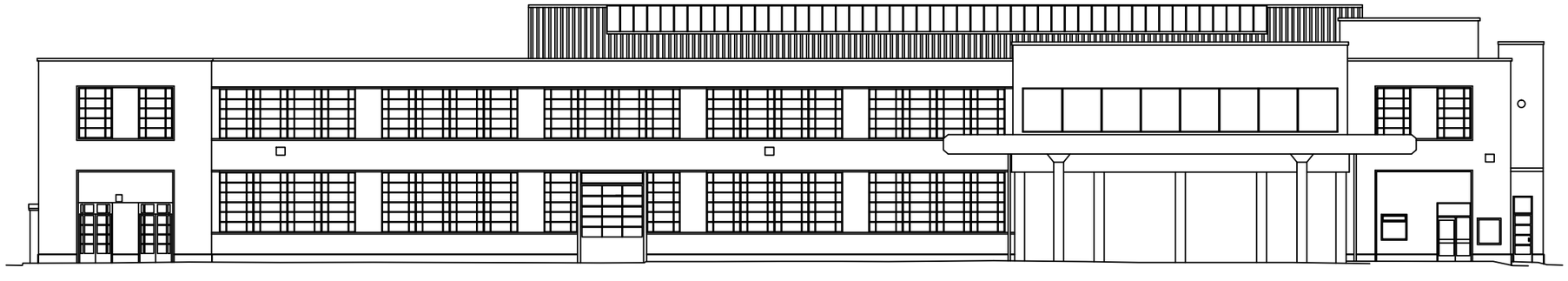

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APRIL 2015

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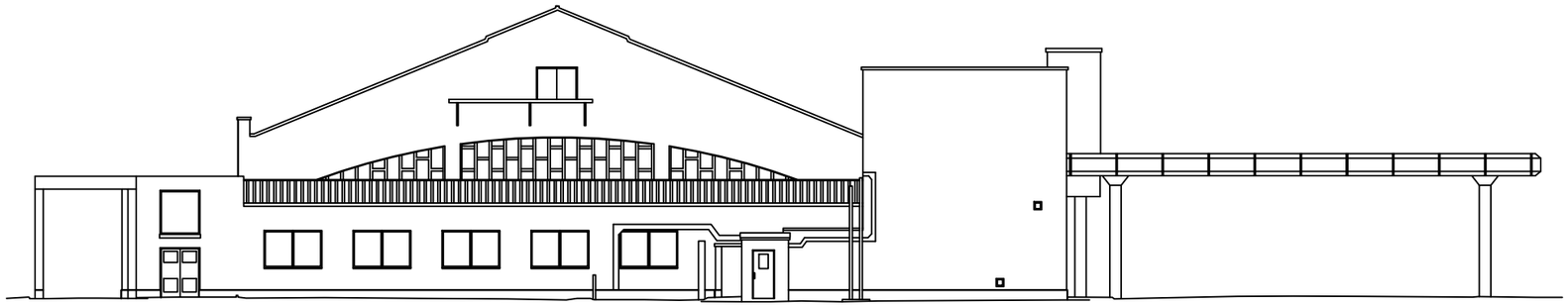

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Former Nestle Factory

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Nestle Avenue, Hayes, Hillingdon

CLIENT:
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SURVEY DATE:
APRIL 2015

SURVEY BY:
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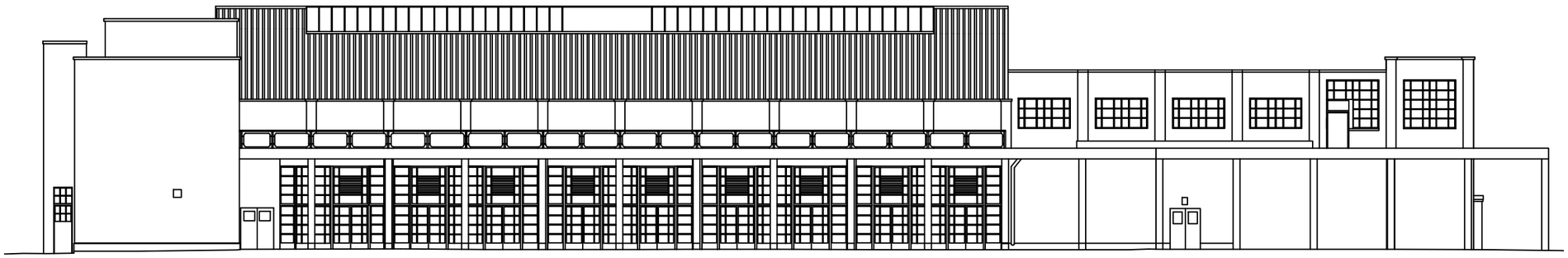

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Former Nestle Factory

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CLIENT:
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SURVEY DATE:
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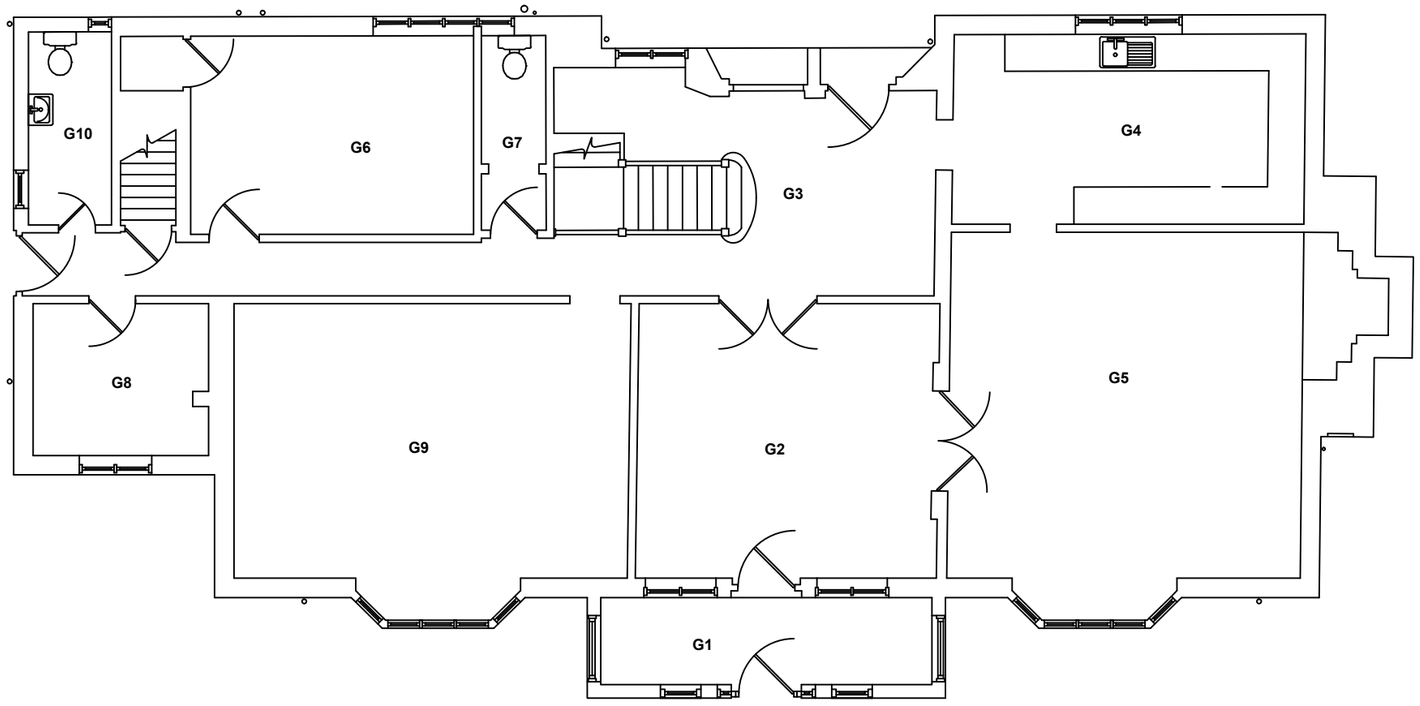

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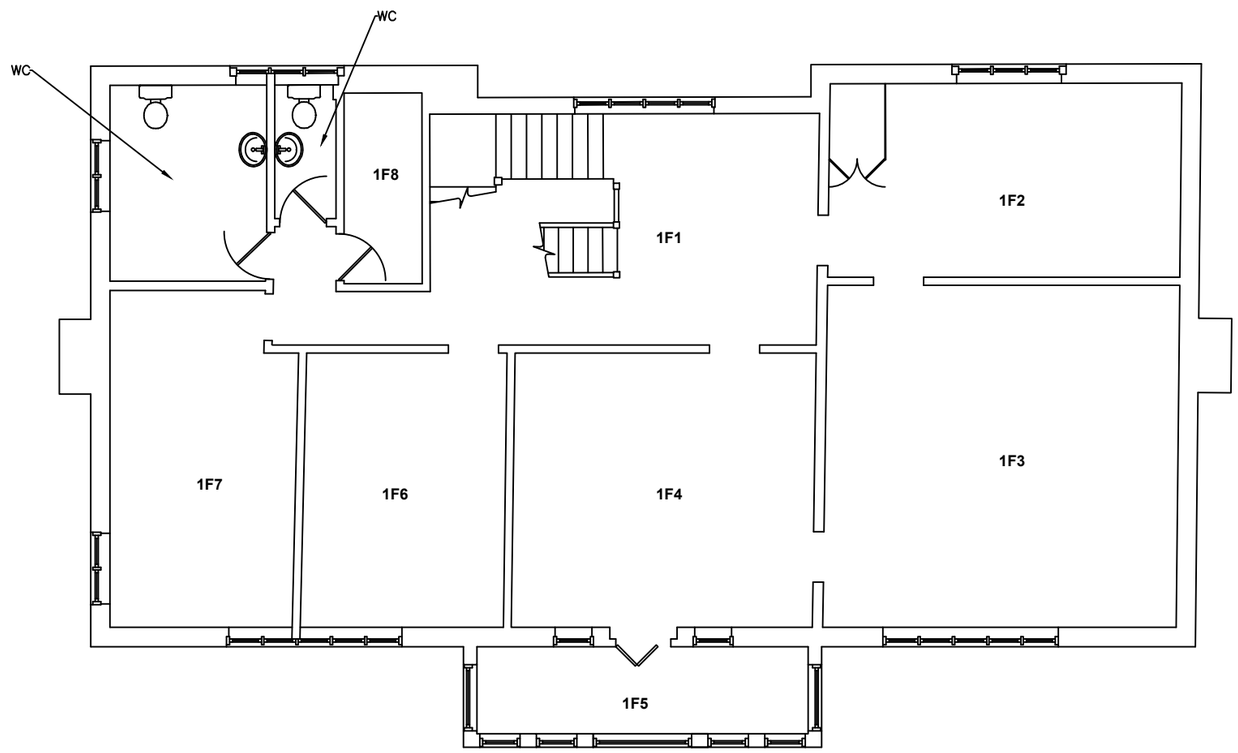

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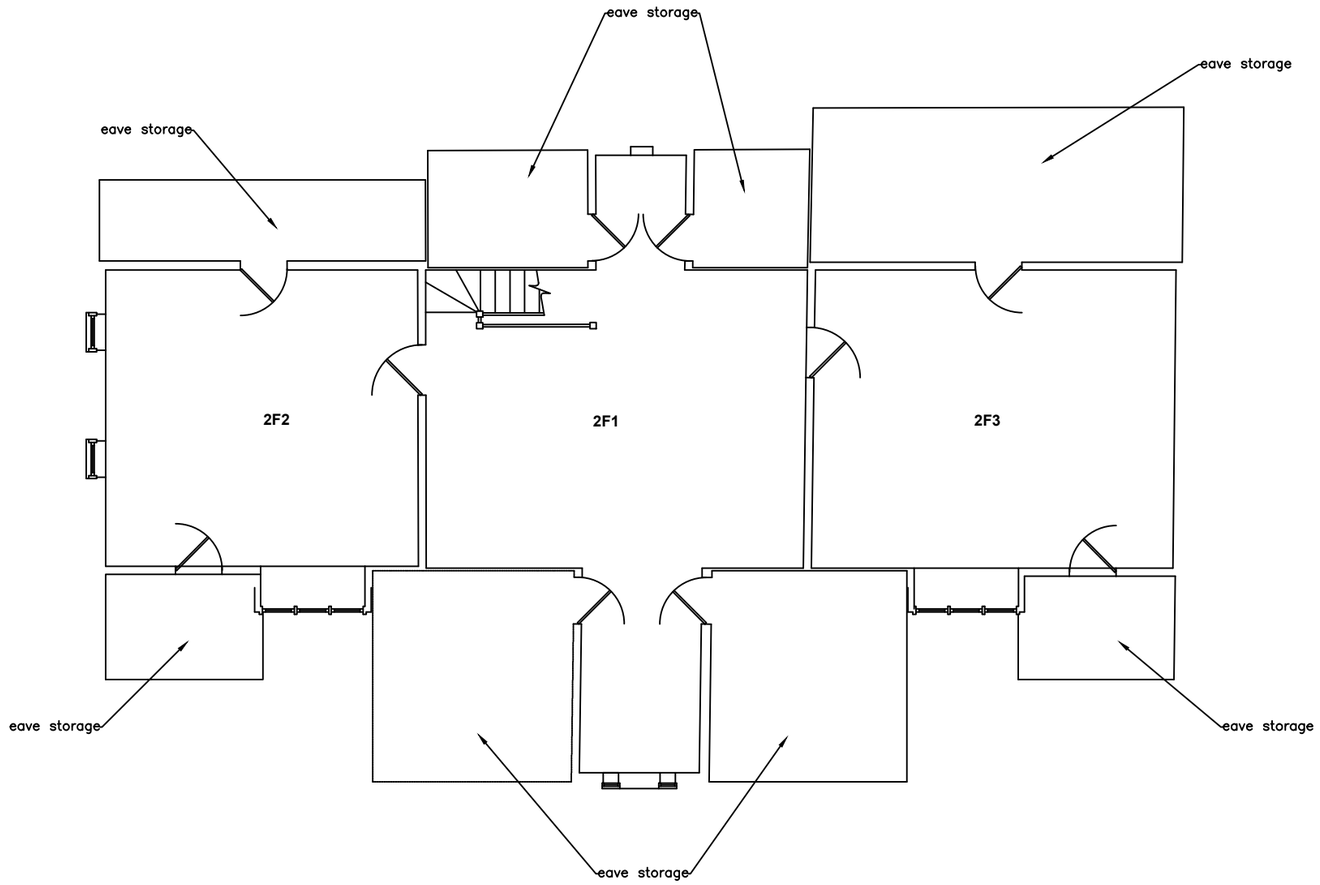

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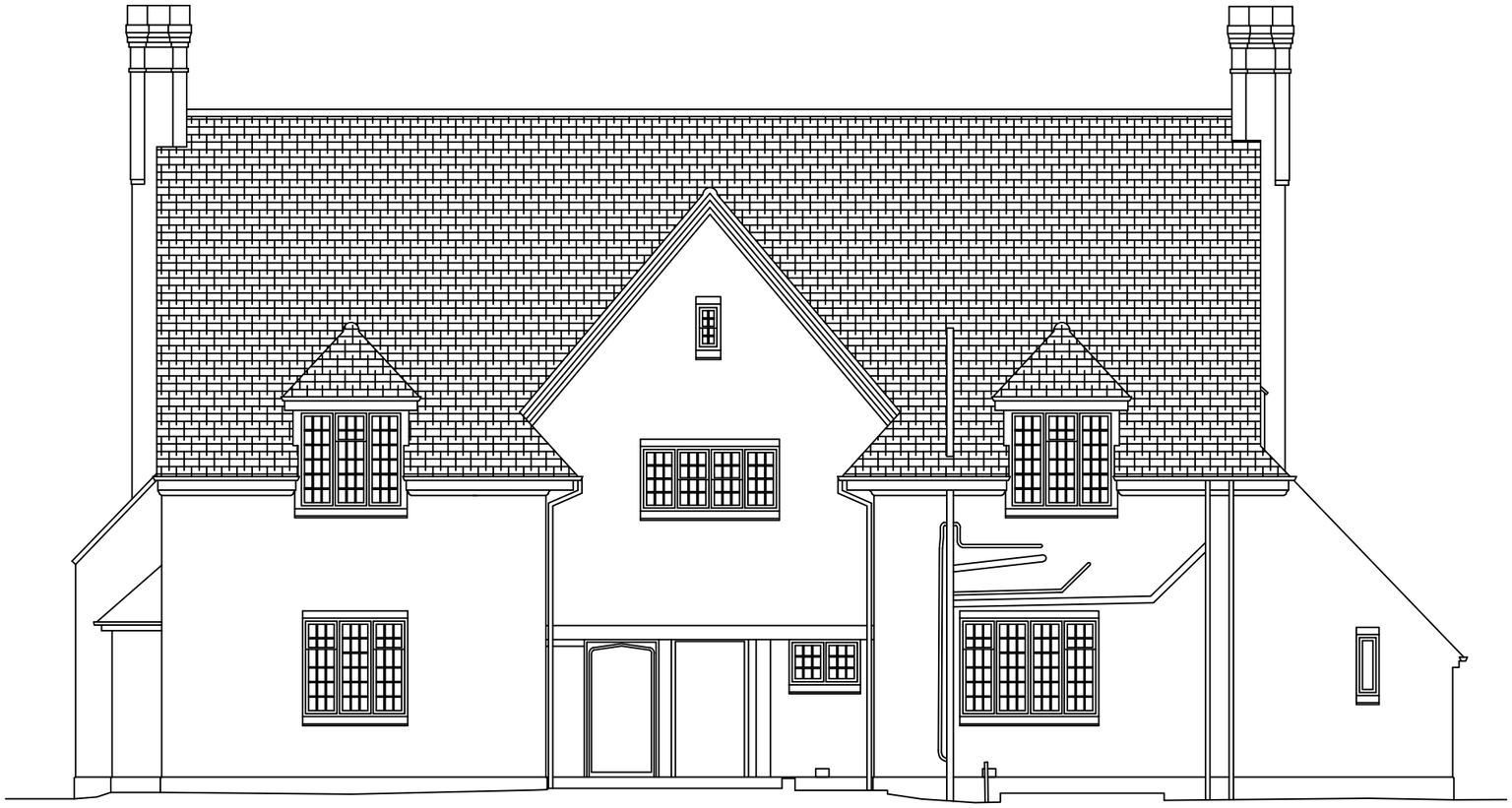

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North elevation of the Lodge

PROJECT NAME:
Former Nestle Factory

ADDRESS:
Nestle Avenue, Hayes, Hillingdon

CLIENT:
SEGRO

SURVEY DATE:
APRIL 2015

SURVEY BY:
GREENHATCH GROUP

DRAWING STATUS:
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METRE

FILENAME:
MainFactory_Plans.DWG

PROJECT DIRECTORY:
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AUTOCAD VERSION:
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DRAWING SCALE: : 1:100 on A3

0 5 m

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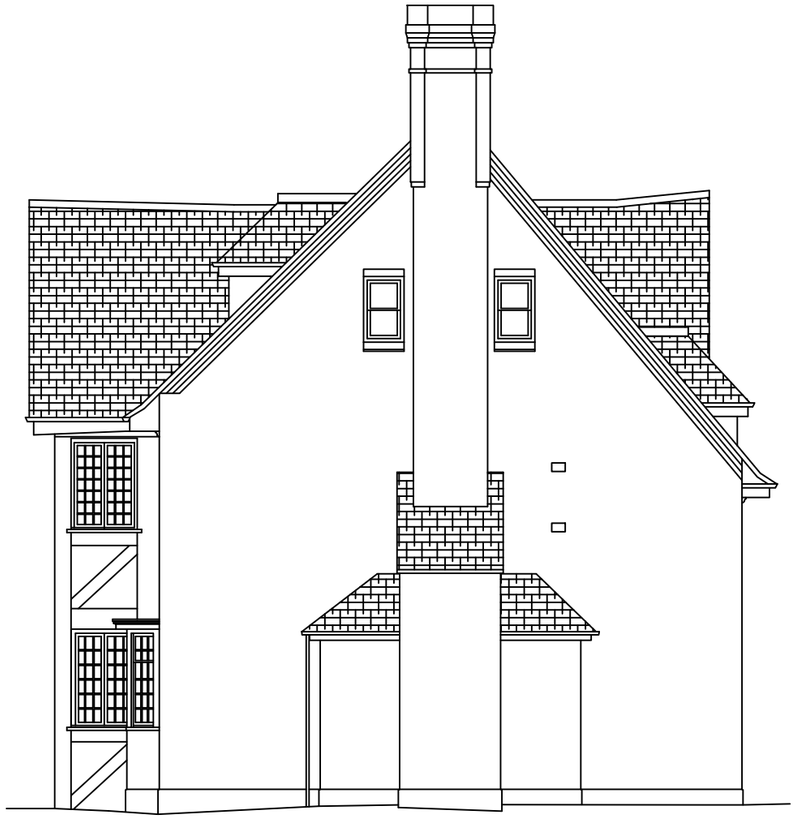
Telephone: 0207 410 2200
Email: business@mola.org.uk
Web: www.mola.org.uk

Datum: 25.00m.

DRAWING TITLE: North elevation of the Lodge **PROJECT NAME:** Former Nestle Factory **ADDRESS:** Nestle Avenue, Hayes, Hillingdon **CLIENT:** SEGRO	**SURVEY DATE:** APRIL 2015 **SURVEY BY:** GREENHATCH GROUP **DRAWING STATUS:** Reproduced **© MOLA 2018**	**MEASUREMENT UNITS** METRE **FILENAME:** MainFactory_Plans.DWG **PROJECT DIRECTORY:** P:\HILL\1220\ **AUTOCAD VERSION:** CREATED IN 2013, SAVED in 2013	**DRAWING SCALE: : 1:100 on A3** 0 5 m N	**MOLA** Mortimer Wheeler House 46 Eagle Wharf Road LONDON N1 7ED Telephone: 0207 410 2200 Email: business@mola.org.uk Web: www.mola.org.uk



East Elevation

Datum: 25.00m.

West Elevation

Datum: 25.00m.

DRAWING TITLE:
North elevation of the Lodge

PROJECT NAME:
Former Nestle Factory

ADDRESS:
Nestle Avenue, Hayes, Hillingdon

CLIENT:
SEGRO

SURVEY DATE:
APRIL 2015

SURVEY BY:
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PROJECT DIRECTORY:
P:\HILL\1220\

AUTOCAD VERSION:
CREATED IN 2013, SAVED in 2013

DRAWING SCALE: : 1:100 on A3

0 5 m

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Appendix 2: Ortho-rectified elevation views

0 10 m

1:100 on A3

South Elevation (central section) of the Main Factory Building

0 10 m

1:100 on A3

South elevation (east end section) of the Main Factory Building

0 10 m

1:250 on A3

South elevation (west end section) of the Main Factory Building

0 10 m

1:200 on A3

West elevation of the Main Factory Building (Southern section 1920s Truscon construction)

0 10 m

1:250 on A3

East elevation of the Main Factory Building (Southern section)

0 10 m

1:200 on A3

South elevation of the Former Canteen Building

0 10 m

1:200 on A3

West elevation (north of canopy) of the Former Canteen Building