



# MAPLE SYRUP

# DIGEST

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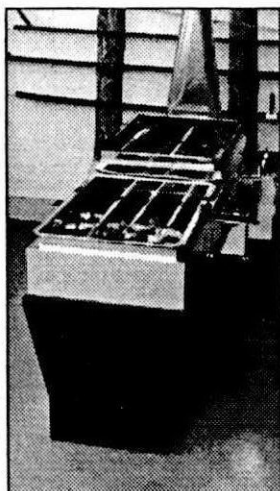
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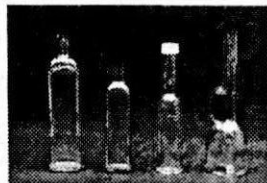
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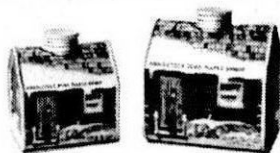
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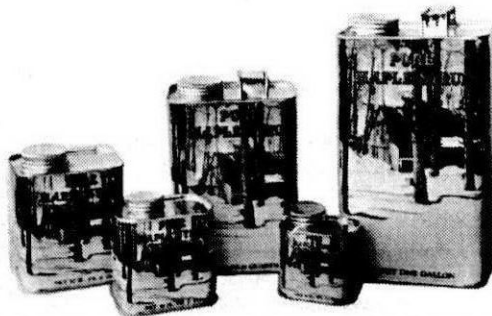
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# MAPLE SYRUP DIGEST

Official publication of the  
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MAPLE SYRUP COUNCIL

## DIRECTORY

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COVER: Lynn Reynolds



## GREETINGS FROM YOUR PRESIDENT



As I began to write this letter, I noticed that the leaves have started to change their colour — a clear indicator that fall is on our doorstep. It's time, once again, to get those last minute odd jobs done around the sugar camp and bush in preparation for the next season.

The annual meeting of the NAMSC and IMSI, being held in Titusville, Pennsylvania on October 21-24, is also fast approaching. The overview of the meeting indicates that it is going to be very good and informative. Bring any problems or questions you might have to the meeting so that experts from all over North America can help you come up with solutions.

I have just learned of the passing of Lynn Reynolds, a fixture within the North American Maple Syrup Council and IMSI for many years. His contribution of time and effort will be irreplaceable. It is with heavy heart that we proceed with the business of the upcoming convention.

Come and take part in the meeting. We need your involvement!

See you in Titusville in October.

Sincerely,

Avard Bentley  
President, NAMSC

## FROM THE EDITOR

This indeed is a sad time for the Maple industry. We have lost one of the giants in the Maple business. Lynn was a tireless worker for Maple. He was an advocate of research, having been one of the driving forces to get the research fund started. He spent many hours reading proposals and helping to decide which ones were worthy of funds. He also felt strongly about promotion, maintaining that we had a unique product and we should promote and price it accordingly.

Another one of his passions was the cooperation between NAMSC and the IMSI.

I would like to think that Lynn was my friend, although I only saw him once a year at the convention of NAMSC. He was one of the first people to greet you with a smile and a firm handshake.

I talked to him during the year on several occasions. Anytime anyone wanted information that I could not supply I had them call Lynn. He will be missed by many.

On the day I learned of Lynn's death I also received his report on IMSI Business, which is in this issue, Lynn more than anyone knew how important it was to "Smell the Roses."

Contributions in his memory can be made to Research Fund c/o Chris Hauge, 5551 South Lowes Creek Road, Eau Claire, WI 54701.

Roy

## IN MEMORY

Lynn H. Reynolds passed away on August 30, 1998, at Ripon Medical Center, Ripon.

He was born March 6, 1936 in Aniwa, a son of the late Adin and Geraldine (Wheeler) Reynolds.

He is survived by his wife Anne Reynolds; two sons, Andrew and Jon Reynolds, and five grandchildren, a brother, Juan Reynolds, a sister, Kathleen Sipes, and a step-brother Don Kiltzka.

He was a 1954 graduate of Antigo High School. He received an undergraduate degree from the University of Wisconsin-Stevens Point, majoring in chemistry and biology, with emphasis in mathematics, conservation, and forestry. He received a fellowship and scholarship for graduate studies at the Institute of Paper Chemistry (IPC) in 1970. Lynn received his masters degree in tree (plant) physiology (and paper technology) from the IPC. He had completed his academis (but not his research) towards his Ph.D., in tree (plant) physiology.

Lynn served in the U.S. Marine Corps during the Korean Conflict.

Lynn's life was Maple, but he cherished old iron, owning a large collection of old machinery, especially old tractors. He also enjoyed poetry, the woods, deer and bird hunting and collecting antiques.

Lynn was C.E.O. and chairman of the board of Reynolds Sugar Bush, Inc., president of Reynolds Enterprises, president of Reynolds Real Estate, Inc. and the trustee, along

with Anne, for Reynolds Family Trust, and president of Reynolds Holding Corporation. Lynn was a certified mediator in the Wisconsin Department of Agriculture Farmer Assistance Program. Lynn was the Executive Director of the International Maple Syrup Institute and serves on the Board of Directors. He was a past member of the Board of Directors of the North American Maple Syrup Council, and Director of the Research Program for the NAMSC. He served on the Board of Directors of the Wisconsin Maple Syrup Producers Council and is the Delegate for the WMSPC on the IMSI Board. He had been past President and Vice President of the IMSI, past President and Vice President of the NAMSC.

Lynn was named the Wisconsin Maple Producer of the year in 1994 and was inducted into the American Maple Hall of Fame in 1995.

Lynn had just finished writing a book titled *Reynolds, Maple and History, Fit for Kings*.

## MAPLE IS US

By Lynn Reynolds  
for  
*Maple Syrup Digest*  
December, 1986

**Maple** is a Delicacy,  
**Maple** is Versatile,  
**Maple** is Necessary,  
**Maple** is Wonderful.

**Maple** is an Art,  
**Maple** is a Craft,  
**Maple** is an Industry,  
**Maple** is about Trees,  
**MAPLE IS US!**

# AN ODE TO MY DAD

This past Sunday we lost a legend,  
Whose life was cut too short.  
This man was a builder of character,  
When asked to build a crate, instead  
he built a fort.

This man was a businessman,  
A Farmer and Marketer by trade,  
A Maple producer, promoter, and packager,  
He will be remembered, for all the  
friends he made.

A life of pain and suffering,  
Complaints we never heard,  
He went about his work,  
And was always good for his word.

He was a people person,  
Who shared a joke every minute,  
He brought smiles to the crowd,  
But you had to be careful, or you may  
be in it!

He rooted for the Packers,  
And always for the small guy,  
He went to rummage sales and auctions,  
To seek out the "best buys!"

A poet and a writer,  
His pen was never empty,  
He consummated his life's work,  
**Reynolds, Maple and History.**

He was the foundation for continued  
optimism,  
He didn't believe in failure,  
He called them "successes that didn't  
materialize,"  
His direction clear, without waver.

An International Executive,  
A diplomat by name,

Titles weren't important,  
His picture sits in the Maple Hall of Fame.

Steam Engine shows,  
Were the places he wanted to be,  
Sharing memories and telling stories,  
Around the campfire, motor homes & RVs.

His family was important,  
His children and spouses were his life,  
Judy & Andy, and Jack & Sandy,  
He dearly loved his grandchildren and most  
importantly, his wife.

He went to all the kids events,  
The baseball tournaments were his fav,  
He was the coach, the mentor, and teacher,  
Free lessons are what he gave,

He believed in doing things right,  
Or not doing them at all,  
He symbolized courage and achievement,  
Among all the opposition, he always  
stood tall.

His passion was research,  
Genealogy and Maple Decline,  
His knowledge of our ancestry and  
acid rain,  
Would really blow your mind.

He was a loving father,  
Who will be missed by many,  
He was the kind of man,  
Who would give you his last penny.

Not only is he a beloved family member,  
But a friend which I spend unforgettable  
time with as a lad,  
He goes by the name of Lynn Reynolds,  
But I will always remember him as Dad.

Written By:  
Jon (Jack) Reynolds  
September 1, 1998

## IMSI BUSINESS

The IMSI is sponsoring the first international maple syrup contest at the convention in Titusville, Pennsylvania, in October 1998. I realize that by the time this article is printed, it will be too late to enter for this year. However, the contest is expected to be ongoing and therefore, look forward to next year. Winners of this contest, which is primarily for packers, will establish a brand as "the maple syrup of excellence." The use of this title on labels, letterheads, or other promotional materials will be allowed for the year.

Certification of maple equipment for food production is progressing in committee. Discussions are moving forward toward establishing guidelines which are developed in the industry, rather than by those which could force us to comply with imposed rules, if we did not take the lead.

Random testing of maple syrup samples for adulteration is being planned. The IMSI logo represents 'pure maple syrup'. Spot checking for any adulteration will be a method in which the IMSI can perform their function towards guaranteeing purity to the consumers. This can only aid the pure maple syrup industry in providing a positive image and to fulfill the 'guarantee of integrity' for a pure maple product. The rules, sampling methods, and how to enforce the results, are currently being developed for an effective program.

Maple producers, maple packers, and maple equipment related persons are welcome to attend the annual convention of the NAMSC and the

IMSI. This year, the convention is in Titusville, Pennsylvania, October 21 through October 24, 1998. The benefits from what you can learn are tremendous. Please try to attend. You will meet friends in the same business. Our problems are mutual. Solutions to our mutual problems are often easier to come by when we discuss them in open forum. Social gatherings provide time to share ideas. The conventions give you these opportunities.

Well, we do not have any surpluses. But we do have the finest product in the world to sell. Sell your syrup at a profit. Do not give it away. This is a year when you can make some money. So, have happy selling. Smell the roses. Enjoy the fall season. Try to help someone who needs you. And, our maple lives more forward.

Lynn Reynolds  
Executive Director

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# A TRIBUTE TO LYNN REYNOLDS

By Bill Clark, Vermont

It suddenly grew dark Monday morning when a phone call informed us of Lynn's passing. Suddenly the Maple world had stopped. It took a moment to grasp the reality of it — A great Maple leader was gone.

Lynn was many things, not only a Maple man but also a business man, scientist, researcher, family man, poet, author and perhaps most of all **A Dreamer**.

It has been said that if it wasn't for dreamers, little if anything would have ever been accomplished in this world. Lynn was that. To accomplish dreams, you also must have **Great Faith**. Lynn had that also.

Thirty-nine years ago the Maple industry was on the skids. Some predicted its doom by 2000. Prices were too low. Canadian competition was a growing problem. Maple producers were quitting, etc. Some farsighted Maple producers had the vision of forming a National Maple Council—they made it happen. It went a long way in dealing with many producer problems of the day. However, it did not solve marketing problems. One member of this group was Adin Reynolds of Wisconsin. Adin's vision was that all maple marketing entities in the world should be working together, all sitting around one table discussing their common problems.

Thru his efforts and others the International Maple Syrup Institute was formed. For the first time, U.S. and Canadian Maple marketers were working together. IMSI had its "Ups and Downs" over the next 15 years. There was still distrust by some as to the abil-

ity of a common resolve to benefit all. Until his death, Adin believed in this cause. Lynn picked up his father's vision—his dream. Lynn said **"Someday I want to see every maple state and province sitting around one table, all representative members of one maple group."**

There still remained many doubts and conflicts. The era of the 90s dawned. Maple was now looking at world markets. The "WEB" became a marketing reality. New concepts of purity and health issues arose., other sweeteners competed for consumer dollars, growing problems of adulteration loomed worldwide. Lynn was right. All Maple people were in this together. All Maple people needed to create solutions together. With Lynn's efforts and others, IMSI has at last become the common ground for the entire Maple industry. Just about every Maple entity in the world including NAMSC, is a working partner with IMSI. The 1997 NAMSC-IMSI annual meeting in Connecticut saw the greatest total accord ever achieved in the history of the Maple industry for the common good of all.

At last Lynn's dream—Adin's dream was a reality. The world Maple industry thanks you, Lynn for your vision, your dream and your faith. We're glad you passed our way. The Reynolds family can be very proud of their place in the world of Maple and well deserved to have **two stars** in the *International World Maple Hall of Fame!*

I do not see anyone yet who can fill that big pair of shoes that Lynn left. He expects us to keep the faith, continue the dream. I say we can do no less. We all wish not to say "Goodbye Lynn," so we won't. We know you will be watching us, we can never forget your smile. We hope we can hear you say, "Well Done" for years to come.

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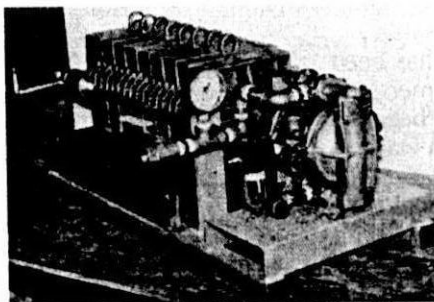
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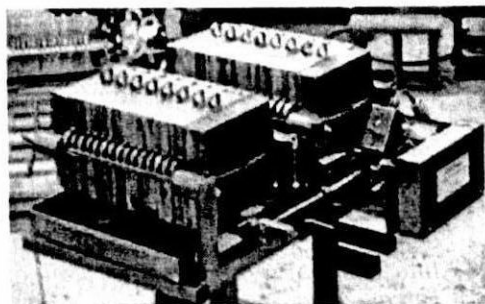
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# LIVING THROUGH A SUGAR BUSH DISASTER

By August E. Andersen

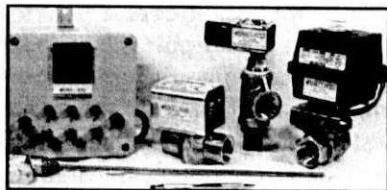
Those of us that live in southern New York State were fortunate to have a relatively mild winter compared to the ice storms which occurred in northern New York, some of New England and Canada.

However, in the mid-1950's we had experienced a heavy ice storm and I thought some of my observations would be of benefit to those who have now experienced the 1998 ice storm. I have been in the maple business most of my life and have seen many disasters come and go; so for what it's worth, here is my experience.

Producers in the maple syrup industry have some hard decisions to make. Questions, like, which trees should I cut and which trees should I leave and how long can I wait to cut these trees. Back in the 1950's ice storm the damage estimated to the tree tops averaged 10%-70% and many limbs were broken and hanging down. That spring we tapped all but the worst damaged trees and have tapped all these trees ever since. We had a 98% recovery of these trees. On the down side, it took 10 years for all the broken branches to fall out of these trees. The branches that died the first year dropped out in five years. Some branches lived on for a few years and then died; but the whole natural clean-up process took 10 years before the trees looked normal again. This wasn't so much of a problem in bucket tapped bushes, but it could be a real problem with tubing systems, due to branches falling as they died over a

period of time. Very few trees developed any rot, insect damage or fungus infection from the storm damage. When the forest tent caterpillar destroyed our forests back in 1979 and 1982; 200,000 acres were defoliated in our area. Our township alone lost 25,000 acres of hard maple. We sprayed some of our bushes and those were saved; but the trees that lost 50% or more of their tops died after a few years even in areas that were not tapped. Infestation of rot, fungus and insects was very high. The logs from the trees that died the first summer had already stained and weren't saleable; only as firewood. The trees that had a few live limbs on the lower parts were OK and had a salvage value for about three years. They stained slowly from the top down. My conclusion is that trees damaged when dormant seem to recover much better than trees damaged out of dormancy.

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# ASIAN LONGHORNED BEETLE SHOW UP IN CHICAGO, THREATENS THE MAPLE INDUSTRY

*By Larry Myott  
University of Vermont  
Extension Maple Specialist*

Doctors Margaret Skinner and Bruce L. Parker of the UVM Entomology Laboratory recently announced that a new infestation of the Asian Longhorned Beetle was discovered near Chicago, IL on July 13, 1998. A homeowner put box elder branches in the back of his car, when he opened it the next day, beetles were crawling all over the inside. Luckily this homeowner had the presence of mind to contact a local USDA agency, APHIS. They identified them as the dreaded Asian Longhorned Beetle that had only previously been found in New York City and Long Island, New York.

Little additional information about this new sighting in Chicago is available. Surveys are underway now to delineate the infested area, and plans are being made to cut down and destroy infested trees. Doctors Skinner and Parker point to two very important facts: first, it was a homeowner, not a state or federal pest specialist who detected both the New York and Illinois infestations. Secondly, this beetle has now been detected in another US location demonstrating that there is a real risk that it also could accidentally reach Vermont.

Because homeowners, tree care personnel and landscapers play an

essential role in surveying for this pest, and serve as primary agents in its spread, these people should be aware of what this beetle looks like.

Be on the lookout for insects that fit this description:

- Adults beetles are large (1-1.5 inch long) with very long antennae and have alternating segments of black and white. Their bodies are jet black with white spots. The best time to see them is from May to November.
- Large (3/8 inch diam.) round exit holes anywhere on the tree, including branches, trunk and roots.
- Large piles of coarse sawdust around the base of trees or where branches meet the trunk.

The beetle is believed to have come into the US with the wooden crates used to ship sewer pipes and other goods from China. Extensive efforts to eradicate the beetle from New York are underway, where over 2,000 trees have been destroyed since 1996. Surveys will continue for several years and more infested trees will likely be found and destroyed.

Since sugar maple is a favorite host for this beetle, sugar makers, University and state forestry officials are particularly concerned. The implications are staggering for Vermont and all the northeast states and eastern Canadian provinces and our most famous farm product, pure maple syrup. This beetle attacks live healthy trees and will kill them in a fairly short time, perhaps three to five years.

Personnel from the VT Dept. of Forests & Parks and the University of Vermont Entomology Research Lab

have joined forces to address this threat. Bruce L. Parker and Margaret Skinner, from UVM, are on the APHIS National Science Advisory Panel, which provides scientifically-based recommendations to the Management Team, on which H. Brent Teillon and Ron Kelley, from Forests & Parks, both serve. A public awareness program was organized in 1997 to alert people in Vermont of this pest, and over 2,000 calls of potential sightings were received.

No Asian Longhorned beetles have yet been found by Sugarmakers, but they must be constantly looking for signs. Maple producers and woodland owners are asked to become familiar with what this beetle looks like and the damage it causes. If you see anything that looks like this beetle or if you have any questions, contact Bruce L. Parker or Margaret Skinner at the UVM Entomology Research Lab, 802-656-5440, your Extension Maple Specialist or County Forester.

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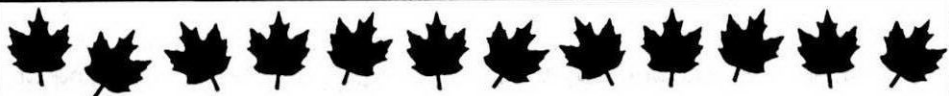
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# NEW YORK NEWS

By Marion Wells

The American Maple Museum opened its doors for the 1998 season on May 16. It was a beautiful sunny, warm day in Croghan, NY for the festivities. Three outstanding maple people were inducted into the Hall of Fame. They are Marjorie Palmer of Vermont, Gilles Croteau of Quebec, and Leslie Lyndaker of New York. All three have had distinguished careers in maple and have contributed greatly to the Maple World.

The New York State Maple Queen pageant was also held that day at the museum. Kim Lasky from Sharon Springs, NY was crowned 1998 NYS Maple Queen. Sarah Baker of Bainbridge, NY is first alternate, while Laurie Jean Fanfarillo of Rome, NY is second alternate, Kim was crowned by 1997 Maple Queen Martha Holland. The girls will be helping to promote Maple throughout New York

State at various fairs and community functions.

A successful New York Maple Tour was held July 23-25 in Chenango County with headquarters at the Fairgrounds. Everyone was thankful for the comfortable air conditioned busses as the temperature reached the high 80's. Many interesting and varied sugar houses were visited, from small to large. An especially interesting stop was the Northeast Classic Car Museum in Norwich, which brought back some great memories of how cars used to be.

Several awards were presented at the banquet on Friday evening. The Charles Hubbell award is presented by the NYS Dept. of Agriculture and Markets to an outstanding sugarmaker in memory of Charles Hubbell of Jefferson, Schoharie County. Mr. Hubbell helped to develop the first maple school in cooperation with Cornell Cooperative Extension. He also helped to write the first Maple Manual. The first award was given to him. He passed away, at age 94,



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shortly after receiving the award in 1991. This years recipient of the award is Florence C. Merle of Attica, NY.

The Bob Lamb Memorial Young Sugarmaker award was presented to Guy Gillette of Sherburne, NY. This award will be given each year at the tour banquet with the selection being made by the tour committee in the county or area holding the tour.

Plaques will be placed on display at the American Maple Museum to honor the recipients of the Hubbell award and the Lamb award. New name plates will be added each year.

A plaque honoring Mr. Henry

Uihlein was presented to American Maple Museum president Kermit Lyndaker by outgoing NYSMPA president Warren Wells. Mr. Uihlein gave generously to the maple industry of North America by donating funds and lands to establish the Cornell Maple Syrup Research Station at Lake Placid, NY. Mr. Uihlein passed away in the Spring of 1997.

By the time this goes to press the great NYS Fair will have become history, along with numerous local and county fairs. Thanks to the Maple Queens and all the maple producer volunteers whose work makes it all possible.

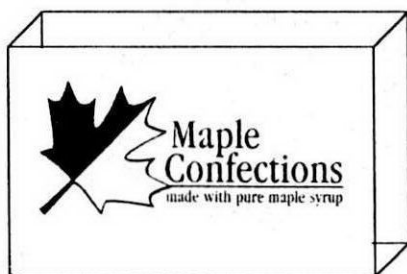


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## VERMONT EXTENSION MAPLE WEB SITE CHANGES ADDRESS

Getting on the Internet and communicating with the world is here; and maple sugar makers are no exception. Since last January the University of Vermont maple web site has been up and running, so far more than 3,300 hits have been made. The counter on the site records a hit each time someone accesses the site.

This extensive site was developed by Extension Maple Specialists Larry Myott and George Cook with the help of Robert Logsdon, a former Vermont Extension employee who had a business developing web sites and hosting

those sites. Due to some very unfortunate health circumstances, Logsdon had to shut down his business in early March, causing the site to get a new address. He passed away unexpectedly in June.

Getting access to the Vermont maple Extension Web site is easy,

the address is:

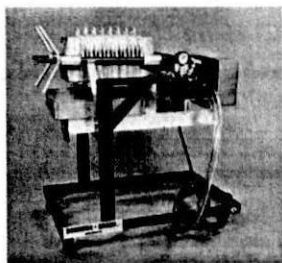
<http://www.uvm.edu/~uvmaple/>

This Extension home page will connect you to numerous other sites, including many Vermont producer web pages, the State of Vermont's web pages, the Proctor Maple Research Center, UVM Entomology and more. Larry Myott's email address is [Lmyott@zoo.uvm.edu](mailto:Lmyott@zoo.uvm.edu) and George Cook can be reached at [gcook@sover.net](mailto:gcook@sover.net).

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## FLORENCE C. MERLE HONORED

Florence C. Merle is the 1998 recipient of the Charles R. Hubbell Memorial Award, established by the New York State Department of Agriculture and Markets to honor New York maple producers who have made significant contributions to the advancement of the state's maple industry. Florence's husband, Arthur E. Merle, Jr. received this award in 1994.

Florence has been active in the maple industry for the past 58 years. Florence's strength is her dedicated work on behalf of New York's maple producers in support positions through the years. She has been the office support for the Secretary/Treasurer of the New York State Maple Producers for 24 years. Florence was the 4H Secretary in Wyoming County prior to her marriage in 1940. She keeps her secretarial skills up-to-date and keeps the membership roll of the New York State Maple Producer Association on her computer.

Florence has helped numerous newcomers to the maple industry over the years get their start. She manages the Merle Farms maple kitchen, at one time making over a ton of maple sugar a year. She is well known for the quality of her maple cream, winning the blue ribbon at NYS Fair for many years. Florence attends the Wyoming County Maple Producers Association meetings, the New York State Maple Producers Association meetings, as well as the North American Syrup Council meetings. She works in the Wyoming County and New York State Fair maple booths.

Florence was a 4H leader for 42

years, raised five children, is Treasurer of Attica's United Methodist Women, as well as being active in the day-to-day Merle Farms maple and livestock businesses.



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# NEWS FROM THE AMERICAN MAPLE MUSEUM

*By Eleanor Allen*

Once again, as summer winds its way into the shorter days of autumn, the American Maple Museum can look back on a busy and active season. For a pleasant change, the re-opening ceremonies, on May 16th, took place in brilliant sunshine. As reported earlier, Majorie Palmer, Leslie Lyndaker, and Giles Croteau were inducted into the American Maple Hall of fame. So many people attended the pancake breakfast that the volunteer staff ran out of sausages at the very end. Many equipment manufacturers and craft people showed their wares. The chicken barbecue and parade rounded out the events at the twenty-first re-opening of the American Maple Museum.

As part of the festivities, the 1997 Maple Queen, Martha Holland, of St. Lawrence County, passed on her crown to Kimberly Lasky of Schoharie County. First and second runners-up were Sarah Baker of Chenango county and Laurie Jean Fanfarillo, of Herkimer County. The other contestants were Erika Reyell of Clinton County, Kimberly Lasky of Schoharie County, and Brooke Bradley, Shannon Thornhill, and Christina Johnson, all of St. Lawrence County. Ann and Lynn Reynolds and Michael Girard judged the contest. Karen Keefer was Chairperson of the 1998 New York State Maple Queen Contest.

The fine weather, unfortunately, did

not extend to the ice cream social and cakewalk on July 4th, which had to be held indoors, due to rain. Chairs were set up in the Museum dining room and visitors enjoyed maple or strawberry sundaes, punch, maple cotton candy and hot dogs, as they listened to the spirited music of the Country Stompers.

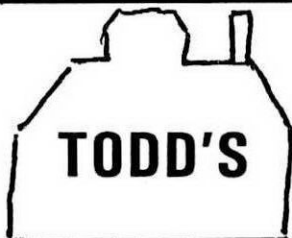
Once again, the Museum participated in the program sponsored by the Pratt-Northam Foundation to provide summer employment to college students in fields related to their college majors. This year, however, the Museum hired two summer interns. Kelly Williams helped to show visitors around the museum and did general maintenance work as needed in the building and the grounds outside. Michelle Wendt, armed with a tape recorder, visited older maple producers and talked with them about the changes that have taken place in the maple syrup industry over the years. The purpose of this special oral history project was to make a record of the stories which will not be remembered if they aren't recorded. The summer was shorter than the stories, however, and the museum now has wonderful tape recordings which still need to be organized, transcribed, and, in some way put on display in the Museum.

By the time you read this, the Museum will have formally closed for the winter, but please keep in mind that it is always available for group tours, if arrangements are made in advance by phoning 315-346-1107 or writing to the Museum at P.O. Box 81, Croghan, NY 13327.



### HALL OF FAMERS—1998

FRONT ROW: New Inductees 1998, Gilles Croteau, QU, 98; Marjorie Palmer, VT, 98; Les Lyndaker, NY, 98. BACK ROWS: Left to Right, Nelson Widrick, NY 81; Bob Coombs, VT, 89; Ron Shaw, ONT, 87; Russ Davenport, MA, 86; Paul Richards, OH, 88; Bill Clark, VT, 95; Lynn Reynolds, WI, 95; Lew Staats, NY, 97; Charles Bacon, NH, 93; Mariafranca Morselli, VT, 91.



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# PROMOTING MAPLE ACROSS THE U.S. AND CANADA

Colchester, VT —

The Vermont maple industry and Premier Coach of Vermont unveiled a great joint promotion in July with a brand new Premier luxury coach painted with an 18 foot long maple sugaring scene on each side.

The maple promotion project was funded jointly by the Orange County Maple Sugarmakers Association and Premier Coach of Vermont. The Orange County group operates a maple sugarhouse at the Tunbridge World's Fair each fall and contributes their earnings to maple promotion, research and marketing projects. Chair Gerard Stevens of Thetford noted how pleased the group is to be able to co-sponsor a project that will depict Vermont maple sugaring all over the U.S. and Canada.

The bus was first used for a maple event at Vermont Maplerama in Washington County last August. It will be traveling to Western Pennsylvania in late October to take the New England delegation to the joint meetings of the North American Maple Syrup Council and International Maple Syrup Institute. The coach is running regular charters and routes for Premier.

Artist Robert Shappy is a native of Burlington who has been a full time working artist since 1990. He is a self taught artist that can seemingly work in any medium. Shappy's motto is "Any Design on Any Surface," he literally has done it, with this bus project being the largest.

The concept, development and coordination was by UVM Extension Maple Specialist Larry Myott of Burlington, who notes, "there are several more buses that could use Vermont agricultural murals, all we need is funding." Contact Larry Myott for further information.

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# THE USE OF HIGH PRESSURE STEAM IN THE PRODUCTION OF MAPLE PRODUCTS

By Clarence F. Coons  
Coons Agroforestry Consulting  
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The use of high-pressure steam for processing in the maple industry is nothing new. Its use dates back to the late 19th century when steam boilers became readily available for use on farms and commercially made steam evaporators were manufactured on a limited basis. Wood or coal fired steam traction engines were sometimes used as a source of steam for boiling sap.

In the past fifty years there has been only one significant attempt by a manufacturer to provide processing equipment using high-pressure steam. In 1968, the G.H. Grimm Co., Inc. of Rutland, Vermont produced the first of several dozen steam finishing pans known as the Sipple steam finishing evaporators. Some are still in use today. In addition, other companies have supplied flat pans and steam coils on a limited basis.

While the use of high pressure steam for processing in the maple industry is not new, the use of modern steam systems is new technology to most producers considering its use. It is a very specialized technology and other applications of its use on farms are rare.

For purpose of definition, high pressure steam is steam pressure over 15 pounds per square inch.

The safe use of high pressure steam is important to everyone using it. Those planning on installing a high pressure steam system should seek advice from qualified experts.

At the 1995 annual meeting held in Kingston, Ontario many maple producers packed a meeting room to hear about the use of high pressure steam in the production of maple products from several experienced persons on the programme. At the pre-conference tour, attendees had already had an opportunity to see the maple syrup operation of George and Marilynne Drummond near spencerville, Ontario which was converted entirely to steam for processing in 1993.

By the end of the conference it was apparent to those attending the steam sessions that the use of high pressure steam offered a good alternative processing method for the production of maple products.

It was also apparent that more information on the subject was needed.

## **The Current Use of High Pressure Steam in the Maple Industry**

To obtain more detailed information on the use of high pressure steam in the maple industry a project to review and evaluate its use was commenced in May, 1997.

A literature search on the subject located only two brief articles on the subject and no references to research projects on its use were found.

To determine the current use of high pressure steam by maple syrup producers a survey consisting of sixty-five questions was developed and sent to known maple producers with experience in its use. Twenty-four producers participated in the survey.

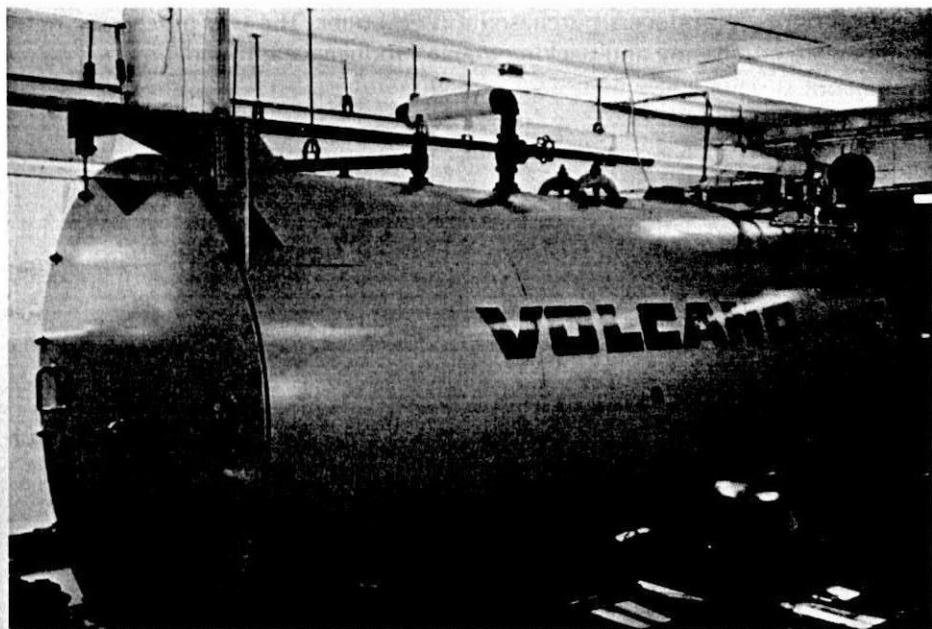
### Highlights of the Maple Producers Steam Survey

The Survey questionnaire dealt with the subject in the following categories:

1. Owner/Operator
2. The Boiler
3. Steam Traps
4. Evaporation Process and Equipment
5. Quality of Maple Products
6. Economics of Using High Pressure Steam
7. Multiple Uses of High Pressure Steam
8. Advantages of Using Steam in the Production of Maple Products
9. Disadvantages of Using High Pressure Steam in the Production of Maple Products.

### Owner/Operator

The average number of years experience of those using high pressure steam was 16.6. The producer with the most experience has used steam for 50 years.



*Conventional oil fired, fire tube boilers are most commonly used. To reduce the capital investment most maple producers purchase a good used boiler. This used 70 Hp Volcano boiler supplies steam for the boiling of all sap from 1,800 taps at the farm of George and Marilynne Drummond near Spencerville, Ontario.*

Steam tends to be used in larger operation. Fifty-nine percent of the operations using steam have 5,000 or more taps. The largest operation had 30,000 taps. Six producers used high pressure steam for all processing while all the others used other conventional equipment such as oil fired evaporators or R.O.'s for part of the processing as well.

### **The Boiler**

The selection of a steam boiler is the most important decision to make when setting up a steam system. Most producers who operate only during the sap season buy a used boiler, since 4-6 weeks use doesn't normally justify the expense of a new one if a good used one is available.

Boilers are either fire tube or water tube and they may be externally or internally fired depending on their construction.

Boilers are rated in terms of steam output in lbs./hr. at a given pressure and temperature at full load or maximum continuous operation. Boiler horsepower and boiler heating surface area in square feet are two measures of boiler capacity. The overall thermal efficiency of steam boilers is in the 70-80% range varying with boiler burner design, steam and return distribution design, trap design and efficiency, boiler maintenance and flash steam loss.

Respondents in the survey indicated they were using boilers of varied capacity and type. For finishing only smaller boilers from 15 to 25 Hp were used. The largest boiler used was 385 Hp. Both fire tube and water tube boilers are being used. All but two producers purchased a used boiler. The two purchasing new boilers were purchasing and packing maple products year round.

The normal operating pressure for initial boiling of sap was in the 70-100 psi range while lower pressures were used by some for finishing depending on the type of equipment used.

### **Steam Traps**

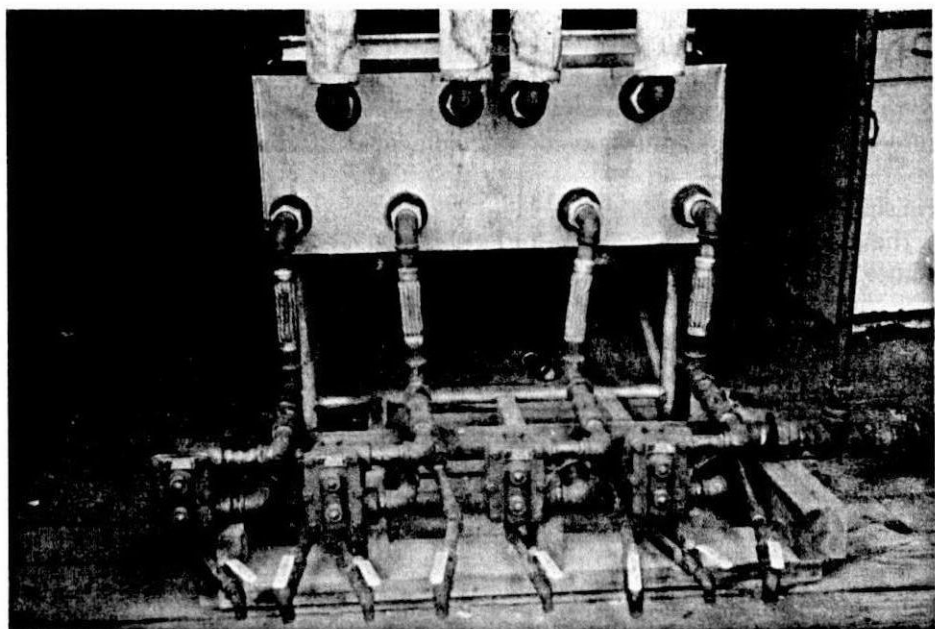
For maximum efficiency, condensation in steam lines must be removed. Cooling of steam in mainlines due to insulation losses or in the evaporator coils during boiling results in condensation of steam in the pipes or coils. This condensate is formed in the steam coils when it gives up its heat through the walls of the tubing or coils causing the sap to boil. Steam traps were used by most producers since they offer the best means to remove condensate.

Condensate from the traps is returned to the boiler feed water supply tank for boiler make-up water.

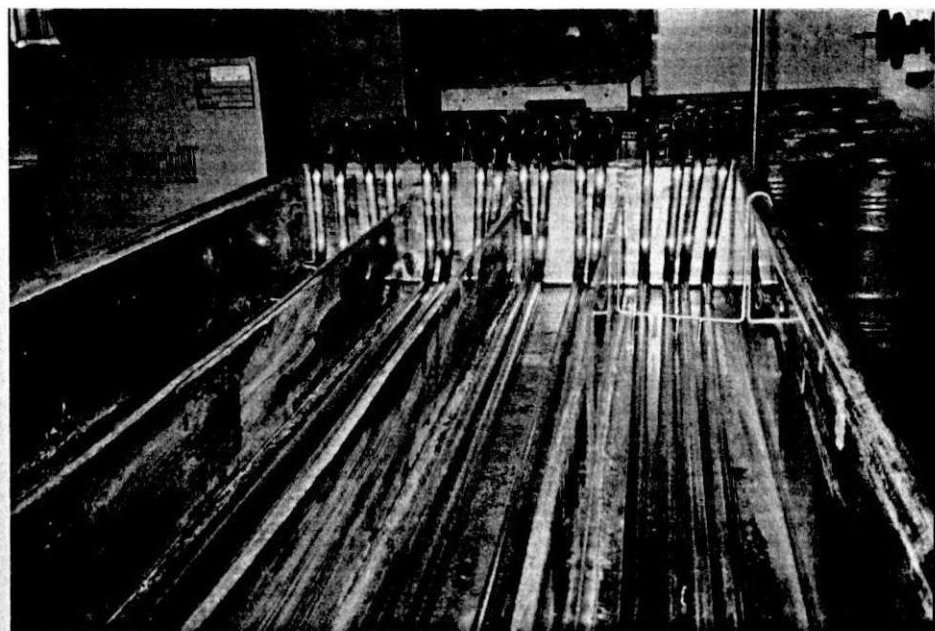
### **Evaporation Process and Equipment**

There were several variations of equipment used in combination with high pressure steam equipment. Included was the use of R.O.'s, oil fired evaporators and a piggy back evaporator. Twelve producers used R.O.'s for initial sap concentration. Nine producers used steam for finishing only.

Fourteen producers used a flat pan with steam coils for boiling. The length and width of the pans varied depending on the size of the operation. Pans were usually



*Steam traps are used to remove condensate and air out of the steam system. Condensate forms in the steam coils as the sap in the pan cools the steam in the coils. The traps remove this condensate automatically.*



*Straight through, single pass thin walled stainless steam tubes in a large four section boiling pan at Bascom Maple Farms near Alstead, New Hampshire.*

18" to 24" deep. Most producers used copper steam coils in the pan, a few used stainless.

Scale formed on the steam coils must be removed, usually daily from the coils or tubes. Most producers found this a relatively easy task. All producers in the survey found their steam evaporation equipment satisfactory.

### **Finishing**

The use of high pressure steam for finishing utilized either commercial steam kettles, flat pans or Sipple steam finishing units.

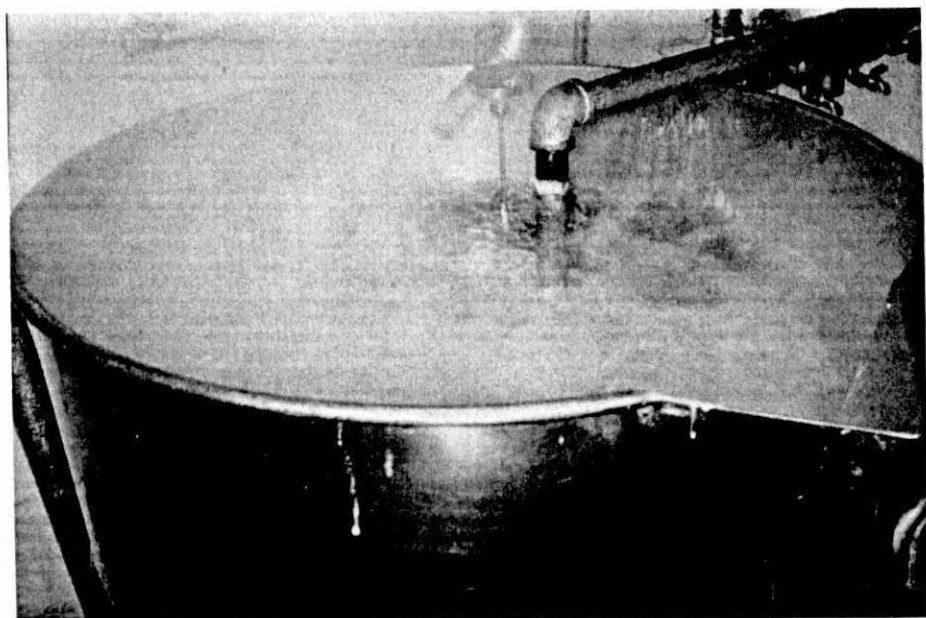
Seven producers used commercial steam kettles varying in size from 20-50 U.S. gallons. Eleven producers used flat pans with steam coils or tubes for finishing. Pans were usually deep with sides in the 14"-24" range. The length and width varied with the boiler capacity, the amount of sap to be boiled and the amount of concentration to be done.

Four producers were using the 2' x 8' Sipple steam finishing units. All producers using high pressure steam for finishing rated it as a good or excellent method.

### **Quality of Maple Products**

Opinions expressed regarding the quality of maple products produced when using high pressure steam equipment were impressive.

- Twenty respondents in the survey felt that the use of high-pressure steam improved the quality of their maple products over the use of conventional



*Commercial steam kettles are excellent for finishing maple syrup. This kettle at Reynolds Sugar Bush near Aniwa, Wisconsin is equipped with a steam coil. In addition, several producers use direct steam jacketed kettles.*



methods. Six felt that the average colour class of maple syrup was improved by one class, while 13 felt that it was improved by one-half class.

- Eight producers felt that the flavour of their maple syrup was improved when using steam while four felt it was not. Eight respondents were not sure.
- Nine producers indicated they used steam for making other maple products including maple sugar, maple candy and butter, granulated and powdered sugar and maple barbeque sauce.
- Six producers felt that the quality of their other products was improved when using steam. One did not see any improvement while three were not sure.

### **Economics of Using High Pressure Steam**

Twenty-three respondents in the survey felt that using steam for processing was economical for them. They rated the cost of production using steam as follows.

	<i>Number of Respondents</i>
Cheaper than conventional methods	10
Costs about the same as using conventional equipment	8
Slightly more expensive	3
Considerably more expensive	Nil

Many felt there were significant savings in labour when using high pressure steam. In addition, the many other uses of steam made its use even more economical. Good maintenance of the entire steam system also minimizes costs by avoiding costly repairs.

### **Multiple Uses of Steam in a Maple Operation**

In addition to using high pressure steam to do the boiling, producers find many other uses for it in various other applications around the sugar house.

Most used steam for reheating syrup for packing, for cleaning buckets and drums and for producing warm water for washing tubing.

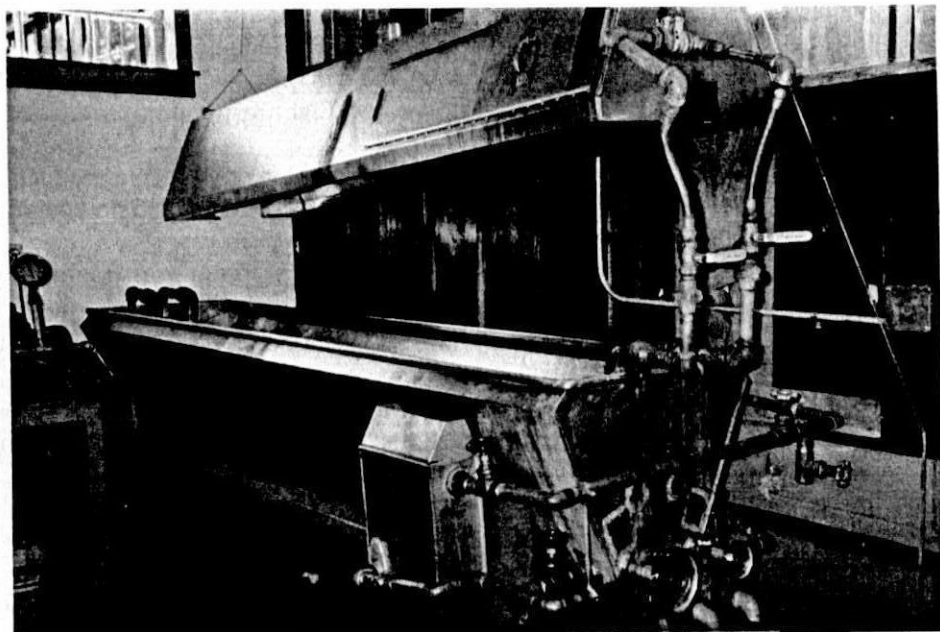
Also several used it for production of other maple products.

Other interesting uses included melting ice in pipes and valves after cold nights, cleaning storage tanks, heating wash water for the cleaning on R.O. machine and sounding the dinner whistle.

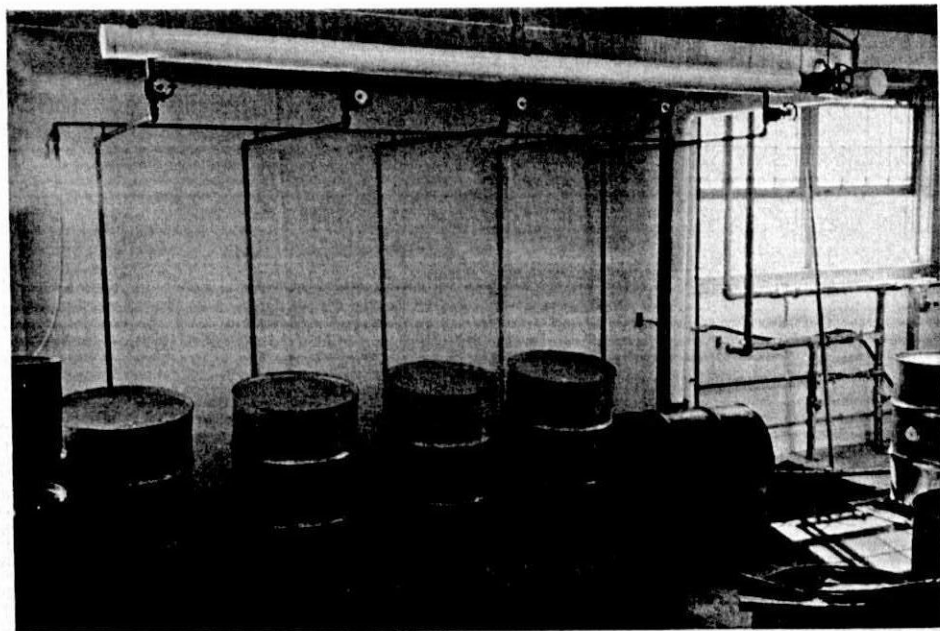
### **Advantages of Using High Pressure Steam**

Respondents in the survey mentioned numerous advantages of using steam. Some important advantages were as follows:

1. Excellent control of boiling.
2. No burning or scorching of syrup or sugar.
3. Easy to remove scale from the steam coils.



*In 1968 the G.H. Grimm Co. of Rutland, Vermont began manufacturing the Sipple steam finishing evaporator. Several of these units are still in use like this one at Doug Rose's Green Mountain Sugar House near Ludlow, Vermont.*



*Cleaning drums at Bascom Maple Farms is an easier task with this well designed steam drum cleaner. Its just one of the many uses of steam at Bascom's.*

4. Excellent for maintaining sanitary conditions for processing.
5. Using high pressure steam can be economical, even less costly for some than other methods.
6. The time and labour involved in processing is minimized especially when used with an R.O. machine.
7. It is easy to produce high quality maple products with considerable consistency.

Other advantages expressed by respondents included: faster boiling rate; syrup is lighter coloured; cheap fuel to syrup ratio; easy to pipe steam wherever you need it; cost advantage; one person can run the operation at the flick of a switch; boiling is almost instant with high pressure steam; can keep equipment cleaner; the whole process is more economical.

While most advantages are readily shared by many, the extent to which producers benefit from some advantages such as the cost advantage will vary somewhat depending on several factors.

### Disadvantages of Using High Pressure Steam

Respondents mentioned some disadvantages of using steam. It should be noted that the disadvantages listed by one respondent were not necessarily considered disadvantages by others.

However the following should be considered:

1. Depending on where you live, steam systems can be expensive to install and service.
2. Several respondents found it difficult to obtain information and advice on the subject.

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3. There have been no detailed research projects to assess the use of high pressure steam in the production of maple products.
4. High pressure steam systems can be dangerous if not installed, maintained and operated properly.
5. There are rules and regulations concerning the use and operation of high pressure steam systems which vary depending on where you live. You must become familiar with them and follow them.

### Conclusions

The Maple Producers Steam Survey clearly indicates the successful production of high quality maple products by all respondents. The advantages of its use are many and the disadvantages are few. For those considering the use of high pressure steam it is highly recommended that you discuss your plans with knowledgeable, qualified persons. This includes manufacturers of high pressure steam equipment, mechanical engineers, engineering technicians, boiler inspectors, steam fitters, stationary engineers and maple producers with experience in using it.

Although there is considerable flexibility in the design of steam systems, components of the system must be carefully selected, properly installed and maintained for safe and efficient operation.

Knowledge of codes and regulations applicable to your area is important and information on them should be obtained from the experts as noted above.

It is estimated that less than 100 maple producers throughout the entire range of maple syrup production use high pressure steam for all or part of their processing. While the number is small, the potential for its use in the industry is extensive.

There are a number of things that could be done to assist the expansion of its use in the industry.

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## Research

The lack of research on the subject has no doubt been a deterrent. Research will help answer many questions and concerns regarding important matters such as: safe use of high pressure steam, equipment design and selection, steam system layout, the economics of using it, quality control of maple products, etc.

## Forum for Discussion

The potential for expanded use of high pressure steam exists in all Provinces and States where commercial production of maple products occurs.

The establishment of a committee at the National level could provide a forum for discussion and dissemination of information on its use. Depending on interest, committees could be set up at local levels.

## Extension Information

The preparation and provision of extension material on the subject will greatly assist potential users in decision making and accelerate expansion of its use.

## Acknowledgments

I would like to thank all twenty-four participants in the Maple Producers Steam Survey who provided much useful and interesting information. I would also like to thank the Ontario Ministry of Agriculture, Food and Rural Affairs for technical support. In addition, I would like to thank the North American Maple Syrup Council and the Ontario Ministry of Agriculture, Food and Rural Affairs, Grow Ontario Investment Program for the financial support which made it possible to conduct this review.

Finally I would like to thank the Eastern Ontario Local of the Ontario Maple Syrup Producers Association and the Eastern Ontario Model Forest who were support partners in the project.

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## MY GRANDPA MEMORIES!

1. The warm HUGS!
2. The trip to Salt Lake City when I helped with the book about the family history!
3. The trip to Yellowstone National State Park!
4. The trip to Apostle Islands when I got sick and then Craig, and then when we made it home Grandpa finally caught it!
5. When we went to the Sears Tower (which I hated) and from then on I was teased by Grandpa such as, ready to go back Lindsey and so on.
6. The special sleigh ride grandpa always had on Christmas which we would ride through the woods singing carols!
7. Santa's Secret Workshop also always on Christmas!
8. Clue games where you grab an adult and go looking for presents hidden all over the place.
9. The game we always played after all the stuff on Christmas was done. (We would play for hours)!
10. The Hello Hello as soon as you walked in the door!
11. The sweet poems he wrote for everyone!
12. The wonderful Chair that was so special to him!
13. His blue blanket which he said I could have after he has left us (but you know what I figured out is that I would rather have my Grandfather than any blanket in the whole world)!
14. The lessons Grandpa has taught me will stick with me for the rest of my life and they are the simple little lessons such as be friendly to everyone, always keep a smile on your face, live your life to the fullest, Grandpa sure did, and never ever give up no matter what is in your way!
15. The laughing and telling stories by the camp fire!
16. The last thing that I will never forget is the way Grandma yelled my name to go and get help!

There are many more memories of Grandpa! I loved my Grandpa more than most other things and would give anything to have him back but I know that can't happen! I love you Grandpa and hope you're always with me!

Love you always,

Lindsey Anne Reynolds (your granddaughter)



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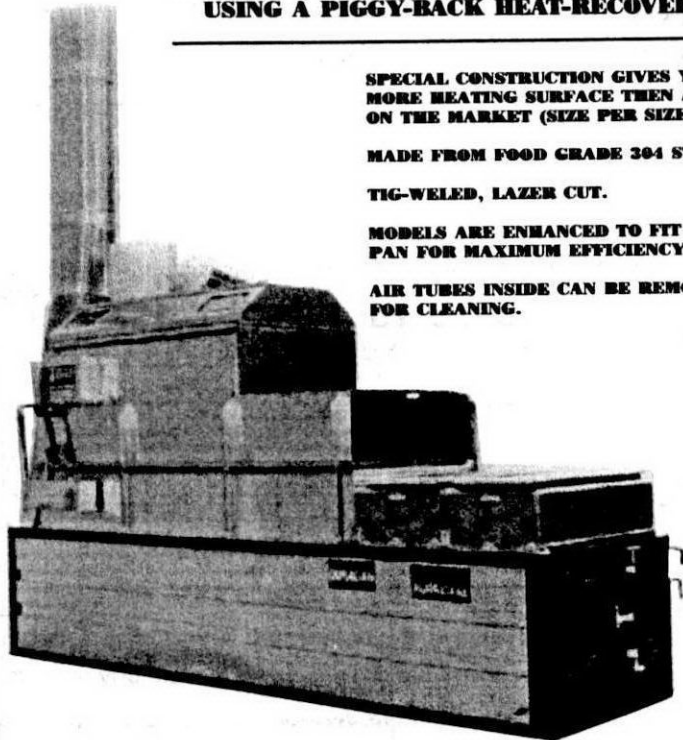
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## PRESSING BUSINESS

Bruce Burchard is a tool maker who has been able to combine his skills with his love of maple syrup.

"Syrup is one of the things I always think about," said Burchard.

Burchard operates BLB Machine of Guys Mills in his semi-retirement after founding and being president of Tresco Tool. He also produces about 200 gallons of maple syrup.

His love of designing tools and that of maple syrup have teamed up in a new invention — a five-inch filter press for the maple syrup hobbyist.

"Presses aren't new," he said. "They've been used for juice and wine for years." Presses also have been used by the maple syrup industry. They were made of cast iron and were prone to rusting from the liquid.

Burchard first developed aluminum ones, 7-inch and 10-inch, but electrically operated.

Burchard's latest design is made from food grade aluminum and is operated by a small hand pump. He said the press is designed for the smaller producer like himself — those making 200 gallons or less a year.

The syrup passes through a series of 10 paper filters and corresponding metal plate sets as it is filtered.

"The filtering is between the finish boiling and canning while it's still hot," he said. "Most strain theirs through a cloth before the syrup goes in the canner. This is a thorough filter."

His idea has caught on. It's been tested by the Proctor Maple Research Center in Vermont and Cornell University Maple Program at Lake Placid NY with very favorable results.

He's built 50 of the 5-inch presses since the fall and 40 of them were purchased by the Waterloo/Small Evaporator Co. of Enosburg Falls, Vt., a maple syrup equipment supply company. Garth Atherton, operational manager for Waterloo/Small, called the press a welcome addition since a small scale model previously didn't exist.

Asked if it's been a popular seller, Atherton said, "It's the first time in my life I've been able to sell 40 of anything and not get any complaints."

By Keith Gushard, Tribune, 3/23/98 with permission.

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