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**COVER: The original 1818 embossed seal of the West-Point Foundry Association, as found on an indenture dated 14 February 1825 for Samuel McDowell, age 17, to apprentice in the trade of millwright at the West Point Foundry. Courtesy Kemble Family Papers (private collection of a Kemble Family descendant, New York state), box 7, folder 3.**