

George P., he bought the Principio Iron Works in Cecil County, Maryland, one of the oldest and most noted in the country, with which at one time Washington was associated. Connected with this furnace were about eleven thousand acres of land, making them the owners of the most extensive tract of real estate in that State. In 1845, Joseph Whitaker with his son Wm. P. C. Whitaker, and his brother George P. Whitaker and David Reeves, built a furnace at Havre de Grace, Md. The year 1846 brought a change in his business relations. Benjamin Reeves, the head and founder of the firm, with whom he had been closely allied, and for whose judgment he ever entertained the greatest respect, having died, he soon after withdrew his interest, and giving up the house in which he had been living on Main Street, north of Bridge, in Phoenixville, he built a spacious mansion in Montgomery County, opposite the town, upon an elevation overlooking the Schuylkill River, at the historic Gordon's Ford, where Cornwallis and the Hessians crossed in the fall of 1777. The ground had belonged to the Jacobs family, which had furnished the last colonial speaker of the Pennsylvania Assembly. Before that time it had been the site of an Indian village. In the revolutionary period the farm house upon it had been struck by a cannon ball from Cornwallis' artillery. Under the buttonwood trees that grew on the low soil in front, an American had been killed. Bayard Taylor, a friend and frequent visitor, gave to the new home the name of Mont Clare, which later became attached to the village that grew up around it. Here, in peace and plenty, he spent the remainder of his days.

In 1848 Joseph and George P. Whitaker, with James A. Pennypacker, bought the Durham Iron Works and nine hundred acres of land in Bucks County, Pa., one of the oldest furnaces in the State, and the same year, as a