

## CLEVIS WITH THREADED PIN

When a person has sufficient time, and a set of thread plates, he will do well to make a clevis of this type. It is more satisfactory than the small clevis, Plate 10.

## How to Make the Clevis with Threaded Pin

1. Upset each end of the stock for a distance of about  $1\frac{1}{2}$  inches.

2. Shape the ends as shown in the top and front views, Plate 11. To make the shoulder, shape over the round edge of the face of the anvil.

3. Drill or punch a  $\frac{1}{16}$ -inch hole in one end, and drill a  $\frac{1}{2}$ -inch hole in the other. Tap the  $\frac{1}{2}$ -inch hole with a  $\frac{5}{8}$ -inch tap.

4. Bend over the horn of the anvil to the proper size, and with the holes exactly above each other.

5. Make the pin. Flatten one end to  $\frac{5}{16}$  inch thick,  $\frac{5}{8}$  inch wide and  $2\frac{1}{4}$  inches long.

6. Heat, and clamp in the vise, and bend the flattened end over to one side, as in Fig. 16. Then bend over the horn of the anvil until the curve for the head is almost completed. Finish by hammering down directly on the stock until the end comes around and touches. The eye of the gate hook, Plate 3, is forged in much the same way. Fig. 28 shows the completed clevis.

7. Thread the pin with a  $\frac{5}{8}$ -inch die. Be sure the end of the pin is perfectly round before trying to thread it.

*Note.*—Use plenty of oil when threading a bolt or tapping a hole in wrought iron, or “blacksmith iron” or “mild steel.” In cast iron no oil is required.



FIG. 28.  
THREADED PIN.



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# FARM BLACKSMITHING

A TEXTBOOK AND  
PROBLEM BOOK FOR STUDENTS IN AGRICULTURAL  
SCHOOLS AND COLLEGES, TECHNICAL  
SCHOOLS. AND FOR FARMERS

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