

### SMALL CLEVIS

This type of clevis is quickly and easily made, and is, therefore, the kind to make for a "help out" when another breaks.

#### How to Make a Small Clevis

1. Upset both ends of the 14-inch piece of stock for a distance of 1 inch.

2. Flatten and shape these ends as shown in the top and front views, Plate 10. Shoulder in for the flat part, on the rounding edge of the face of the anvil.

3. Punch a  $\frac{9}{16}$ -inch hole in each end. Punch the hole far enough back from the end to give sufficient strength.

4. Mark the center and bend over the horn of the anvil to the size indicated in the drawing. Be sure to bend the iron so that the straight side is on the inside of the clevis.

5. Now make the pin. Upset the stock for the head first.

6. Shape the head as shown on the front view and the separate drawing of the pin at the bottom of the plate.

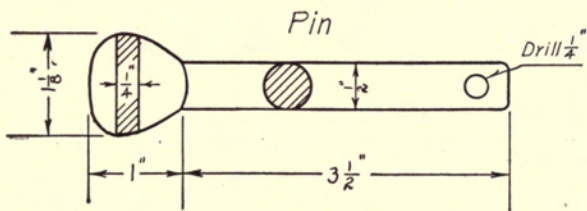
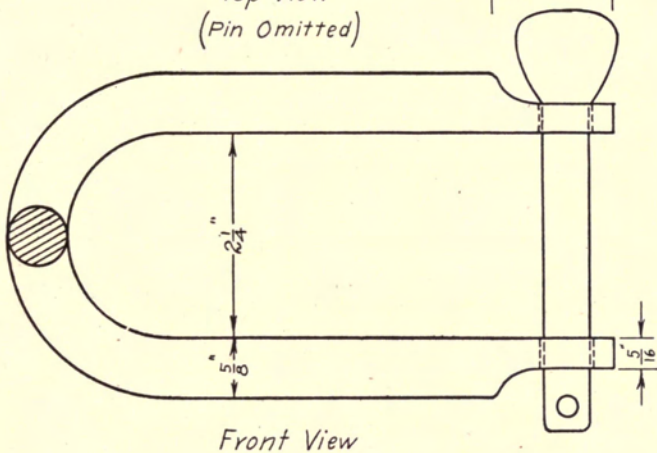
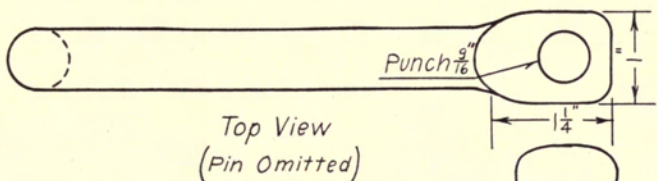
7. Mark with a center punch, and drill a  $\frac{1}{4}$ -inch hole in the end. Fig. 27 shows the completed clevis.



FIG. 27.  
SMALL CLEVIS.

*Note.*—Drilling thru round stock requires more care and skill than is required on flat stock. Hold the piece firmly. When the drill starts to come thru it has a great tendency to catch and break. Therefore, when you feel the drill beginning to come thru do not apply any pressure to it, but let it go thru slowly. A broken drill can often be reground when only a part is broken off. Use another drill for a pattern when regrinding.

# SMALL CLEVIS



Stock  
 1pc.  $\frac{5}{8}$ " x 14" Round  
 1pc.  $\frac{1}{2}$ " x 4  $\frac{1}{2}$ " Round

UNIVERSITY OF CALIFORNIA

# FARM BLACKSMITHING

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

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