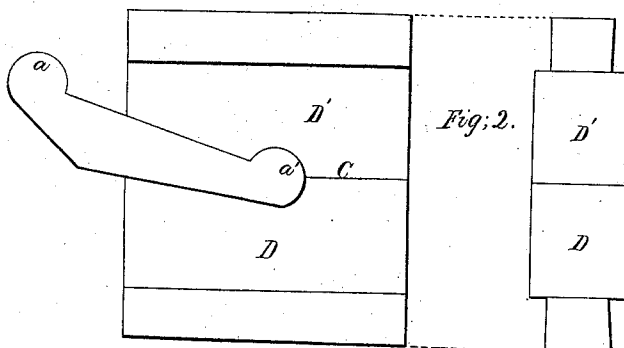
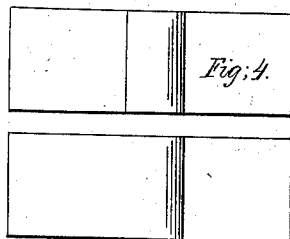
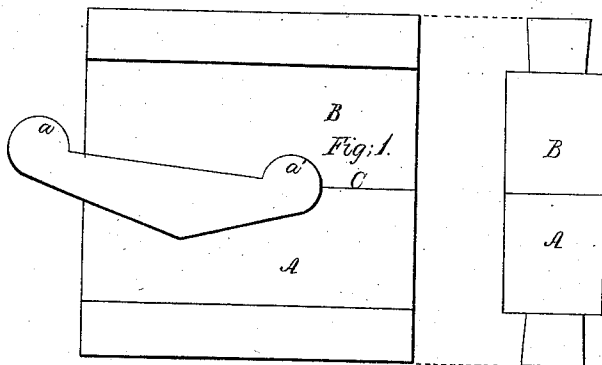
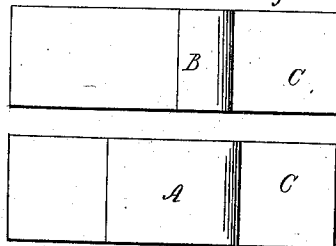
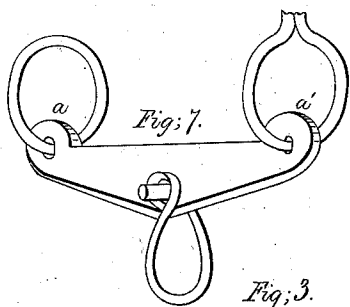
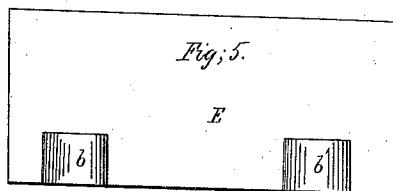
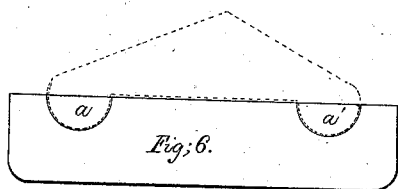


J. Kritch,

Making Plow-Irons,

N^o 81,380.

Patented Aug. 25, 1868.



Witnesses.
E. E. Nailor
H. Conn.

Inventor.
Jacob Kritch

United States Patent Office.

JACOB KRITCH, OF CLEVELAND, OHIO.

Letters Patent No. 81,380, dated August 25, 1868.

IMPROVED DIE FOR MAKING CLEVIS-BLANKS.

The Schedule referred to in these Letters Patent and making part of the same.

TO ALL WHOM IT MAY CONCERN:

Be it known that I, JACOB KRITCH, of Cleveland, in the county of Cuyahoga, and State of Ohio, have invented certain new and useful Improvements in Dies for Making Three-Horse Plow-Clevises; and I do hereby declare that the following is a full and complete description of the same, reference being had to the accompanying drawings, making part of this specification, in which—

Figure 1 is a side view of the dies for forging one part of the clevis.

Figure 2 is a side view of the die used in forging the other part.

Figures 3 and 4 are top views of the dies.

Figures 5 and 6 represent the gauge.

Like letters of reference refer to like parts in the different views.

My invention relates to dies for forging a three-horse plow-clevis, in order to save the trouble and expense of making them in the ordinary way, and which, also, gives them a uniform size and shape, whereas the usual mode of making them they are uneven and rough in appearance, and unequal in size; also, by this manner, they are more quickly, cheaper, and better made. The manner in which they are constructed is as follows:

A, fig. 1, represents the bottom die, which is connected with the anvil. B is the upper die, which is attached to the head of the trip-hammer. A bar of iron, of the desired size and dimensions, is heated and placed in the cavity of the lower die, and is beaten or swaged into shape by the upper, in concert with the lower one. In being forged, it will usually spread out laterally. This can be remedied by placing it in the flattener C of the dies, and, by the action of the upper die on the lower, it is formed in the desired shape, when it can again be placed in the dies; and again hammered between them. Thus alternately the iron is compressed or forged between the dies A and B and flattener C, until the desired form and configuration of one part of the clevis are obtained.

When this end of the clevis is formed, it can be cut from the bar at the length desired, and the unformed end be placed in the die D, the upper die, D', being attached to the hammer the same as in the former case; thus this end is forged into shape in substantially the same manner as the end before described.

Its length is measured by placing it in the gauge E. The two ends, *a* and *a'*, fit in the cavities *b b'*, as indicated by the dotted line *c* in fig. 6.

It is important that the three-horse plow-clevis be of uniform size and dimensions. This cannot be accomplished in the ordinary manner, hence the forging is always done with reference to this gauge or templet.

The clevis is now ready for receiving the holes, hooks, and rings.

What I claim as my improvement, and desire to secure by Letters Patent, is—

The dies as herein described for the purpose set forth.

JACOB KRITCH.

Witnesses:

W. H. BURRIDGE,

E. E. WAITE.