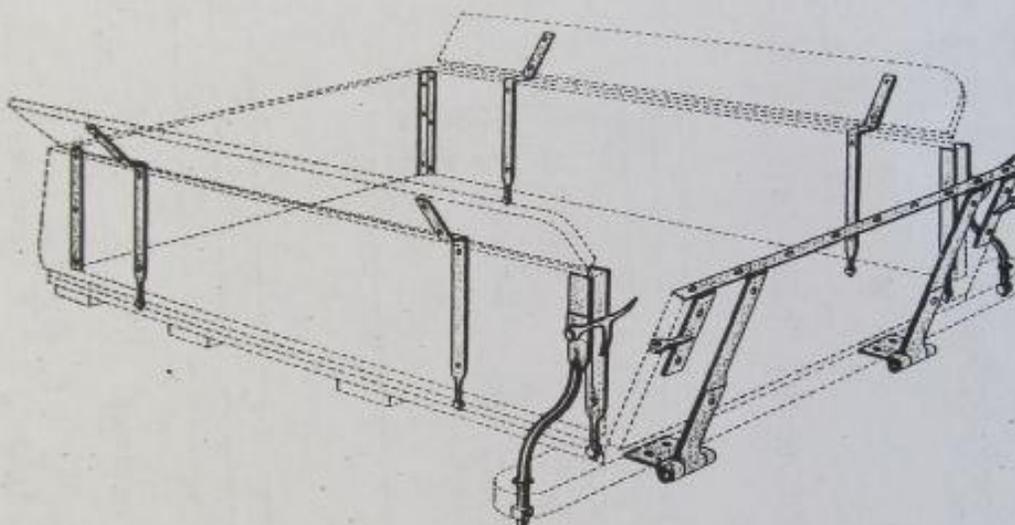


*"Cleveland"*  
**FORGED STEEL**  
*Ford Slip-on Body Irons*



*Drop Forged Body Iron Set, No. 1-B*



Working Drawings and  
Directions for Building a  
**SLIP-ON BODY** for  
**FORD ROADSTERS**

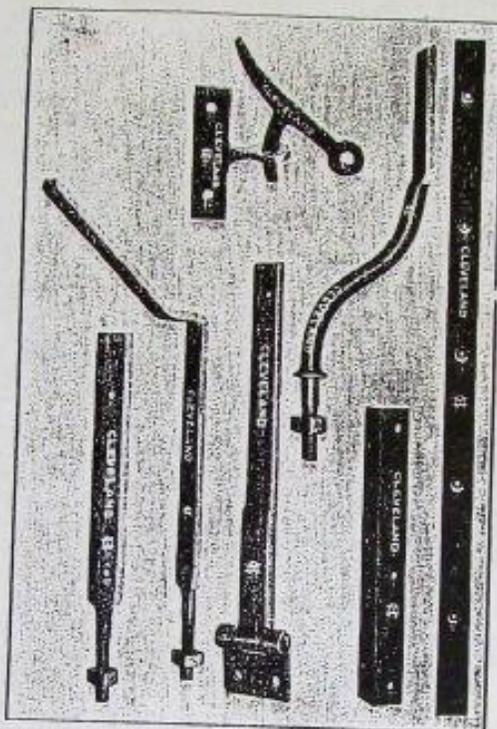
MADE BY

**THE CLEVELAND HARDWARE CO.**

CLEVELAND, OHIO

## CONTENTS OF PACKAGE

*Check Out Carefully*



- |                                      |                        |
|--------------------------------------|------------------------|
| 2 End Gate Fasteners,<br>(4 pieces.) | 4 Flare Board Irons.   |
| 2 End Gate Hinges.                   | 2 Rear Inside Straps.  |
| 2 Rear Outside Braces.               | 1 Tail Gate Edge Iron. |
|                                      | 2 Front Corner Irons.  |

### BOLTS AND WASHERS

- |    |              |                                   |
|----|--------------|-----------------------------------|
| 2  | 2 x 1/4      | oval head round shouldered bolts. |
| 4  | 2 1/2 x 1/4  | oval head carriage bolts.         |
| 26 | 1 1/2 x 1/4  | " " " "                           |
| 12 | 1 1/4 x 1/4  | " " " "                           |
| 4  | 3 x 3/8      | " " " "                           |
| 4  | 3/8          | washers.                          |
| 8  | 1/2          | "                                 |
| 8  | 3/4 x No. 10 | wood screws.                      |

Note the unusual completeness of this set. It contains FRONT CORNER ANGLE IRONS, making it unnecessary to make wood blocks, a TAIL GATE EDGE IRON, adding to the life of your tail gate and INSIDE BODY STRAPS, giving additional strength to your body.



The lumber used in the construction of this body should all be finished  $\frac{7}{8}$ " in thickness, with the exception of the rear cross sill which is  $1\frac{1}{4}$ " in thickness. We recommend the use of HARD WOOD for the four cross sills.



In getting out the lumber for this body, work exactly to measurements specified in drawings and your body will go together without difficulty.



Enclosed you will find a full size pattern for your use in cutting the curve on the front end of the side panel to conform with the curve on the seat back.



If you desire to build a longer body than shown in the drawings, we would recommend the use of three flare-board irons to a side instead of two, for the additional strength required.

You can buy them from your jobber or we shall be glad to send them to you, postage paid, on receipt of price, if he cannot supply you.

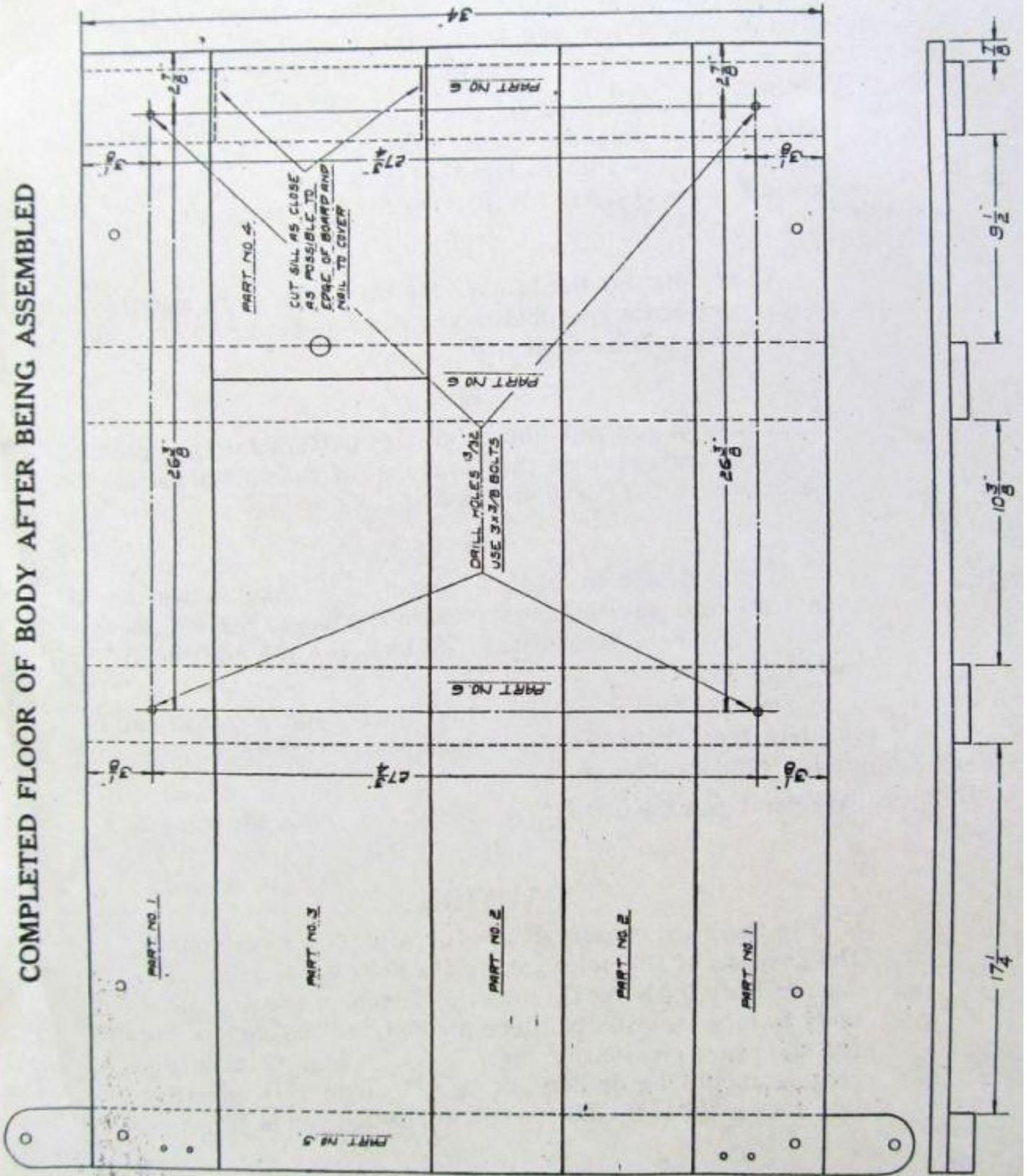
Ask for 1 pair 2460 C-1.....Price 60c per pair



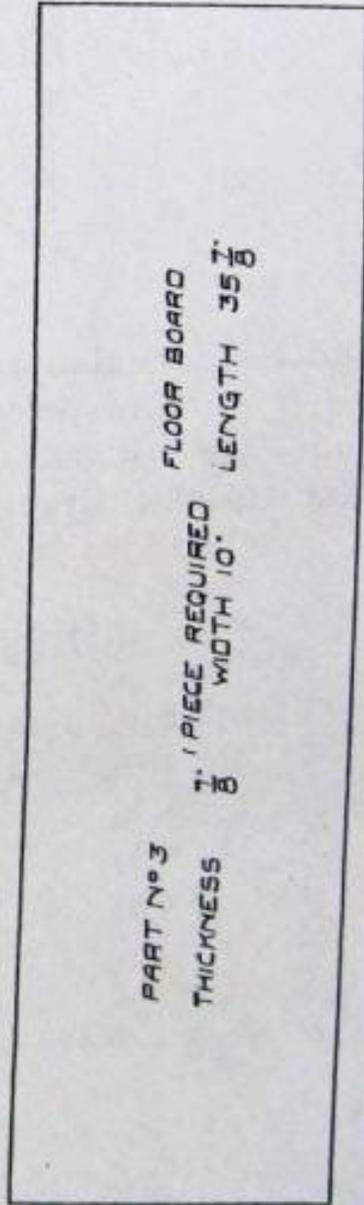
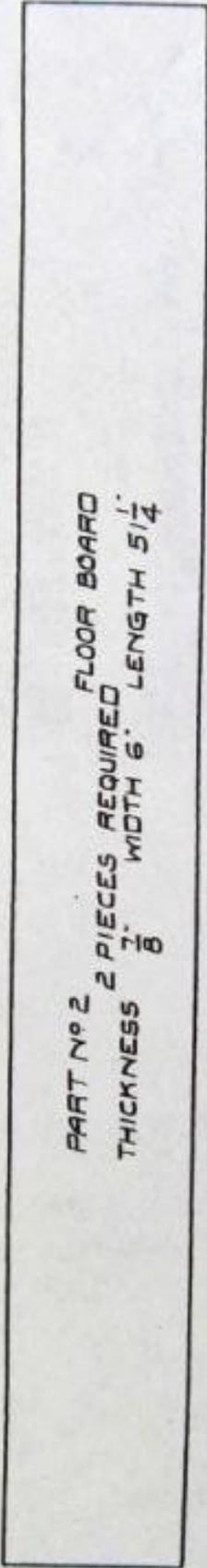
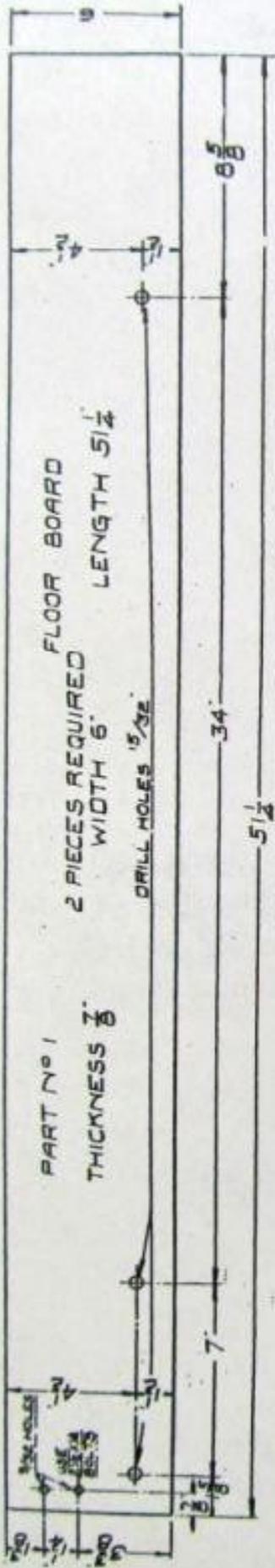
## CAUTION

In the Ford chassis there is occasionally a variation in the position of the holes taking the hold down bolts. Before drilling the holes through the bottom of the completed body to take these bolts, place the body on the chassis and get the exact position of these holes. These holes in the chassis should be drilled out to  $\frac{3}{8}$ ". You will find they now take a  $\frac{1}{4}$ " bolt, and the bolt furnished you is  $\frac{3}{8}$ ".

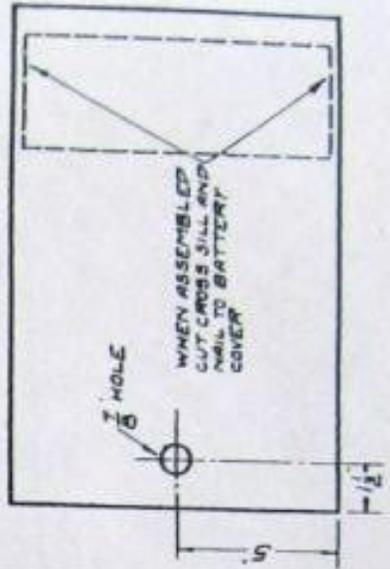
# COMPLETED FLOOR OF BODY AFTER BEING ASSEMBLED



# DRAWINGS 1-2-3-4—DETAIL OF FLOOR BOARDS



PART NO. 4  
 1 PIECE REQUIRED  
 THICKNESS  $\frac{7}{8}$ "  
 WIDTH 10"  
 LENGTH  $15\frac{3}{8}$ "  
 BATTERY COVER



## DIRECTIONS

---

Cut out and finish lumber to measurements on drawings; then drill holes and nail FLOOR BOARDS to CROSS SILLS.

Then insert SIDE BRACES and FLARE BOARD IRONS in holes in bottom boards and bolt on SIDE PANELS, bolting INSIDE STRAP at rear end of side panel.

Now bolt on FRONT PANEL, using corner angle irons furnished, after which bolt on HINGES and TAIL GATE.

The special round shouldered bolt which holds the END GATE FASTENER passes thru both outside brace, side panel and inside strap.

After body is together saw thru front cross sill on each side of battery box opening as directed in drawing of completed body floor and nail the piece cut out to the BATTERY BOX COVER.

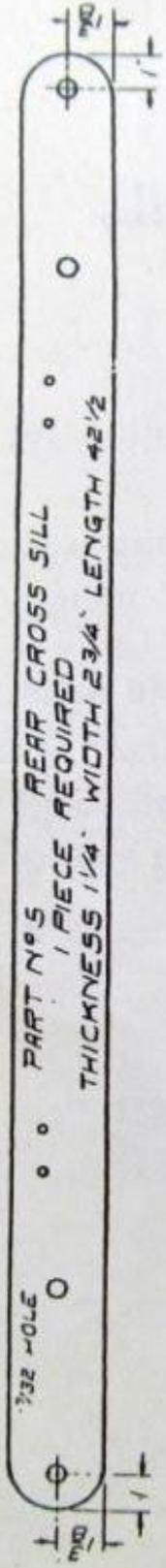
Place completed body on chassis and check position of holes for hold-down bolts.

Drill holes in body for hold-down bolts.

Drill out holes in chassis to  $\frac{13}{32}$ " and bolt body on chassis.

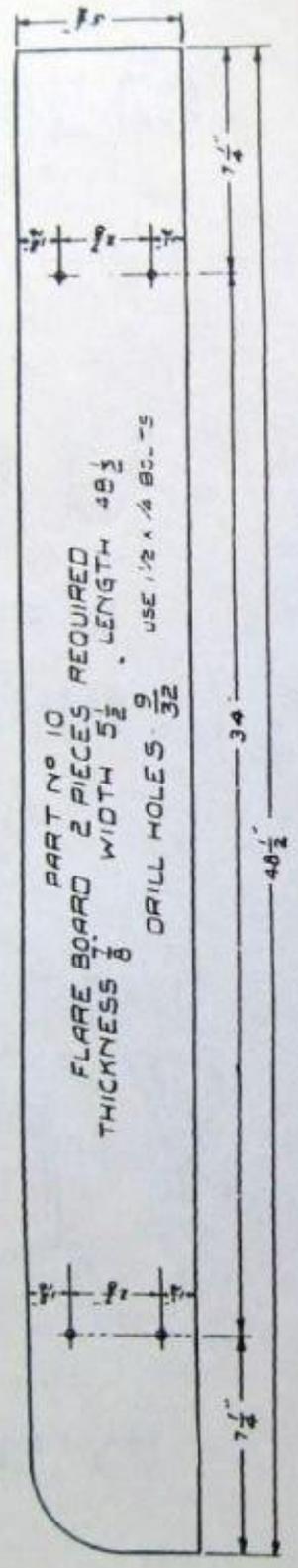
The  $\frac{1}{2}$ " washers furnished are to be used on SIDE BRACES, FLARE BOARD IRONS and INSIDE STRAPS.

# DRAWINGS 5 and 6—DETAIL OF CROSS SILLS



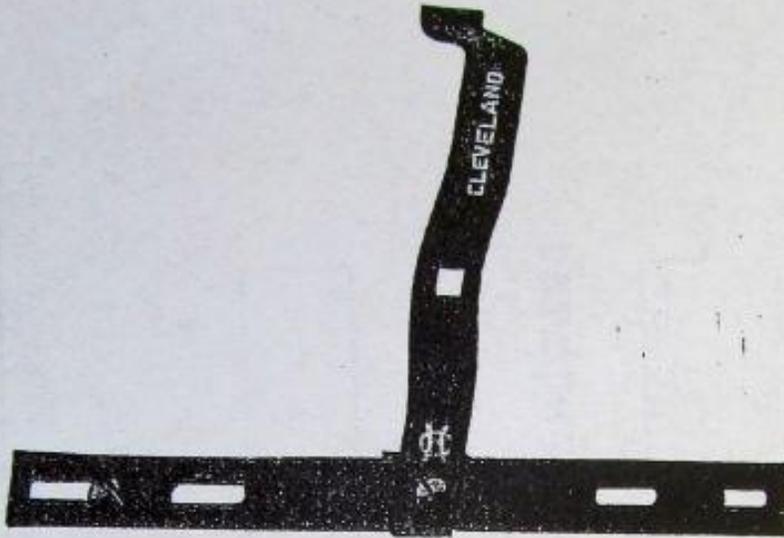
PART NO 6  
 THICKNESS  $\frac{7}{8}$   
 3 PIECES REQUIRED  
 WIDTH  $3\frac{1}{2}$   
 CROSS SILL  
 LENGTH 34"

# DRAWING 10—DETAIL OF FLARE BOARDS





**THE INSTALLING OF YOUR SLIP-ON BODY  
Necessitates the Removal of the  
Tire Carrier with the Tail Lamp  
and License Bracket**



Catalog No. 2595-A

Above is a cut of our lamp and license tag bracket to take the place of the one removed. It bolts to the rear of your chassis, using one of the same bolts which fastens the tire carrier in place.

Mailed, postage paid, on receipt of price, or have your jobber order for you.

Ask for number 2595-A.....Price 25c

---

**THE CLEVELAND HARDWARE CO.**  
CLEVELAND, OHIO