

No.1905

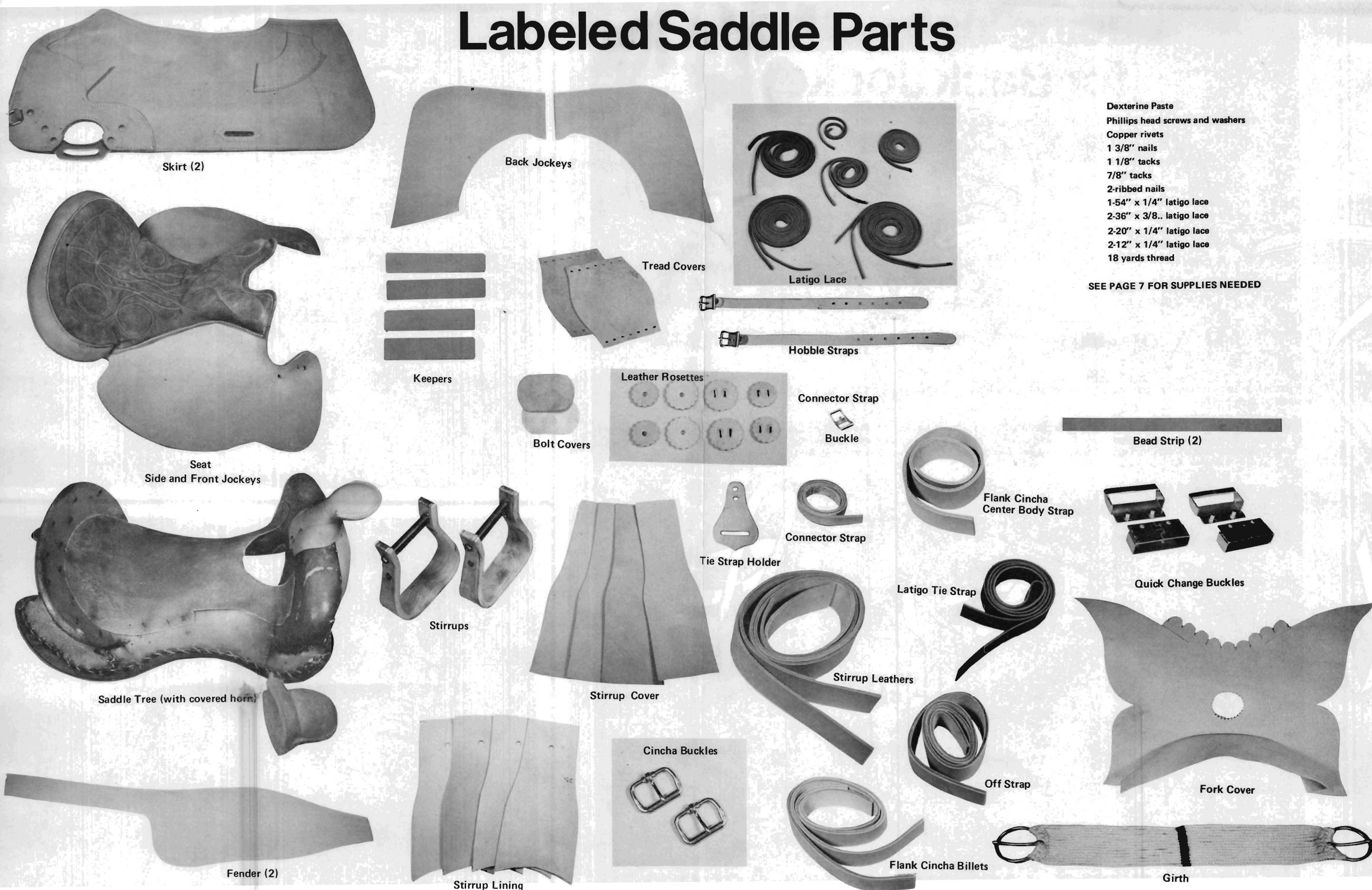
PATTERN and COMPLETE INSTRUCTIONS for SADDLE

tandy
LEATHER COMPANY

No.3520



Labeled Saddle Parts



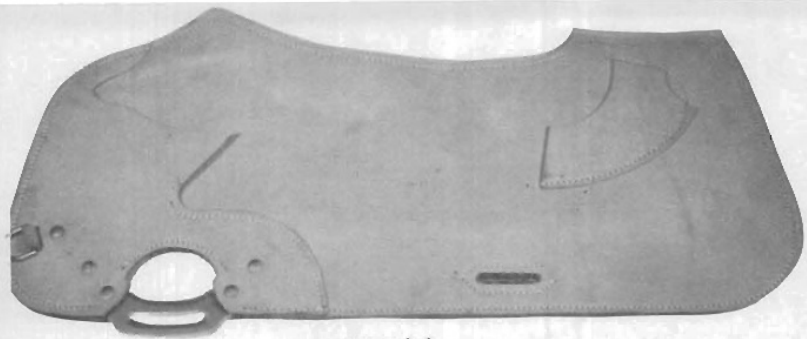
Dexterine Paste
Phillips head screws and washers
Copper rivets
1 3/8" nails
1 1/8" tacks
7/8" tacks
2-ribbed nails
1-54" x 1/4" latigo lace
2-36" x 3/8" latigo lace
2-20" x 1/4" latigo lace
2-12" x 1/4" latigo lace
18 yards thread

SEE PAGE 7 FOR SUPPLIES NEEDED

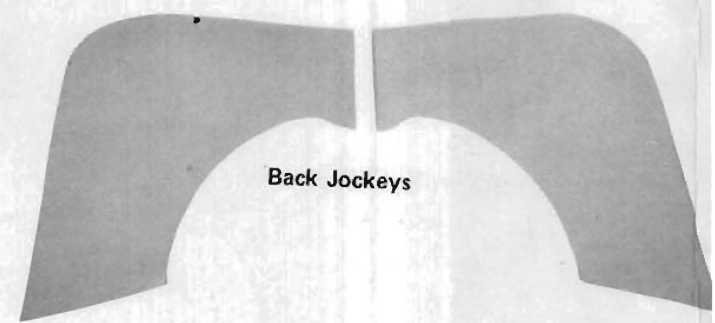
No.1905



**PATTERN and
COMPLETE
INSTRUCTIONS
for SADDLE**



Skirt (2)



Back Jockeys



Tread Covers

Labeled Sa



No. 3520

iddle Parts



Dexterine Paste

Phillips head screws and washers

Copper rivets

1 3/8" nails

1 1/8" tacks

7/8" tacks

2-ribbed nails

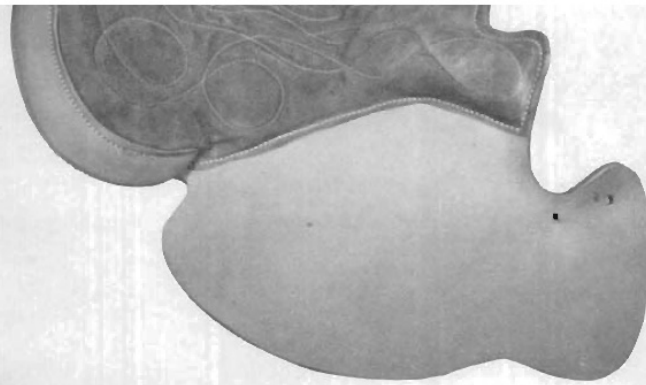
1-54" x 1/4" latigo lace

2-36" x 3/8.. latigo lace

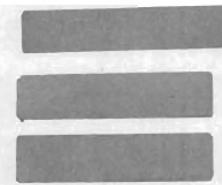
2-20' x 1/4" latigo lace

2-12" x 1/4" latigo lace

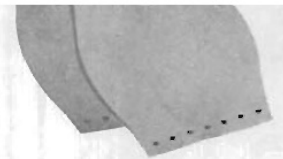
18 yards thread



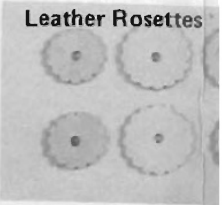
Seat
Side and Front Jockeys



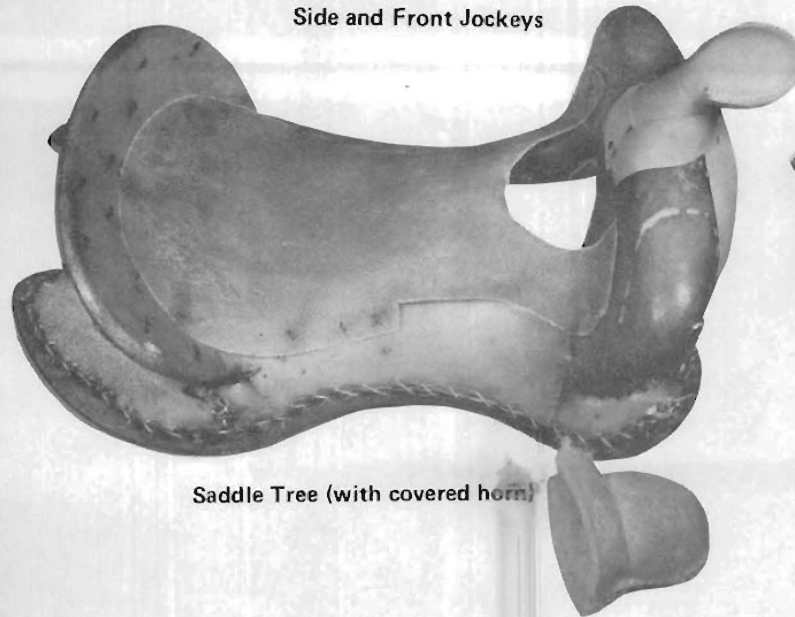
Keepers



Bolt Covers



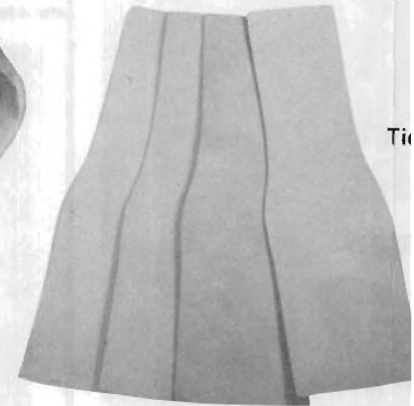
Leather Rosettes



Saddle Tree (with covered horn)



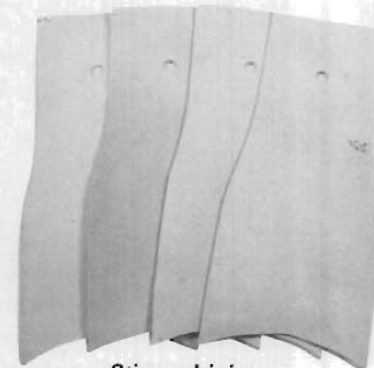
Stirrups



Stirrup Cover



Fender (2)



Stirrup Lining



Cincha Buckle

Latigo Lace

Hobble Straps

Connector Strap

Buckle

Bead Strip (2)

Flank Cincha
Center Body Strap

Connector Strap

Quick Change Buckles

Latigo Tie Strap

Stirrup Leathers

Off Strap

Fork Cover

Flank Cincha Billets

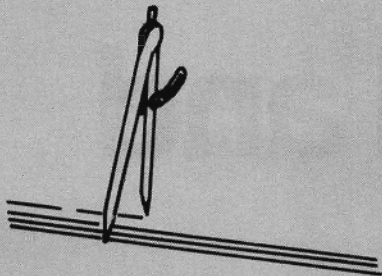
Girth

e Strap Holder

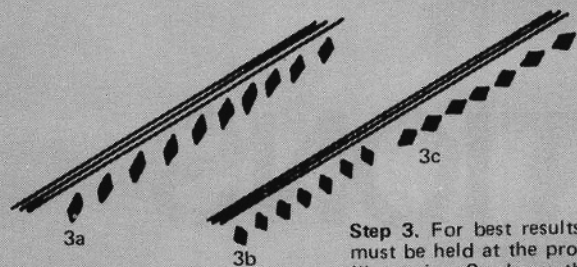
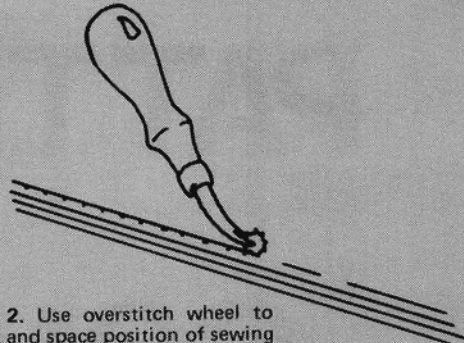
es

Hand Sewing Instructions

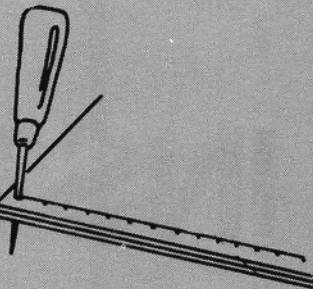
Step 1. Adjust compass to mark leather about 3/16" from edge of leather.



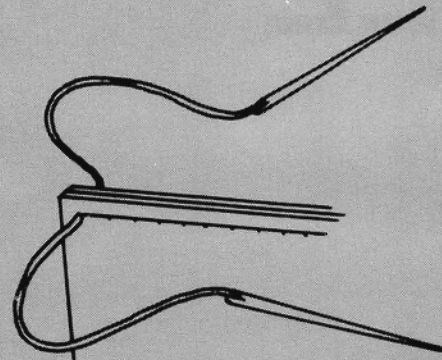
Step 2. Use overstretch wheel to mark and space position of sewing holes. For clear imprints, dampen leather before marking.



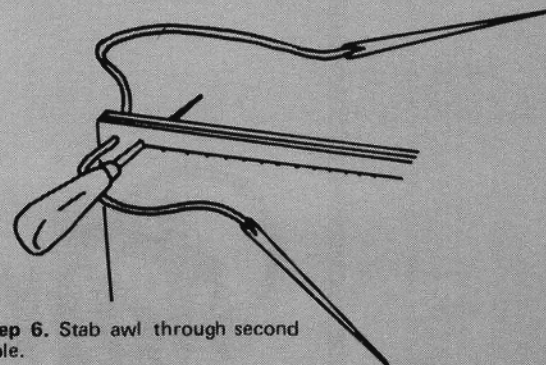
Step 3. For best results, the awl must be held at the proper angle. Illustration 3a shows the correct angle of holes. If holes are like 3b, awl marks will show after stitching. If holes are like 3c, thread will tear through holes if not already cut through.



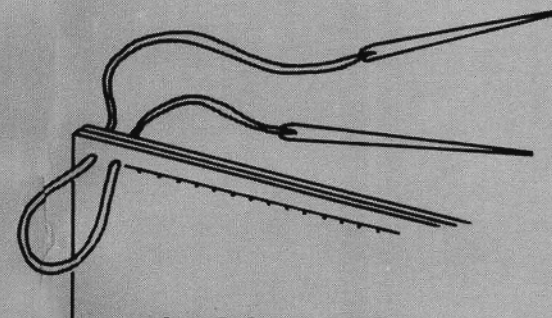
Step 4. Stab awl through first hole at proper angle. Thread the needle. (See threading the needle instructions.)



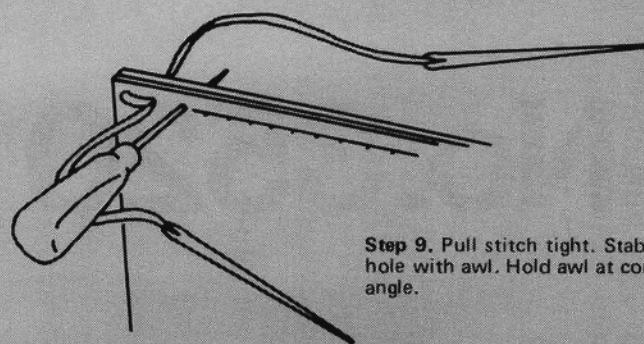
Step 5. Push one needle through first hole and pull to center of thread.



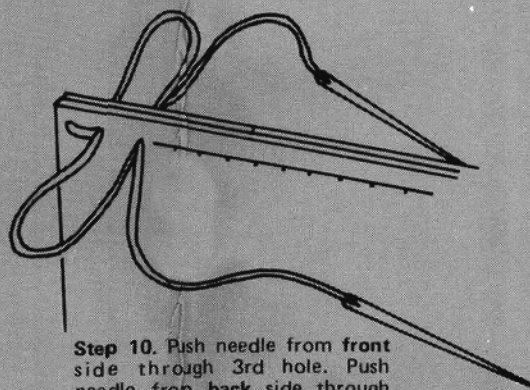
Step 6. Stab awl through second hole.



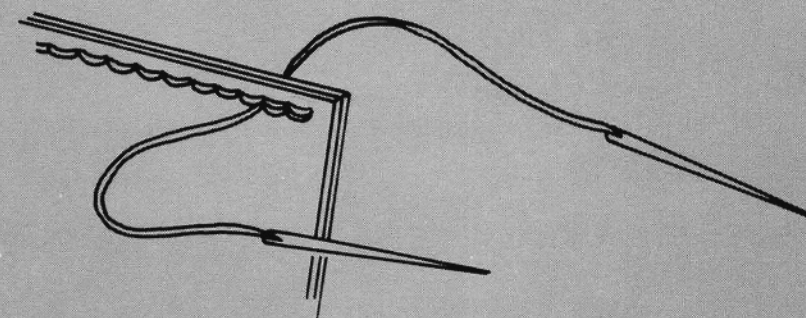
Step 7. Push needle from front side through second hole.



Step 9. Pull stitch tight. Stab 3rd hole with awl. Hold awl at correct angle.



Step 10. Push needle from front side through 3rd hole. Push needle from back side through same hole and pull stitch tight.



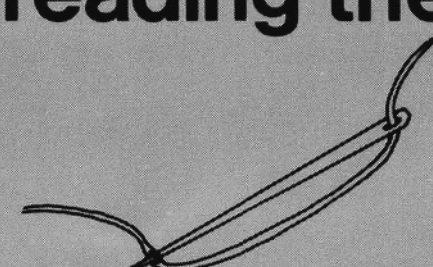
Step 11. To finish off, back stitch through last two holes and cut threads off flush with leather.

Threading the Needle

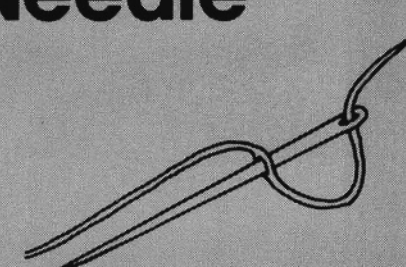
Step 1. Push end of thread through needle of eye about 1/2".



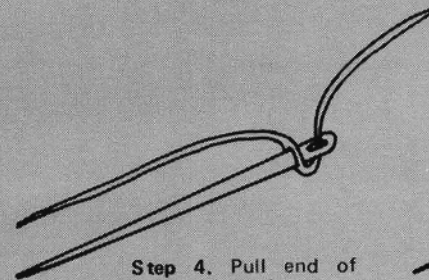
Step 2. Pierce thread with needle point as shown.



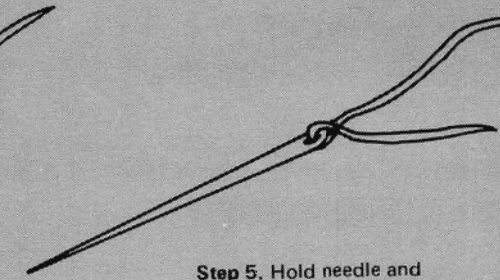
Step 3. Push thread up on needle to eye.



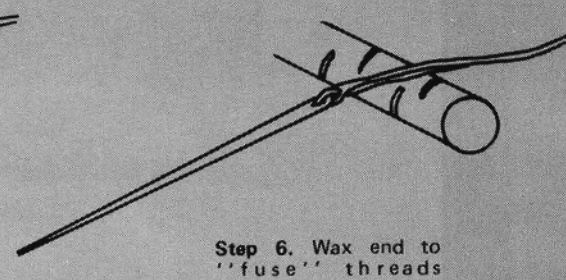
Step 4. Pull end of thread through eye as far as it will go.



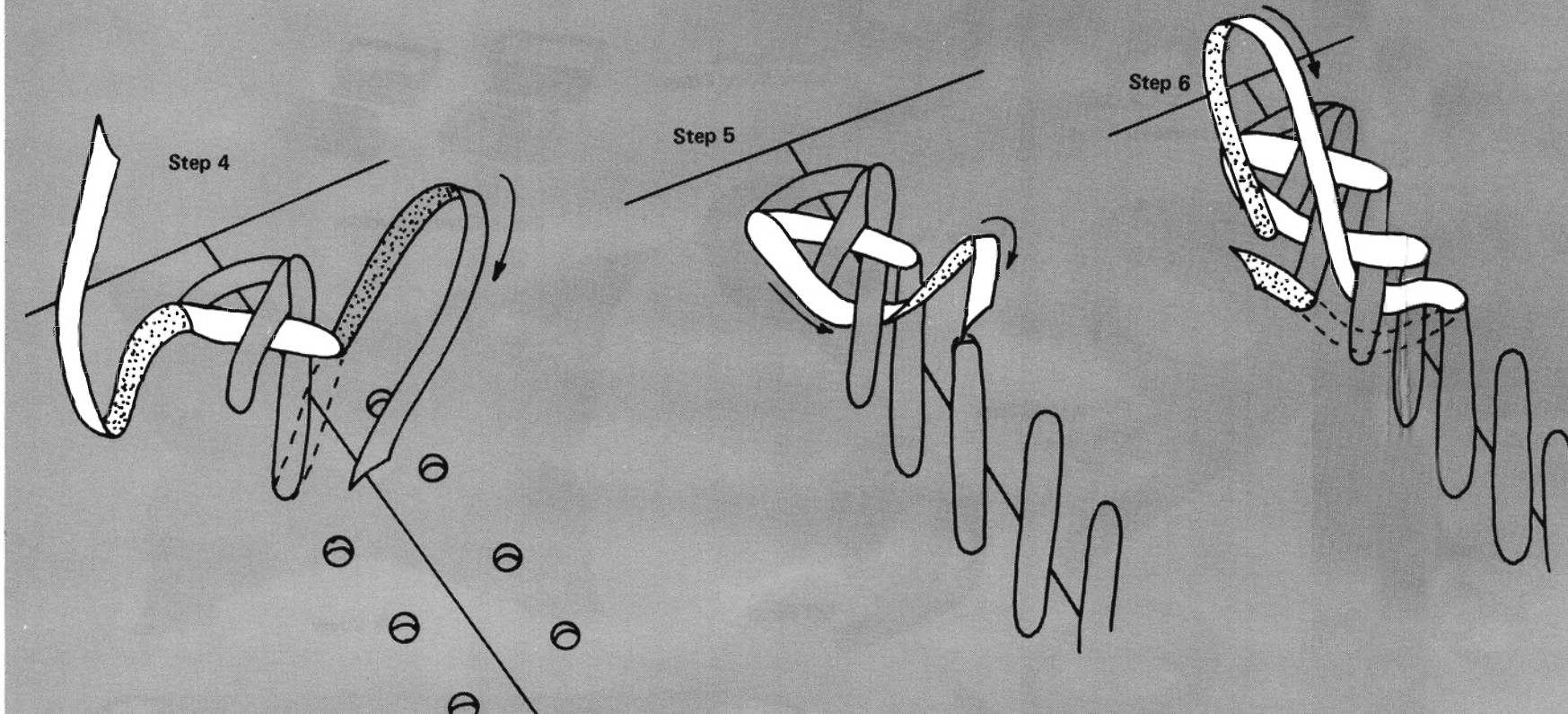
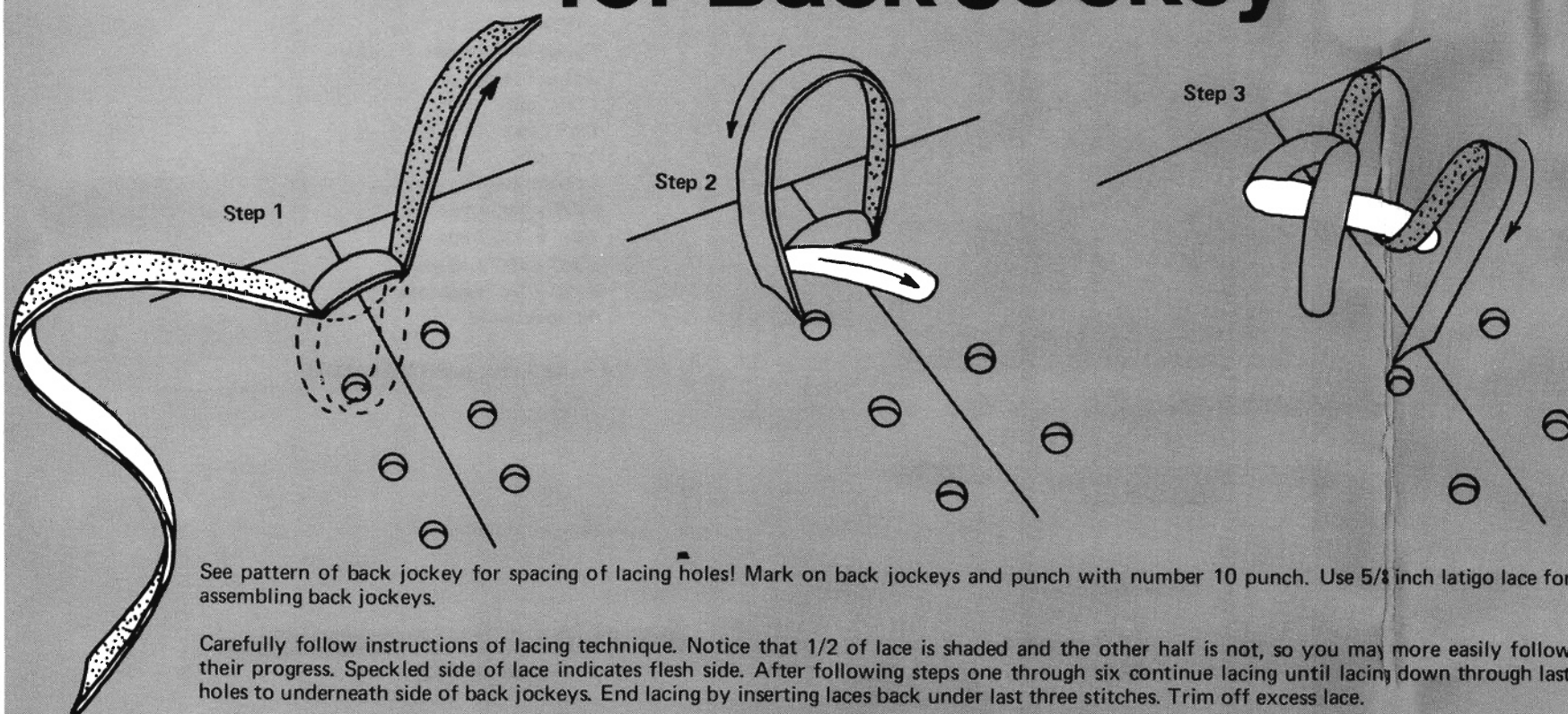
Step 5. Hold needle and pull thread over eye to lock end of thread.



Step 6. Wax end to "fuse" threads together. Thread is ready for sewing.

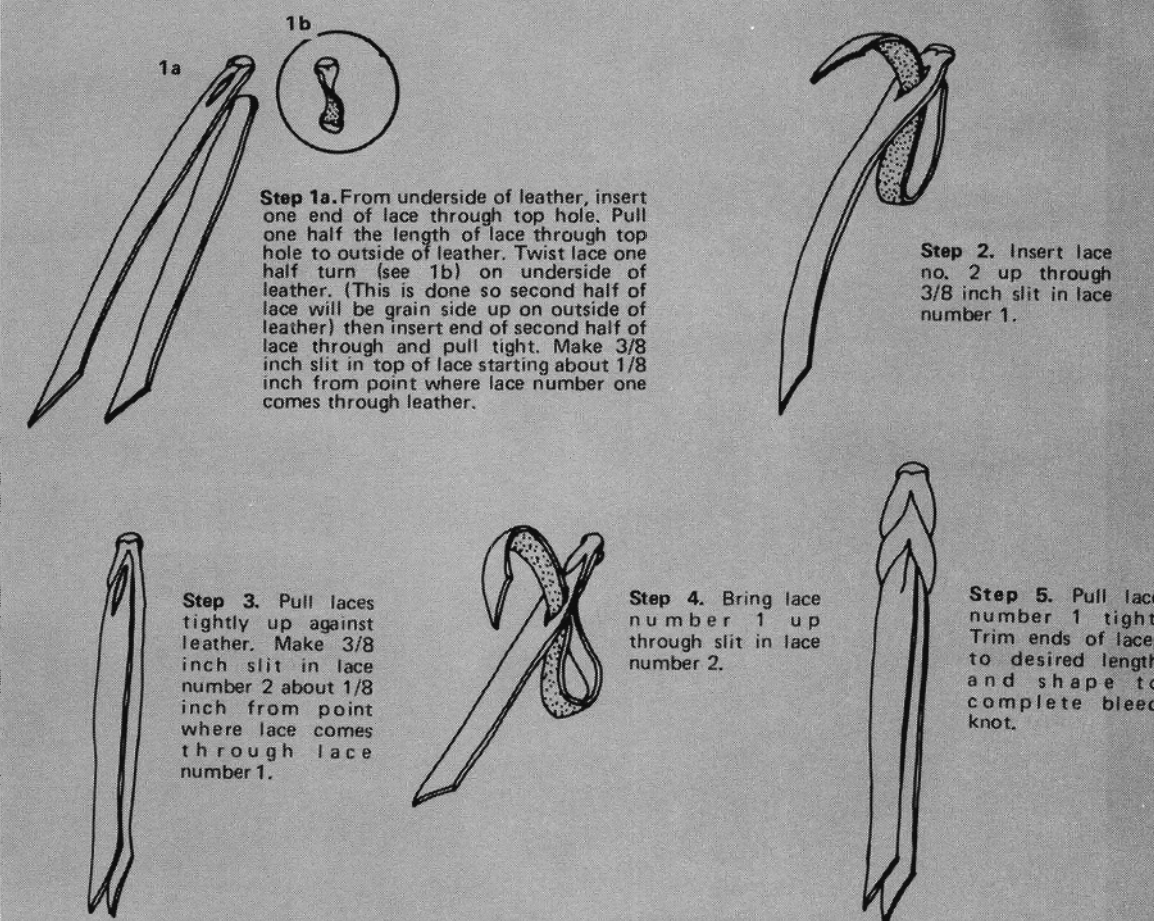


Lacing Instructions for Back Jockey

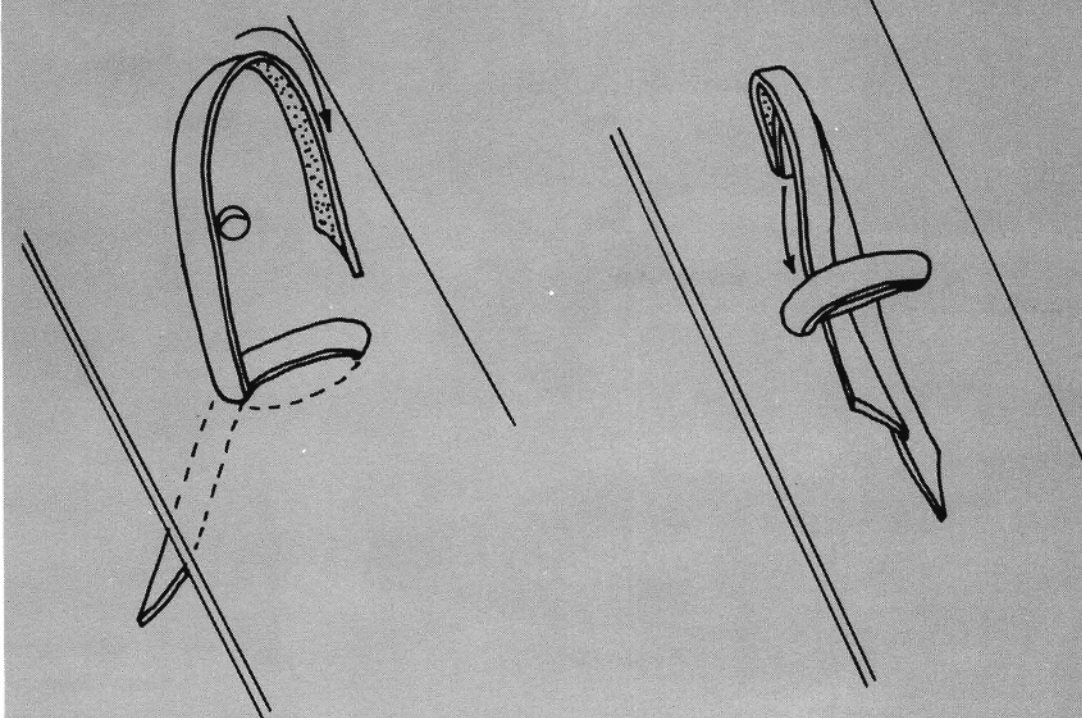


Do All Carving and Tooling Before Assembly

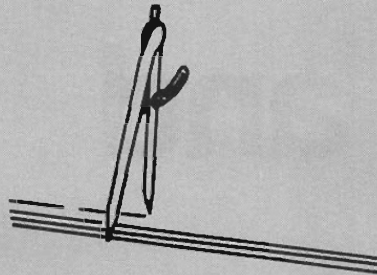
Bleed Knot



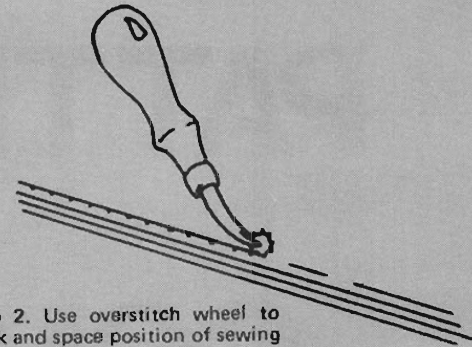
3 Hole Knot



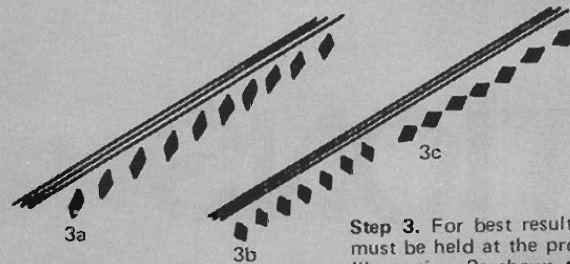
Hand Sewing Instructions



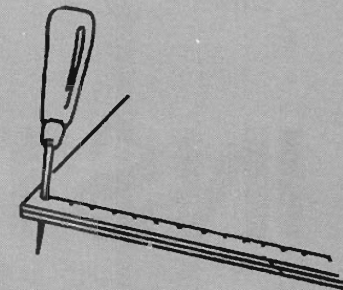
Step 1. Adjust compass to mark leather about 3/16" from edge of leather.



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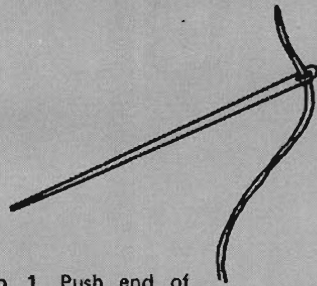


Step 3. For best results, the awl must be held at the proper angle. Illustration 3a shows the correct angle of holes. If holes are like 3b, awl marks will show after stitching. If holes are like 3c, thread will tear through holes if not already cut through.

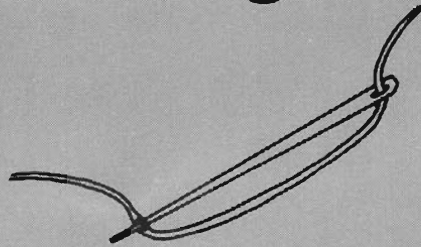


Step 4. Stab awl through first hole at proper angle. Thread the needle. (See threading the needle instructions.)

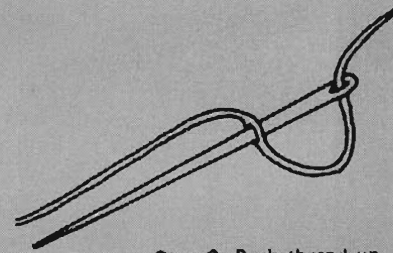
Threading the Needle



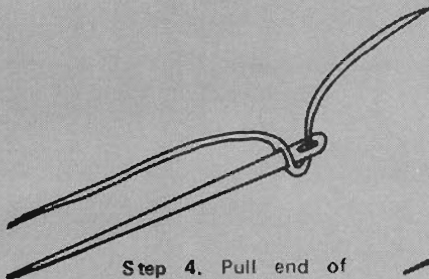
Step 1. Push end of thread through needle of eye about 1/2".



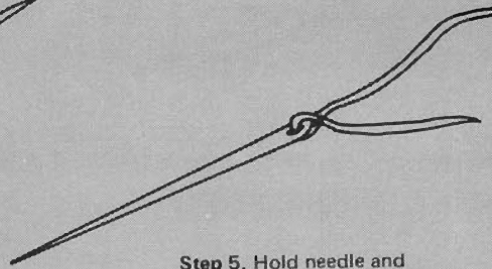
Step 2. Pierce thread with needle point as shown.



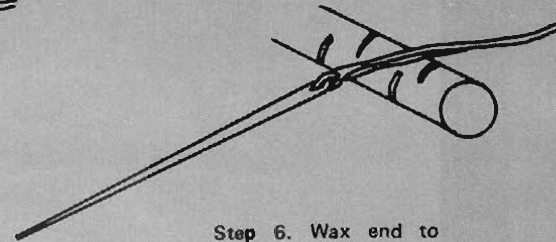
Step 3. Push thread up on needle to eye.



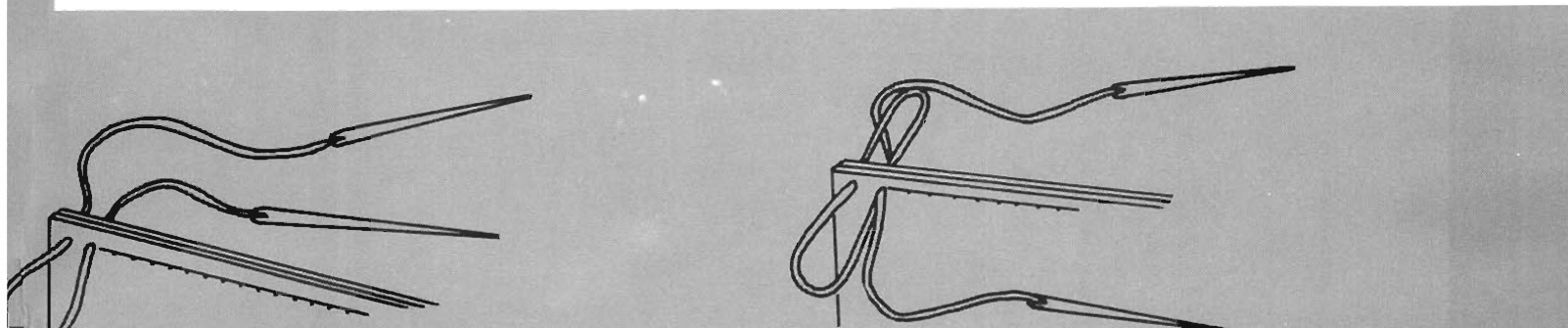
Step 4. Pull end of thread through eye as far as it will go.

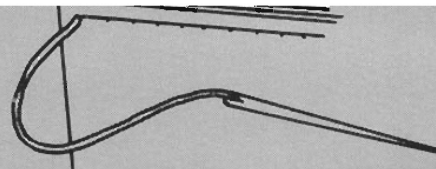


Step 5. Hold needle and pull thread over eye to lock end of thread.

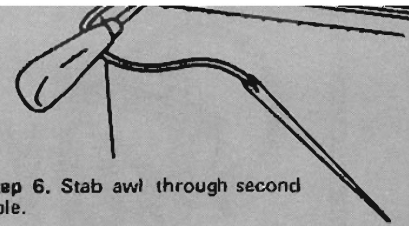


Step 6. Wax end to "fuse" threads together. Thread is ready for sewing.

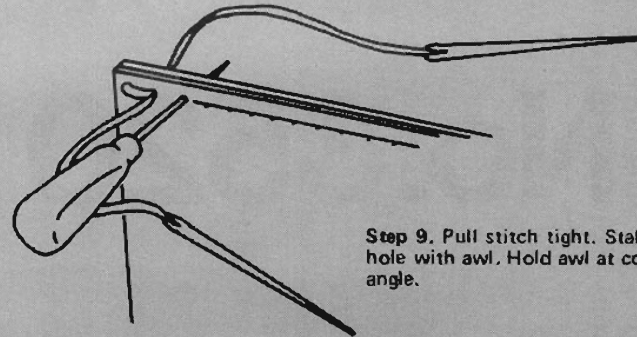




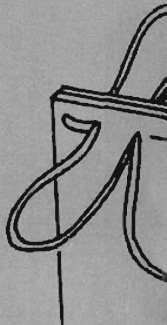
Step 5. Push one needle through first hole and pull to center of thread.



Step 6. Stab awl through second hole.

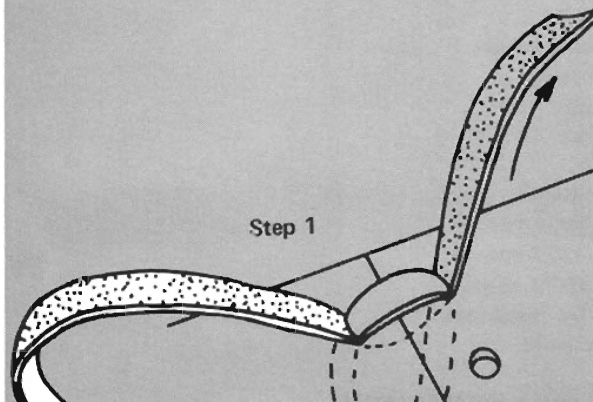


Step 9. Pull stitch tight. Stab 3rd hole with awl. Hold awl at correct angle.

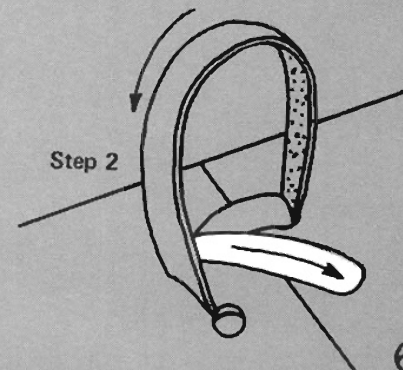


Step 10. Insert side thread needle from same hole.

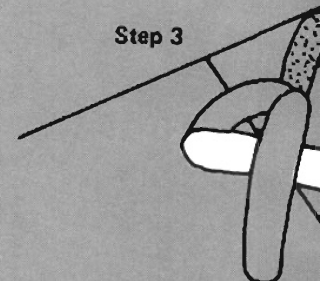
Lacing Instructions for Back Jockey



Step 1



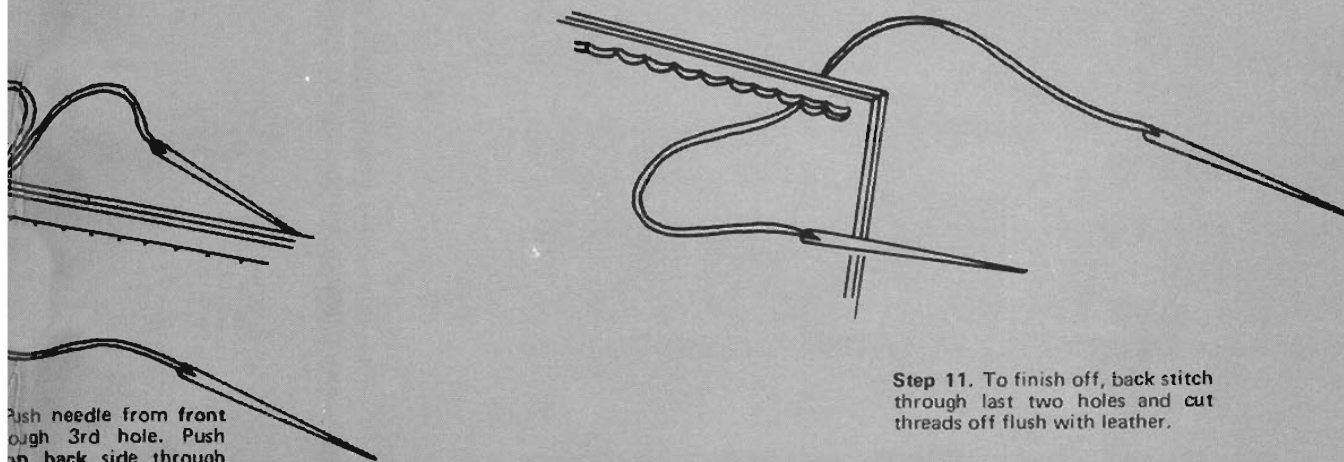
Step 2



Step 3

Step 7. Push needle from front side through second hole.

Step 8. Push needle from back side through same hole. Use care not to puncture thread with 2nd needle.



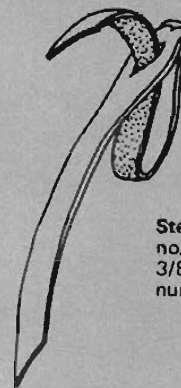
Push needle from front side through 3rd hole. Push on back side through and pull stitch tight.

Step 11. To finish off, back stitch through last two holes and cut threads off flush with leather.

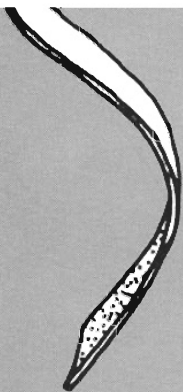
Bleed Knot



Step 1a. From underside of leather, insert one end of lace through top hole. Pull one half the length of lace through top hole to outside of leather. Twist lace one half turn (see 1b) on underside of leather. (This is done so second half of lace will be grain side up on outside of leather) then insert end of second half of lace through and pull tight. Make 3/8 inch slit in top of lace starting about 1/8 inch from point where lace number one comes through leather.

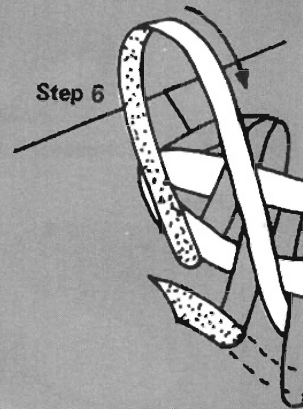
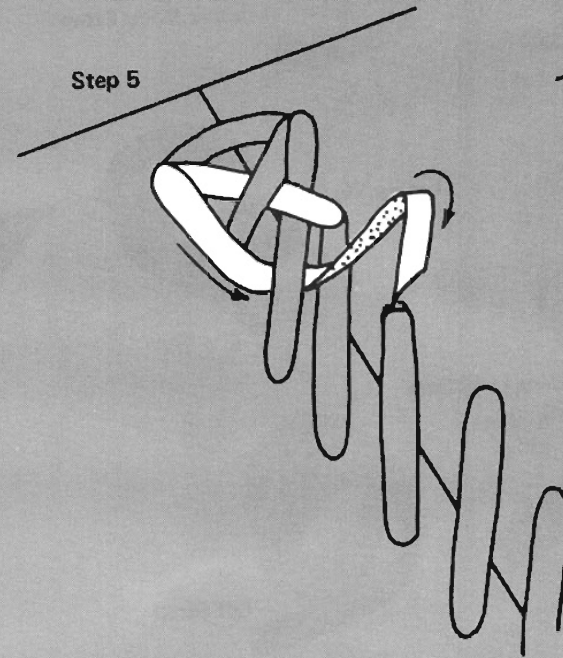
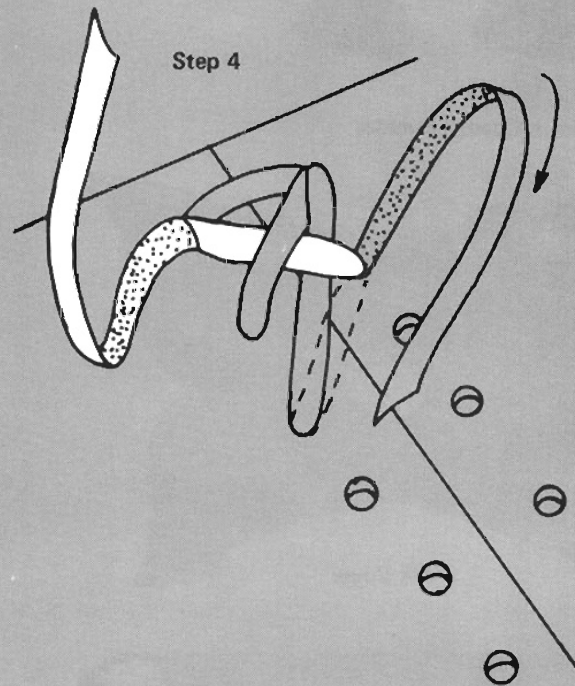


Step 2. Insert lace no. 2 up through 3/8 inch slit in lace number 1.

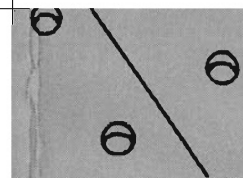


See pattern of back jockey for spacing of lacing holes! Mark on back jockeys and punch with number 10 punch. Use 5 assembling back jockeys.

Carefully follow instructions of lacing technique. Notice that 1/2 of lace is shaded and the other half is not, so you may track their progress. Speckled side of lace indicates flesh side. After following steps one through six continue lacing until lacing holes to underneath side of back jockeys. End lacing by inserting laces back under last three stitches. Trim off excess lace.

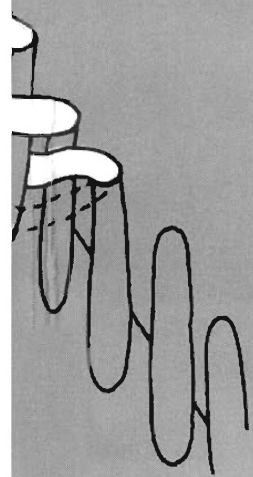


Do All Carving and Tooling Before Ass



3/8 inch latigo lace for

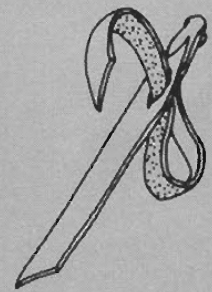
ay more easily follow
ing down through last



sembly



Step 3. Pull laces tightly up against leather. Make 3/8 inch slit in lace number 2 about 1/8 inch from point where lace comes through lace number 1.

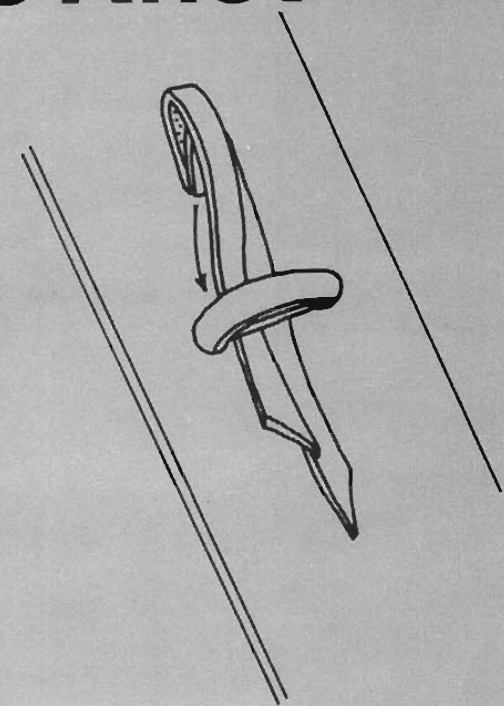
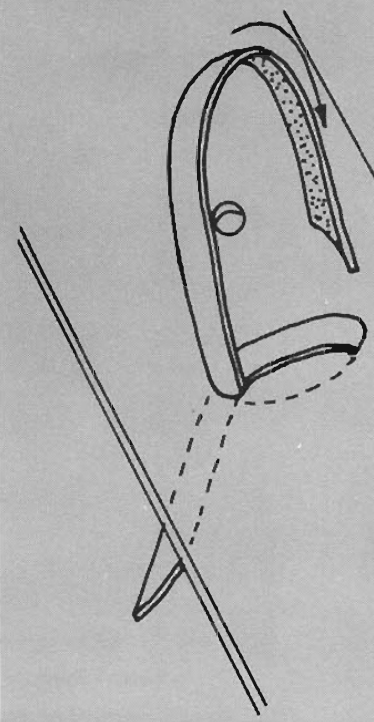


Step 4. Bring lace number 1 up through slit in lace number 2.



Step 5. Pull lace number 1 tight. Trim ends of laces to desired length and shape to complete bleed knot.

3 Hole Knot



I

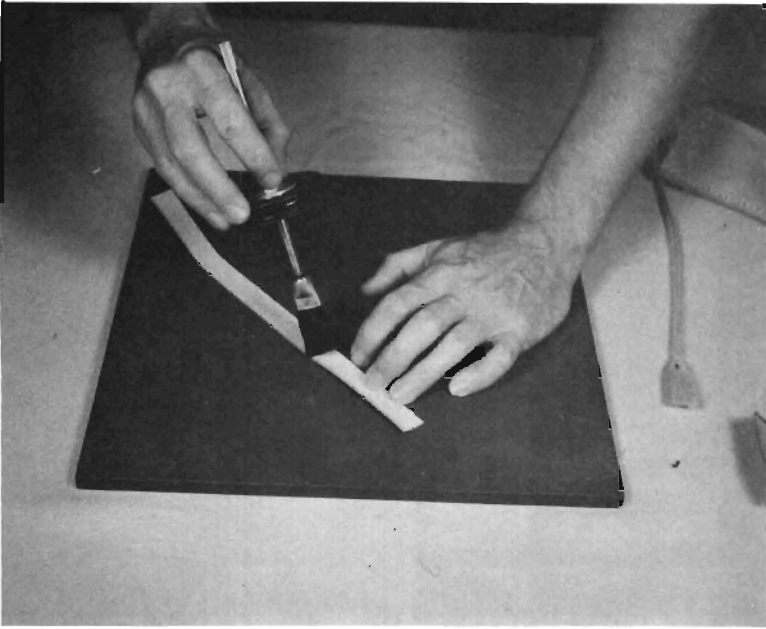
Sewing Beading Strip to Fork Cover

Note: Beading strips are sewn in with fork cover wrong side out.

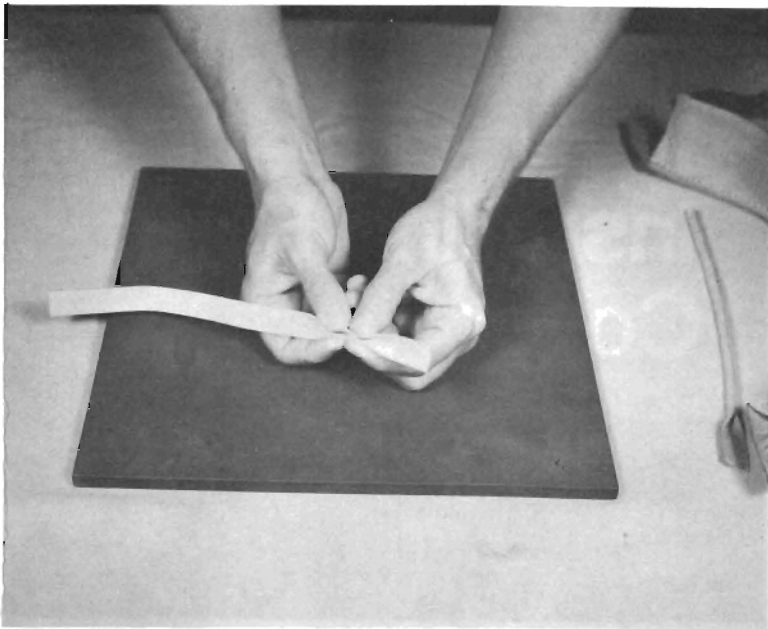
Read general instructions on page 7 before assembling saddle.

Carve and dye saddle parts before assembling.

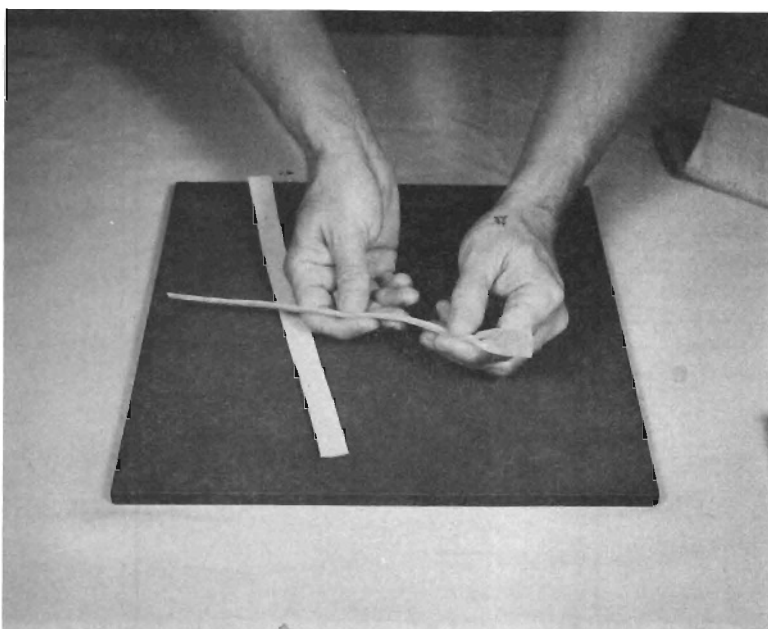
Edge and burnish all exposed edges of saddle before assembling.



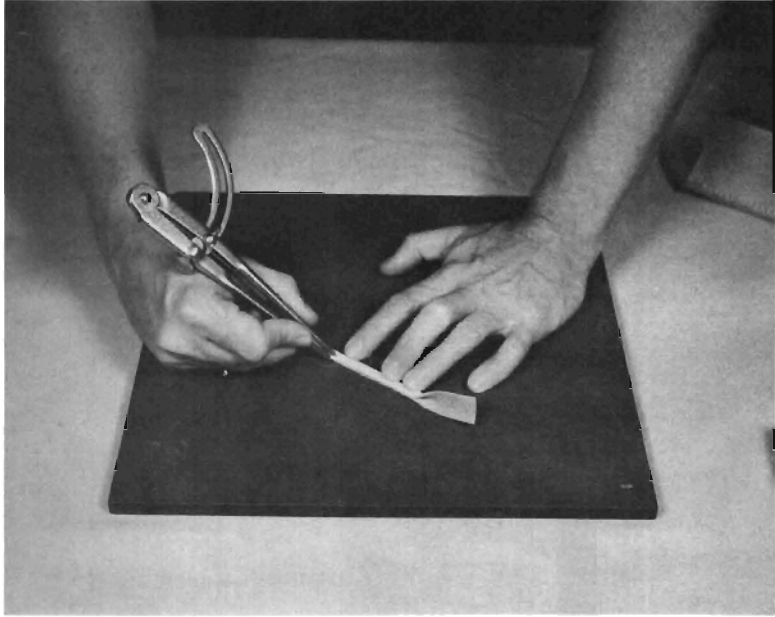
Step 1. Apply cement to flesh sides of beading strips starting about 1" from end of strip.



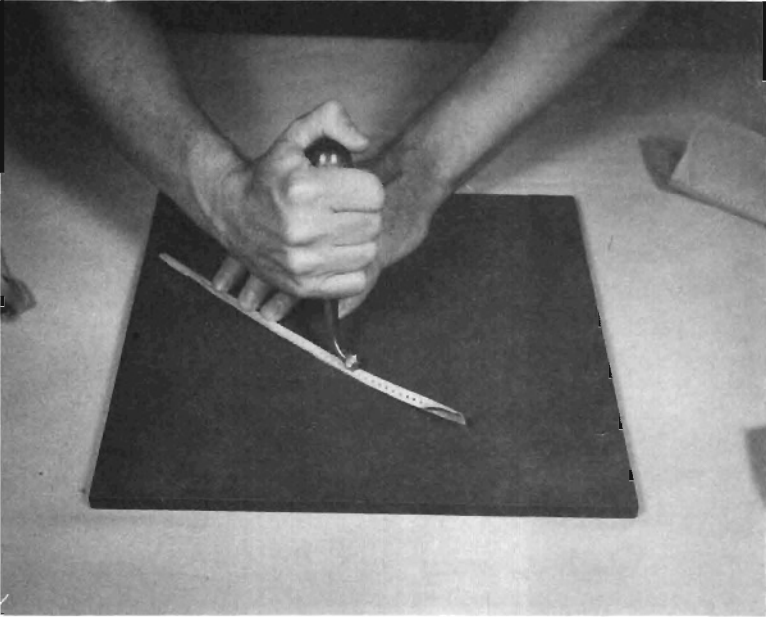
Step 2. When cement becomes tacky, fold beading strip in half (flesh side to flesh side).



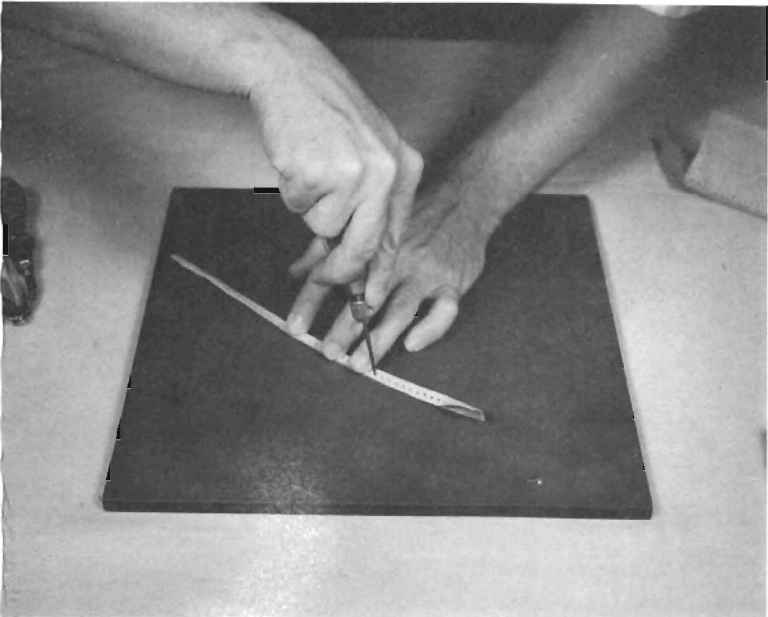
Step 3. The part of strip not cemented will remain flat.



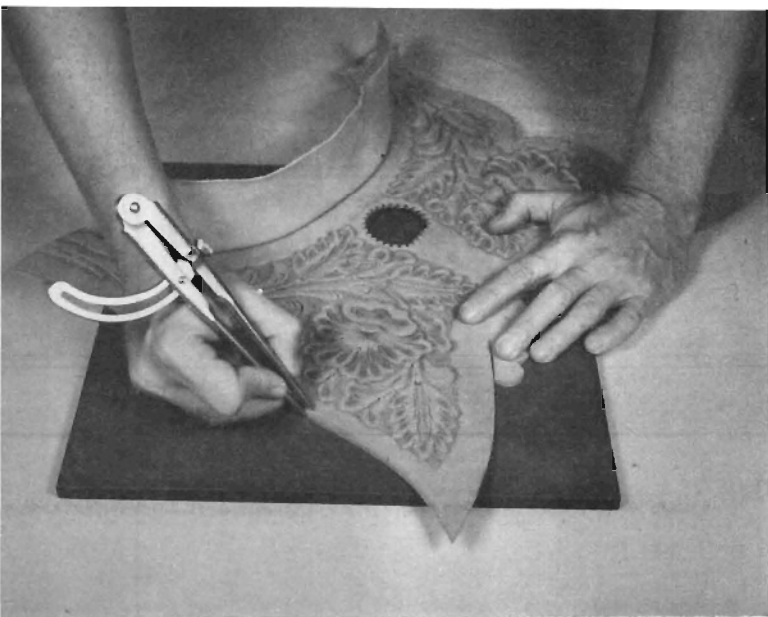
Step 4. Scribe line, with compass, about half way between folded edge and the cemented edges (on folded part only).



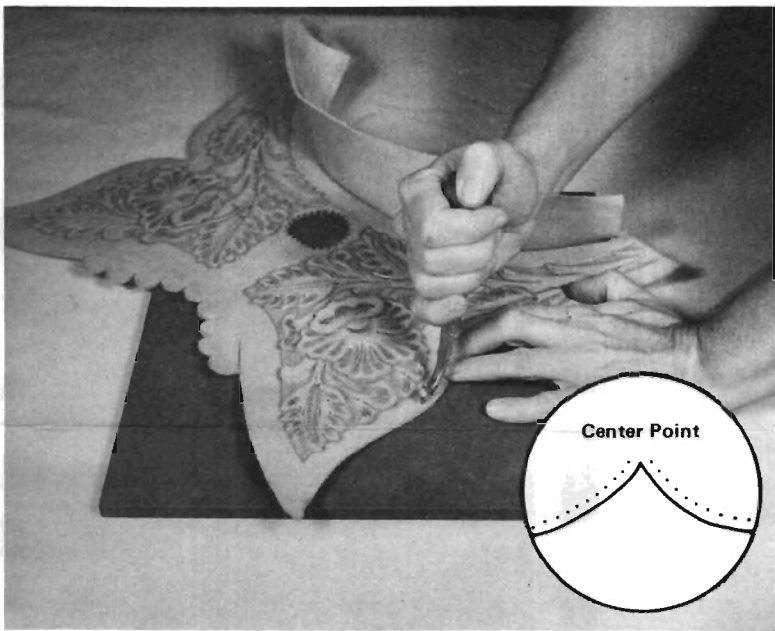
Step 5. Using #5 Craftool spacer (or overstretch) mark stitching holes along scribed line on folded part of beading strip.



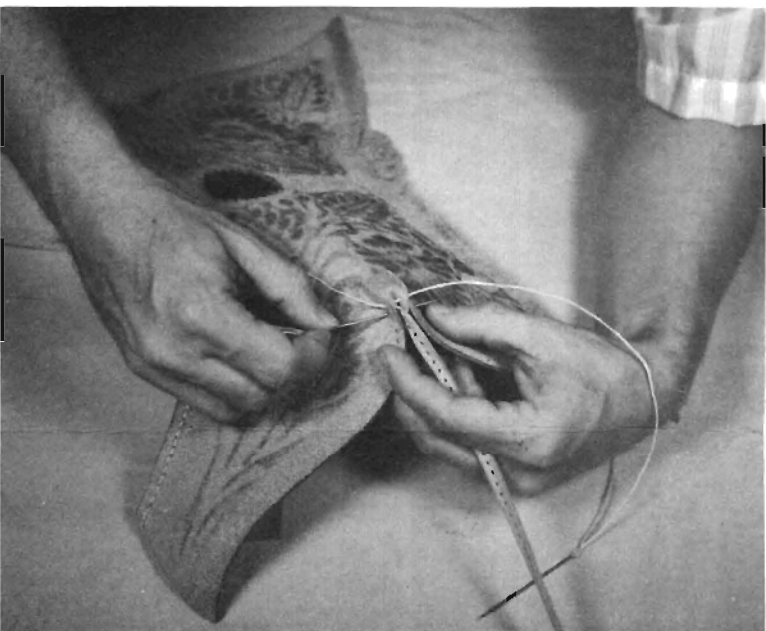
Step 6. Using stitching awl or #0 punch, punch stitching holes on folded part of beading strip.



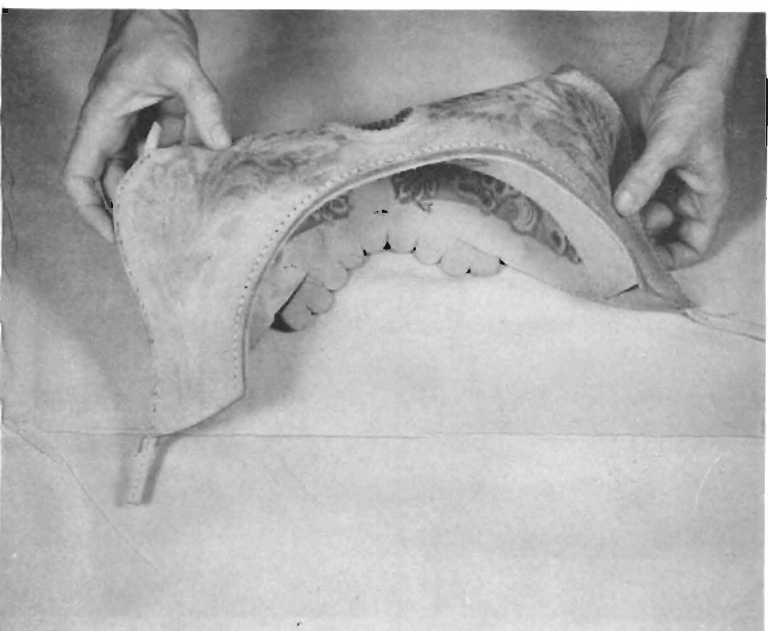
Step 7. With compass scribe line (1/4" from edge) along left and right side of fork cover.



Step 8. Starting on grain side, about 1/8" from center point on side of fork cover (see illustration), mark stitching holes with Craftool #5 spacer or overstretch down front and back edge. With awl or #0 punch, punch stitching holes. Mark and punch right and left sides.



Step 9. Fold fork cover at center point on side (flesh sides out) and place bead strip (folded edge inward) between, aligning top stitching holes. Begin stitching in the top holes and continue down side, aligning holes in fork cover and bead strip as you go.



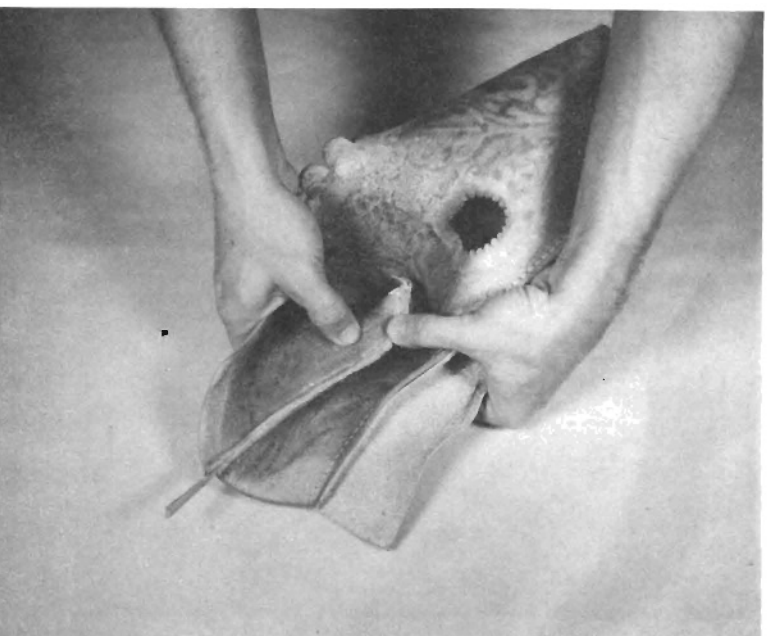
Step 10. Fork will look like this when beading strips on both sides have been sewn in. Trim ends of beading strips off at bottom of fork cover and cement flat part of beading strips to fork cover.

II

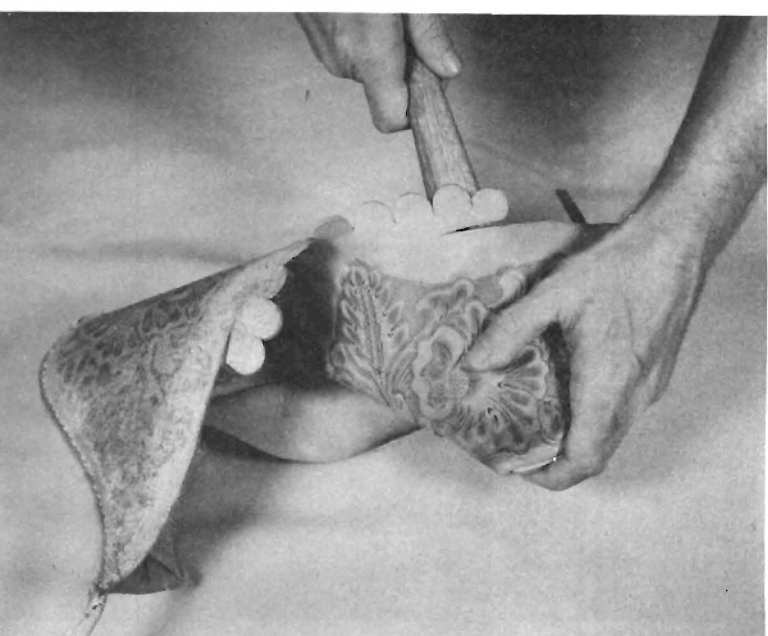
Turning Fork Cover and Fork Binder



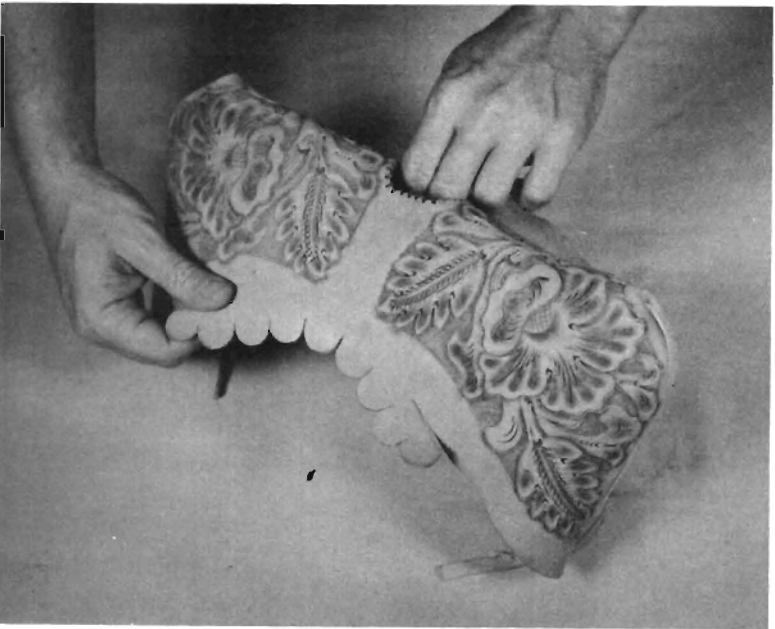
Step 11. Dampen flesh side of fork cover with sponge before turning grain side out. Do not apply so much moisture that it soaks through to grain side.



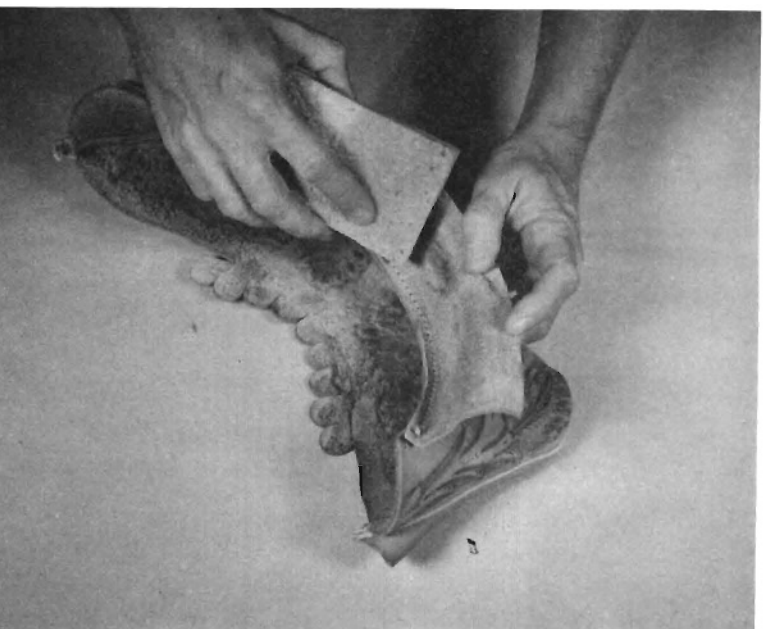
Step 12. Beginning at one corner, turn fork cover grain side out.



Step 13. Use handle of hammer or mallet to push corner out from flesh side.



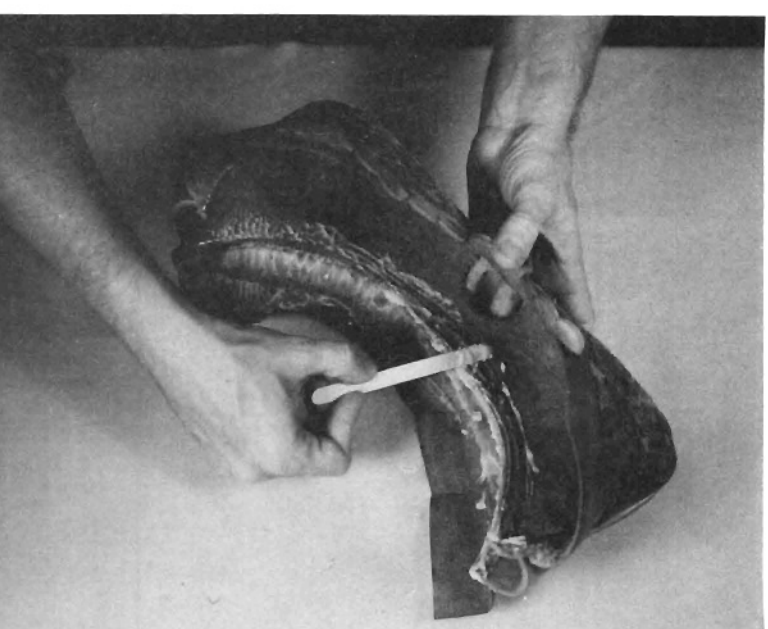
Step 14. Fork cover will look this way when "turned".



Step 15. Dampen fork binder.



Step 16. Roll under to flesh side of fork cover making a small tight roll. Edge of roll may have to be cut so it will lie flat with no wrinkles. Cautions: do not clip edge too far or it will show after fork cover is installed.



Step 17. After you have fitted binder apply paste to flesh side of binder and roll into place smoothing out all wrinkles.

Mix Dexterine Paste with water to make heavy paste.

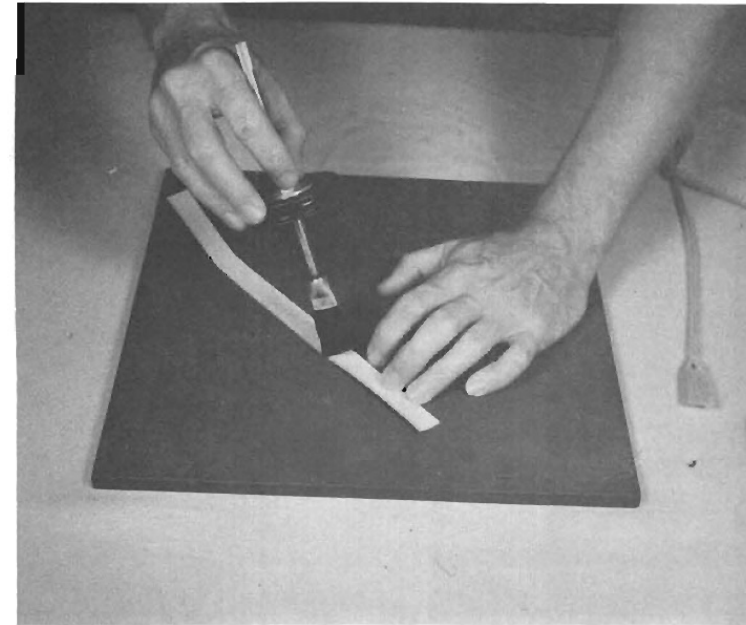
I Sewing Beading Strip to Fork Cover

Note: Beading strips are sewn in with fork cover wrong side out.

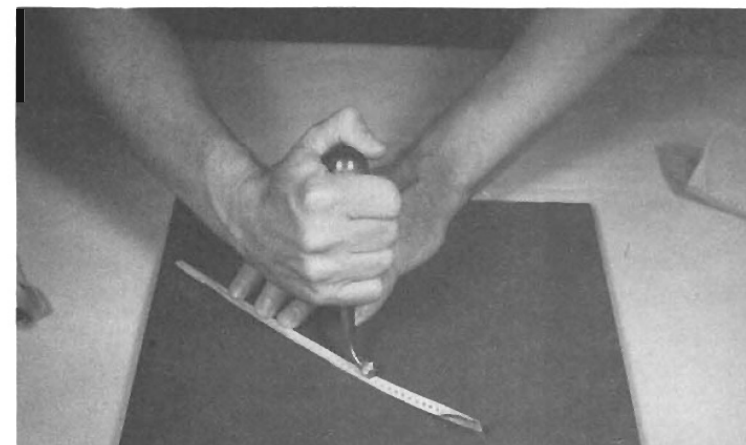
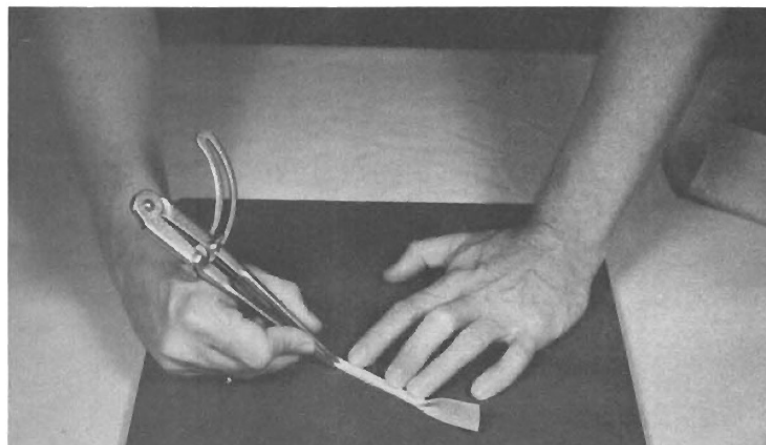
Read general instructions on page 7 before assembling saddle.

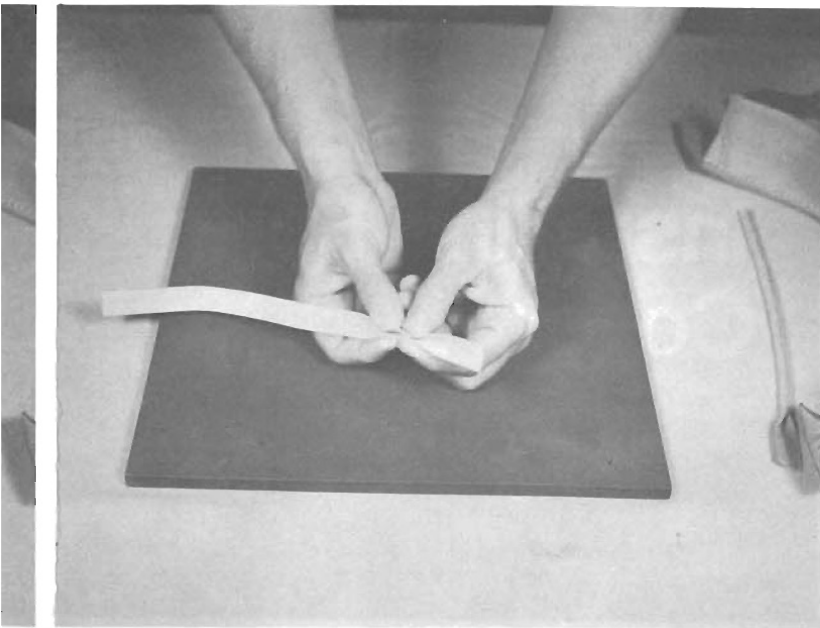
Carve and dye saddle parts before assembling.

Edge and burnish all exposed edges of saddle before assembling.

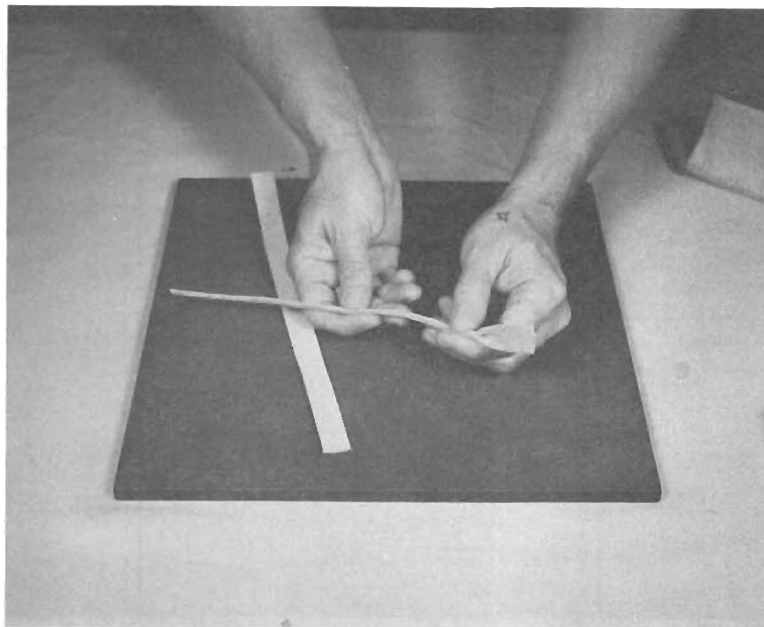


Step 1. Apply cement to flesh sides of beading strips starting about 1" from end of strip.

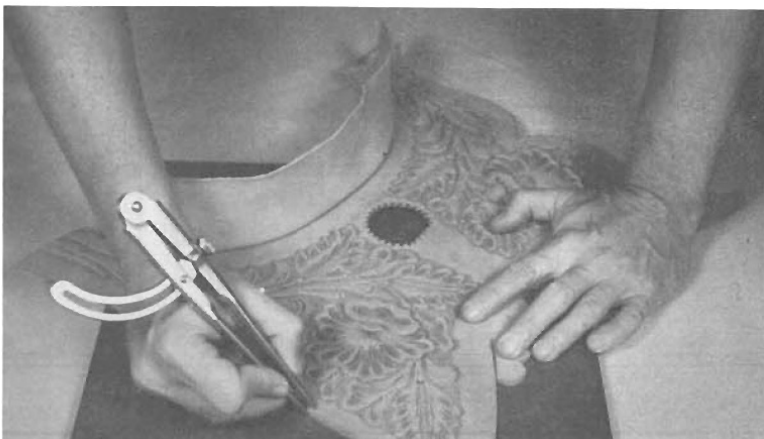
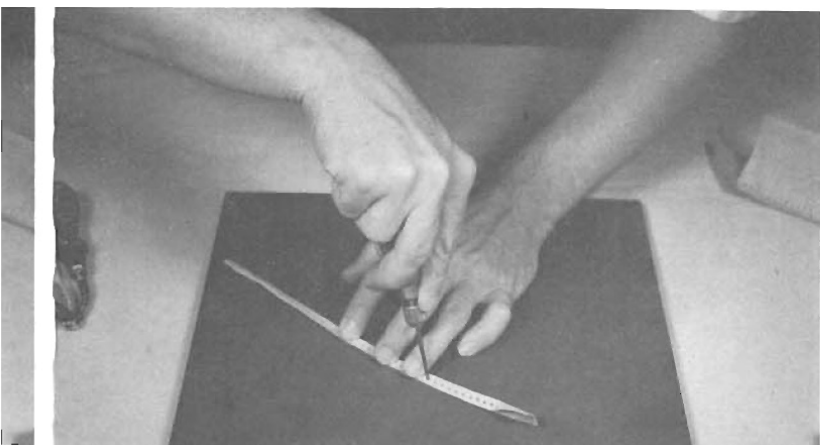


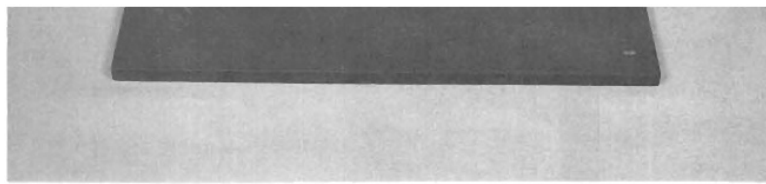


Step 2. When cement becomes tacky, fold beading strip in half (flesh side to flesh side).

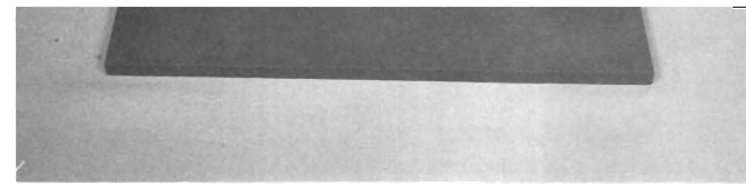


Step 3. The part of strip not cemented will remain flat.

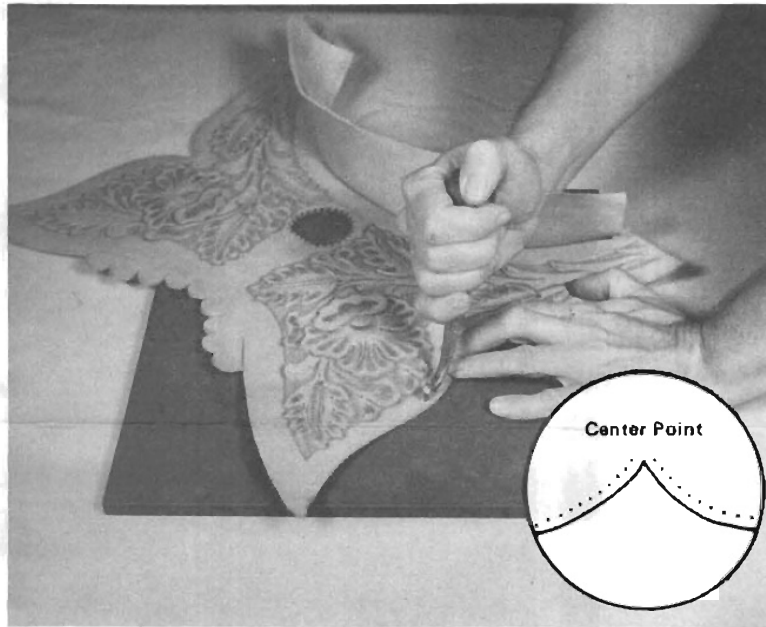




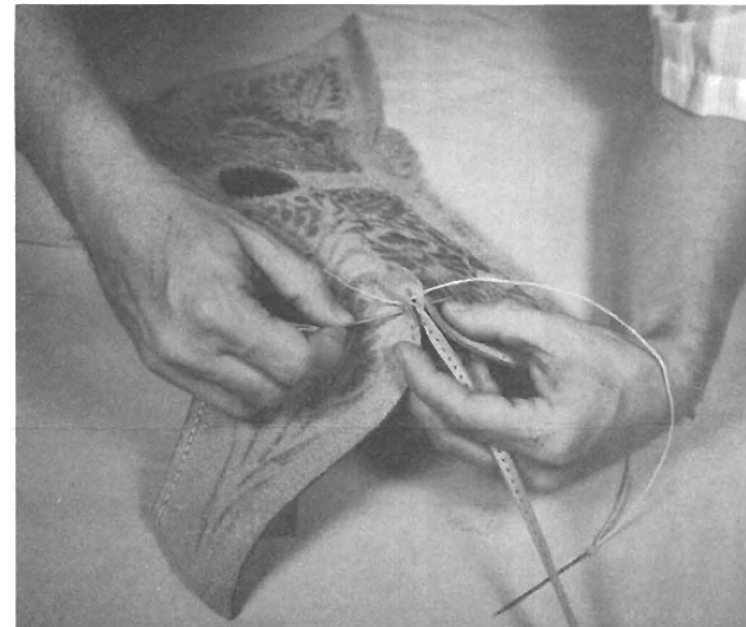
Step 4. Scribe line, with compass, about half way between folded edge and the cemented edges (on folded part only).



Step 5. Using #5 Craftool spacer (or overstitch) mark stitching holes along scribed line on folded part of beading strip.



Step 8. Starting on grain side, about 1/8" from center point on side of fork cover (see illustration), mark stitching holes with Craftool #5 spacer or overstitch down front and back edge. With awl or #0 punch, punch stitching holes. Mark and punch right and left sides.



Step 9. Fold fork cover at center point on side (flesh sides out) and place bead strip (folded edge inward) between, aligning top stitching holes. Begin stitching in the top holes and continue down side, aligning holes in fork cover and bead strip as you go.

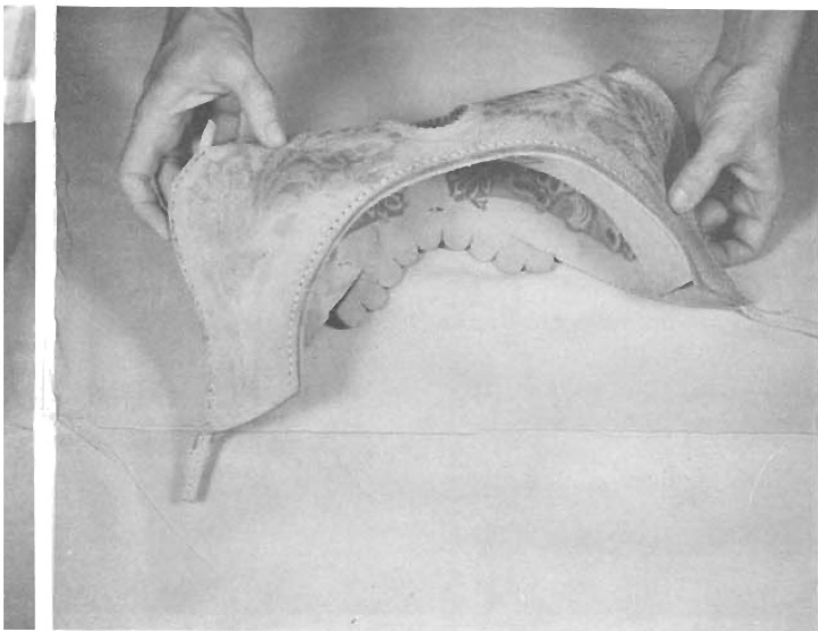




Step 6. Using stitching awl or #0 punch, punch stitching holes on folded part of beading strip.



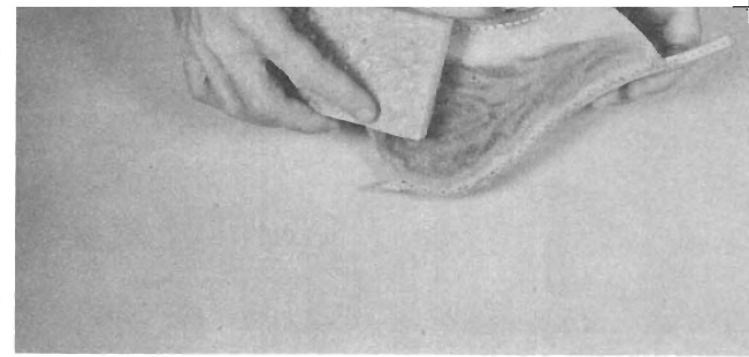
Step 7. With compass scribe line (1/4" from edge) along left and right side of fork cover.



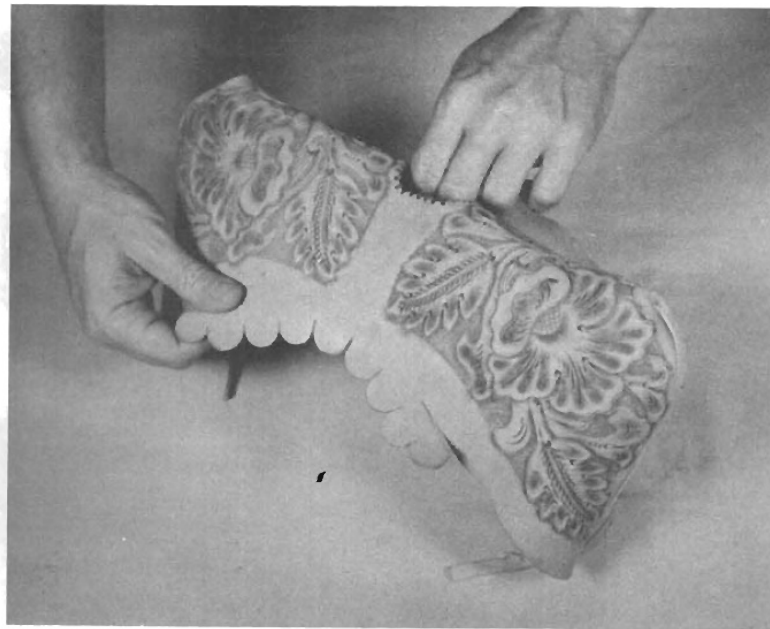
Step 10. Fork will look like this when beading strips on both sides have been sewn in. Trim ends of beading strips off at bottom of fork cover and cement flat part of beading strips to fork cover.



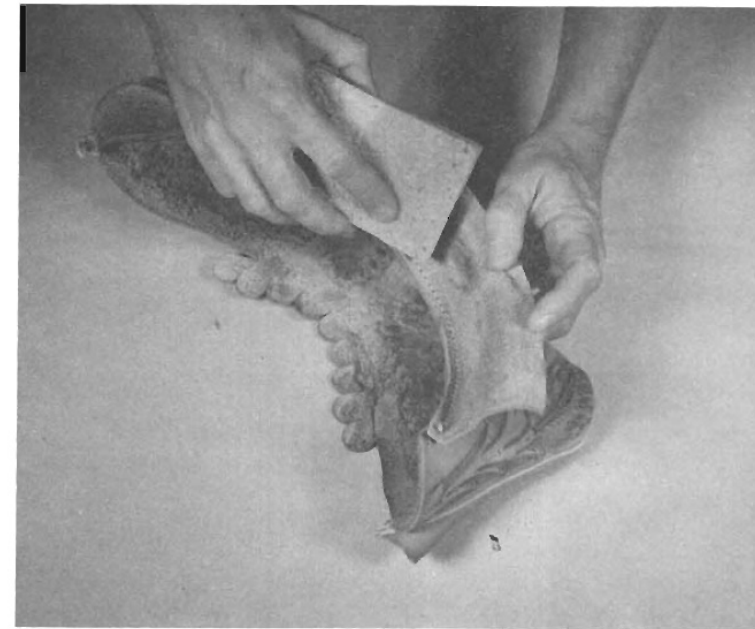
Cover and Fork Binder



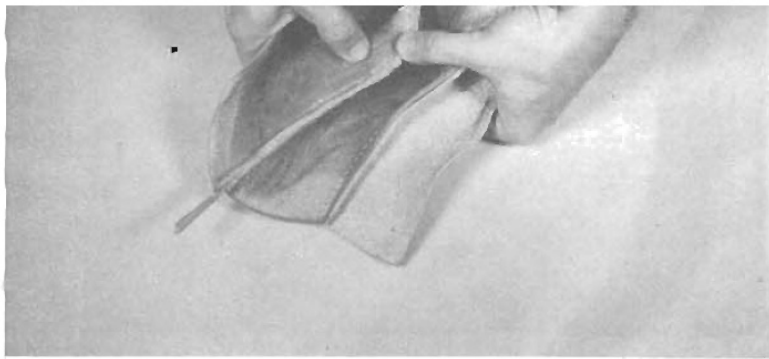
Step 11. Dampen flesh side of fork cover before turning grain side out. Do not apply so much moisture that it soaks through to grain side.



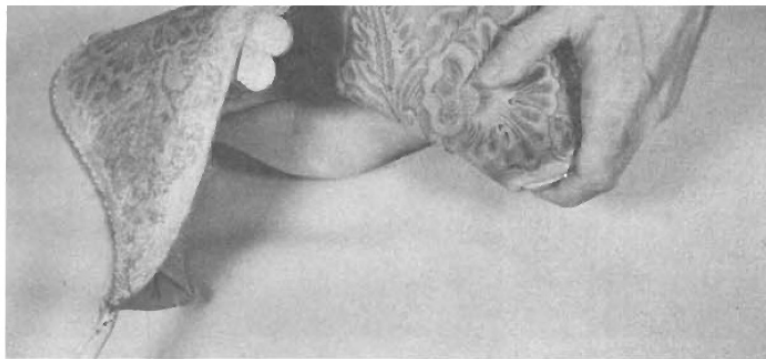
Step 14. Fork cover will look this way when "turned".



Step 15. Dampen fork binder.



Step 12. Beginning at one corner, turn fork cover grain side out.



Step 13. Use handle of hammer or mallet to push corner out from flesh side.



Step 16. Roll under to flesh side of fork cover making a small tight roll. Edge of roll may have to be cut so it will lie flat with no wrinkles. **Cautions:** do not clip edge too far or it will show after fork cover is installed.



Step 17. After you have fitted binder apply paste to flesh side of binder and roll into place smoothing out all wrinkles.

Mix Dexterine Paste with water to make heavy paste.



Step 18. Fork binder will appear this way when completed.

III Installing Fork Cover



Step 19. Lightly dampen grain side of fork cover. Using a side to side motion pull fork cover over horn.



Step 20. Holding corners of fork cover up, apply paste liberally to swells and fork area, especially to point of swells. This will fill area around swells so they will be smooth and firm.



Step 21. Pull both sides of fork cover down over tree and smooth into place so there are no wrinkles. Use your hand to smooth leather into place or use saddlers awl (or phillips head screwdriver) to drive in at base of cover and pull into place.



Step 22. After pulling fork cover as smooth and tight against tree as possible, drive first tack (1 1/8" long) close to side seam at base of fork cover. Be sure tacks are low enough so they will be hidden. Drive second tack at front, at base of binder. Drive third tack between first and second at base of fork cover. Drive 3 tacks in similar manner behind side seam. Secure other side of fork cover in same manner.



Step 23. Pull scalloped end of fork cover tightly under tree to gullet and tack.

IV Installing Seat [Cantle]



Step 24. Thoroughly dampen back of seat.



Step 25. Apply paste to back of seat and to back and front of cantle.



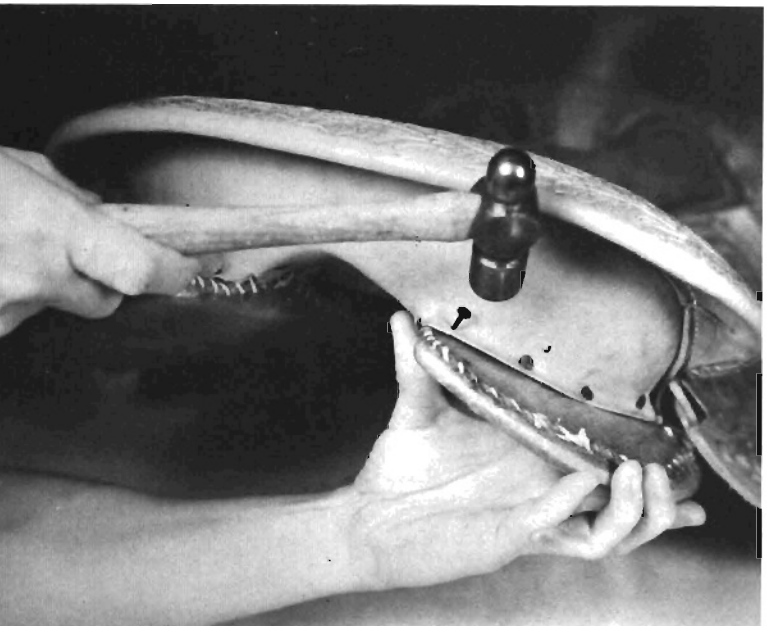
Step 26. Pull seat over cantle.



Step 27. Push seat firmly against cantle smoothing leather tightly under "dish" of cantle.



Step 28. Pull leather (on back cantle) tightly and firmly under cantle and tack into place. Using 1/8" tacks.



Step 29. Pull leather at base of back cantle down firmly and tack into place.



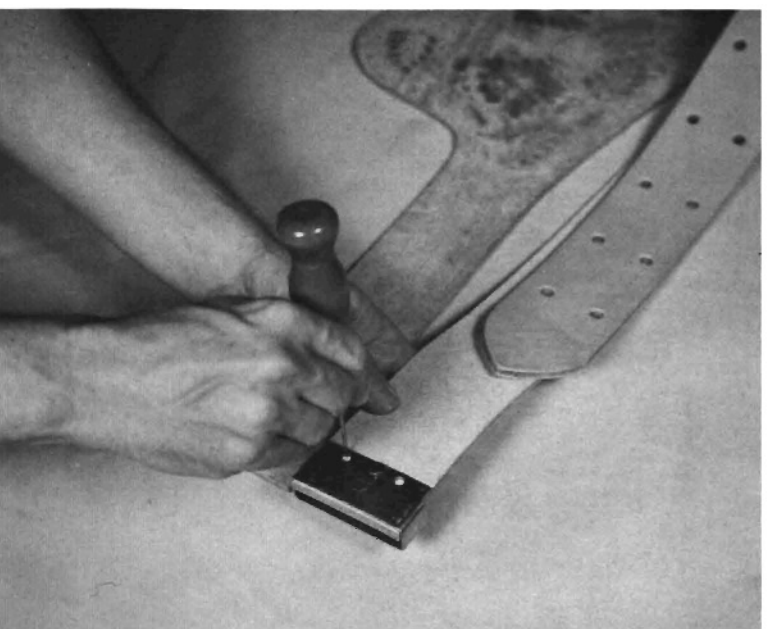
Step 30. Pull ends of cantle binder forward (with pliers or saddlers awl) and tack into place (use 2-1 1/8" tacks) on bar at the base of cantle. Be sure seat is centered.



Step 31. Trim ends of cantle binder off.

V Attach Stirrup Leather to Fenders

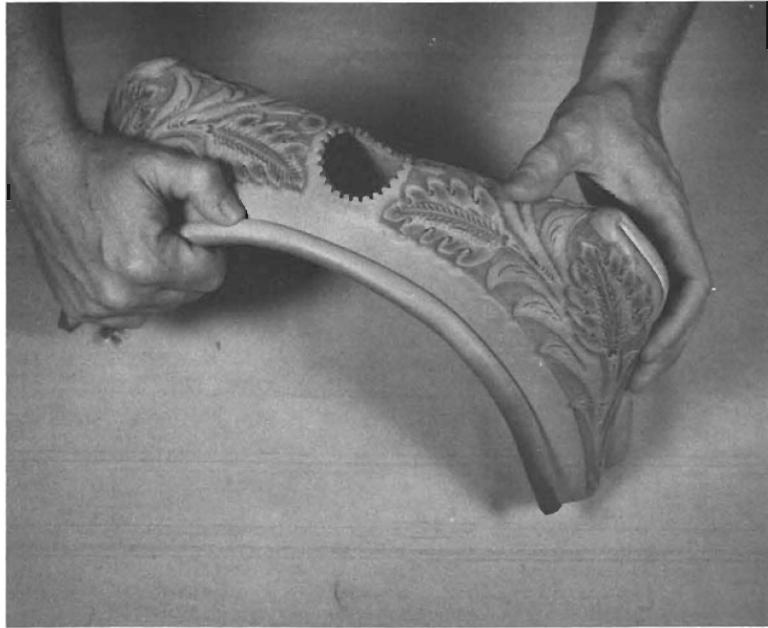
Fabricate stirrup leathers. See page 16.



Step 32. Place squared end of stirrup leather, flesh side up, on table. Slide stirrup leather buckle on squared end as shown, aligning end of buckle and end of leather. Mark the two rivet holes.



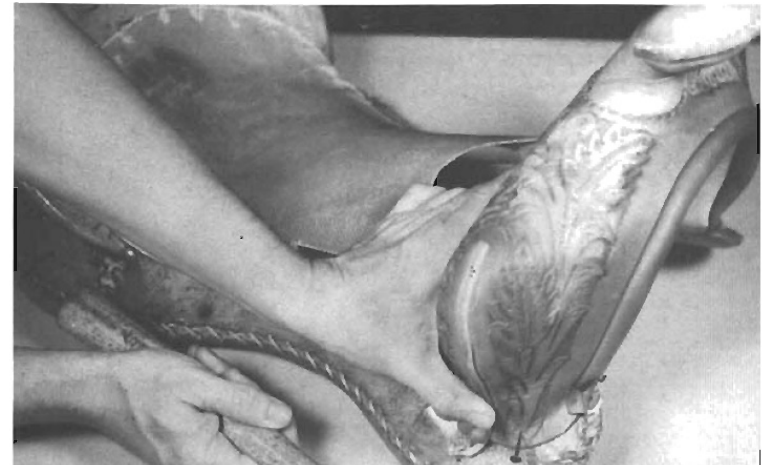
Step 33. Punch rivet holes with #5 punch.

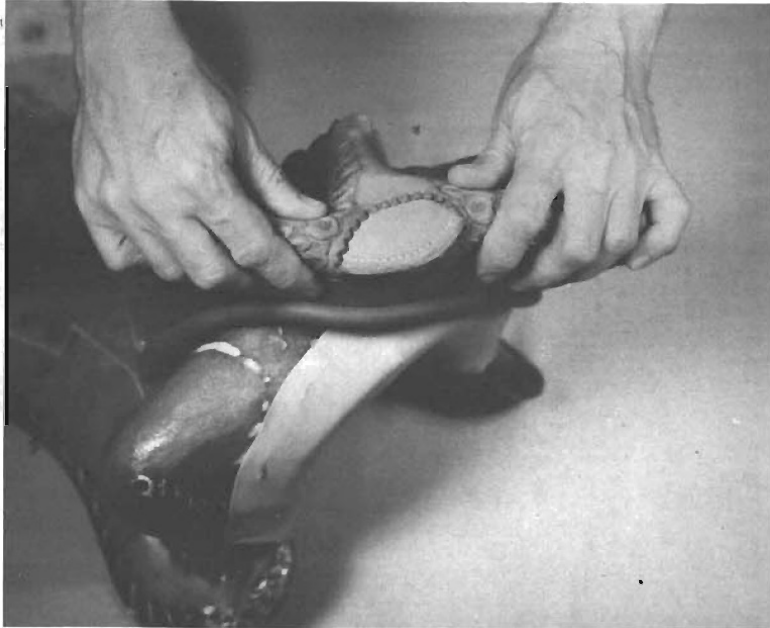


III

Installing Fork Cover

Step 18. Fork binder will appear this way when completed.





Step 19. Lightly dampen grain side of fork cover. Using a side to side motion pull fork cover over horn.



Step 20. Holding corners of fork cover up, apply paste liberally to swells and fork area, especially to point of swells. This will fill area around swells so they will be smooth and firm.





Step 21. Pull both sides of fork cover down over tree and smooth into place so there are no wrinkles. Use your hand to smooth leather into place or use saddlers awl (or phillips head screwdriver) to drive in at base of cover and pull into place.



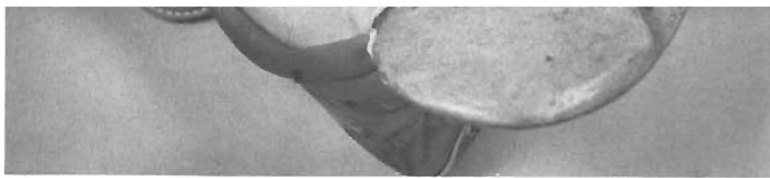
Step 22. After pulling fork cover as smooth and tight against tree as possible, drive first tack (1 1/8" long) close to side seam at base of fork cover. Be sure tacks are low enough so they will be hidden. Drive second tack at front, at base of binder. Drive third tack between first and second at base of fork cover. Drive 3 tacks in similar manner behind side seam. Secure other side of fork cover in same manner.

IV Installing Seat (Cantle)



Step 24. Thoroughly dampen back of seat.





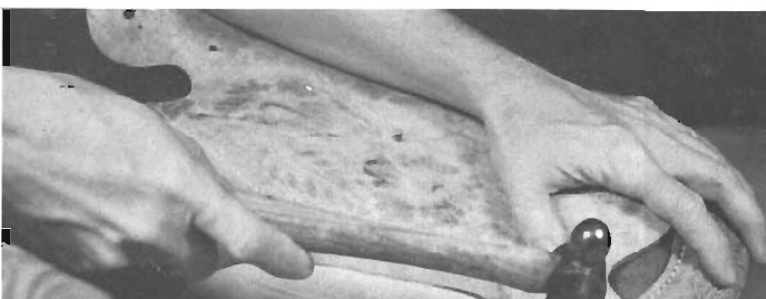
Step 23. Pull scalloped end of fork cover tightly under tree to gullet and tack.



Step 25. Apply paste to back of seat and to back and front of cantle.



Step 26. Pull seat over cantle.





Step 27. Push seat firmly against cantle smoothing leather tightly under "dish" of cantle.



Step 28. Pull leather (on back cantle) tightly and firmly under cantle and tack into place. Using 1/8" tacks.



Step 31. Trim ends of cantle binder off.

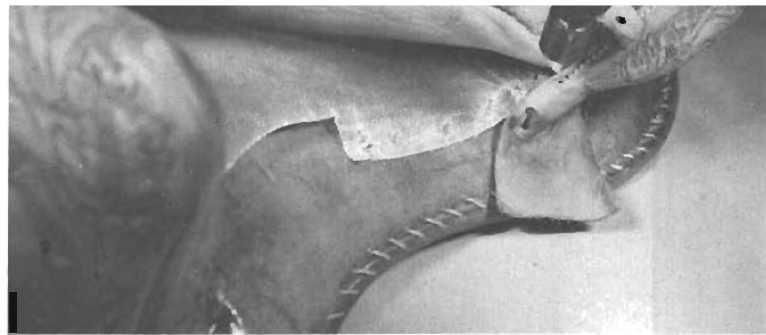
V

Attach Stirrup Leather to Fenders

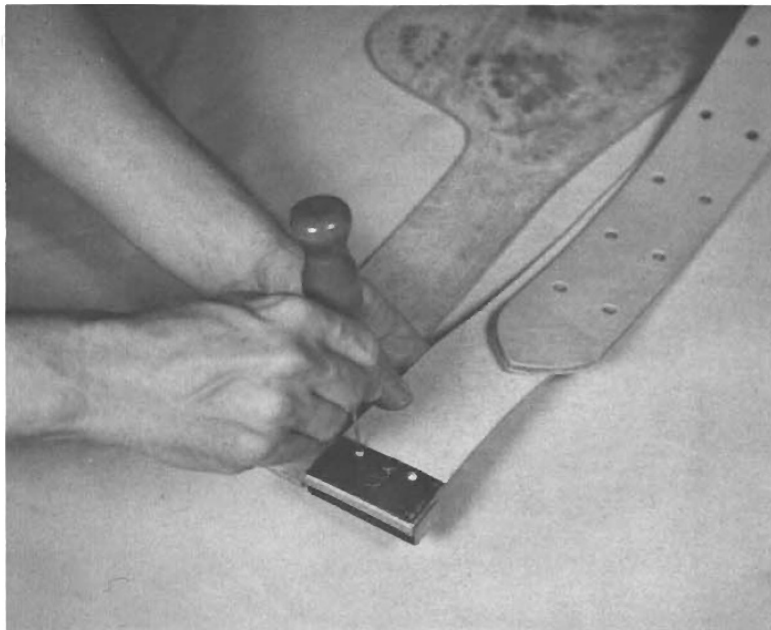
Fabricate stirrup leathers. See page 16.



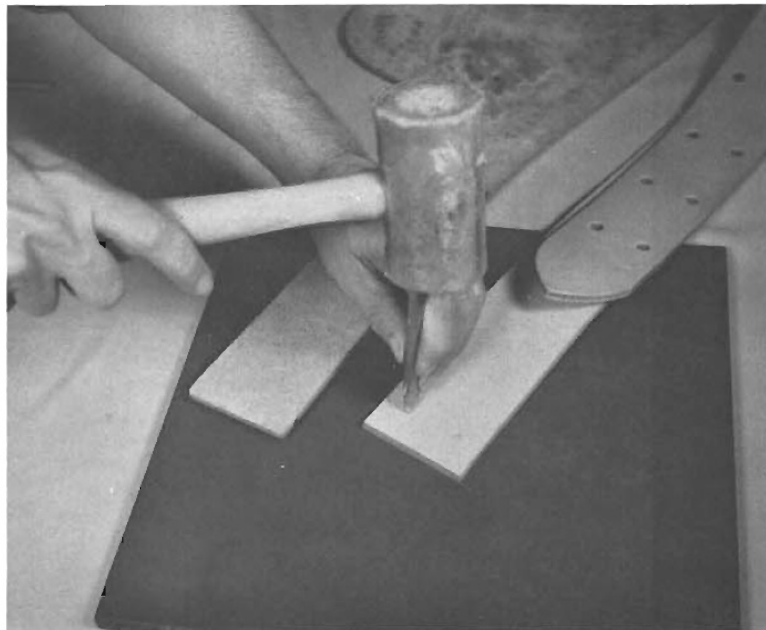
Step 29. Pull leather at base of back cantle down firmly and tack into place.



Step 30. Pull ends of cantle binder forward (with pliers or saddlers awl) and tack into place (use 2-1 1/8" tacks) on bar at the base of cantle. Be sure seat is centered.



Step 32. Place squared end of stirrup leather, flesh side up, on table. Slide stirrup leather buckle on squared end as shown, aligning end of buckle and end of leather. Mark the two rivet holes.



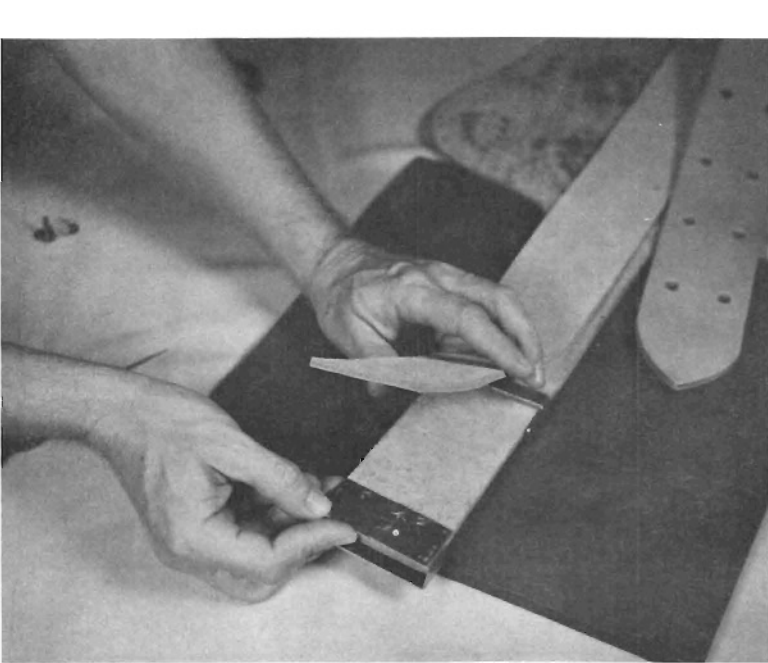
Step 33. Punch rivet holes with #5 punch.



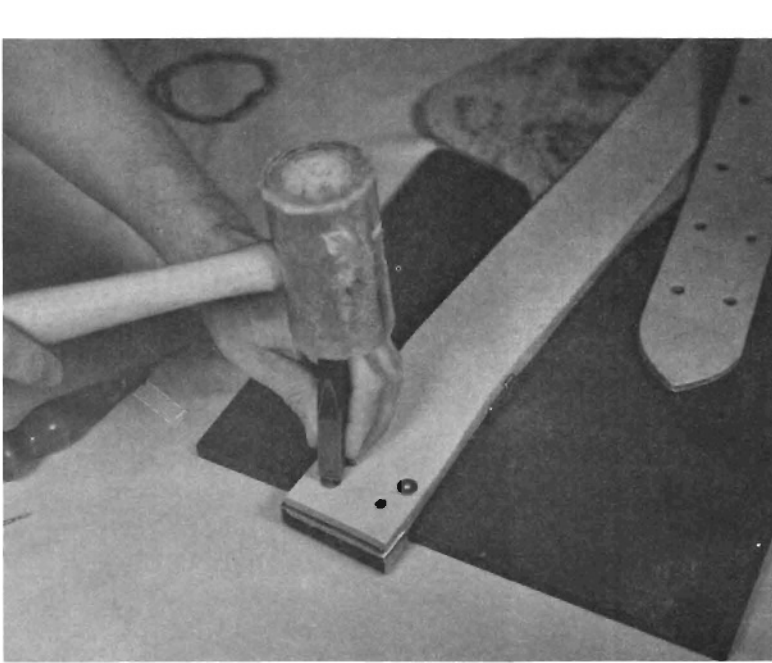
Step 34. Place the stirrup end of left fender (flesh side up) underneath end of stirrup leather, aligning ends and edges. Mark the two rivet holes and punch with no. 5 punch.



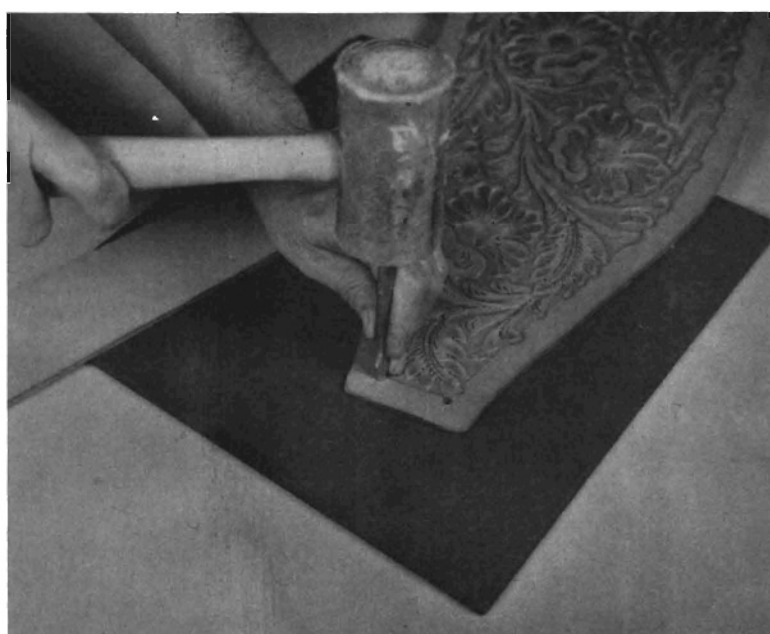
Step 35. Slip tongue end of stirrup buckle on fender (stirrup end) as shown. Push buckle up about 8", out of way.



Step 36. Slide keeper end of buckle on fender (stirrup end) as shown, aligning holes.



Step 37. Insert 5/8" copper rivet up (from grain side of fender leather) through fender leather, buckle and stirrup leather. Place washer over end of rivet and set using rivet setter and mallet or ball peen hammer.



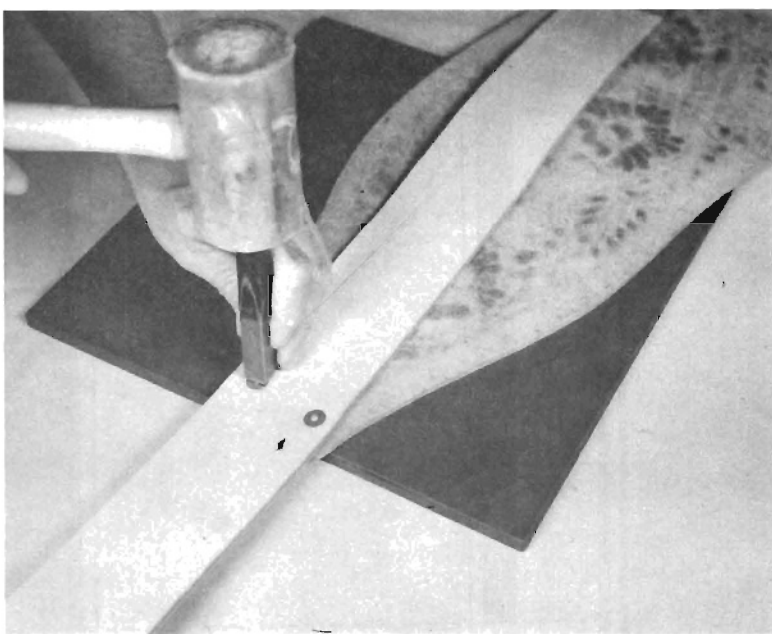
Step 38. Punch two holes, 1 3/8" apart with no. 5 punch, in top of fender (grain side) about 3/4" from end. (See stirrup leathers, page 16.)



Step 39. Fold stirrup end of fender (with stirrup leather and buckle attached) under as shown.



Step 40. With fender still folded mark location of holes on stirrup leather (grain side). Punch holes with no. 5 punch.



Step 41. Turn fender and stirrup leather over as shown. Insert 1/2" copper rivet up (from grain side of fender) through fender and stirrup leather. Place washer on rivet and set. Assemble both fenders, stirrup leathers and buckles in this manner.

VI Installing Skirts



Step 42. Dampen front and back bar pockets and area on skirt between these pockets.

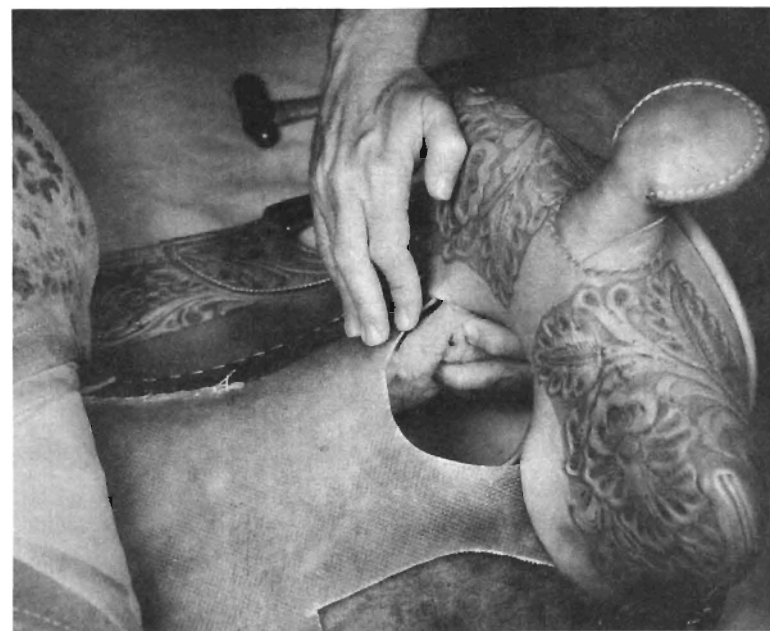


Step 43. Push back part of bar into back bar pocket as far as it will go.

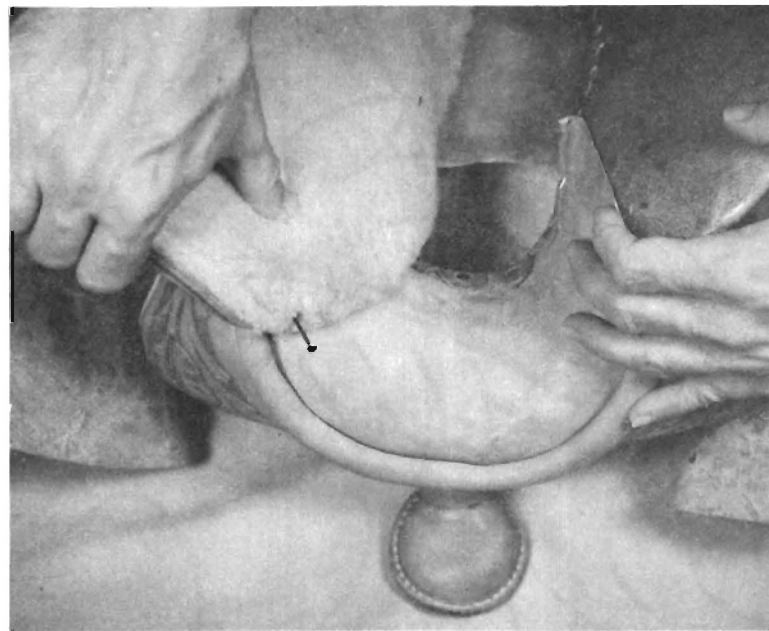


Step 44. Push front part of bar into front bar pocket.

Apply finishes to saddle parts before boring and stringing saddle.



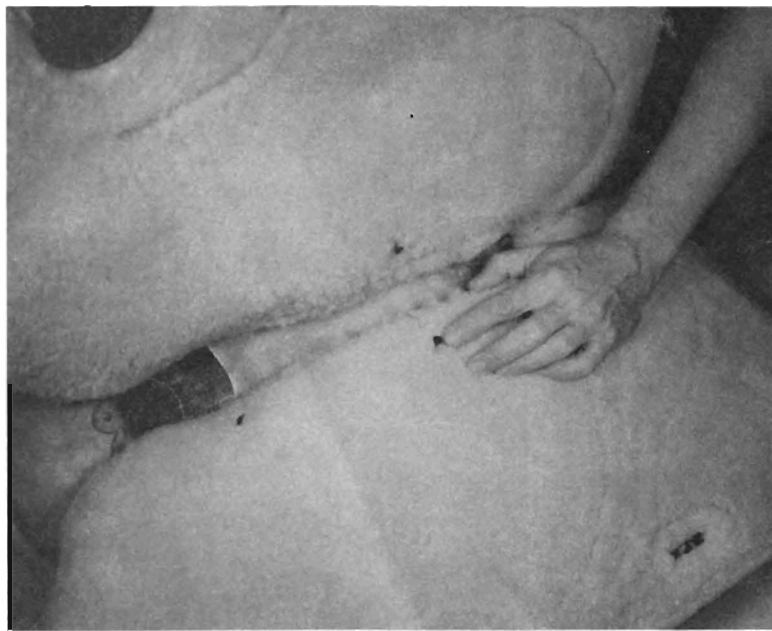
Step 45. Pull top of skirt up against fiberglass ground seat. At point where bar and fork meet, temporarily nail point at top of skirt (nail will be pulled out later) to inside edge of bar.



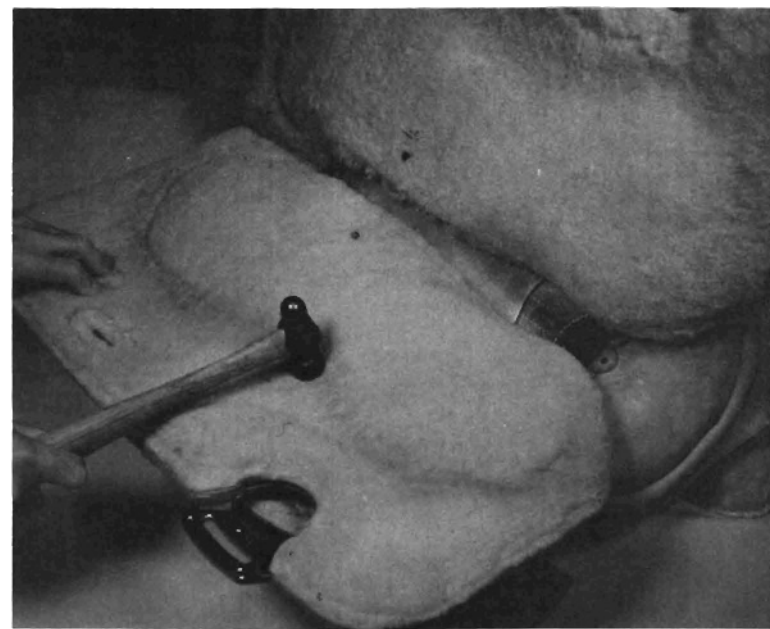
Step 46. Pull skirt as high and as tight under gullet as possible and drive nail through skirt and into front of gullet next to fork binder. Between bars on bottom of cantle.



Step 47. Place top back edge of skirt in center and nail through skirt and into bottom of cantle. This completes proper alignment of one skirt. Install other skirt in same manner.



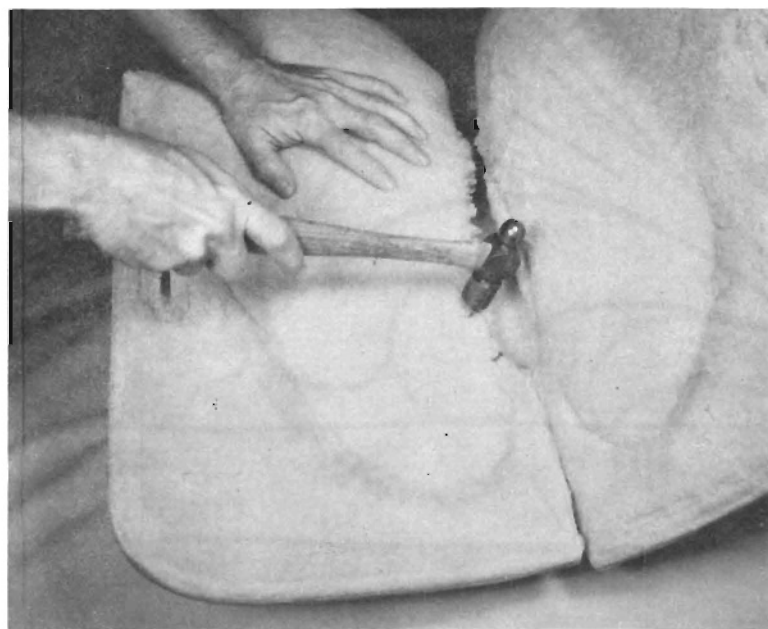
Step 48. Drive temporary tacks through skirts into bars. Cowhide part of skirt must be wet when you block the skirt.



Step 49. Check skirt and apply water to grain side of skirt again if necessary. Block or shape skirt to the bar by beating skirt around the outside of bar contour. Do not hit bars. Block both skirts. Remove 2 temporary tacks.



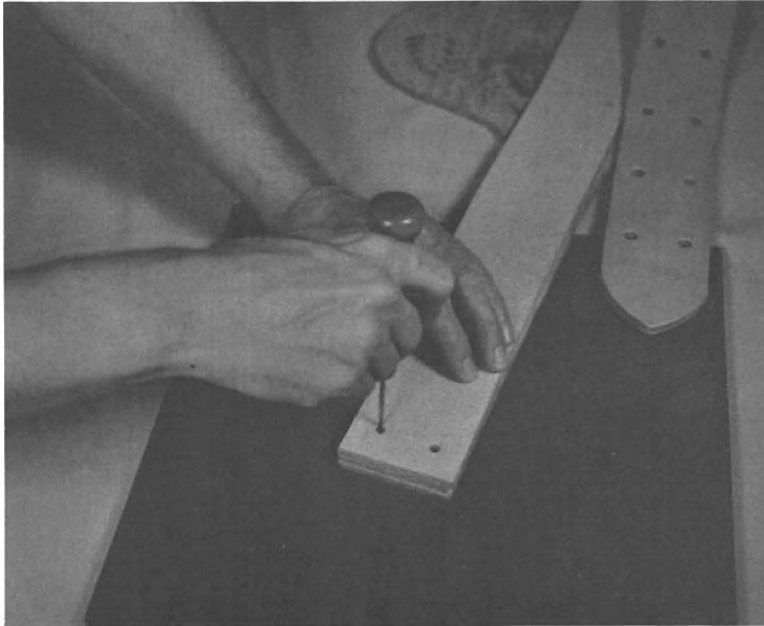
Step 50. Secure top front of skirt with 2 nails driven through skirt into gullet. Secure both sides.



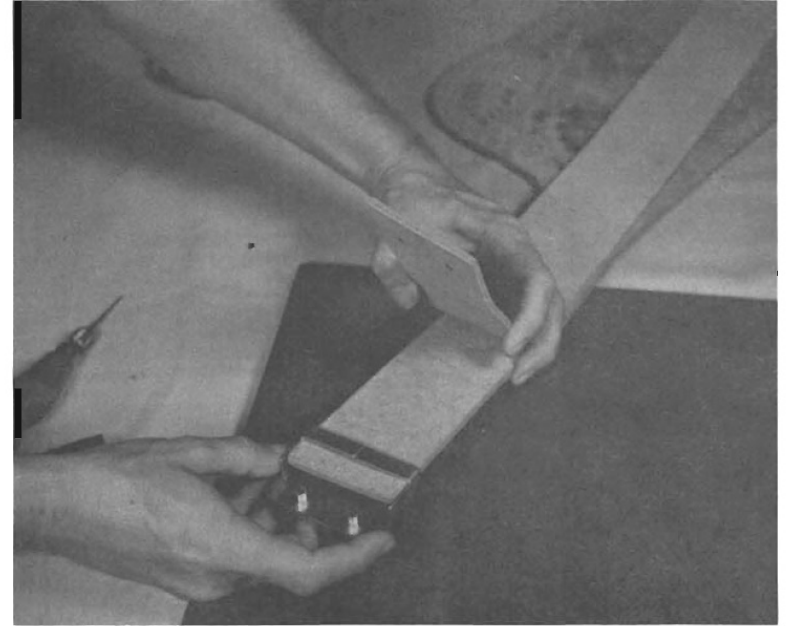
Step 51. Drive 2 nails through skirts into top of bar to secure top back part of skirt.



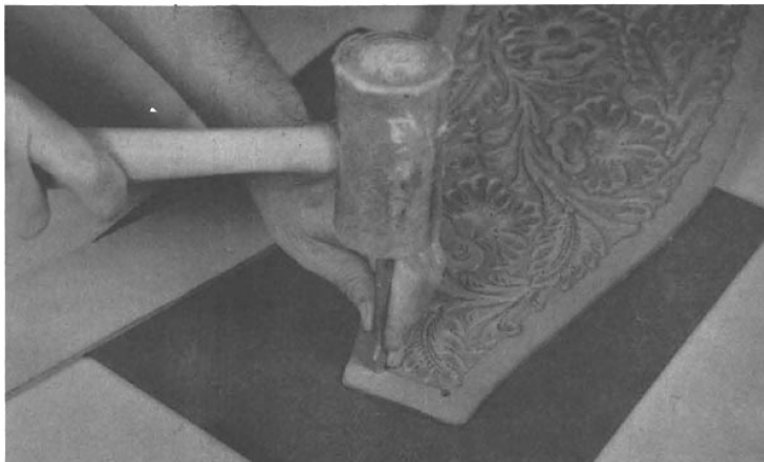
Step 52. Remove temporary nails in points at front of skirts (step 45). This will make installing fenders and stirrup leathers easier.

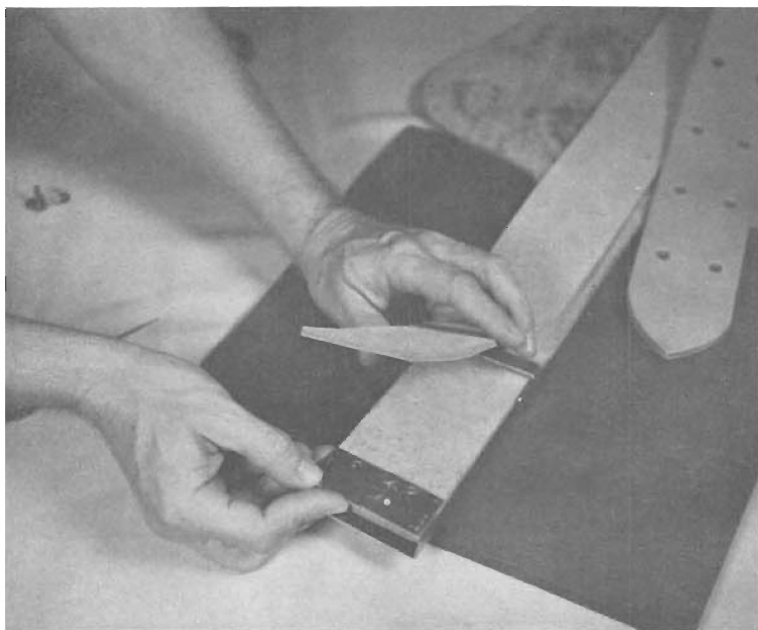


Step 34. Place the stirrup end of left fender (flesh side up) underneath end of stirrup leather, aligning ends and edges. Mark the two rivet holes and punch with no. 6 punch.

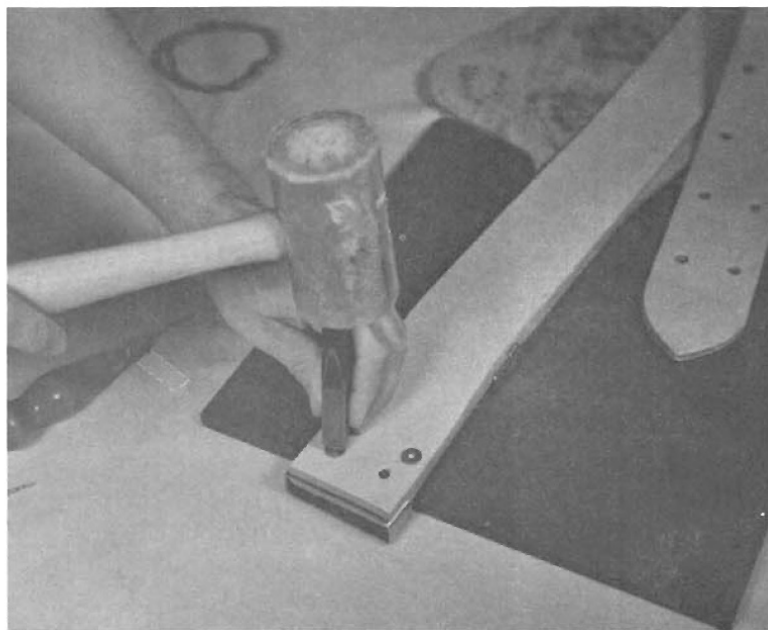


Step 35. Slip tongue end of stirrup buckle on fender (stirrup end) as shown. Push buckle up about 8", out of way.

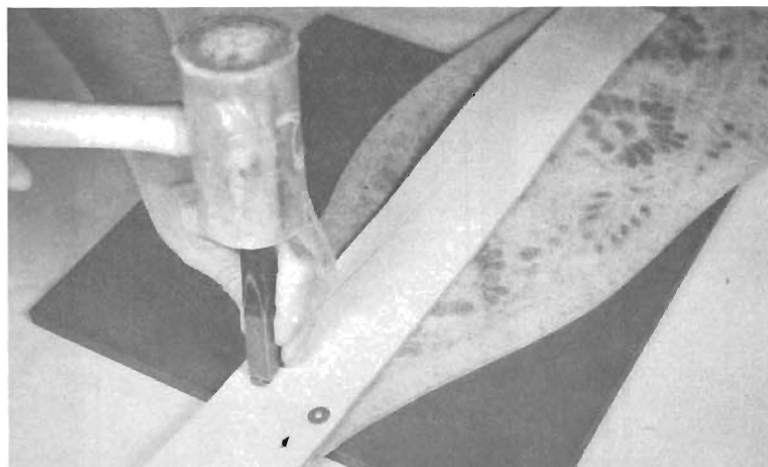


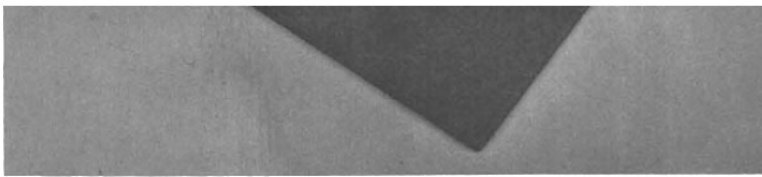


Step 36. Slide keeper end of buckle on fender (stirrup end) as shown, aligning holes.



Step 37. Insert 5/8" copper rivet up (from grain side of fender leather) through fender leather, buckle and stirrup leather. Place washer over end of rivet and set using rivet setter and mallet or ball peen hammer.



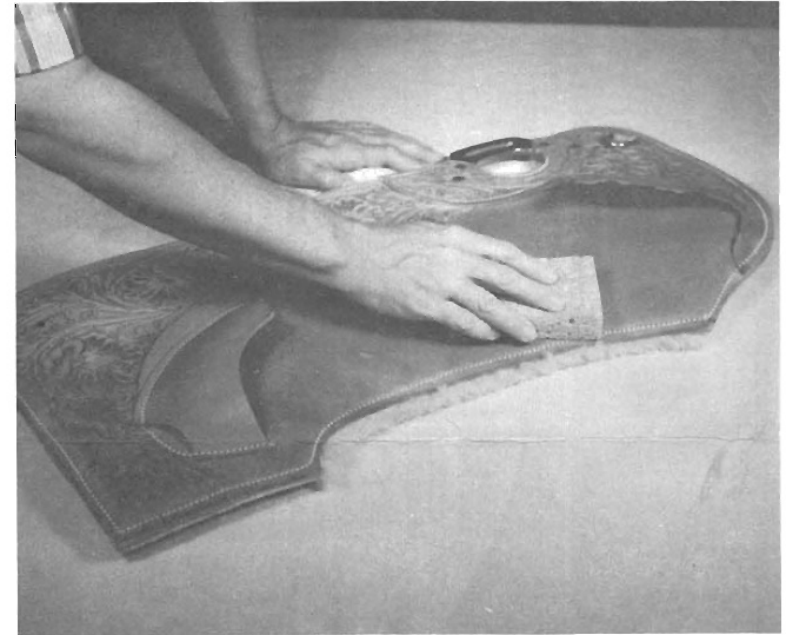


Step 38. Punch two holes, 1 3/8" apart with no. 5 punch, in top of fender (grain side) about 3/4" from end. (See stirrup leathers, page 16.)



Step 39. Fold stirrup end of fender (with stirrup leather and buckle attached) under as shown.

VI Installing Skirts



Apply finishes to saddle parts before boring and stringing saddle.

Step 42. Dampen front and back bar pockets and area on skirt between these pockets.





Step 40. With fender still folded mark location of holes on stirrup leather (grain side). Punch holes with no. 5 punch.



Step 41. Turn fender and stirrup leather over as shown. Insert 1/2" copper rivet up (from grain side of fender) through fender and stirrup leather. Place washer on rivet and set. Assemble both fenders, stirrup leathers and buckles in this manner.

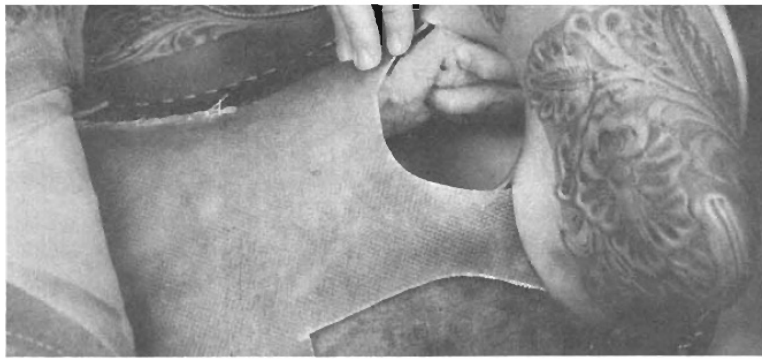


Step 43. Push back part of bar into back bar pocket as far as it will go.

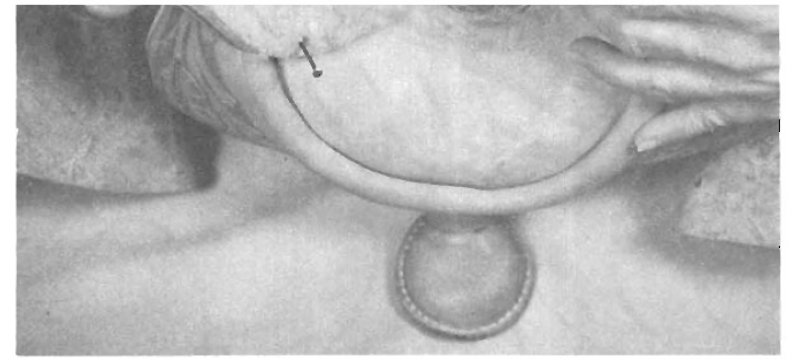


Step 44. Push front part of bar into front bar pocket.

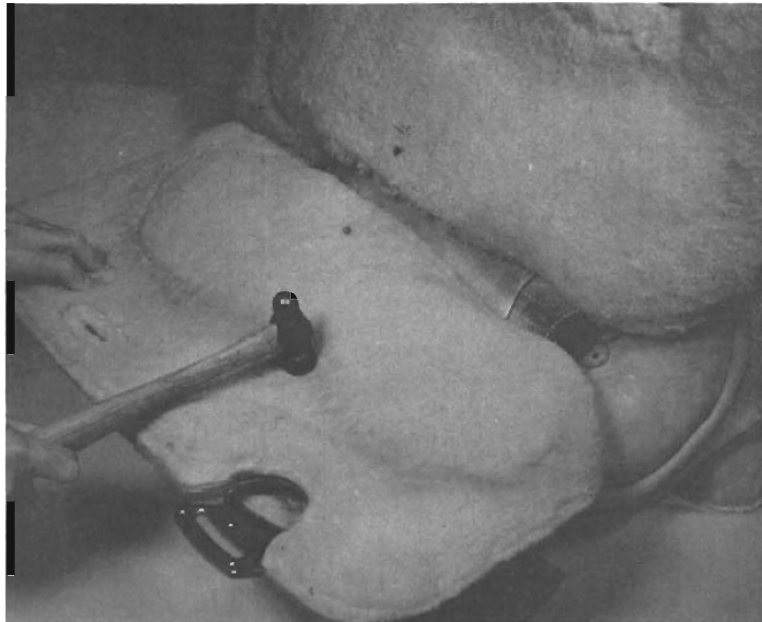




Step 45. Pull top of skirt up against fibreglass ground seat. At point where bar and fork meet, temporarily nail point at top of skirt (nail will be pulled out later) to inside edge of bar.



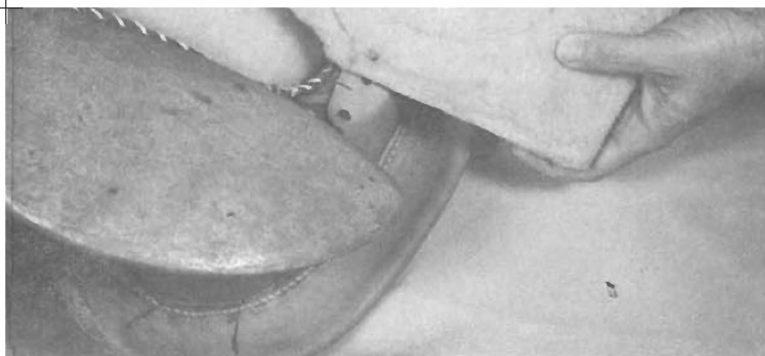
Step 46. Pull skirt as high and as tight under gullet as possible and drive nail through skirt and into front of gullet next to fork binder. Between bars on bottom of cantle.



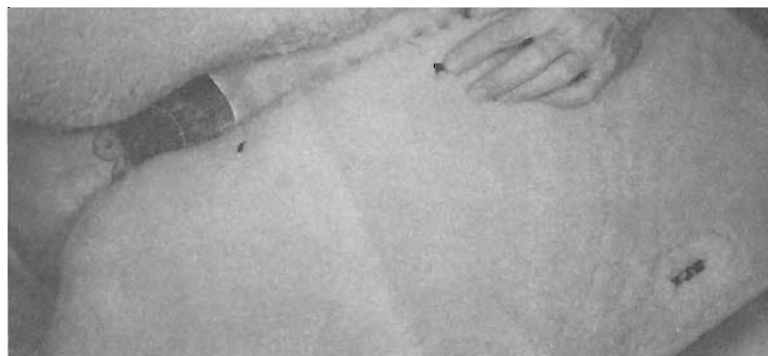
Step 49. Check skirt and apply water to grain side of skirt again if necessary. Block or shape skirt to the bar by beating skirt around the outside of bar contour. Do not hit bars. Block both skirts. Remove 2 temporary tacks.



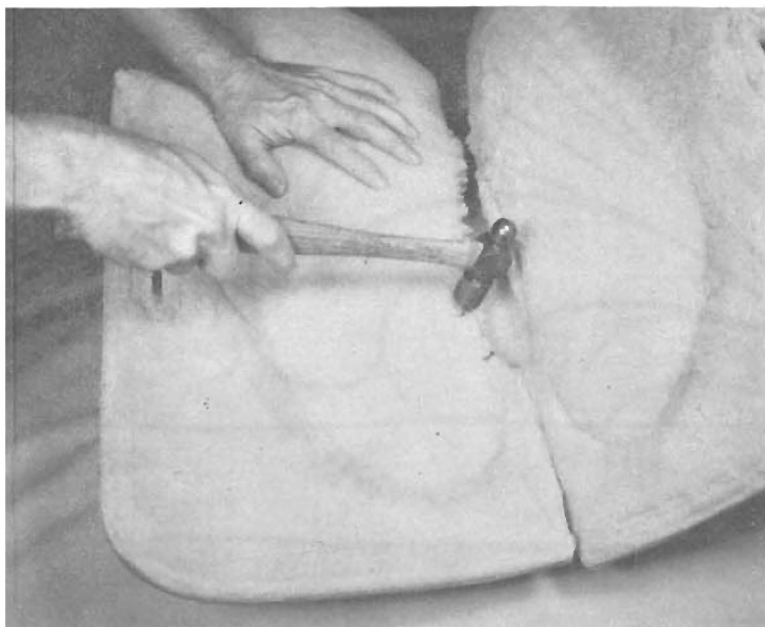
Step 50. Secure top front of skirt with 2 nails driven through skirt into gullet. Secure both sides.



Step 47. Place top back edge of skirt in center and nail through skirt and into bottom of cantle. This completes proper alignment of one skirt. Install other skirt in same manner.



Step 48. Drive temporary tacks through skirts into bars. Cowhide part of skirt must be wet when you block the skirt.

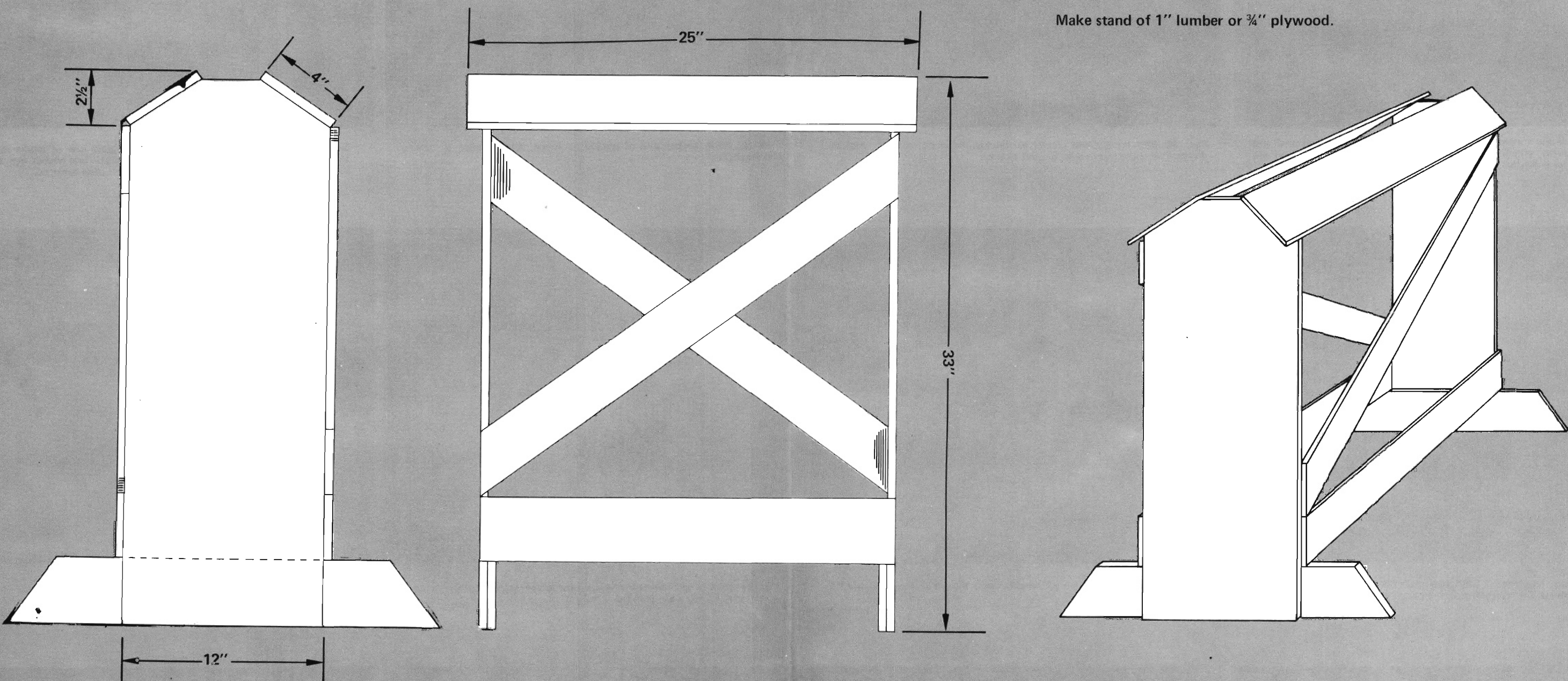


Step 51. Drive 2 nails through skirts into top of bar to secure top back part of skirt.

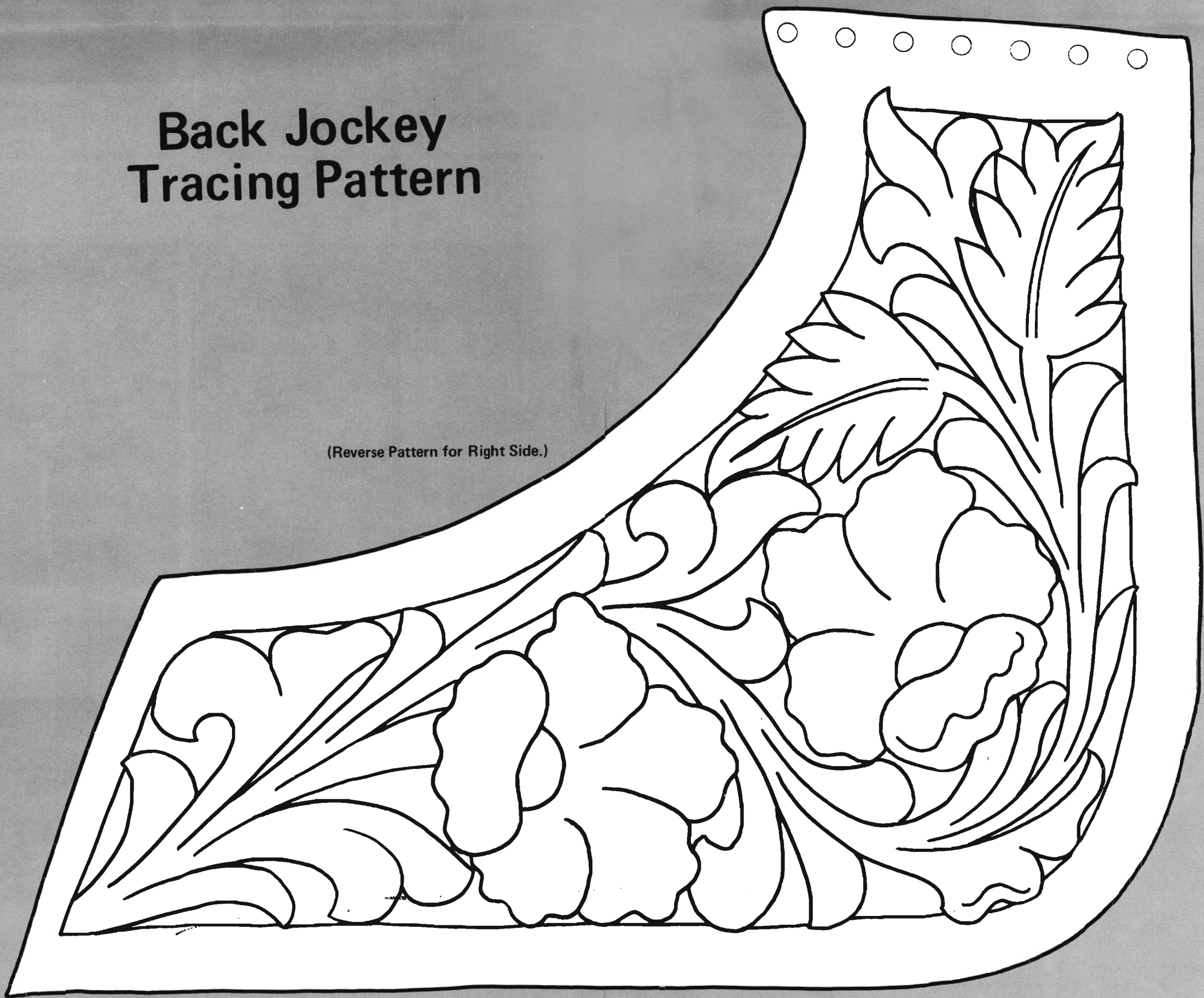


Step 52. Remove temporary nails in points at front of skirts (step 45). This will make installing fenders and stirrup leathers easier.

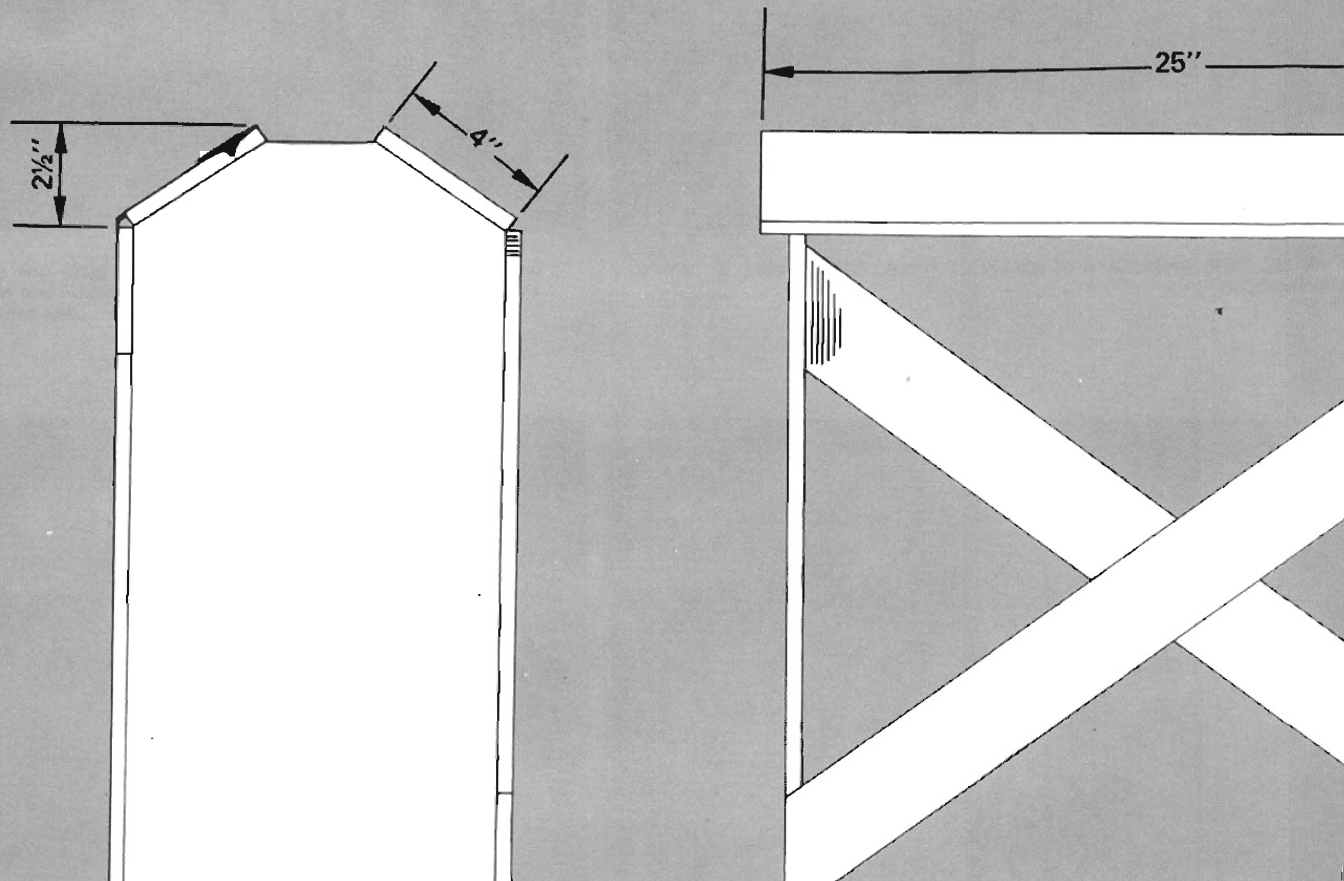
Saddle Stand Assembly Instructions



Back Jockey Tracing Pattern



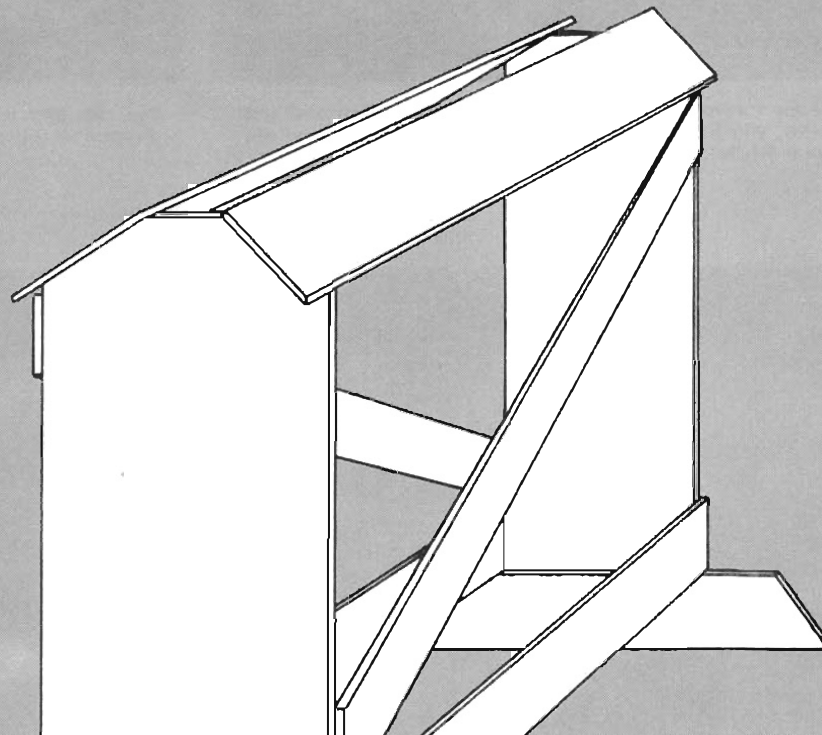
Saddle Stand Asse

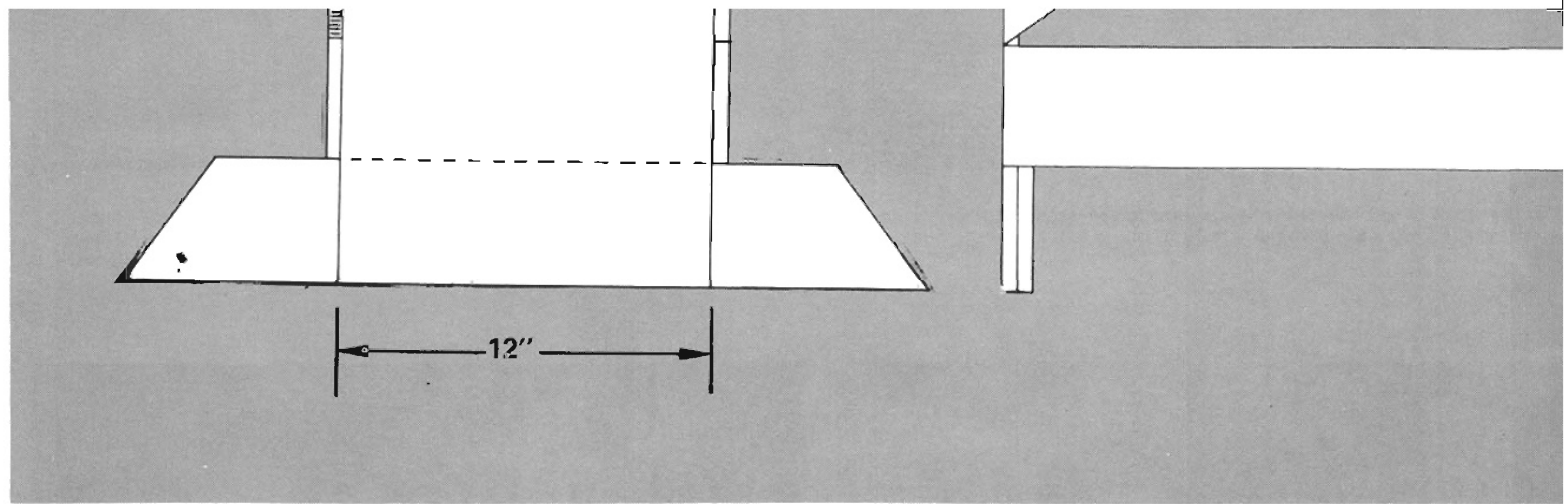


Assembly Instructions

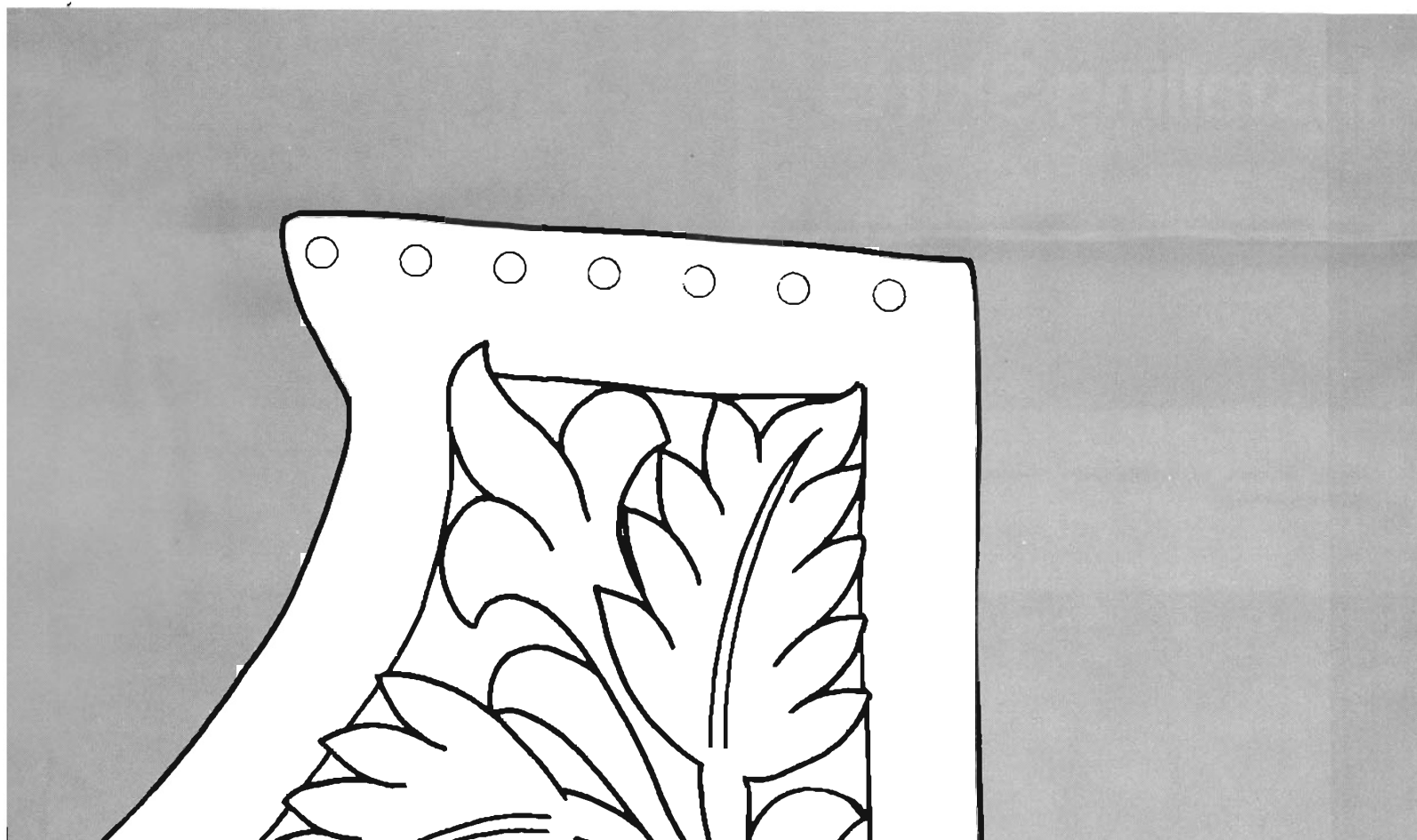
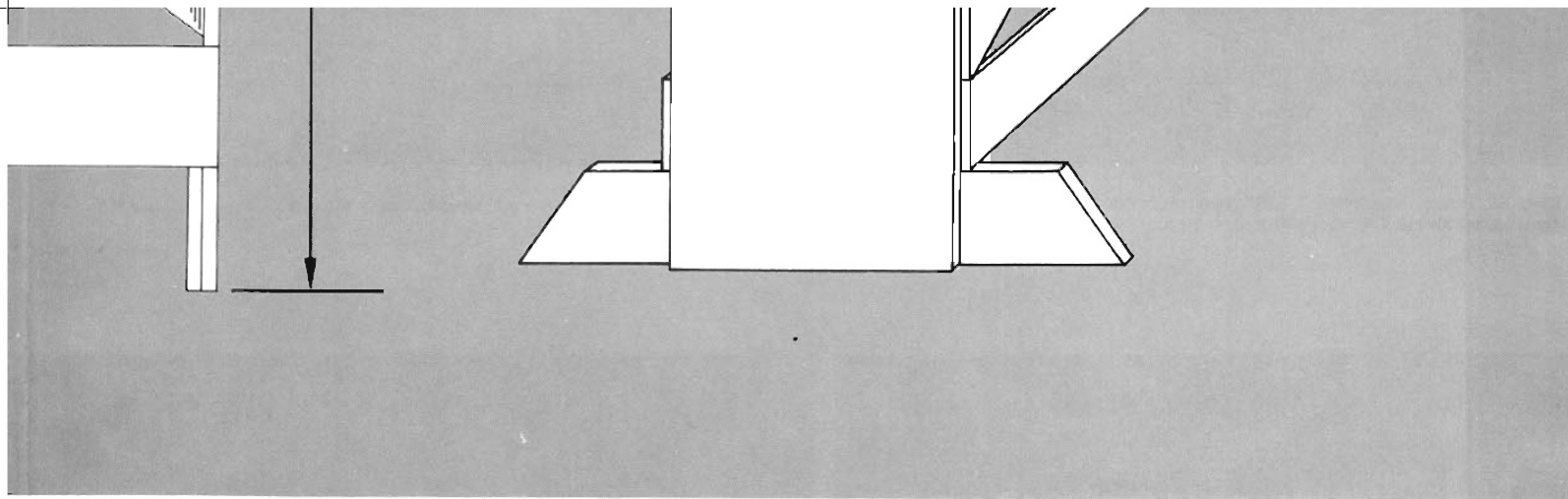
Make stand of 1" lumber or $\frac{3}{4}$ " plywood.

33"

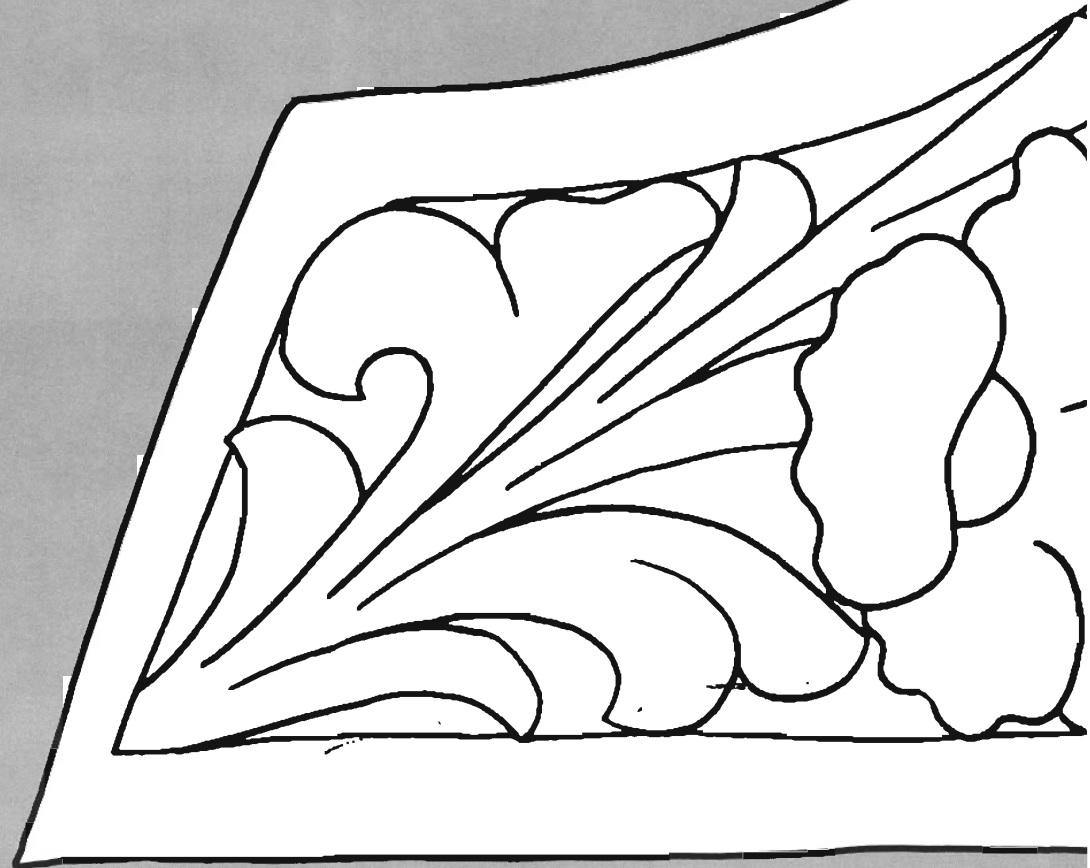


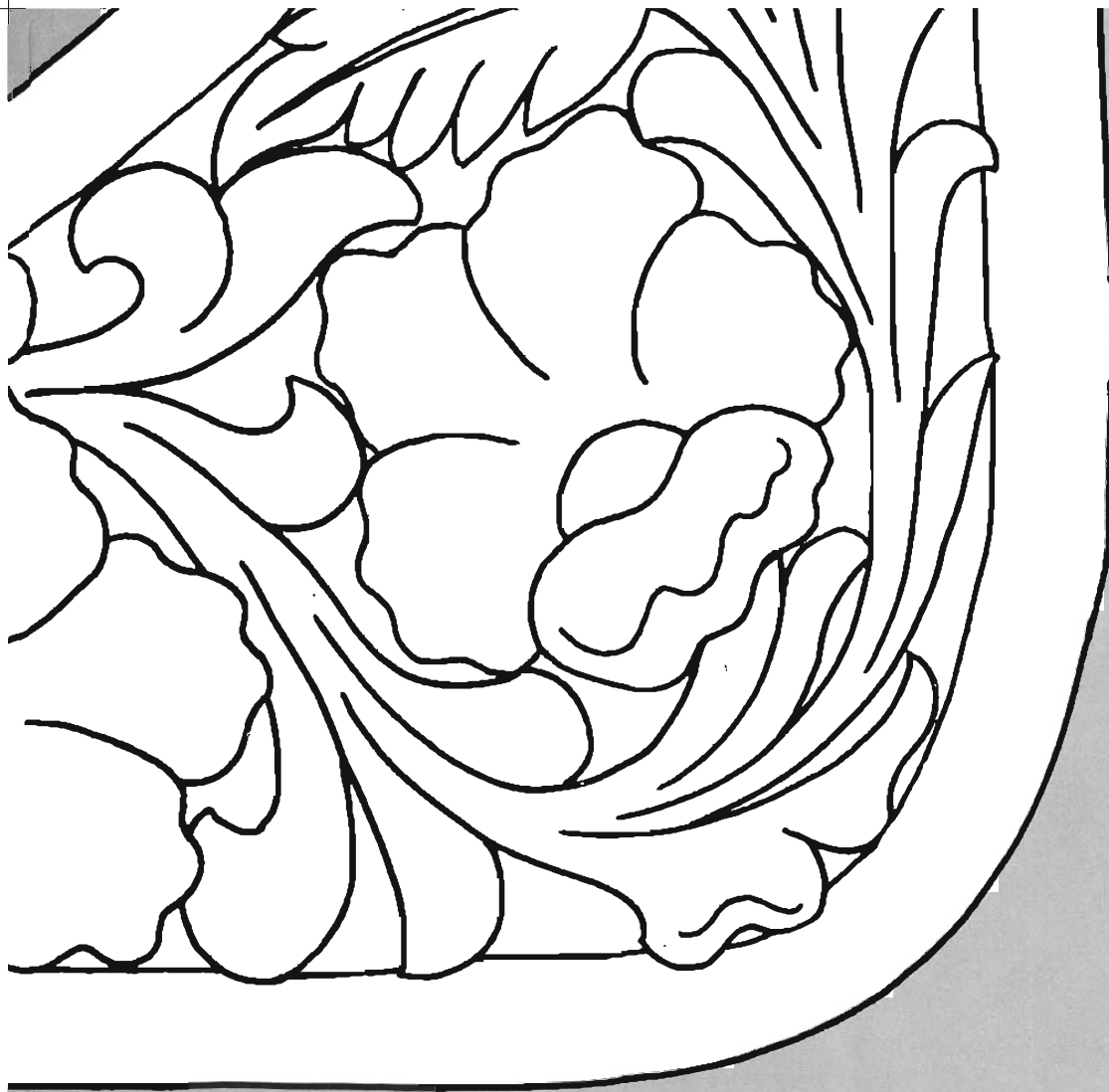


**Back Jockey
Tracing Pattern**



(Reverse Pattern for Right Side.)





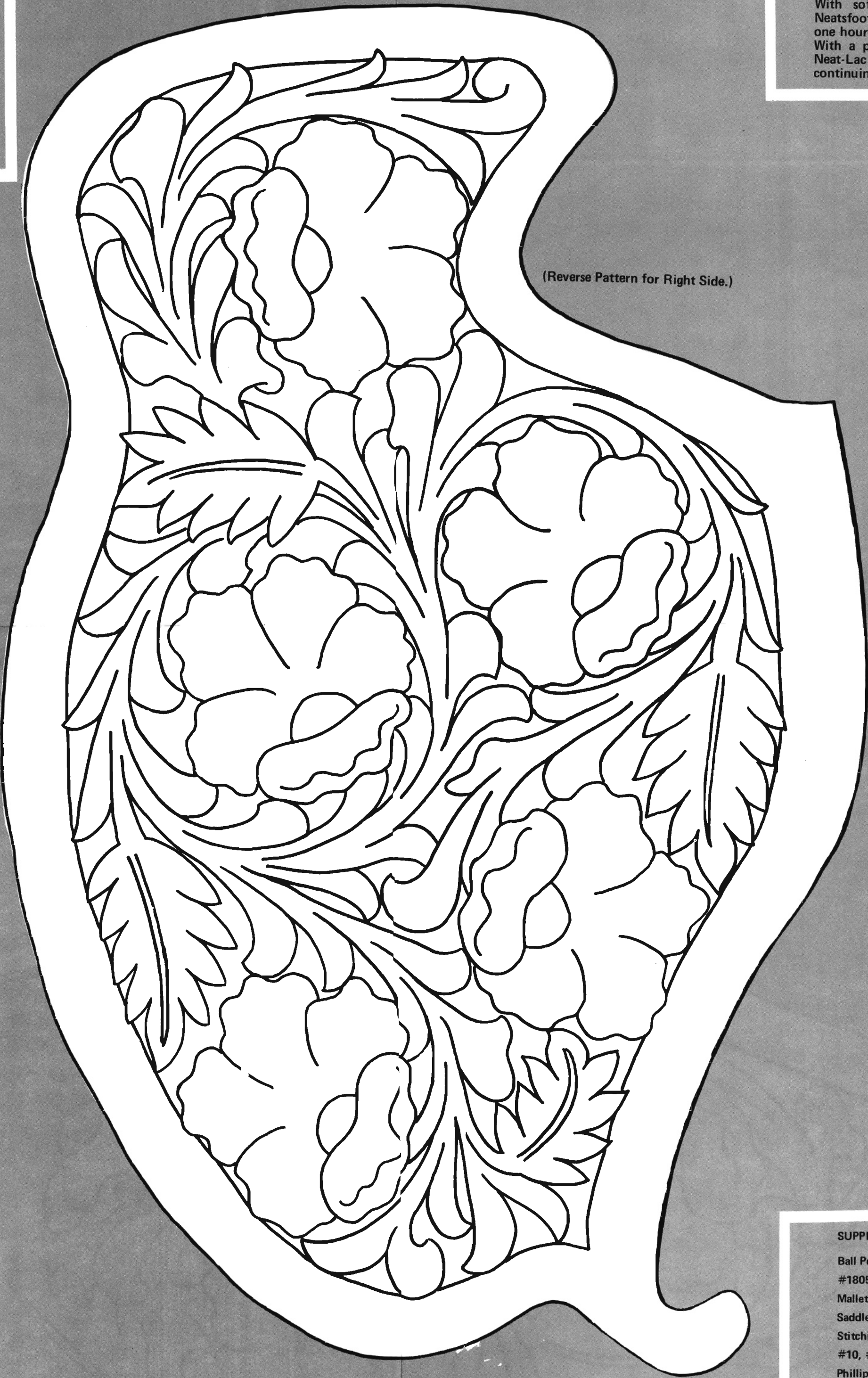
Caring for Your Saddle

Wash the saddle thoroughly with any good laundry soap, using a soft brush and lukewarm water. When all grease and dust particles have been removed, rinse the saddle with clean lukewarm water until no trace of soap remains. When you have done this, let the saddle dry at normal temperature . . . never in the sun or under intense heat.

Apply the oil, preferably Neatsfoot Oil, with soft cloth. Do not saturate the saddle with the oil; only apply enough to coat the saddle evenly. If care is taken, one coat of oil will be sufficient and effective. Allow the oil to seep into the pores of the leather for one hour.

Make a thorough application of saddle soap. Allow this to dry for two hours, then rub down with a soft dry cloth. If a glossy finish is desired, an application of any good neutral shoe polish may be used.

Side Jockey Tracing Pattern



(Reverse Pattern for Right Side.)

Note: Before beginning assembly examine saddle tree to see that there is plenty of clearance between fiberglass ground seat and bars for stirrup leathers to slide through easily. Also examine underneath edge of ground seat to determine if there are any sharp edges that might scratch stirrup leathers. Use a file or sandpaper to correct these problems.

To protect saddle horn when turning saddle upside down during assembly, place padding under saddle or leave sheepswool horn cover on horn.

Finishing Saddle Parts Before Assembly

Apply finishes before boring and stringing saddle.

With soft cloth, apply an even coat of Neatsfoot Oil to saddle parts. Allow about one hour for oil to penetrate pores in leather. With a piece of sheeps wool, apply coat of Neat-Lac to all saddle parts and let dry before continuing saddle assembly.

SUPPLIES YOU WILL NEED:

- Ball Peen Hammer
- #1805 Copper Rivet Setter
- Mallet
- Saddlers Awl
- Stitching Awl
- #10, #8 and #4 Drive Punch
- Phillips Screw Driver
- Ruler or Tape Measure
- Knife-for cutting leather
- #4 Bevel Eze Edge Beveler
- #5 Craftool Spacer Overstitch
- Drill with 1/8" and 1/4" Bits
- Neatsfoot Oil
- Pliers
- Neat Lac
- Skiving Knife or French Edge Skiving Tool
- Scissors
- Edge Slicker

Caring for Your Saddle

Wash the saddle thoroughly with any good laundry soap, using a soft brush and lukewarm water. When all grease and dust particles have been removed, rinse the saddle with clean lukewarm water until no trace of soap remains. When you have done this, let the saddle dry at normal temperature . . . never in the sun or under intense heat.

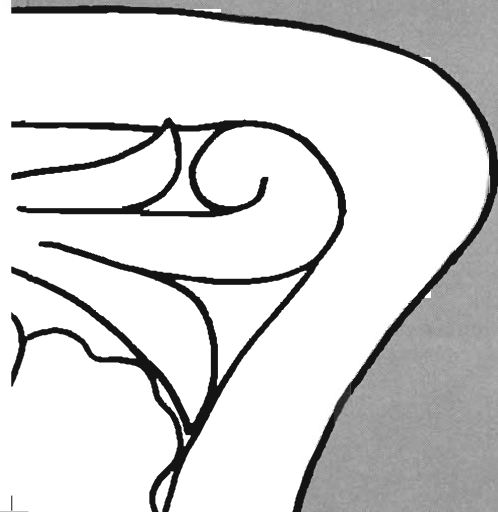
Apply the oil, preferably Neatsfoot Oil, with soft cloth. Do not saturate the saddle with the oil; only apply enough to coat the saddle evenly. If care is taken, one coat of oil will be sufficient and effective. Allow the oil to seep into the pores of the leather for one hour.

Make a thorough application of saddle soap. Allow this to dry for two hours, then rub down with a soft dry cloth. If a glossy finish is desired, an application of any good neutral shoe polish may be used.

Side Jo Tracing



ockey Pattern



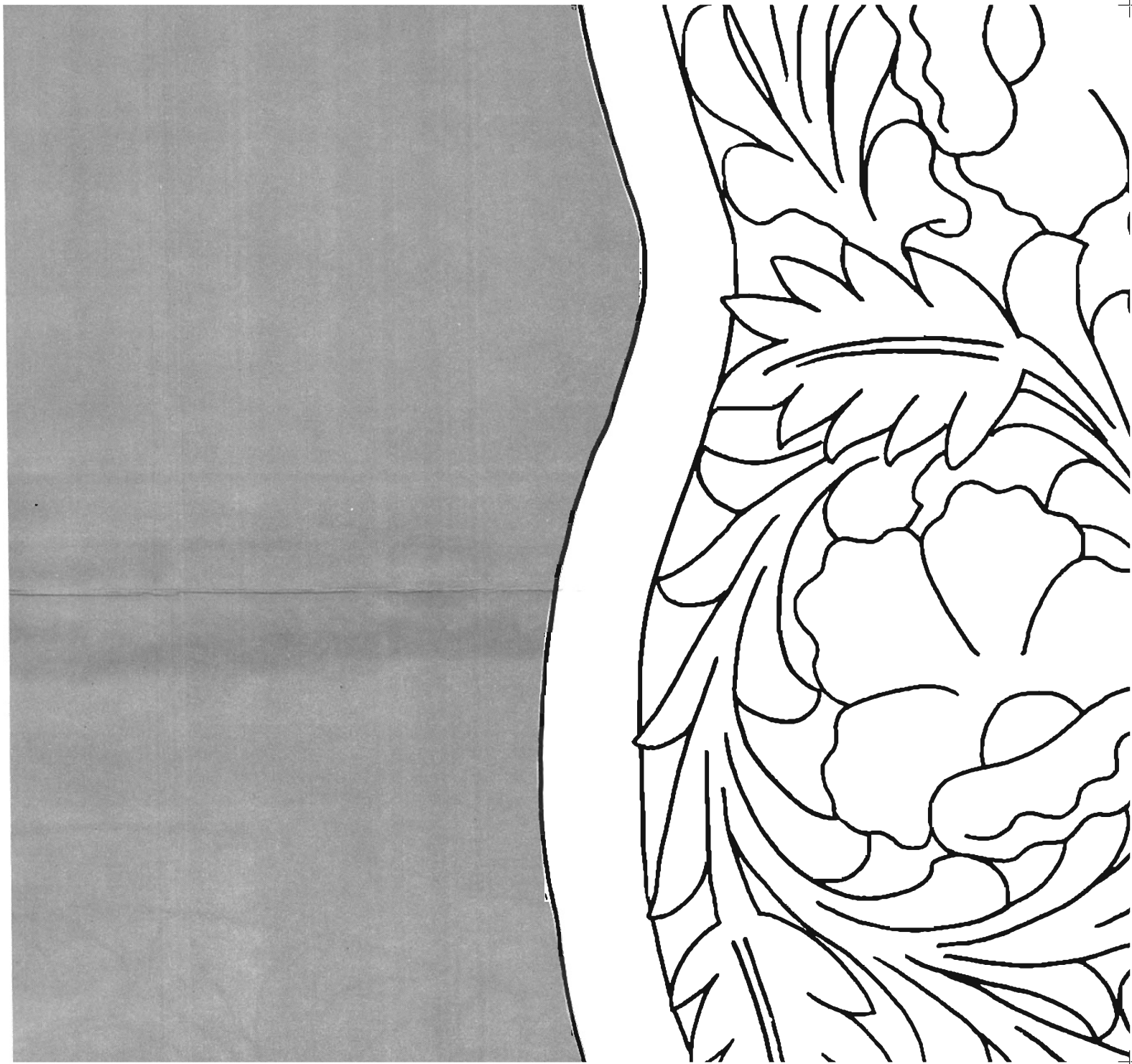
Note: Before beginning assembly examine saddle tree to see that there is plenty of clearance between fiberglass ground seat and bars for stirrup leathers to slide through easily. Also examine underneath edge of ground seat to determine if there are any sharp edges that might scratch stirrup leathers. Use a file or sandpaper to correct these problems.

To protect saddle horn when turning saddle upside down during assembly, place padding under saddle or leave sheepswool horn cover on horn.

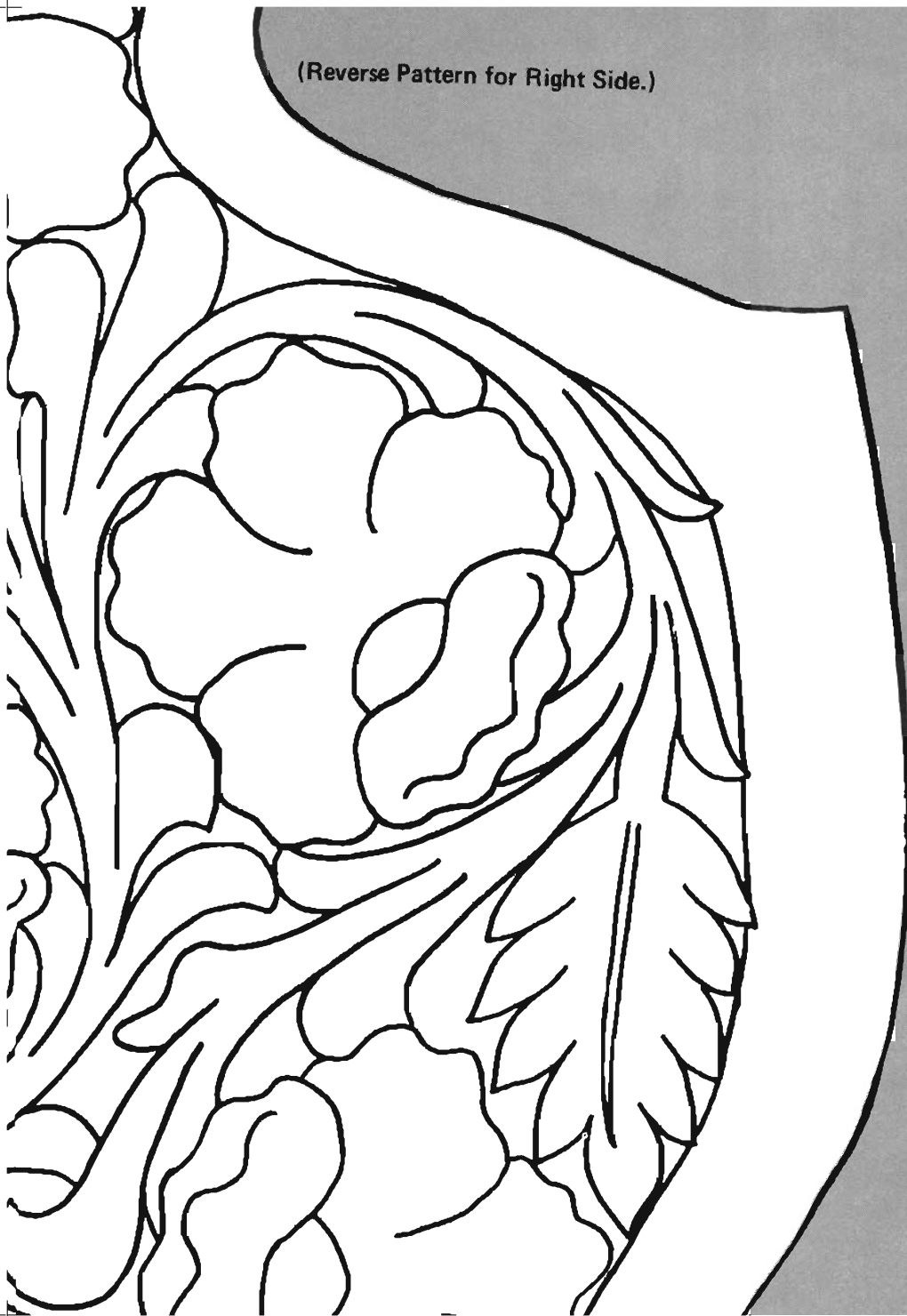
Finishing Saddle Parts Before Assembly

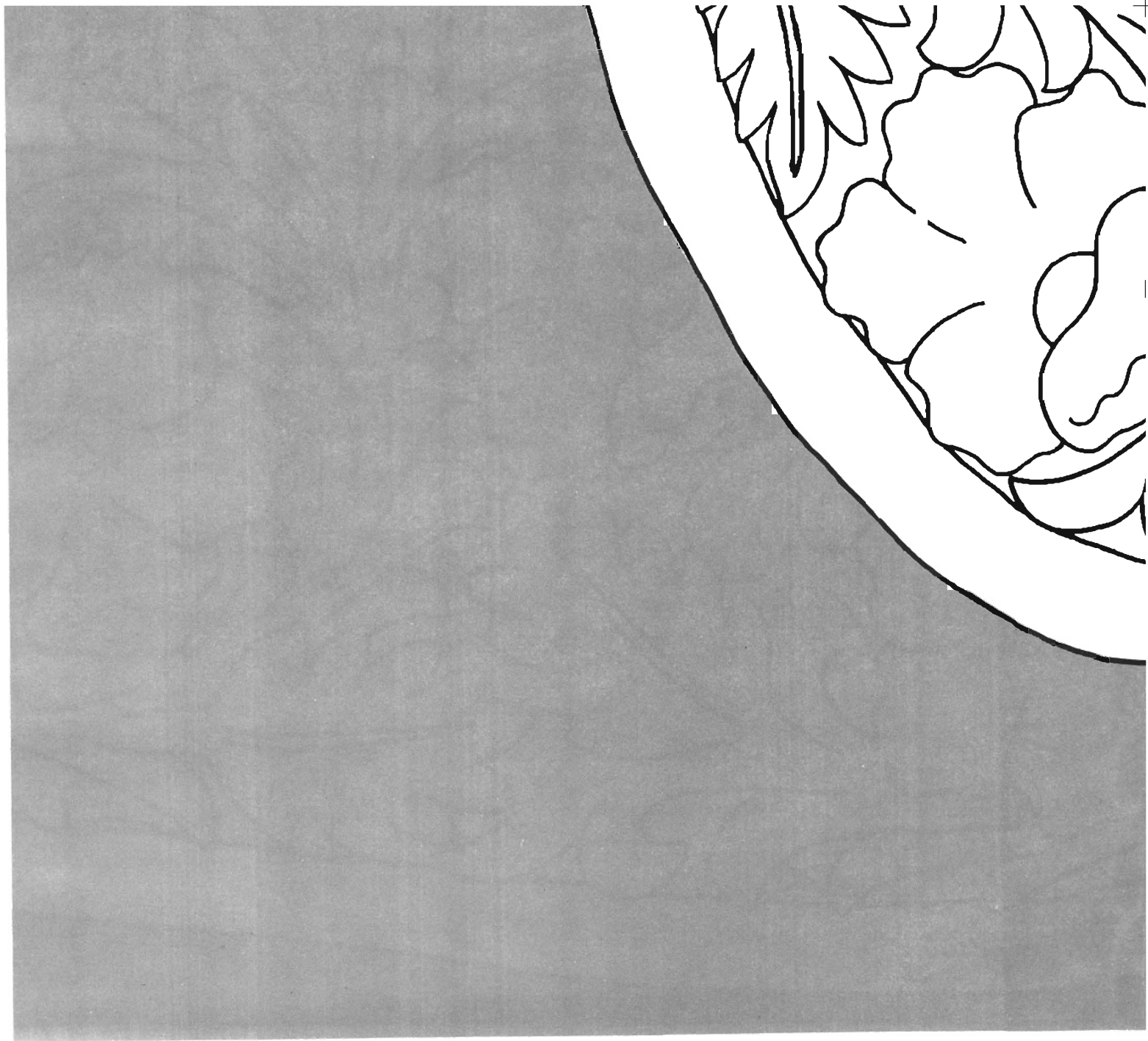
Apply finishes before boring and stringing saddle.

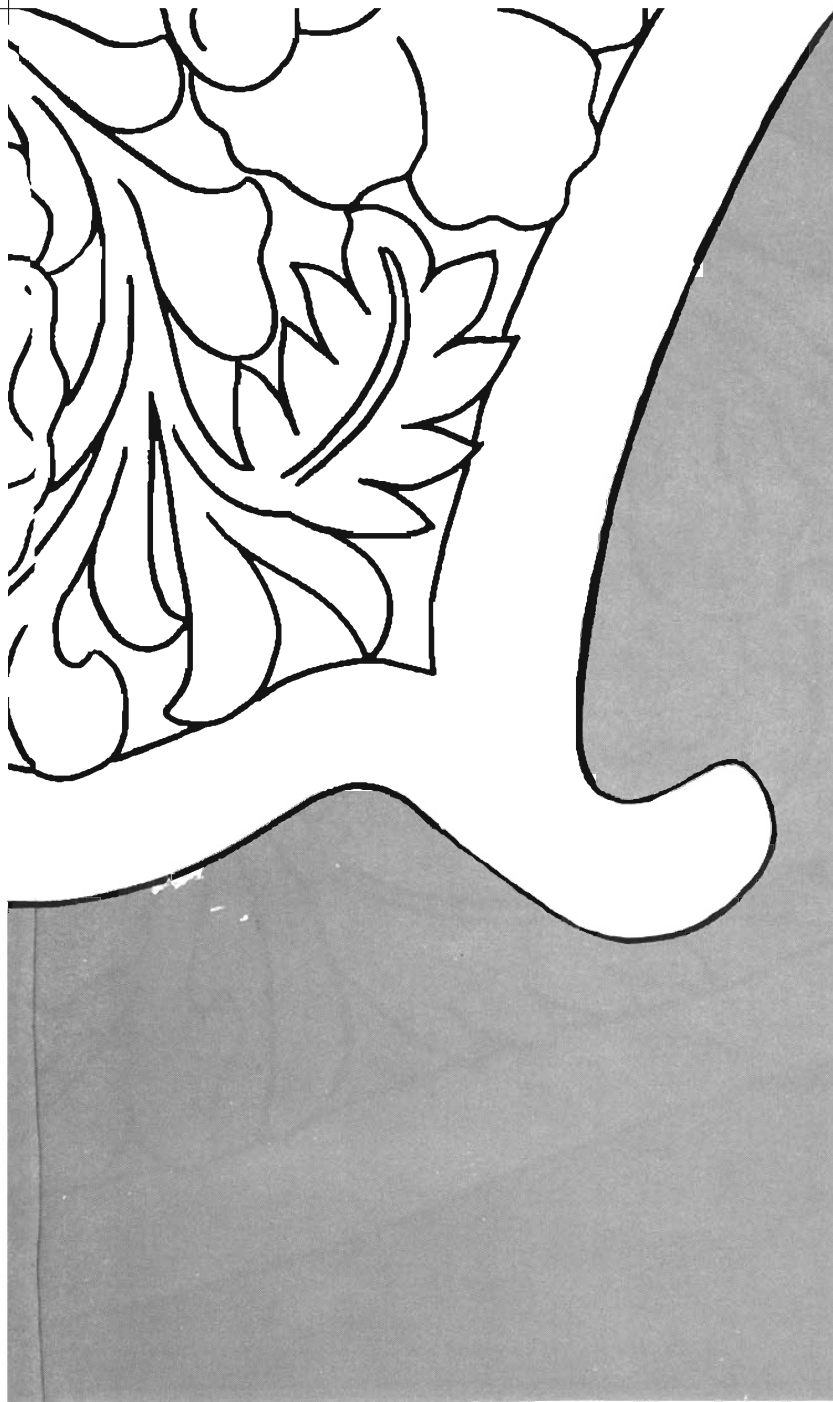
With soft cloth, apply an even coat of Neatsfoot Oil to saddle parts. Allow about one hour for oil to penetrate pores in leather. With a piece of sheep's wool, apply coat of Neat-Lac to all saddle parts and let dry before continuing saddle assembly.



(Reverse Pattern for Right Side.)







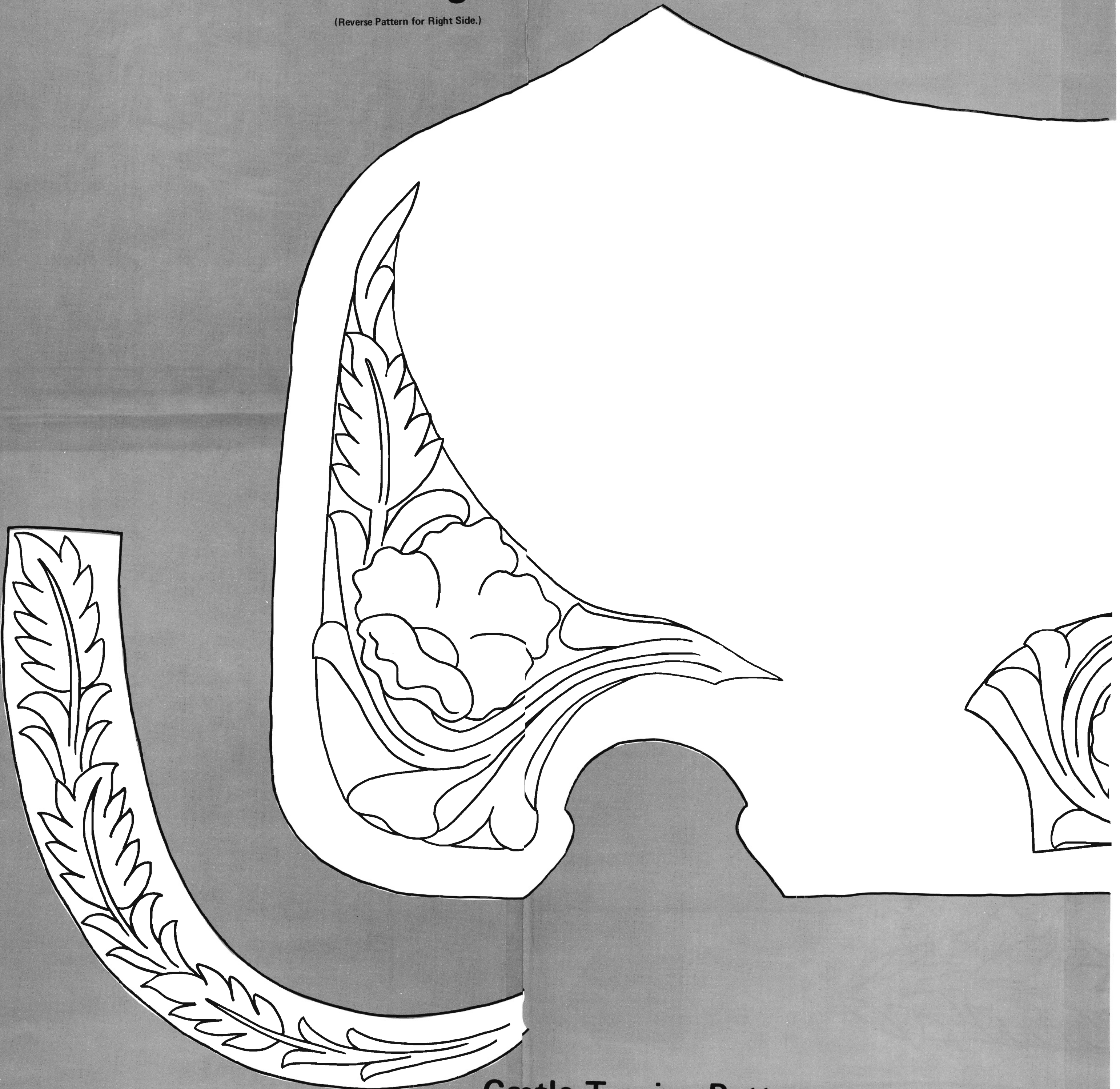
SUPPLIES YOU WILL NEED:

Ball Peen Hammer
#1805 Copper Rivet Setter
Mallet
Saddlers Awl
Stitching Awl
#10, #8 and #4 Drive Punch
Phillips Screw Driver
Ruler or Tape Measure
Knife-for cutting leather
#4 Bevel Eze Edge Beveler
#5 Craftool Spacer Overstitch
Drill with 1/8" and 1/4" Bits
Neatsfoot Oil
Pliers
Neat Lac
Skiving Knife or French Edge Skiving Tool
Scissors
Edge Slicker

Do All Carving and Tooling Before Assembly

Skirt Front Tracing Pattern

(Reverse Pattern for Right Side.)



Cantle Tracing Pattern

(Reverse Pattern for Left side.)

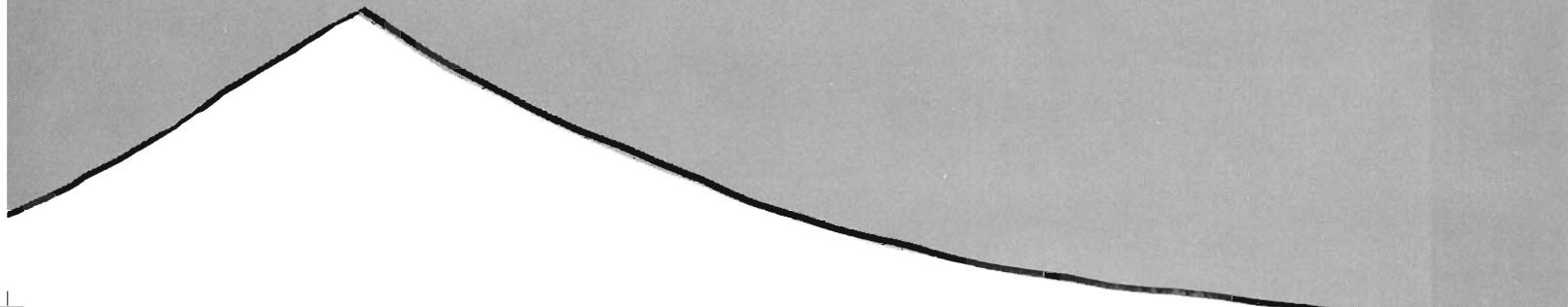
Do All Carving and Too

**Skirt Front
Tracing Pat**

(Reverse Pattern for Right Side.)

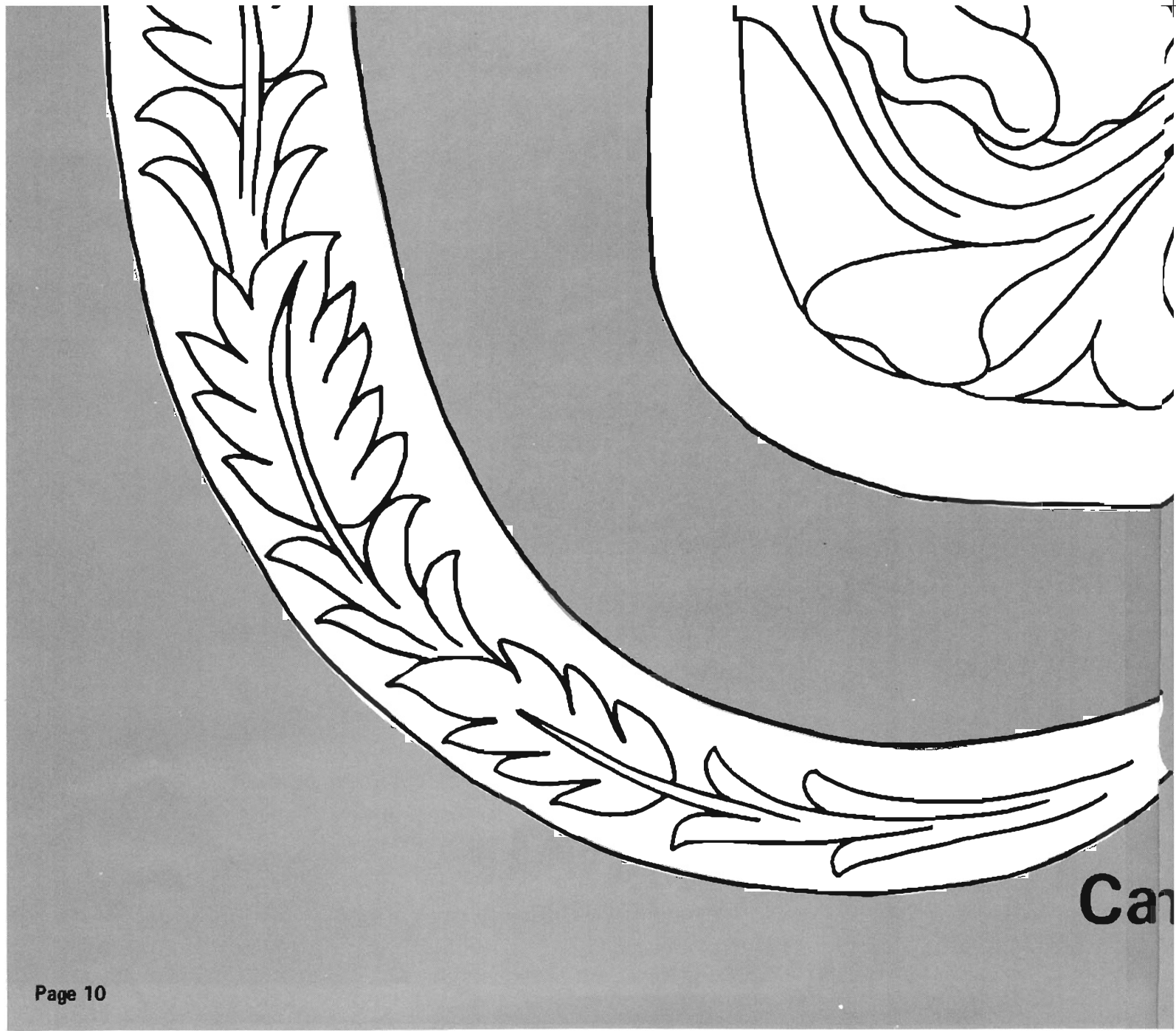
ling Before Assembly

tern









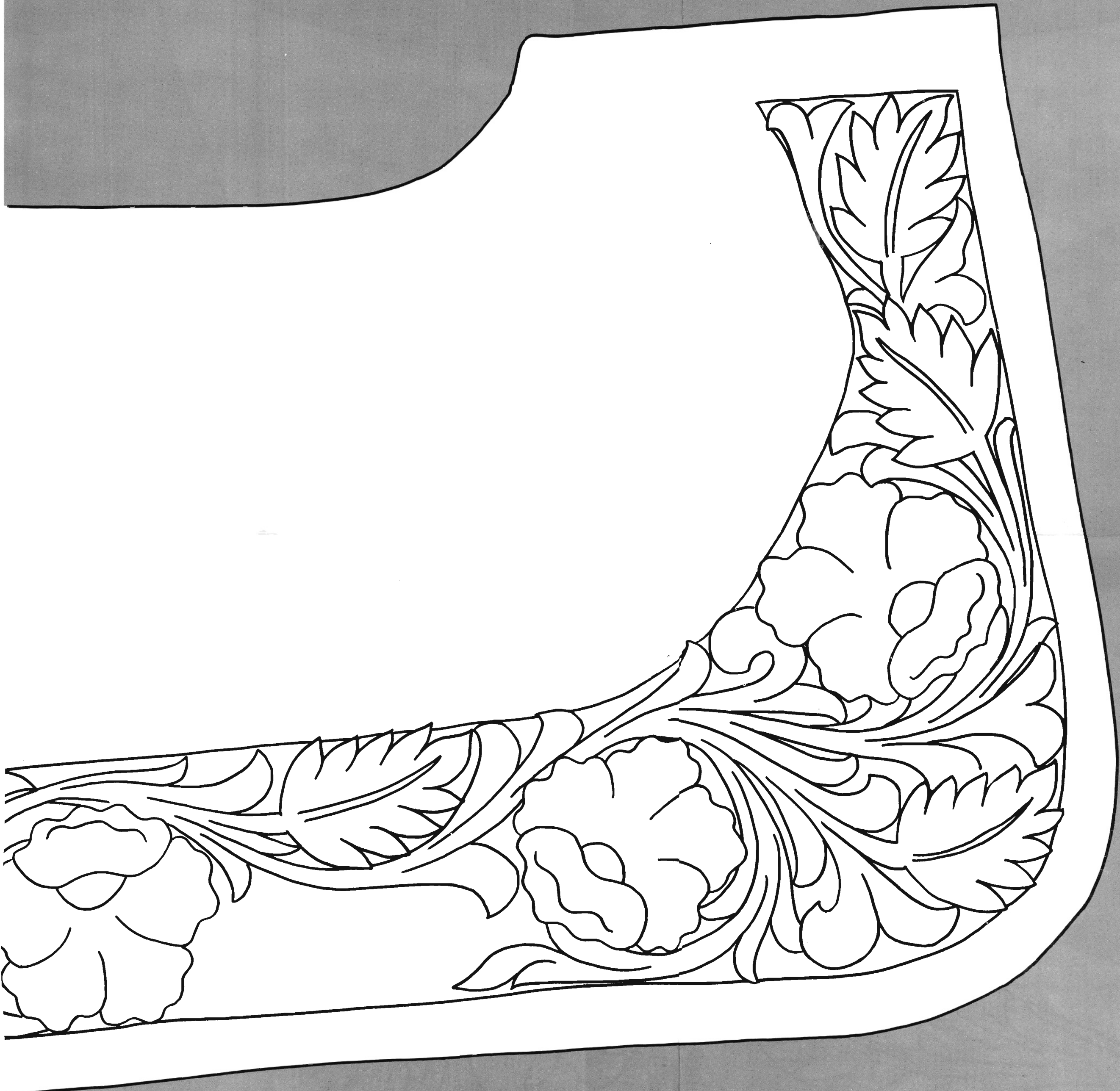
Can



tle Tracing Pattern

(Reverse Pattern for Left side.)

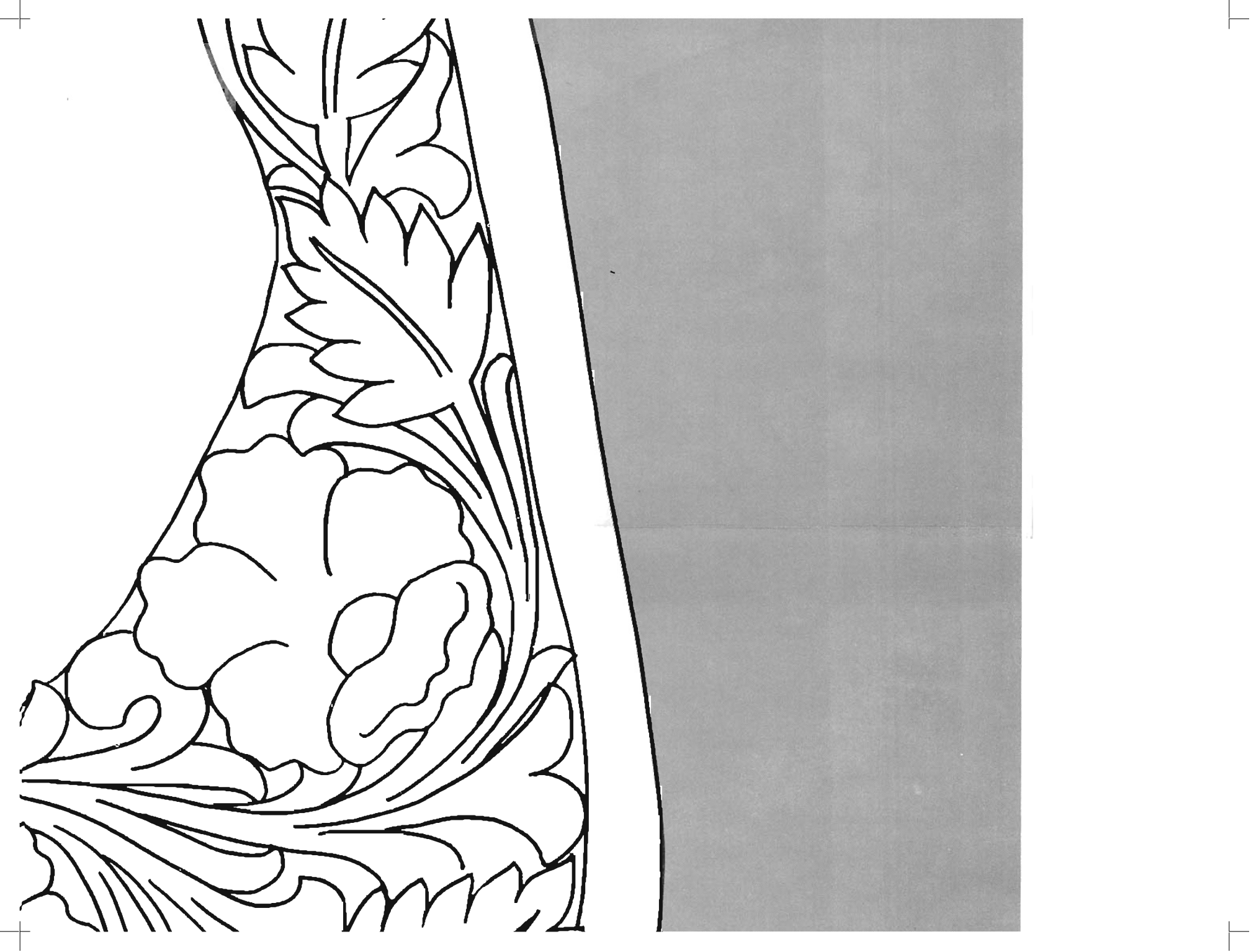
Skirt Tracing Pattern



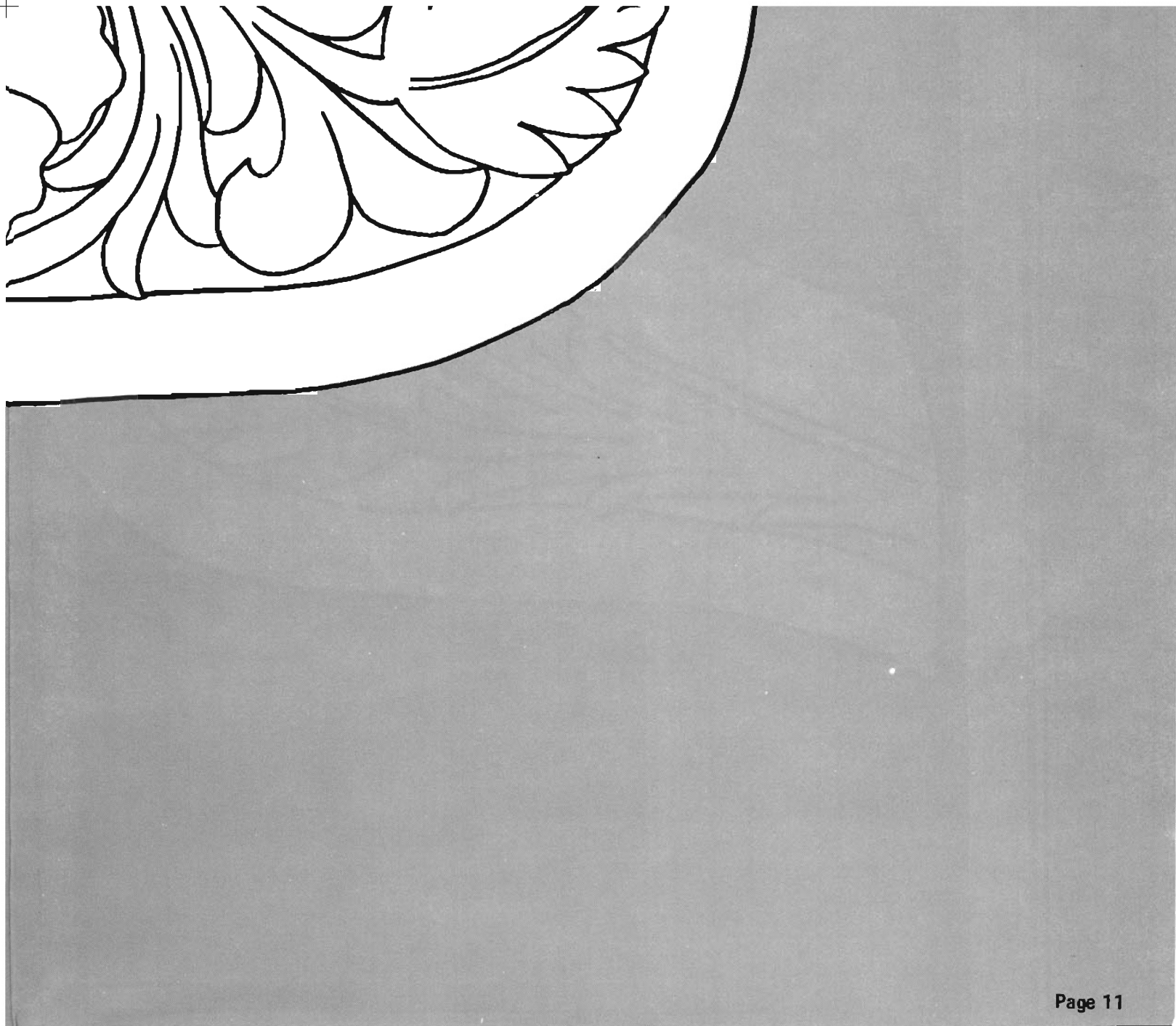
Skirt Tracing Pattern



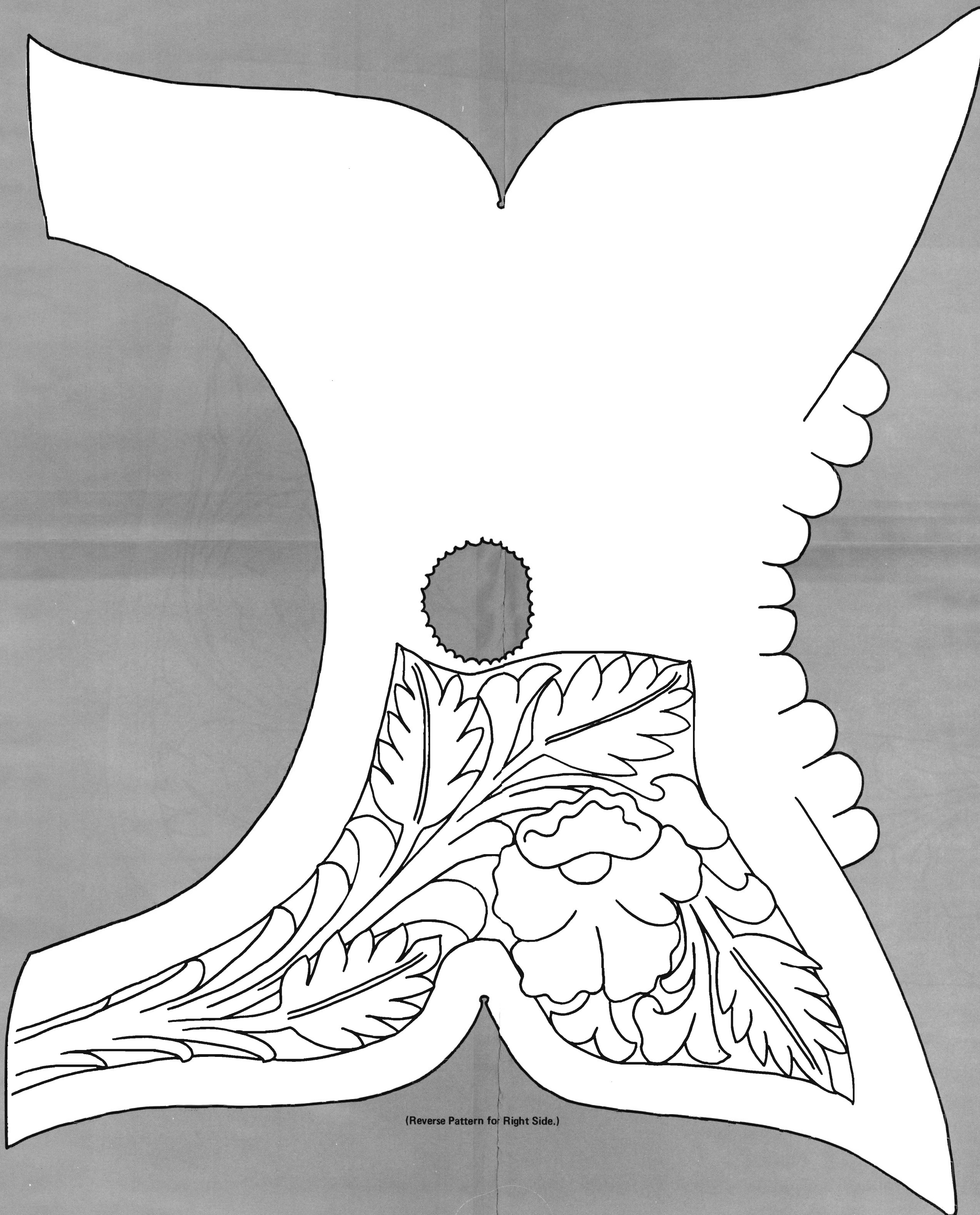






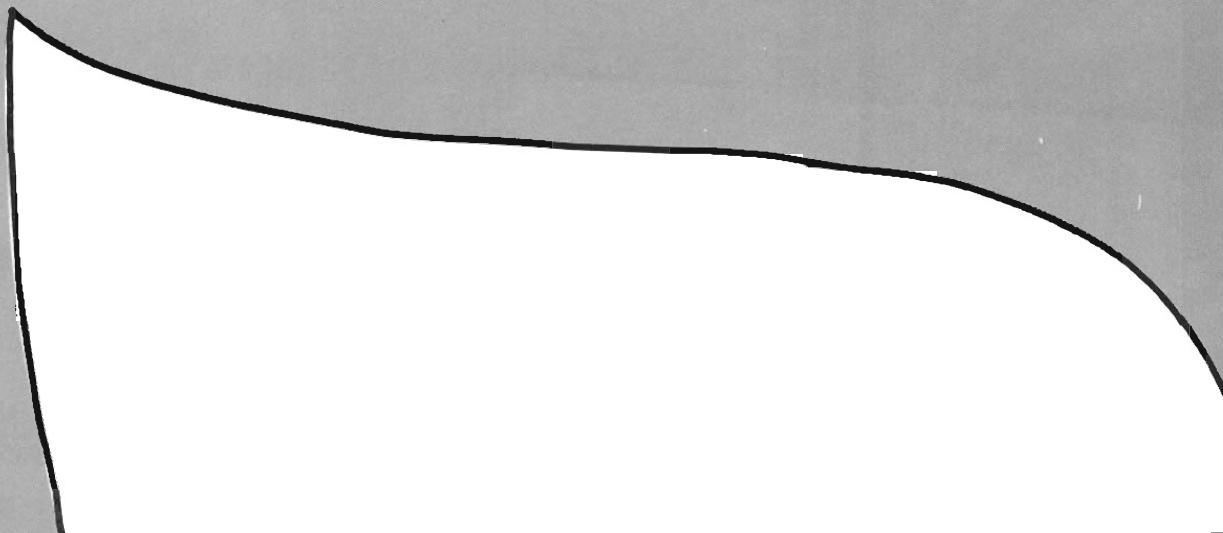


Fork and Swell Cover Tracing Pattern

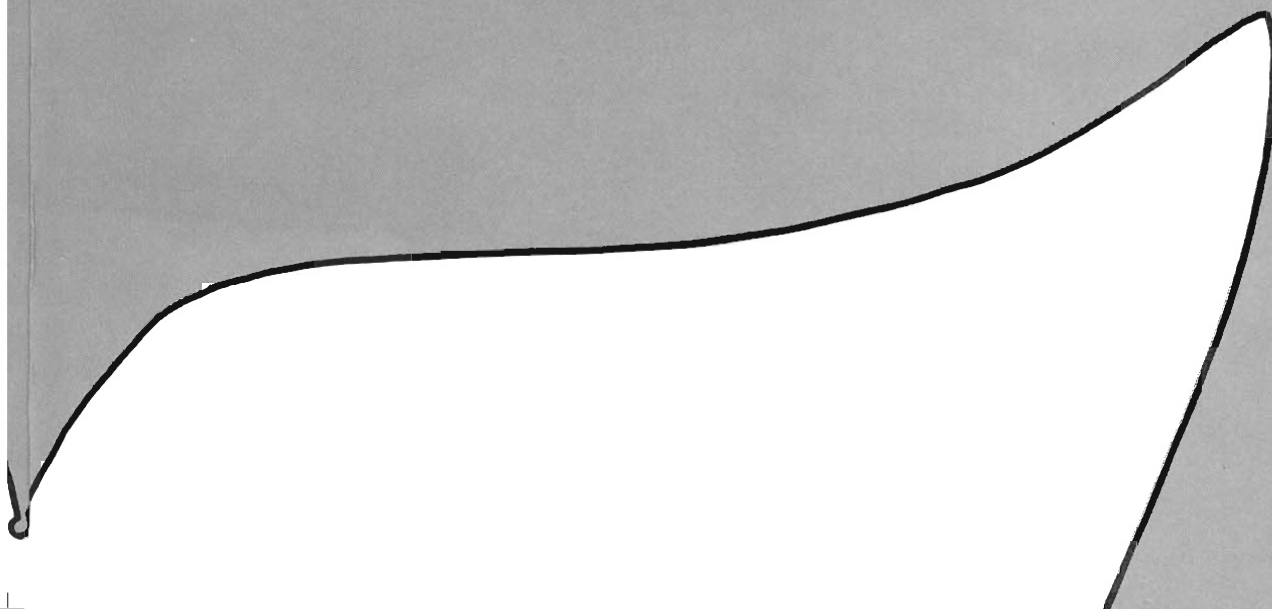


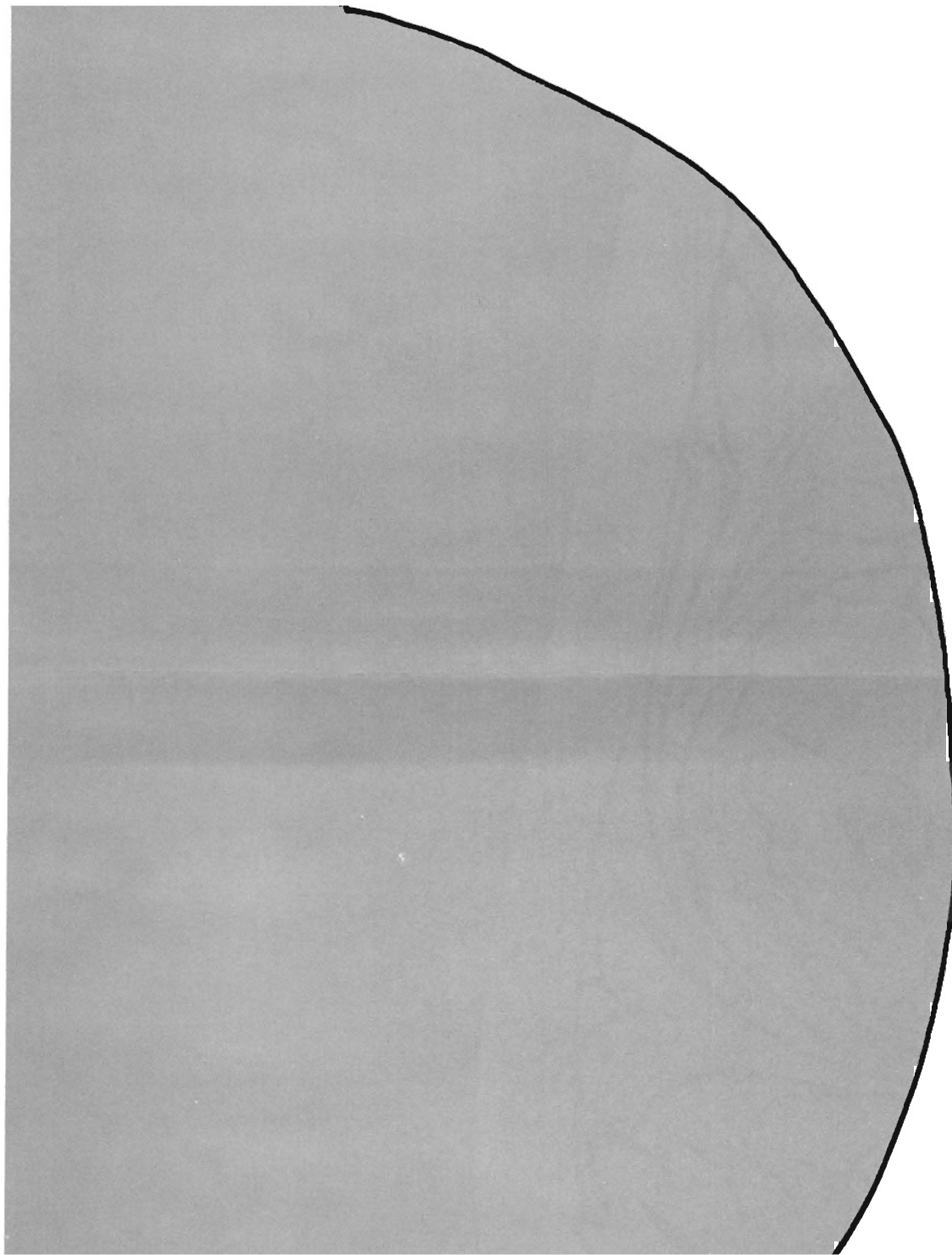
(Reverse Pattern for Right Side.)

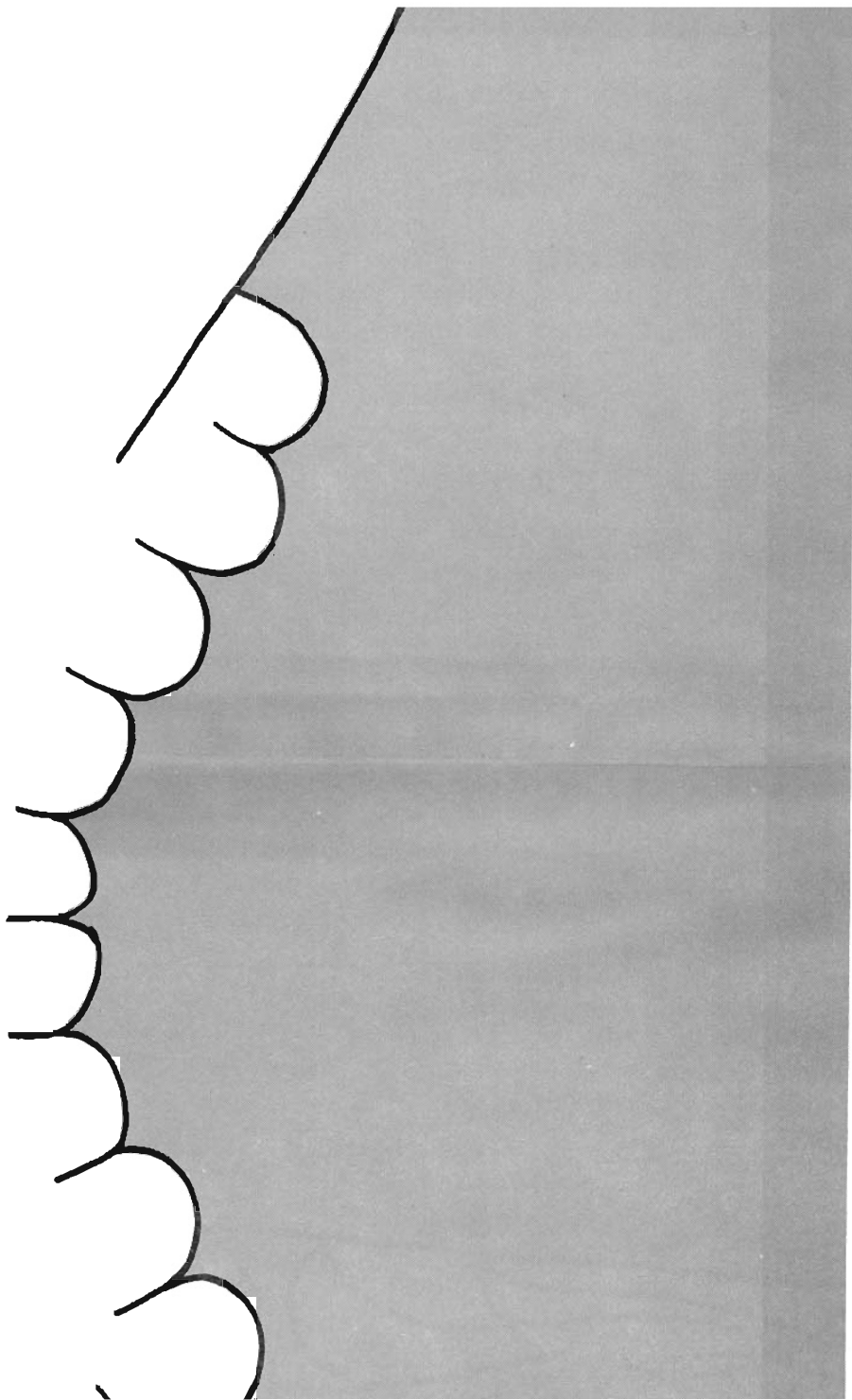
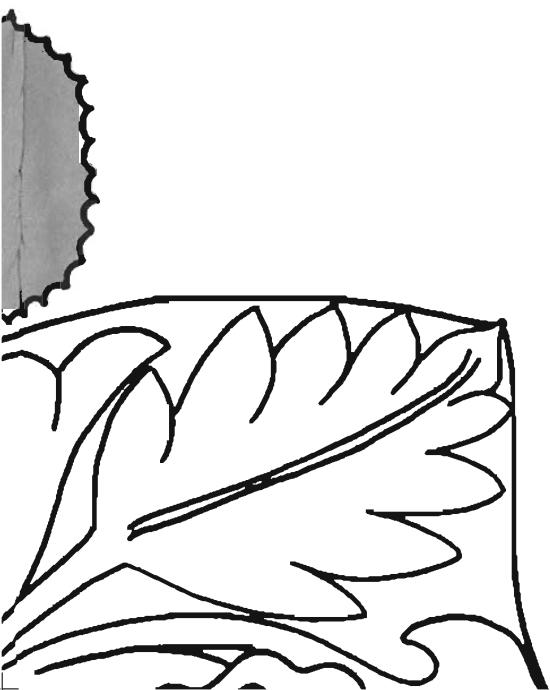
Fork and Tracing

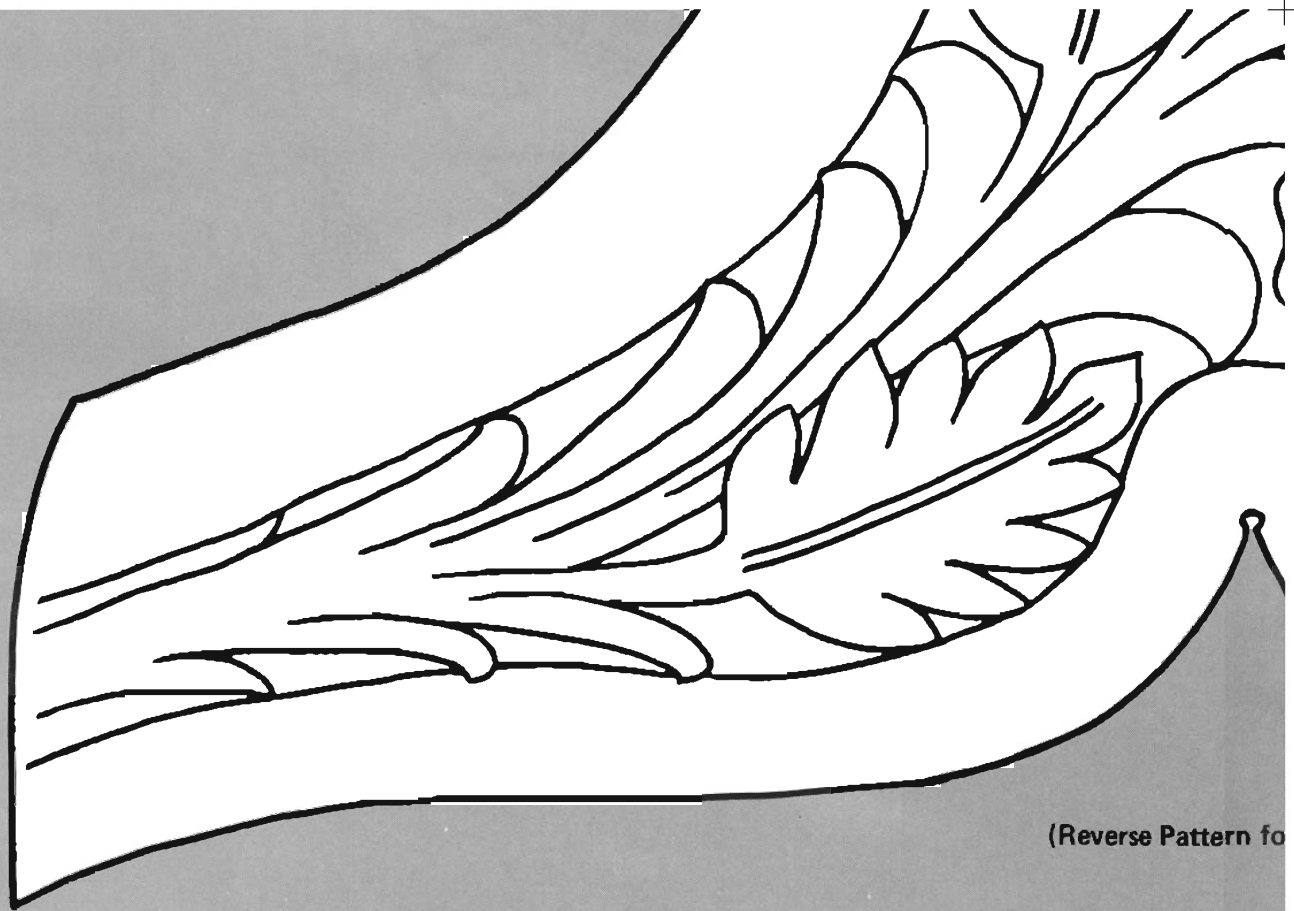


Swell Cover ing Pattern

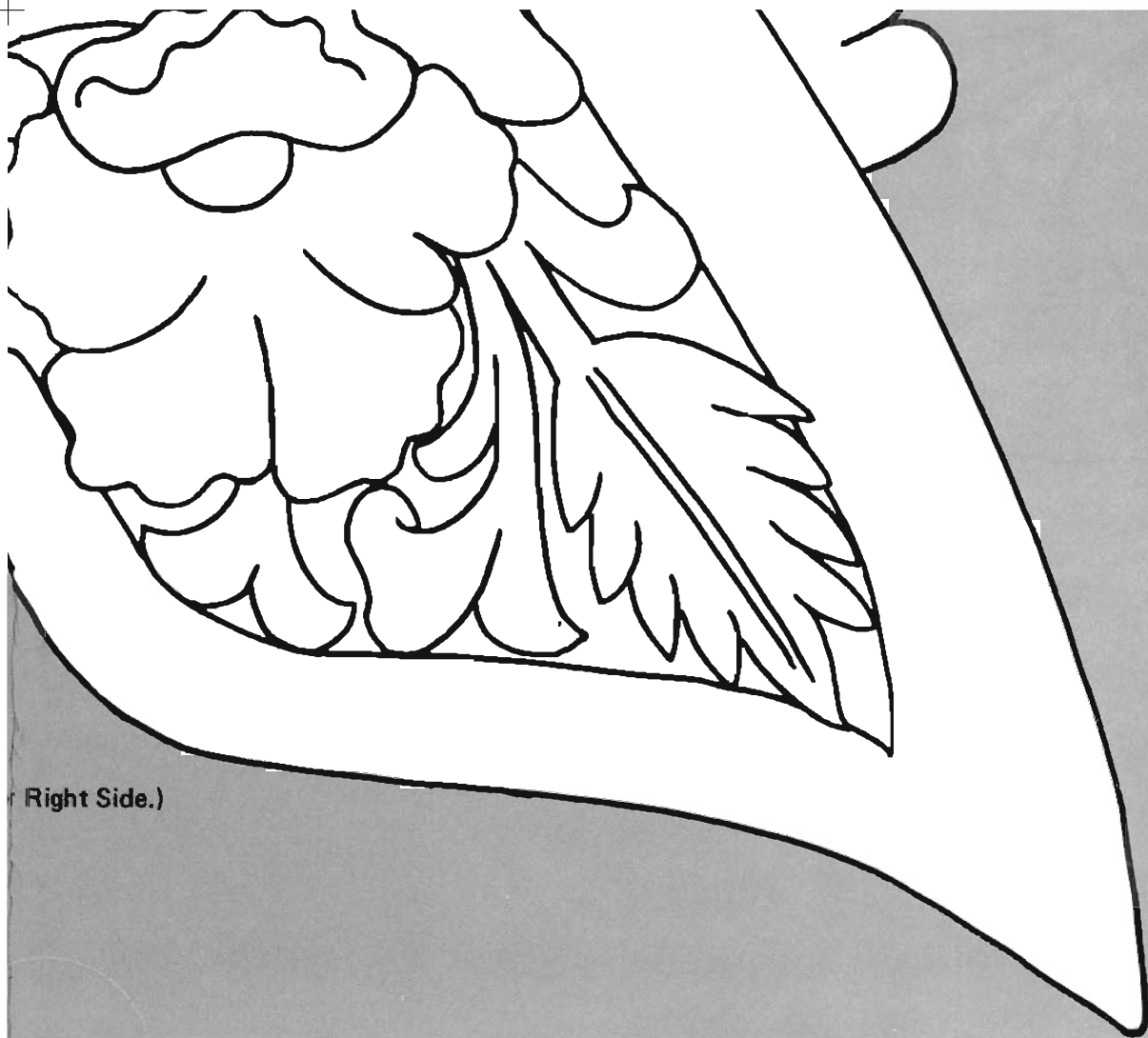








(Reverse Pattern fo



(Right Side.)



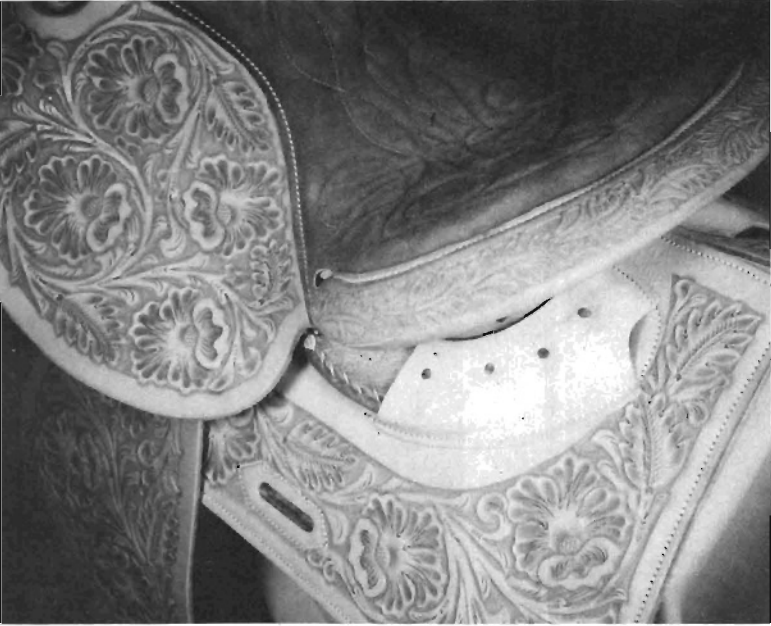
Step 53. Insert pointed end of stirrup leather (grain side up) between ground seat and bar.



Step 54. Bring leather around bar and back between bar and skirt. Install fender and stirrup leather on other side.



Step 55. Drive 7/8" tack through back bar pocket into bar.



Step 56. Drive 4-7/8" tacks into both back bar pockets.



Step 57. To secure front bars in front bar pocket, pull (with pliers or saddle awl) leather tightly around fork and tack with 7/8" tack.



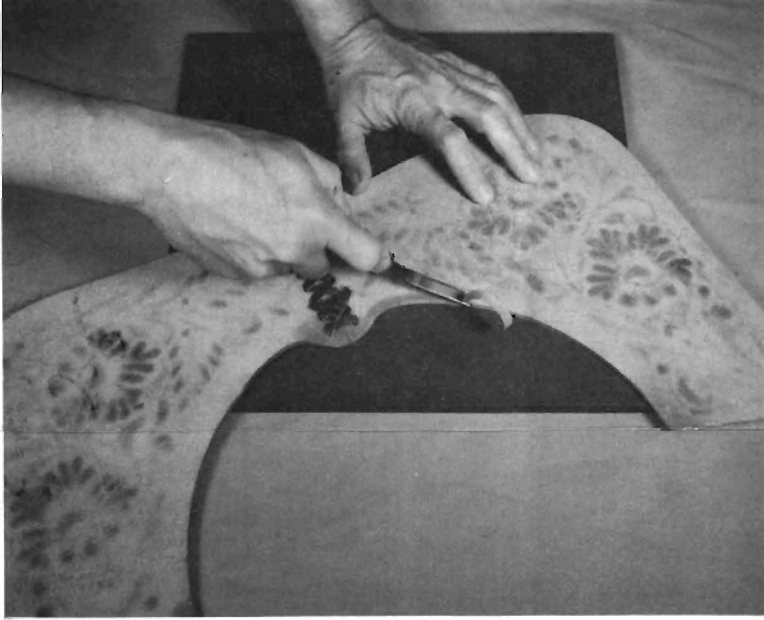
Step 58. Place 2 more tacks as shown. Tack other side in same manner. Using 1/8" bit, drill hole through leather and into bar.



Step 59. Drill and place 2-1" screws as shown, on each side.

VII Install Back Jockeys

Use 54" x 1/4" piece of lace to lace back jockeys together.



Step 60. Lace back jockey together. See tracing pattern for location of lacing holes (page 6) and lacing instructions (page 2). Skive inside edge (flesh side) of back jockey.



Step 61. Dampen inside edge of back jockey on flesh side. Push center of back jockey tightly up against back of cantle.



Step 62. Pull one side of back jockey tightly around base of cantle. Pull jockey so that lacing is about 1/4" off center and drive tack (1 1/8") about 1/2" from top front corner of jockey.

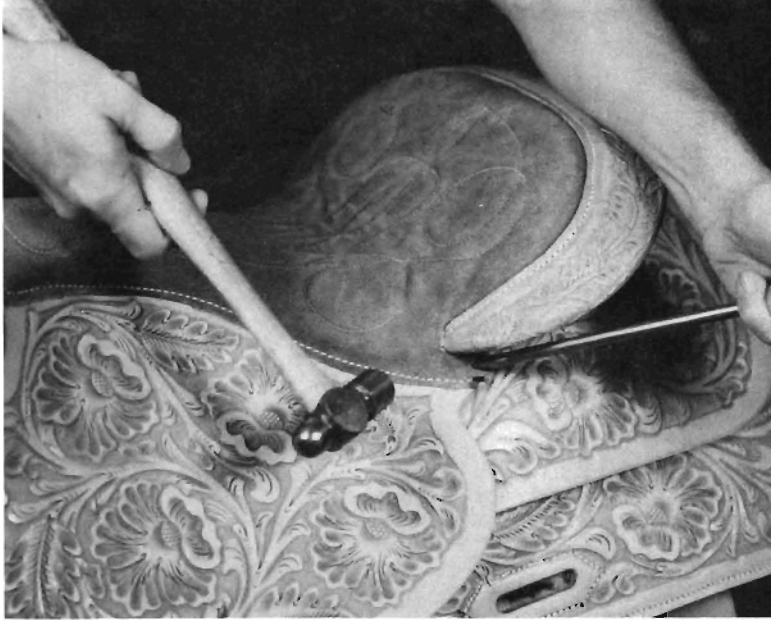


Step 63. On opposite side pull back jockey tightly around back of cantle.



Step 64. Back jockeys should be parallel to skirts at back and side. If they are not, you may have to trim inside edge of jockeys so they may be properly aligned. When you are sure of proper alignment, pull tightly around base of cantle (so lace centers properly in back) and tack as you did on other side.

VIII Installing Seat (Side and Front Jockeys)



Step 65. With saddlers awl pull "ear" of side jockey tightly around base of cantle. Drive tack (1 1/8") into "ear" just below awl. Tack opposite side also.



Step 66. Place leather rosette on "ear" and mark center. Rosette should cover tack and secure "ear" on side jockey.



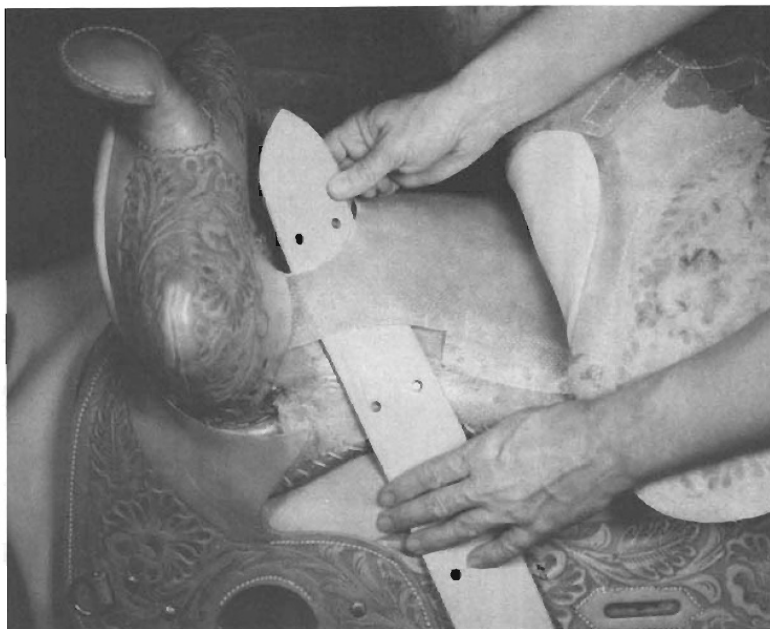
Step 67. Drill (with 1/8" bit) hole where center of rosette was marked. Mark and drill hole on opposite side also.



Step 68. Install rosettes with 1 1/2" screws (with washer).



Step 69. With saddlers awl, pull front jockey tightly around base of fork and drive (1 1/8") tack to hold in place. Tack opposite side.



Step 53. Insert pointed end of stirrup leather (grain side up) between ground seat and bar.

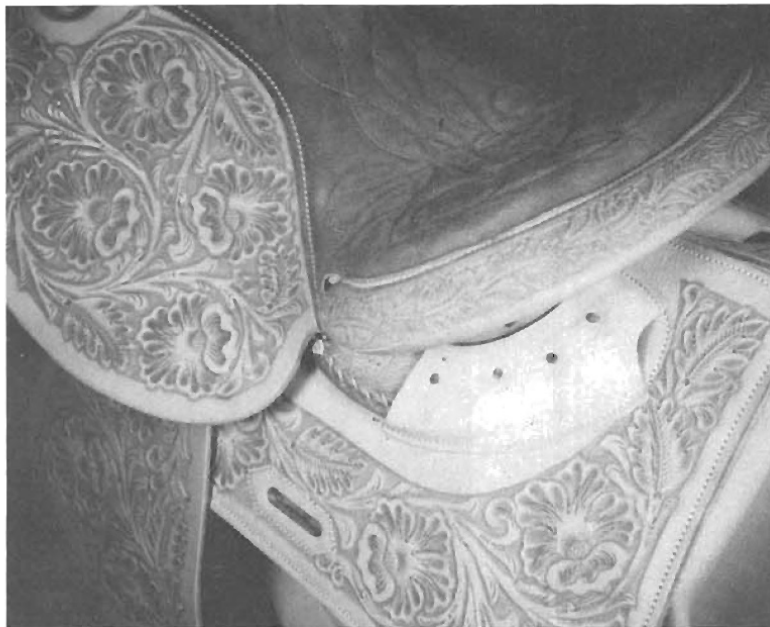


Step 54. Bring leather around bar and back between bar and skirt. Install fender and stirrup leather on other side.





Step 55. Drive 7/8" tack through back bar pocket into bar.



Step 56. Drive 4-7/8" tacks into both back bar pockets.





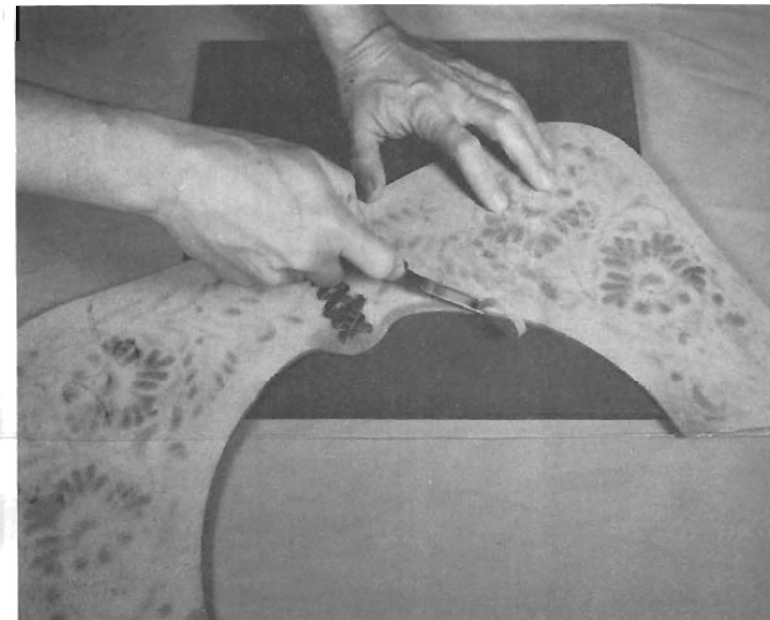
Step 57. To secure front bars in front bar pocket, pull (with pliers or saddle awl) leather tightly around fork and tack with 7/8" tack.



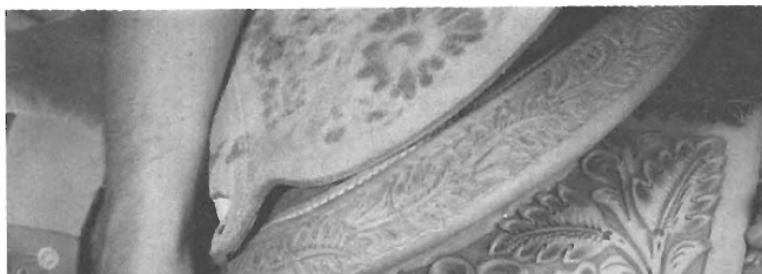
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VII Install Back Jockeys

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Step 61. Dampen inside edge of back jockey on flesh side. Push center of back jockey tightly up against back of cantle.



Step 62. Pull one side of back jockey tightly around base of cantle. Pull jockey so that lacing is about 1/4" off center and drive tack (1 1/8") about 1/2" from top front corner of jockey.

VIII

Installing Seat





Step 63. On opposite side pull back jockey tightly around back of cantle.



Step 64. Back jockeys should be parallel to skirts at back and side. If they are not, you may have to trim inside edge of jockeys so they may be properly aligned. When you are sure of proper alignment, pull tightly around base of cantle (so lace centers properly in back) and tack as you did on other side.



Step 66. Place leather rosette on "ear" and mark center. Rosette should cover tack and secure "ear" on side jockey.



Step 67. Drill (with 1/8" bit) hole where center of rosette was marked. Mark and drill hole on opposite side also.

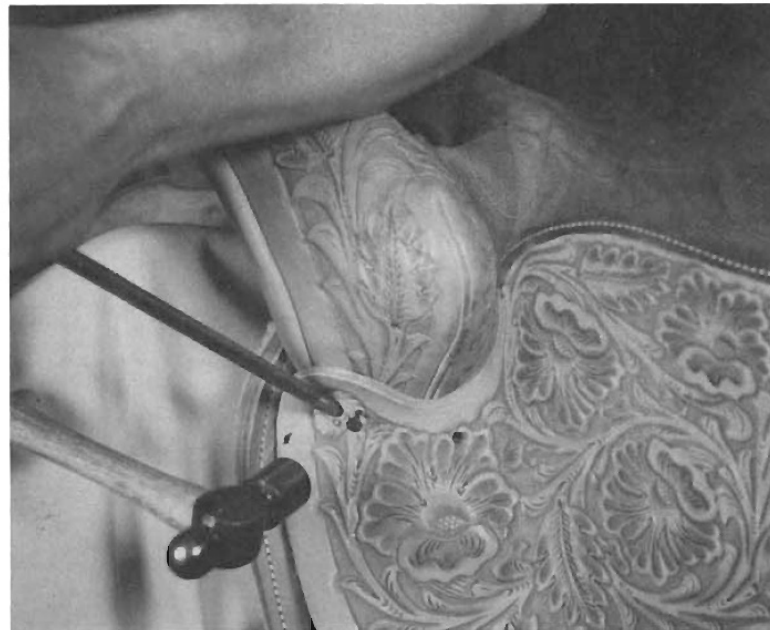
[Side and Front Jockeys]



Step 65. With saddlers awl pull "ear" of side jockey tightly around base of cantle. Drive tack (1 1/8") into "ear" just below awl. Tack opposite side also.



Step 68. Install rosettes with 1 1/2" screws (with washer).



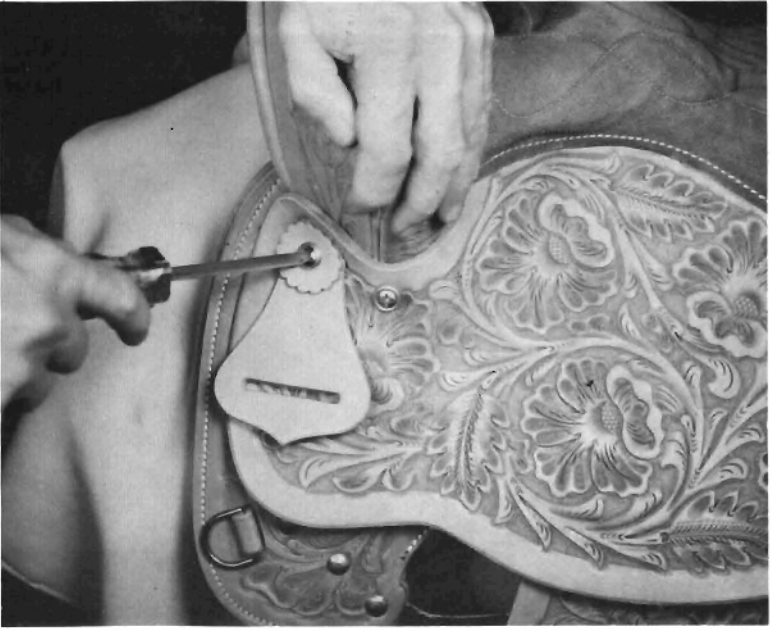
Step 69. With saddlers awl, pull front jockey tightly around base of fork and drive (1 1/8") tack to hold in place. Tack opposite side.



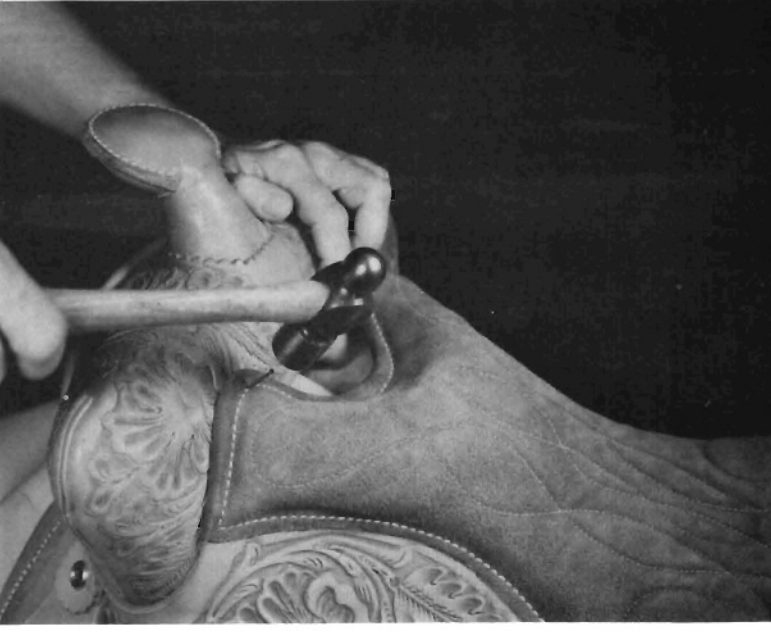
Step 70. Drill hole (1/8" drill bit) 3/4" from edge of jockey and just behind side seam. Install 1 1/2" screw and washer.



Step 71. Drill hole (1/8" drill bit) just below tack, in front jockey.



Step 72. Install tie strap holder (left side only) and rosette with 1 1/2" screw and washer. Drill holes and install rosette, screws and washers on opposite side.

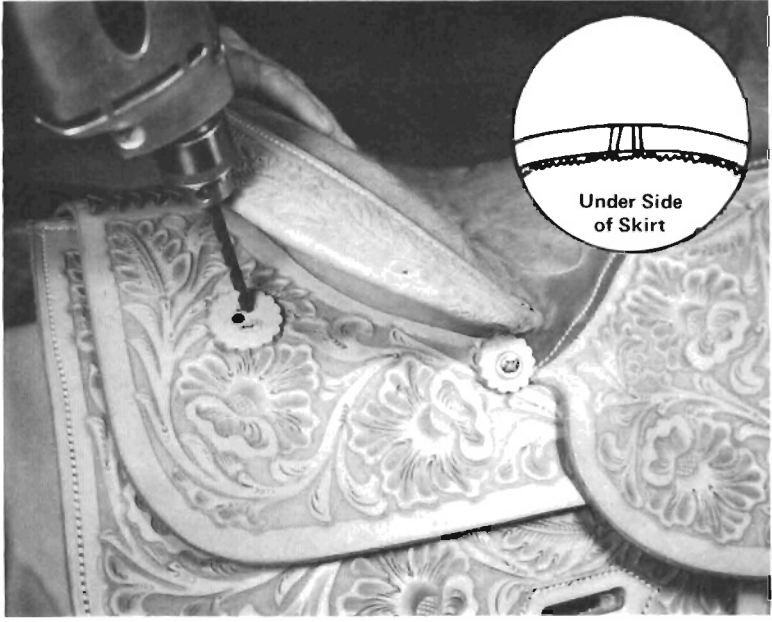


Step 73. At top front point of seat, drive ribbed nail through stitching hole and into back of fork. Drive nail on other side in similar manner.

VIX Install Leather Rosettes and Tie Strings on Back Jockey



Step 74. On back jockey, center large rosette with 2 slots (grain side up) 4 1/4" from center of lacing and 3 1/4" from back edge of jockey. Drive (1 1/8") tack through leather and into bar to hold rosette in place.



Step 75. Drill (with 1/4" drill bit) holes for tie strings. When drilling holes for tie strings tilt drill slightly so holes will be farther apart on the under-side of skirt (see illustration).



Step 76. Point and insert strings through, from underside of skirt (wool side). Pull up through slots in large rosette then place small rosette (with slots) on strings. Tie bleed knot as close to rosettes as possible. (See bleed knot instructions on page 2.) Install rosettes and string on other side.

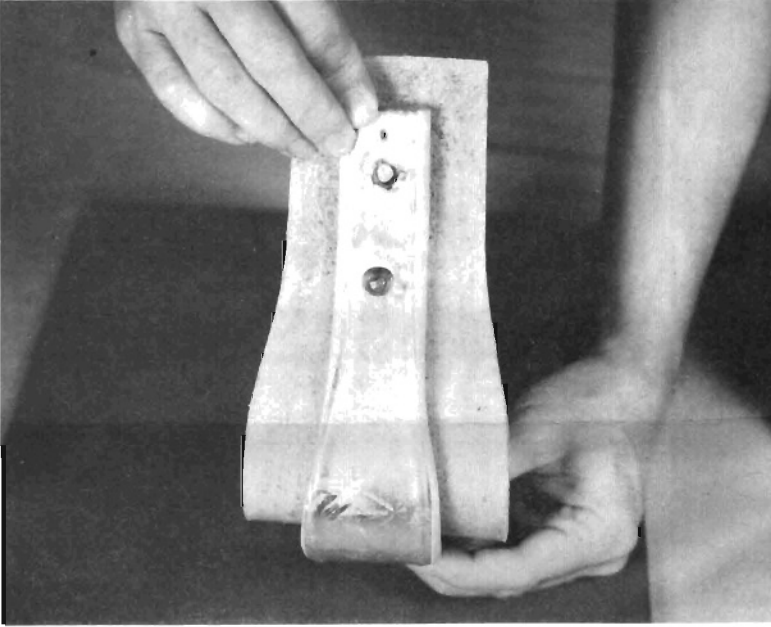
X Covering Stirrups



Step 77. Apply contact type cement (Craftsman) to flesh side of stirrup lining. (Apply cement to both halves.)



Step 78. Apply Craftsman cement to inside of stirrup.



Step 79. When cement becomes tacky, place 2 halves of lining to inside of stirrup, aligning bolt hole in linings and stirrups and centering linings and stirrups.



Step 80. Install bolt, roller and nut on stirrup. Saw or grind end of bolt off even with nut.



Step 81. Dampen stirrup linings.



Step 82. With fingers, form stirrup linings around sides of stirrup.



Step 83. Scribe line 1/4" from edge around sides and top of 2 stirrup covers.



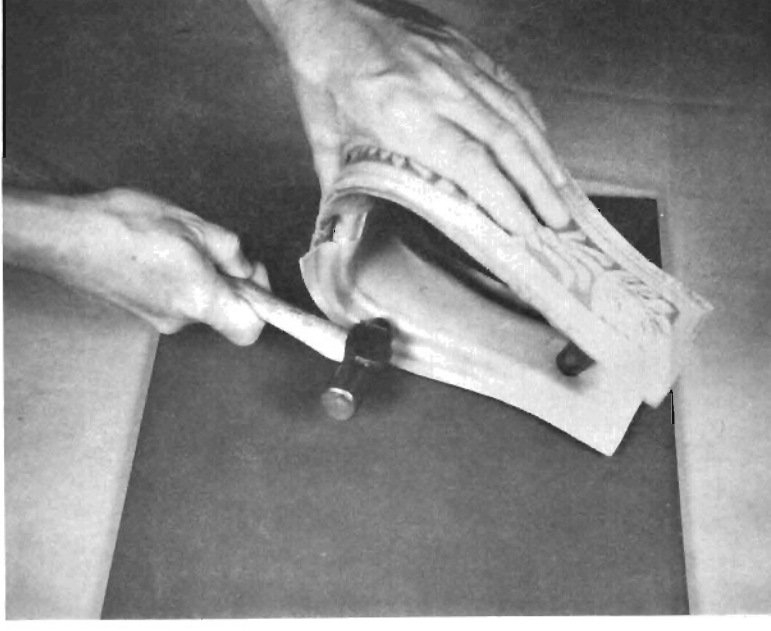
Step 84. With #5 Craftool spacer or overstitch, mark stitching holes along scribed line.



Step 85. Apply Craftsman cement to stirrup covers and outside of stirrup. Centering stirrup covers on stirrup (leaving 3/8" of stirrup cover above top of stirrup) begin sticking cover and lining together at edges.



Step 86. Stirrup cover will remain flat and lining is brought around stirrup to meet cover. Trim cover off at bottom if 2 halves overlap.



Step 87. After covers and lining are stuck together at edges, use round end of ball-peen hammer to form lining around stirrup.



Step 70. Drill hole (1/8" drill bit) 3/4" from edge of jockey and just behind side seam. Install 1 1/2" screw and washer.

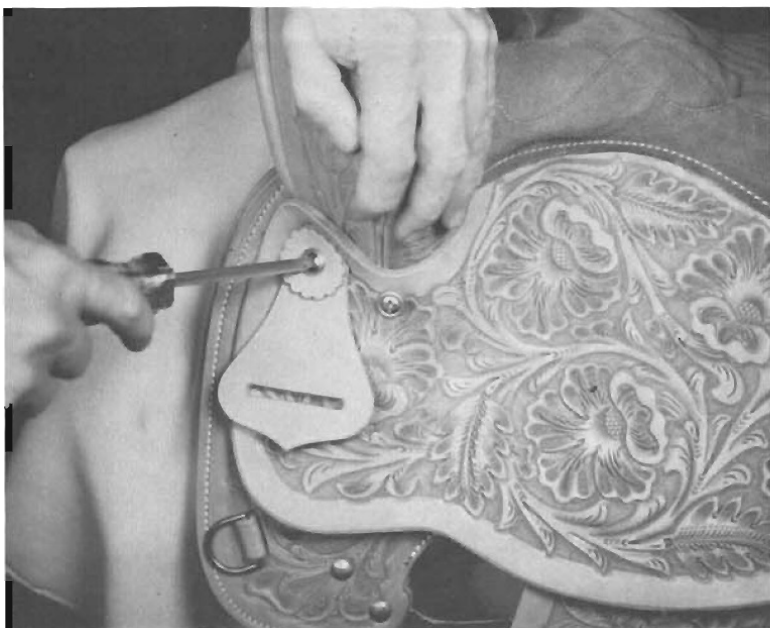


Step 71. Drill hole (1/8" drill bit) just below tack, in front jockey.

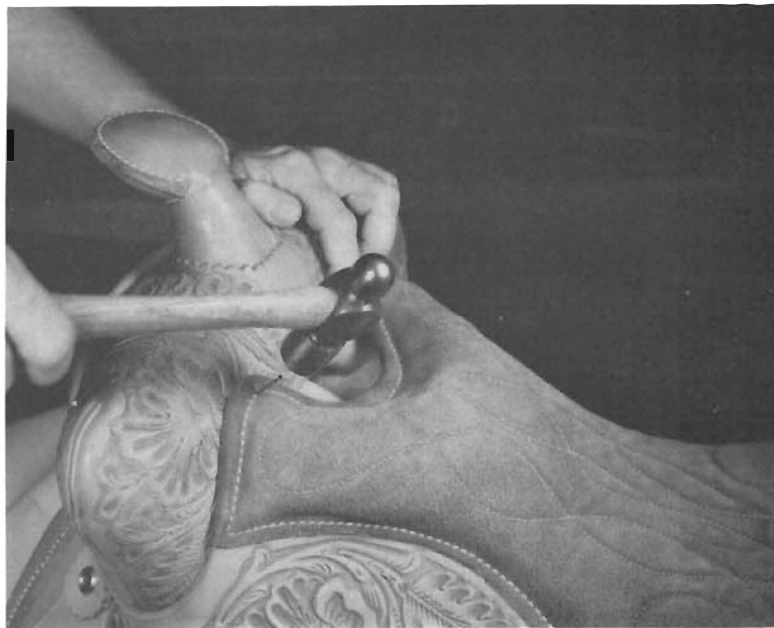
VIX

Install Leather Rosettes and Tie Strings on Back

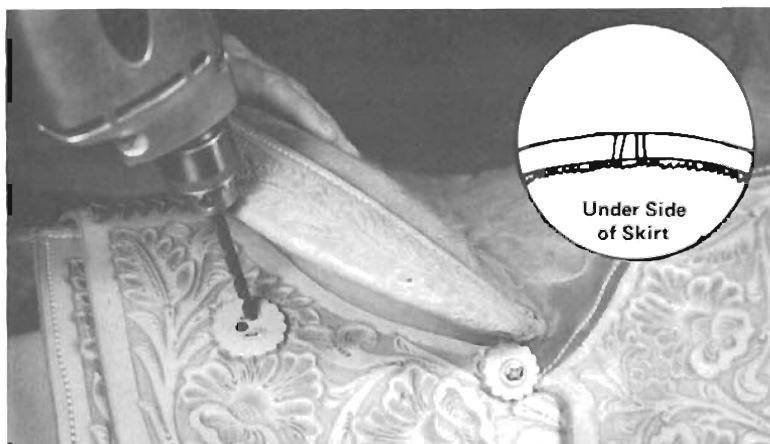




Step 72. Install tie strap holder (left side only) and rosette with 1 1/2" screw and washer. Drill holes and install rosette, screws and washers on opposite side.



Step 73. At top front point of seat, drive ribbed nail through stitching hole and into back of fork. Drive nail on other side in similar manner.

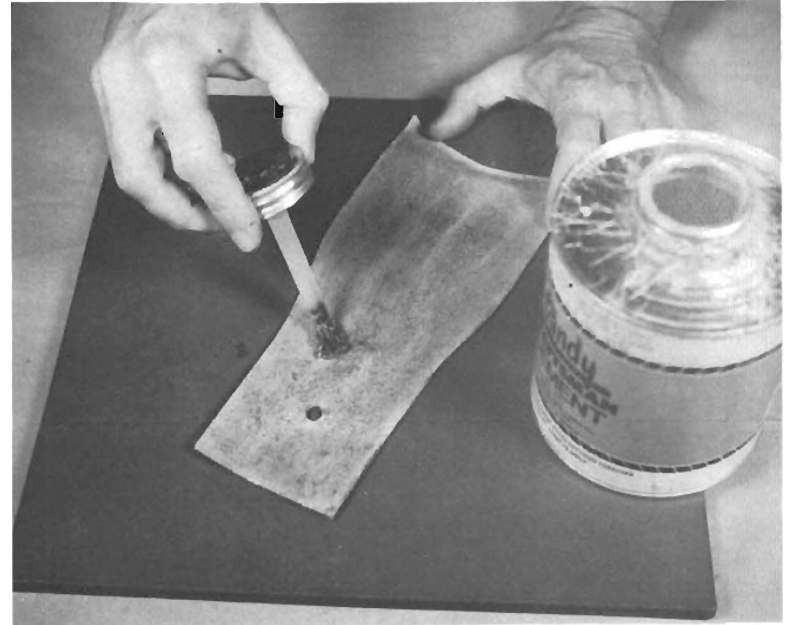


Jockey



Step 74. On back jockey, center large rosette with 2 slots (grain side up) 4 1/4" from center of lacing and 3 1/4" from back edge of jockey. Drive (1 1/8") tack through leather and into bar to hold rosette in place.

X Covering Stirrups

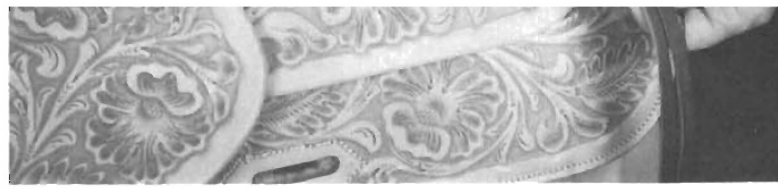


Step 77. Apply contact type cement (Craftsman) to flesh side of stirrup lining. (Apply cement to both halves.)

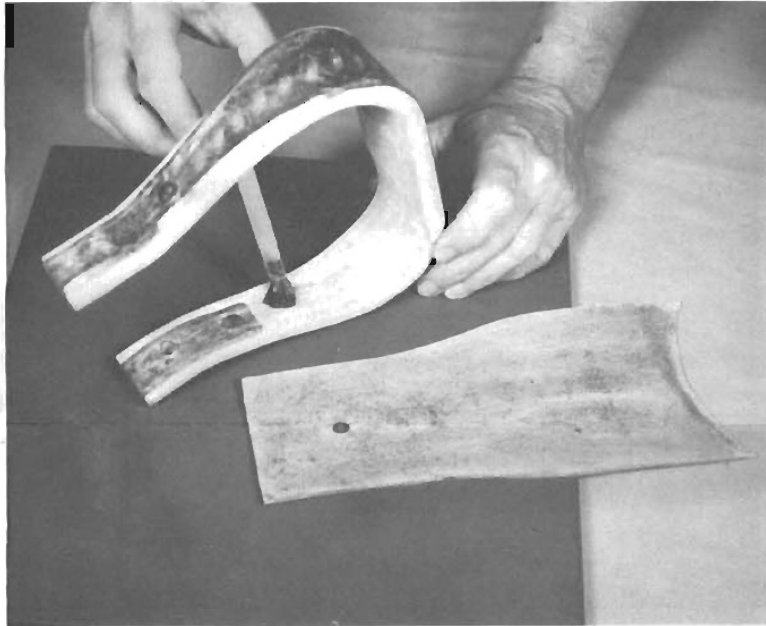




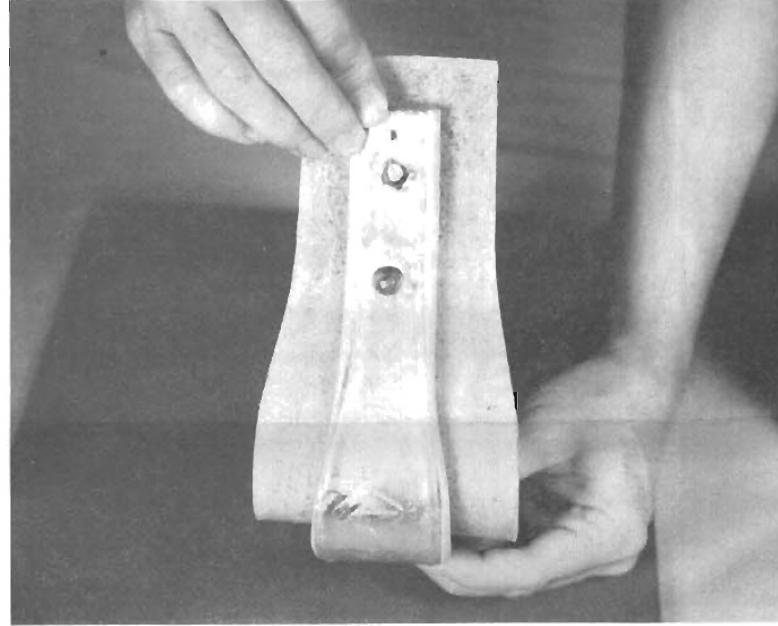
Step 75. Drill (with 1/4" drill bit) holes for tie strings. When drilling holes for tie strings tilt drill slightly so holes will be farther apart on the under-side of skirt (see illustration).



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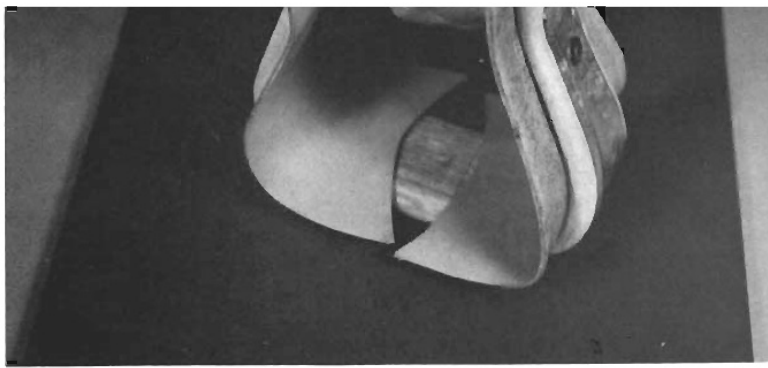


Step 78. Apply Craftsman cement to inside of stirrup.

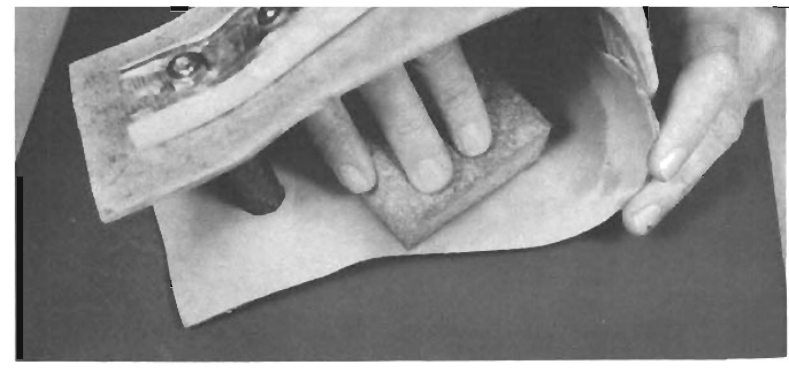


Step 79. When cement becomes tacky place 2 halves of lining to inside of stirrup, aligning bolt hole in linings and stirrups and centering linings and stirrups.

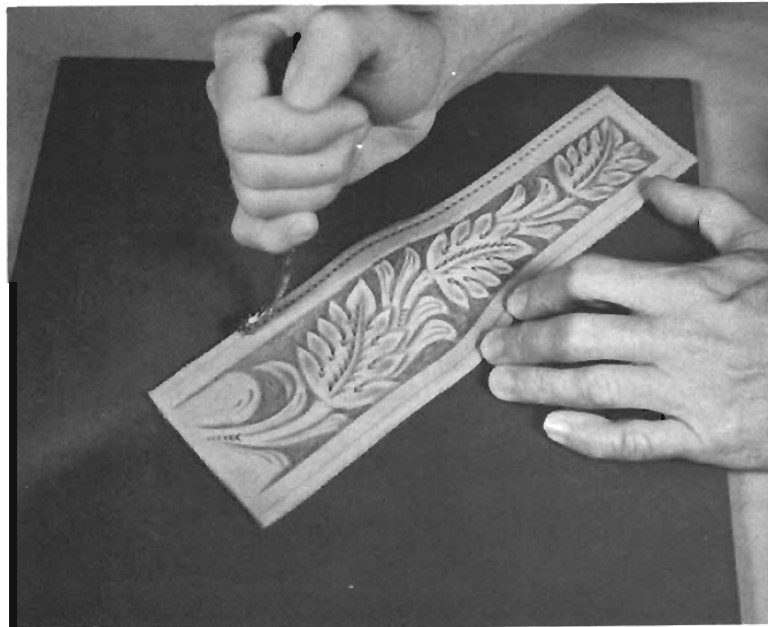




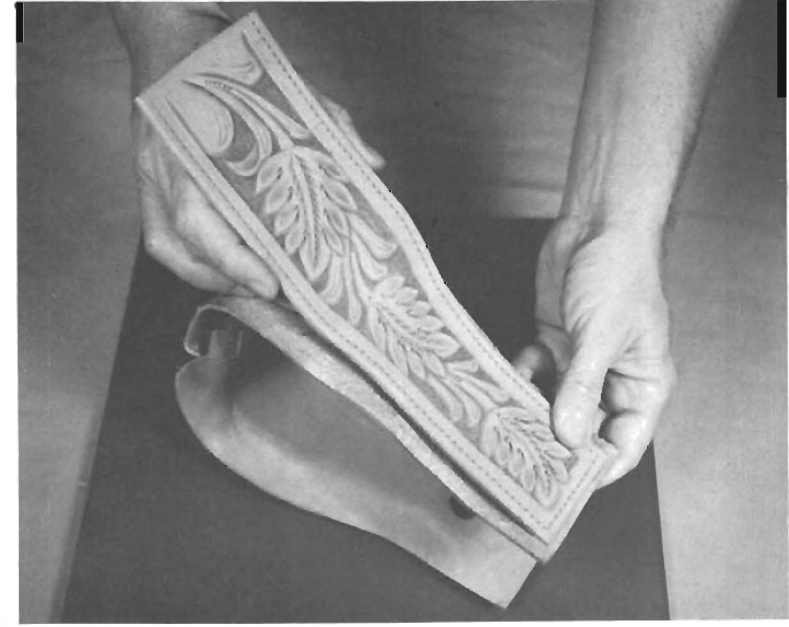
Step 80. Install bolt, roller and nut on stirrup. Saw or grind end of bolt off even with nut.



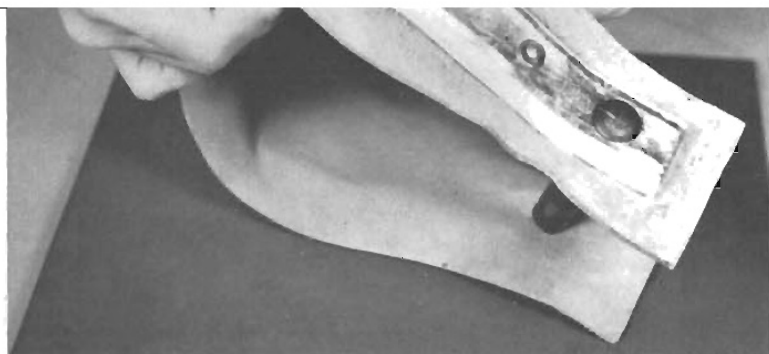
Step 81. Dampen stirrup linings.



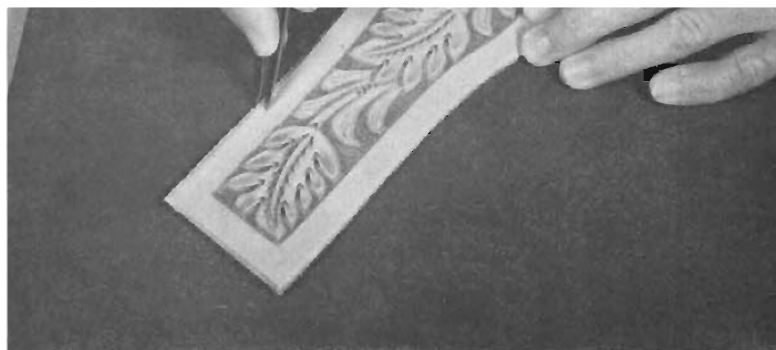
Step 84. With #5 Crafttool spacer or overstretch, mark stitching holes along scribed line.



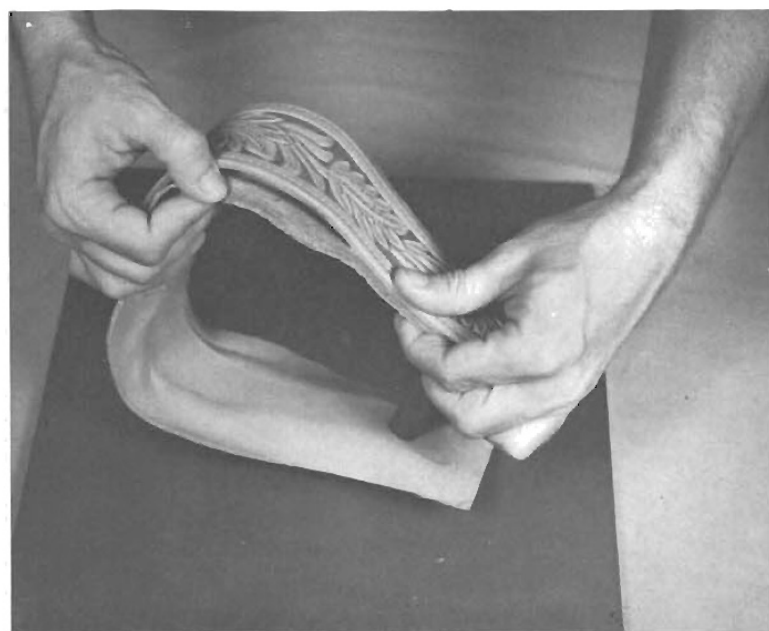
Step 85. Apply Craftsman cement to stirrup covers and outside of stirrup. Centering stirrup covers on stirrup (leaving 3/8" of stirrup cover above top of stirrup) begin sticking cover and lining together at edges.



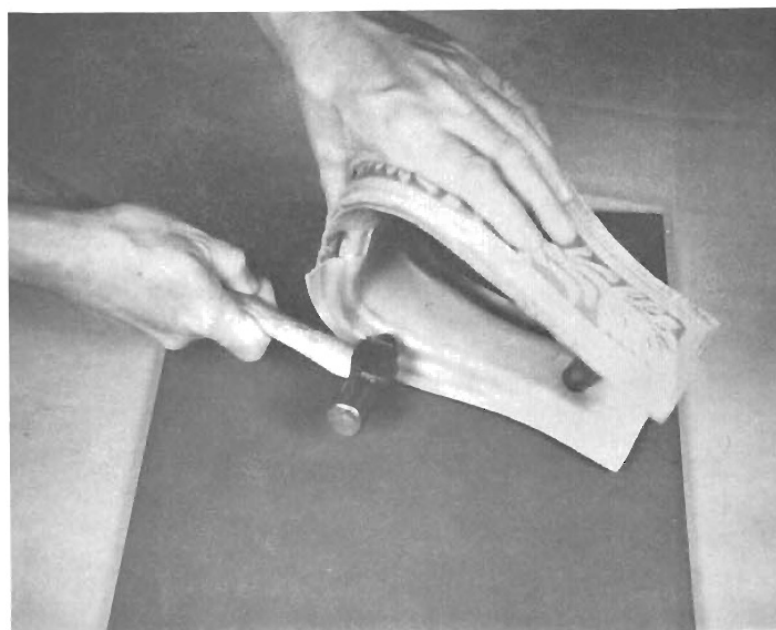
Step 82. With fingers, form stirrup linings around sides of stirrup.



Step 83. Scribe line 1/4" from edge around sides and top of 2 stirrup covers.



Step 86. Stirrup cover will remain flat and lining is brought around stirrup to meet cover. Trim cover off at bottom if 2 halves overlap.



Step 87. After covers and lining are stuck together at edges, use round end of ball-peen hammer to form lining around stirrup.



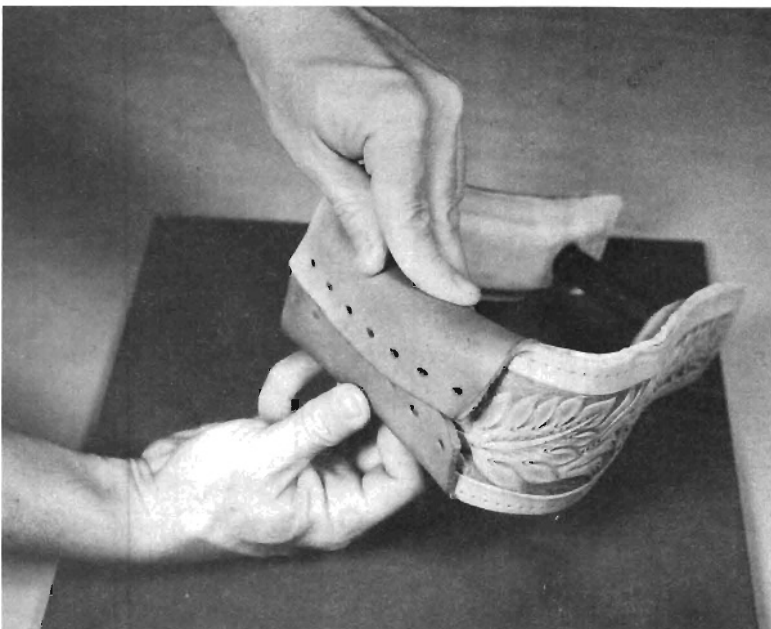
Step 88. Trim surplus lining off even with edges of covers.



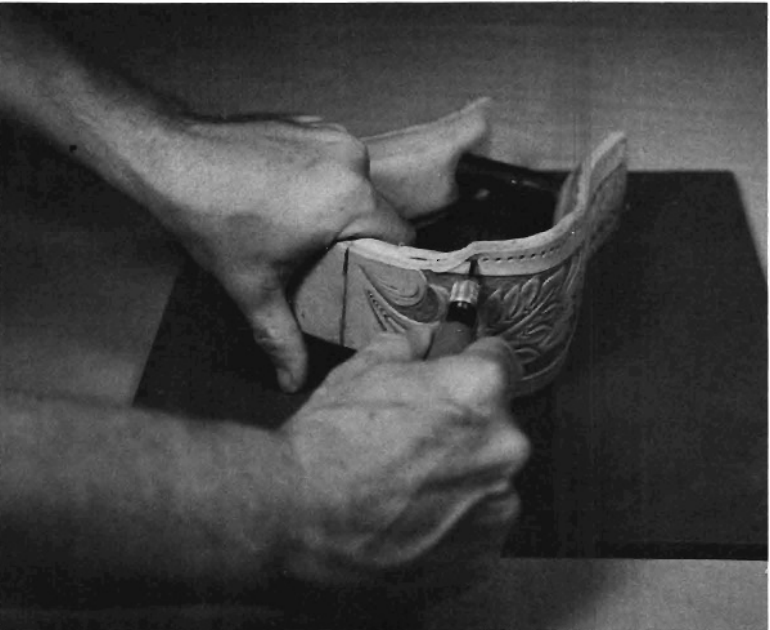
Step 89. Dampen thread cover, center, and form around bottom of stirrup. With awl, mark (on bottom of stirrup) 4 points where tread cover wraps around edges of stirrup bottom.



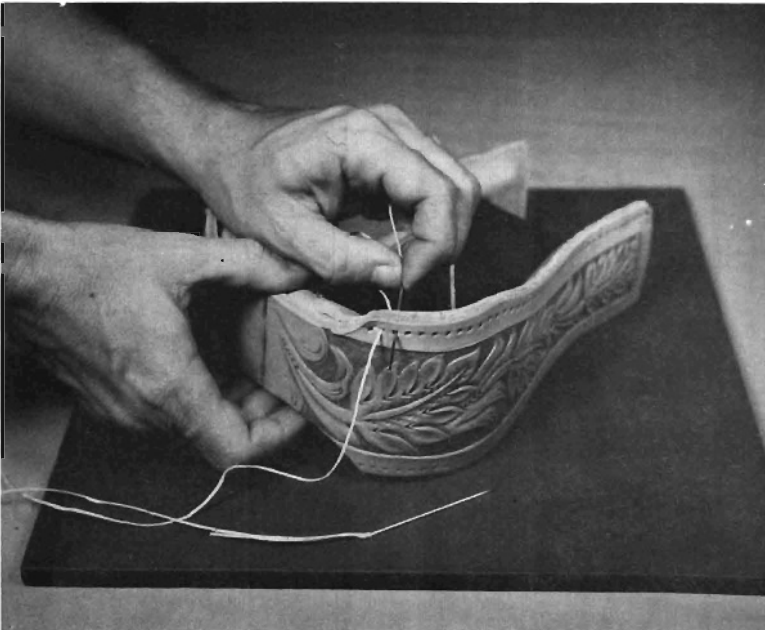
Step 90. Between the points you have marked on stirrup bottom, trim cover and lining off next to edge of stirrup.



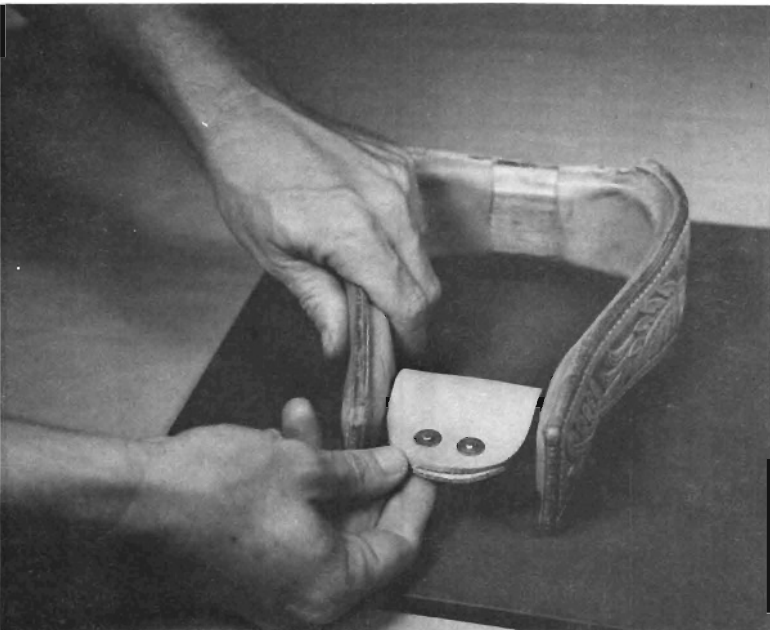
Step 91. Form damp tread cover around stirrup again to check fit. Edges should meet at bottom of stirrup.



Step 92. At first stitching mark on one side of bottom of stirrup, stab hole with awl through cover and lining. All stitching holes may be made with awl now. (See page 2 for proper use of awl.)

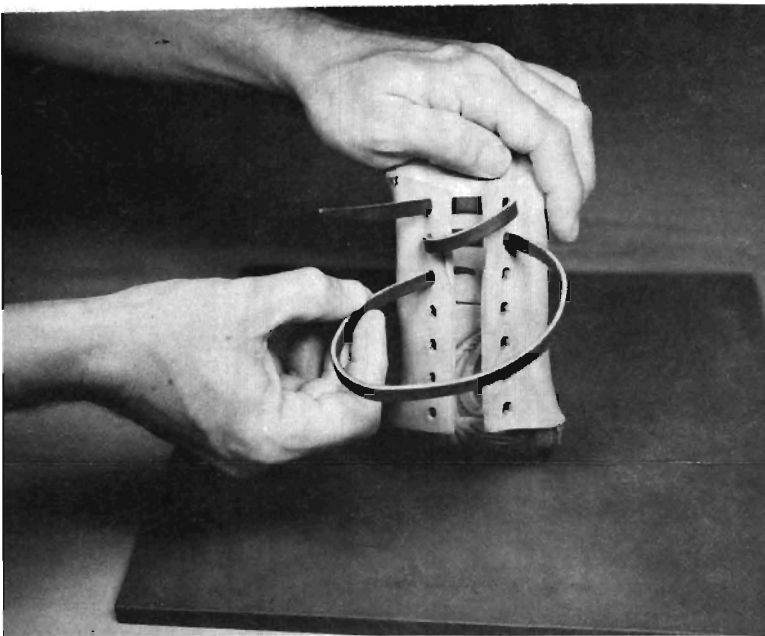


Step 93. Begin sewing at bottom of stirrup as shown. (See page 2 for stitching instructions.) Sew around one half of stirrup. Sew other side of stirrup.

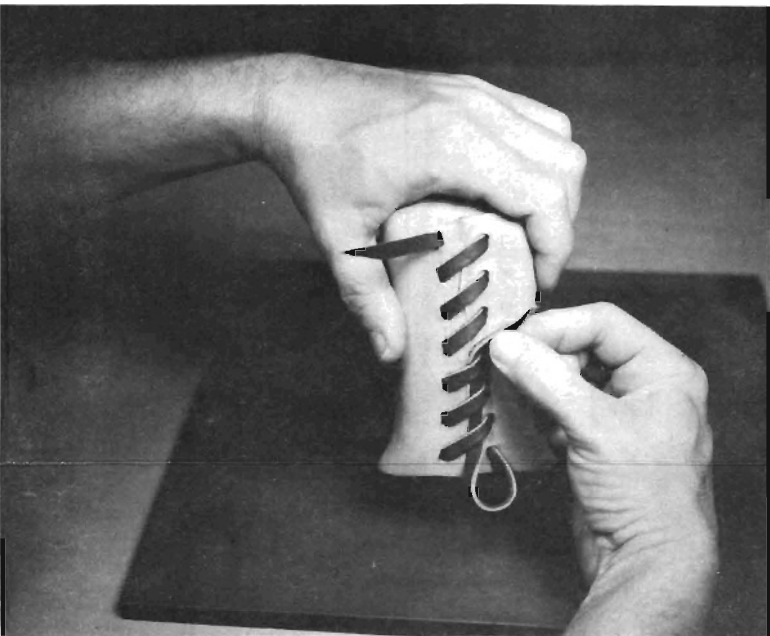


Step 94. Fold bolt cover and punch 2 holes with #5 punch. Insert 2 1/2" copper rivets, place washers and set. Cut rivets off if too long.

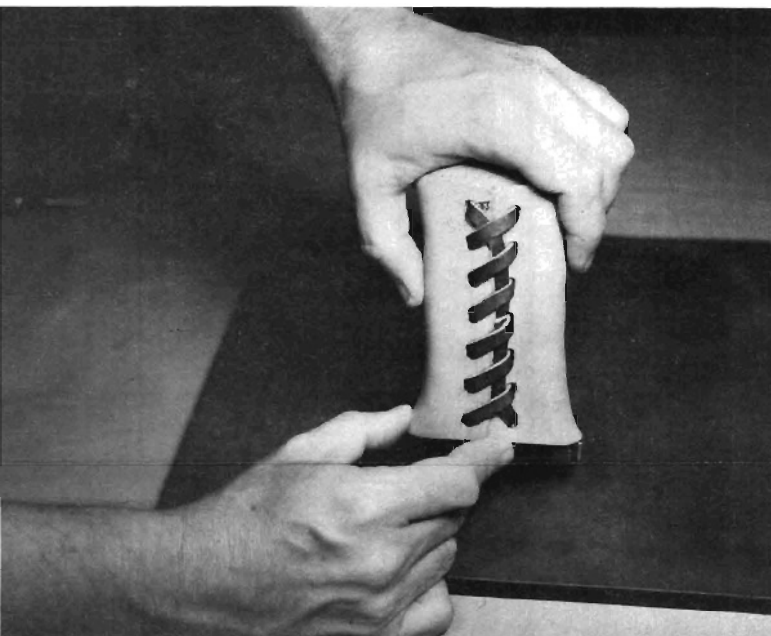
XI Installing Tread Cover



Step 95. Point ends of 20" piece of 1/4" lace and begin lacing tread cover (from grain side) as shown, leaving about 3" of lace outside first hole.

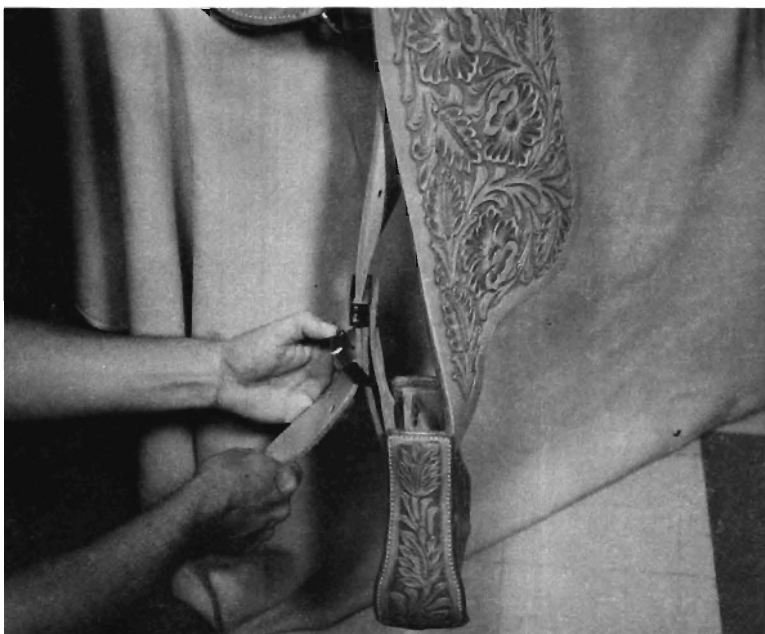


Step 96. Lace through last hole then insert lace under three laces (on grain side) to center of stirrup and trim off.

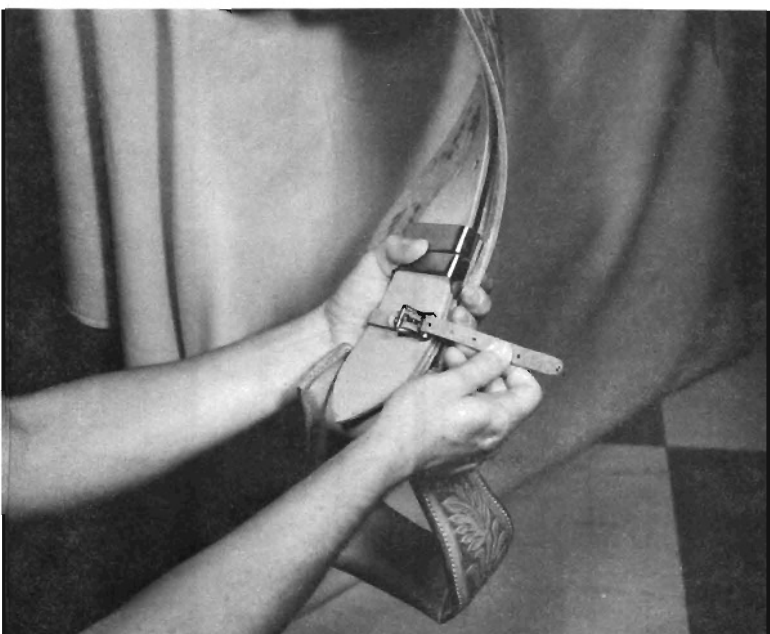


Step 97. Insert beginning end of lace under 3 laces to center and trim off. Hammer laces flat.

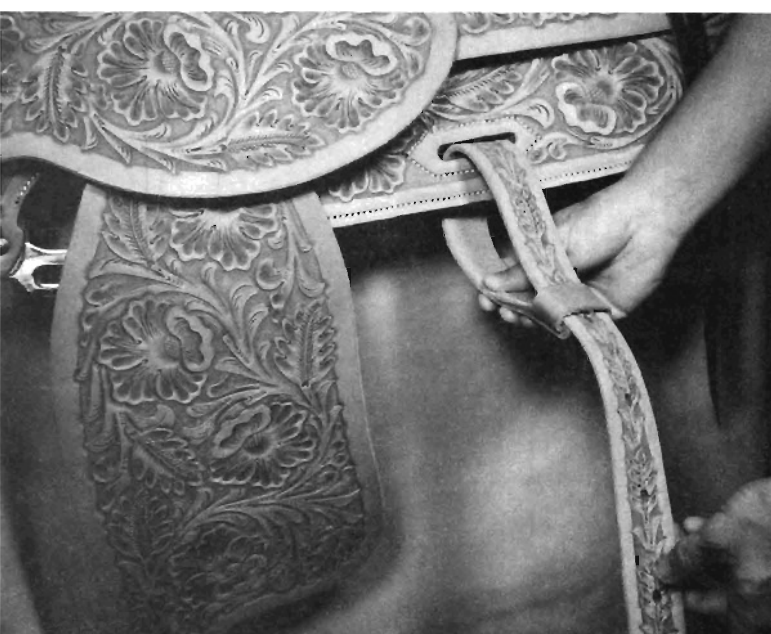
XII Installing Stirrups and Rigging



Step 98. Insert stirrup leathers through stirrups, adjust to desired length and buckle.



Step 99. Buckle hobble straps around stirrup leathers.



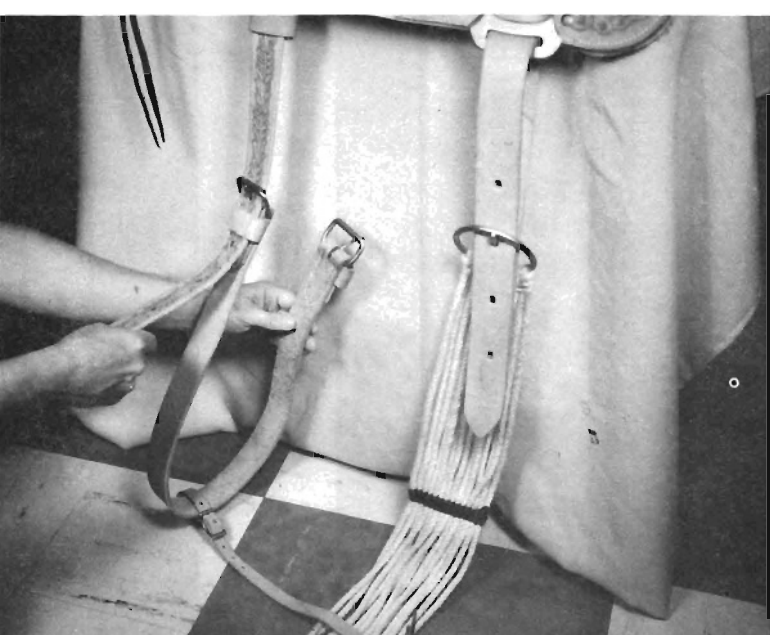
Step 100. Install flank cincha billets as shown.



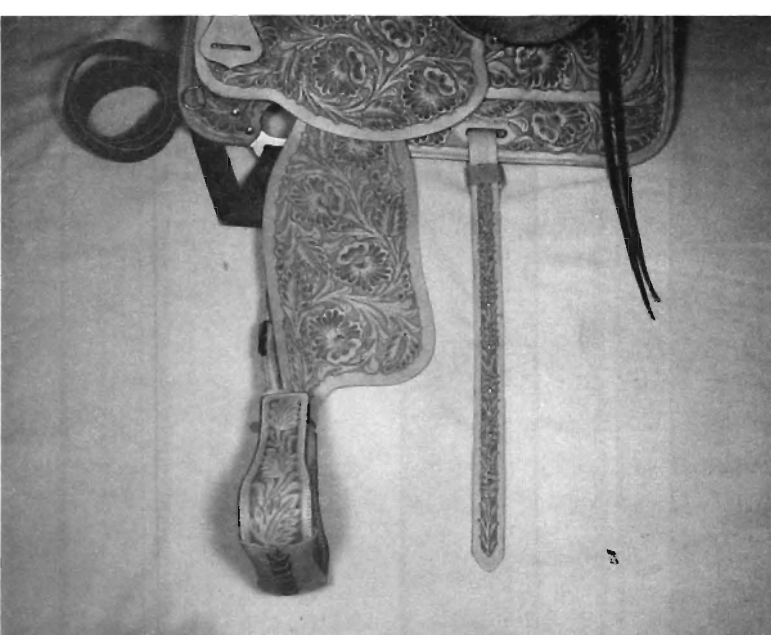
Step 101. Install tie strap with 3 hole tie as shown.



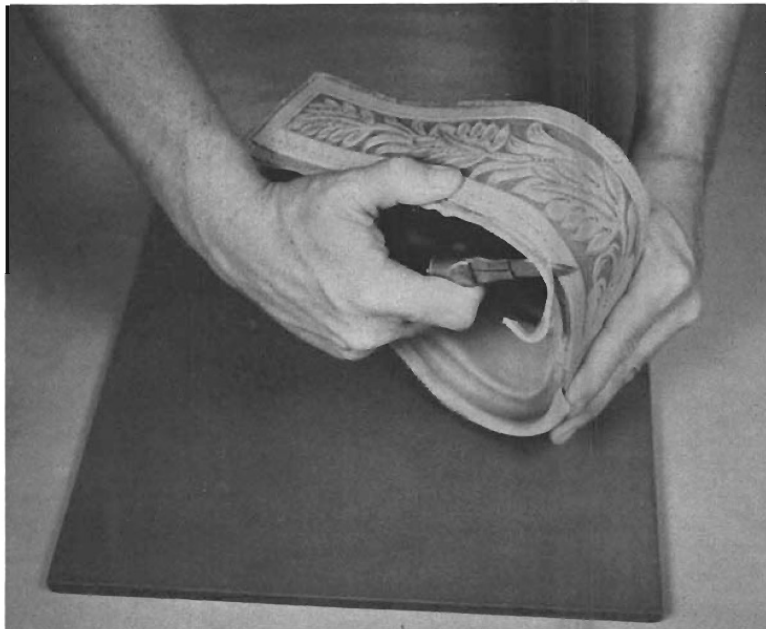
Step 102. Install off strap and girth.



Step 103. Install center body of flank cincha with connector strap attached. Lace end of connector strap to center of girth.



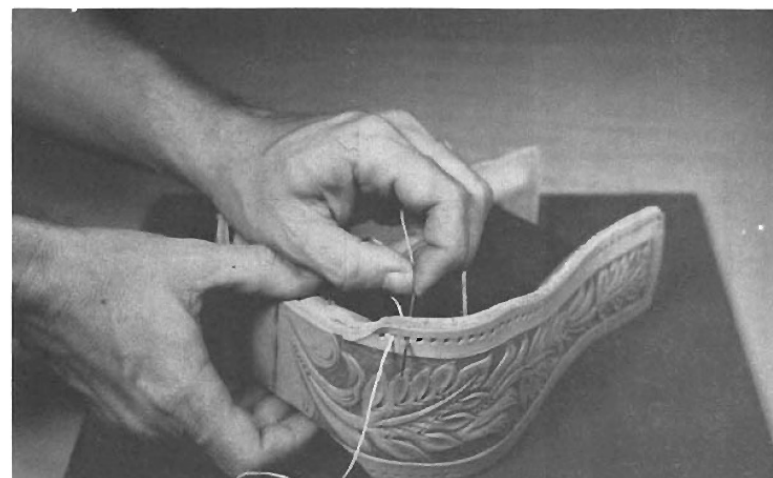
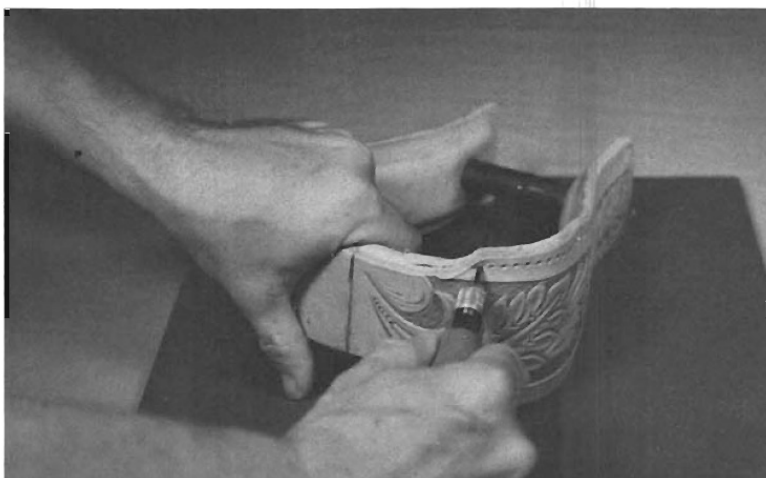
Step 104. After adjusting stirrup leathers to desired length, place saddle flat on floor. Dampen lower part of fenders (on flesh side) and stirrup leathers. Turn stirrups as shown and allow to dry.



Step 88. Trim surplus lining off even with edges of covers.

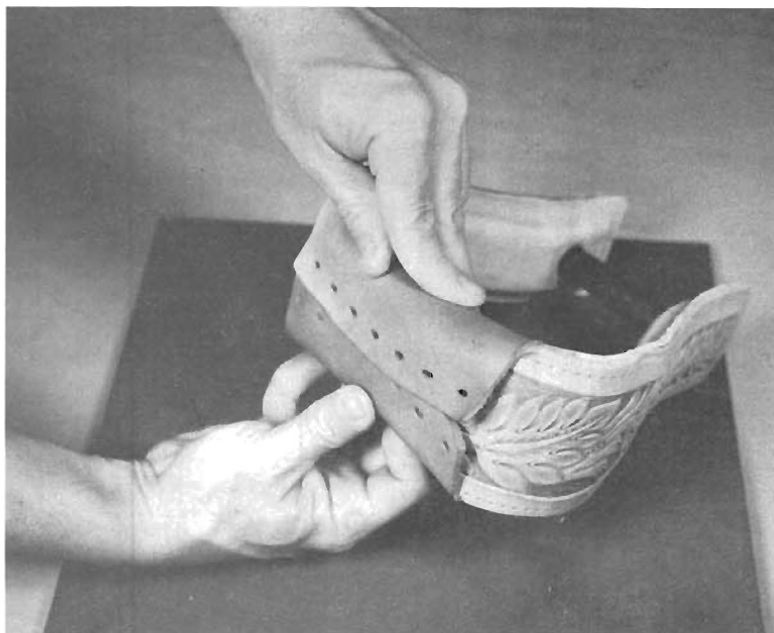


Step 89. Dampen thread cover, center, and form around bottom of stirrup. With awl, mark (on bottom of stirrup) 4 points where tread cover wraps around edges of stirrup bottom.



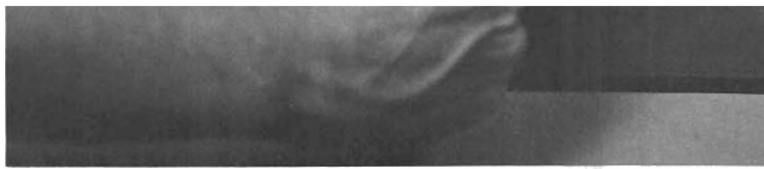


Step 90. Between the points you have marked on stirrup bottom, trim cover and lining off next to edge of stirrup.

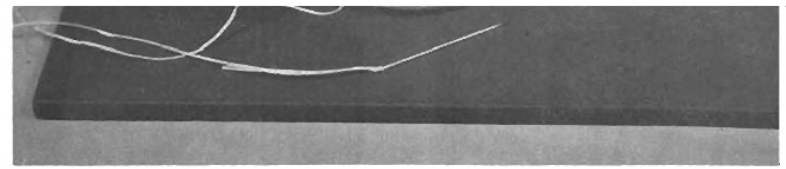


Step 91. Form damp tread cover around stirrup again to check fit. Edges should meet at bottom of stirrup.



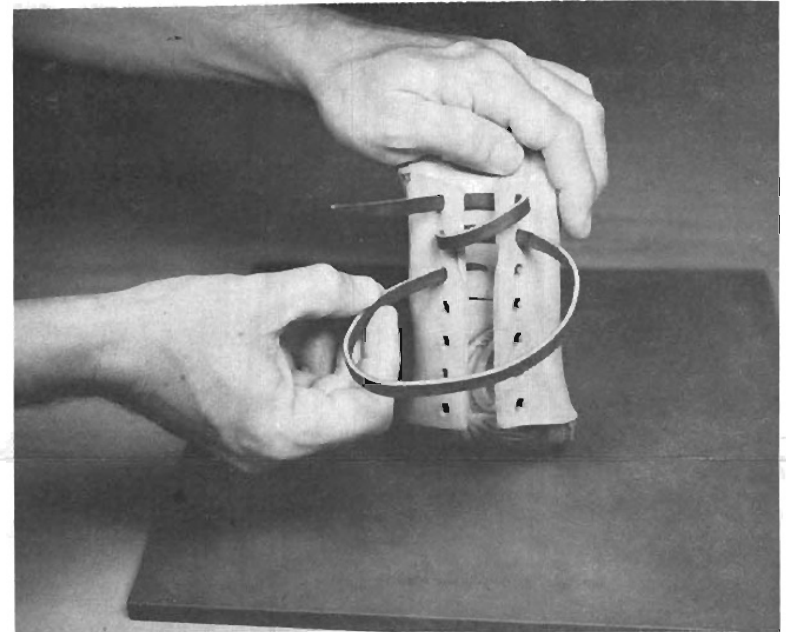


Step 92. At first stitching mark on one side of bottom of stirrup, stab hole with awl through cover and lining. All stitching holes may be made with awl now. (See page 2 for proper use of awl.)



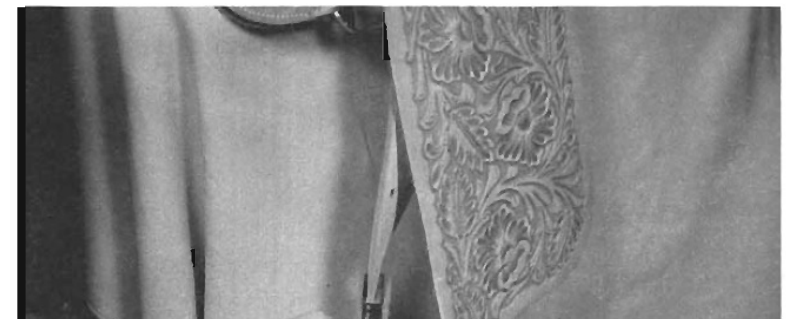
Step 93. Begin sewing at bottom of stirrup as shown. (See page 2 for stitching instructions.) Sew around one half of stirrup. Sew other side of stirrup.

XI Installing Tread Cover



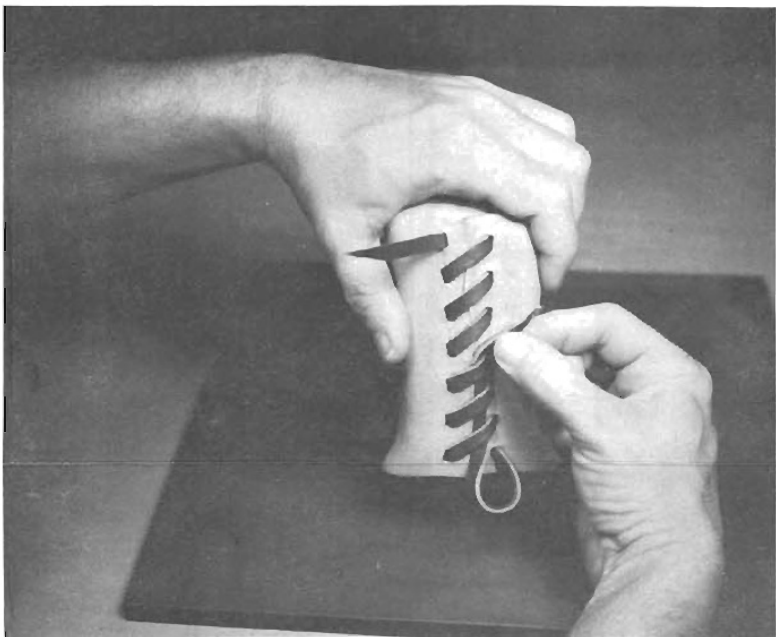
Step 95. Point ends of 20" piece of 1/4" lace and begin lacing tread cover (from grain side) as shown, leaving about 3" of lace outside first hole.

XII Installing Stirrups

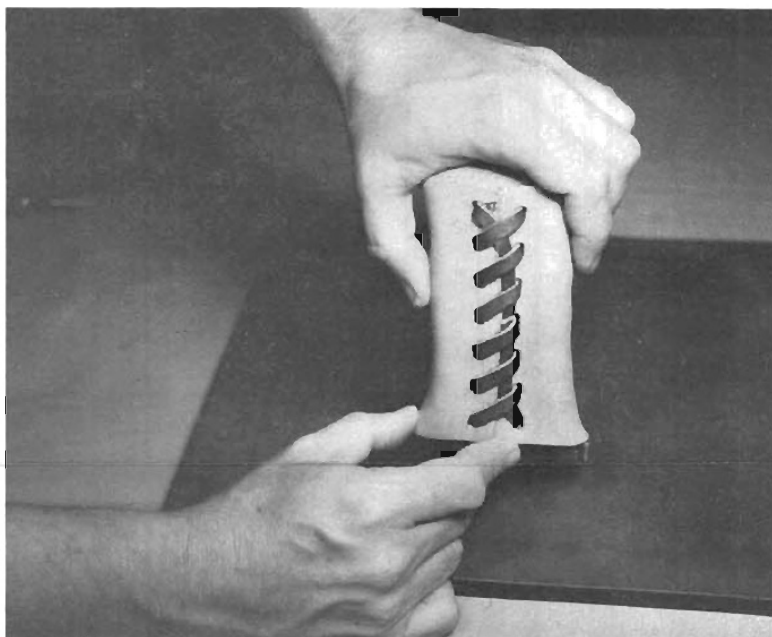




Step 94. Fold bolt cover and punch 2 holes with #5 punch. Insert 2 1/2" copper rivets, place washers and set. Cut rivets off if too long.



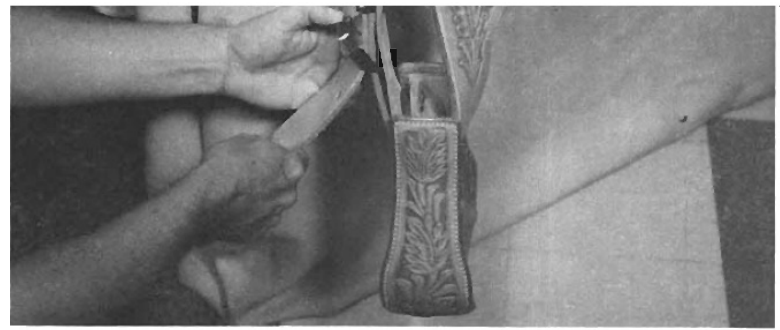
Step 96. Lace through last hole then insert lace under three laces (on grain side) to center of stirrup and trim off.



Step 97. Insert beginning end of lace under 3 laces to center and trim off. Hammer laces flat.



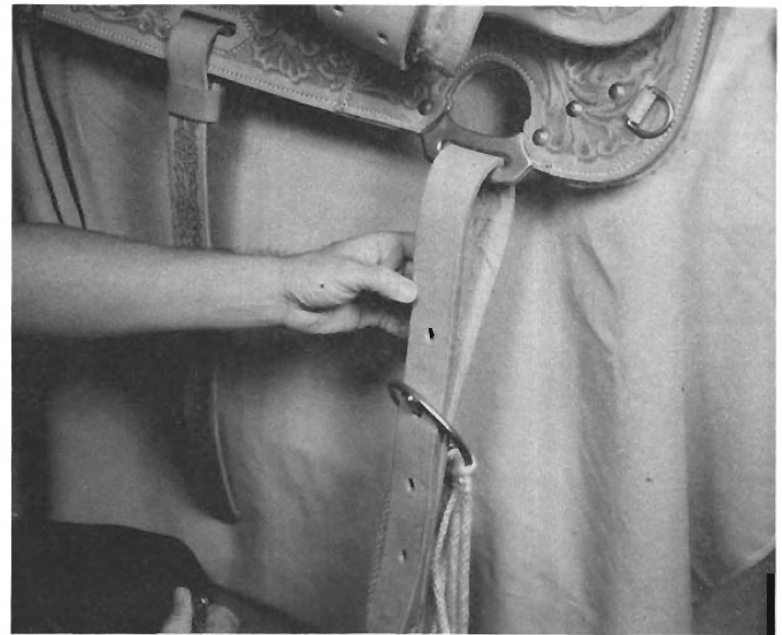
and Rigging



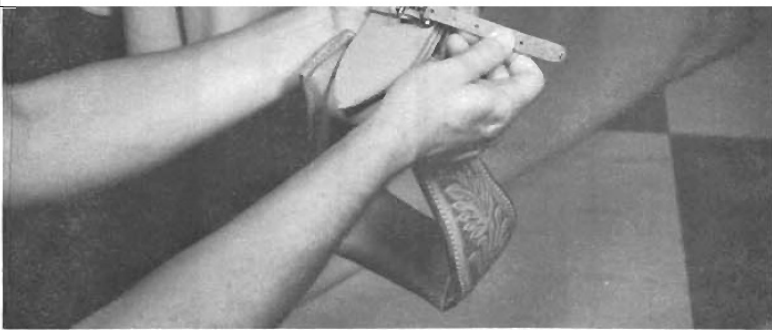
Step 98. Insert stirrup leathers through stirrups, adjust to desired length and buckle.



Step 101. Install tie strap with 3 hole tie as shown.



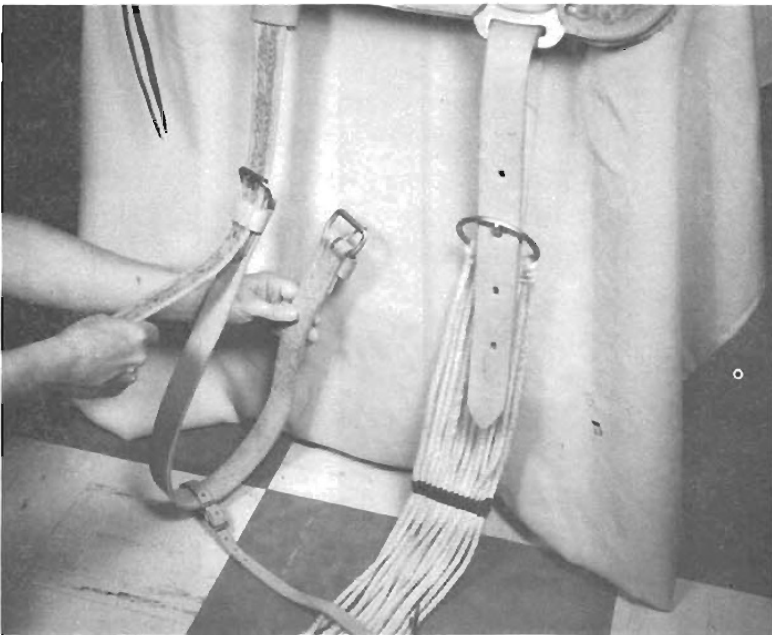
Step 102. Install off strap and girth.



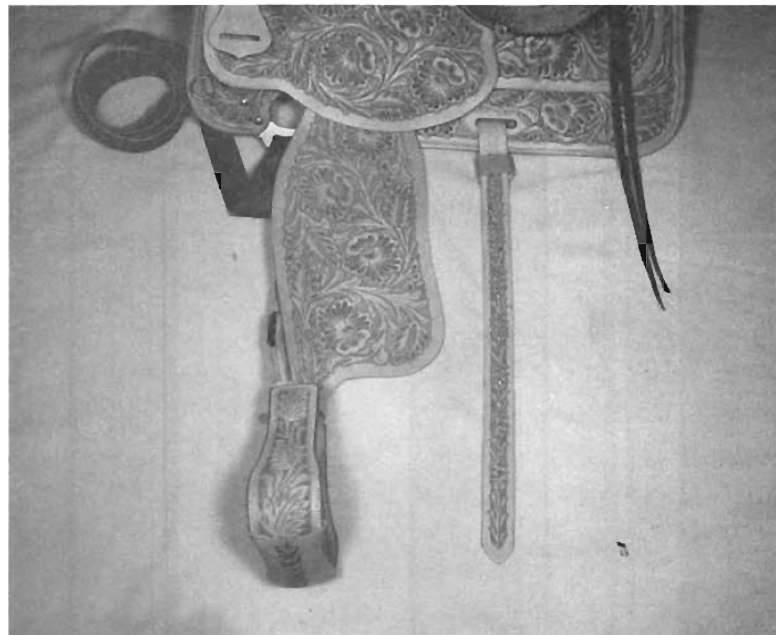
Step 99. Buckle hobble straps around stirrup leathers.



Step 100. Install flank cincha billets as shown.



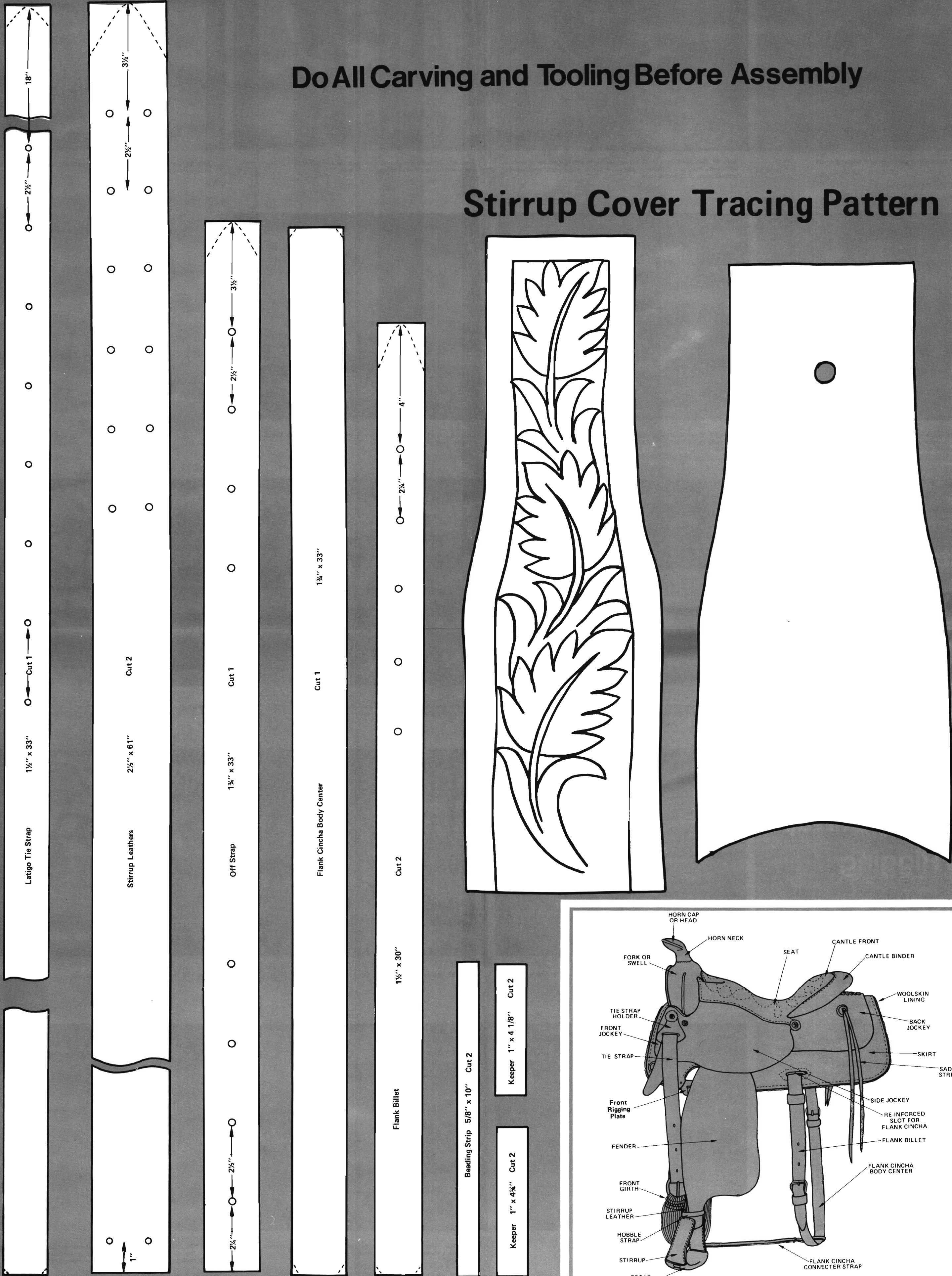
Step 103. Install center body of flank cincha with connector strap attached. Lace end of connector strap to center of girth.

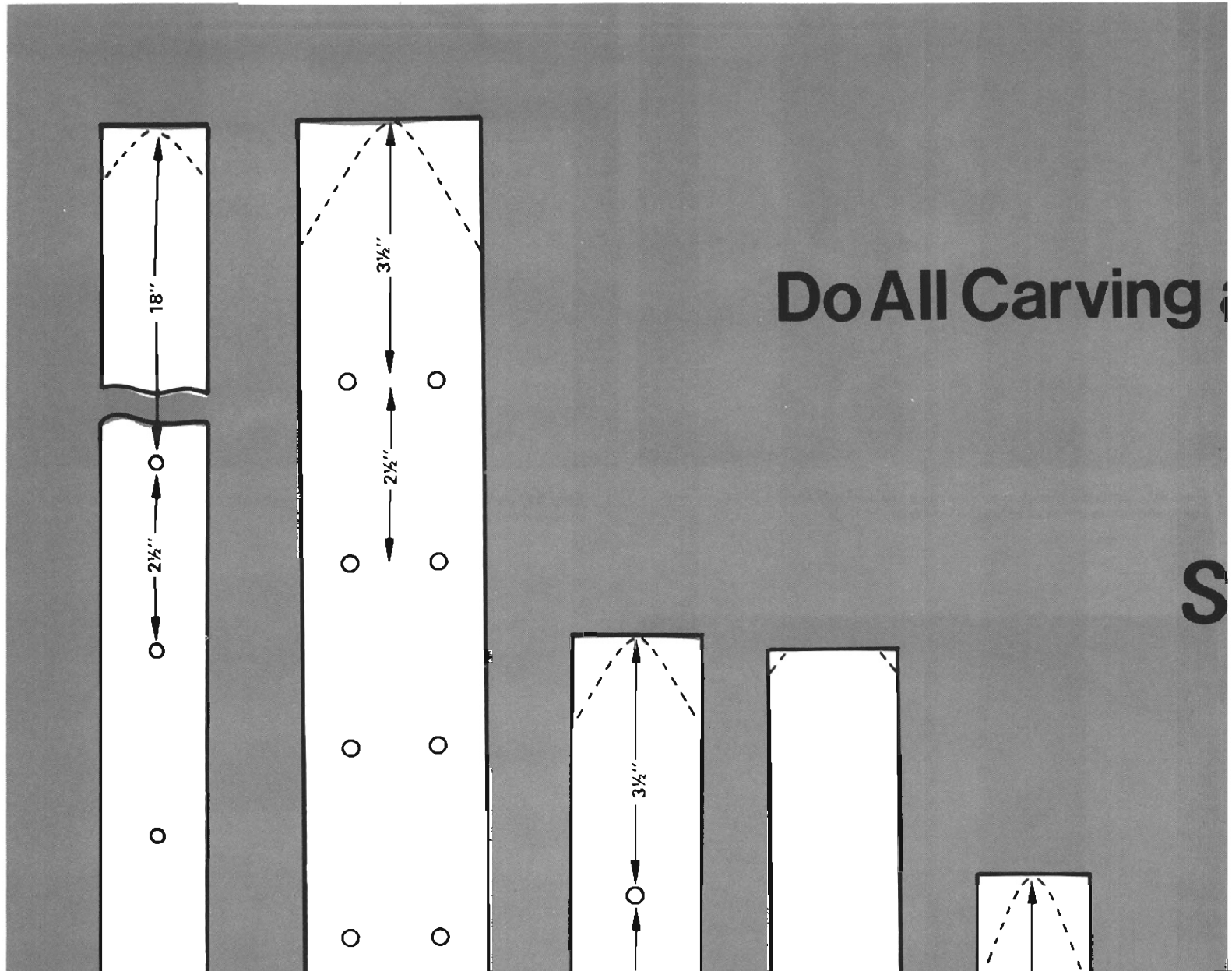


Step 104. After adjusting stirrup leathers to desired length, place saddle flat on floor. Dampen lower part of fenders (on flesh side) and stirrup leathers. Turn stirrups as shown and allow to dry.

Do All Carving and Tooling Before Assembly

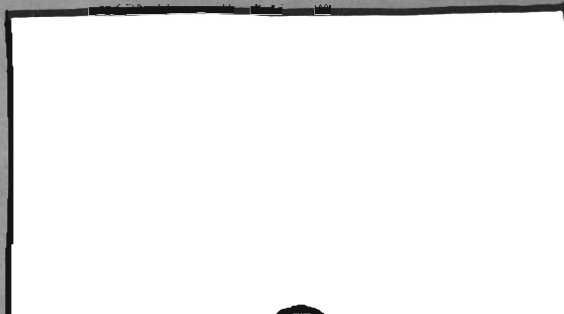
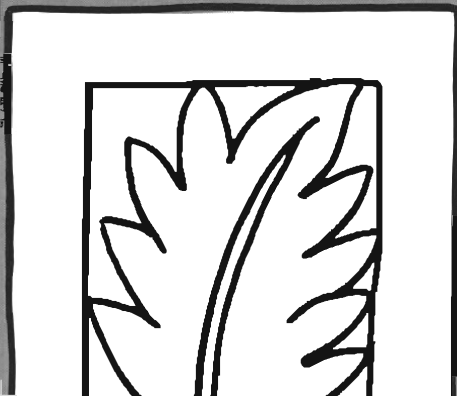
Stirrup Cover Tracing Pattern





and Tooling Before Assembly

tirrup Cover Tracing Pattern





e Strap

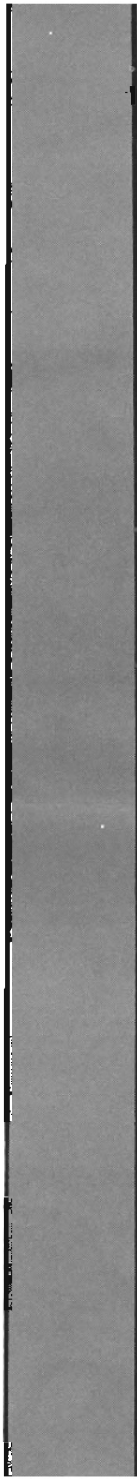
1½" x 33"

○ ← Cut 1 → ○

○

○

○



athers

2½" x 61"

Cut 2

○

○

○

○



ap

1¾" x 33"

Cut 1

○

○

○ → 2½"



incha Body Center

Cut 1

1¾" x 33"



○

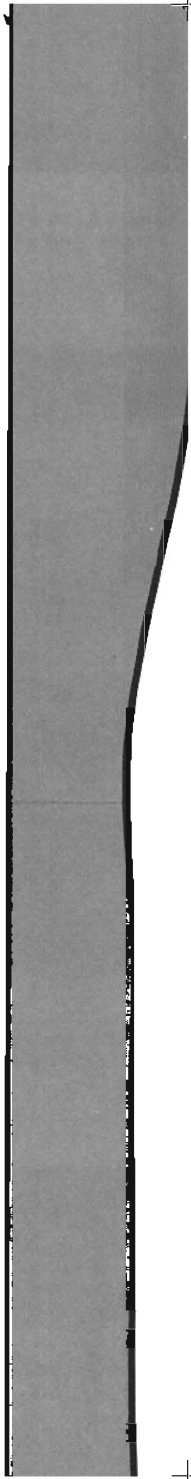
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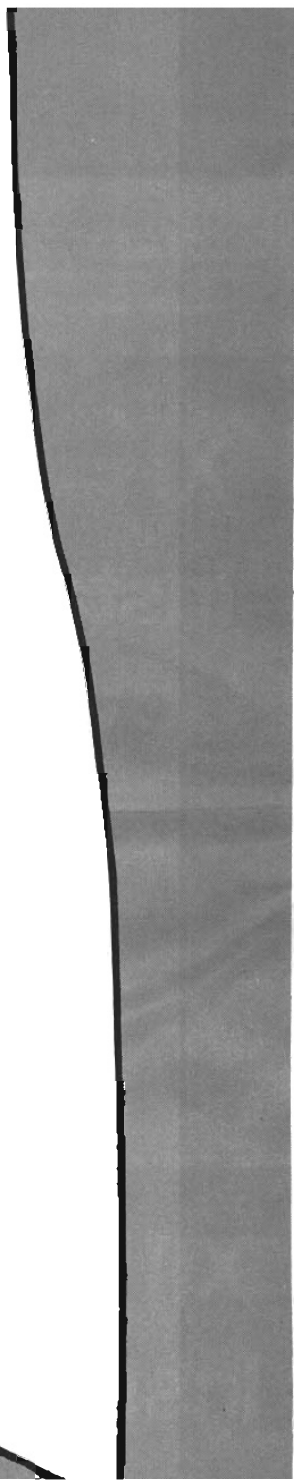
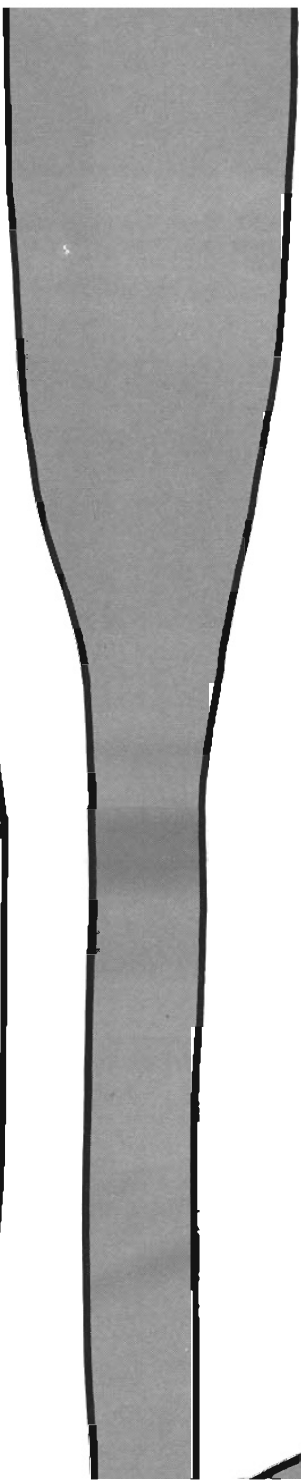
○

○

○

○ → 2½" → 4"





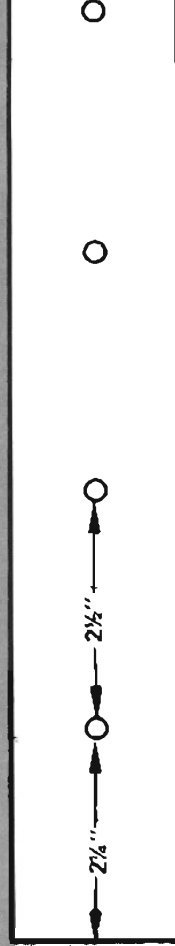
Latigo Tip



Stirrup Le



Off Str



Flank C



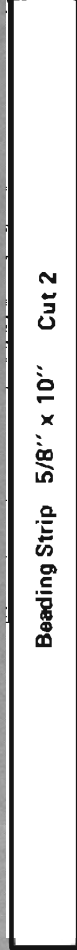
Cut 2

1 1/2" x 30"

Flank Billet

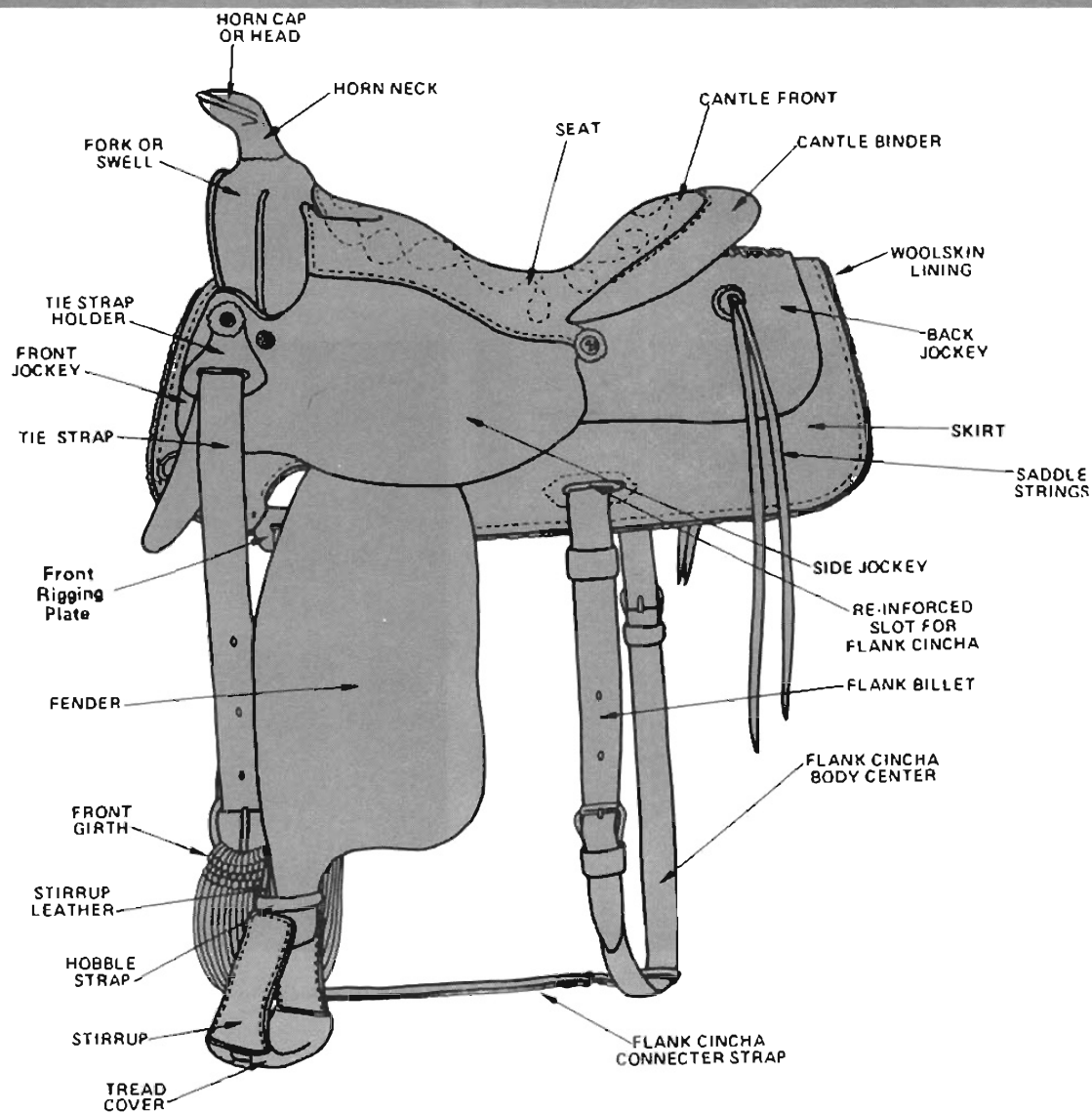


Beading Strip 5/8" x 10" Cut 2

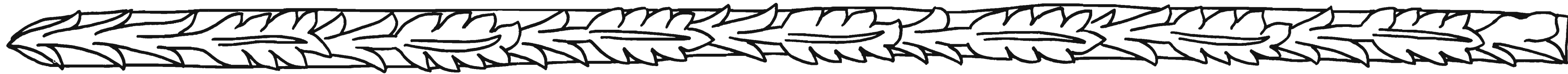


Keeper 1" x 4 1/8" Cut 2

Keeper 1" x 4 3/4" Cut 2



1½" x 30"



Flank Cincha Tracing Pattern

Do All Carving and Tooling Before Assembly

Flank Cincha Assembly Instructions

See page 16 for fabrication of Flank Cincha

Keeper for Flank Cincha

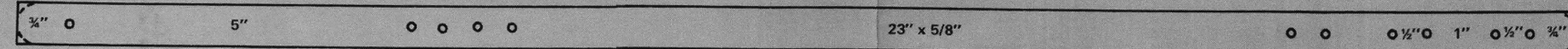
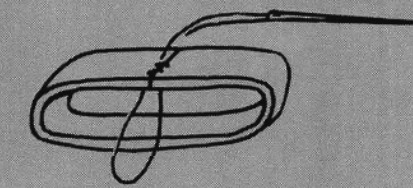
ACTUAL SIZE

Fabricate Leather Keepers

Mark holes in keepers (as shown on patterns) and punch with awl. Whipstitch ends together as shown. Use 24" of thread to sew all (4) loops together.

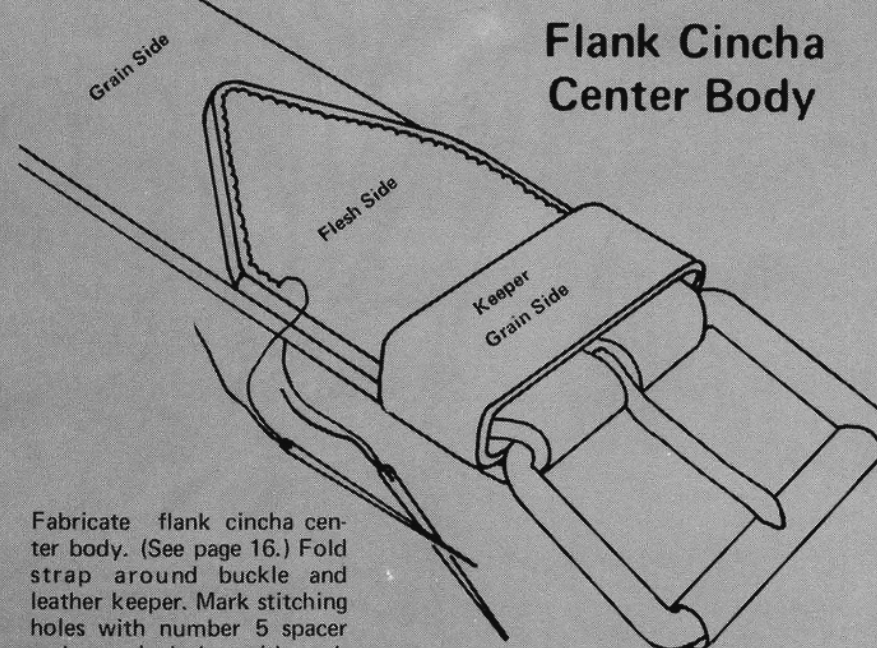
Keeper for Flank Cincha Center Body

ACTUAL SIZE



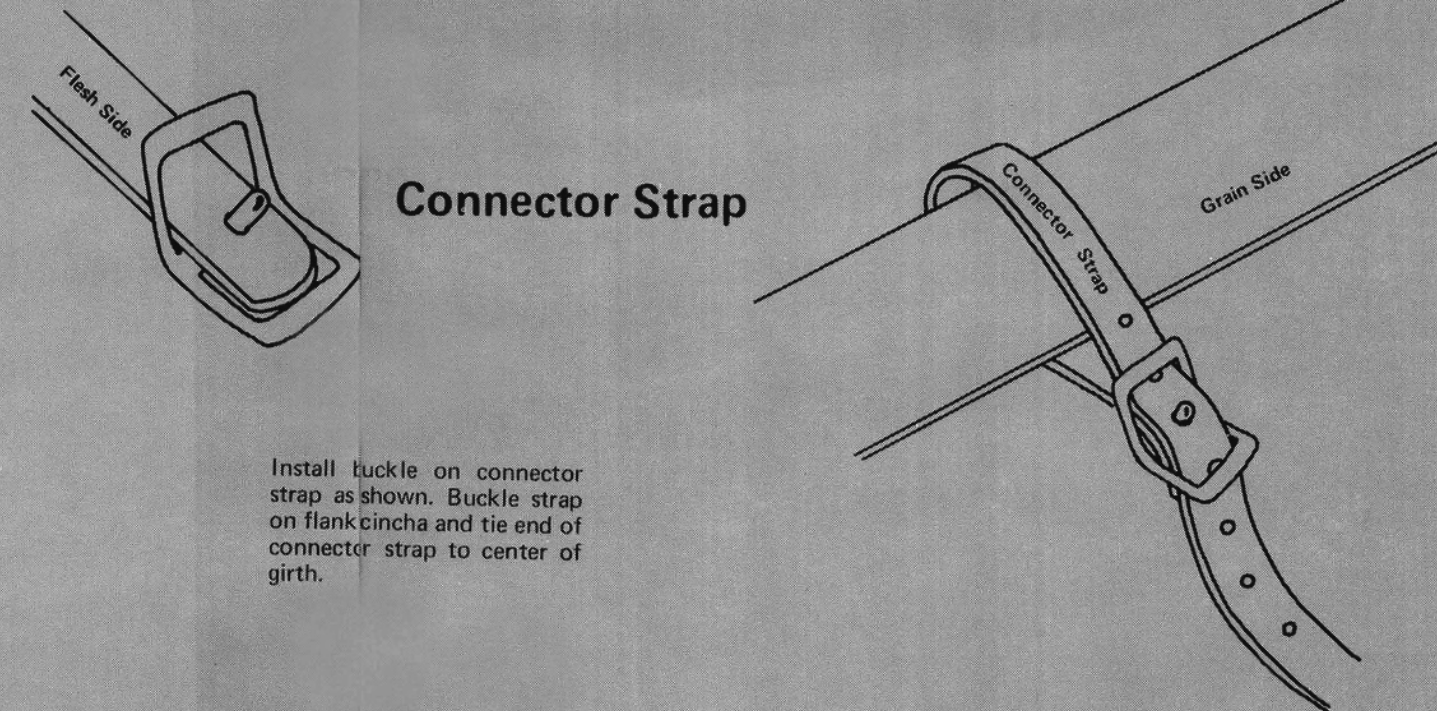
Connector Strap Pattern

Flank Cincha Center Body



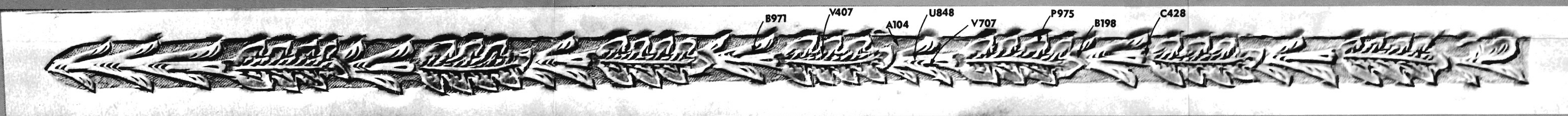
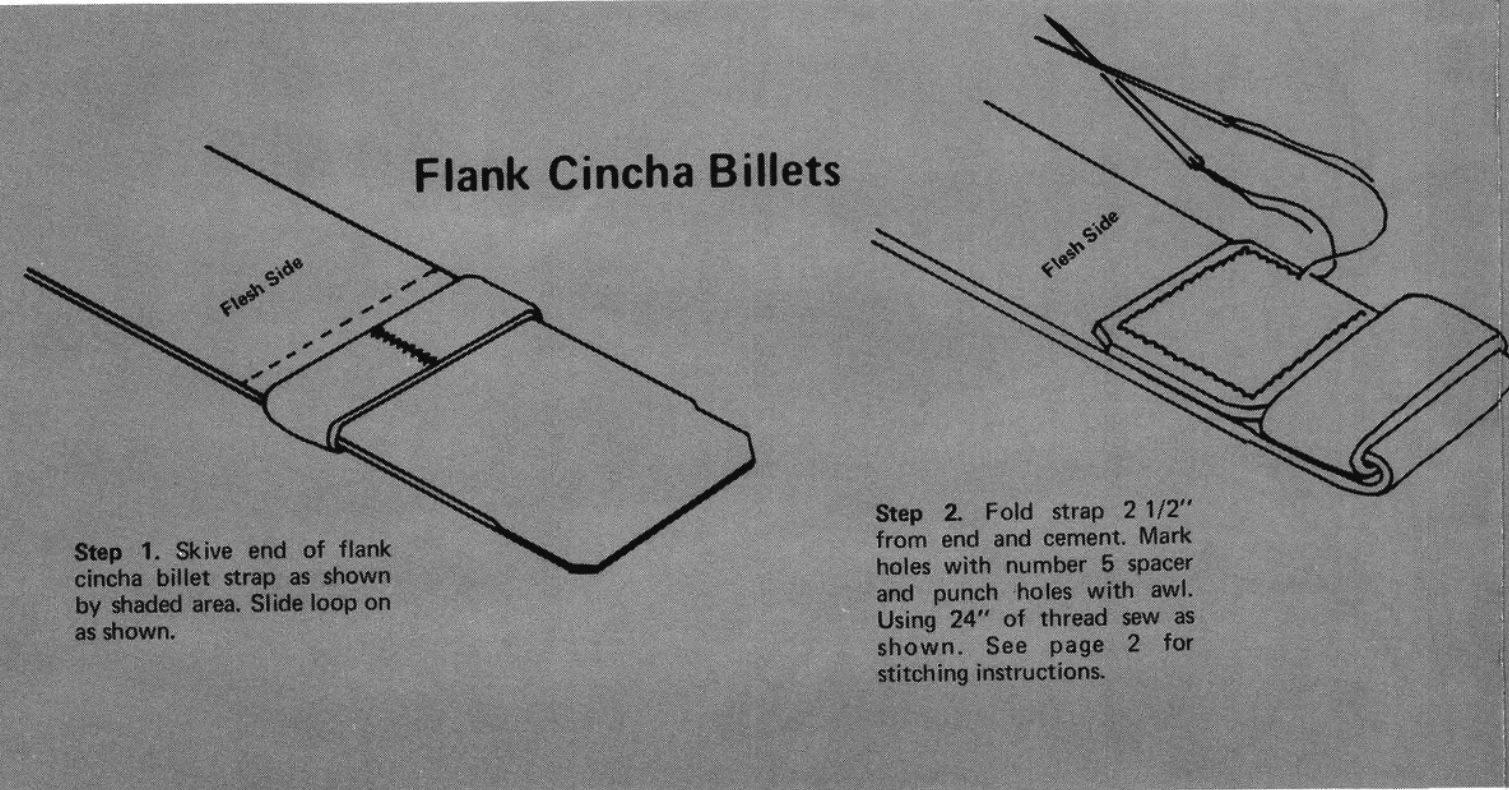
Fabricate flank cincha center body. (See page 16.) Fold strap around buckle and leather keeper. Mark stitching holes with number 5 spacer and punch holes with awl. Sew with 3 ft. of thread. See sewing instructions on page 2.

Connector Strap



Install buckle on connector strap as shown. Buckle strap on flank cincha and tie end of connector strap to center of girth.

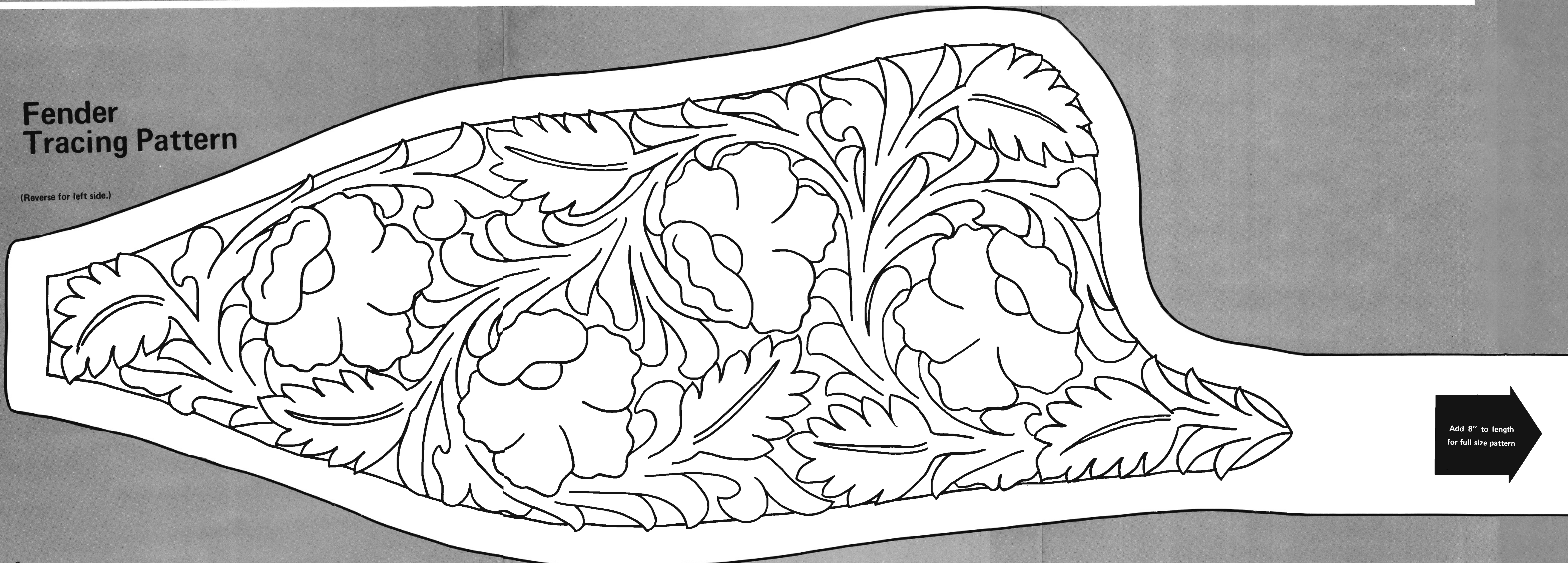
Fender Photocarve Pattern



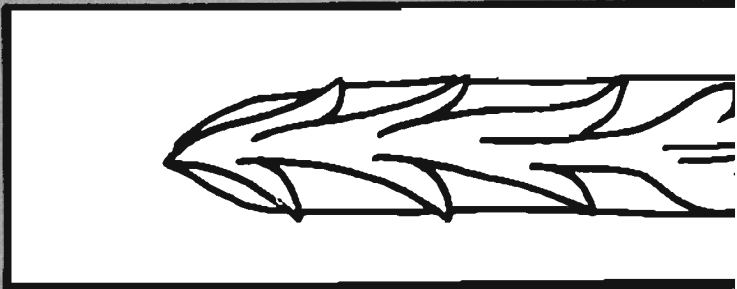
Flank Cincha Photocarve Pattern

Fender Tracing Pattern

(Reverse for left side.)



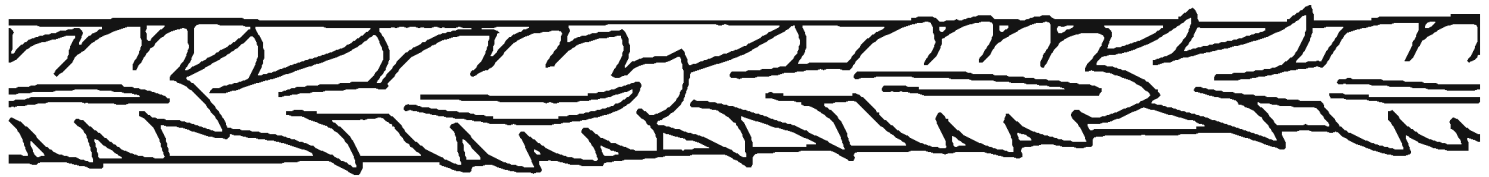
1½" x 3"



Flank Cincha Tr

**Do All Ca
Tooling Befo**

30"



acing Pattern

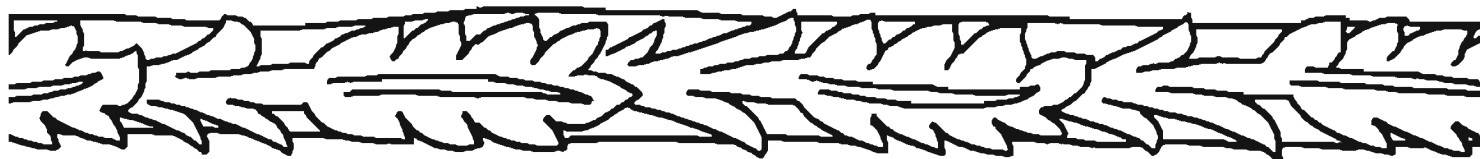
erving and
re Assembly

Fla

See page 16 for fabrication of

Keeper for l

ACTU



ank Cincha Assembly Instructions

Flank Cincha

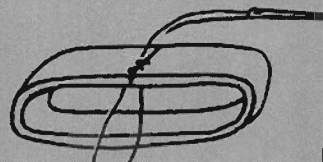
Fabricate Leather Keepers

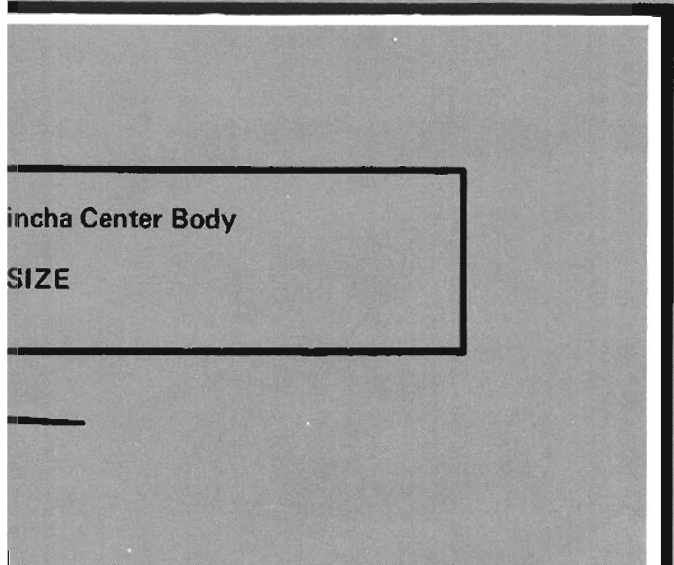
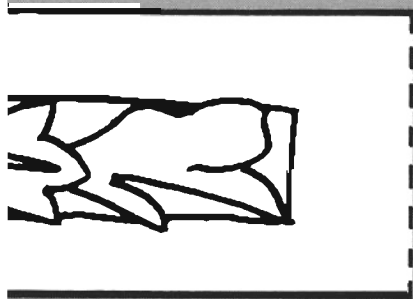
Keeper for Flank C
ACTUAL

Flank Cincha

AL SIZE

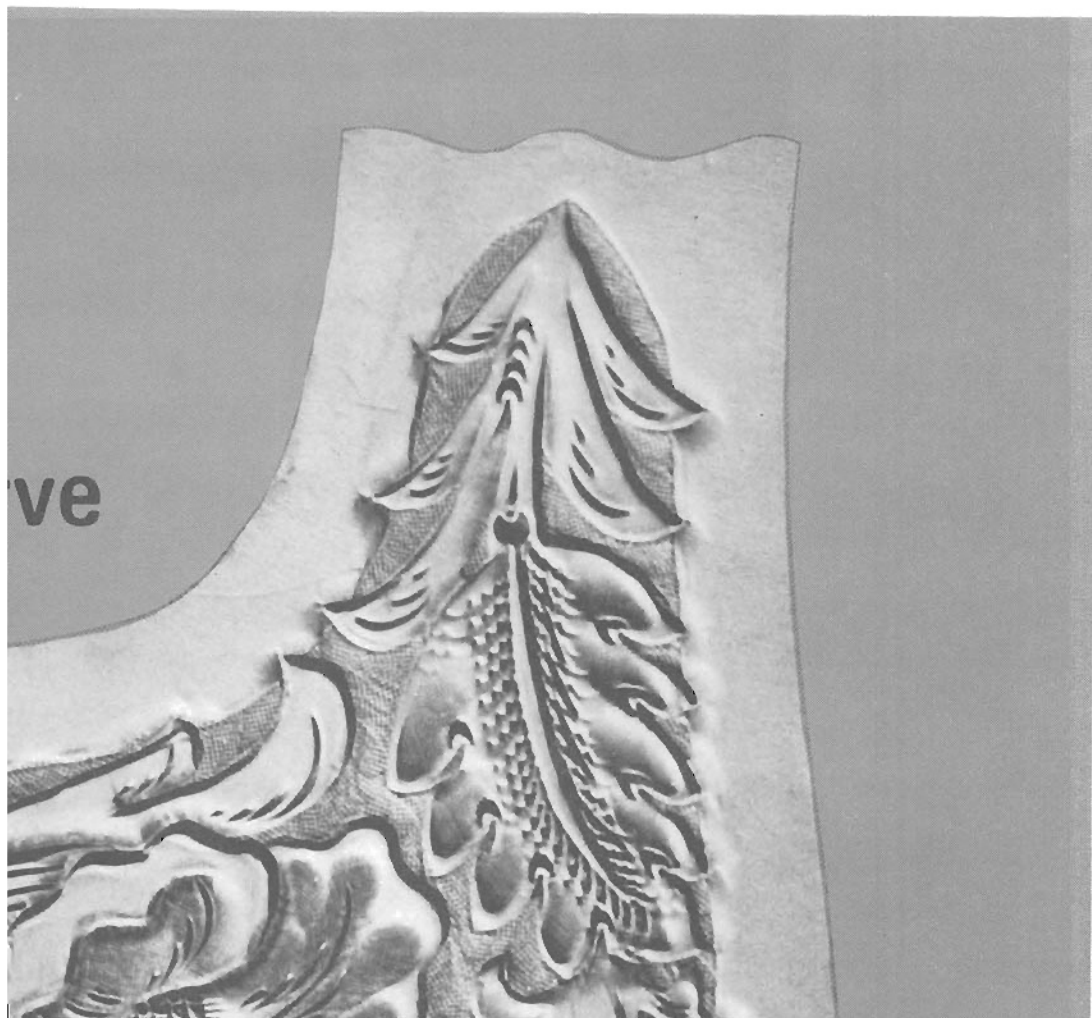
Mark holes in keepers (as shown on patterns) and punch with awl. Whipstitch ends together as shown. Use 24" of thread to sew all (4) loops together.



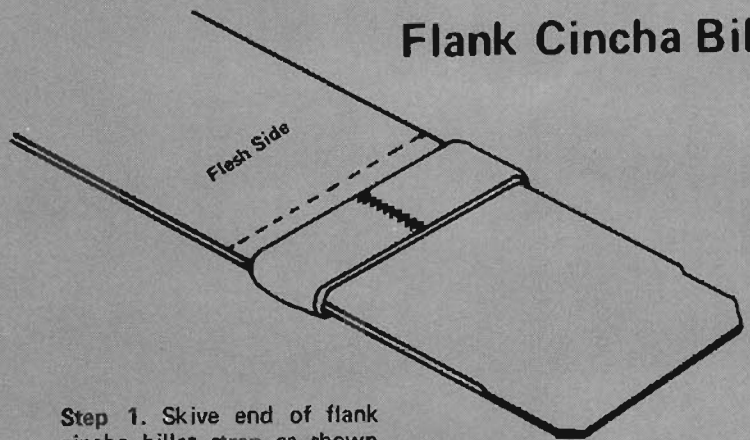


Fender Photocar Pattern

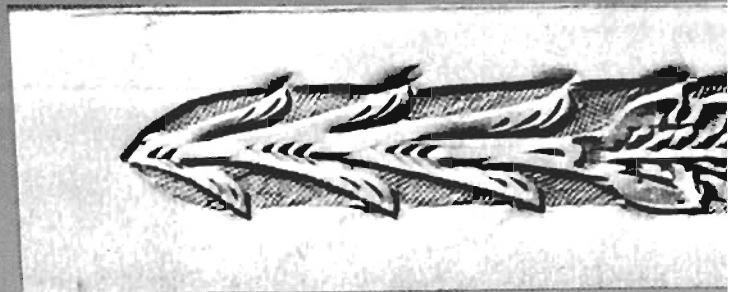




Flank Cincha Billet



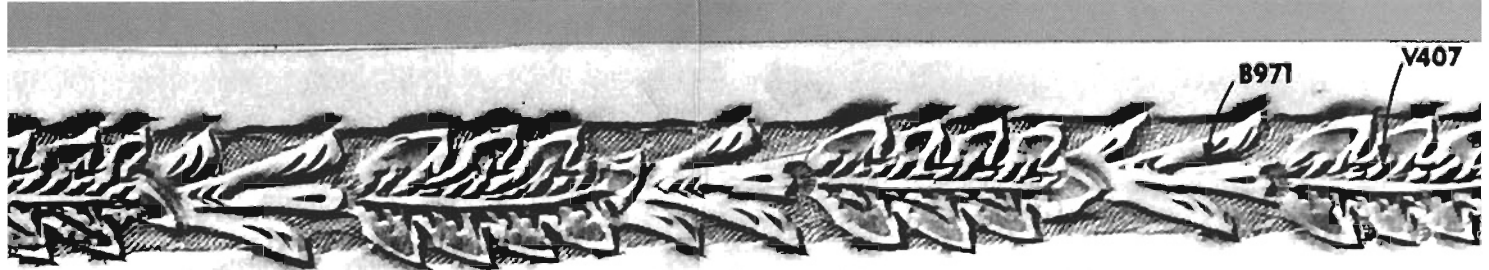
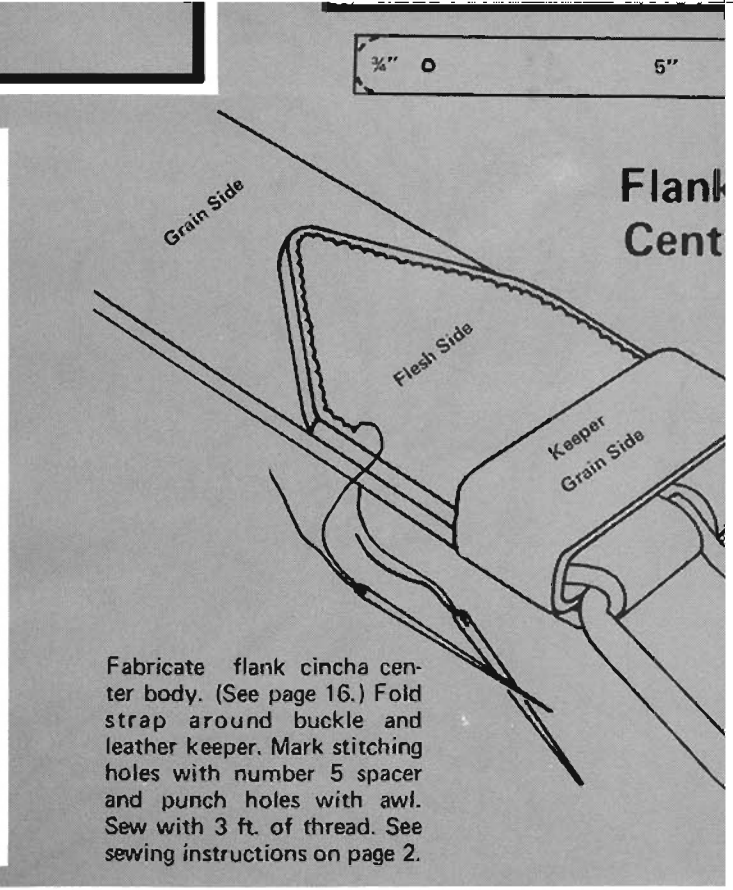
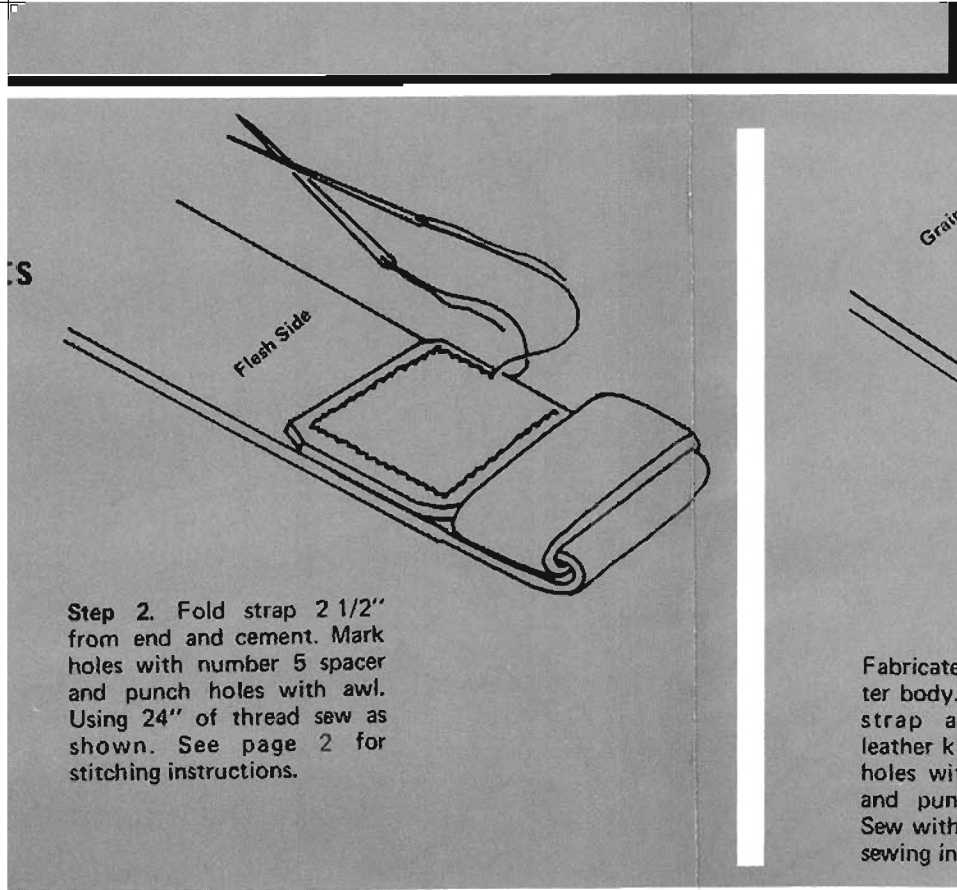
Step 1. Skive end of flank cincha billet strap as shown by shaded area. Slide loop on as shown.



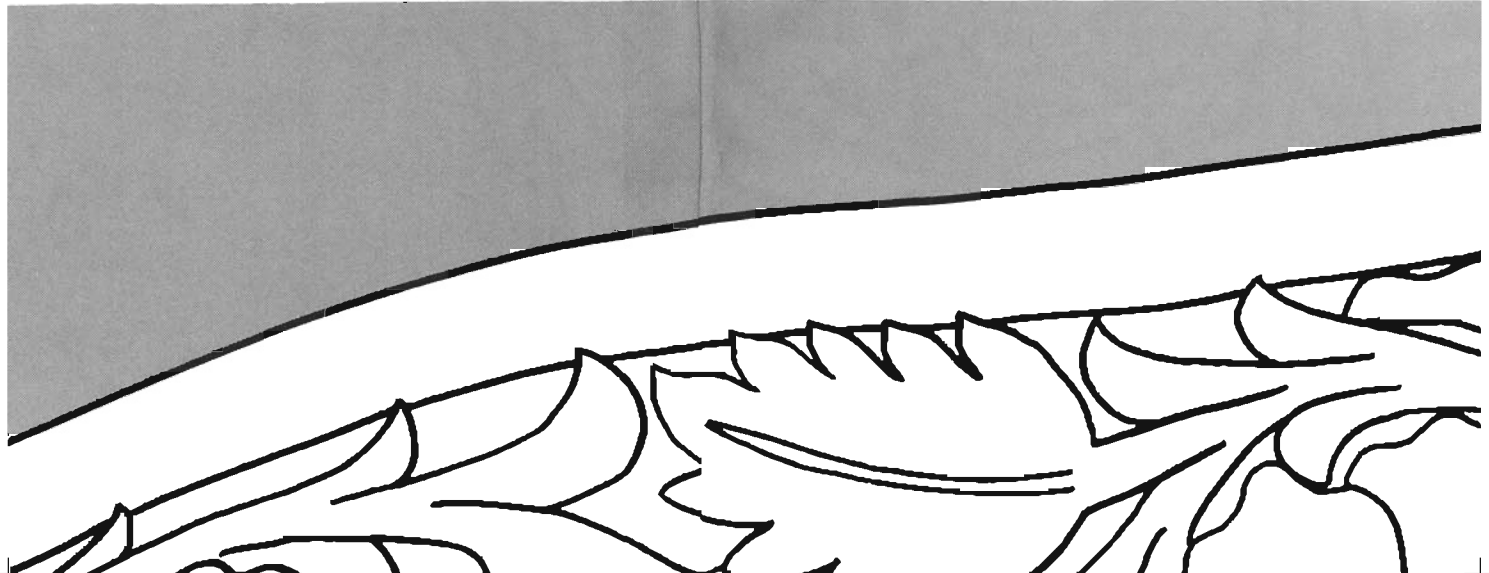
Flank Cincha Ph

Fender Tracing Pattern

(Reverse for left side.)

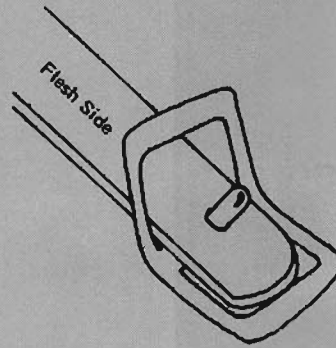


otocarve Pattern



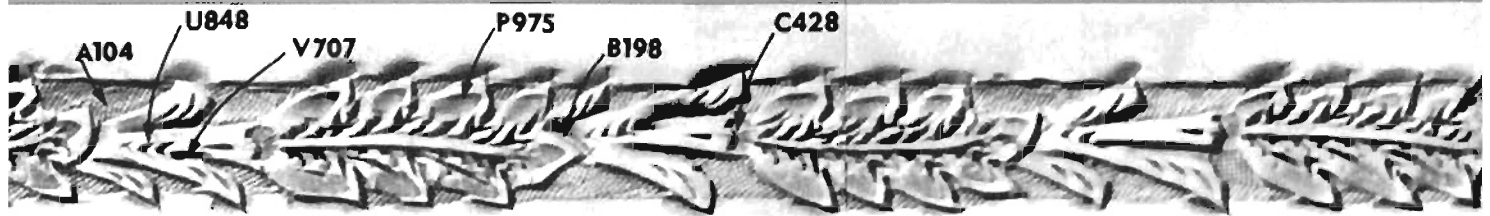
Flank Cincha
Body

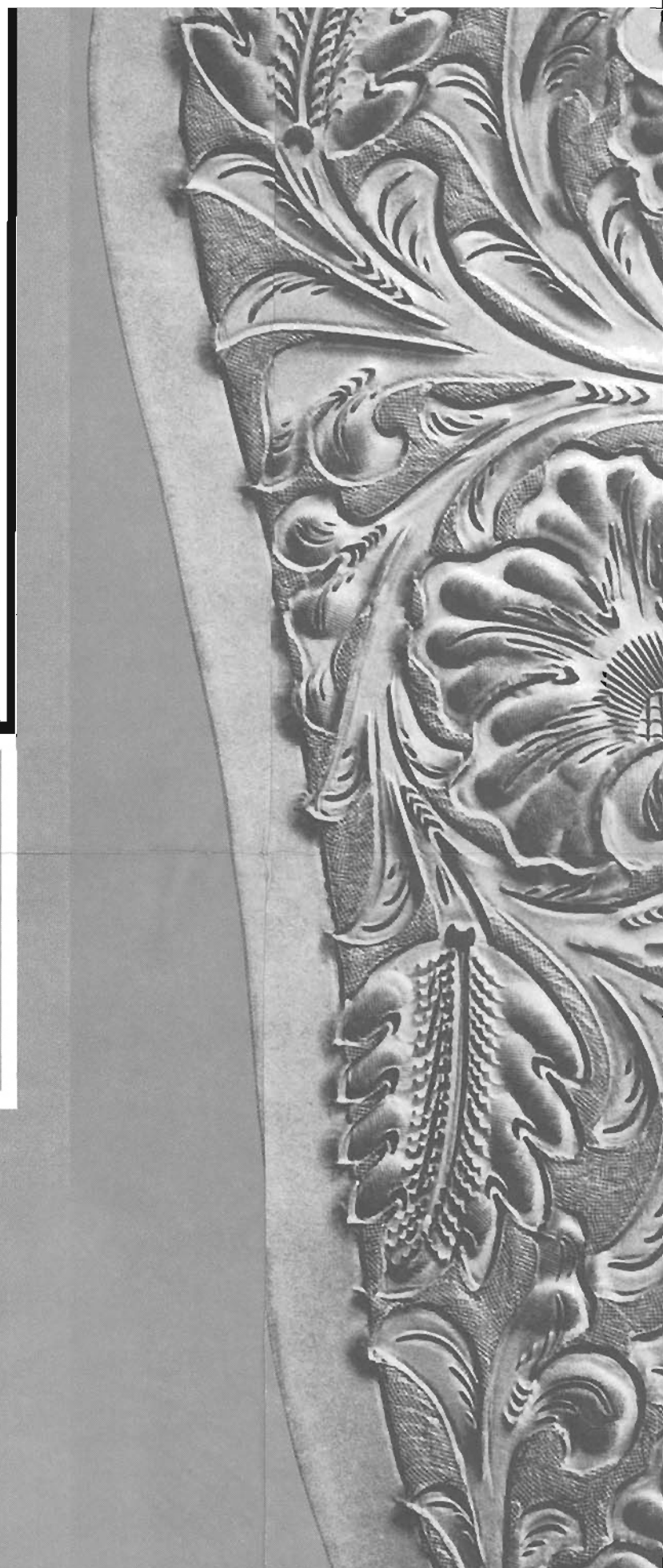
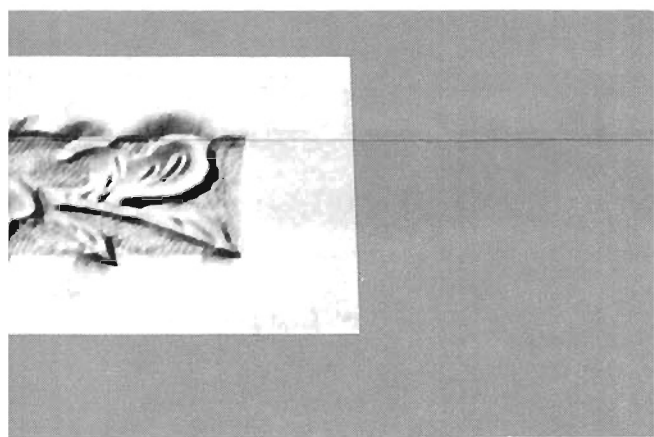
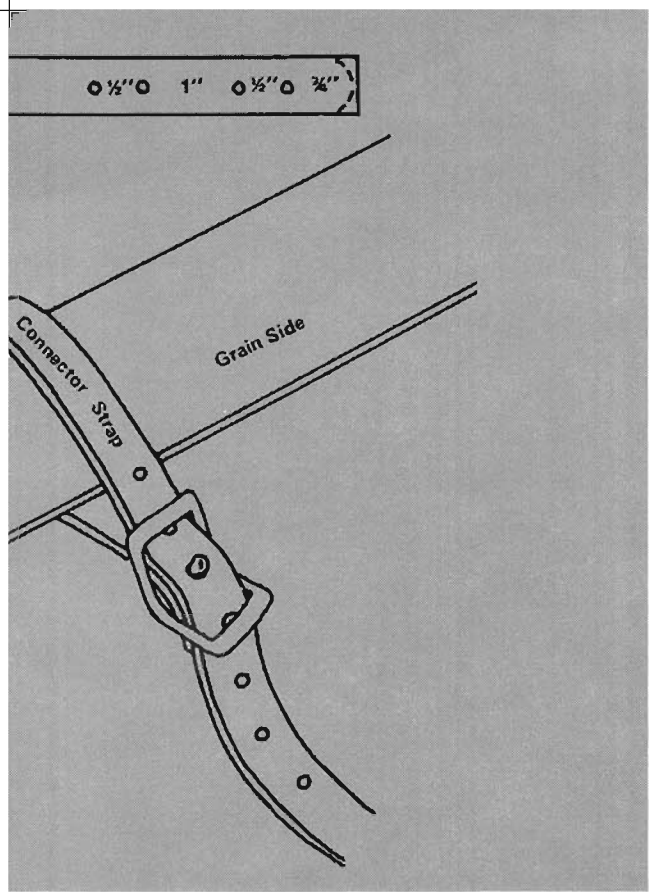
Connector Strap Pattern

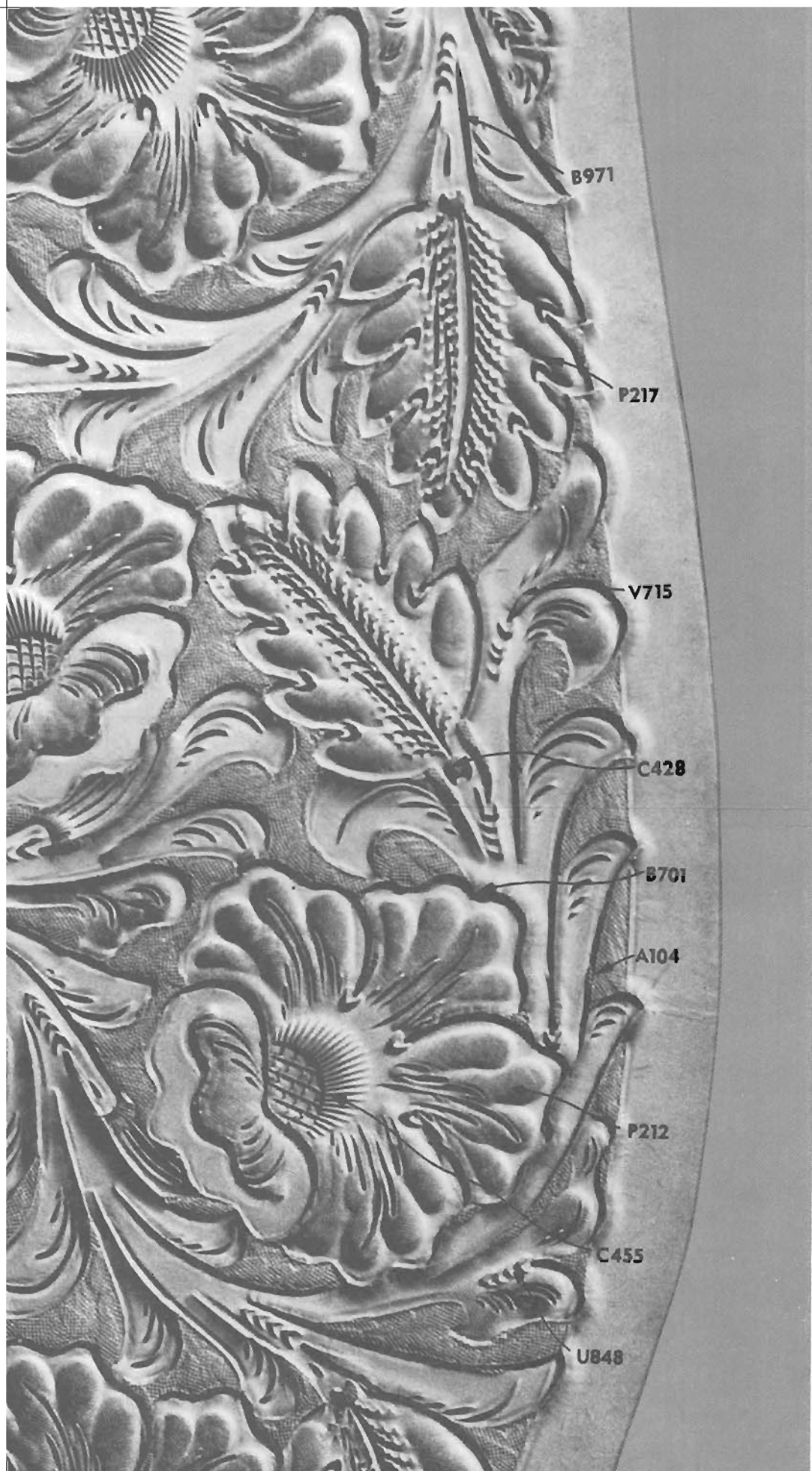


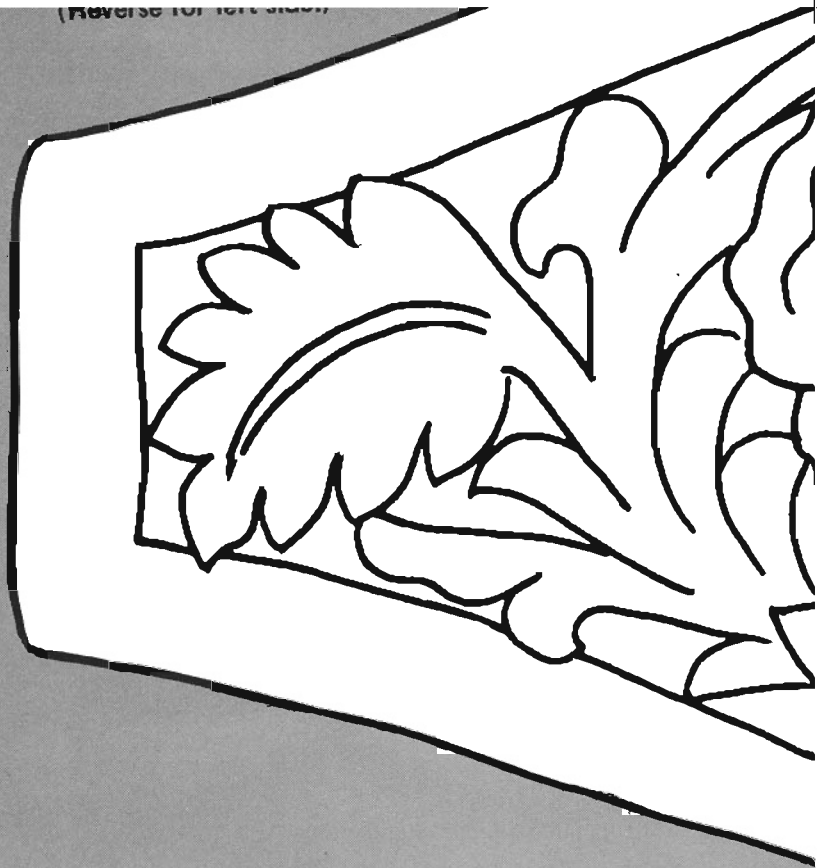
Connector Strap

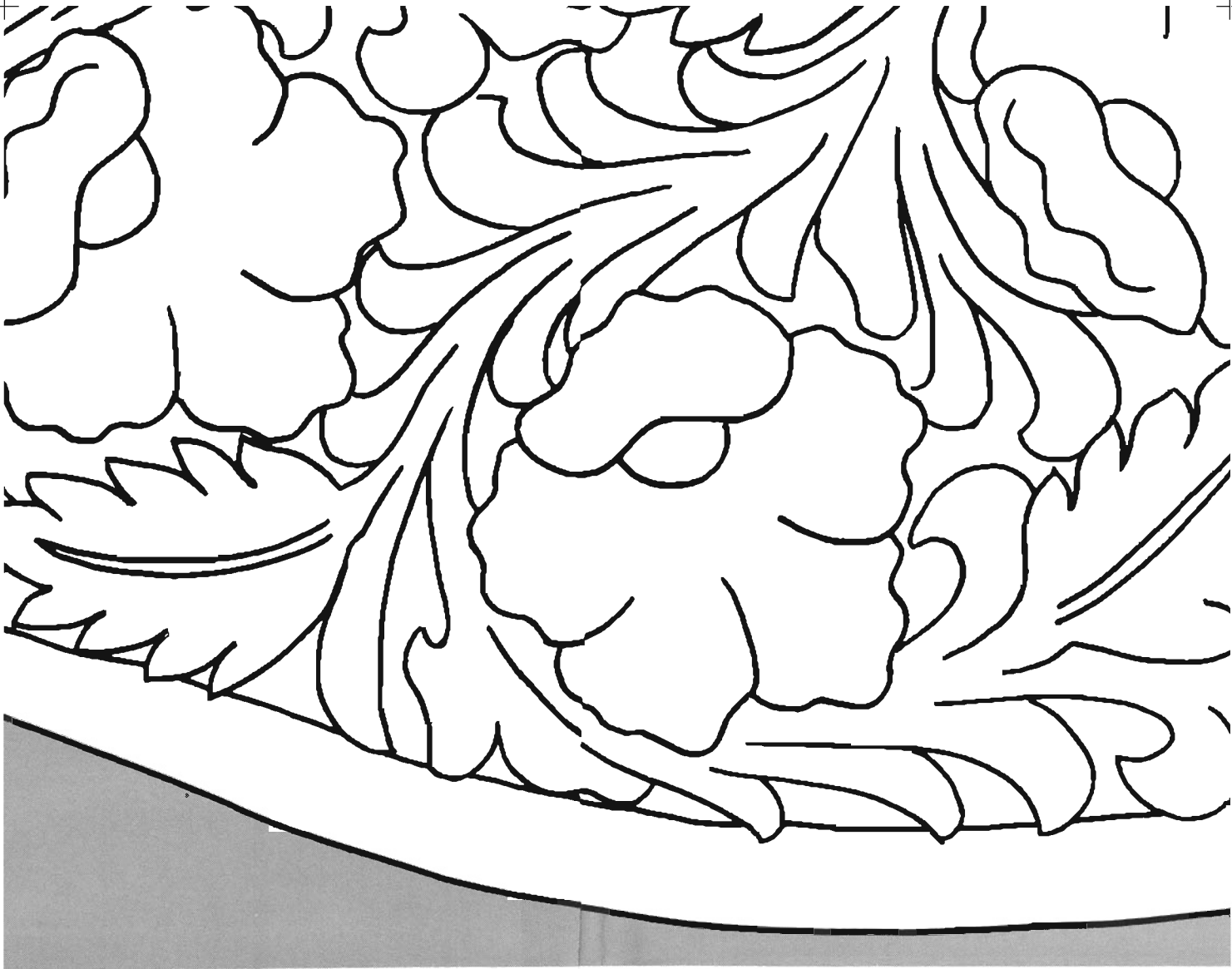
Install buckle on connector strap as shown. Buckle strap on flank cincha and tie end of connector strap to center of girth.

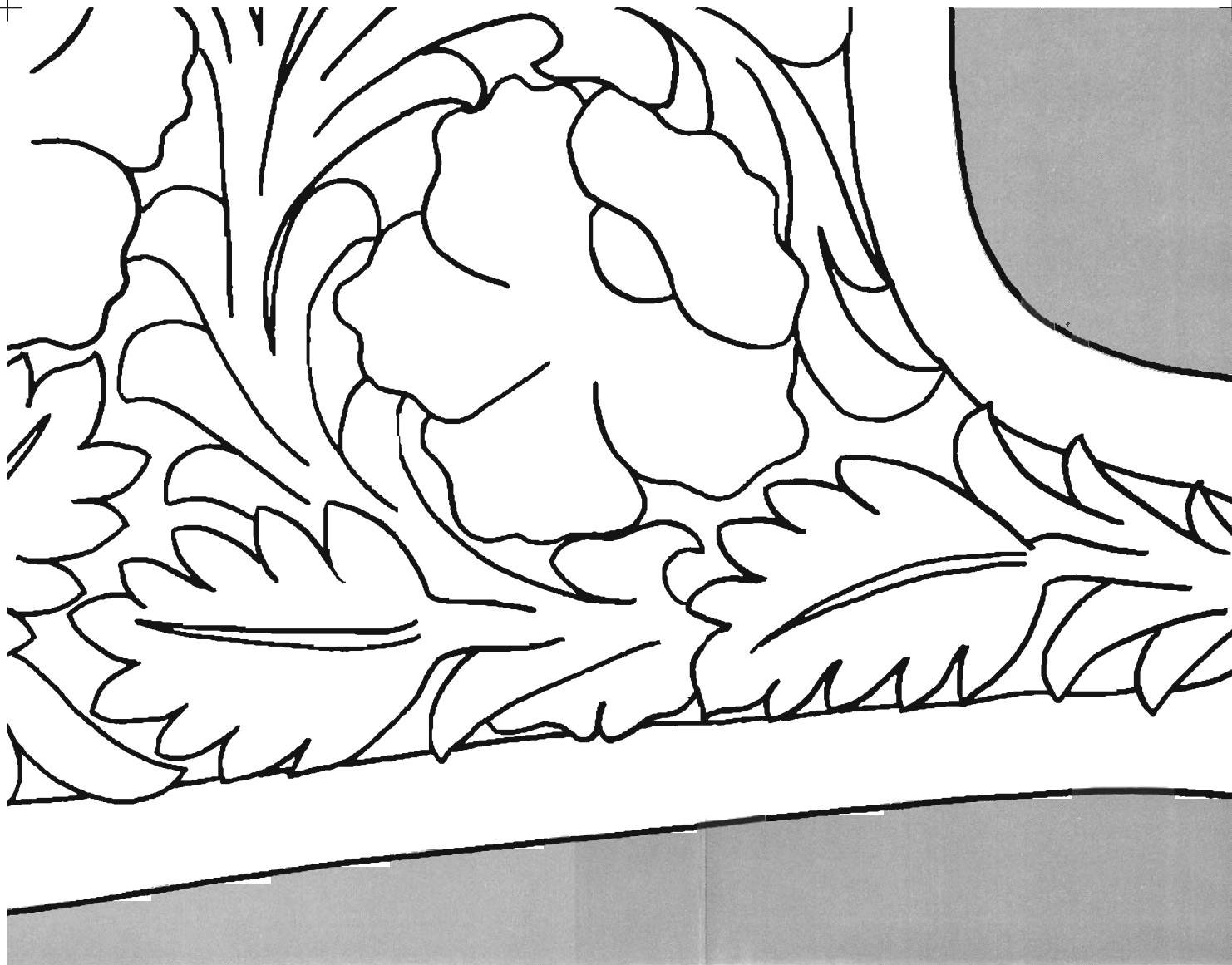















**Add 8" to length
for full size pattern**

