

# ROPER SADDLE PATTERN

## MATERIALS NEEDED

1	ROPER SADDLE TREE (STOCK No. 4820)
1pr	ROPER SADDLE STIRRUPS (STOCK No. 4823)
4	3" RIGGING DEES
2sides	SADDLE SKIRTING
1	ROPER SADDLE CINCHA (STOCK No. 4824)
5	1/4" X 72" LATIGO LACE
48	1 1/4" TACKS
60	1" TACKS
2	3/4" DOMED SCREWS
12	1" DOMED SCREWS
8	1 1/2" DOMED SCREWS
22	No. 10 FINISHING WASHERS
2	MEDIUM RAPID RIVETS (STOCK No. 1273)
15	5/8" BRASS NAILS
16	COPPER RIVETS AND BURRS (STOCK No. 1280-01)
2	3" STIRRUP BUCKLES
3	5/8" UTILITY BUCKLES (STOCK No. 1638)
2	1" SOLID DEES (STOCK No. 1132)
2	1 1/2" ROLLER BUCKLES (STOCK No. 1750-01)
100yds	WAXED THREAD
1piece	RAWHIDE (AT LEAST 2" X 4")
2	1/2" X 48" LATIGO SADDLE STRINGS (OPTIONAL)
4	1" LEATHER CONCHOS
2	2" LEATHER CONCHOS
1	1 3/4" X 61" LATIGO TIE STRAP



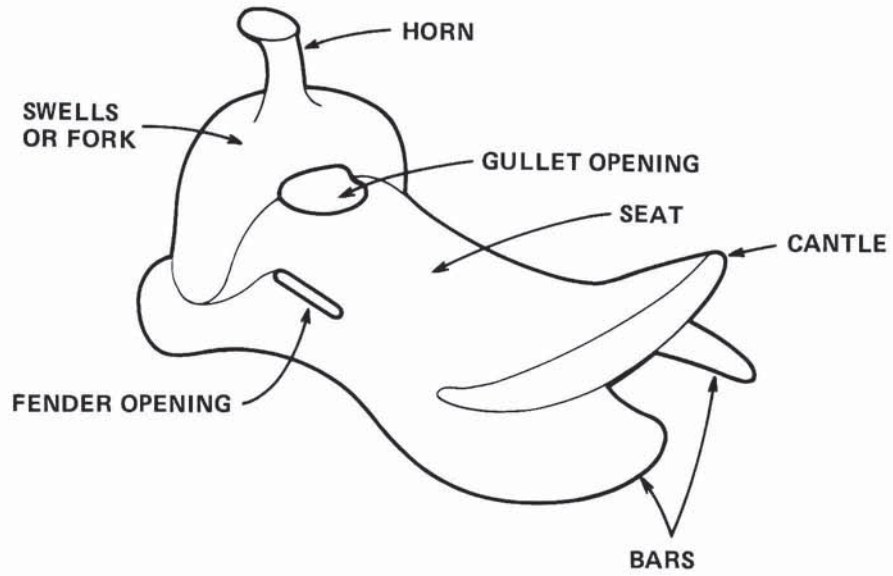
## TOOLS NEEDED

SKIVING KNIFE  
 SHEARS  
 TACK HAMMER  
 SMOOTH FACED HAMMER  
 Mallet  
 EDGE BEVELERS (ASSORTED SIZES)  
 CRAFTSMAN CEMENT  
 1/8", 3/16", 13/64" AND 5/16" HOLE PUNCHES  
 1" OBLONG PUNCH  
 WING DIVIDER  
 SCRATCH AWL  
 NO. 5 OVERSTITCH WHEEL  
 STITCHING GROOVER (OPTIONAL)  
 STITCHING AWL  
 HARNESS OR EASY THREAD NEEDLES  
 LATIGO "LIFE-EYE" NEEDLE  
 DRILL WITH 1/8" BIT  
 PHILLIPS HEAD SCREWDRIVER  
 COPPER RIVET SETTER  
 RAPID RIVET SETTER  
 MODELING TOOL OR BONE FOLDER

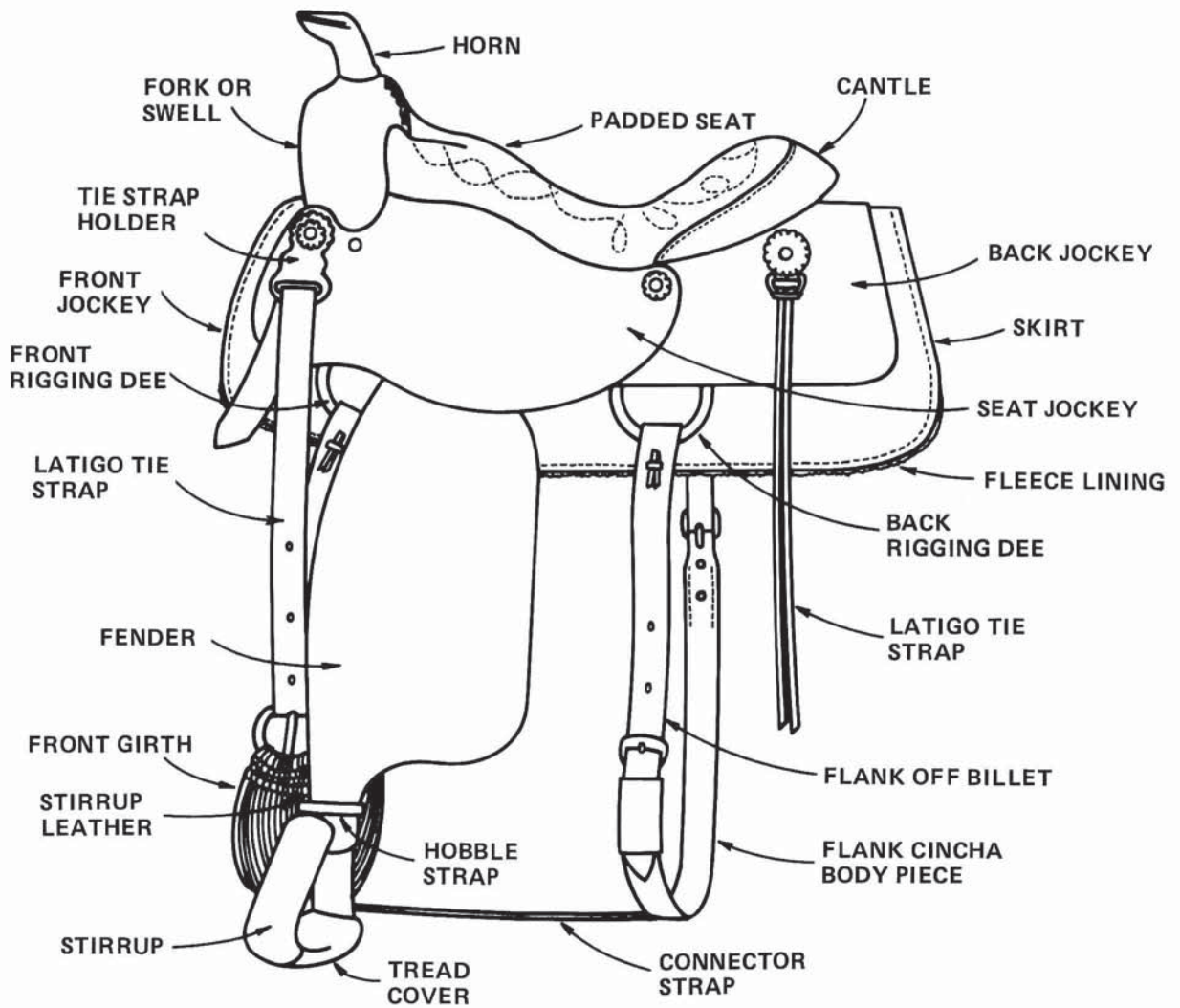
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# Parts of the Saddle Tree



# Parts of the Saddle





# Important Information

Be sure to read the entire instruction book completely before you start. This will make the project easier to assemble and you will be much happier with the final results.

## Tips and Hints

Do all tooling before assembly except for the swells cover. For best results, tool swells cover after it is in place on tree. This will be a bit awkward to accomplish but the final results will be much better.

Bevel and slick all exposed edges before final assembly. Bevel with an edge beveler then slick with smooth hardwood, canvas or a bone folder.

Should you desire to add color to your saddle the best times to apply dyes or antique stains are as follows:

Horn cover and swells-after they are attached to the tree but prior to final assembly.

Seat-after padded seat and cantel binding are completed but prior to final assembly.

Skirts-after they are fitted to bars but prior to final assembly.

Fenders-after tooling is completed.

Stirrups-after stirrups are assembled but prior to final assembly of saddle.

Strap Goods-after tooling is completed but prior to final assembly.

Conchos, Strap Holders-after tooling is completed but prior to final assembly.

NOTE: All leather must be completely dry prior to application of dye or antique stain.

Leathercrafters,

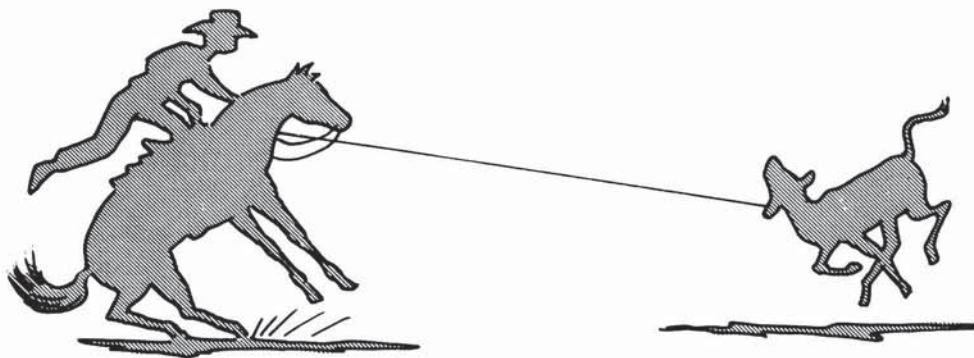
It is my sincere wish that you have a very enjoyable time making the ultimate leathercraft project, a saddle. I am sure you will enjoy using it for many-many years.

Good Luck,



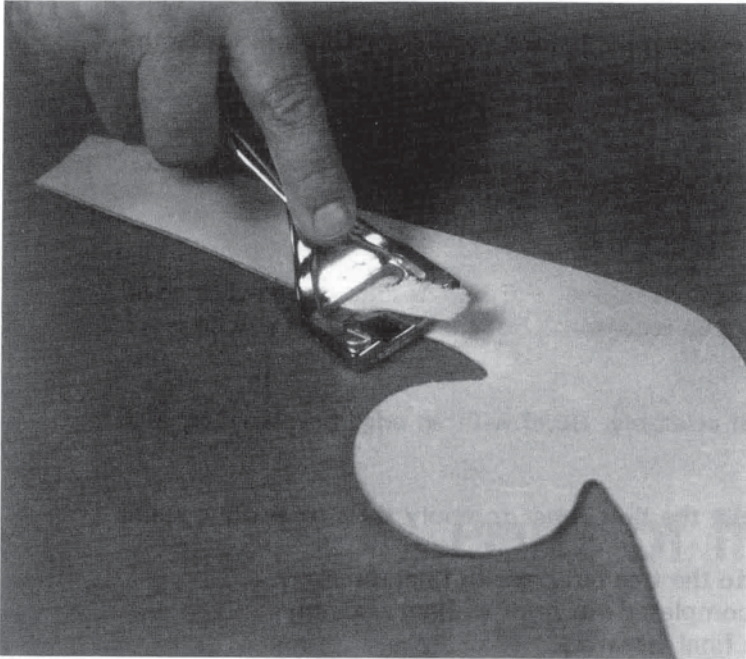
George Hurst

Thanks to Joe Bennett and Tony Laier for their help and advise on this project.

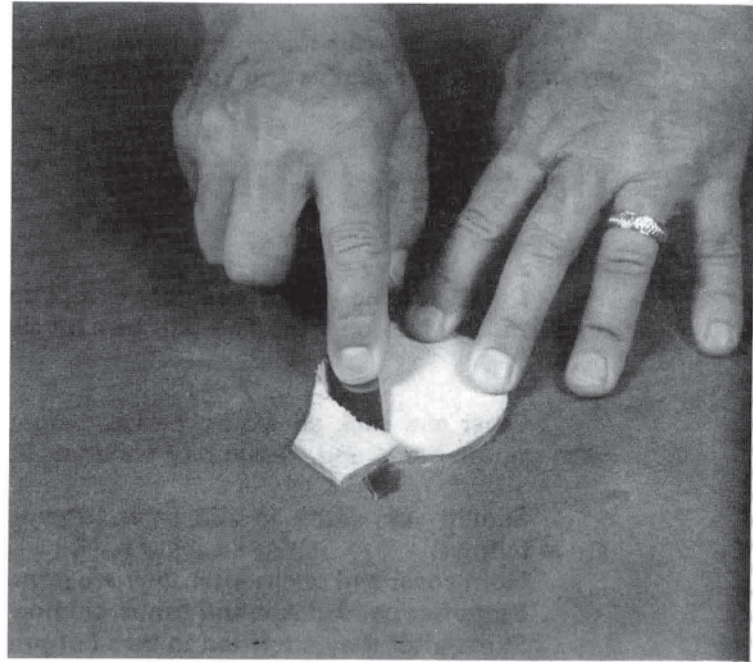


# Section I

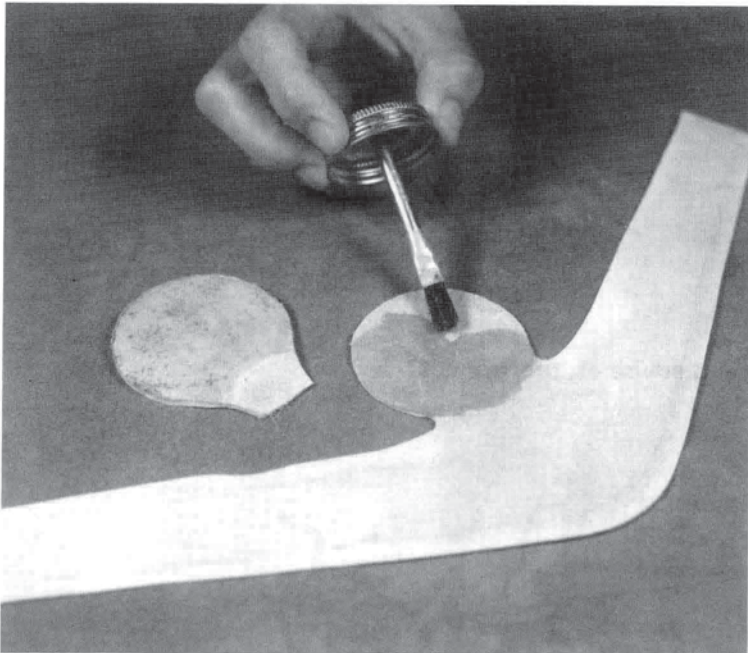
## Covering the Horn



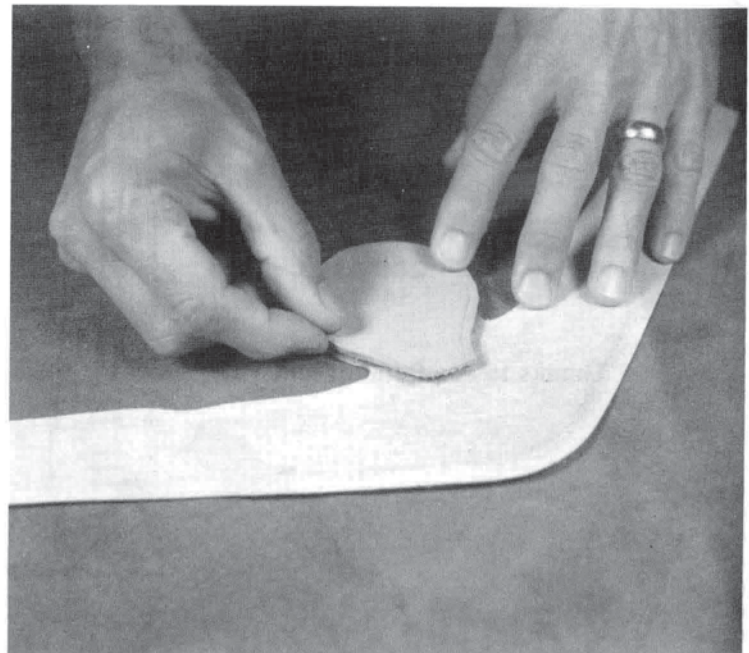
STEP 1. Skive horn cover as shown on pattern sheet.



STEP 2. Skive horn filler and horn lining as shown on pattern sheet.

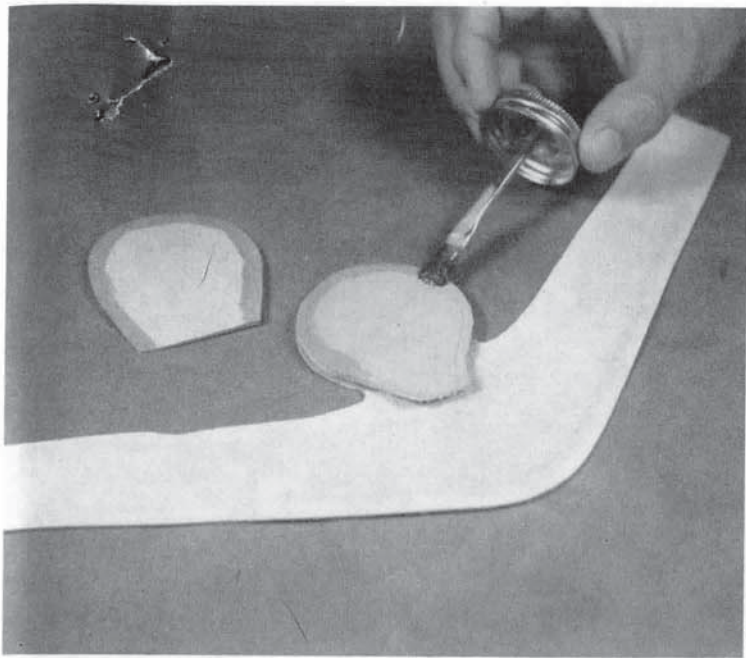


STEP 3. Apply craftsman cement to entire surface, except tail section, of horn cover (flesh side) and horn filler.

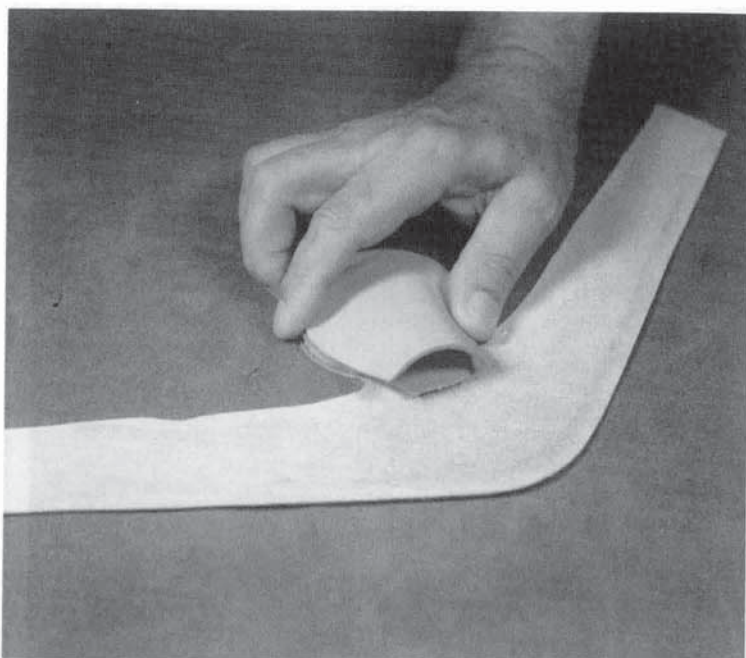


STEP 4. Allow cement to become tacky then adhere filler to cover as shown.

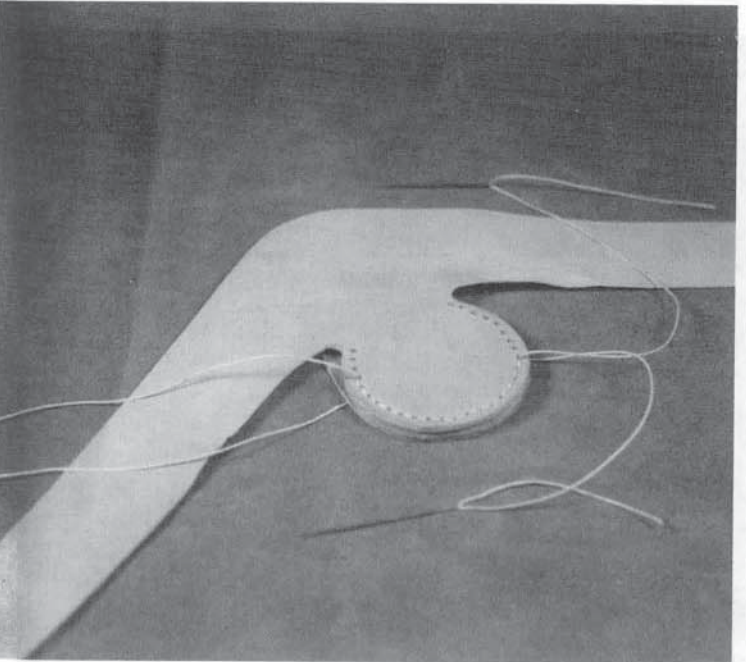




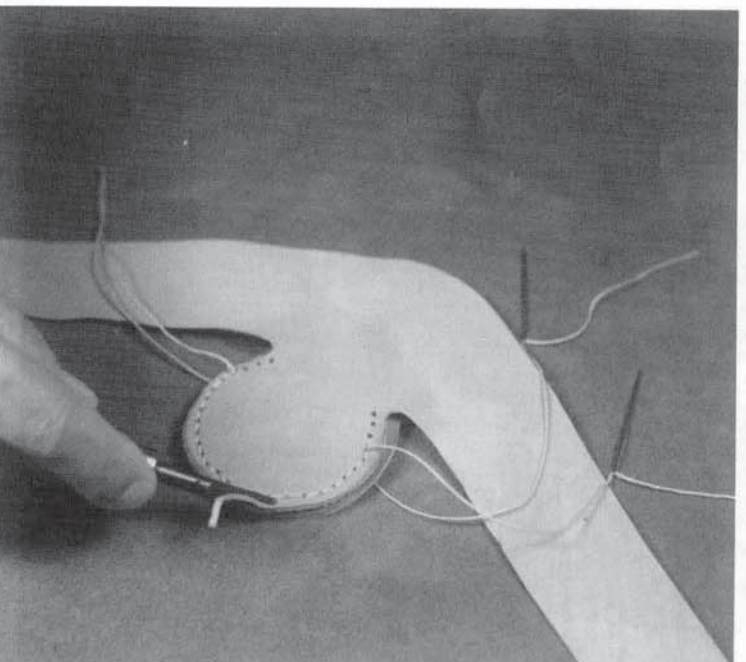
**STEP 5.** Apply cement along curved edges of horn liner (flesh side) and filler.



**STEP 6.** Allow cement to become tacky then adhere liner in place as shown. NOTE: open end to receive horn later.

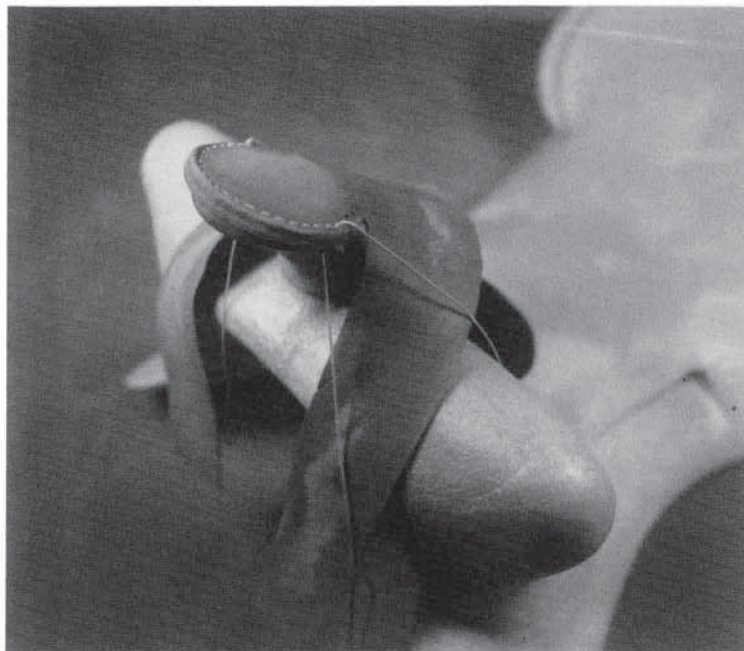


**STEP 7.** Stitch around outside of horn cover assembly. Leave thread ends about 6" long and begin stitching 4 stitch holes in from either end. Stitch around horn cover assembly, stopping 4 stitch holes from opposite end. NOTE: Refer to saddle stitching instructions included in this booklet.

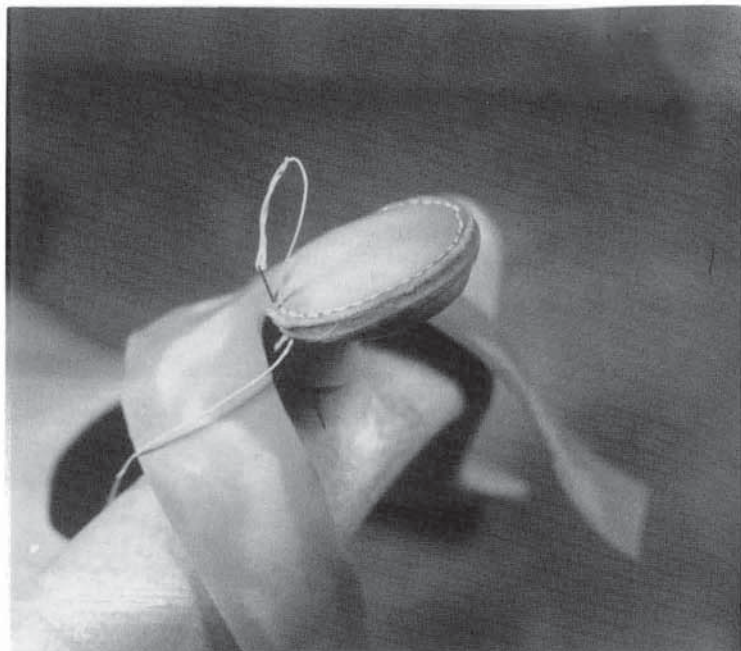


**STEP 8.** Round off top and bottom edge of horn cover assembly with an edge beveler.

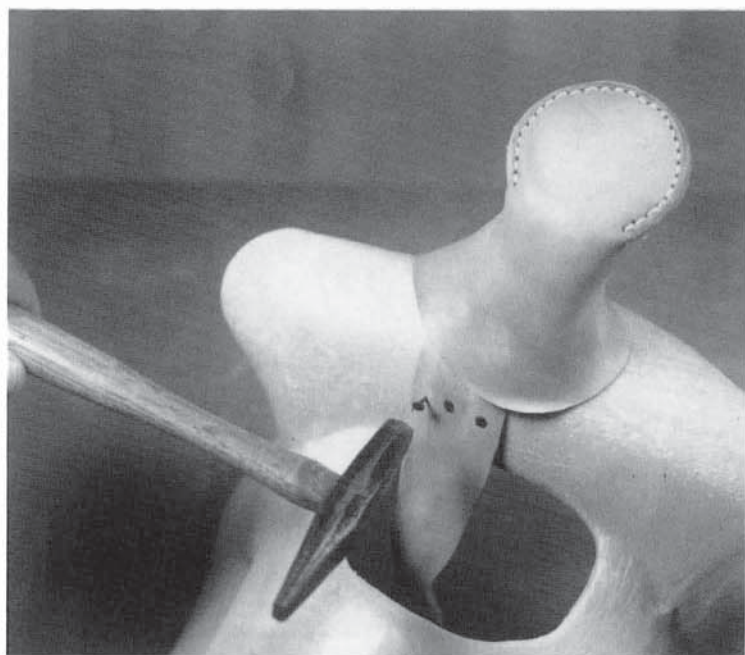




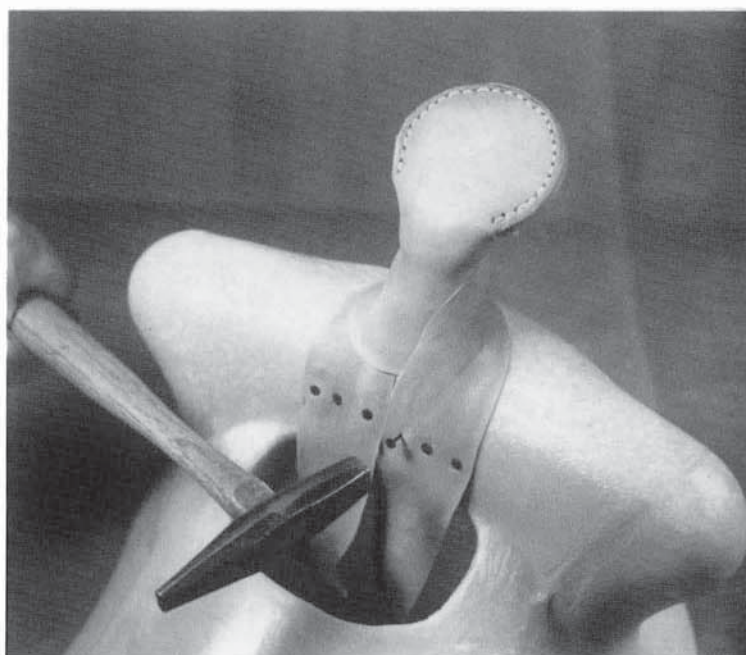
**STEP 9.** Completely soak assembly in water and pull over horn as shown.



**STEP 10.** Finish stitching in 4 open holes left on one side of horn cover. Repeat on other side.



**STEP 11.** Apply craftsman cement to flesh side of wing section of horn cover assembly. Pull one wing of cover assembly snugly around front of horn then down into gullet as shown. Secure with small tacks. NOTE: Re-wet leather if necessary and do this step and step 12 immediately before cement dries.

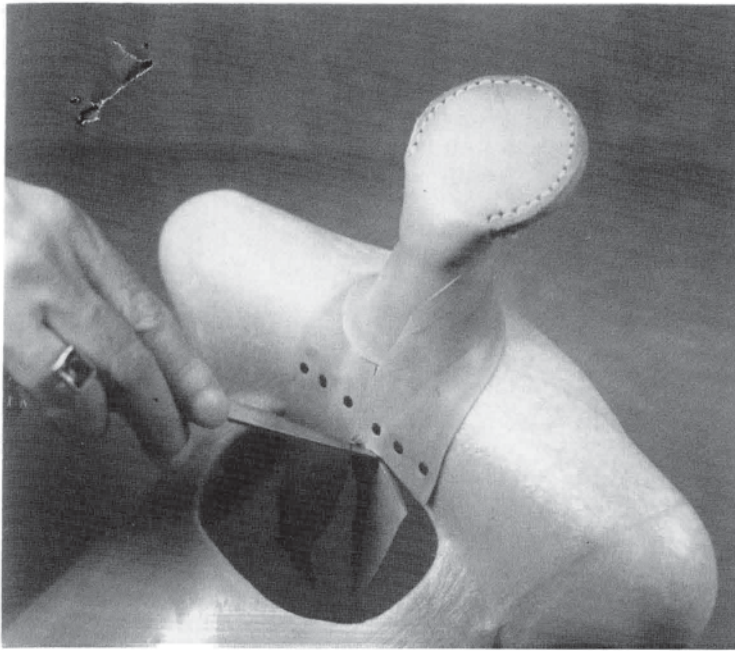


**STEP 12.** Pull other wing snugly around front of horn then down into gullet and secure with small tacks.



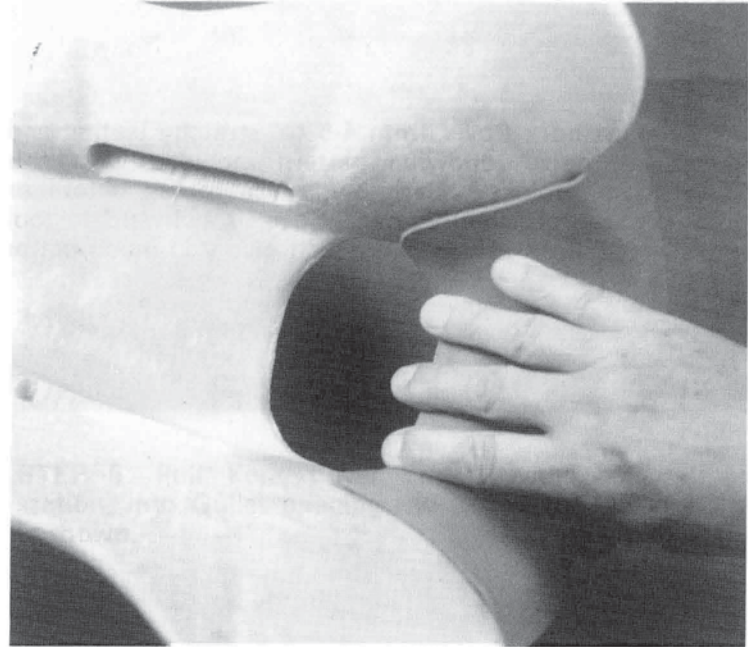
## Section II

### Gullet Liner

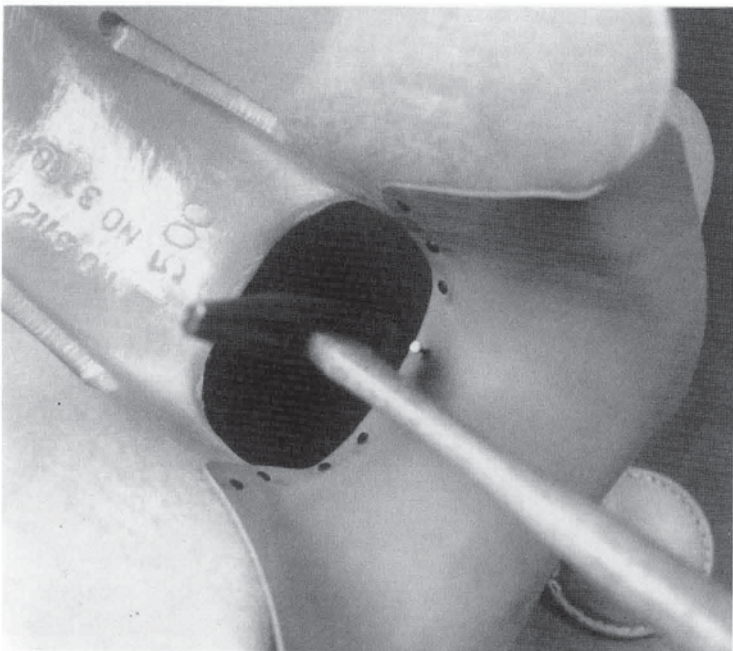


**STEP 13.** Trim off excess wing leather with a sharp knife as shown.

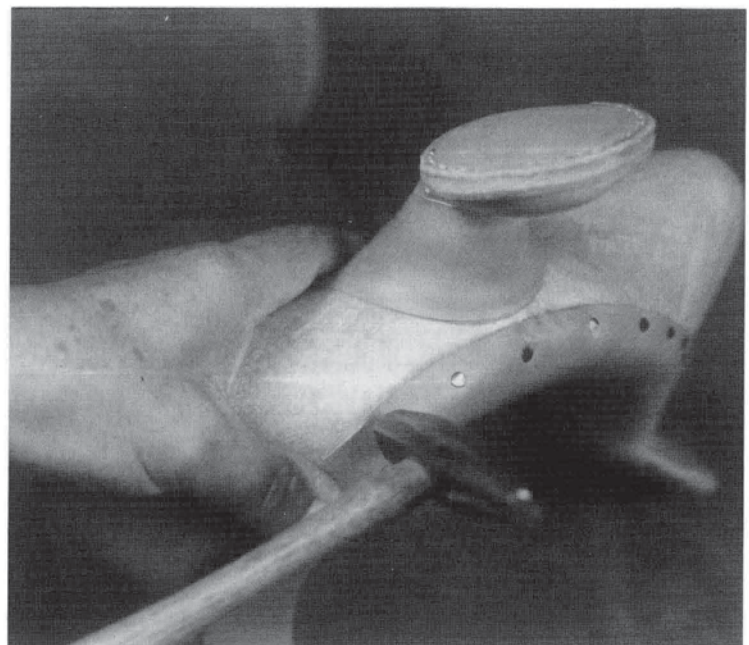
**STEP 14.** After horn cover has dried, redampen stitched edge then slick with a piece of canvas or denim.



**STEP 1.** Soak gullet liner in water then prefit on gullet as shown. Narrow end of lining should be even with edge of gullet opening.



**STEP 2.** Coat flesh side of liner with craftsman cement then tack narrow end into position with small tacks. Do this while cement is still wet.



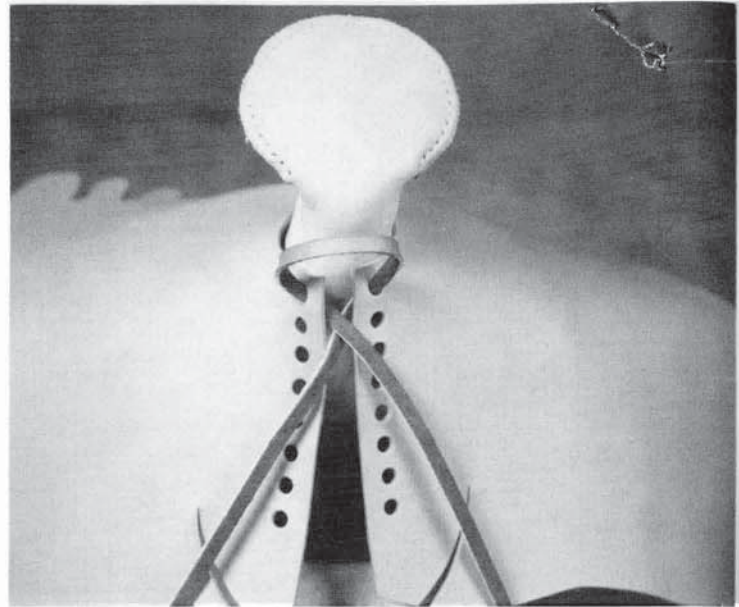
**STEP 3.** Pull liner tightly around to front of fork and tack in place as shown.



## Section III

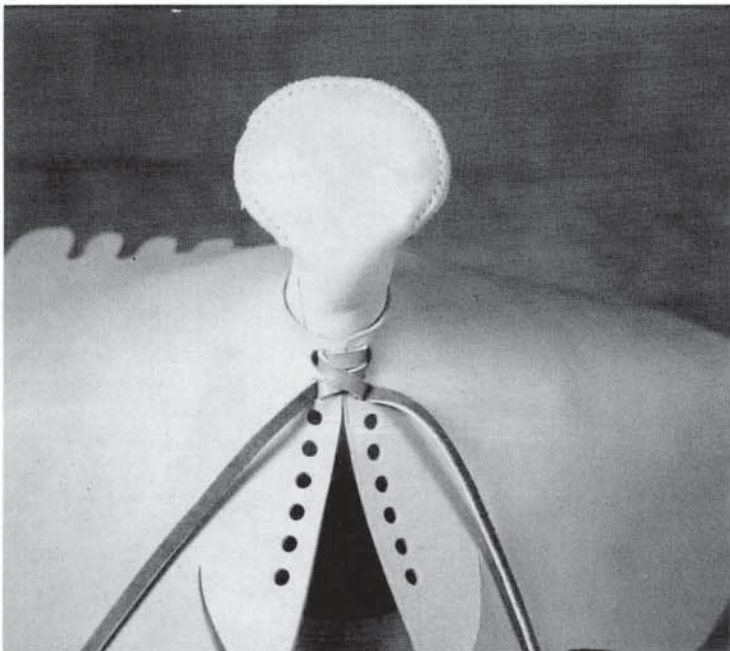
### Fork Cover

**NOTE.** Cut Fork Cover from 4-5 oz. stretchy leather and punch all holes following pattern included with this instruction booklet. Designs may be tooled before or after cover is attached to tree. Cover is awkward to tool after it has been attached but will give you much better looking results.

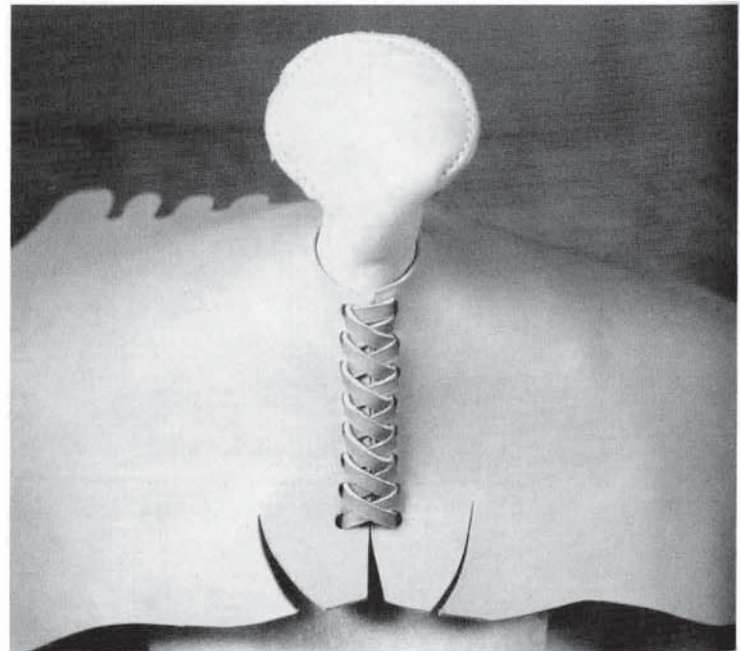


**STEP 1.** Thoroughly dampen leather with water. Place around horn, as shown, and begin lacing with a 48" long piece of 1/4" latigo lace.

**NOTE.** Refer to cross stitch lacing instructions included in this booklet.

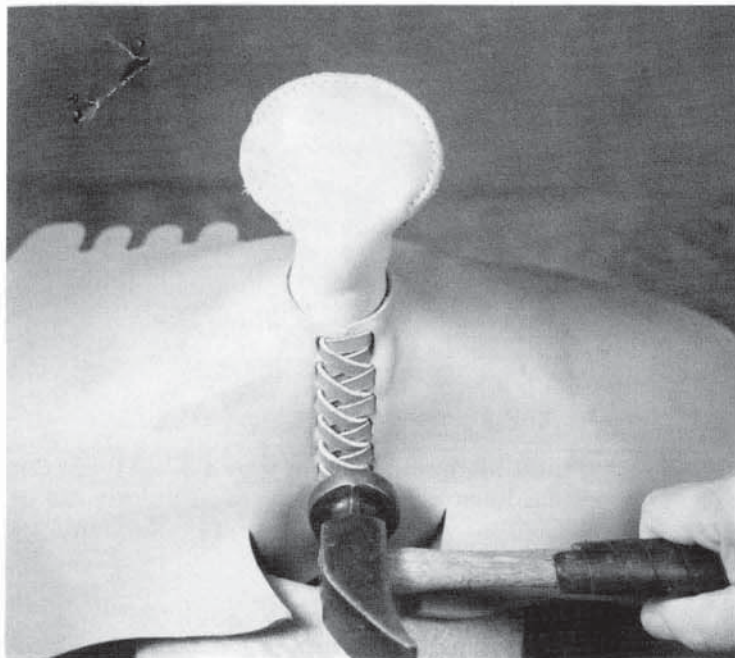


**STEP 2.** Continue lacing, pulling lace just tight enough to cause edges of cover to butt together. Do not allow the edges to overlap.



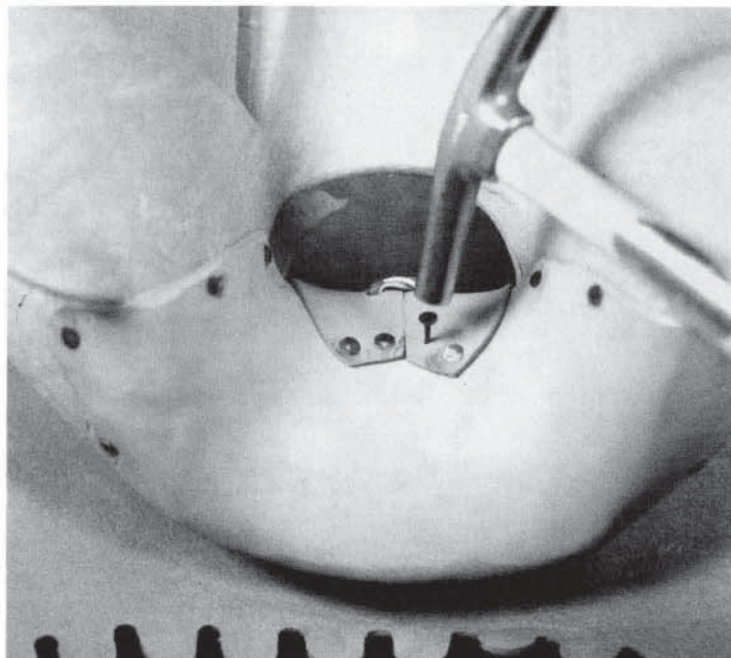
**STEP 3.** After lacing through bottom last two holes, trim lace ends off leaving about 1" of lace on inside of Fork Cover. Secure ends in place with Craftsman Cement.



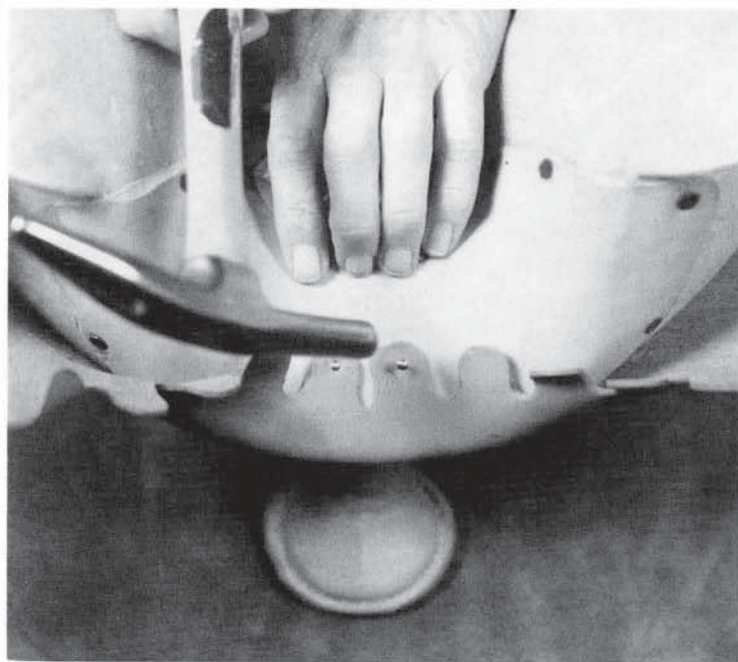


**STEP 4.** Tap lacing flat with a mallet or smooth faced hammer.

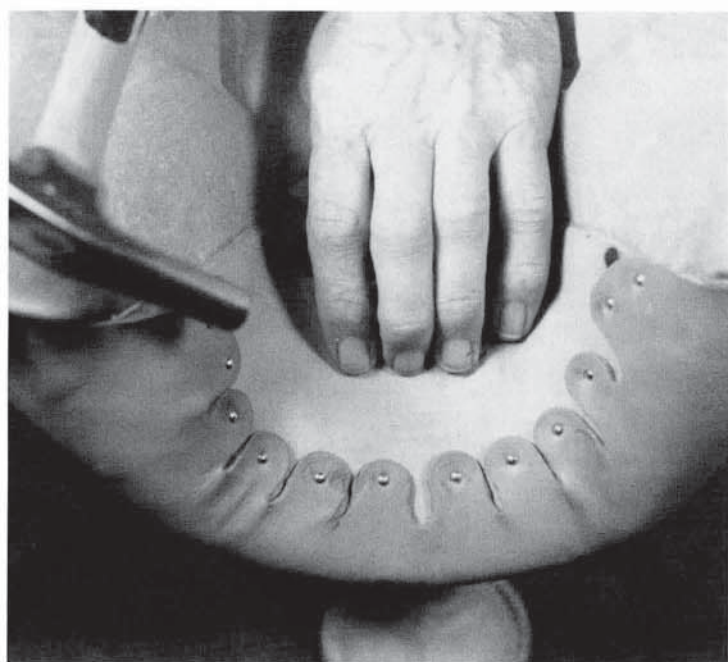
**NOTE:** At this time, apply a liberal coat of Craftsman Cement to inside of Fork Cover. Continue on to step 5 immediatly, while cement is still wet.



**STEP 5.** Pull Fork Cover Ends, located below laced section, into Gullet opening and secure with small tacks, as shown.

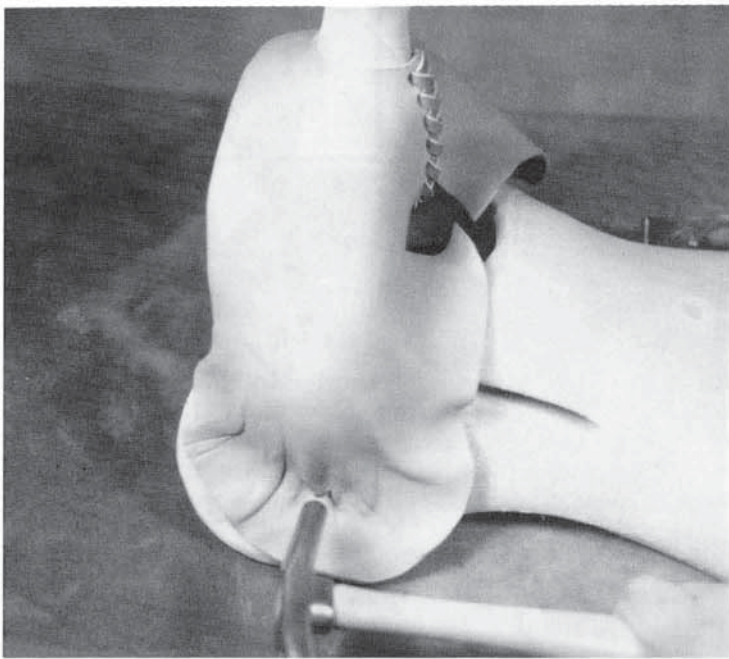


**STEP 6.** Secure front part of Fork Cover to underside of Gullet opening with brass nails. Start in center, as shown.

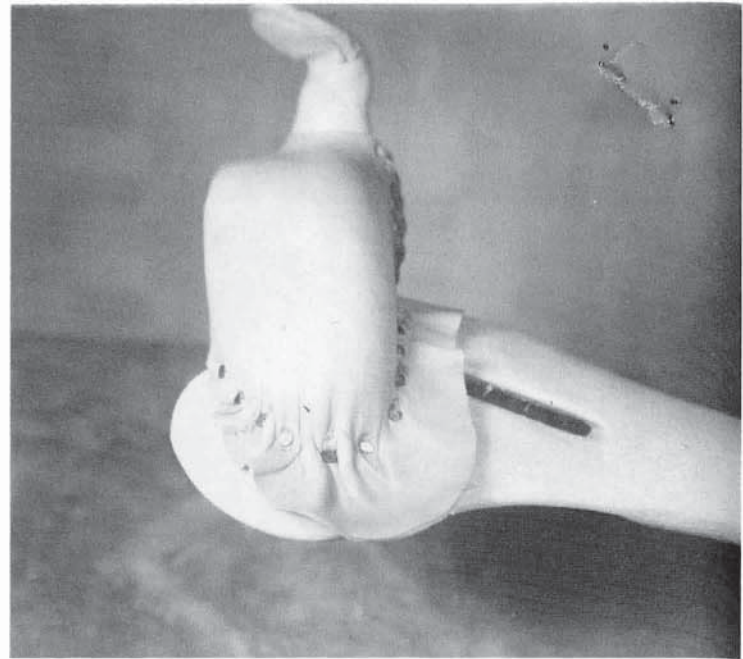


**STEP 7.** Continue pulling, stretching, forming then nailing front part of Fork Cover to underside of Gullet, as shown.

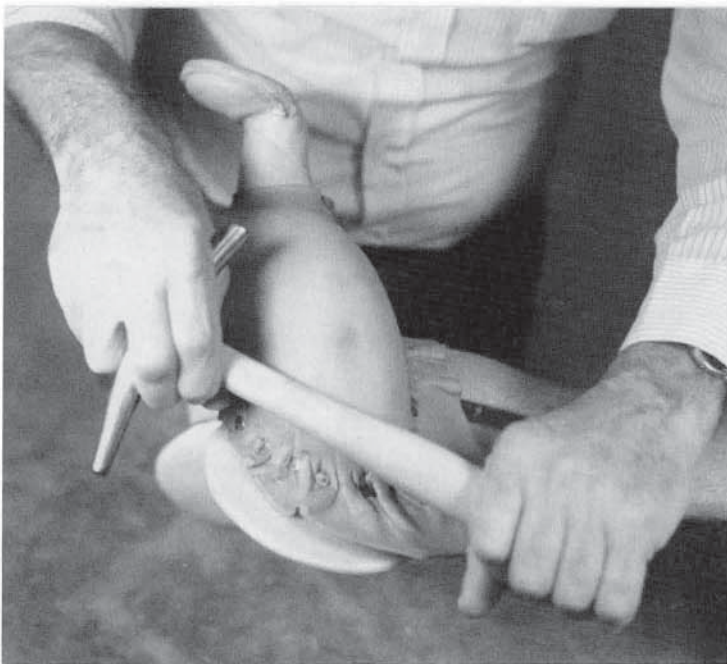




**STEP 8.** Pull and shape one side of Fork Cover down over Swell and secure in place with a small tack, as shown. Repeat on other side.



**STEP 9.** Continue molding, shaping then tacking Fork Cover into crease where Swells meet Tree Bars, as shown. Use as many tacks as necessary.



**STEP 10.** Smooth leather down with handle of tack hammer or mallet, as shown.



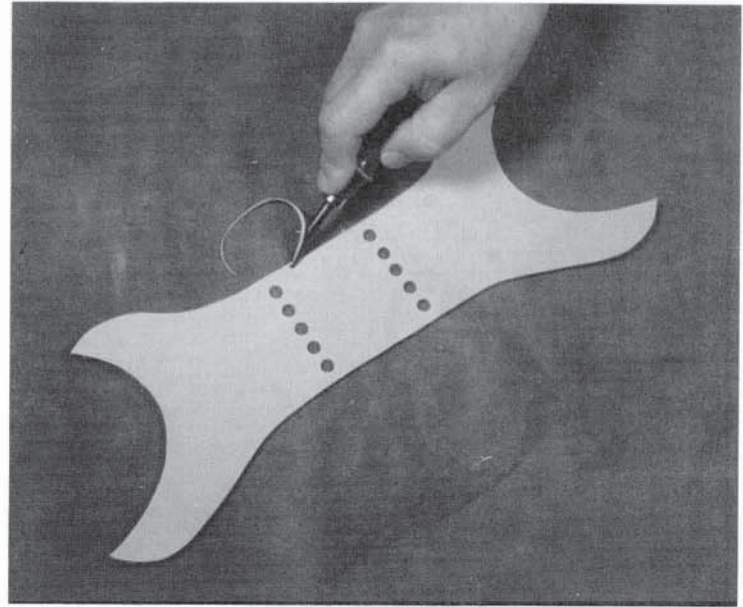
**STEP 11.** Trim away excess leather, as shown.



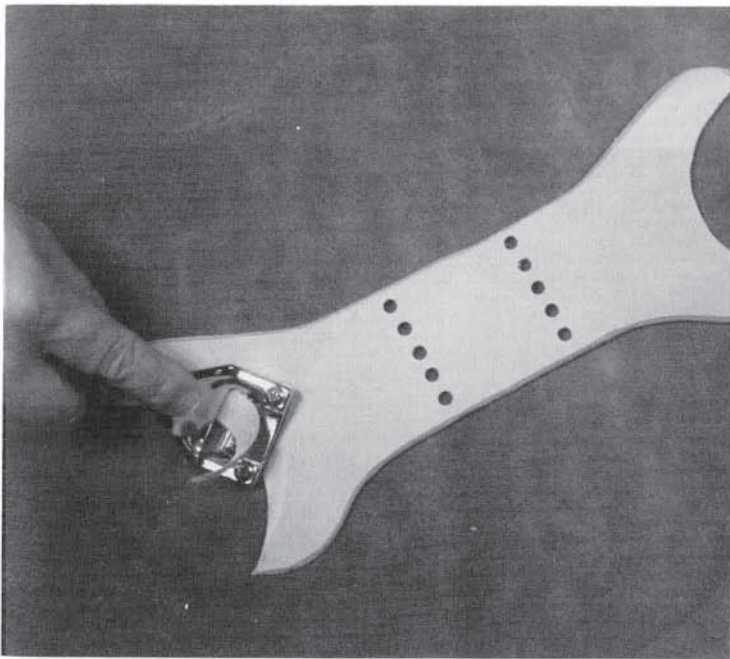
## Section IV

### Rigging

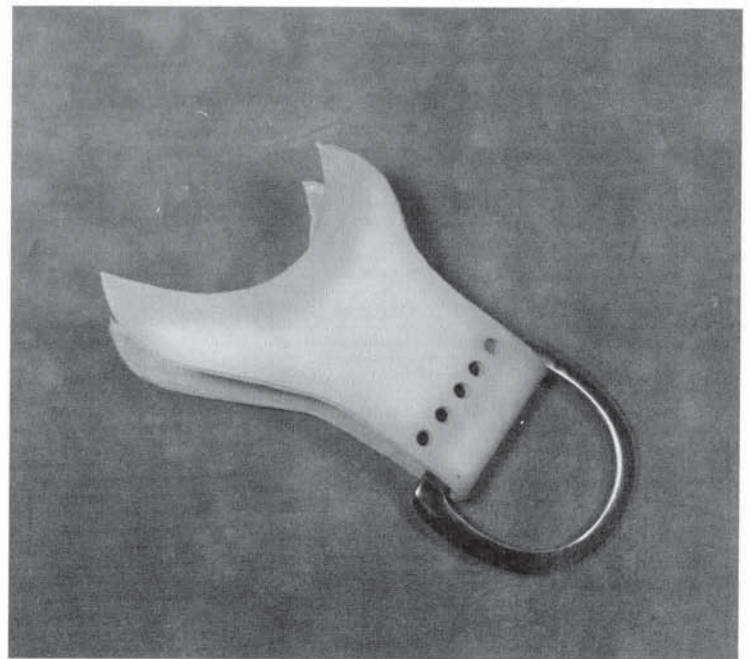
**NOTE.** This is a very important part of the saddle. Be sure to cut rigging from very firm section of hide. Avoid belly and neck areas.



**STEP 1.** Bevel then slick both top (smooth) and bottom (rough) sides of all edges on front and back rigging parts.



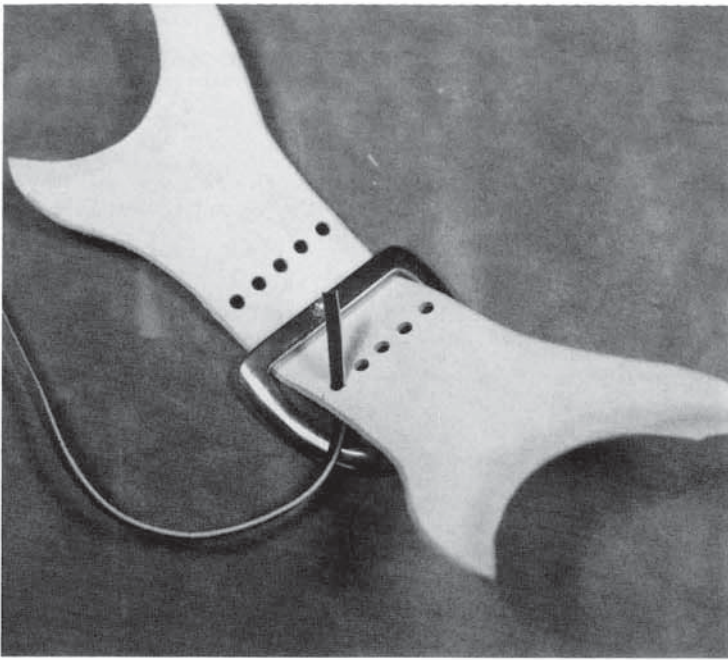
**STEP 2.** Skive parts where indicated on pattern sheet.



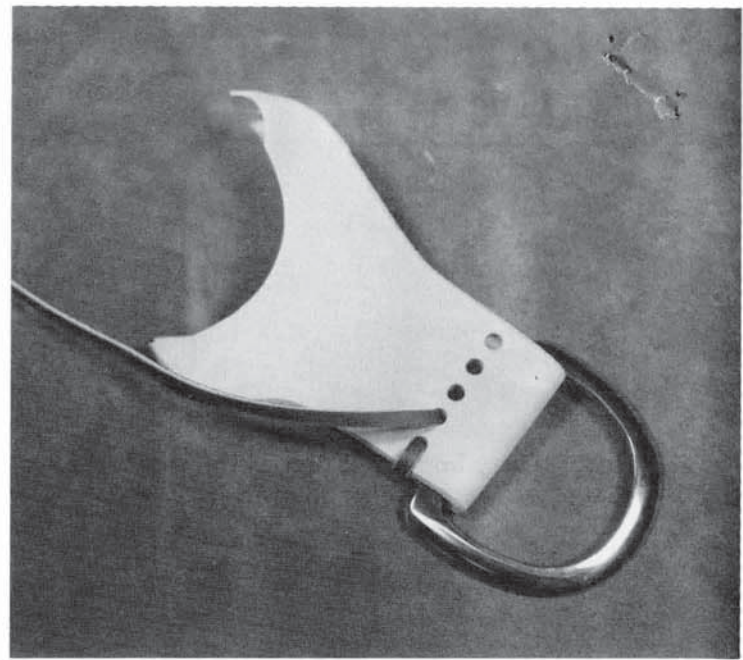
**STEP 3.** Dampen one rigging part and fold through one rigging dee, as shown. Photos in steps 1 through 9 show a front rigging part being made. Back rigging parts are assembled the same way until you reach step 10.

**NOTE.** Dees have a back (flat) side and a front (rounded) side. You will make one front and one back rigging part for right side of saddle as well as one front and one back part for left side of saddle.

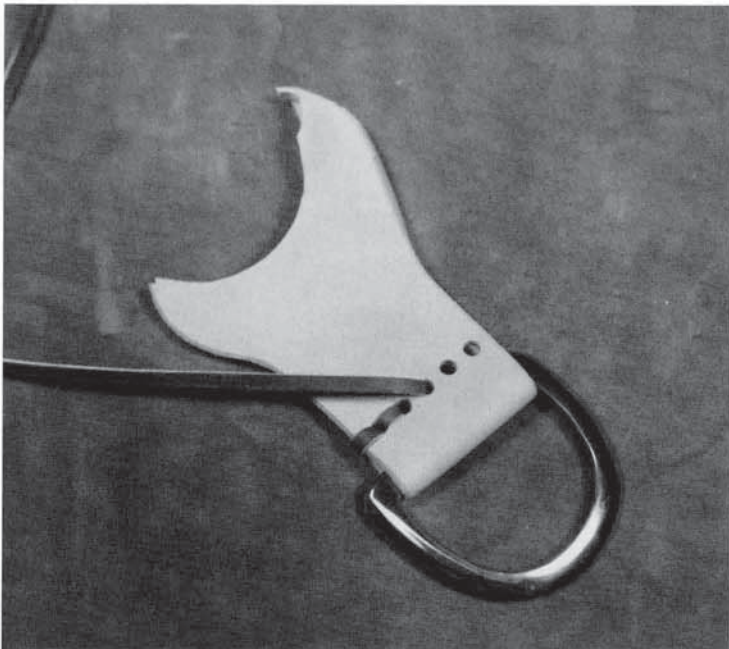




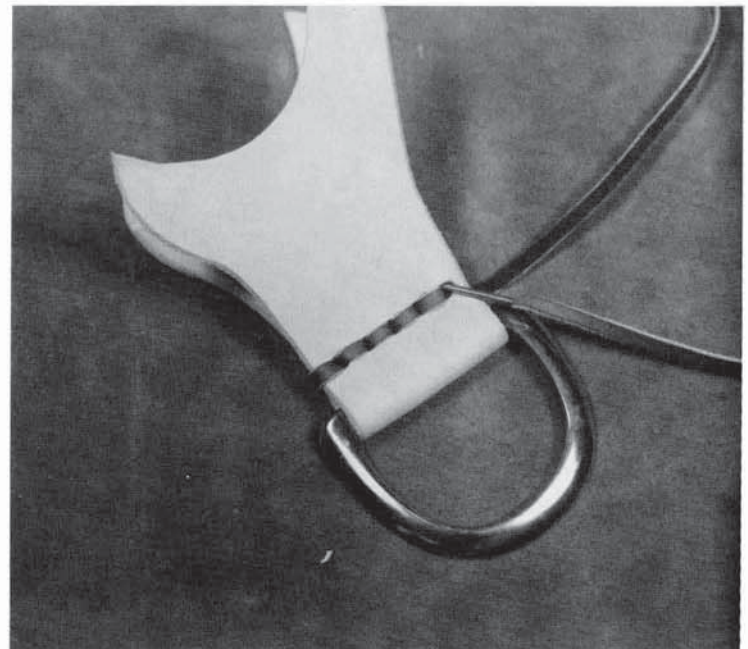
**STEP 4.** Begin lacing using one 12" long piece of 1/4" latigo lace, as shown. Start lacing through first hole on rounded side of rigging dee.



**STEP 5.** Fold rigging part over. Pull lace around edge then run end up through second hole, from back side to front side, as shown.

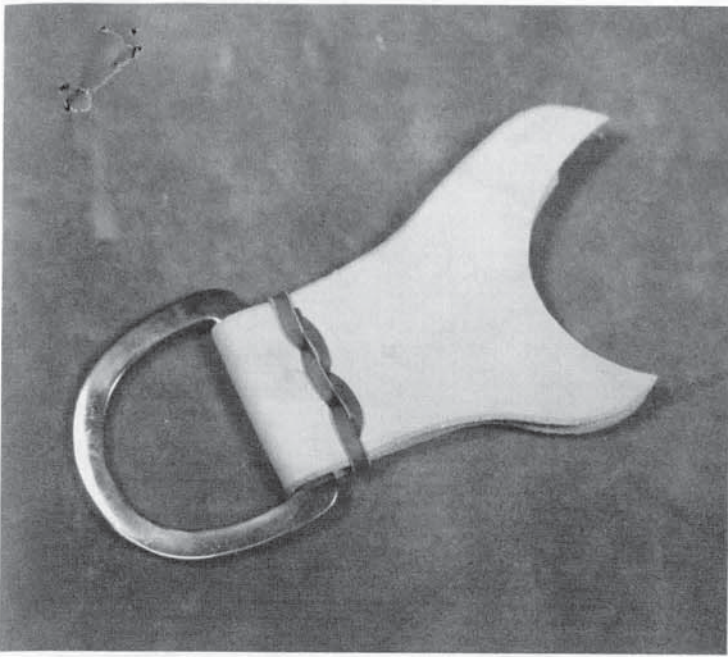


**STEP 6.** Continue lacing by running end of lace back down through first hole, then up through third hole as shown.

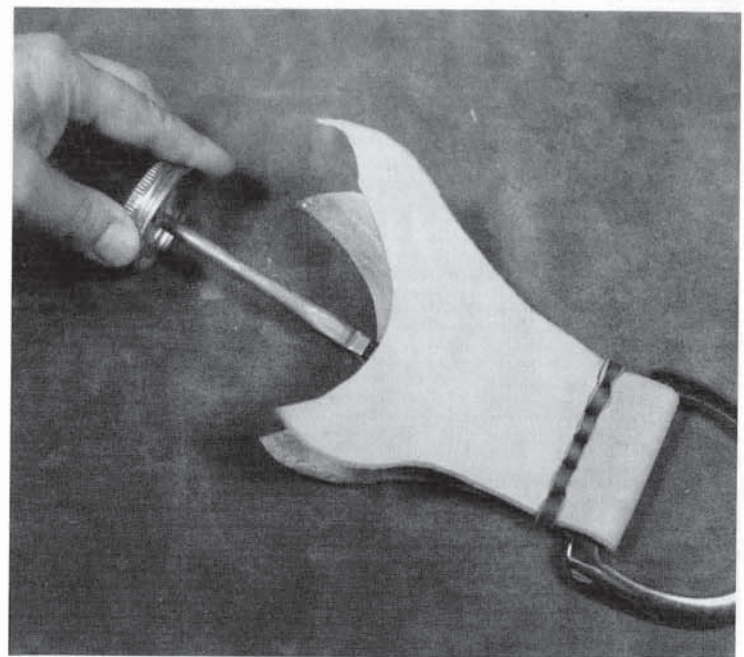


**STEP 7.** Continue lacing in this manner until you reach the other end. Pull lace around edge. Run lace end through last hole, coming out between the two layers of leather. Trim off all but 1" of excess lace.

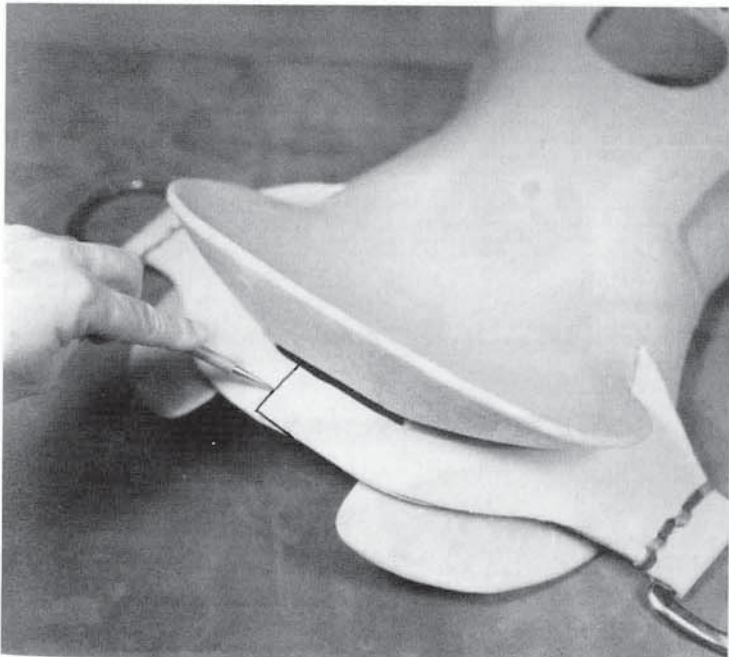




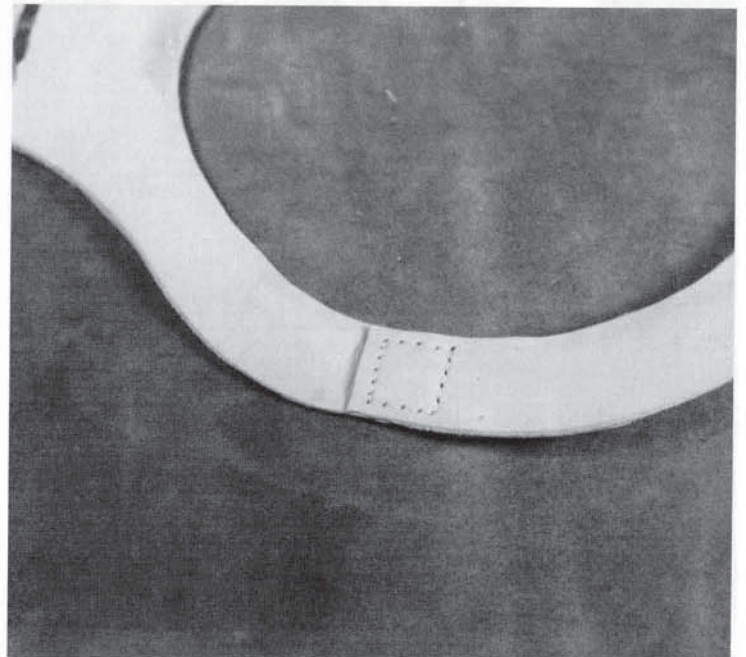
STEP 8. Back view of completed Rigging Assembly.



STEP 9. Cement both layers of leather together with Craftsman Cement, as shown. Repeat steps 1 through 9 with remaining front and back rigging parts and dees.

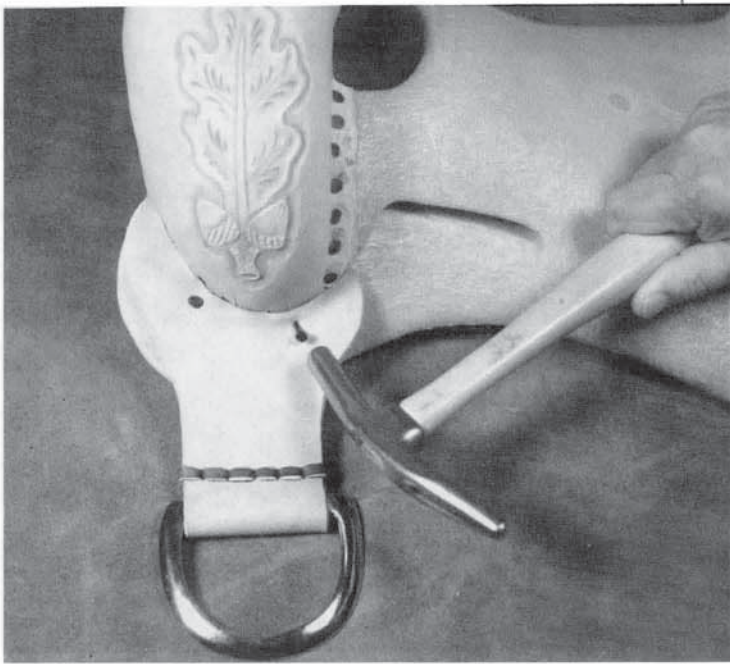


STEP 10. Place two back rigging assemblies in position on tree, behind Cantel. Mark where long ends of assemblies overlap, as shown.



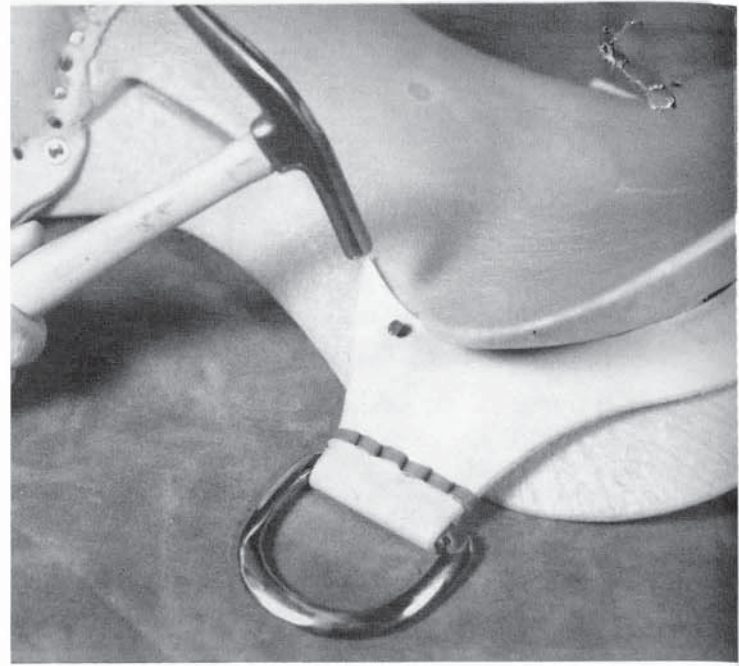
STEP 11. Stitch back assemblies together, as shown.





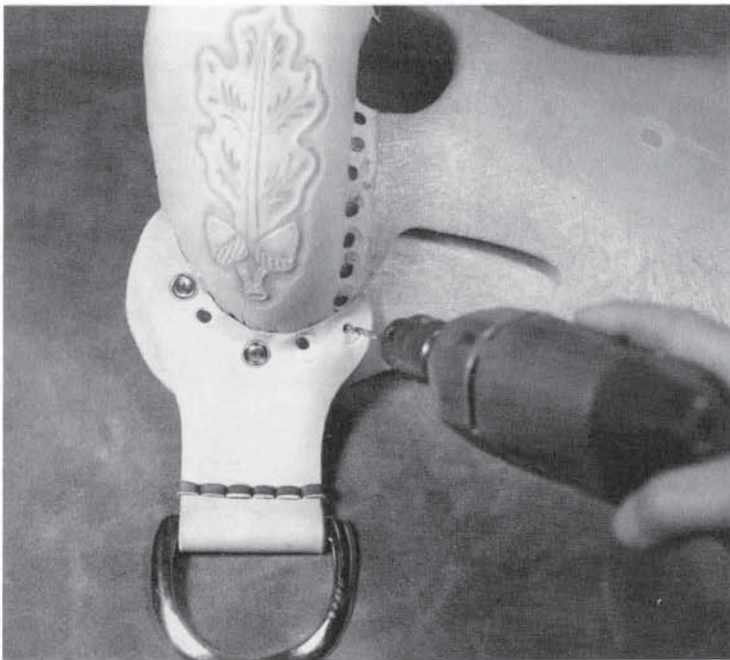
**STEP 12.** Tack front rigging assemblies in place with small tacks, as shown.

**NOTE.** Positioning is very important. Dees must hang at a perfect right angle to the line of the Swells.

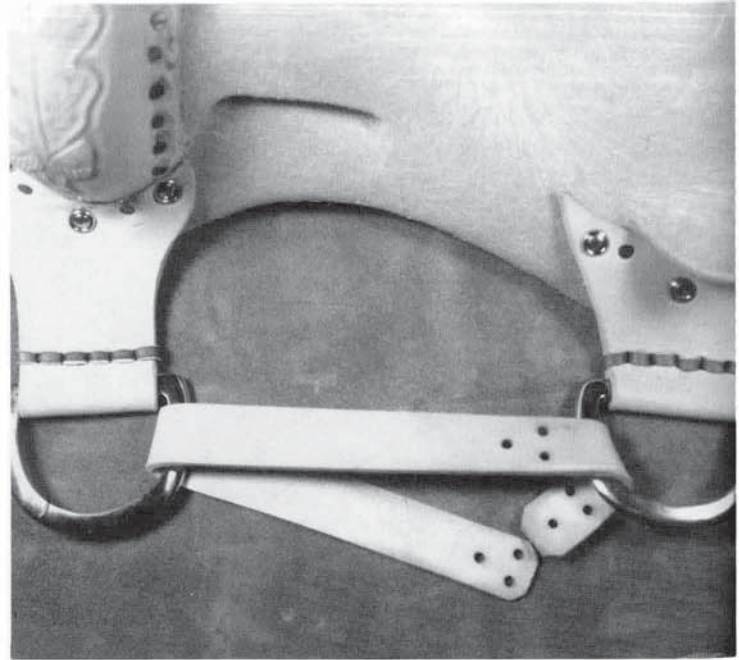


**STEP 13.** Tack Back Rigging Assemblies in place with small tacks, as shown. Back dees must also hang at right angles to the line of the tree and must line up with front dees.

**NOTE.** See step 16 for view of completed rigging.



**STEP 14.** Secure Rigging Assemblies to Tree, as shown. Use three 1" domed head screws and finishing washers for each Rigging Assembly. See pattern sheet for correct positions of screws.

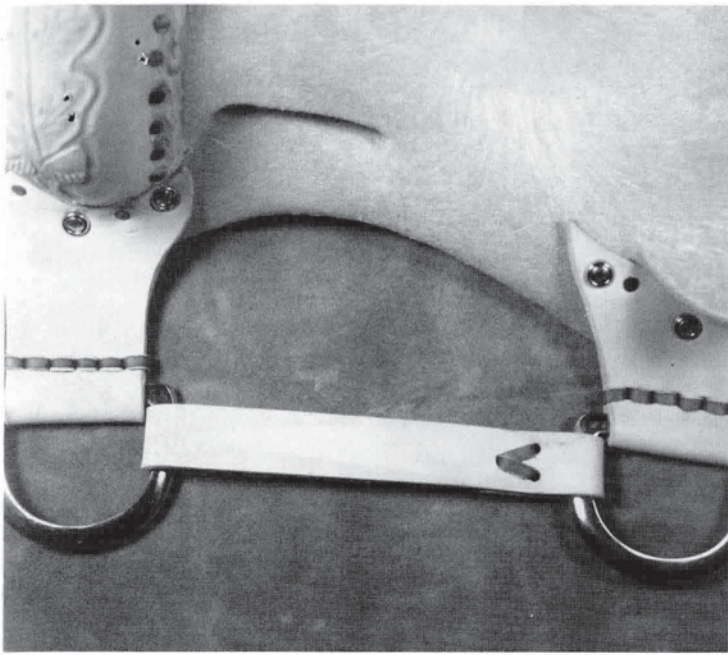


**STEP 15. IMPORTANT:** Before you cut out and punch holes in connector straps, check exact length needed. Minor variations in length may have occurred as rigging assemblies were secured to tree that need to be corrected now.

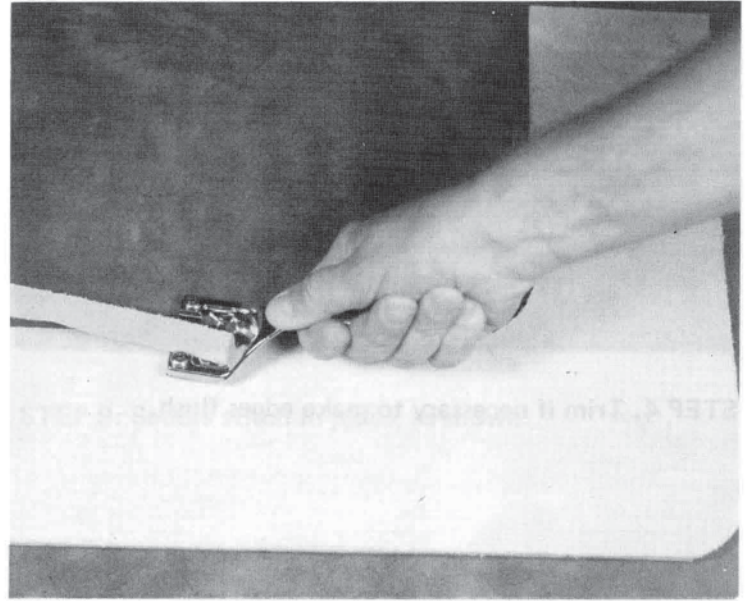


## Section V

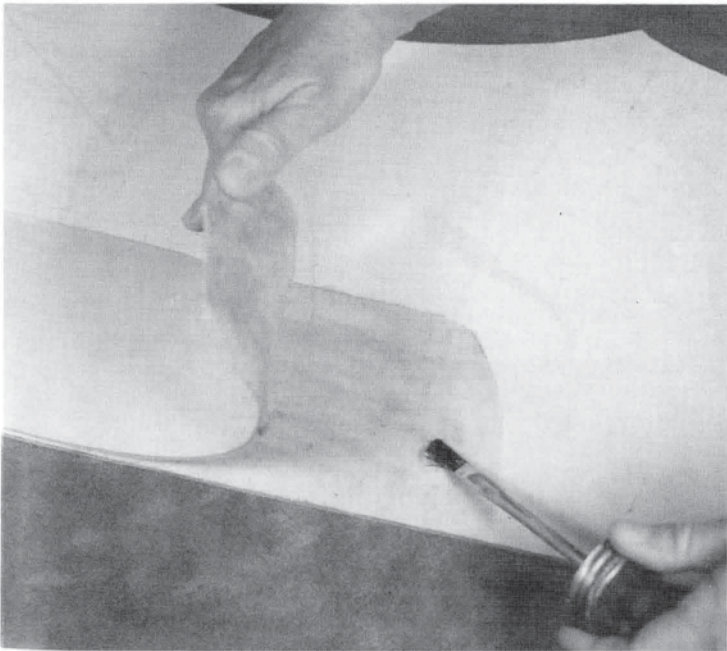
### Skirts



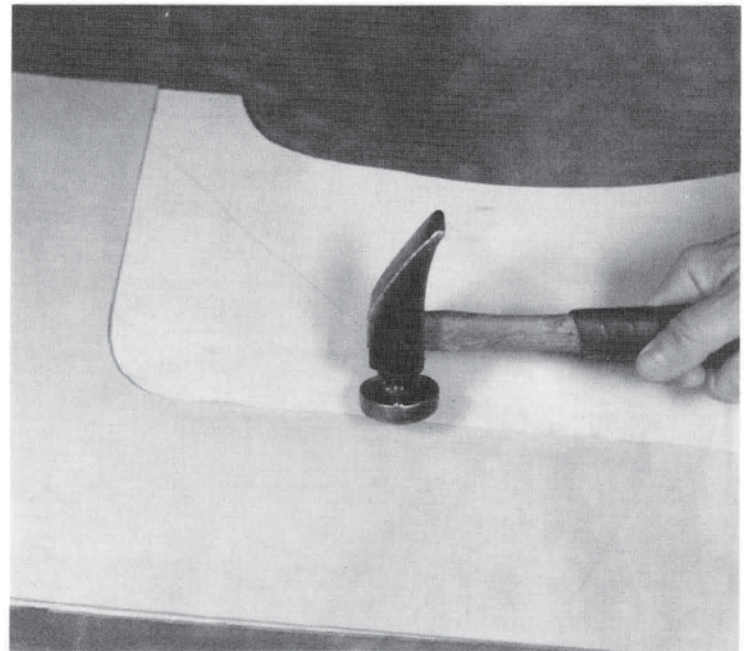
**STEP 16:** Secure one connector strap to rigging dees on one side of tree with a 6" long piece of 1/4" latigo lace. Refer to 3 hole bleed knot instructions included in this booklet. Repeat on other side of tree.



**STEP 1:** Cut and skive skirts, skirt supports, front jockeys and back bar pockets, as indicated on pattern sheet.

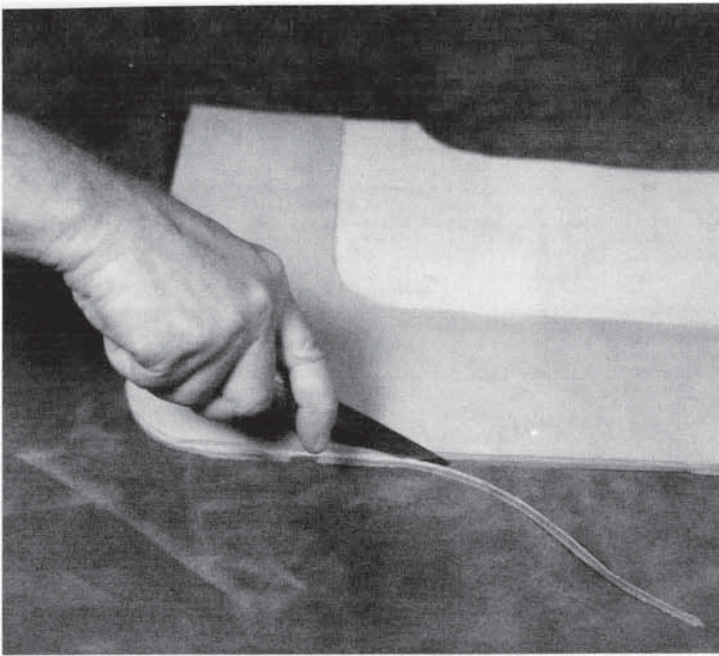


**STEP 2:** Cement skirt supports to skirts, rough sides together, where shown on pattern sheet.

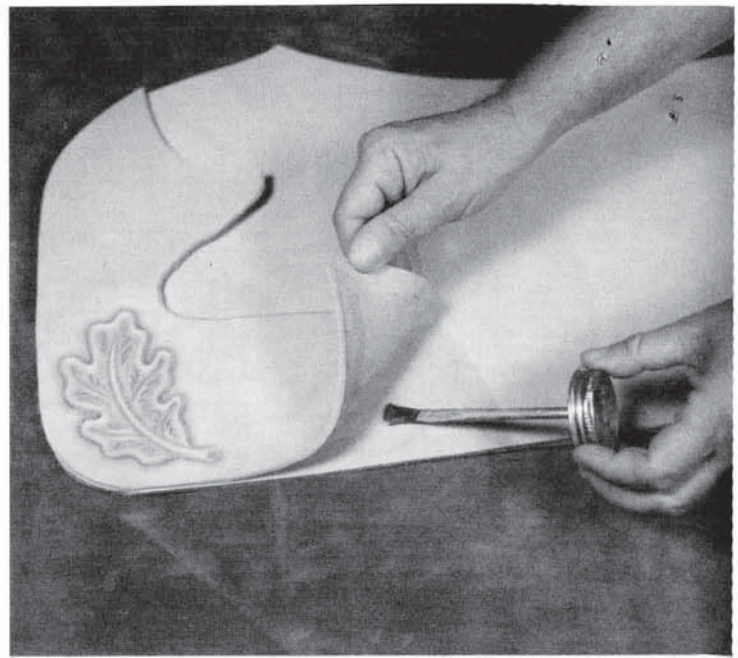


**STEP 3:** Tap down securely with mallet or smooth faced hammer.

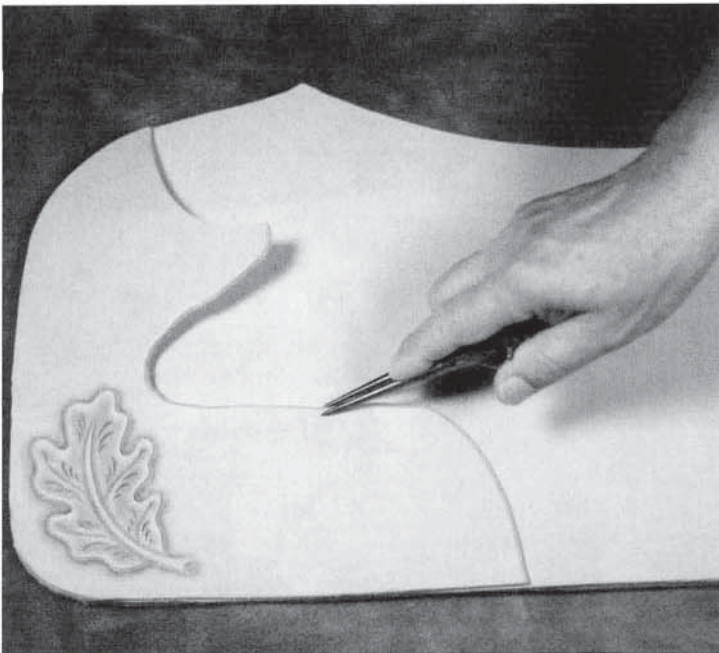




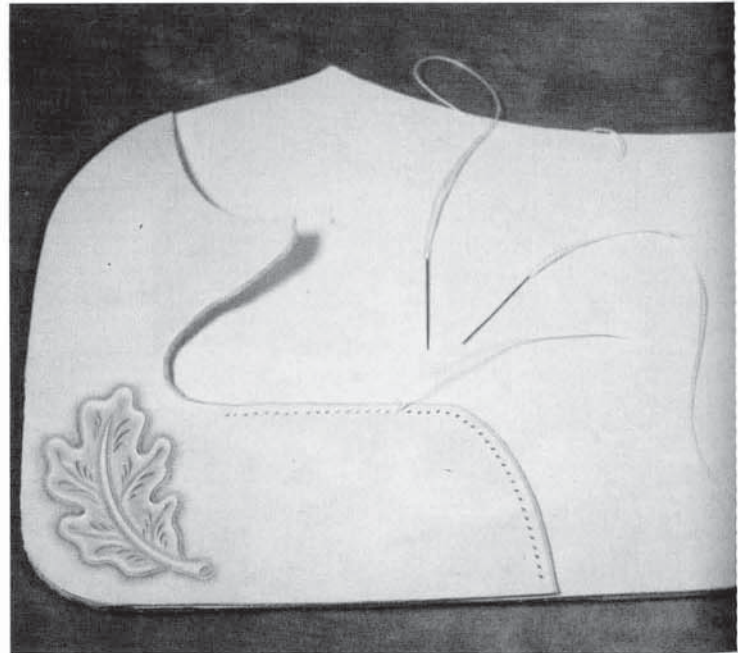
**STEP 4.** Trim if necessary to make edges flush.



**STEP 5.** Cement front jockeys to skirts (rough sides of jockeys to smooth sides of skirts), as shown. **IMPORTANT:** Apply cement to skived areas only.

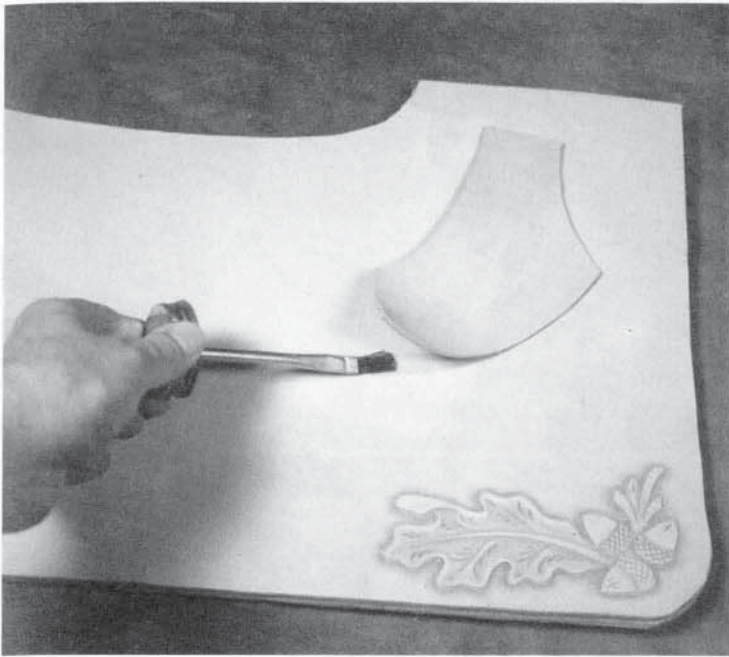


**STEP 6.** Mark stitching line  $3/16''$  in from edge on both front jockeys, as shown. Refer to pattern sheet for starting point.



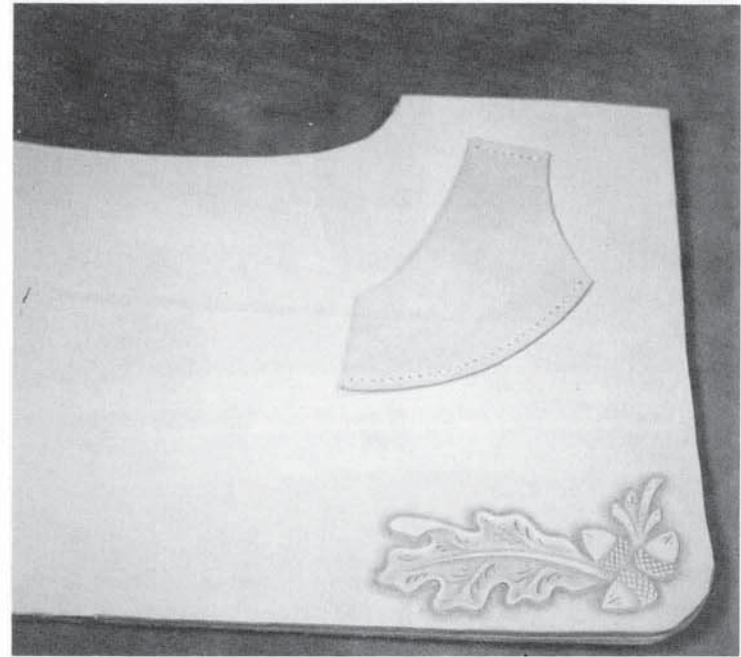
**STEP 7.** Stitch jockeys in place, as shown, following saddle stitching instructions included in this booklet.



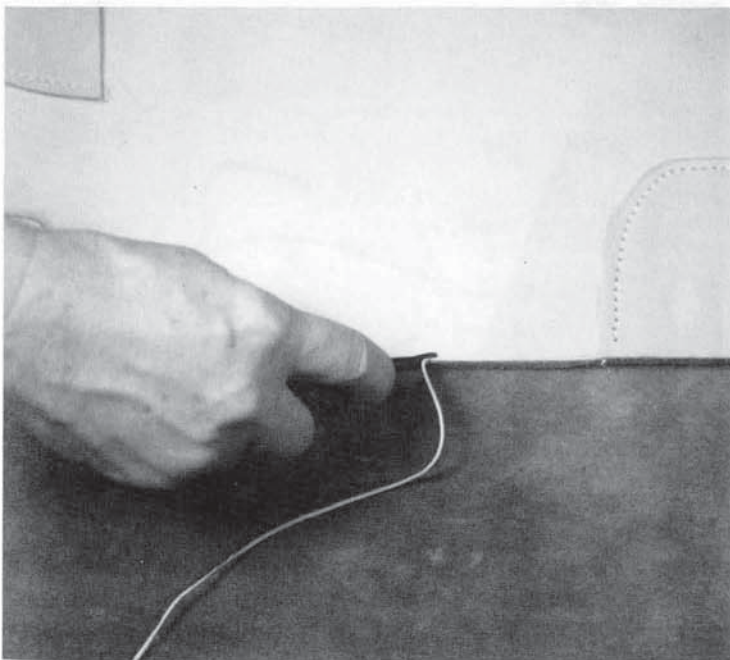


**STEP 8:** Cement back bar pockets in place on skirts (rough sides of pockets to smooth sides of skirts), where shown on pattern sheet.

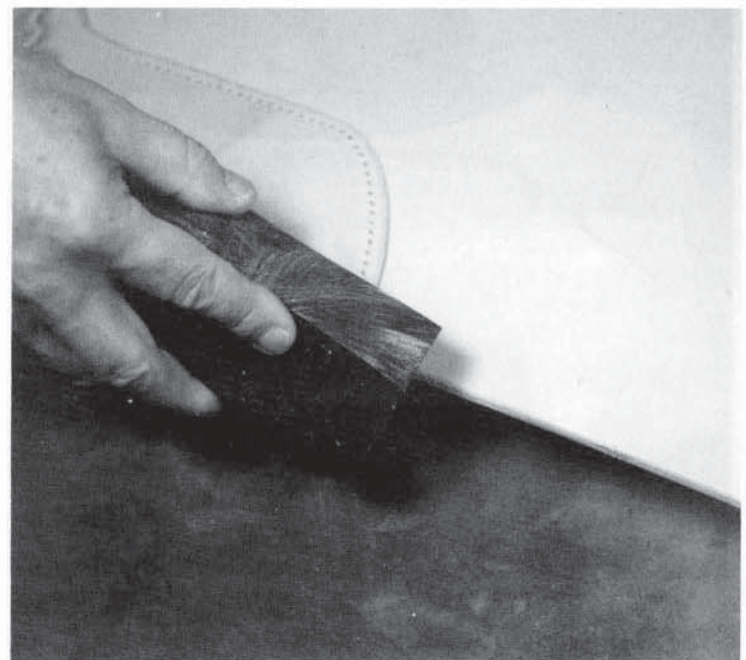
**IMPORTANT:** Cement edges to be stitched only.



**STEP 9:** Saddle stitch in place, as shown.

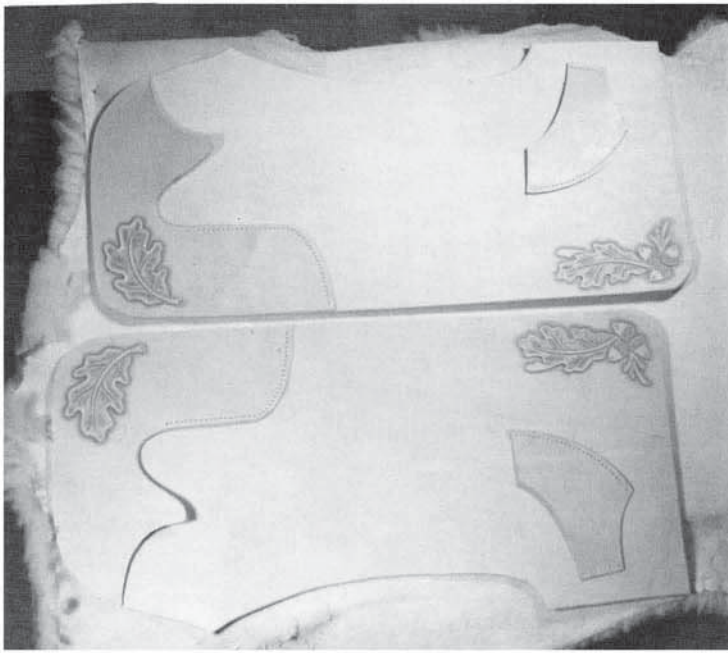


**STEP 10:** Round off all outside edges of both skirts with edge beveler, as shown. Edge both front and back sides.

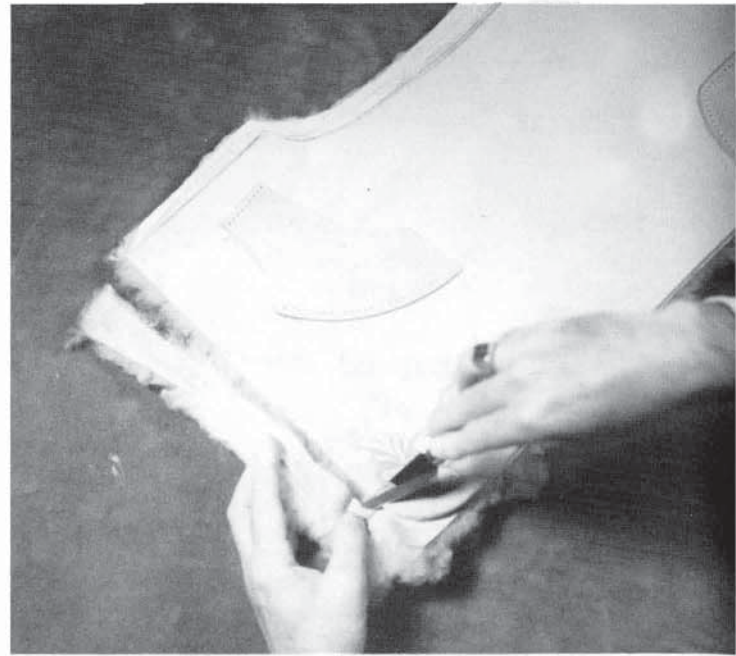


**STEP 11:** Smooth all edges with medium, then fine grit sand paper or emory cloth.



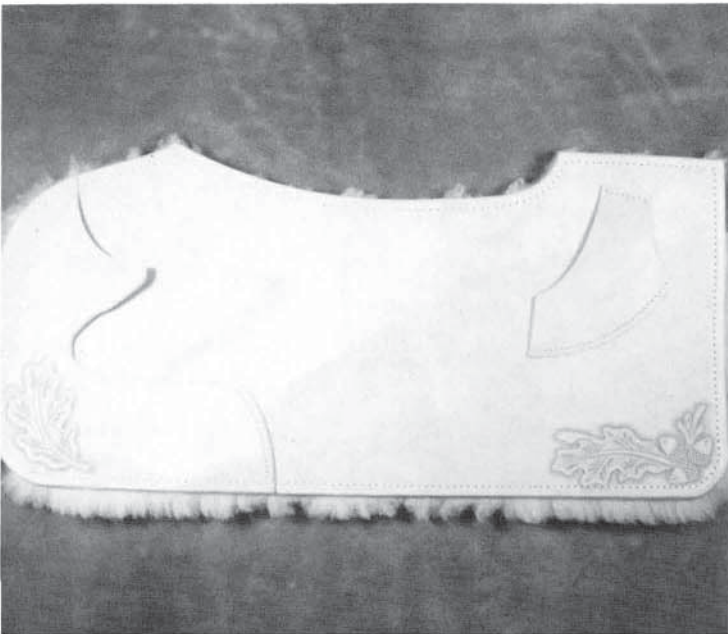


**STEP 12:** Cut 2 Skirt Liners out of 3/4" shearling or synthetic sheepswool, slightly larger than skirt assemblies.



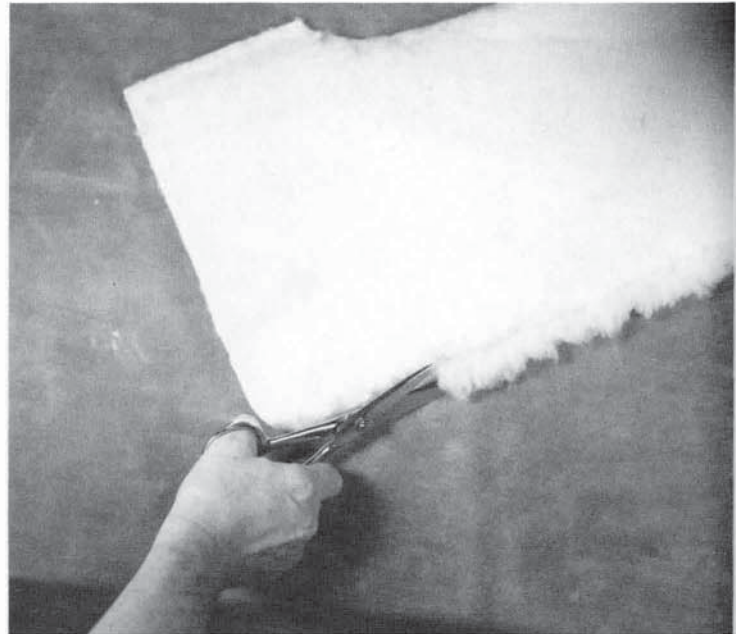
**STEP 13:** Cement Liners in place on skirts with Craftsman Cement then trim with a sharp knife, as shown.

**NOTE:** Apply cement sparingly. If cement soaks through Liners it will cause wool to clump.



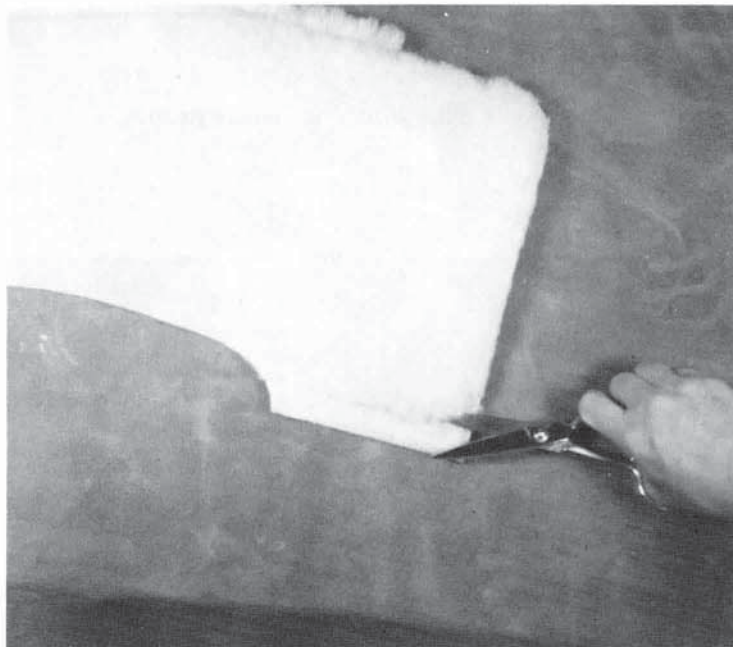
**STEP 14:** Saddle stitch around entire outside edge of both skirts, as shown.

**IMPORTANT:** Prepare threads for stitching through wool, as shown in this booklet.

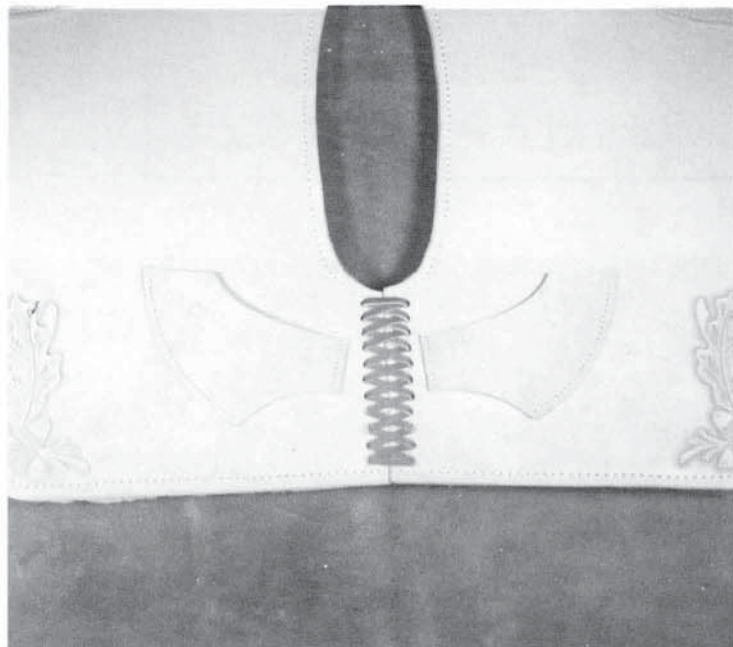


**STEP 15:** Trim excess wool from edges with shears.

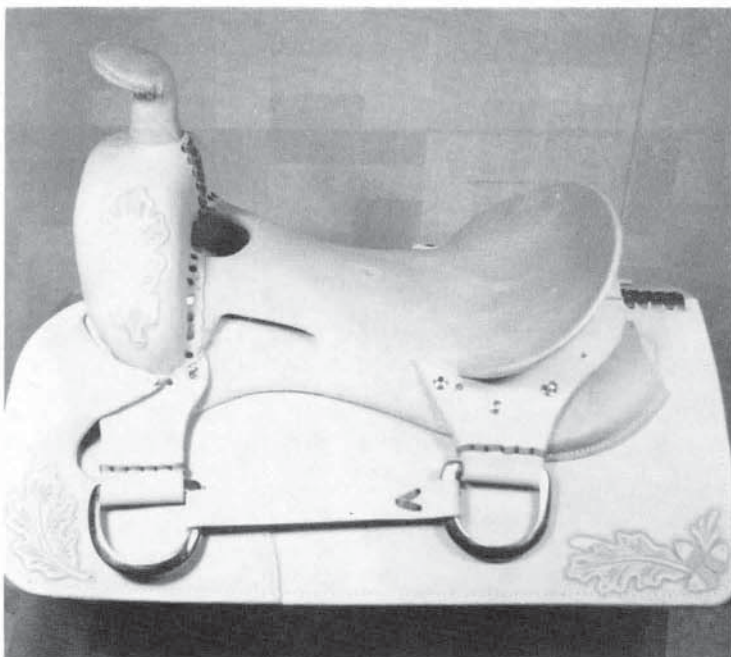




**STEP 16:** Cut wool as short as possible, approximately 1" in from edges, where skirts will be joined.

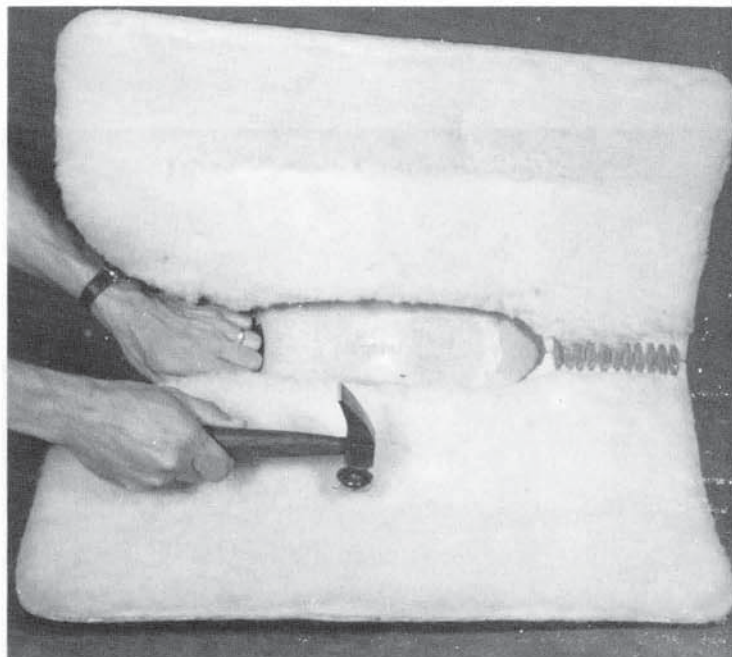


**STEP 17:** Punch lacing holes along back inside edges of left and right skirts, where shown on pattern sheet. Lace left and right skirts together with a 72" long piece of 1/4" latigo lace following cross stitch instructions.



**STEP 18:** Thoroughly dampen skirt assembly. Insert Tree Bars into pockets and jockeys on skirts, as shown. Mold leather around Tree Bars and secure with a few small tacks.

**IMPORTANT:** Do not drive tacks in all the way as they will be removed later.



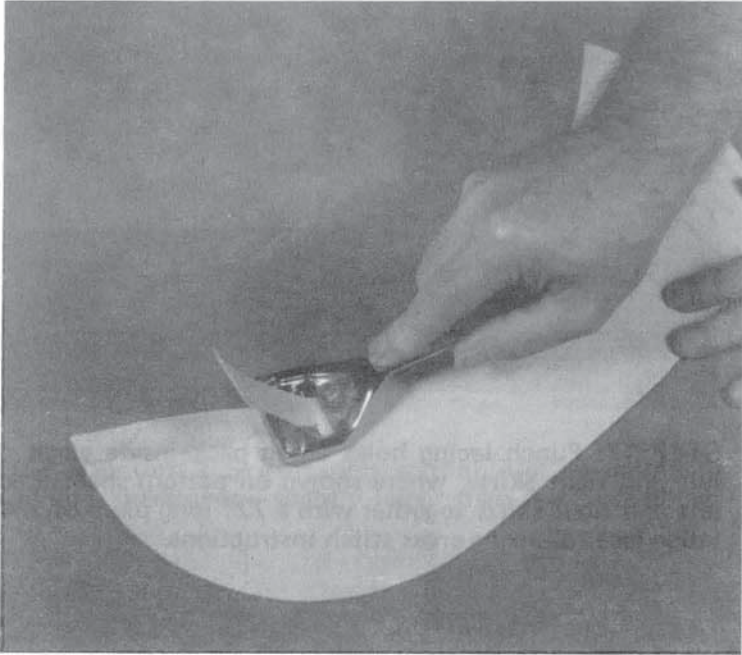
**STEP 19:** Mold skirts to bars, from the lining side, with a smooth faced hammer. Allow skirts to dry in this position.



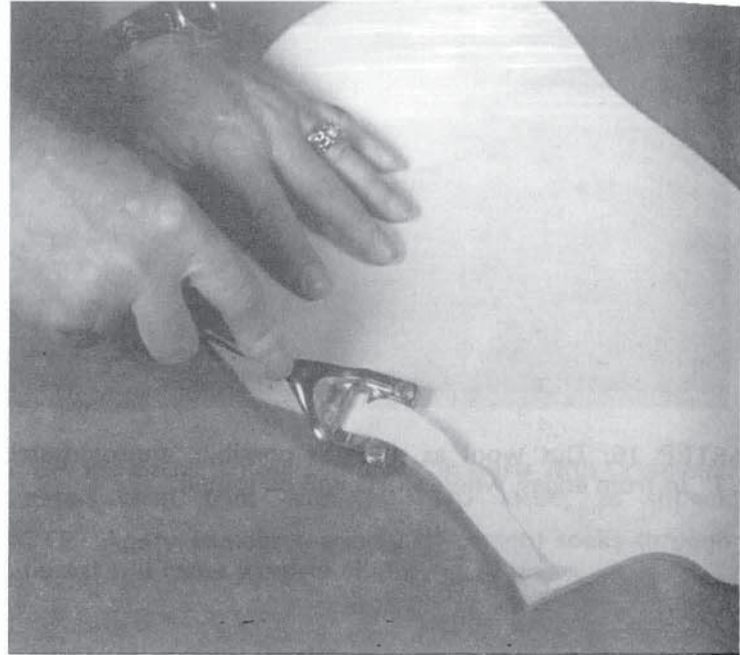
## Section VI

### Making A Padded Seat

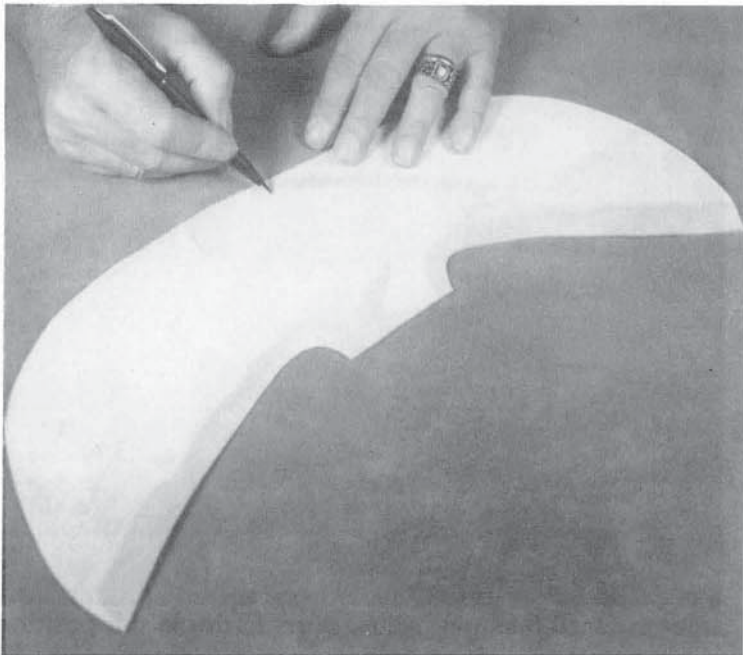
NOTE: Do all tooling and edge finishing before assembly.



STEP 1. Skive back cantele cover on flesh side as shown on pattern sheet.



STEP 2. Skive each seat jockey on flesh side as shown on pattern sheet.

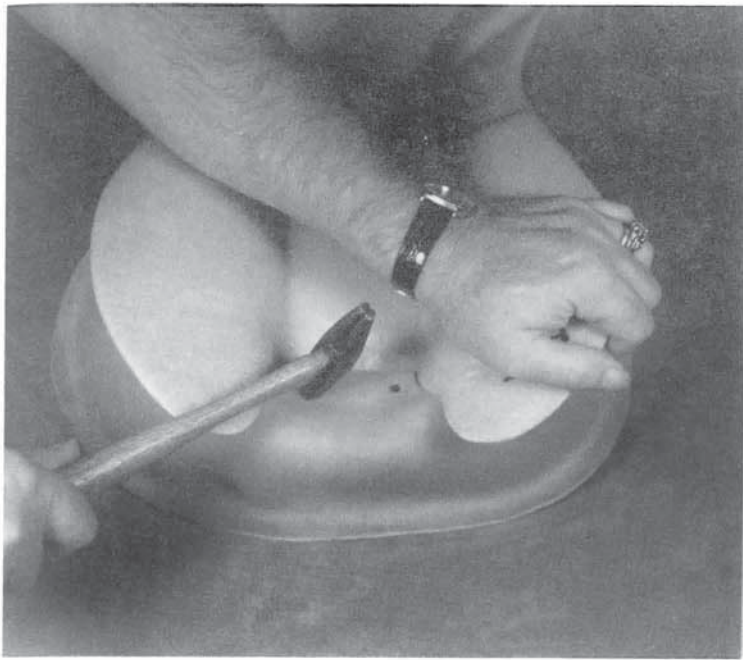


STEP 3. Make a center mark on flesh side of back cantele cover as shown on pattern sheet.

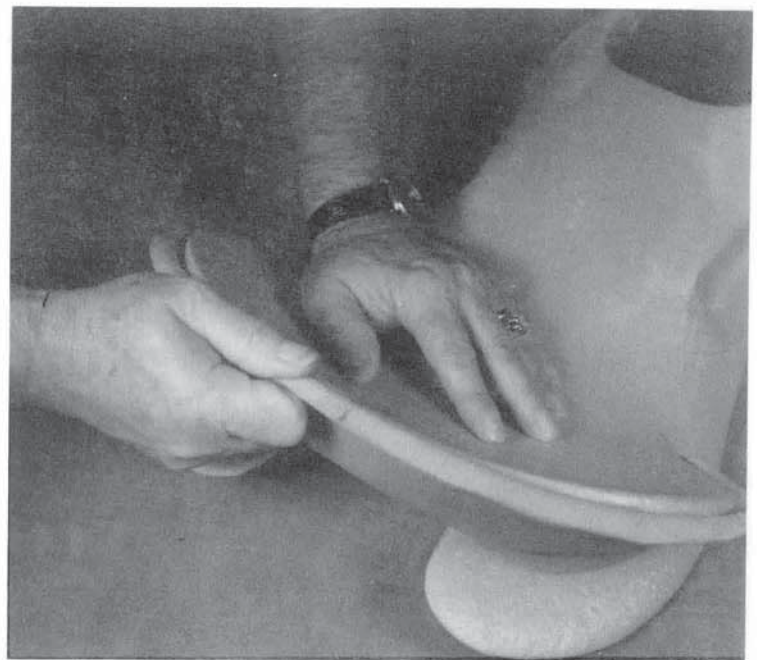


STEP 4. Dampen cover thoroughly then form over back of cantele on tree. Secure temporarily at corners with 2 small tacks.

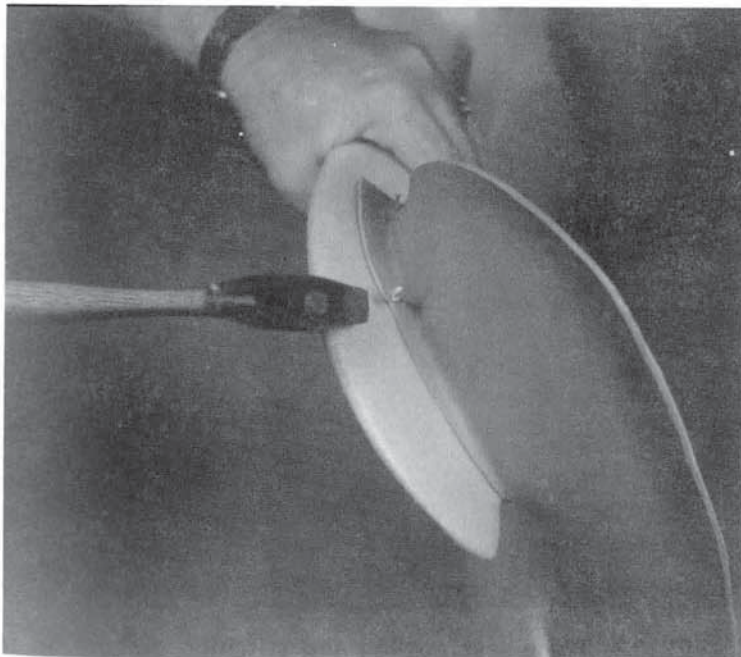




**STEP 5.** Temporarily secure bottom of cover on underside of tree with small tacks.



**STEP 6.** Pre-shape cover around top of cantele as shown.

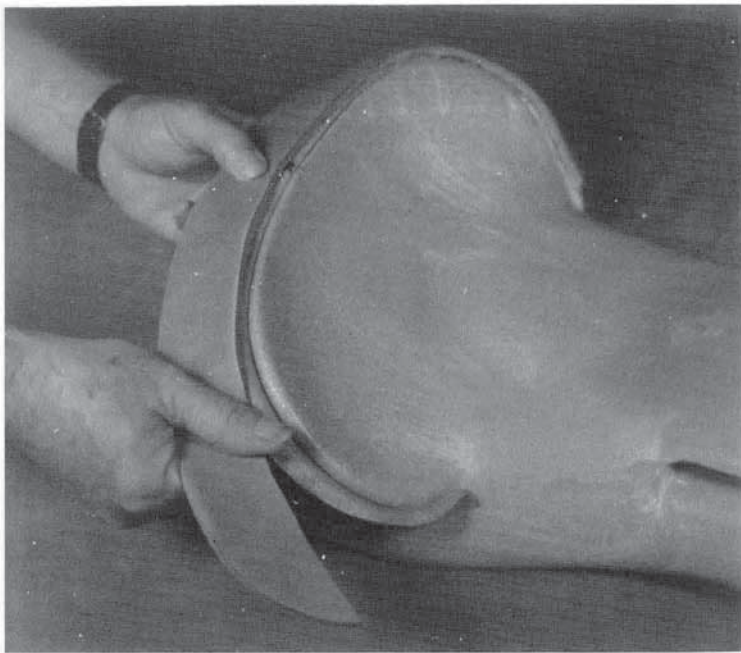


**STEP 7.** Secure temporarily where the cantele meets the tree bars with a few small tacks.

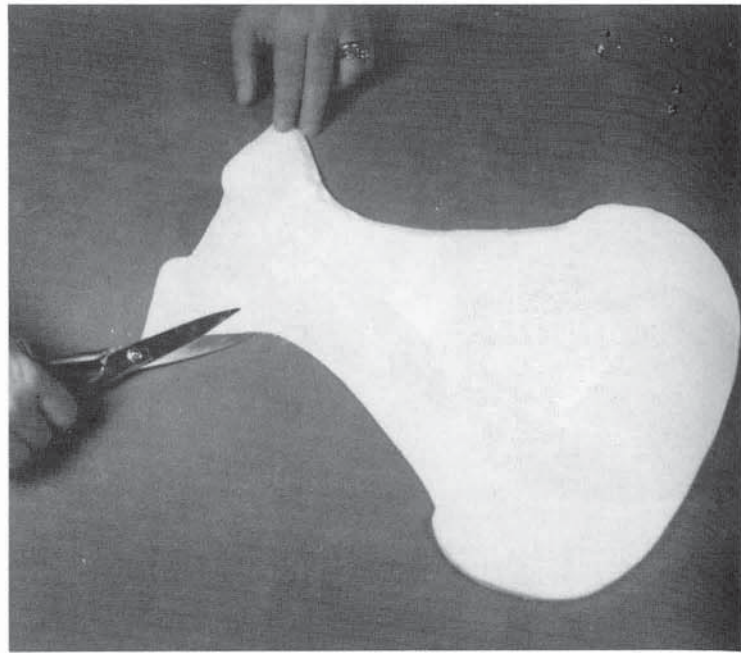


**STEP 8.** Rough-up both sides of cantele filler with sandpaper.

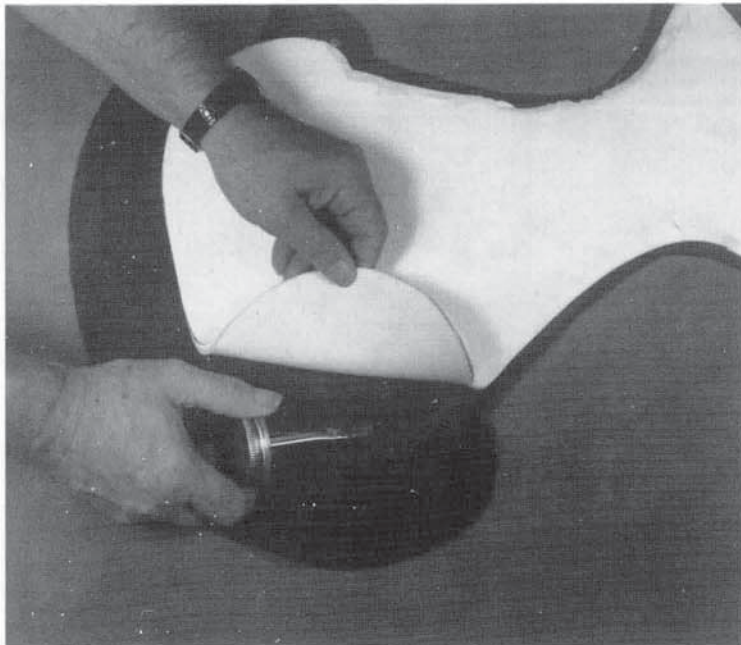




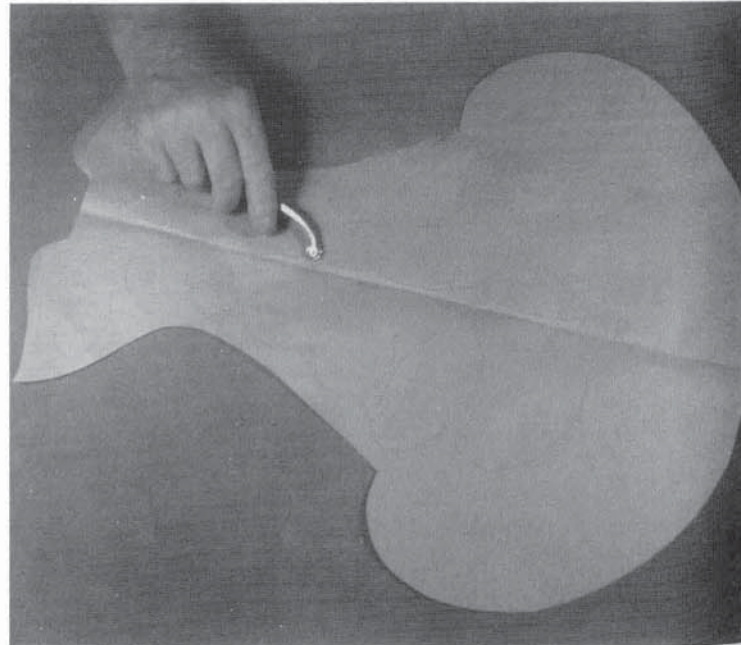
**STEP 9.** Apply cement to, then adhere cantle filler to lip of back cantle cover formed in step 6.



**STEP 10.** Bevel edges of 2 foam seat pads with shears, as shown on pattern sheet.

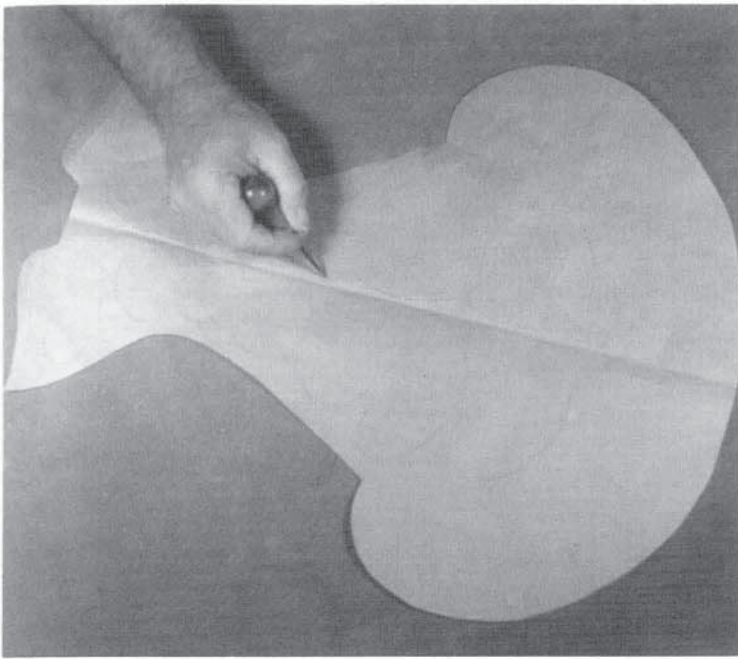


**STEP 11.** Apply cement to, then adhere 1 foam seat pad, beveled in step 10, in position on suede seat cover as shown on pattern sheet.

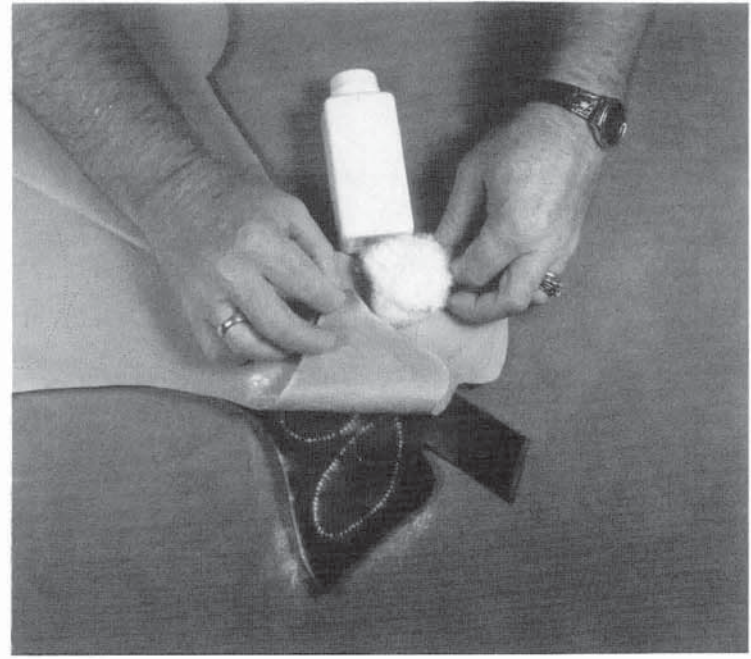


**STEP 12.** Trace seat outline and stitching design on to a piece of heavy wrapping paper. As shown on pattern sheet. Mark stitching hole placement in paper over traced design with a No. 5 overstretch wheel as shown.

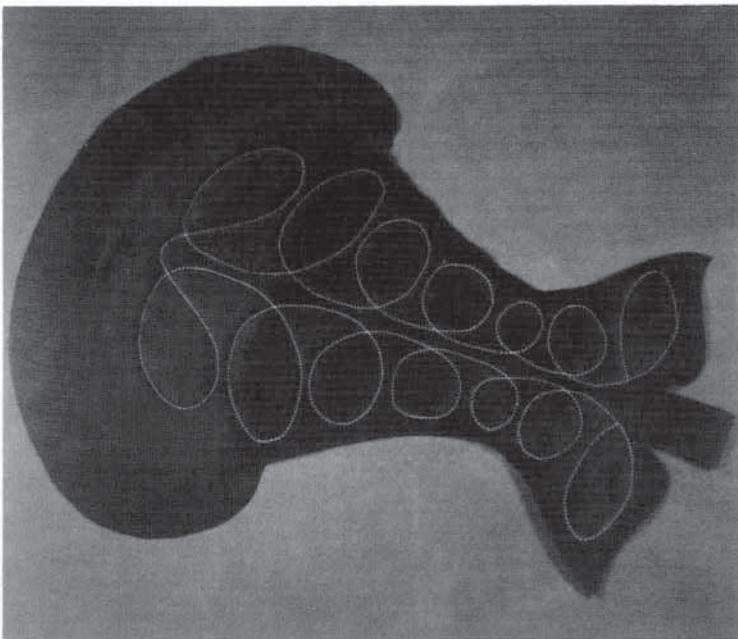




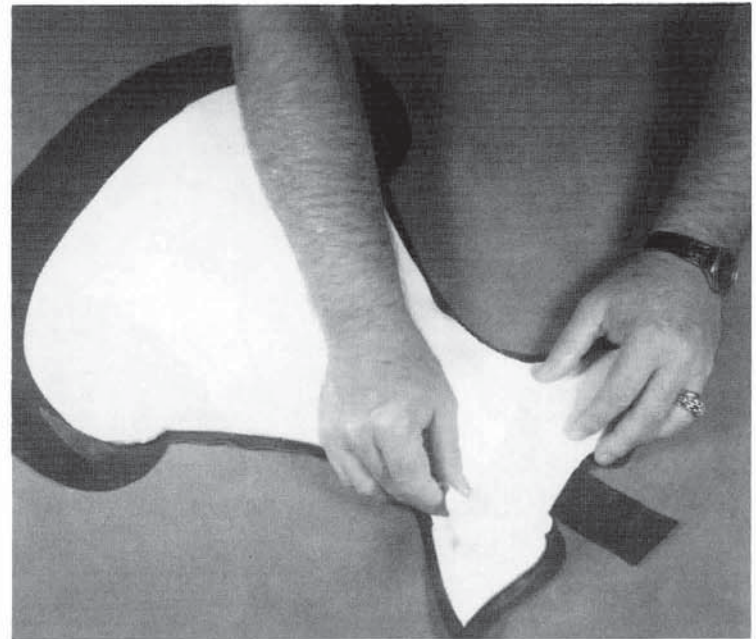
**STEP 13.** Stab pin holes in paper with an awl where marked with over stitch wheel. **NOTE:** This can be done on a sewing machine using an empty needle.



**STEP 14.** Place paper pattern over suede seat cover and dust over holes punched in step 13 with powder. Baby powder applied with a scrap of sheepskin works fine for this.

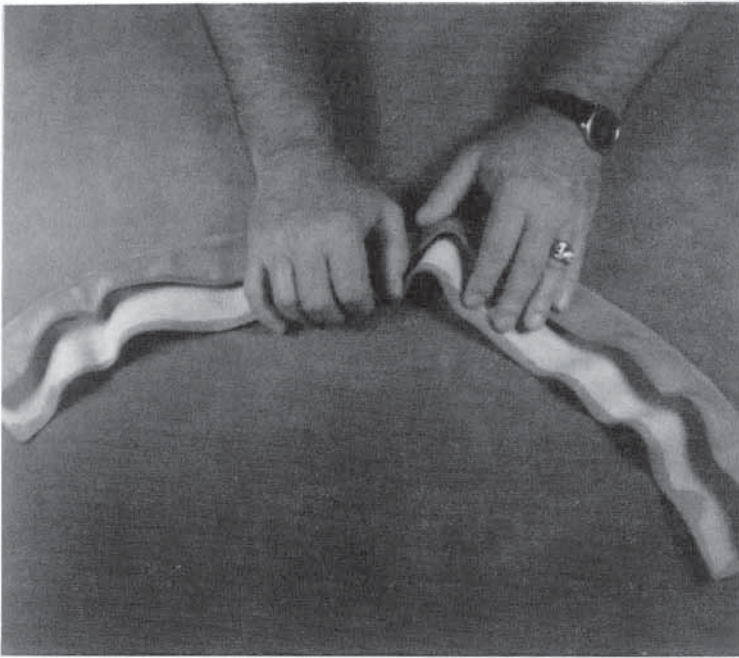


**STEP 15.** Stitch design through suede seat over and foam pad. **NOTE:** Refer to saddle stitching instructions given in this booklet.

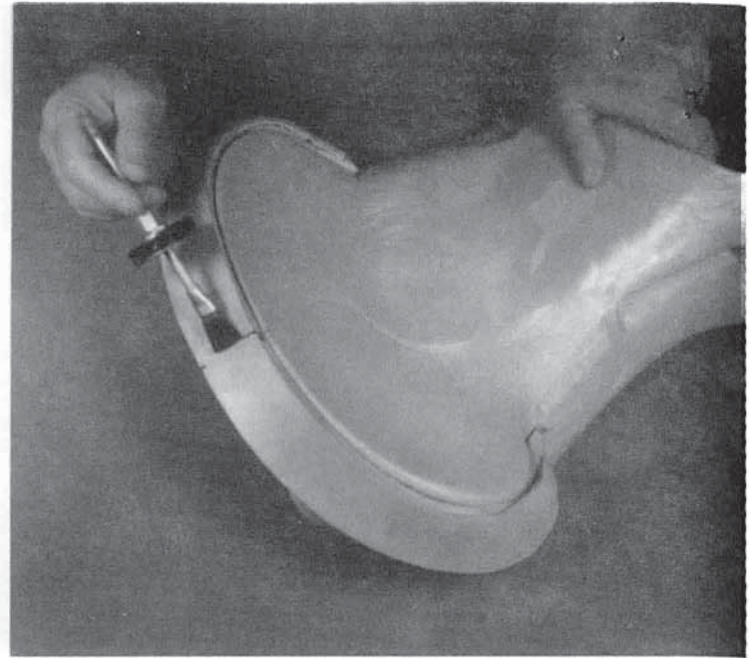


**STEP 16.** Apply cement to, then adhere second foam pad over first pad matching up all edges exactly.

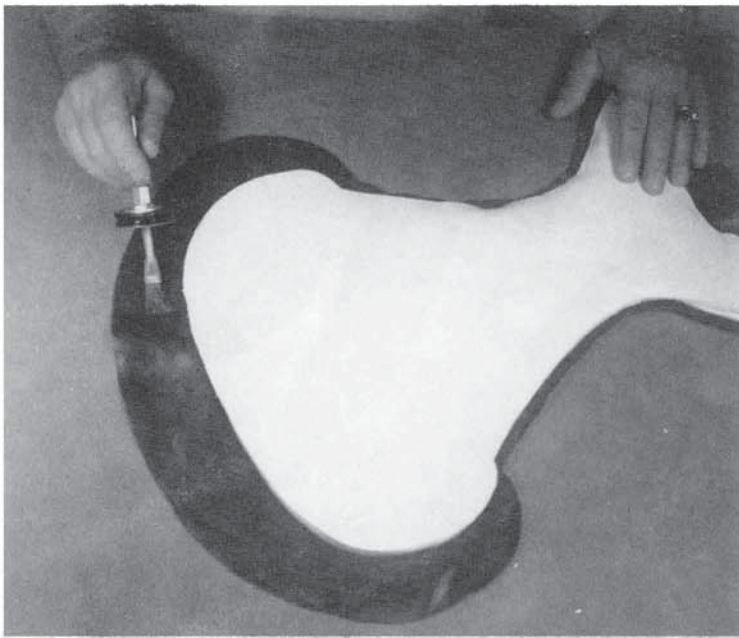




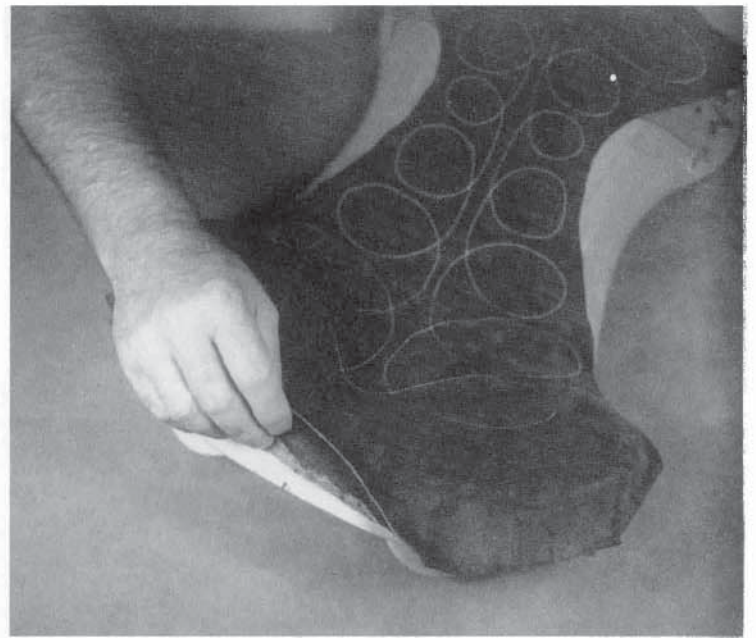
**STEP 17.** Thoroughly dampen cattle binding with water then pre-form to fit over cattle filler.



**STEP 18.** Apply coat of craftsman cement to top side of cattle filler.

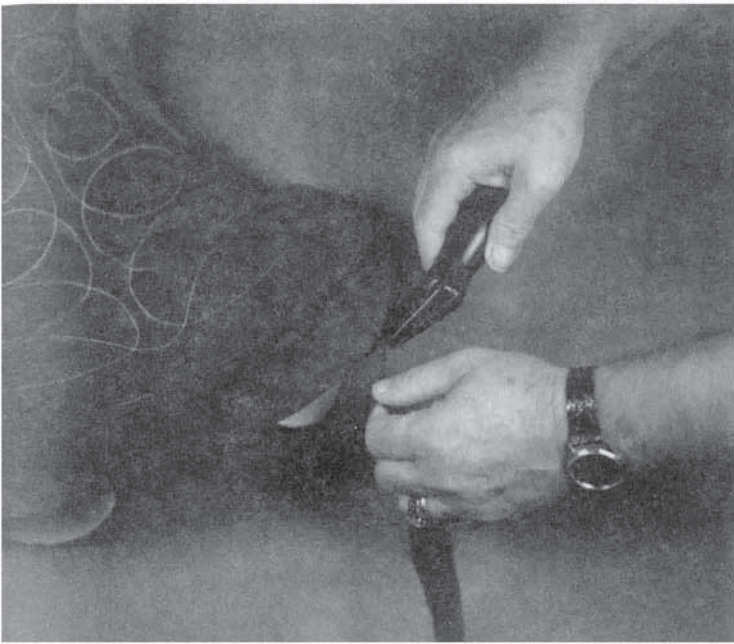


**STEP 19.** Apply coat of craftsman cement to area behind foam pad on bottom of suede seat cover. Do not apply cement to foam pad at this time.

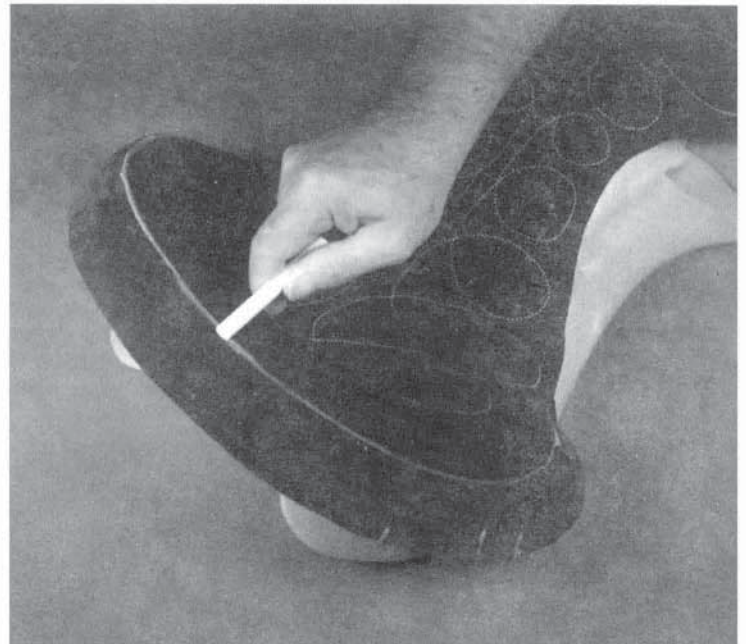


**STEP 20.** Adhere back edge of suede seat cover to cattle filler as shown.





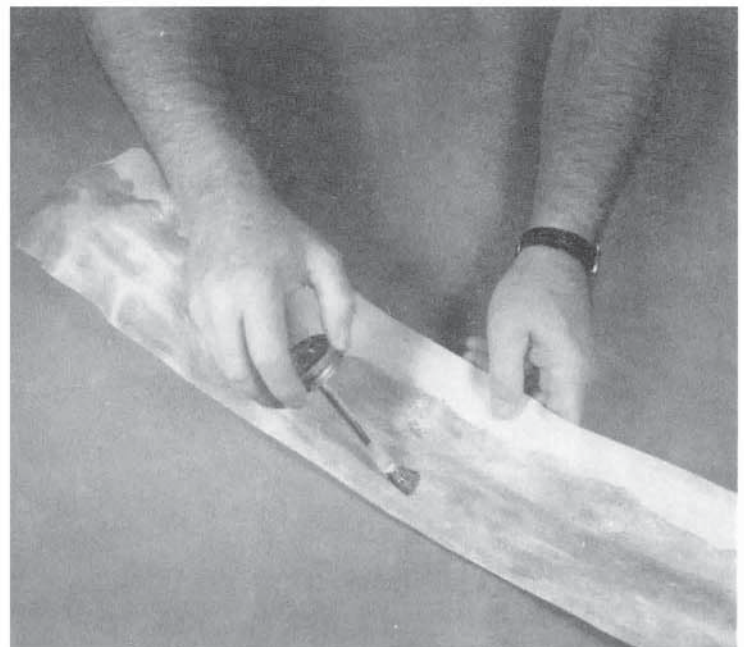
**STEP 21.** Trim off excess suede flush with bottom edge of cantle filler.



**STEP 22.** Mark a line where cantle filler meets cantle with a chalk as shown.

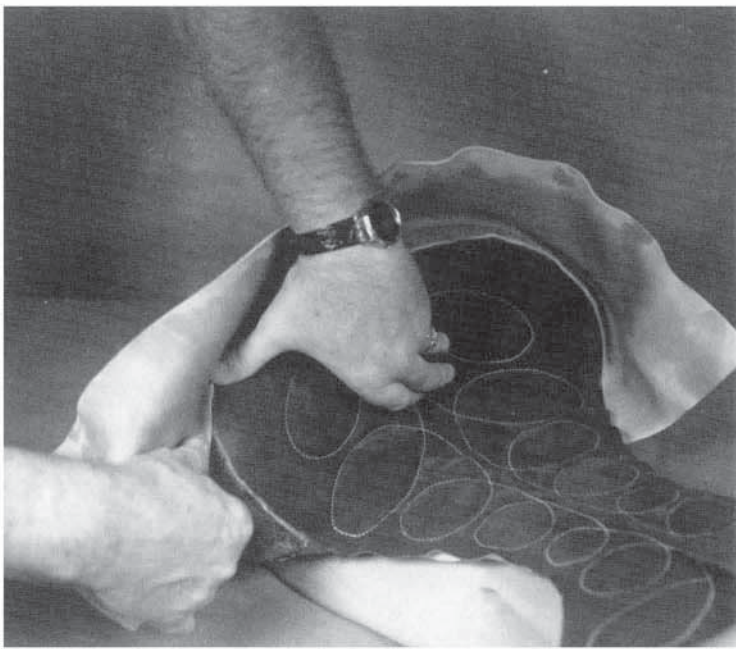


**STEP 23.** Apply craftsman cement to suede seat cover in area over cantle filler.

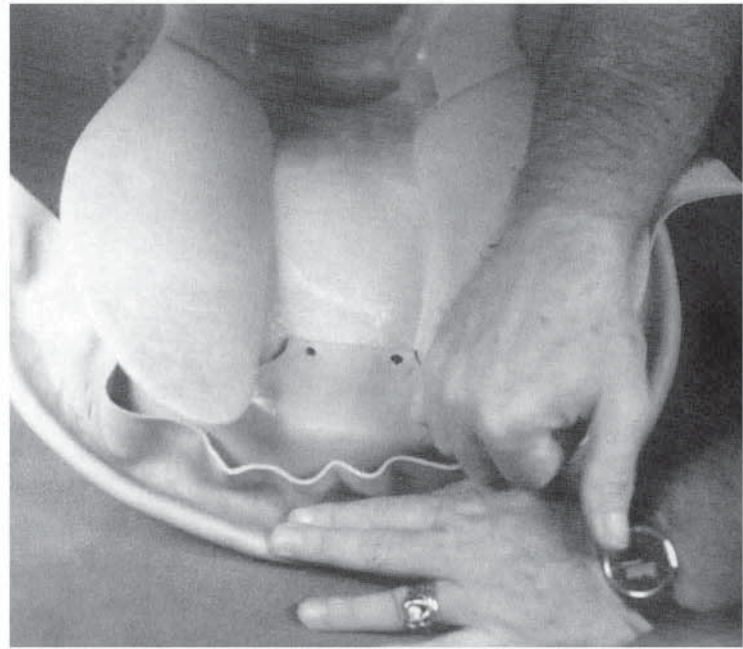


**STEP 24.** Apply craftsman cement to flesh side of cantle binding. **NOTE:** You may want to dampen cantle binding again on grain side only.

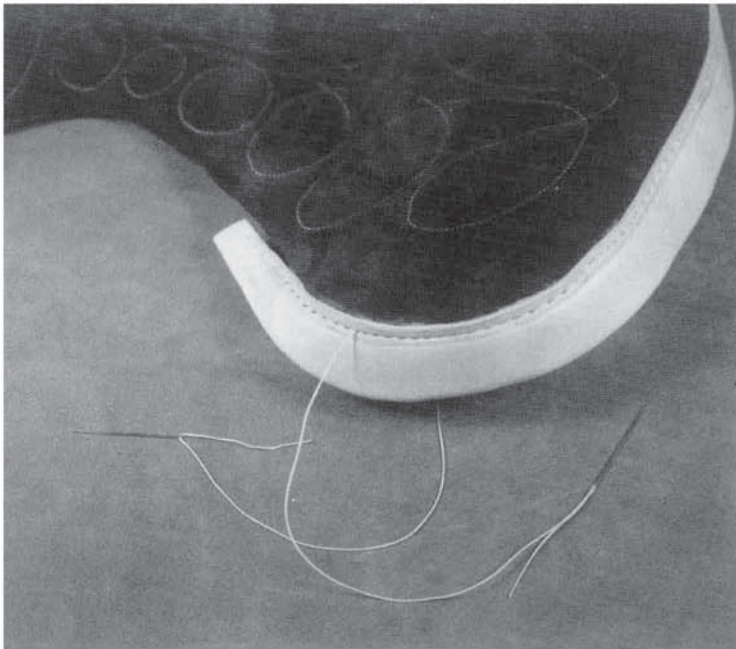




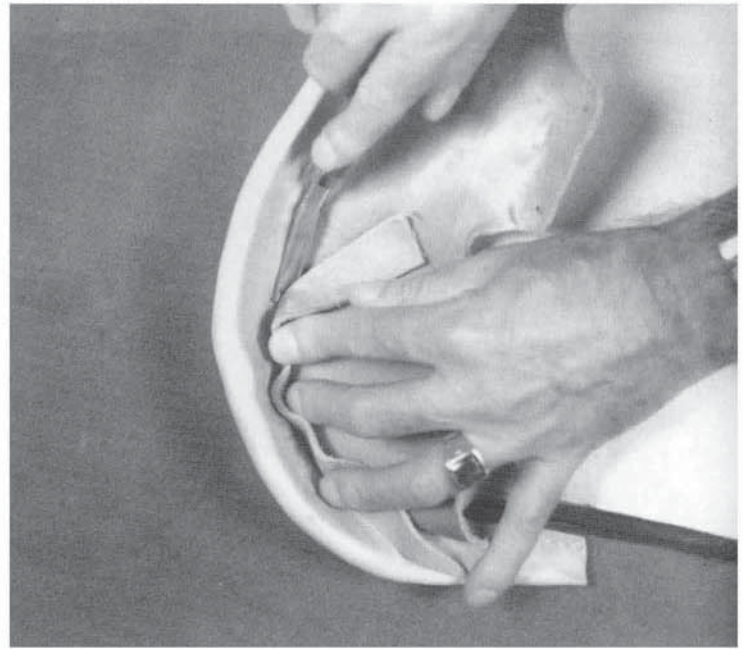
**STEP 25.** Adhere cantle binding to suede seat cover lining up edge of cover to chalk line draw on cover in step 22



**STEP 26.** Roll binding over edge of cantle filler and push down into area where cantle meets forks. **NOTE:** Excess binding leather will be trimmed off later.

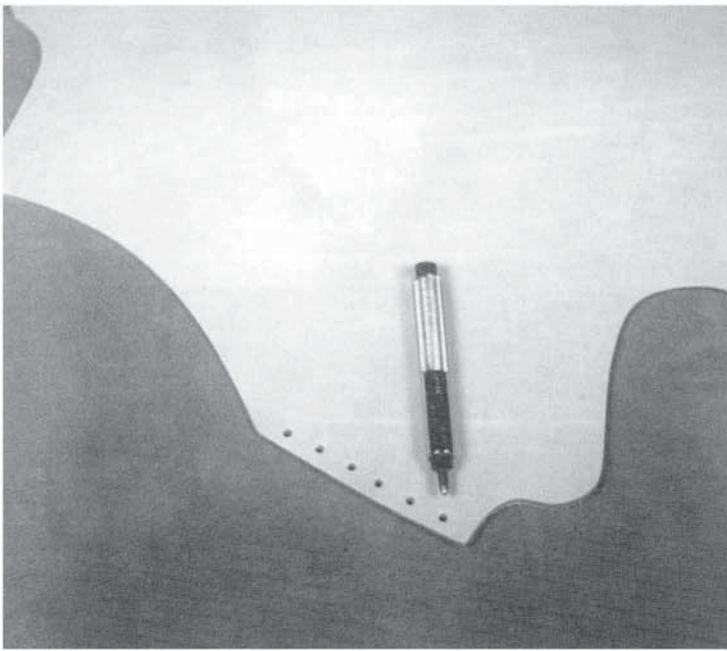


**STEP 27.** Scribe a line  $\frac{3}{16}$ " in around edge of cantle then stitch along line through top of cantle, binding, filler and bottom of binding as shown.

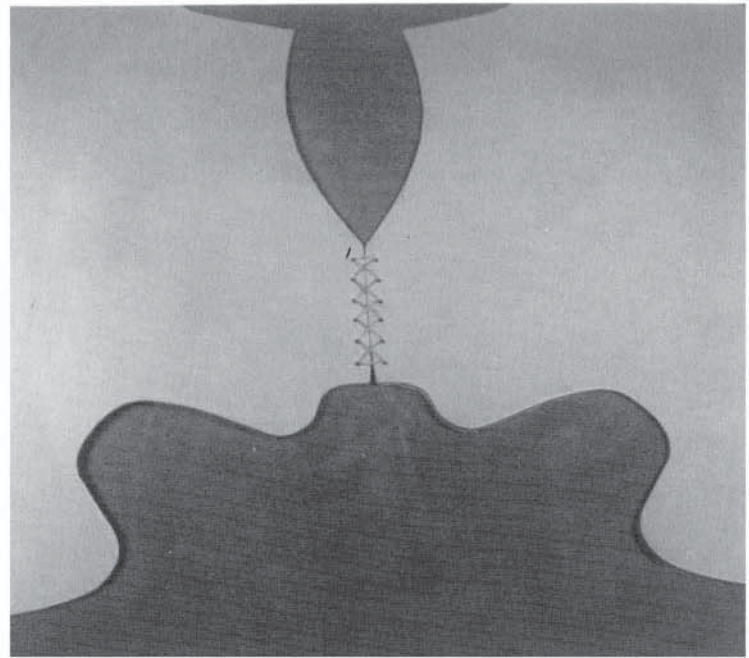


**STEP 28.** Trim off excess binding leather from underside with a french edge skiver. Allow tails to remain on both ends. **NOTE:** Allow seat cover assembly to dry in place then pull temporary tacks and remove from tree.

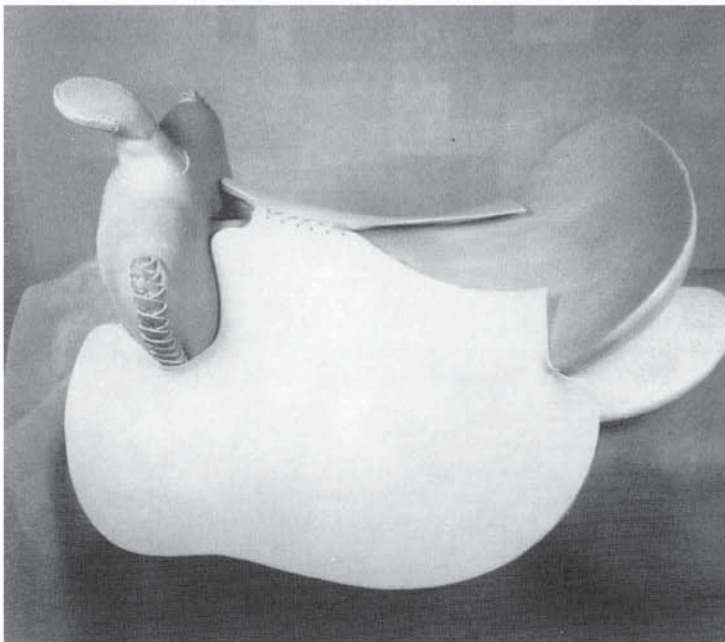




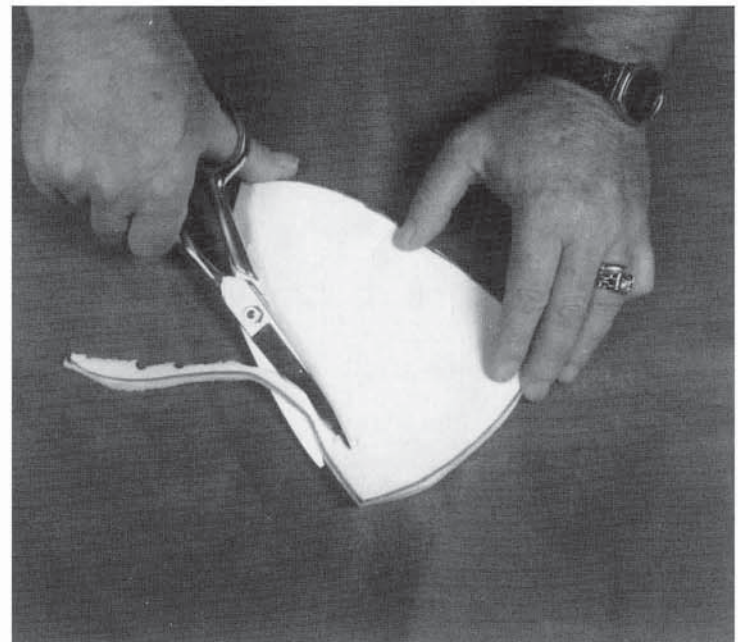
**STEP 29.** Punch holes in seat jockeys where shown on pattern. **NOTE:** Refer to pattern sheet for hole sizes to be punched.



**STEP 30.** Lace left and right jockeys together with artificial sinew as shown.

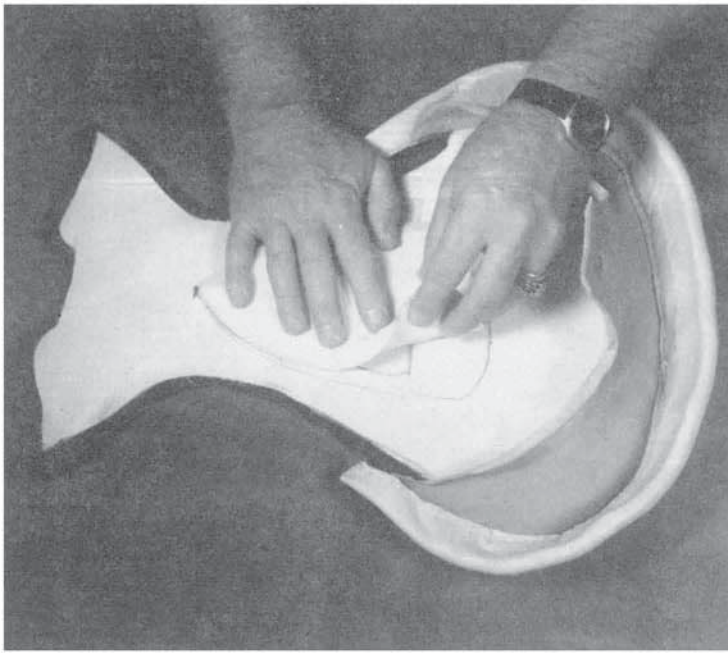


**STEP 31.** Set seat jockey assembly in place over tree.

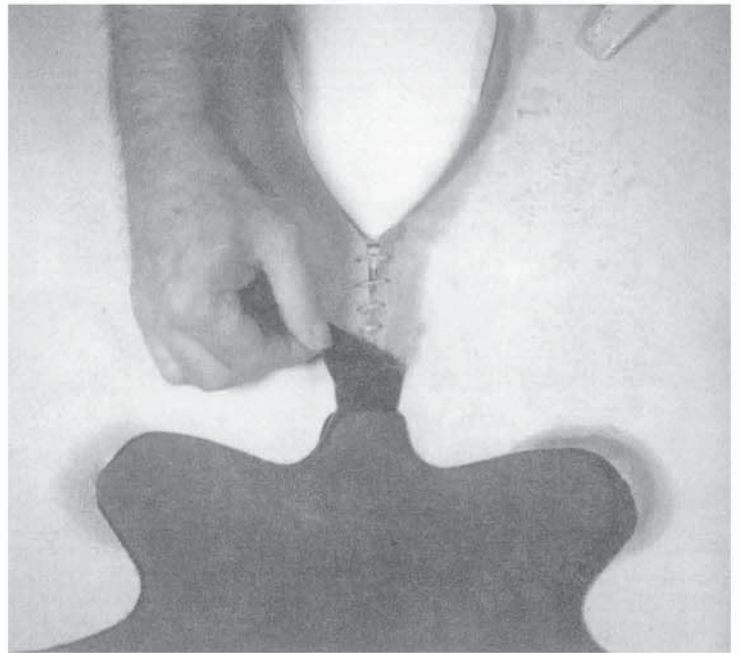


**STEP 32. (OPTIONAL)** Bevel edges of foam seat filler, if used, as shown on pattern sheet. **NOTE:** Filler adds a little extra padding but is not necessary.

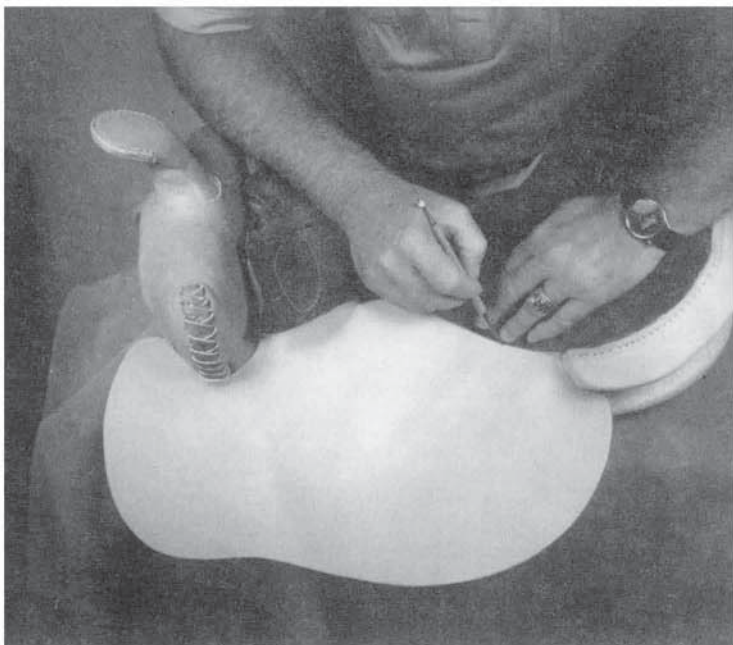




**STEP 33. (OPTIONAL)** Apply craftsman cement to filler then adhere to foam seat pad where opening between seat jockeys will be located.



**STEP 34.** Position seat cover assembly over seat jockeys, lining up front edges. Pull suede tab around to flesh side of jockey assembly and adhere in place with cement as shown.



**STEP 35.** Mark guide lines on seat jockey's where edges of suede seat cover will be with an awl or stylus.



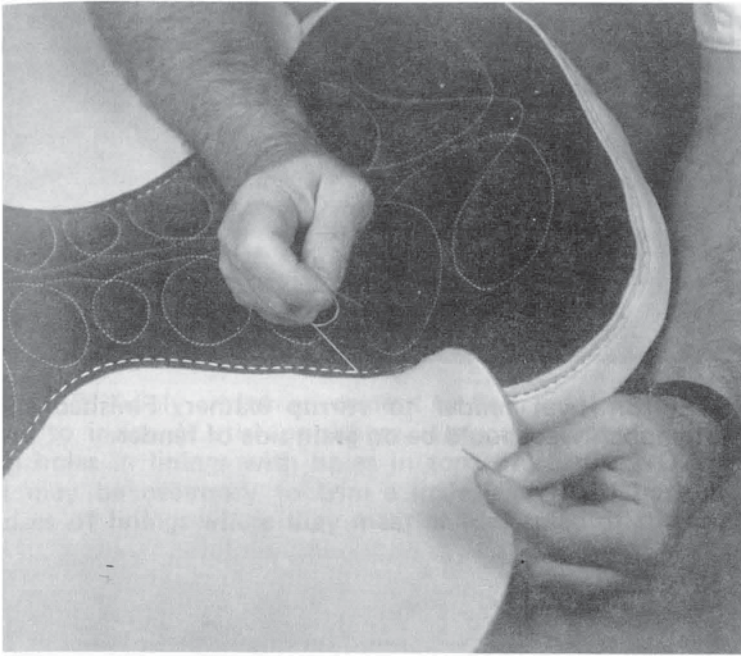
**STEP 36.** Apply craftsman cement to then adhere suede seat cover assembly in place on seat jockey assembly as shown.



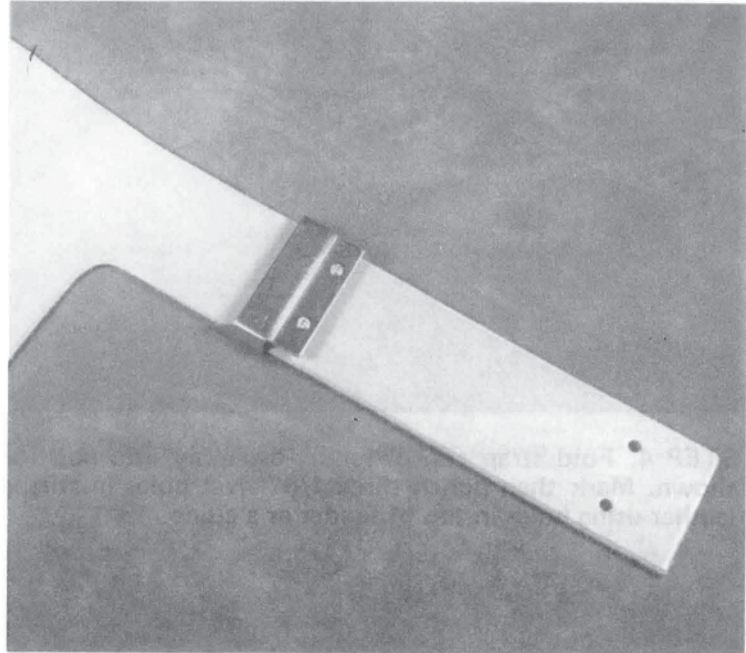
## Section VII Fenders

NOTE. Do all tooling and edge finishing before assembly.

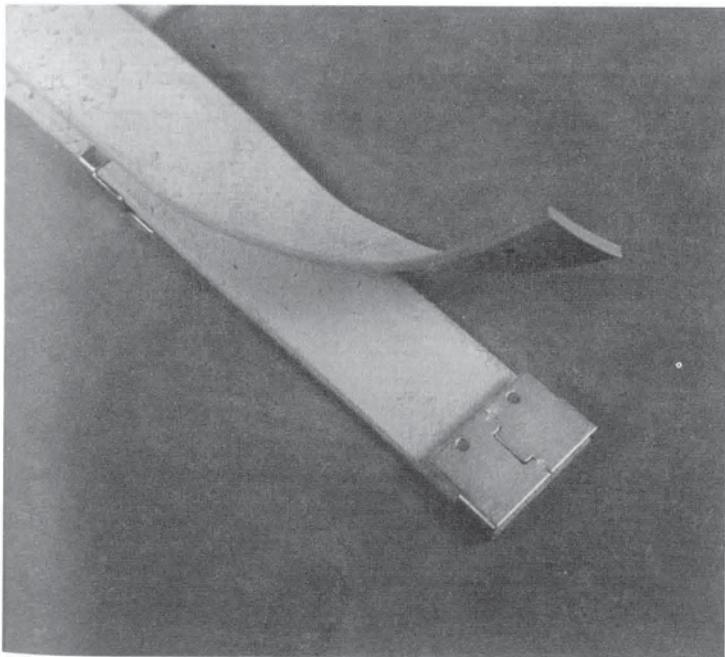
NOTE. Refer to pattern sheet for correct hole sizes to be punched.



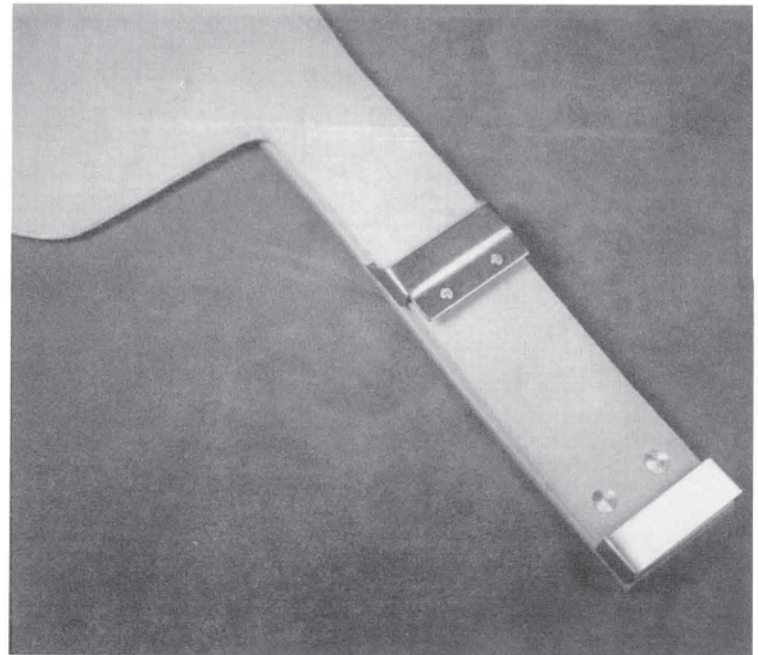
STEP 37. Stitch suede seat cover assembly to seat jockey assembly as shown on pattern sheet.



STEP 1. Punch holes in one fender and stirrup leather as shown on pattern sheet. Slide pronged part of quick release buckle onto fender strap as shown. Prongs should be on grain side of strap.

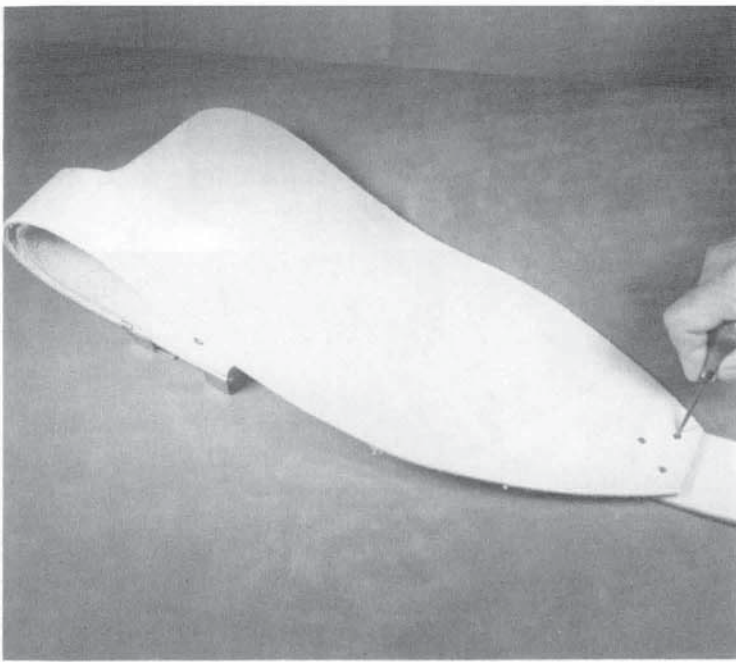


STEP 2. Slide loop part of quick release buckle on end of fender strap. From flesh side lay end of stirrup leather over buckle, grain side of leather to metal, as shown. Line up holes in stirrup leather over holes in buckle and fender strap.

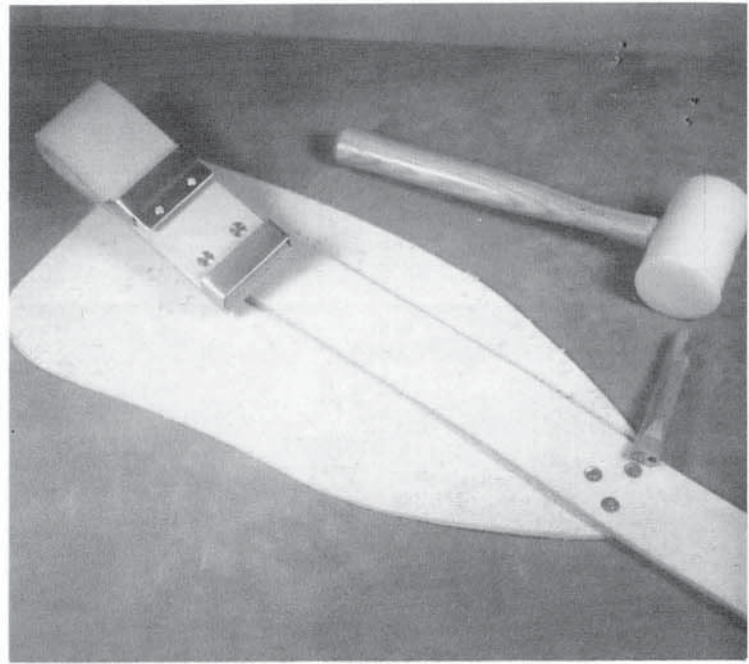


STEP 3. Rivet loop end of buckle in place. Finished ends of copper rivets should be on grain side of fender strap.

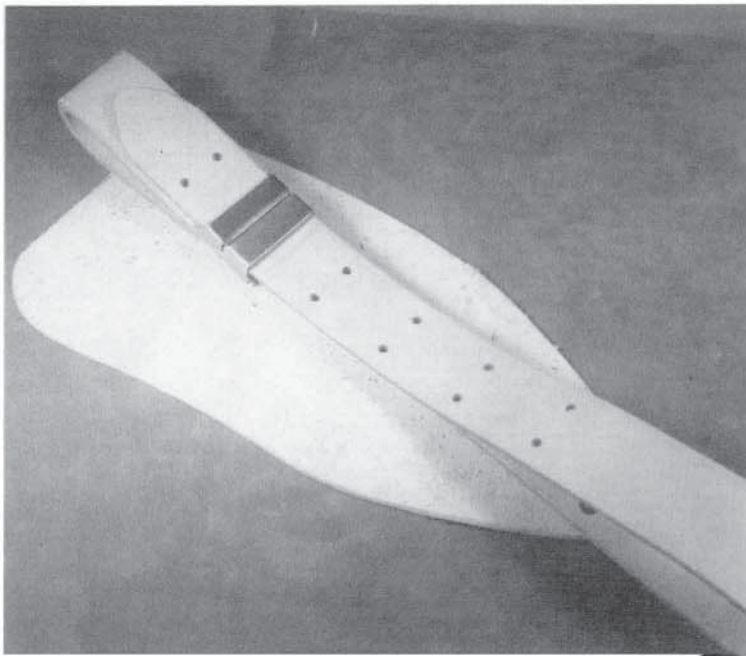




**STEP 4.** Fold strap end of fender assembly into position shown. Mark then punch three 1/8" rivet holes in stirrup leather using holes in top of fender as a guide.



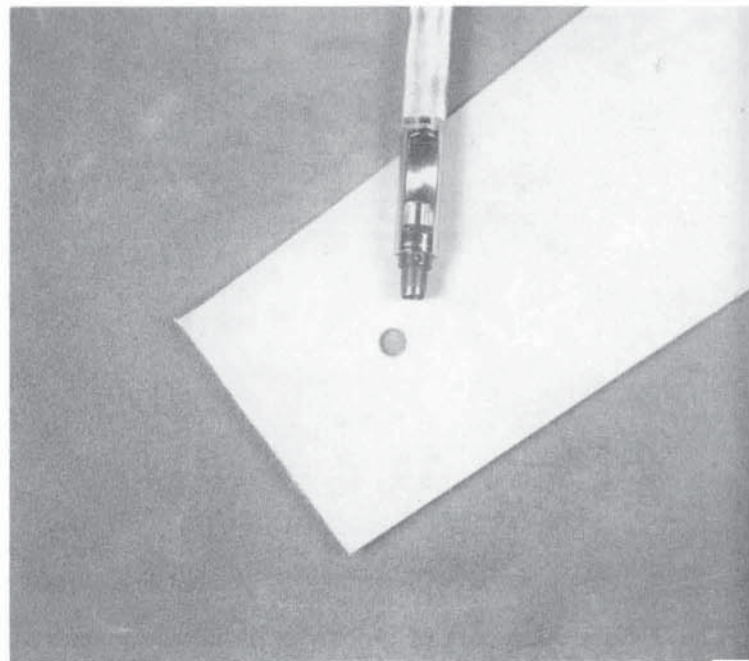
**STEP 5.** Rivet fender to stirrup leather. Finished end of copper rivet should be on grain side of fender.



**STEP 6.** One fender assembly is now complete. Repeat steps 1 through 5 with other buckle, fender and stirrup leather then set both aside till final saddle assembly later.

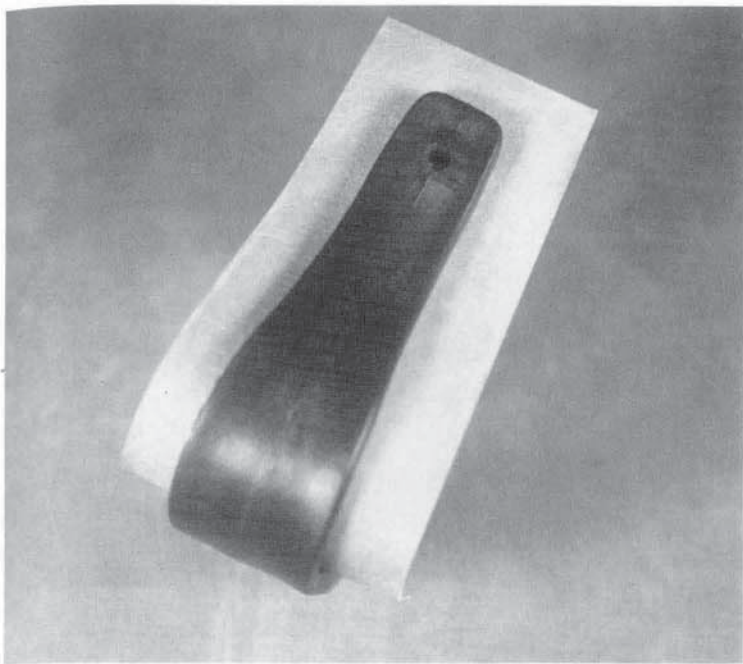
## Section VIII

### Covering Stirrups

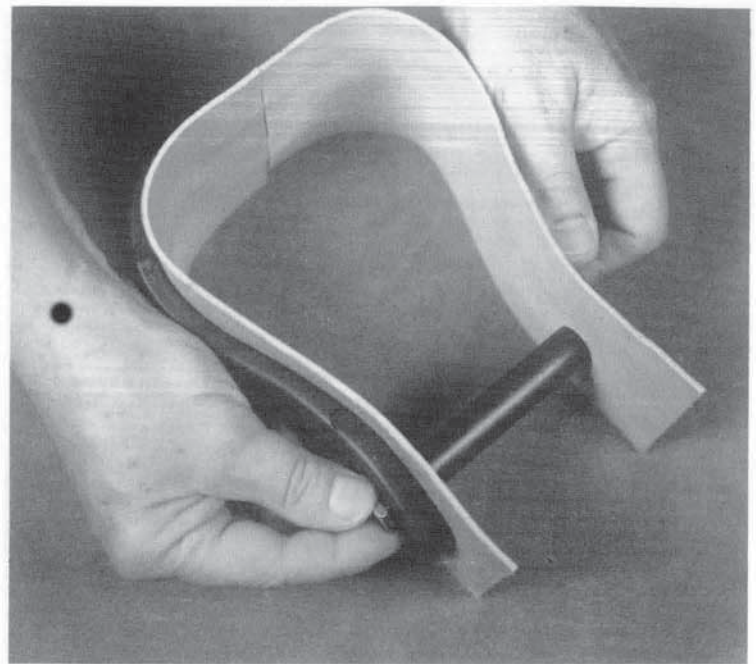


**STEP 1.** Punch a hole in 2 stirrup lining pieces as shown on pattern sheet.

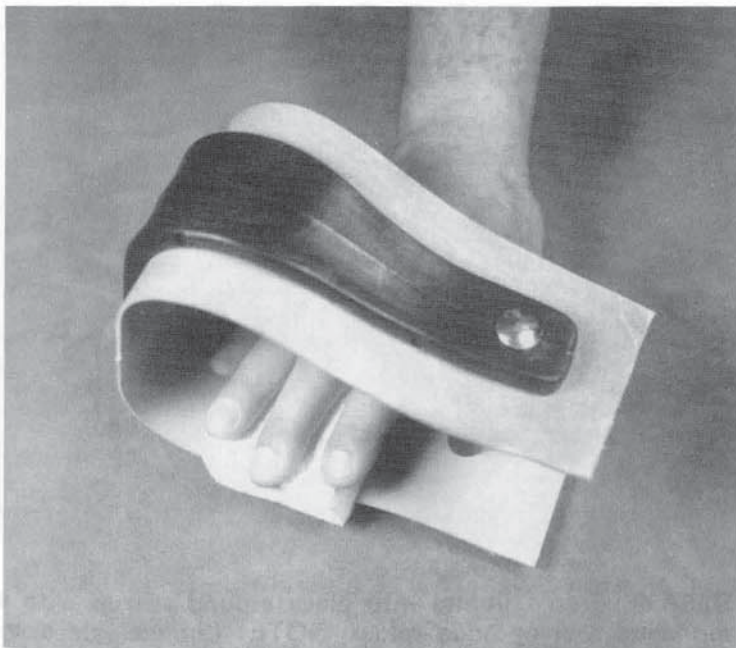




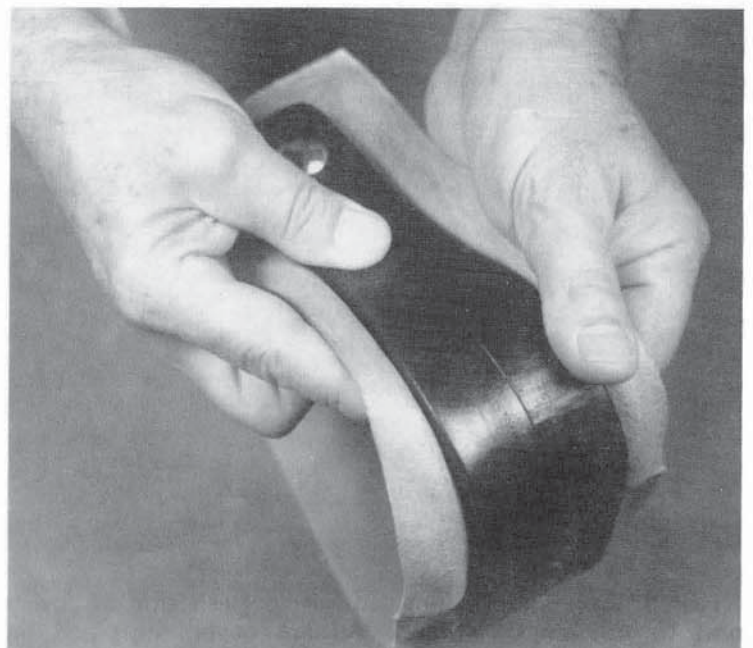
**STEP 2.** Apply craftsman cement to flesh sides of linings and to inside of stirrups adhere in place as shown, lining up holes in linings with holes in tops of stirrup. **NOTE:** It may be necessary to trim a little leather off bottom edges of linings where they meet at foot tread of stirrup.



**STEP 3.** Install bolt and bolt cover as shown.

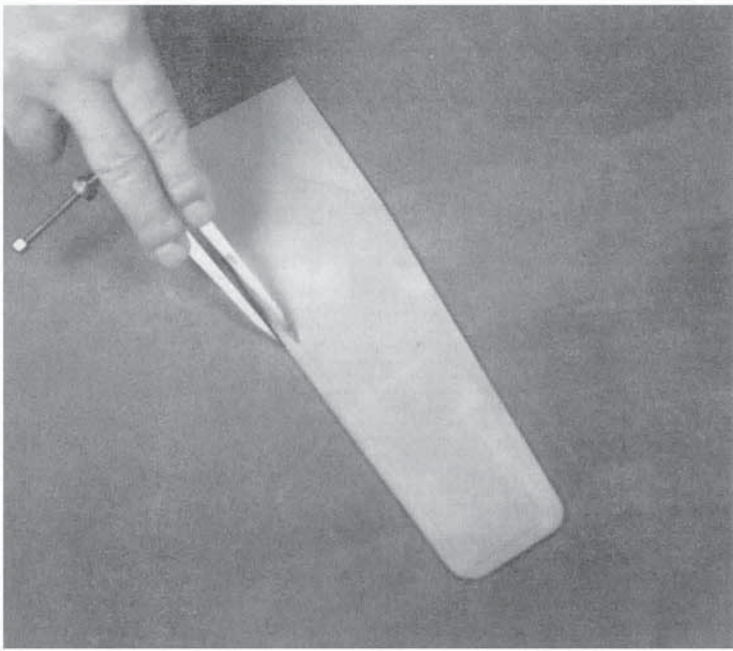


**STEP 4.** Thoroughly dampen lining pieces with water.

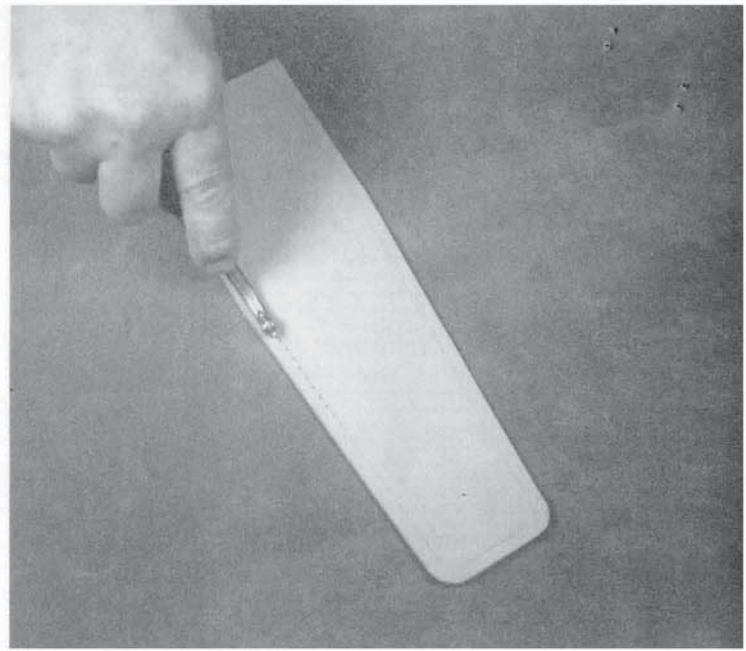


**STEP 5.** Pre-shape linings around edges of stirrup as shown

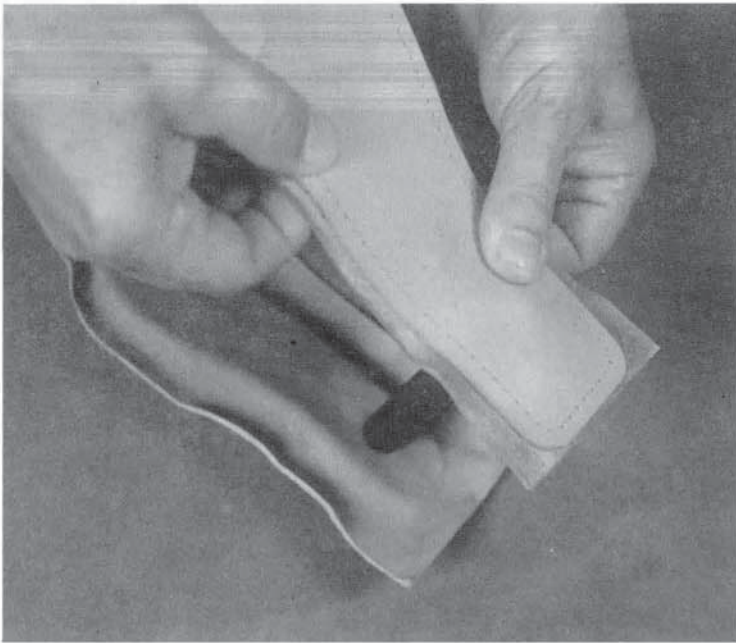




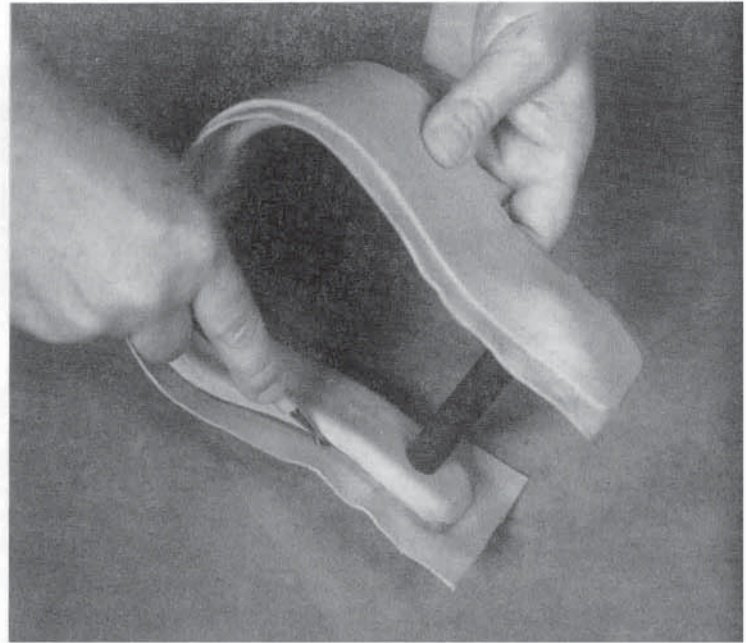
**STEP 6.** Scribe stitching lines around tops and sides of 2 stirrup covers. **NOTE:** You may elect to groove stitch lines at this time.



**STEP 7.** Mark over stitched lines in stirrup covers with a No. 5 over stitch wheel.

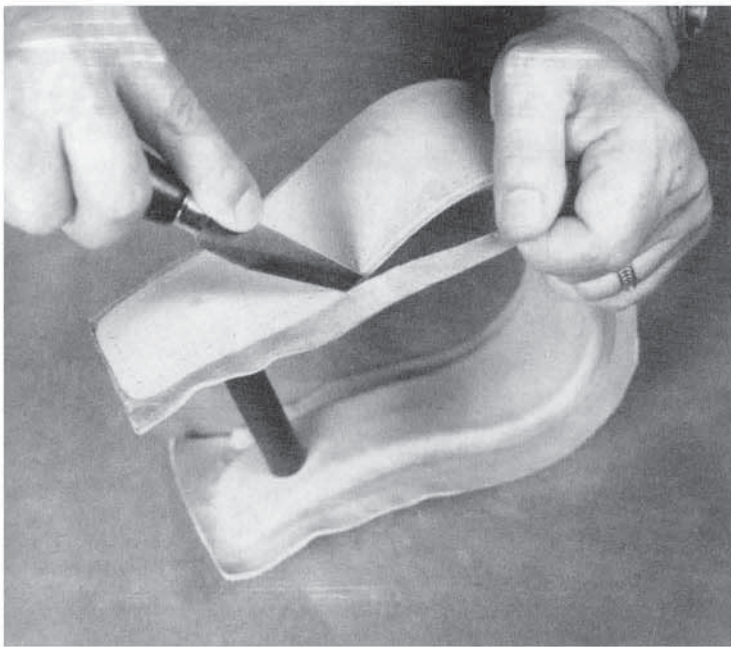


**STEP 8.** Apply craftsman cement to flesh side of covers and to outside of stirrup. Adhere covers in place on stirrup, as shown. **NOTE:** It may be necessary to trim a little leather off bottom edges of covers where they meet under foot tread of stirrup.

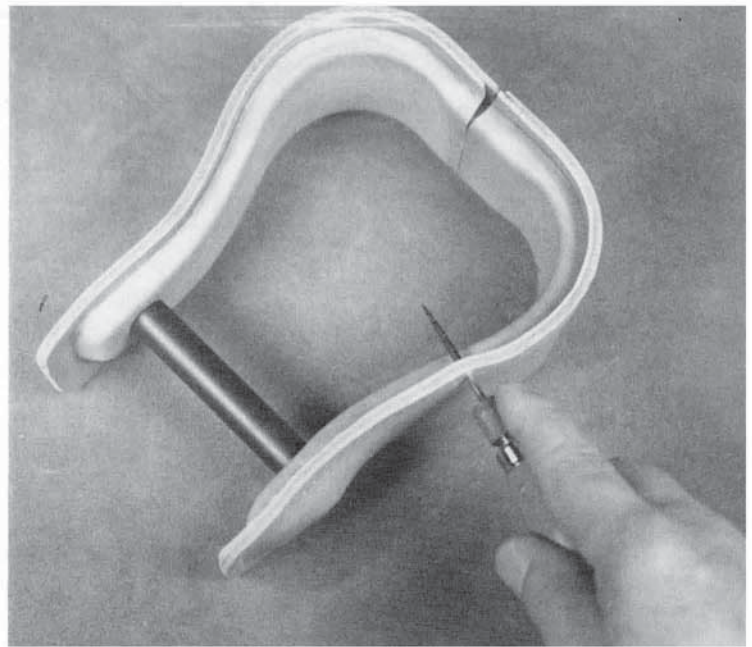


**STEP 9.** Press linings into place around stirrup with a modeling tool or bone folder. **NOTE:** Linings are oversized and will be trimmed later.

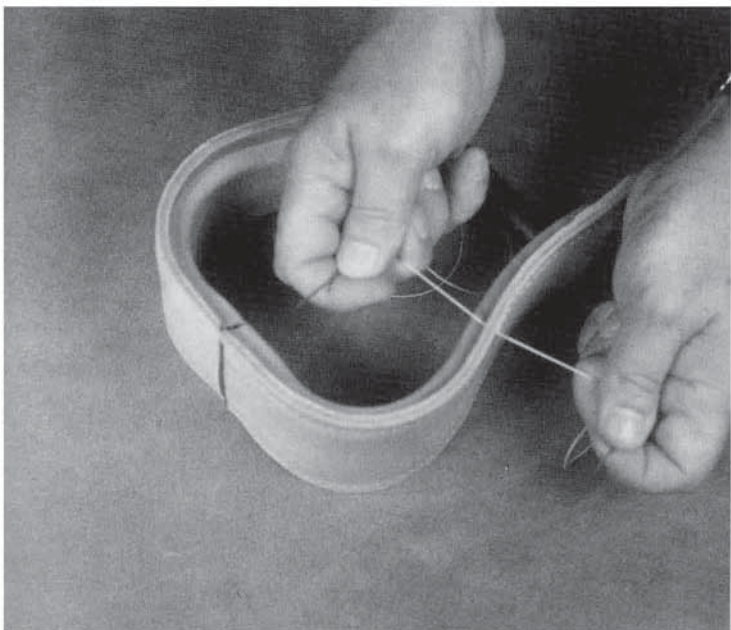




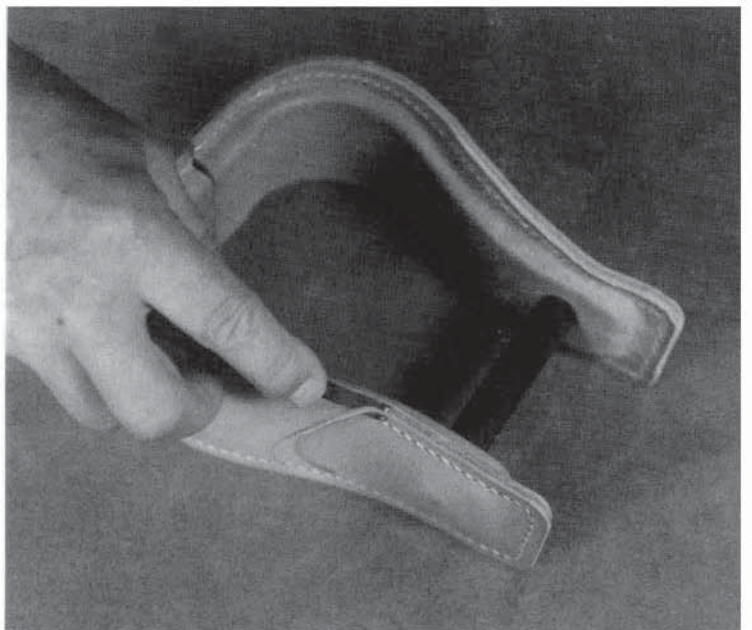
**STEP 10.** Trim excess lining leather even with edges of stirrup covers.



**STEP 11.** Punch stitching holes with an awl.

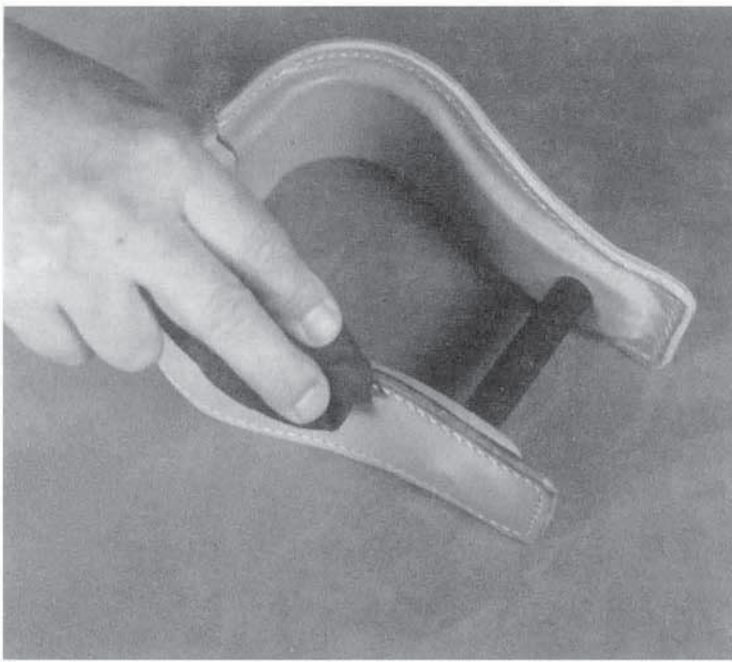


**STEP 12.** Stitch completely around edges of stirrup.  
**NOTE:** Refer to saddlestitching instructions included in this booklet.

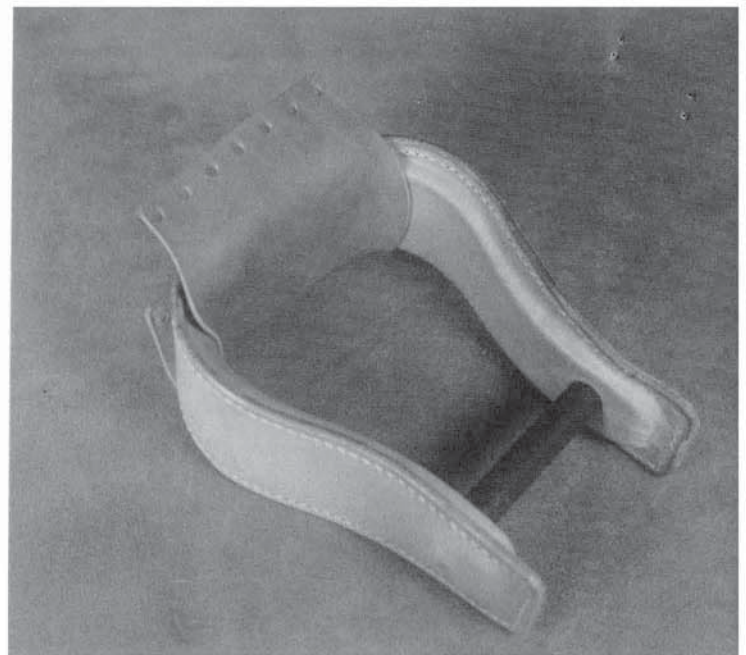


**STEP 13.** Bevel inside and outside edges of stirrup.

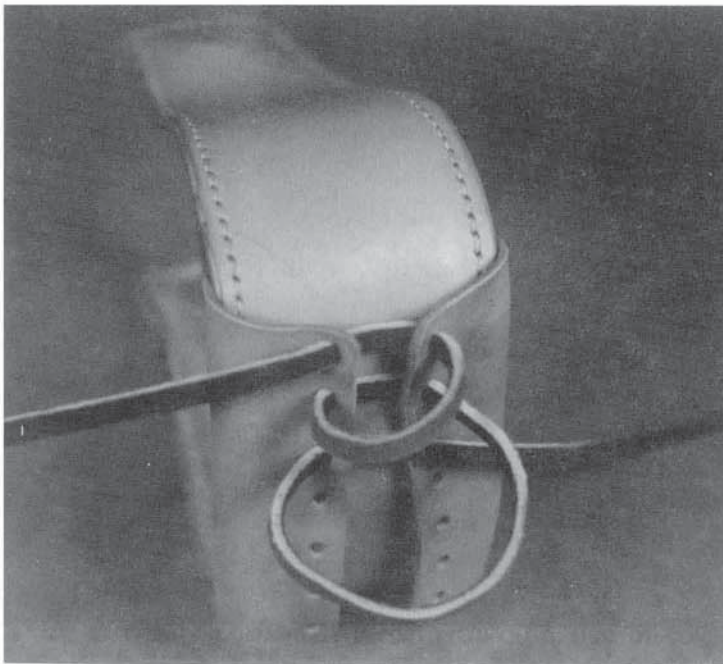




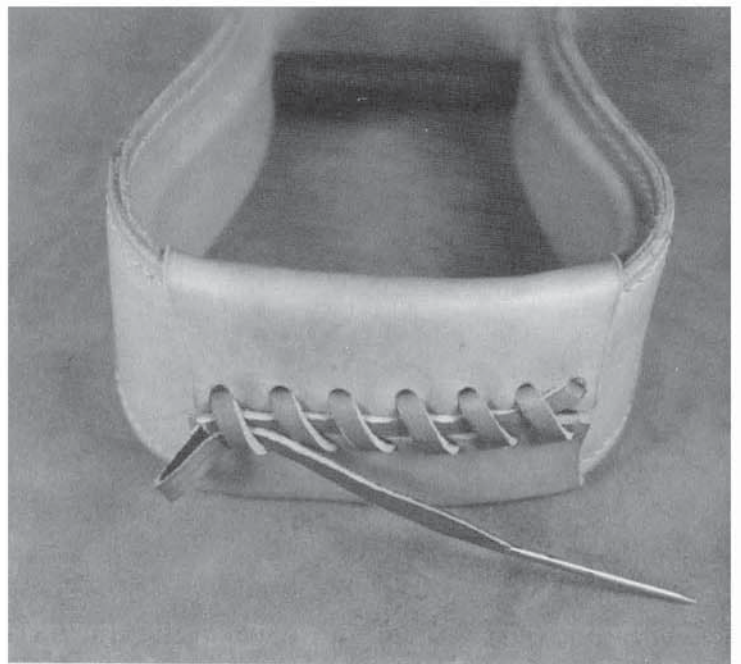
**STEP 14.** Slick edges of stirrup with a scrap of canvas or denim.



**STEP 15.** Punch holes in each edge of tread cover as shown on pattern sheet. Thoroughly dampen tread cover in water then shape around tread of stirrup as shown.



**STEP 16.** Whipstitch tread covers to tread of stirrup with 36" X 1/4" length of latigo lace as shown.

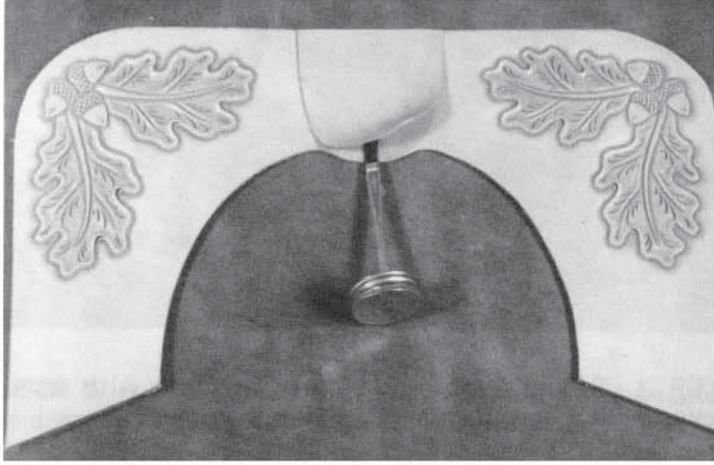


**STEP 17.** Secure lace ends under stitches on tread cover as shown. Repeat steps 1 through 17 on other stirrup.

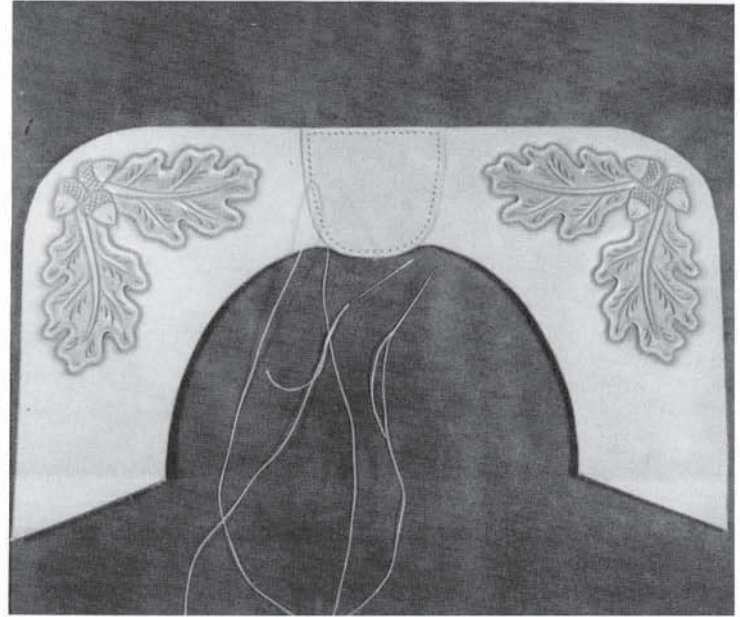


## Section IX

### Back Jockeys Assembly



**STEP 1.** Skive Jockeys in areas shown on pattern sheet. Butt ends of left and right Jockeys together. Cement connector part in place over butted ends with Craftsman Cement, as shown.

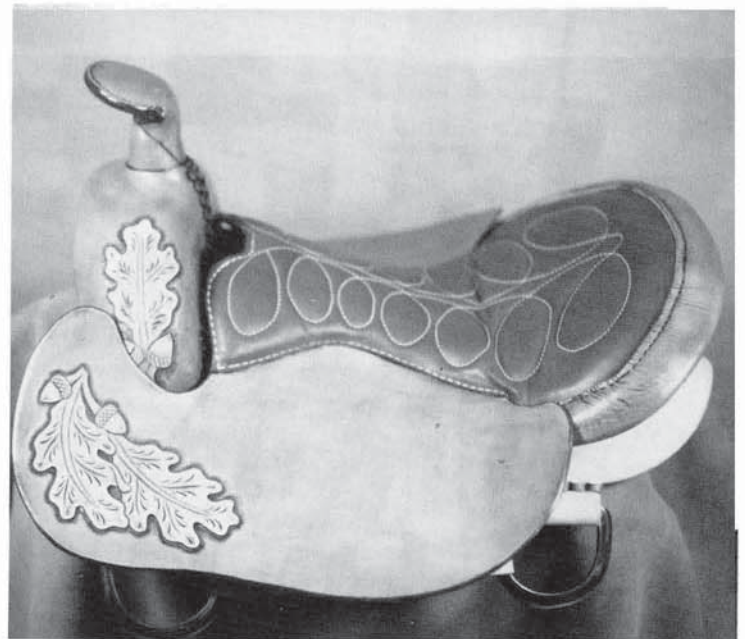


**STEP 2.** Saddle stitch connector part in place, as shown.

## Section X

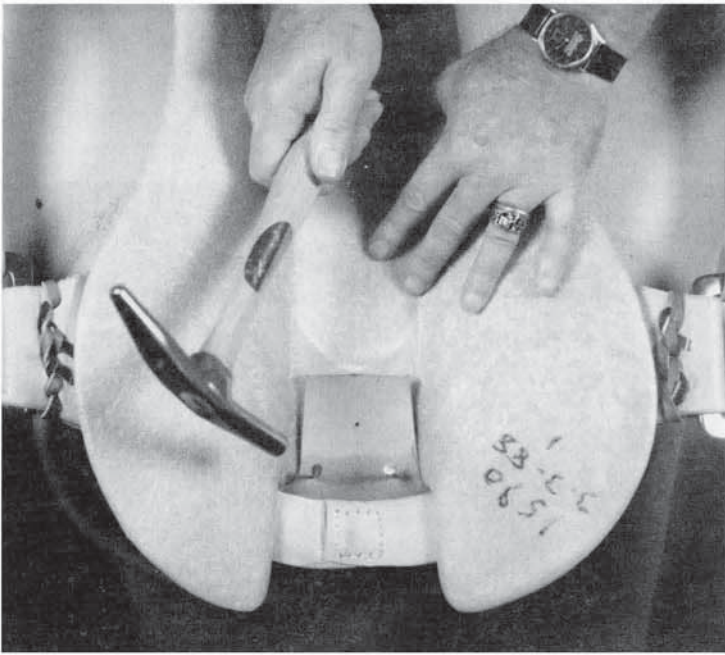
### Final Assembly

**NOTE.** Remove skirts from tree if you have not done so already and put aside.

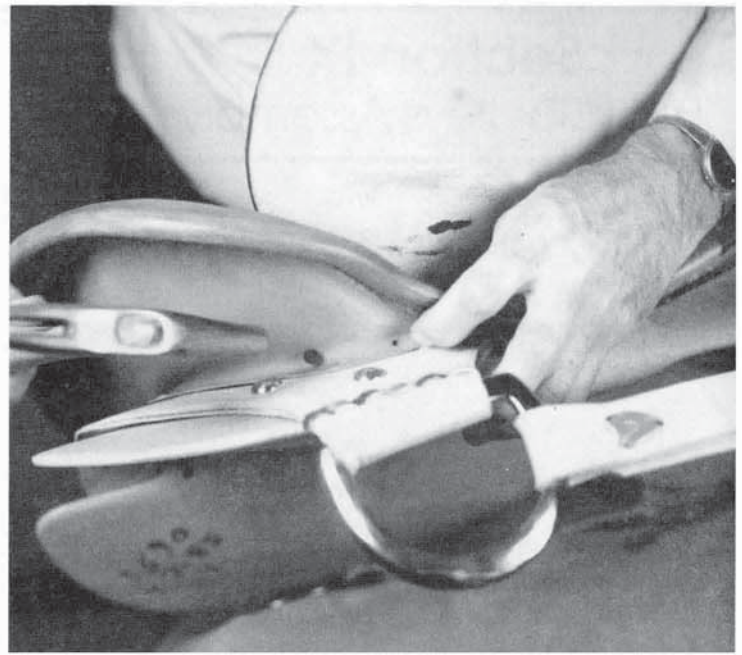


**STEP 1.** Dampen Cantle Binding and Back Cantle Cover with water. Apply Craftsman Cement to inside of cantle portion of seat assembly. Adhere into position over cantle portion of tree while cement is still wet. **IMPORTANT.** Do not apply cement to area forward of cantle at this time.

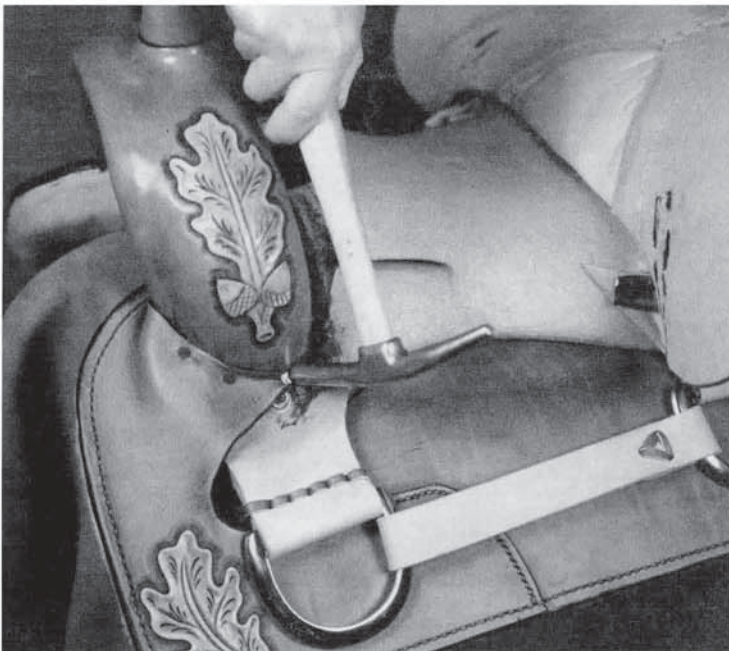




**STEP 2.** Pull tail portion of back cantle down between back rigging connector and tree. Fold tail over area of tree between bars. Secure in place with small tacks, as shown, then trim off any excess leather.



**STEP 3.** Secure back cantle cover in place with small tacks where the cantle meets the bars, as shown.

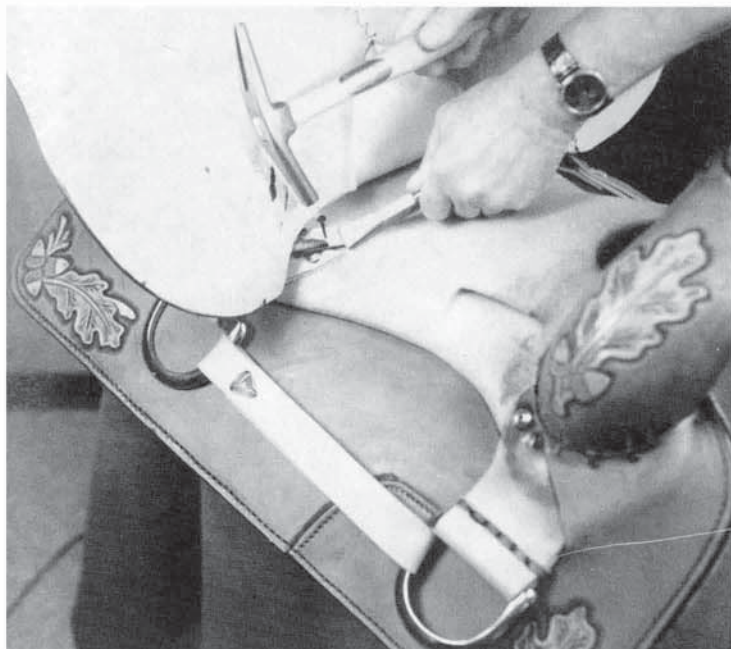


**STEP 4** Put skirts back on tree at this time. Secure front Jockeys in place with large tacks, as shown.



**STEP 5.** Secure back bars in back bar pockets with small tacks, as shown.





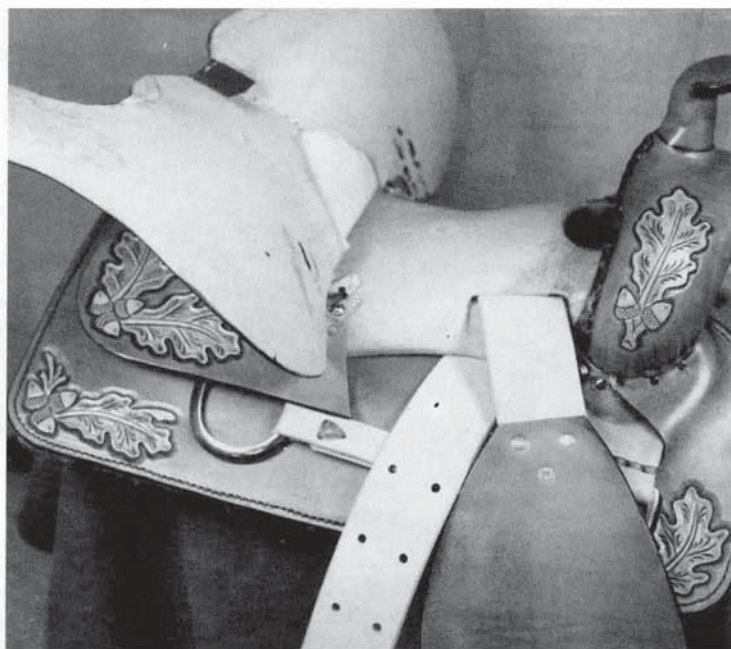
**STEP 6.** Pull both ends of the cantle binding into position and secure in place with large tacks, as shown.



**STEP 7.** Slide back jockeys assembly into position behind cantle, as shown.

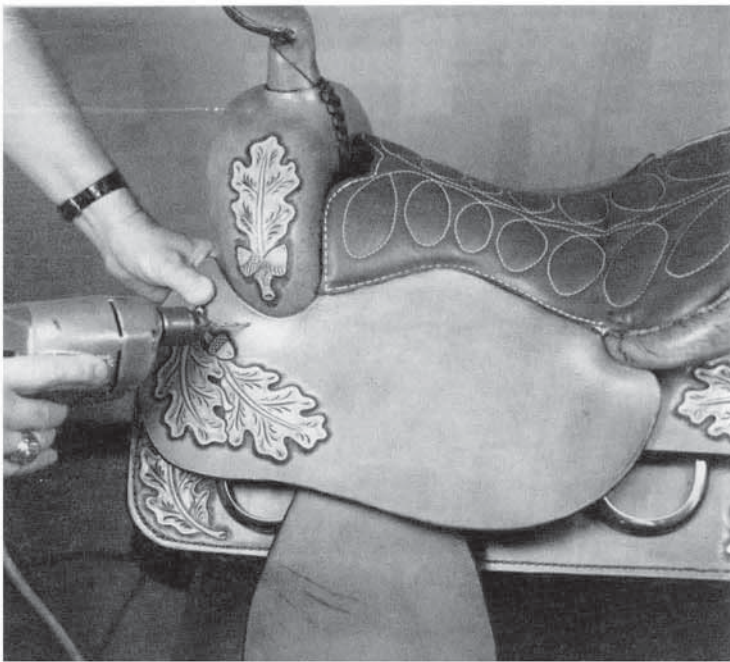


**STEP 8.** Secure both sides of back jockeys assembly to tree with small tacks, as shown.

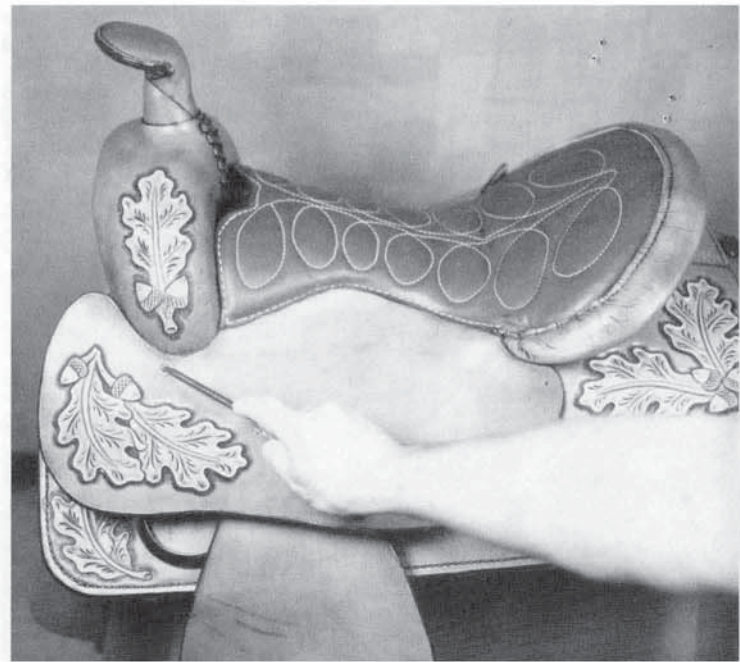


**STEP 9.** Run billet end of one fender assembly down through slot in tree then out over connector strap and skirt, as shown.

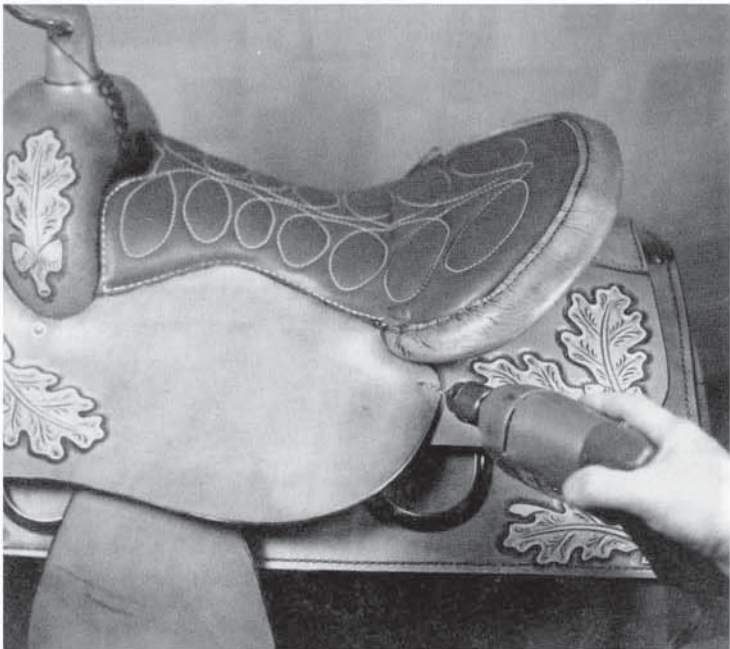




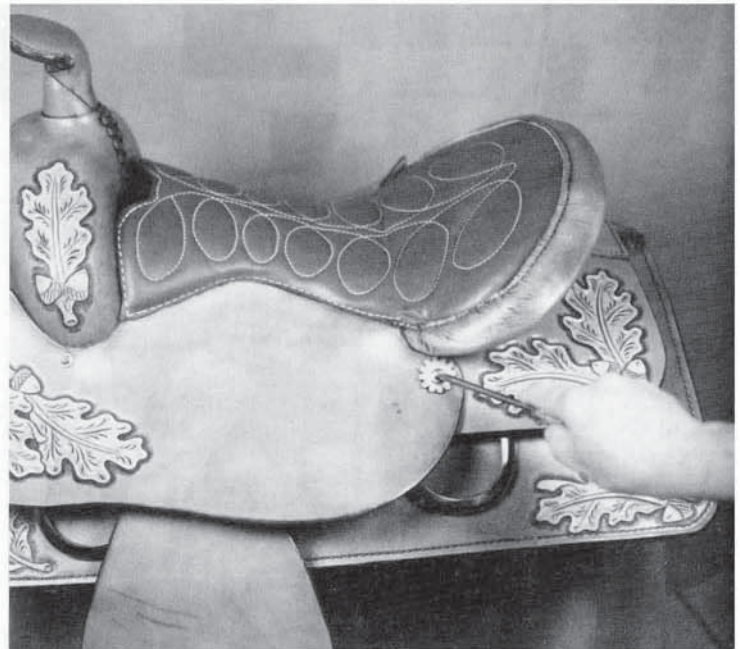
**STEP 10.** Adhere seat in place with Craftsman Cement. Drill starter hole where shown. Repeat on other side.



**STEP 11.** Secure front sections of both seat jockeys in place with 1-1/2" domed screws and finishing washers, as shown.

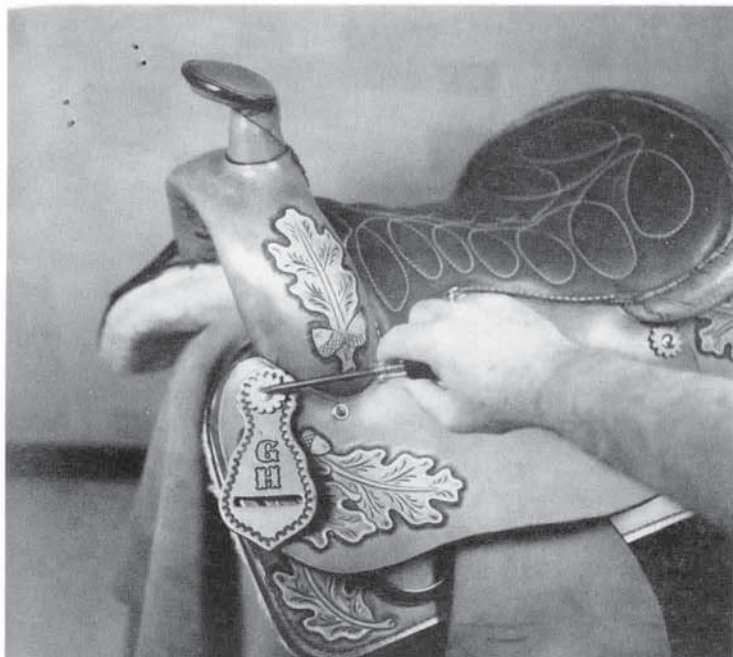


**STEP 12.** Drill starter hole at back of seat jockey where shown. Repeat on other side.

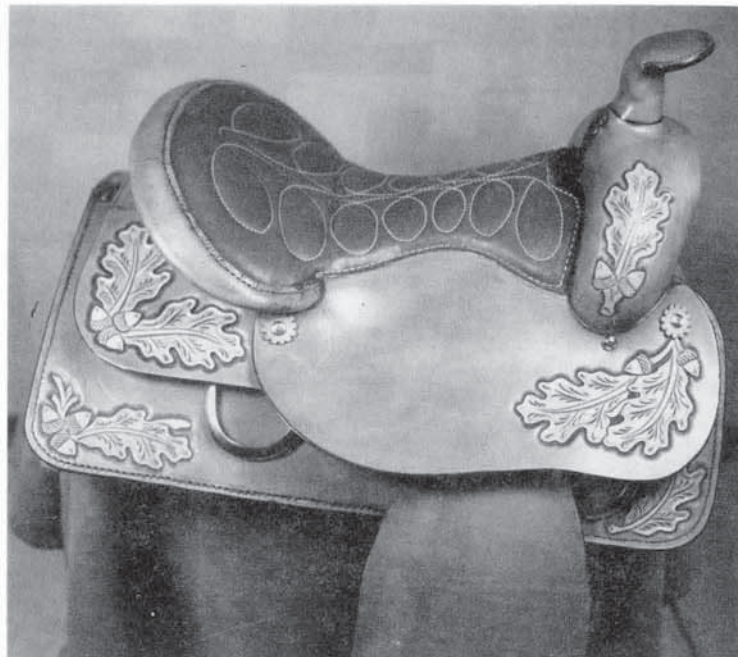


**STEP 13.** Secure back sections of both seat jockeys in place with 1-1/2" domed screws, finishing washers and 1" leather conchos, as shown.





**STEP 14.** Drill starter hole then secure front part of left side seat jockey in place with a 1-1/2" domed screw, finishing washer, 1" leather concho and strap holder.



**STEP 15.** Front part of right side seat jockey is secured the same way as explained in step 14 except strap holder is not used.



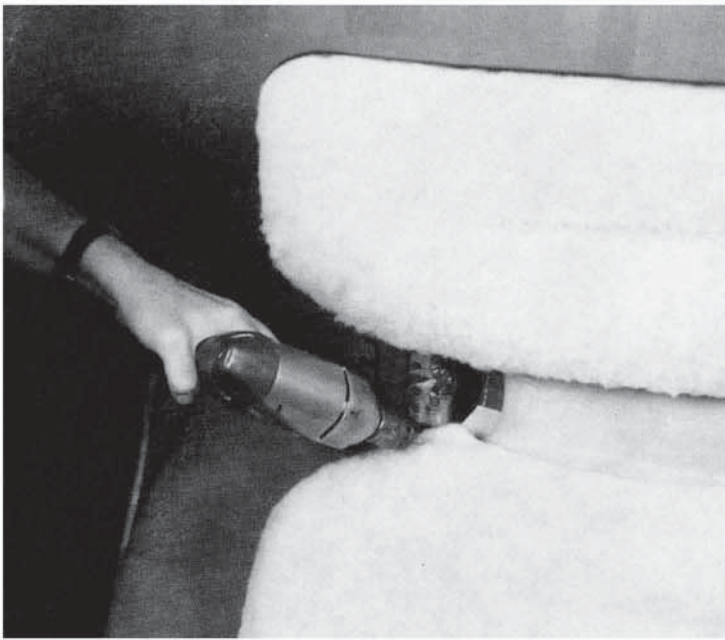
**STEP 16.** Drill pilot hole through one back jockey, as shown.

**IMPORTANT.** Be sure to drill pilot hole well into tree bar. You need to be at least 3/4" in from edge of bar.

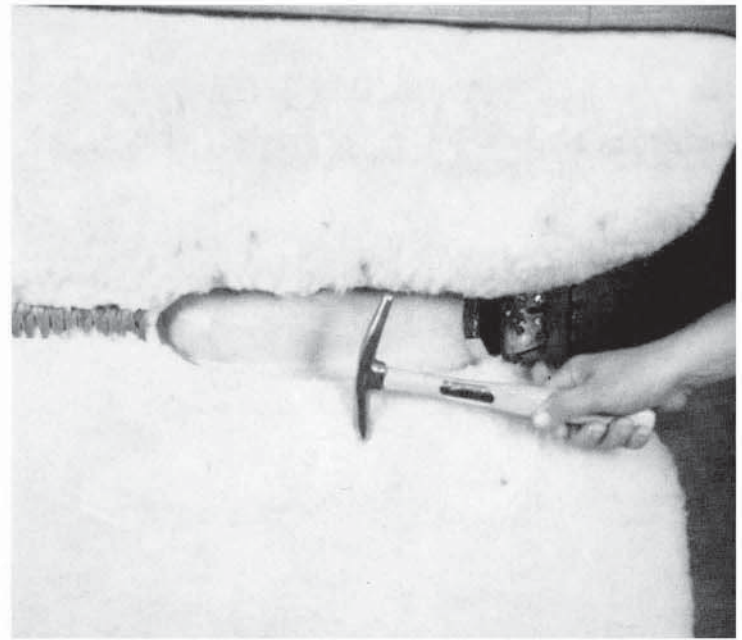


**STEP 17.** Soak one rawhide tab in water for a couple hours until soft and pliable. Fold tab around straight end of one 1" solid dee. Secure tab to back jockey with a 1" domed screw, finishing washer and 2" leather concho using pilot hole drilled in step 16. Repeat steps 16 and 17 on other back jockey.

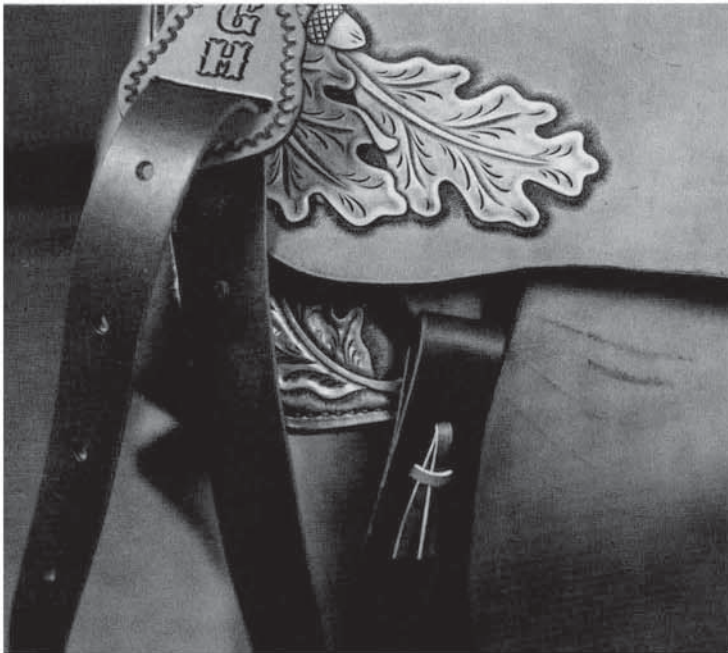




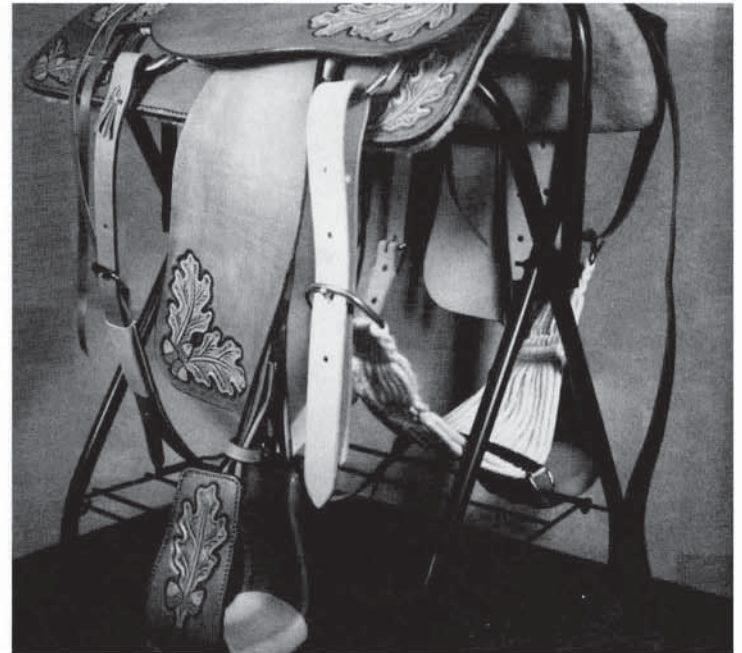
**STEP 18.** Drill pilot hole into tree using hole previously punched in front end of one skirt as a guide. Secure skirt to tree with a 3/4" domed screw and finishing washer. Repeat on other skirt.



**STEP 19.** Secure skirt assembly to bars using about 8 large tacks on each side, as shown. Be sure tacks are driven well into bars but do not hit areas where stirrup leathers come through.

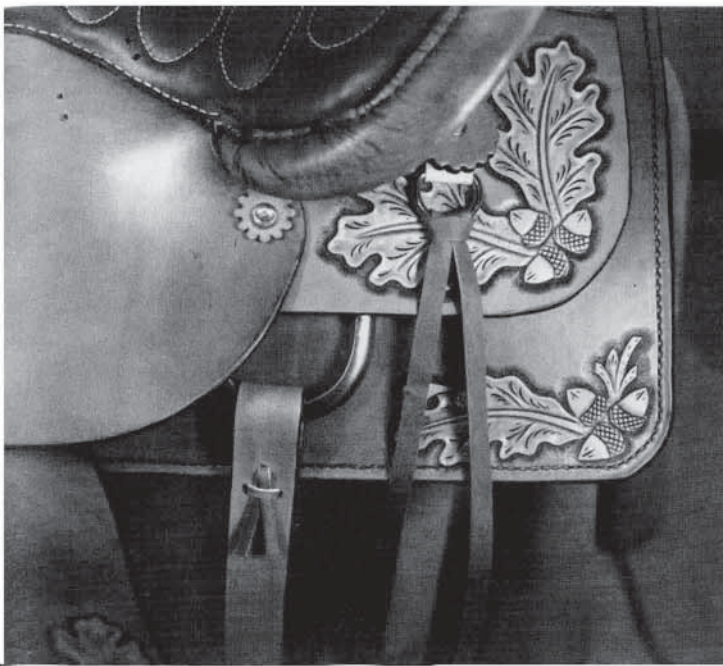


**STEP 20.** Attach Latigo Tie Strap to Front Rigging Dee on left side of saddle with a 3 hole bleed knot. Use a 12" long piece of 1/4" Latigo Lace.

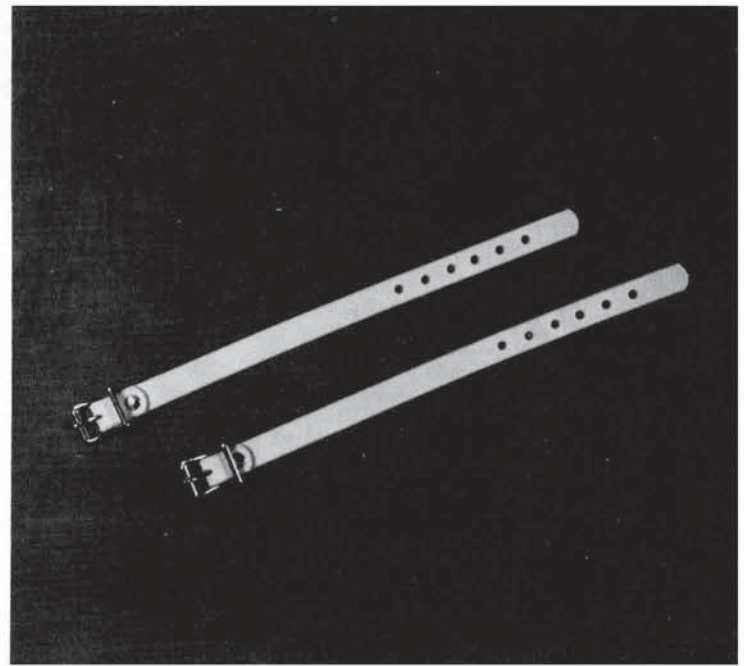


**STEP 21.** Loop Off Billet through Front Rigging Dee on right side of saddle then buckle to cincha, as shown.





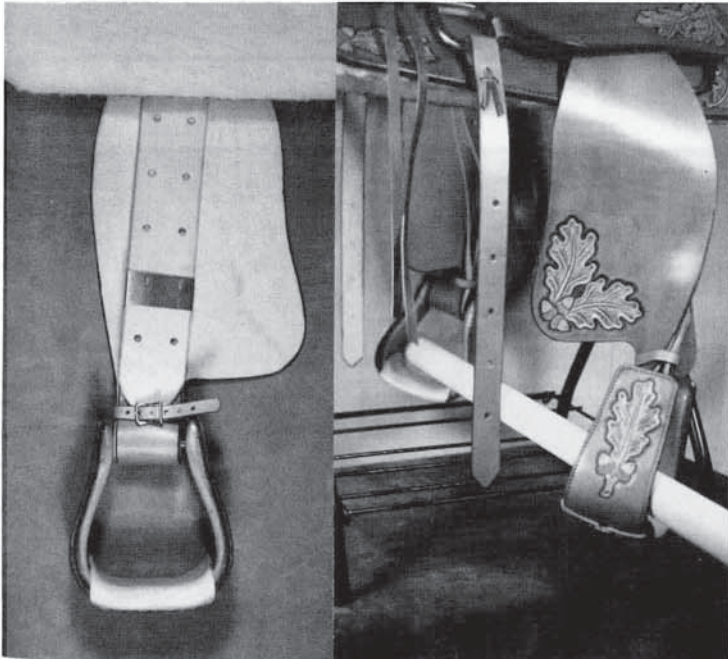
**STEP 22.** Attach Back Cincha Off Billets to Back Rigging Dees with 3 hole bleed knots, as shown. Use 12" long piece of 1/4" Latigo Lace for each side.



**STEP 23.** Attach 5/8" utility buckles to Hobble Straps with medium rivets as shown.

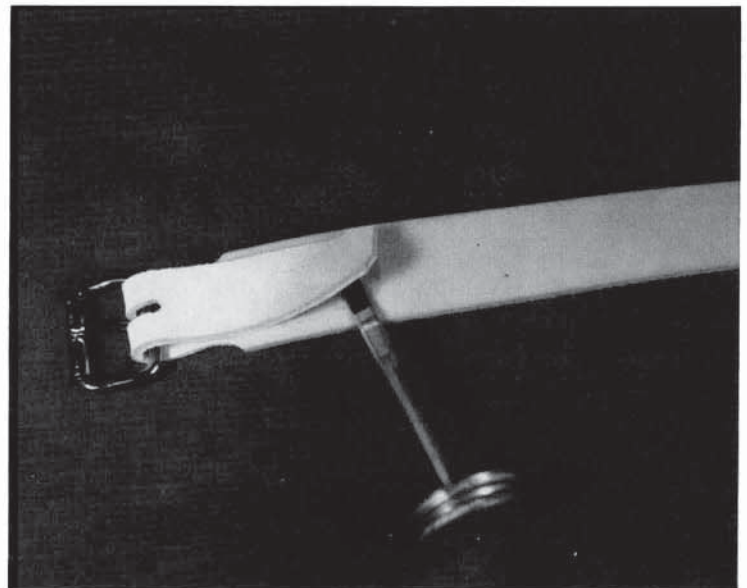
Photo A

Photo B



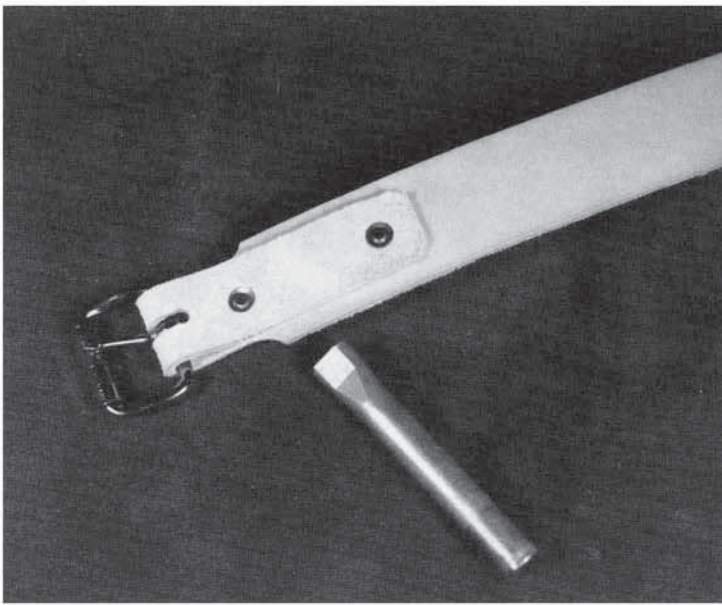
**STEP 24.** Hang stirrups into position on fenders and buckle in place. Secure stirrups with Hobble Straps, as shown (photo A). To train stirrups, dampen back sides of fenders and intire stirrup leathers. Twist into position and hold in place by running a long stick (broom handle) through both fender assemblies, as shown (photo B). Keep stick in place until leather has dried completely.

## Section XI Back Cincha

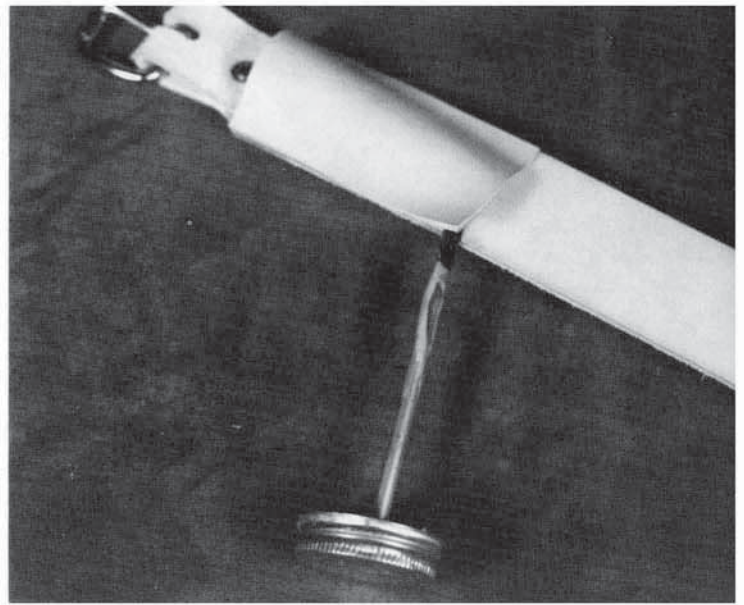


**STEP 1.** Fold one end of Back Cincha over 1 1/2" roller buckle, rough side out. Secure in place with Craftsman Cement. Repeat on other end.

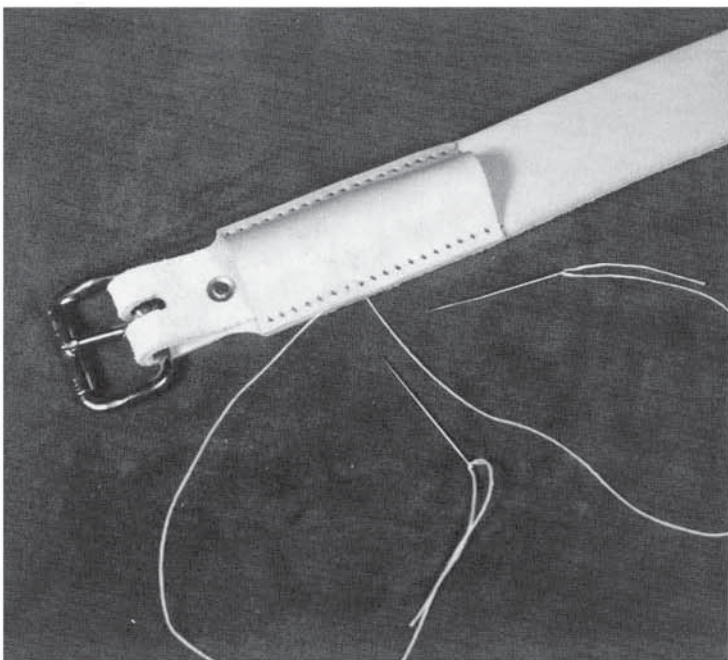




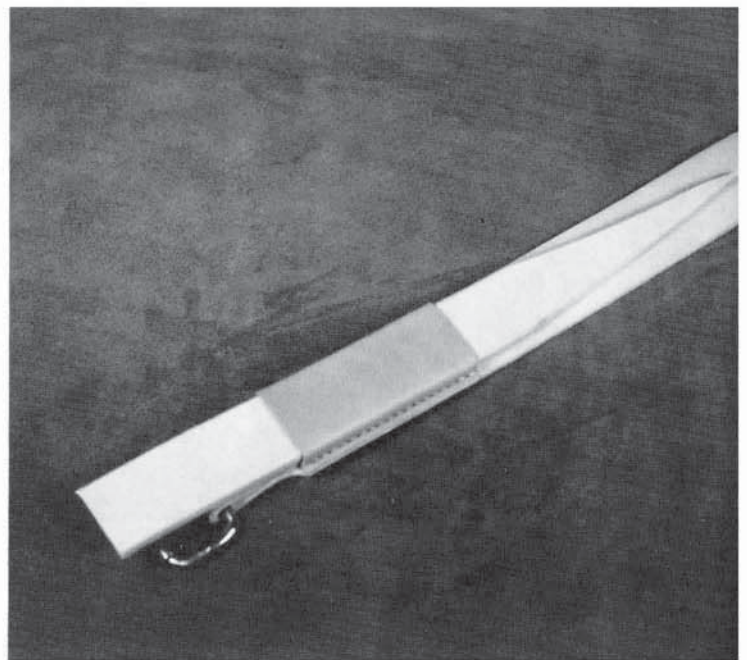
**STEP 2.** Set two copper rivets in each end of Back Cincha, as shown.



**STEP 3.** Cement keepers in place on both ends of Back Cincha, as shown. **IMPORTANT:** Apply cement along long edges of keepers only.

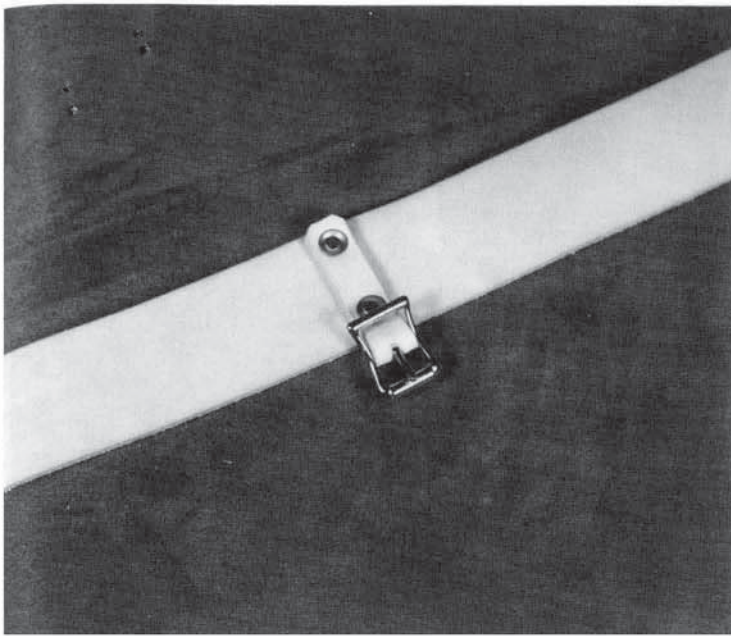


**STEP 4.** Saddle stitch keepers in place along edges, as shown.

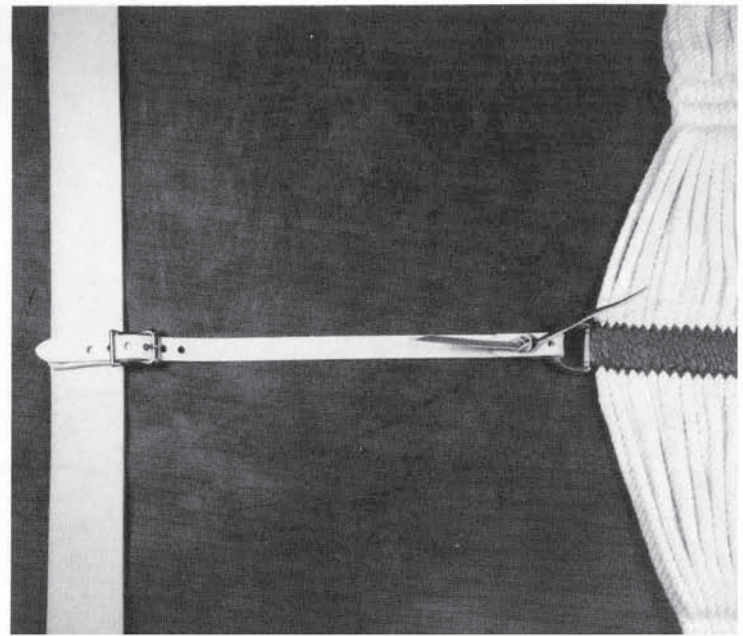


**STEP 5.** Dampen keepers with water, then shape with keep-stretcher, as shown.





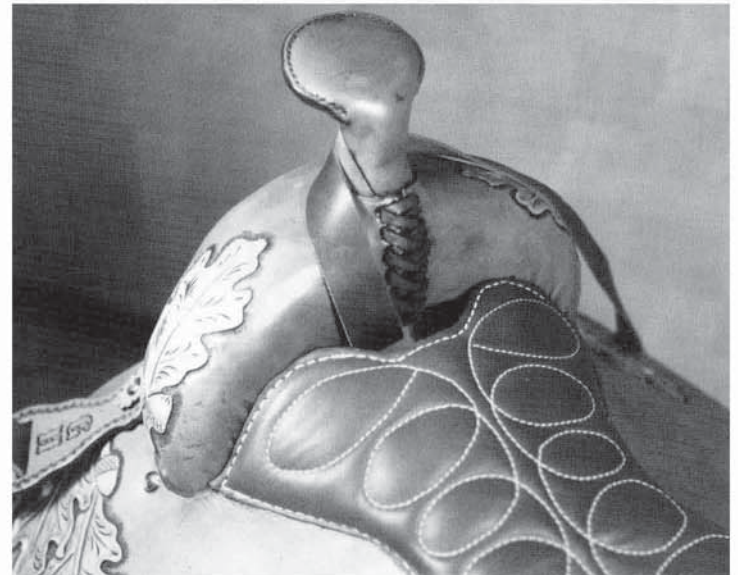
**STEP 6.** Fold Strap Billet over 5/8" utility buckle; then attach to center (smooth side) of Back Cincha with two copper rivets, as shown.



**STEP 7.** Attach end of Connector Strap (end with 4 holes) to dee in back of Front Cincha with a 6" long piece of 1/8" Latigo Lace. Buckle other end of Connector Strap to Strap Billet, as shown.

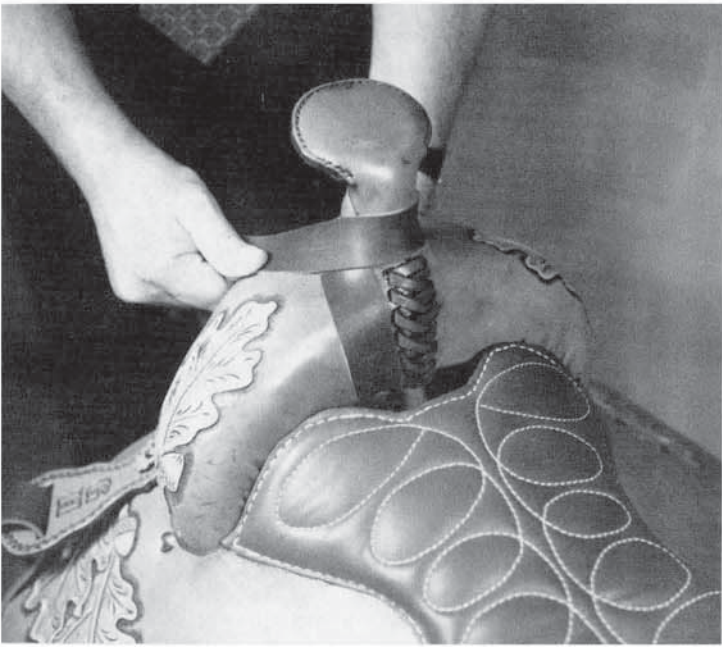
## Optional Horn Wrap

**NOTE.** A Horn Wrap is recommended to protect the Horn Cover from rope burns as well as prolong its life. The wrap is usually made from a 60" long strap of 1" wide, 4-5 oz. Latigo.



**STEP 1.** Secure one end of wrap in gullet opening under swells, with large tacks. Pull wrap up back side of swells and around front of horn.

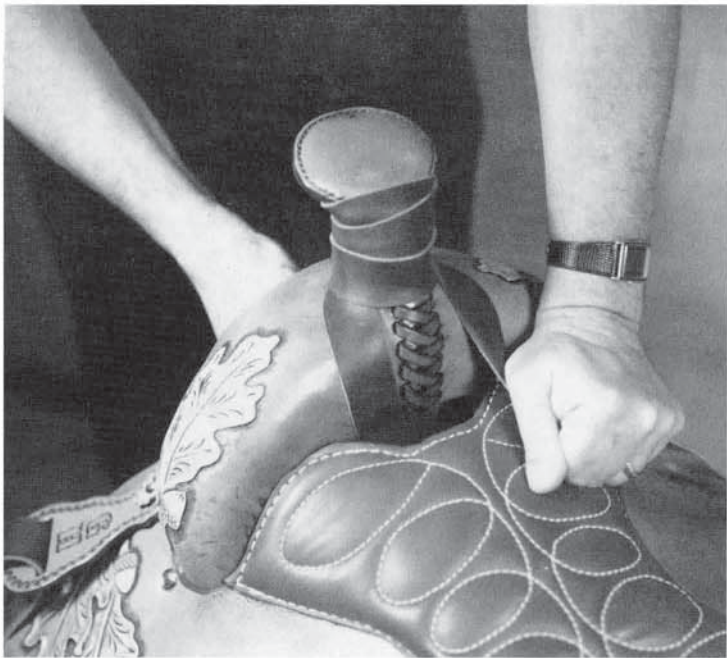




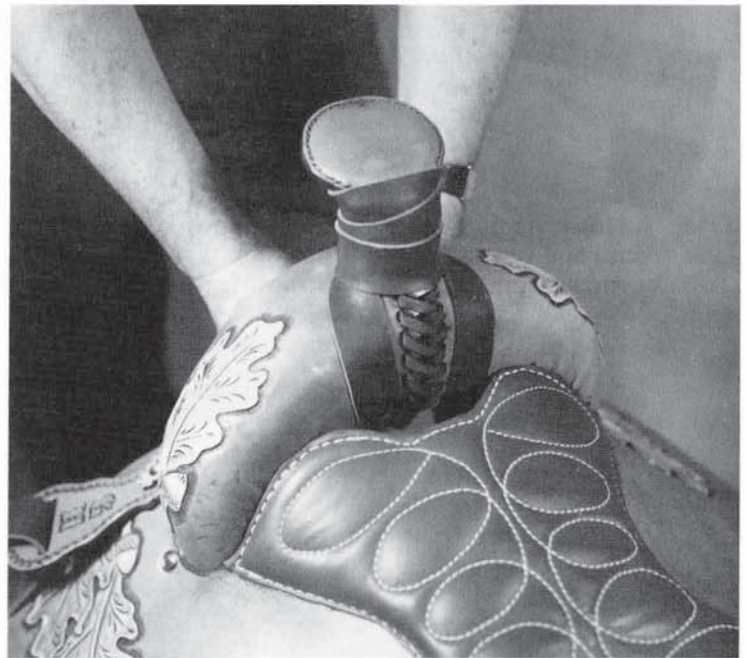
**STEP 2.** Pull wrap around back of horn as tightly as possible.



**STEP 3.** Continue wrapping toward top of horn, pulling as tightly as possible.



**STEP 4.** Wrap back down horn toward gullet opening, as shown.



**STEP 5.** Pull end of wrap down through gullet opening and secure under swells with tacks.



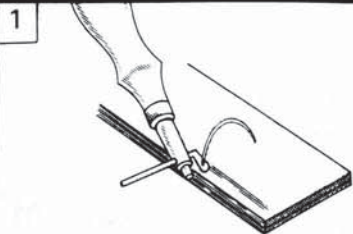
# Saddle stitching

## RECOMMENDED USAGE:

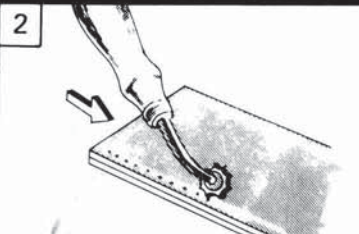
Saddle stitching is the best method for sewing two or more pieces of leather together.

Use a Stitching awl to punch holes. You will also need two harness needles, stitching groover, over-stitch tool, unwaxed linen thread and beeswax or prewaxed thread.

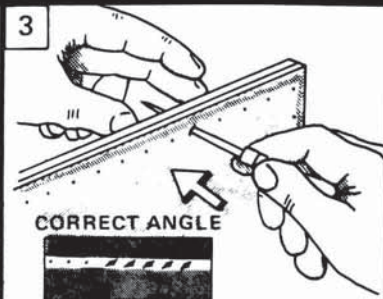
## THREADING THE NEEDLE



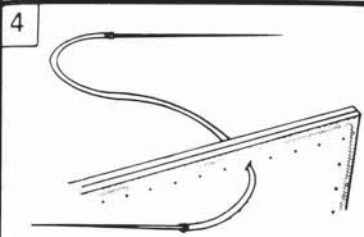
Use the stitching groover and gouge a channel around the edges of the leather. Gouge the leather on both sides. Keep tool tight against leather edges to insure a uniform gouge along the edge.



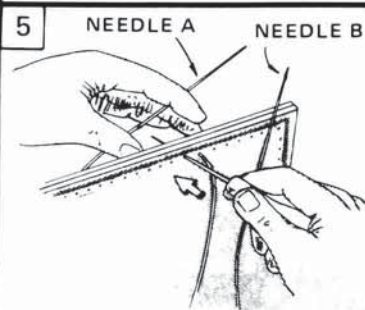
Moisten the gouged channels lightly with a damp sponge, and run the over-stitch tool all around the channel on the front side only. This marks position of awl holes to insure even stitches.



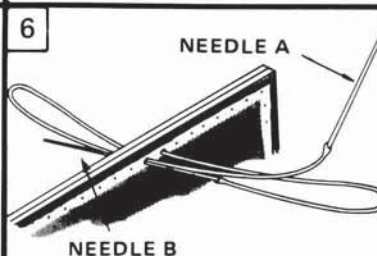
Stab first hole with awl as shown above. Be sure to stab proper angle with the awl blade.



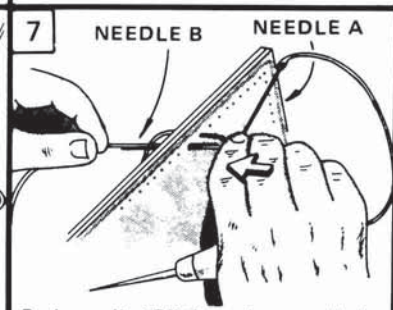
Push one needle through hole and pull until equal amount of thread is on each side of leather.



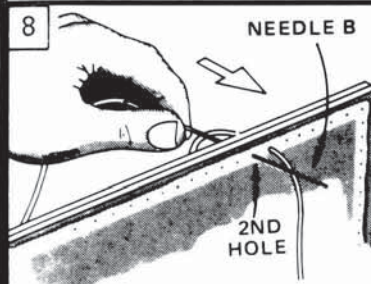
Punch second hole with awl. Hold needles as shown above.



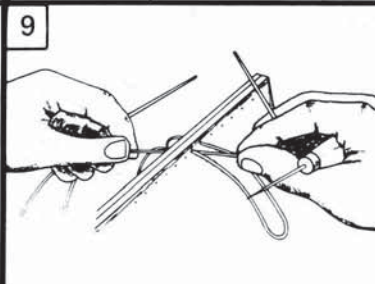
Push needle "A" through second hole from back side as shown. Always push back side needle through hole first.



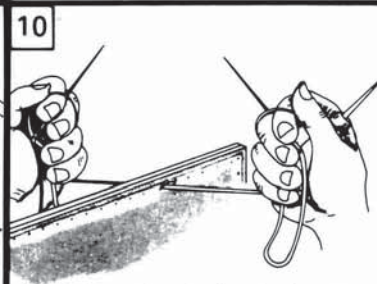
Push needle "B" through second hole from front of leather. Be careful not to pierce "A" with needle "B".



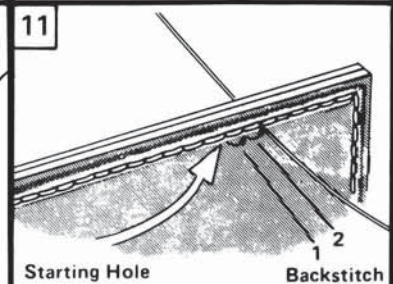
When putting needle "B" through always put it on the same side of thread "A". This will insure uniform appearing stitches.



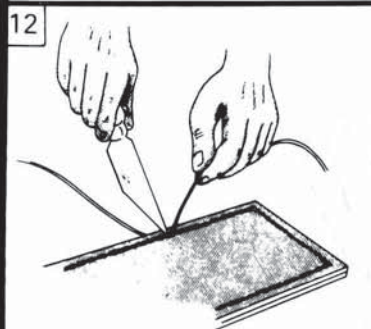
Pull both threads until all slack is taken up.



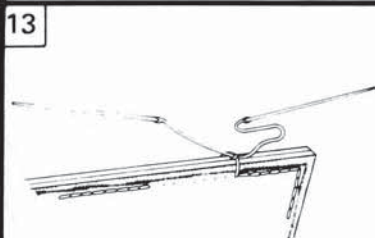
To tighten the stitch grip threads as shown and pull into gouged channel. Use equal tension with both hands. Continue stitching around project to starting hole.



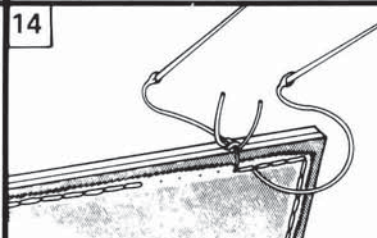
To complete stitching backstitch two holes from starting hole. Pull threads tight with each stitch.



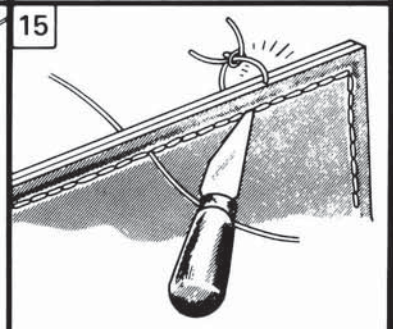
Cut threads off in stitching channel on both sides with a sharp knife.



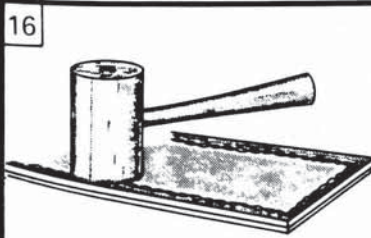
If you are sewing and use up a full length of thread and have not reached the starting hole, pull last stitch tight and tie threads together on top edge of leather as shown.



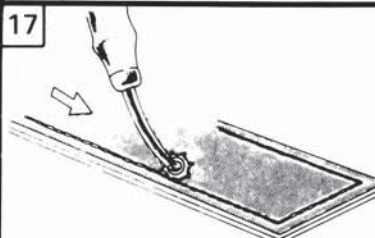
Cut needles off threads. Put needles on a new length of thread. Insert awl one hole back from last stitch and start new thread in this hole as explained in step 4. Continue stitching around project to starting hole.



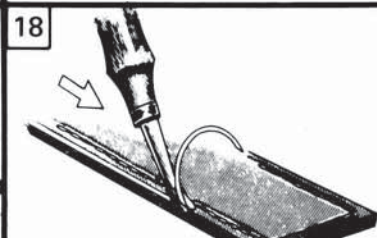
Complete stitching as explained in step 11, then cut off both sets of threads as explained in step 12.



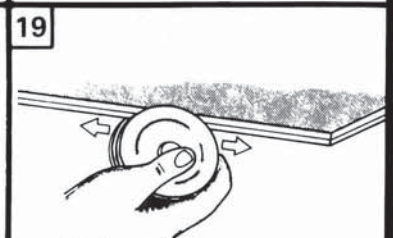
Lay project on work surface and tap over all stitching with a mallet. Be careful not to mar leather.



Run over-stitch wheel over all of the stitches this actually helps the appearance of any slightly irregular stitches.



Round the edges of the leather on both sides with a bevel-edge edge beveler.

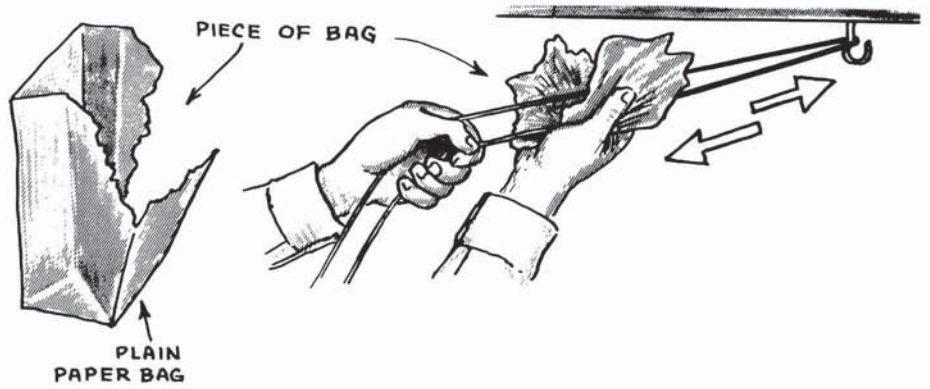


Moisten the edges of the leather and burnish with a circle edge slicker.

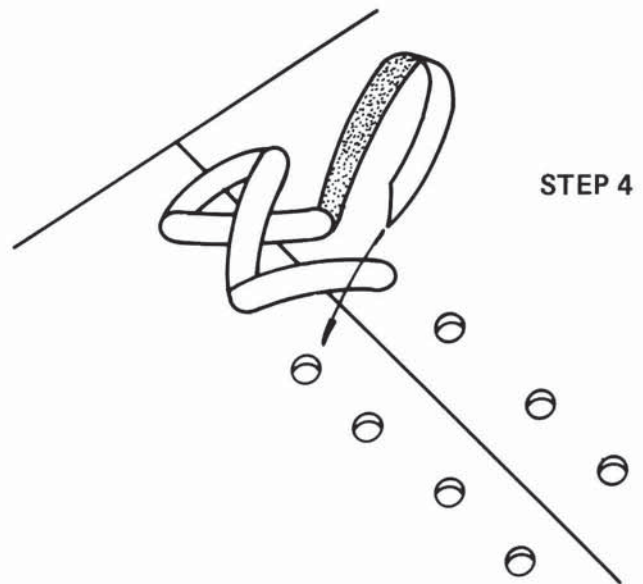
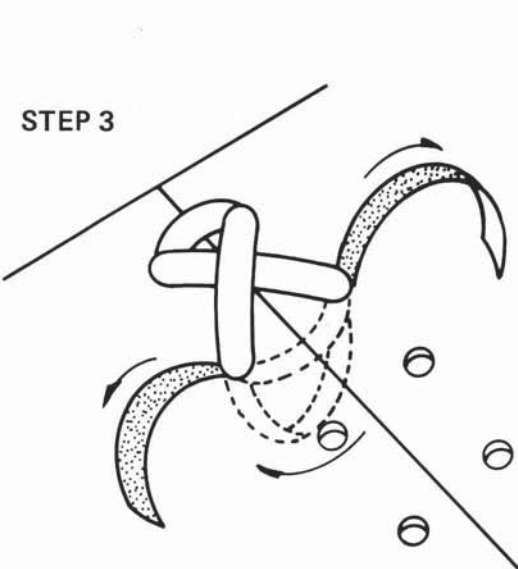
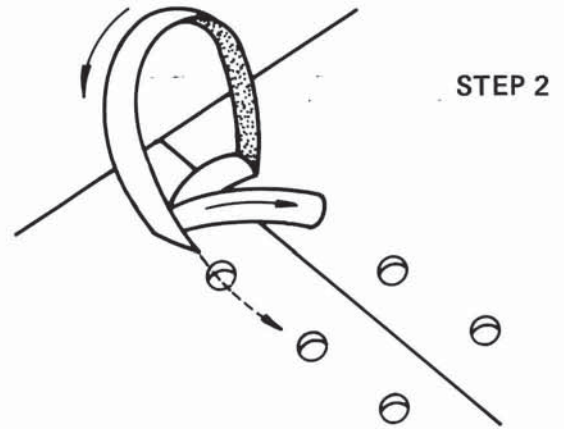
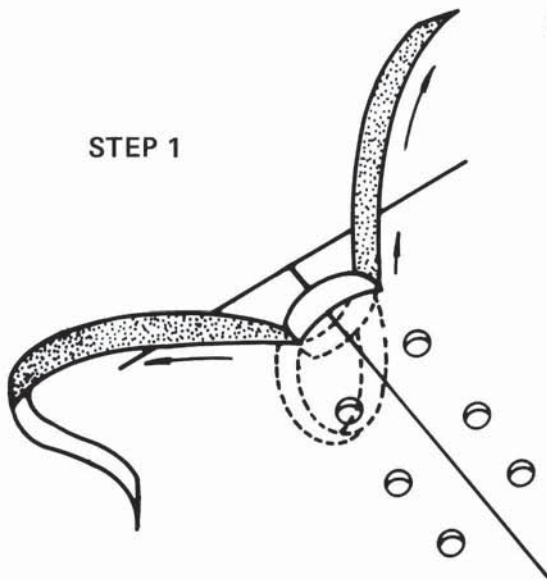


# Stitching through fleece

You cannot sew through the wool without special preparation of the thread... as the wool fibers will "grab" the thread... and pull it into the awl hole, virtually locking the stitch. To overcome this tear a piece from a paper bag. Rub vigorously back-and-forth over the thread. This hardens and burnishes the wax... and the threads will easily pass through the holes.



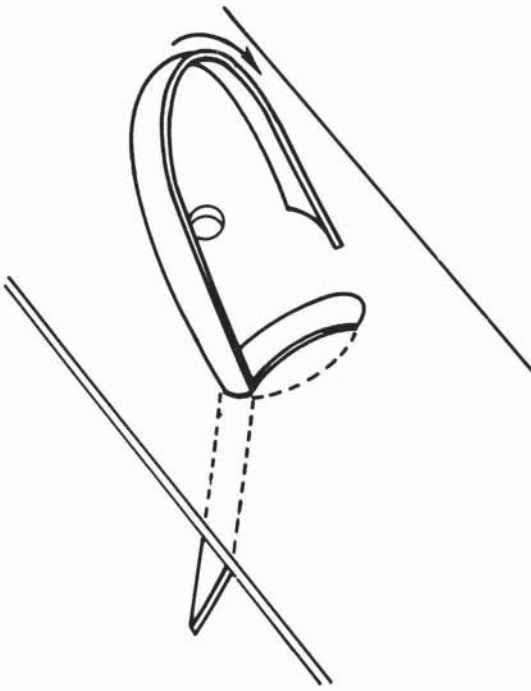
## Cross stitch



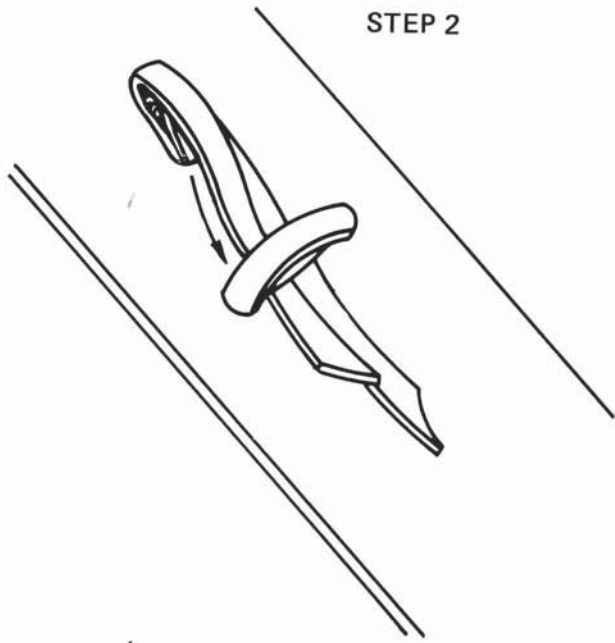


STEP 1

# 3 hole bleed knot

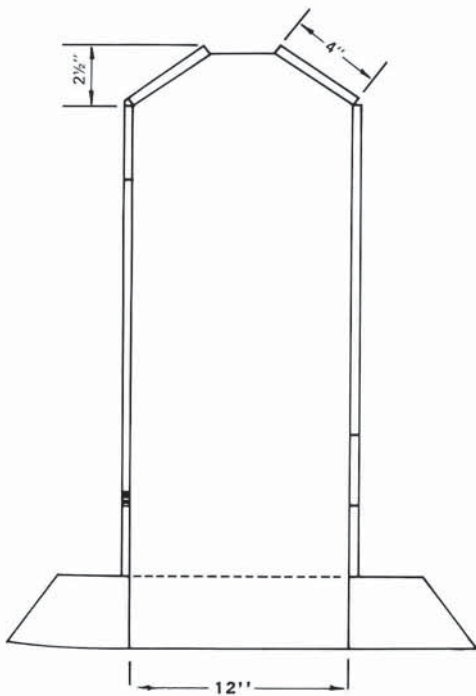


STEP 2

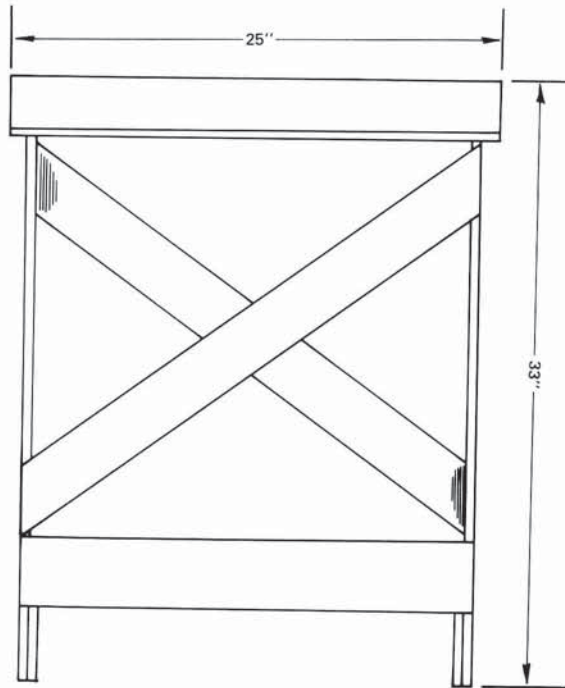


## Saddle stand assembly instructions

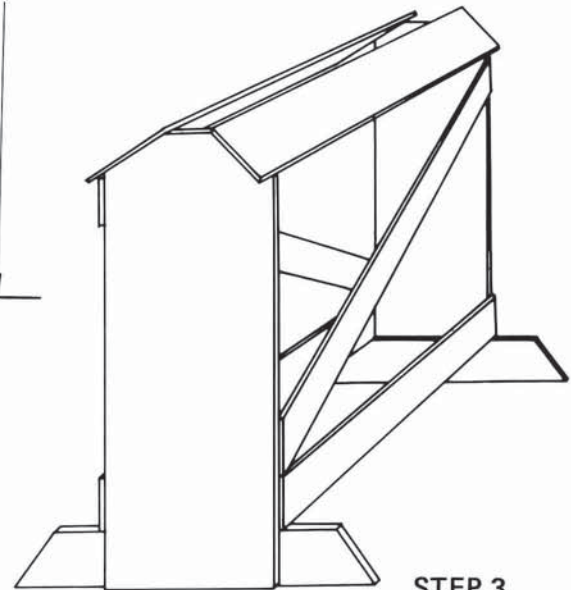
STEP 1



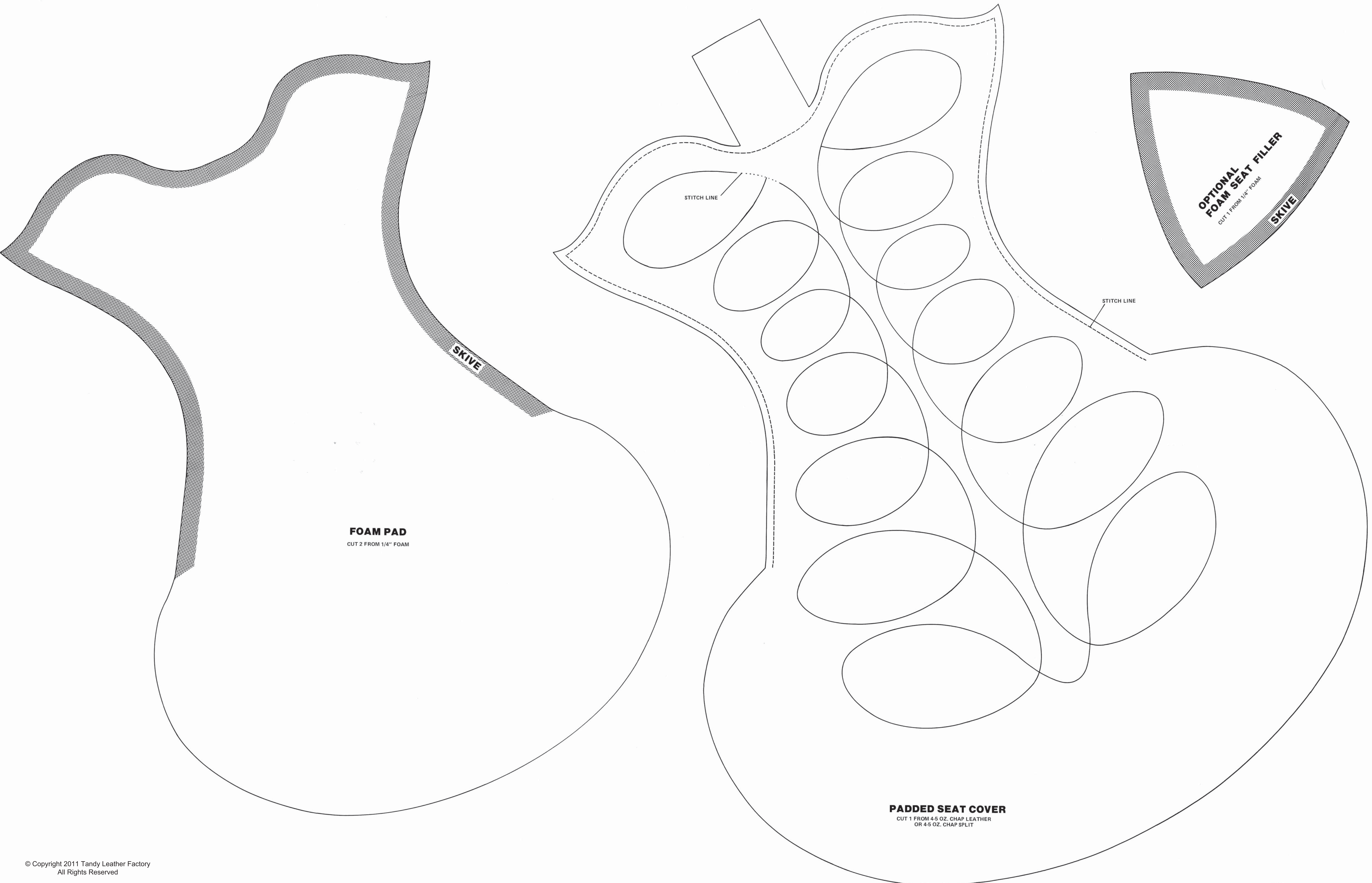
STEP 2



STEP 3







SKIVE

STITCH LINE

STITCH LINE

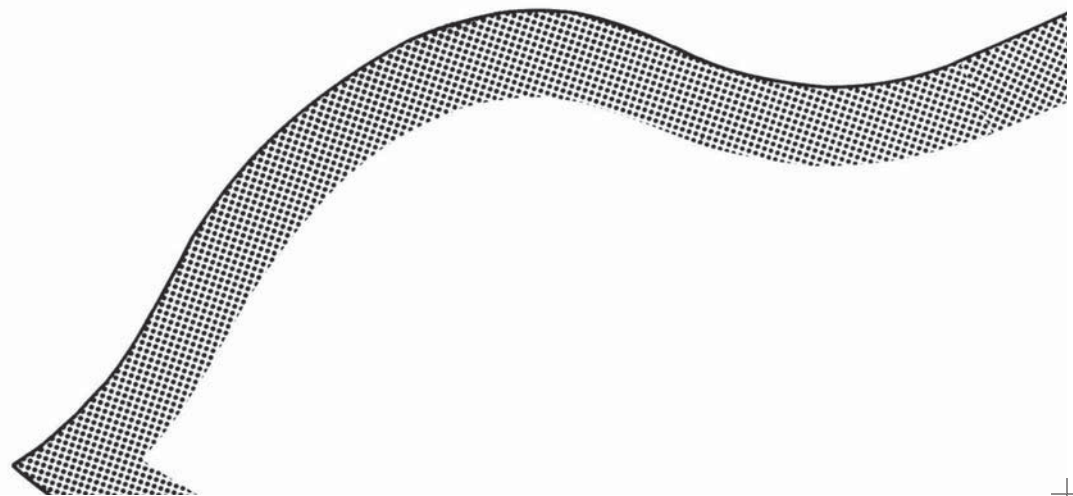
OPTIONAL  
FOAM SEAT FILLER  
CUT 1 FROM 1/4" FOAM

SKIVE

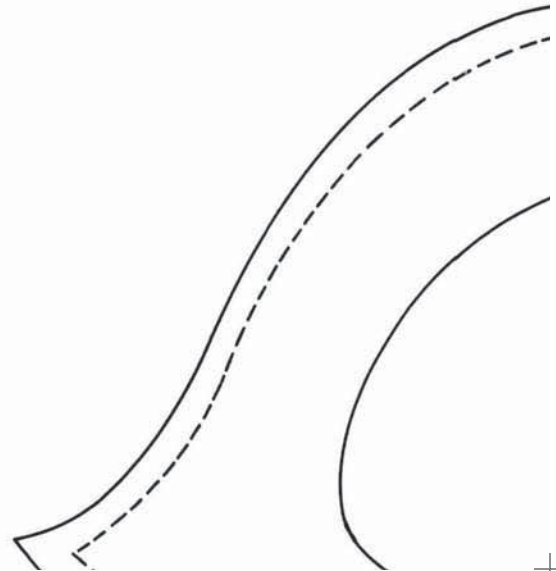
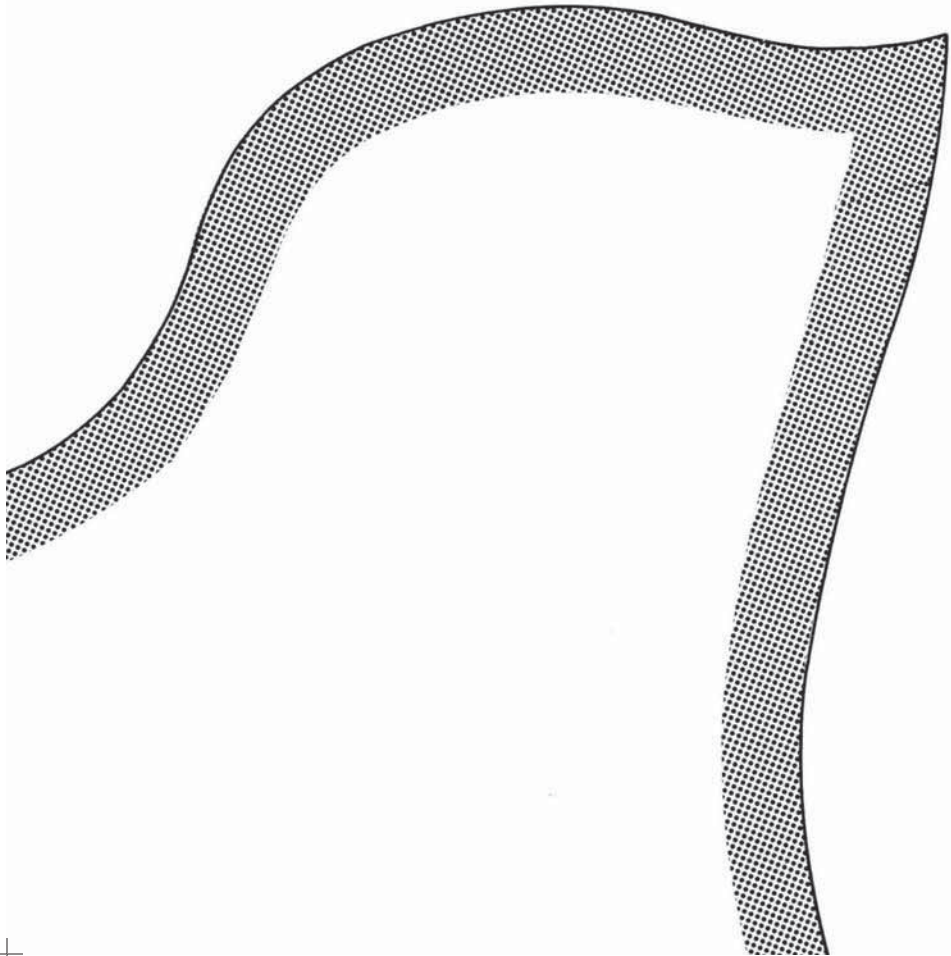
**FOAM PAD**  
CUT 2 FROM 1/4" FOAM

**PADDED SEAT COVER**  
CUT 1 FROM 4-5 OZ. CHAP LEATHER  
OR 4-5 OZ. CHAP SPLIT

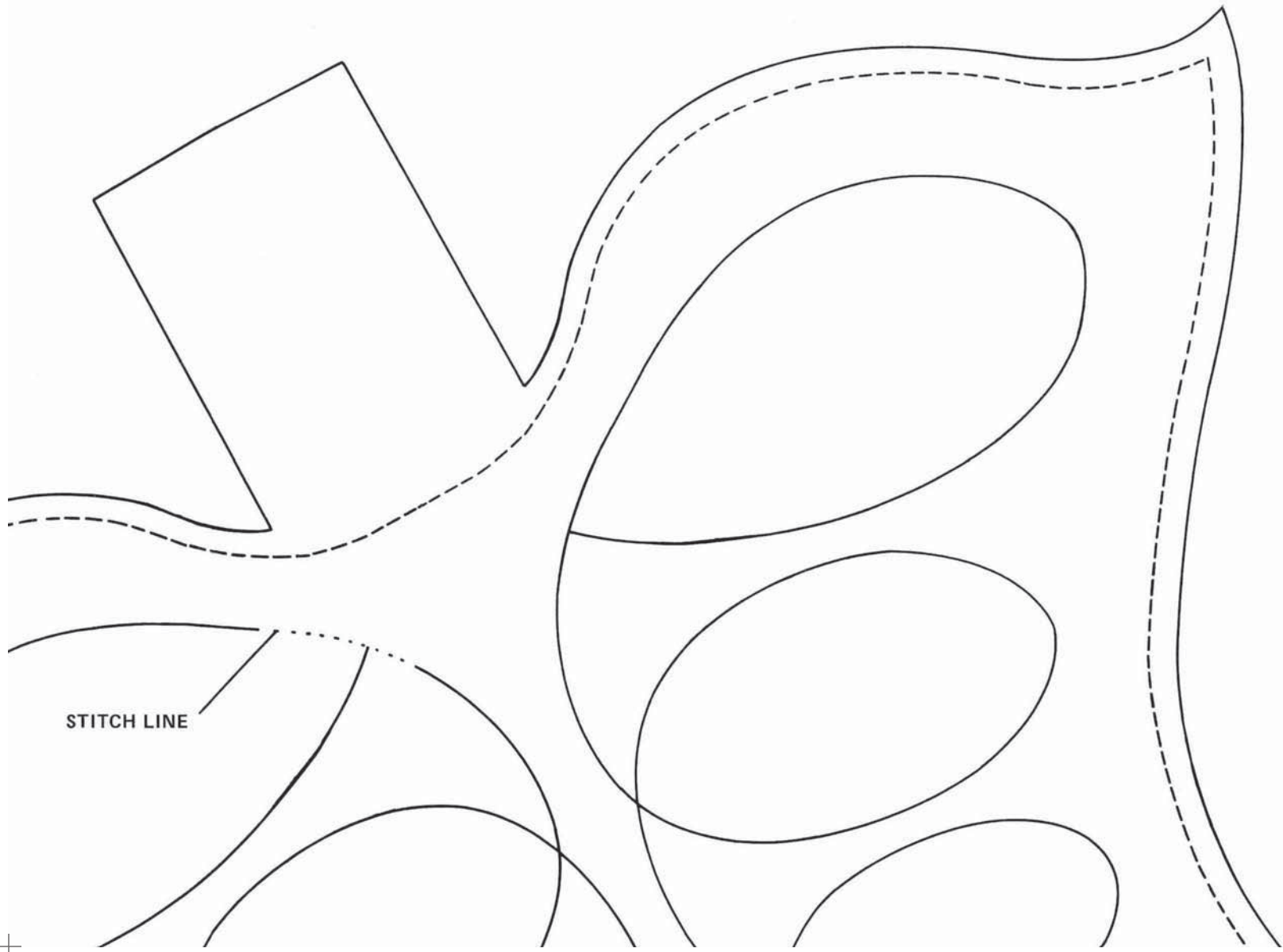






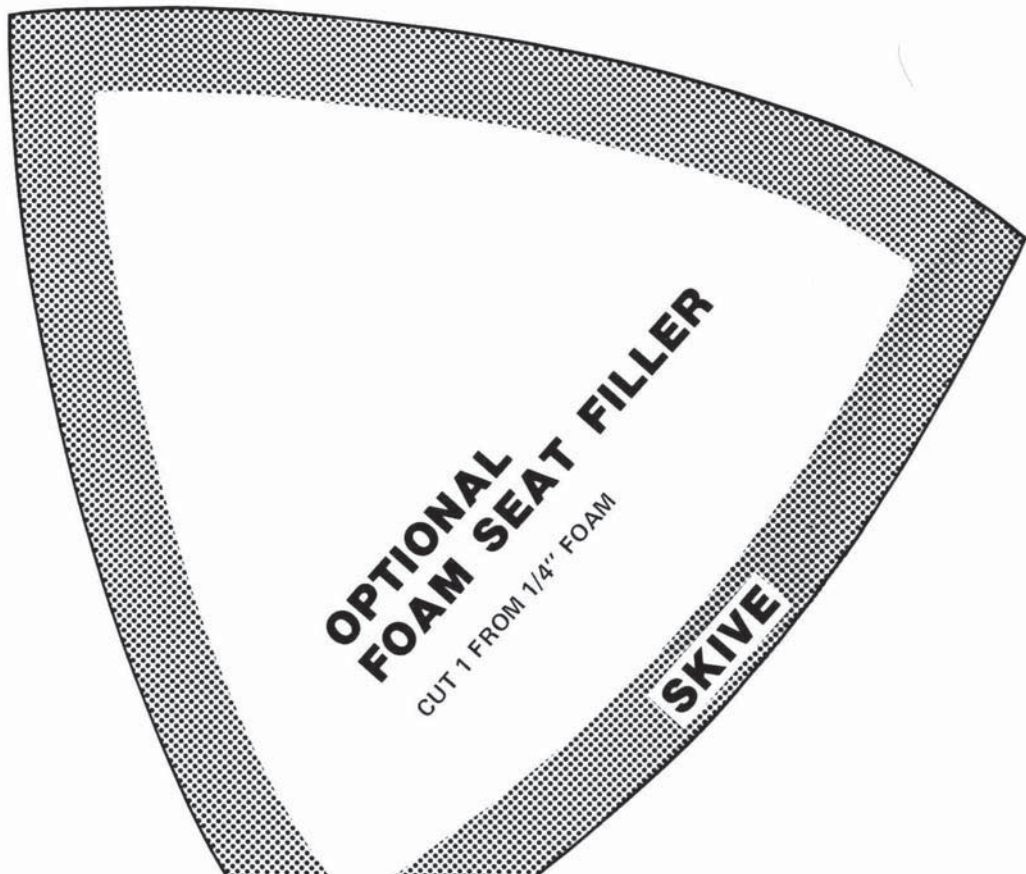






STITCH LINE

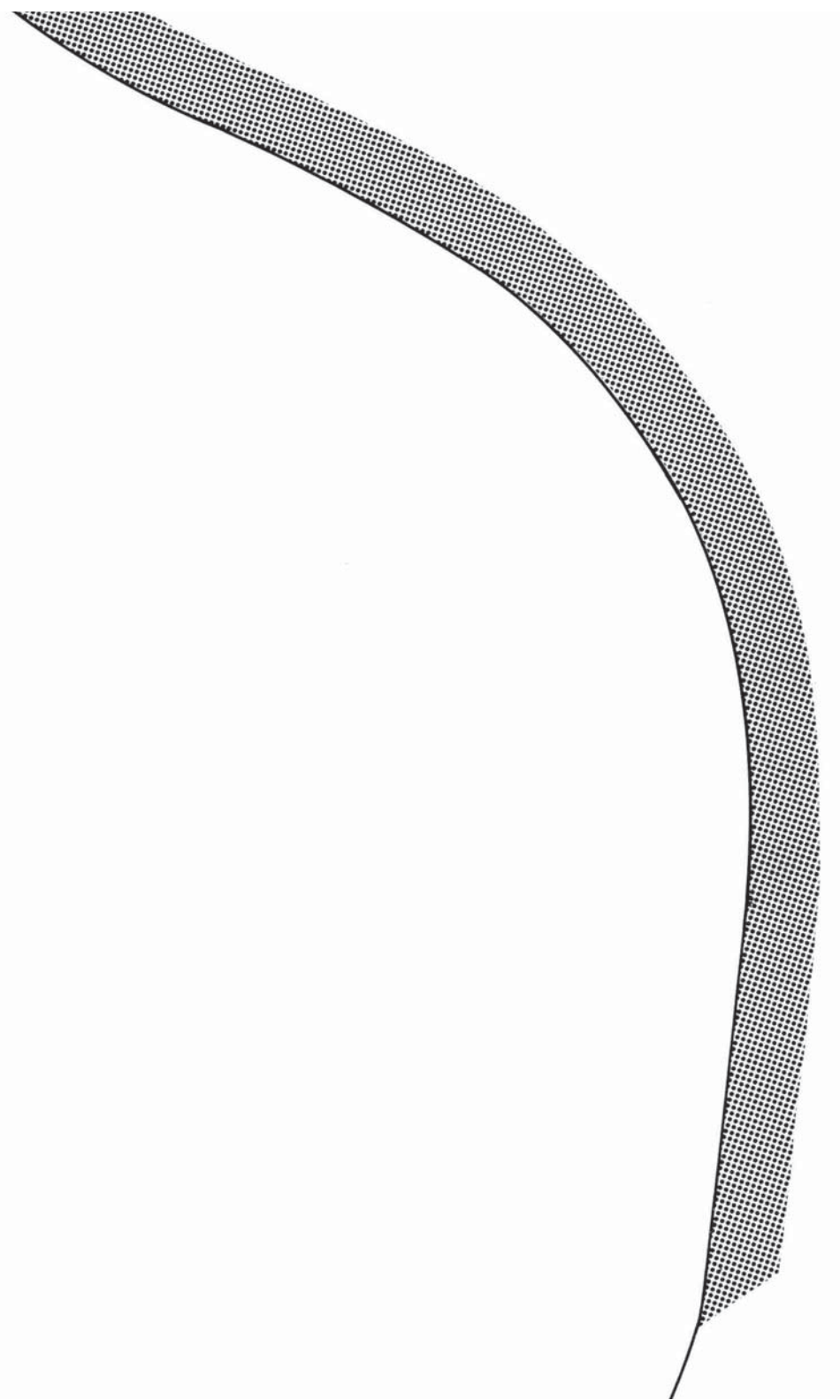




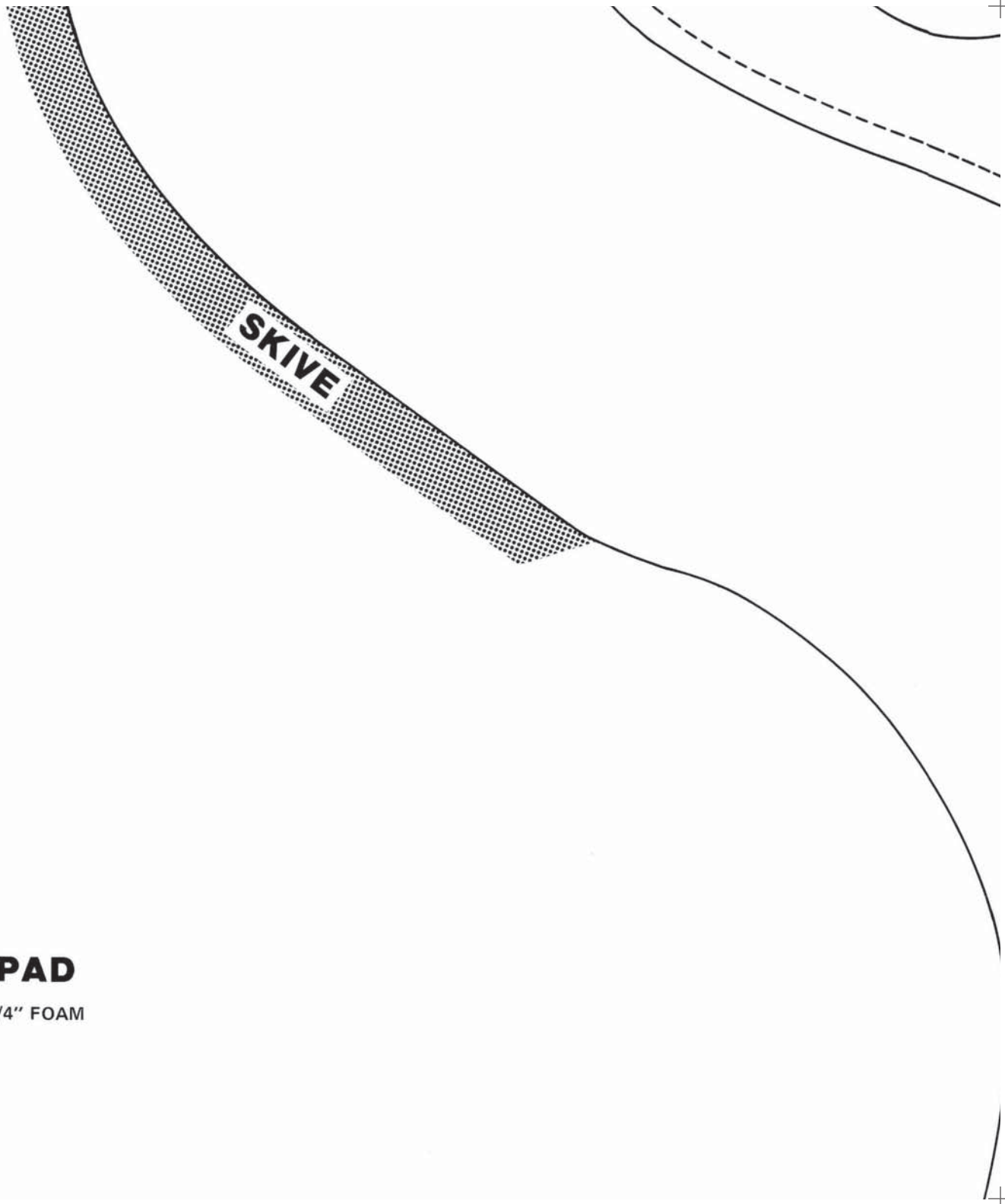
**OPTIONAL  
FOAM SEAT FILLER**  
CUT 1 FROM 1/4" FOAM

**SKIVE**





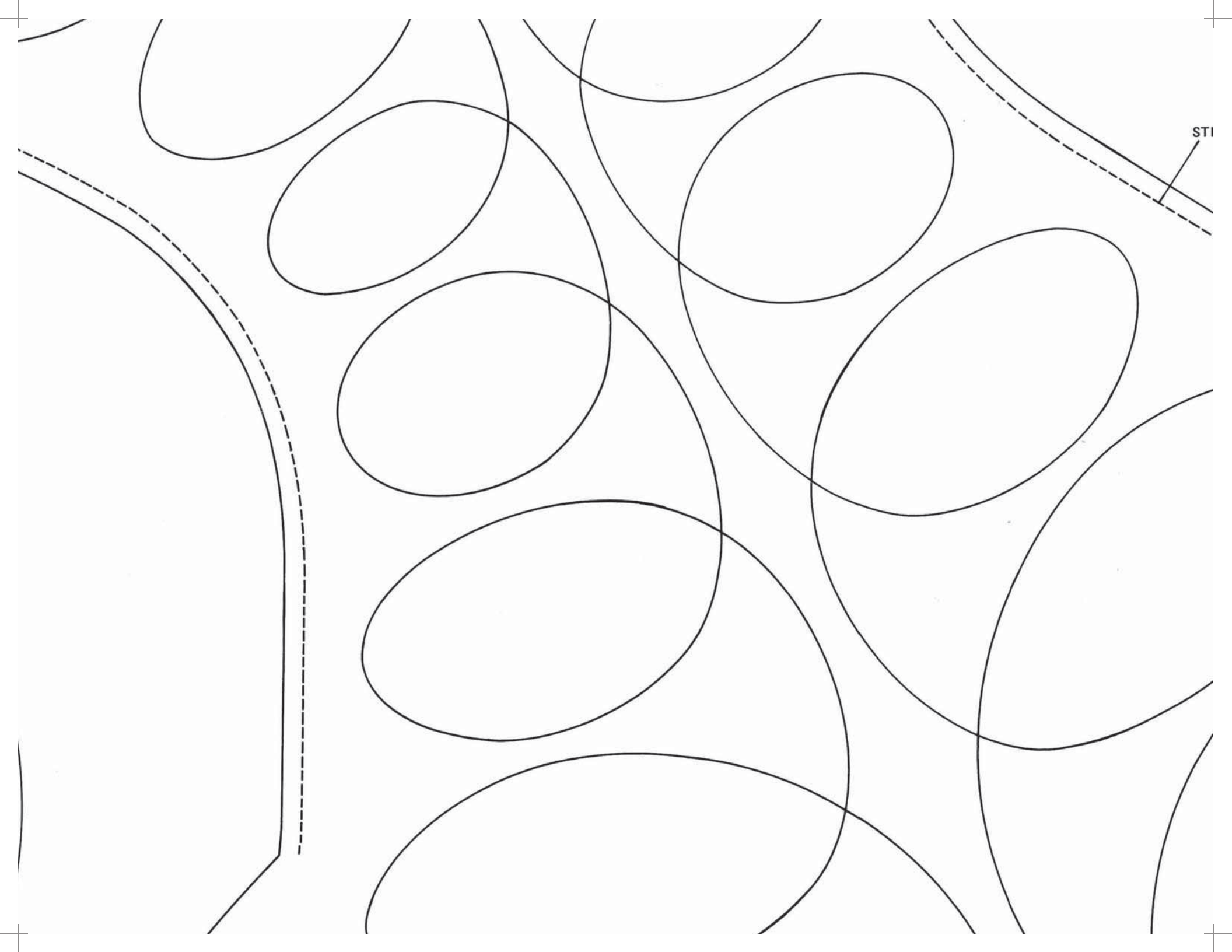


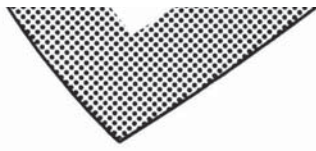


**FOAM PAD**

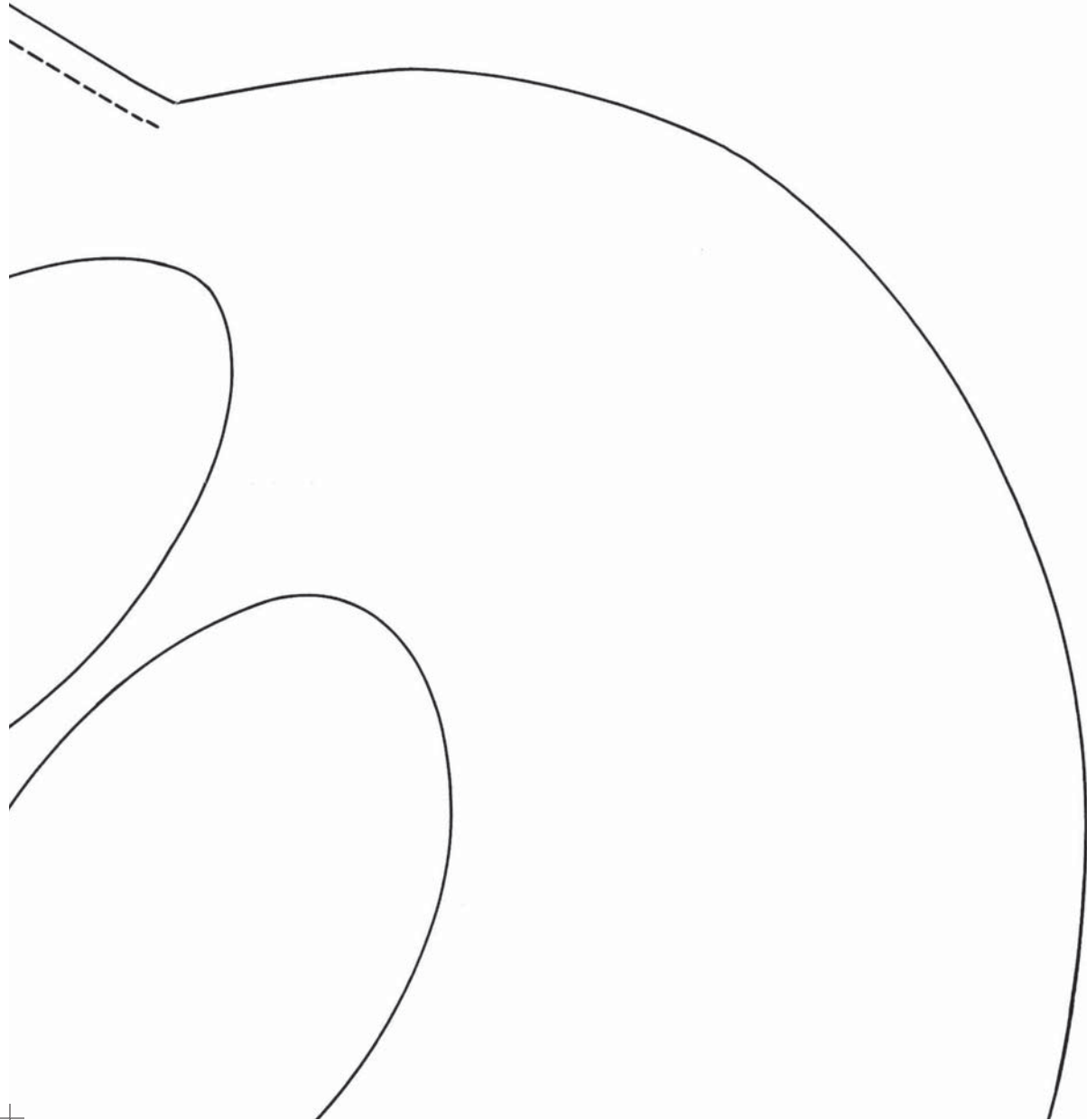
CUT 2 FROM 1/4" FOAM







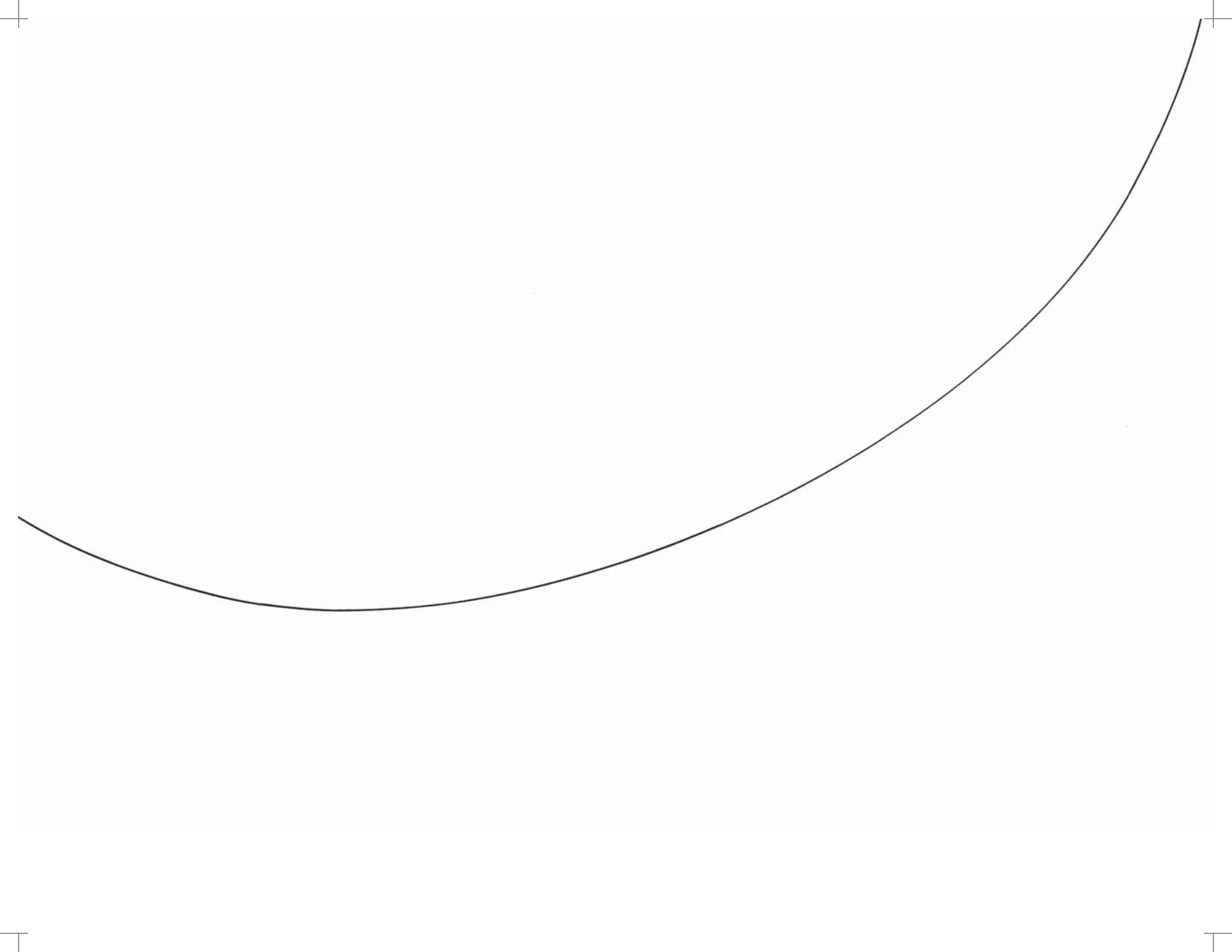
TCH LINE



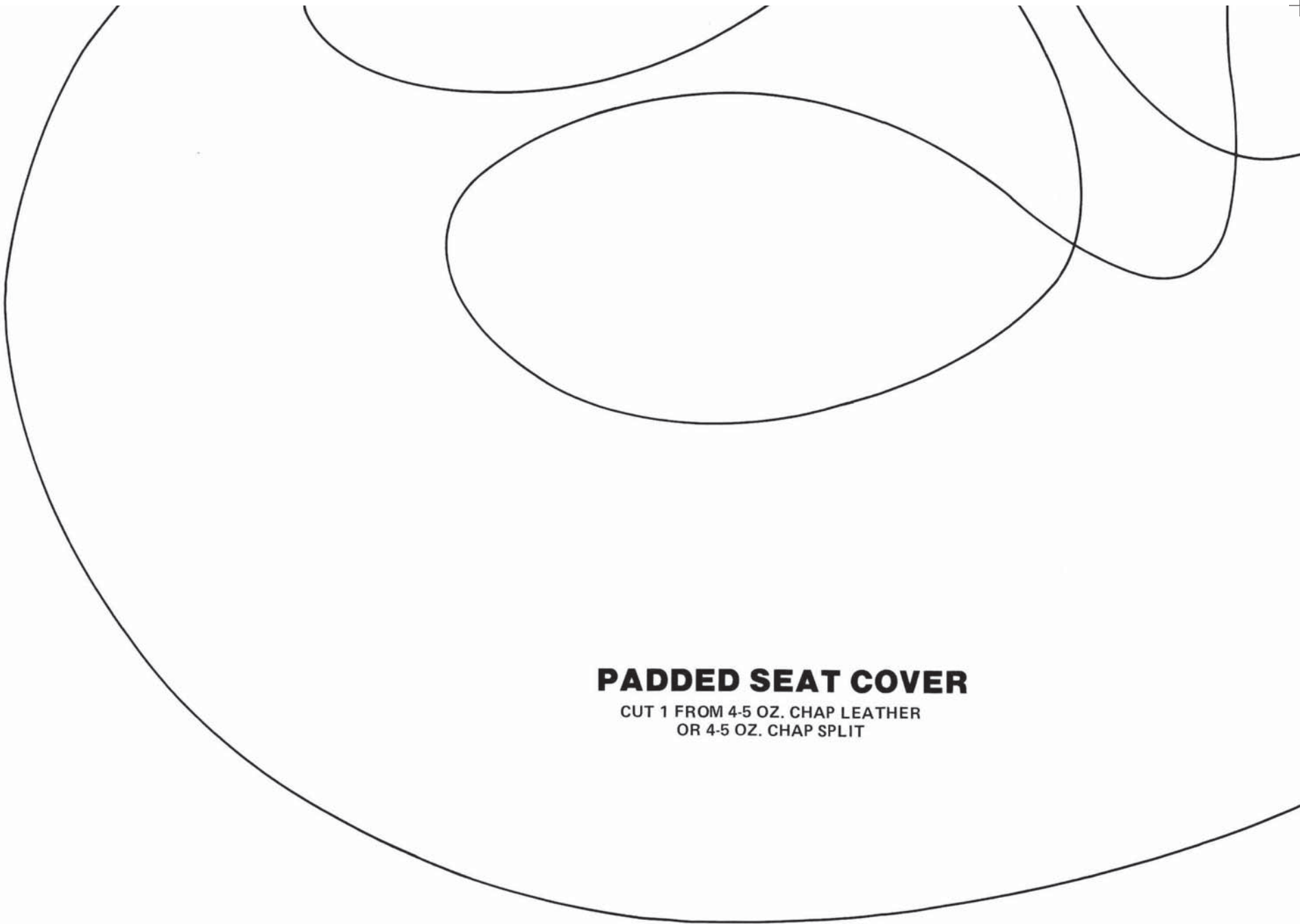




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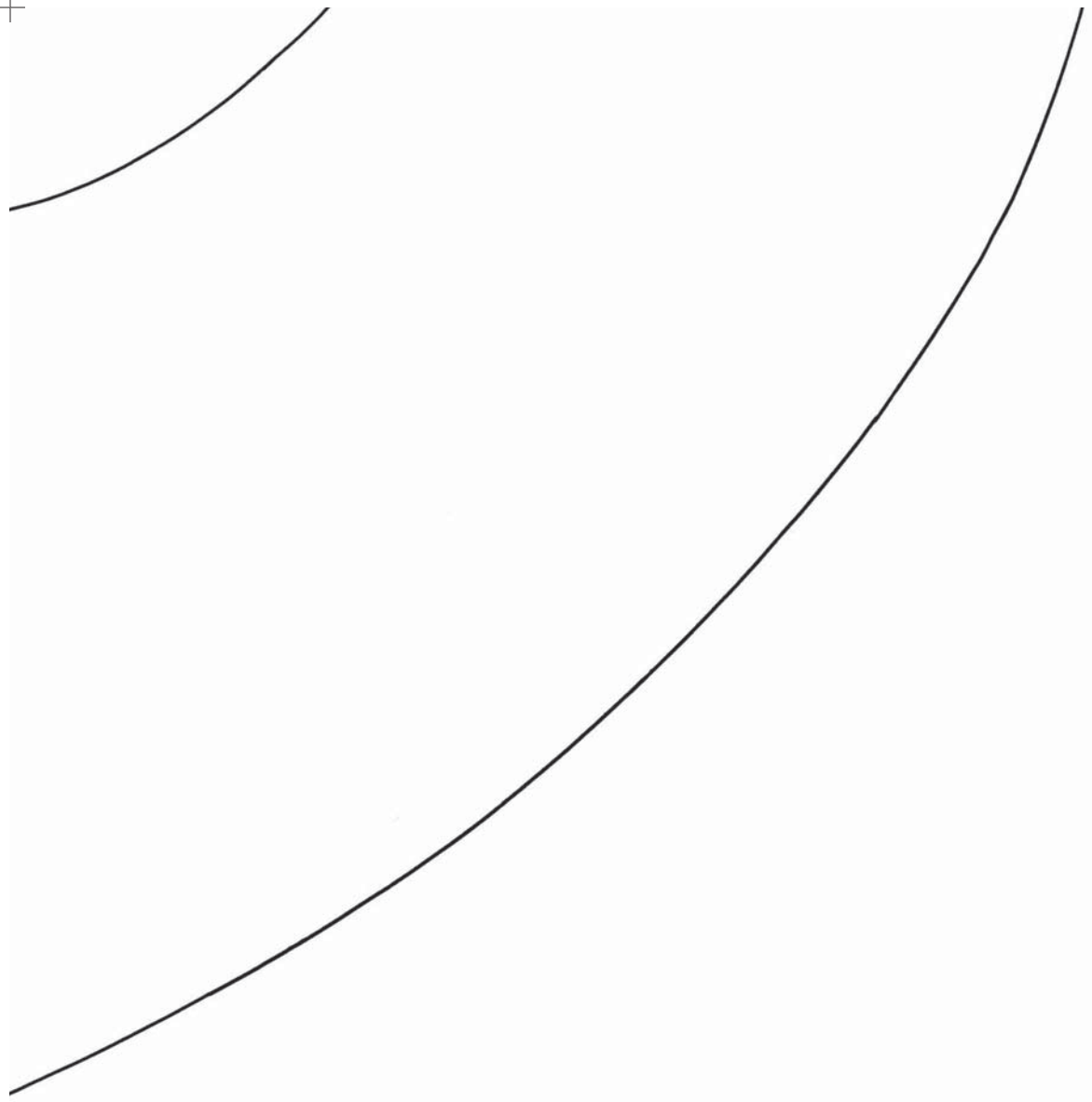






**PADDED SEAT COVER**

CUT 1 FROM 4-5 OZ. CHAP LEATHER  
OR 4-5 OZ. CHAP SPLIT



STOCK No. 4822



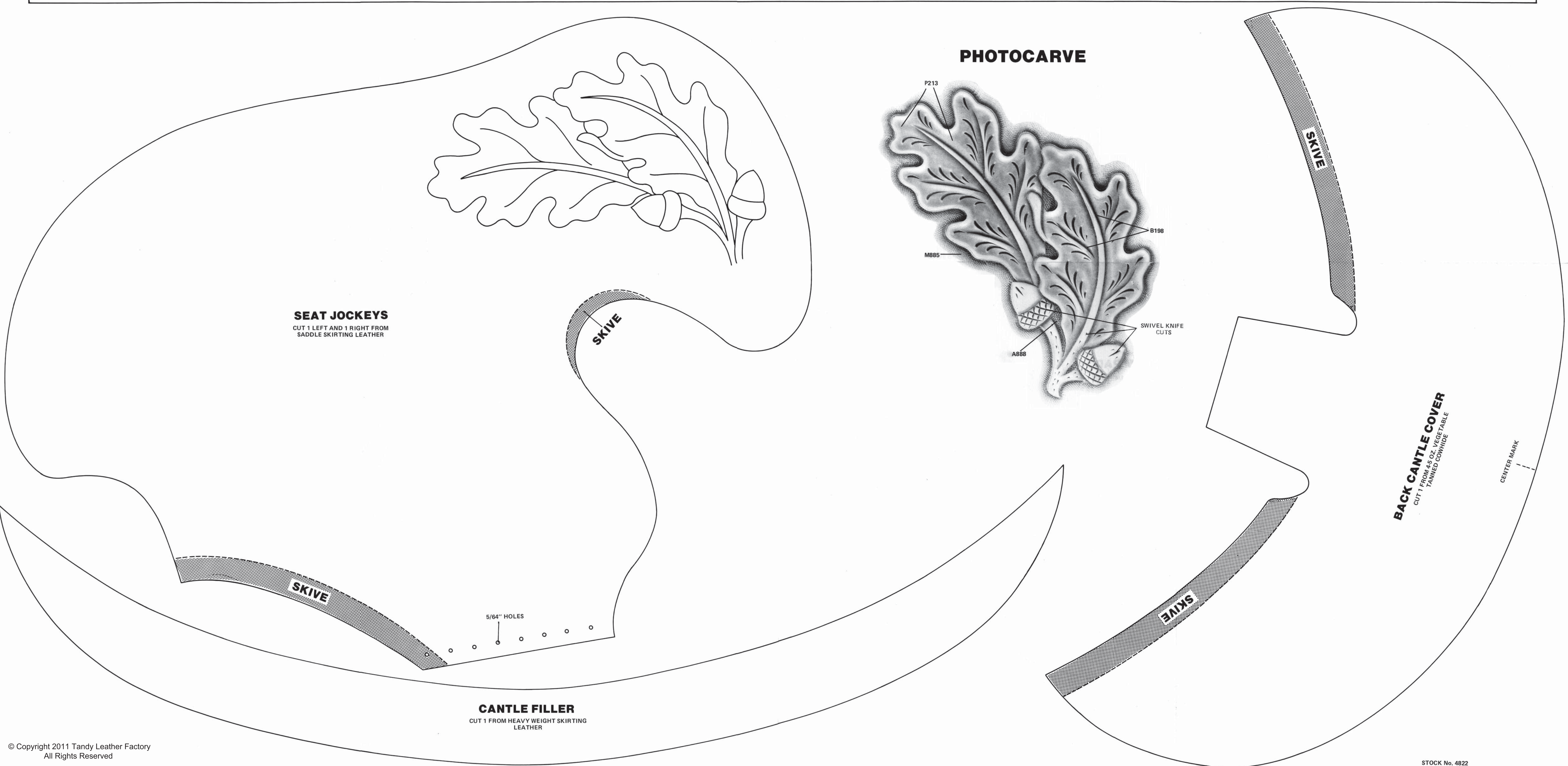
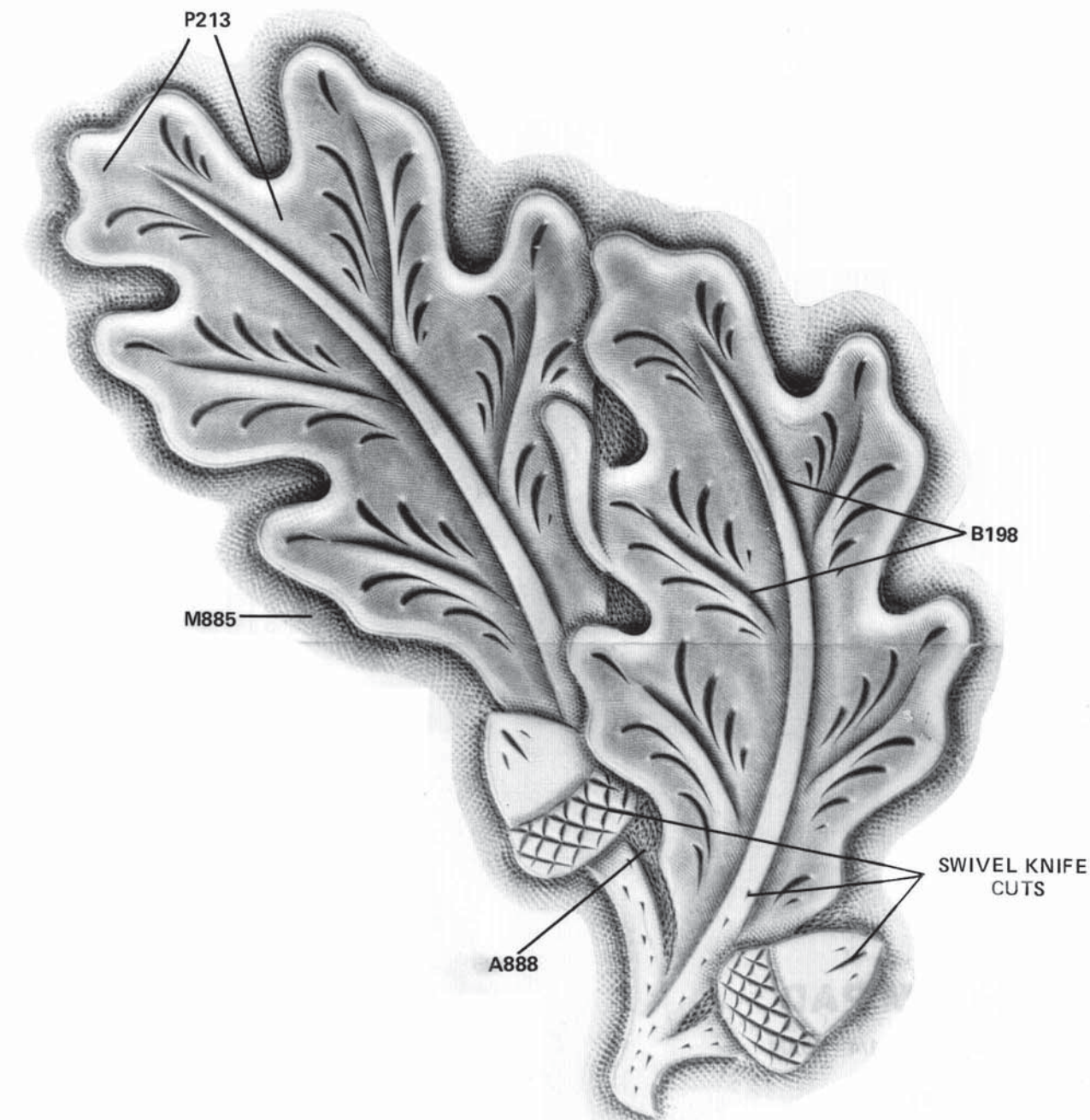
**CANTLE BINDING**  
 CUT 1 FROM 6-7 OZ. VEGETABLE  
 TANNED COWHIDE

**SEAT JOCKEYS**  
 CUT 1 LEFT AND 1 RIGHT FROM  
 SADDLE SKIRTING LEATHER

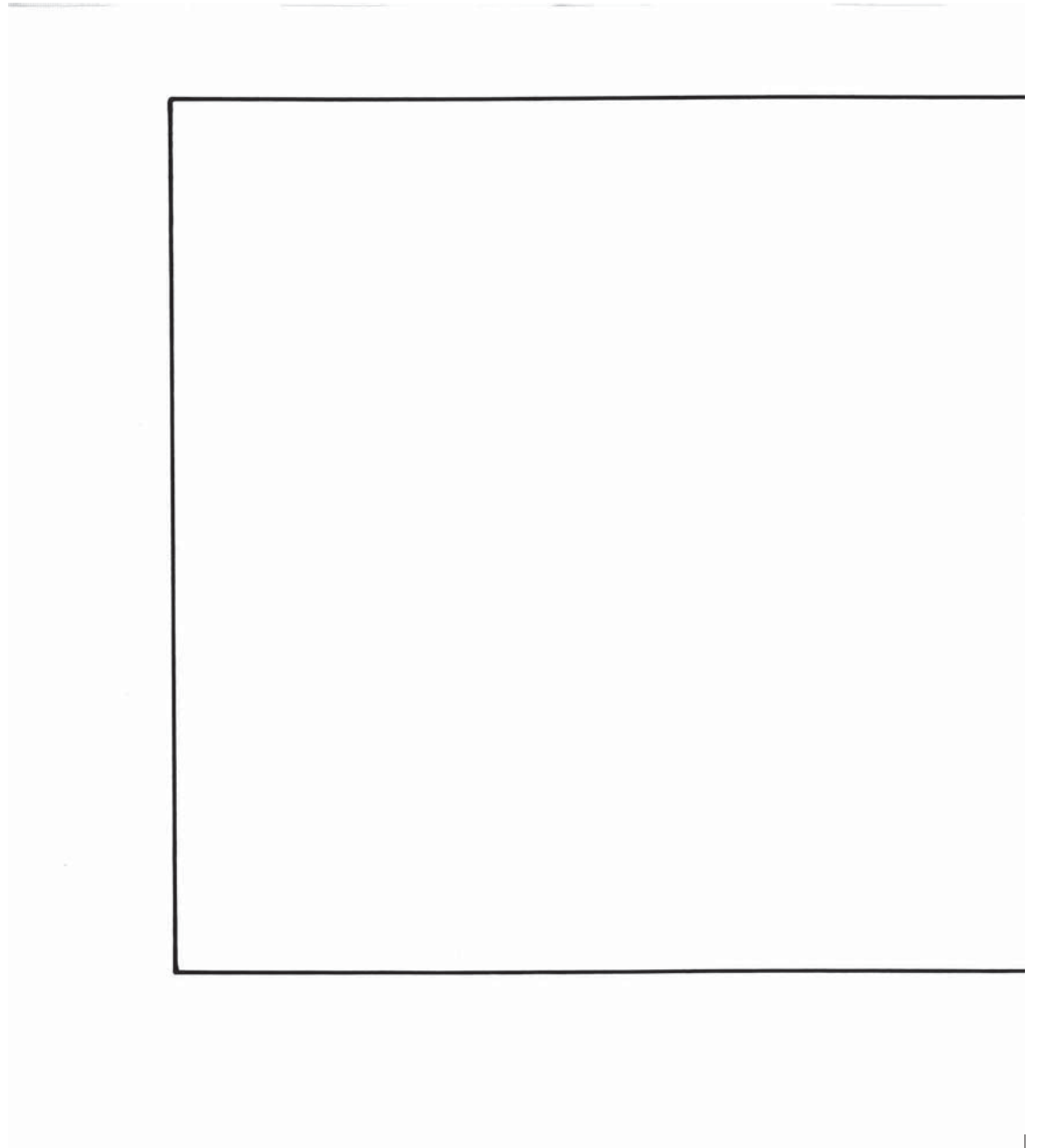
**PHOTOCARVE**

**BACK CANTLE COVER**  
 CUT 1 FROM 6-7 OZ. VEGETABLE  
 TANNED COWHIDE

**CANTLE FILLER**  
 CUT 1 FROM HEAVY WEIGHT SKIRTING  
 LEATHER









**CA**  
CU1

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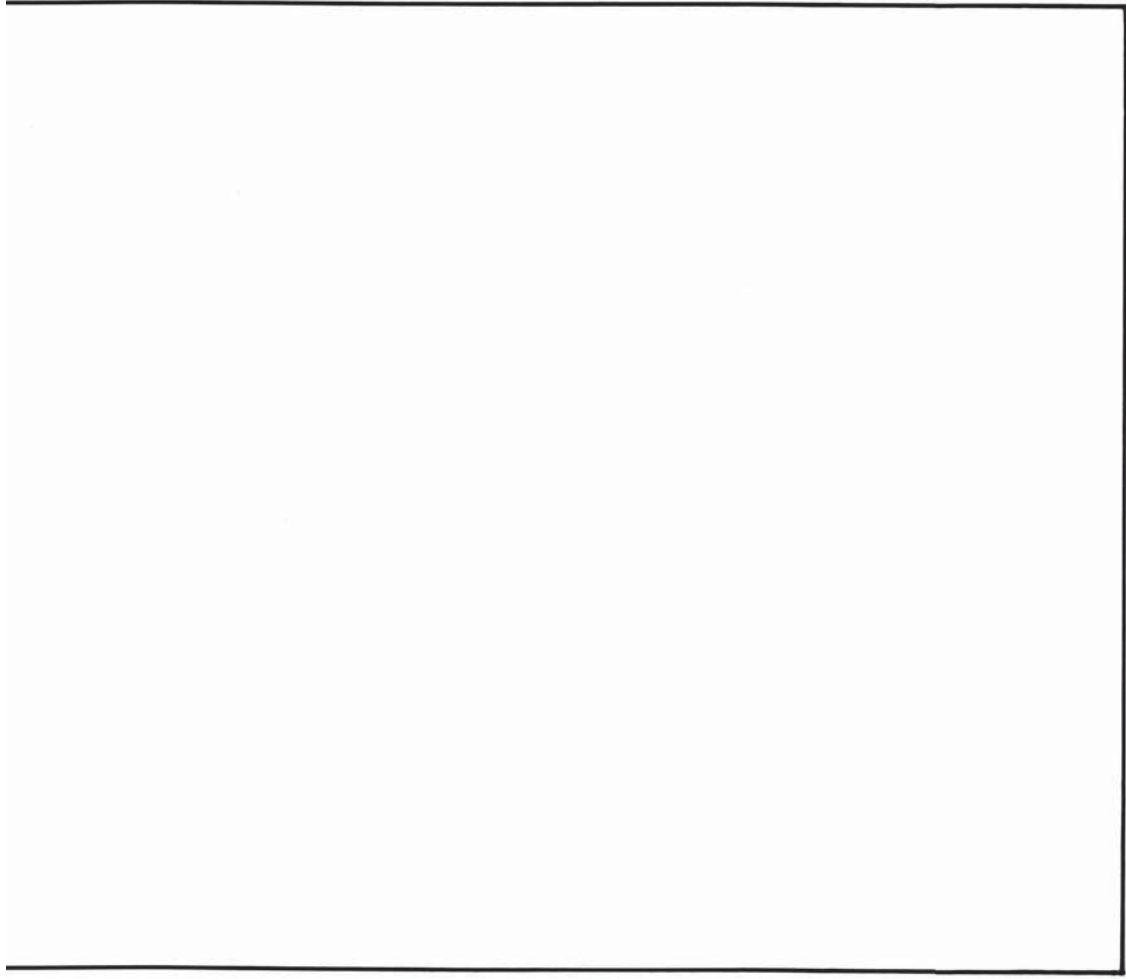
## **ANTLE BINDING**

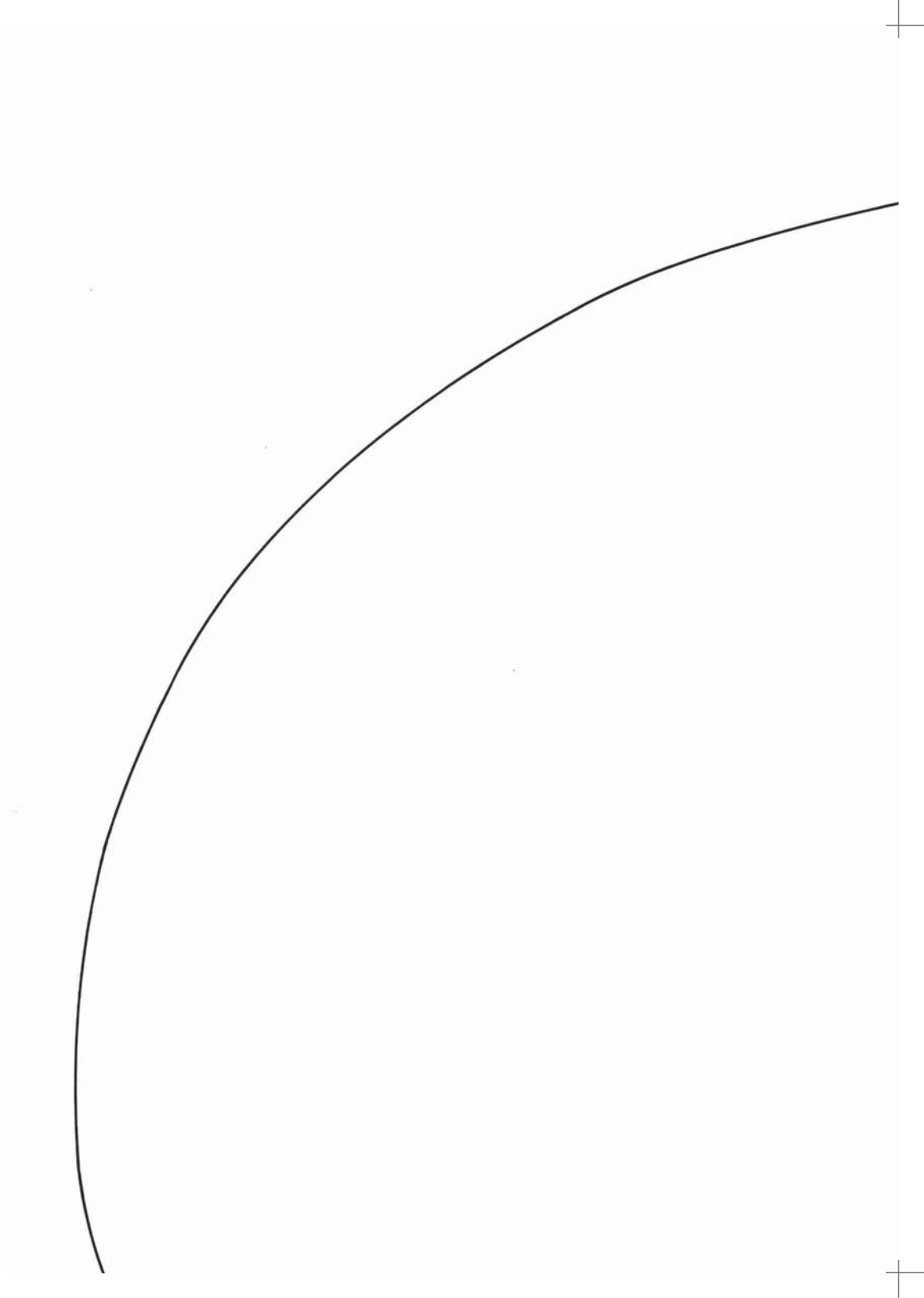
1 FROM 6-7 OZ. VEGETABLE  
TANNED COWHIDE

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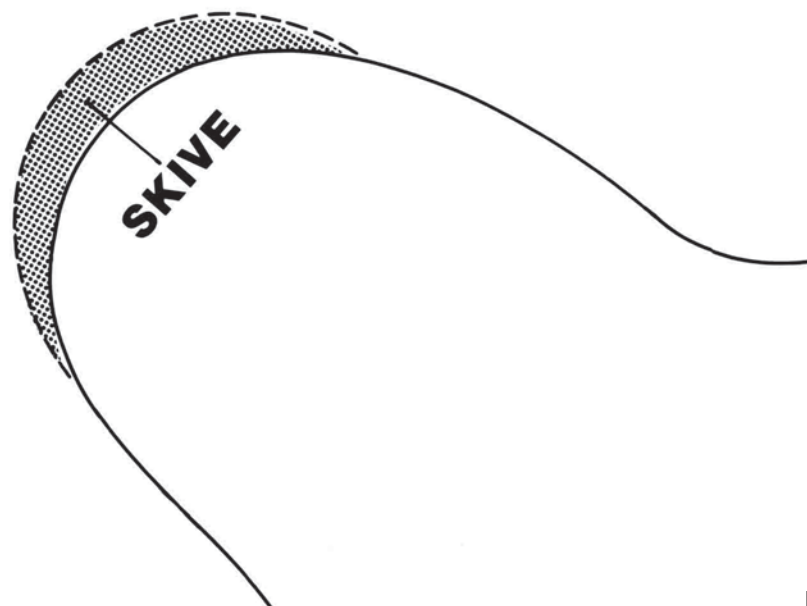




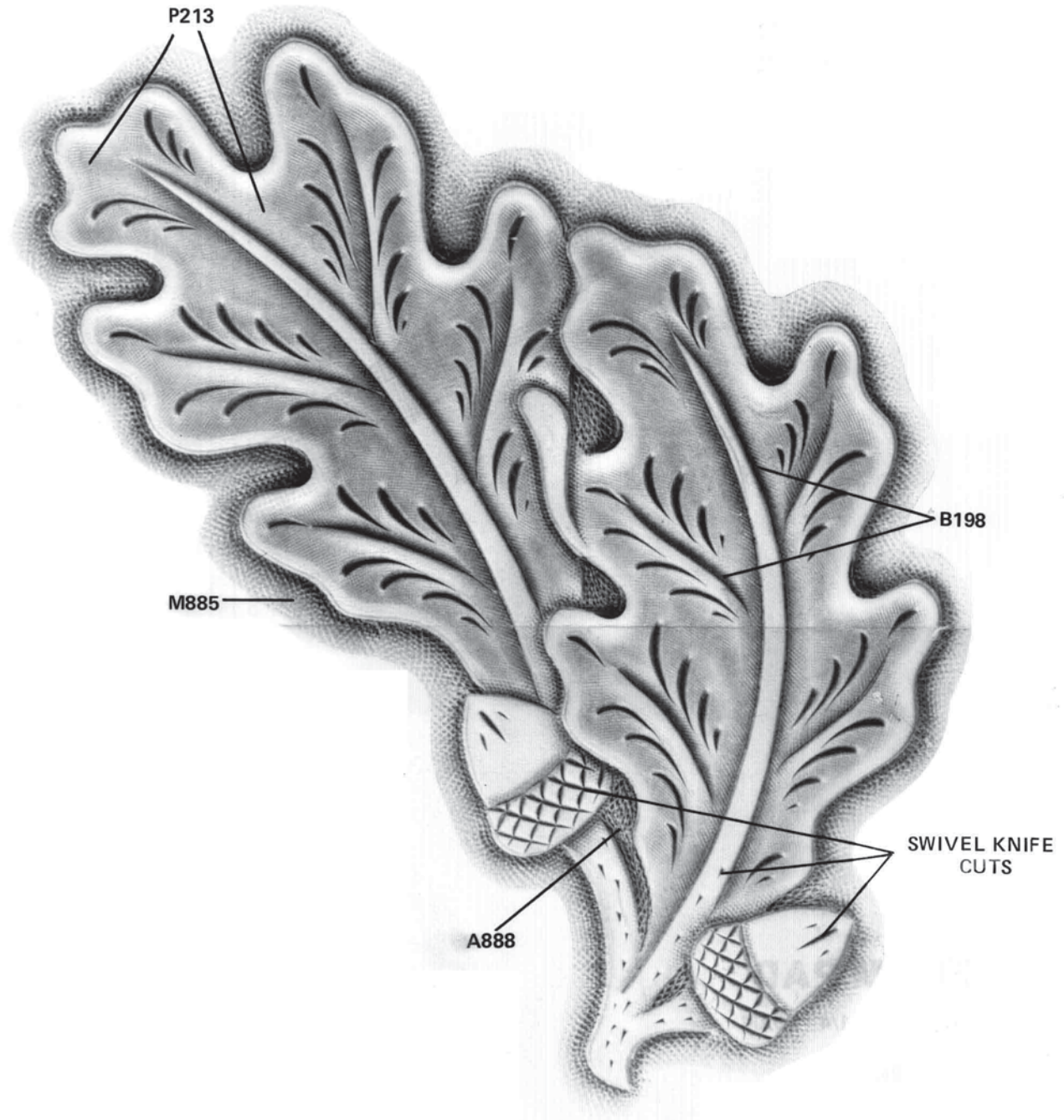


## **SEAT JOCKEYS**

CUT 1 LEFT AND 1 RIGHT FROM  
SADDLE SKIRTING LEATHER



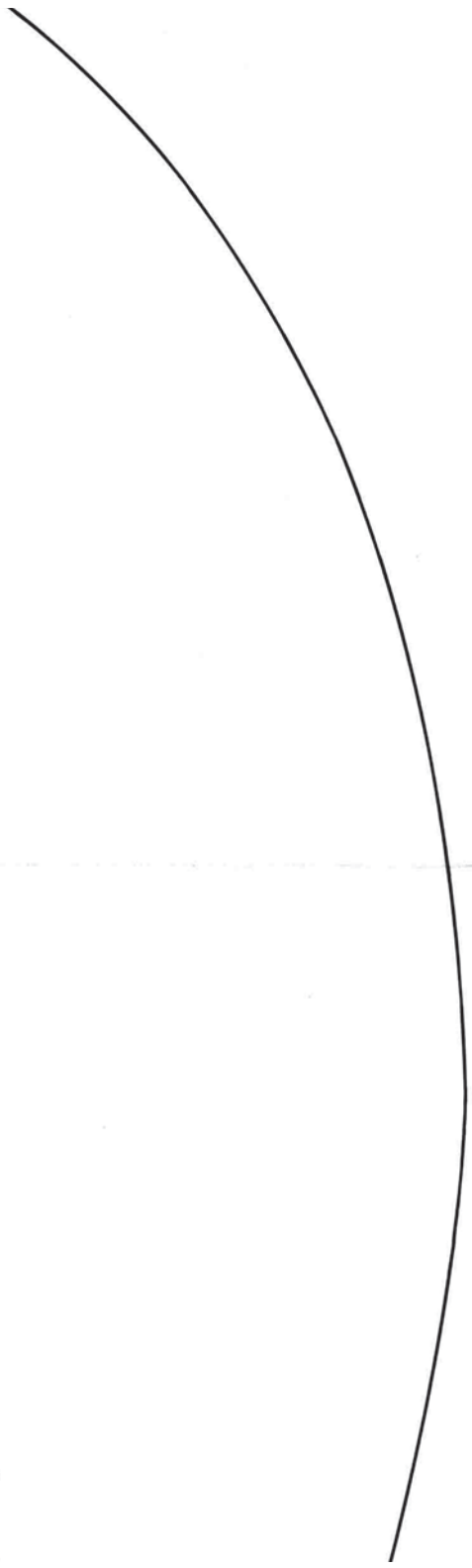
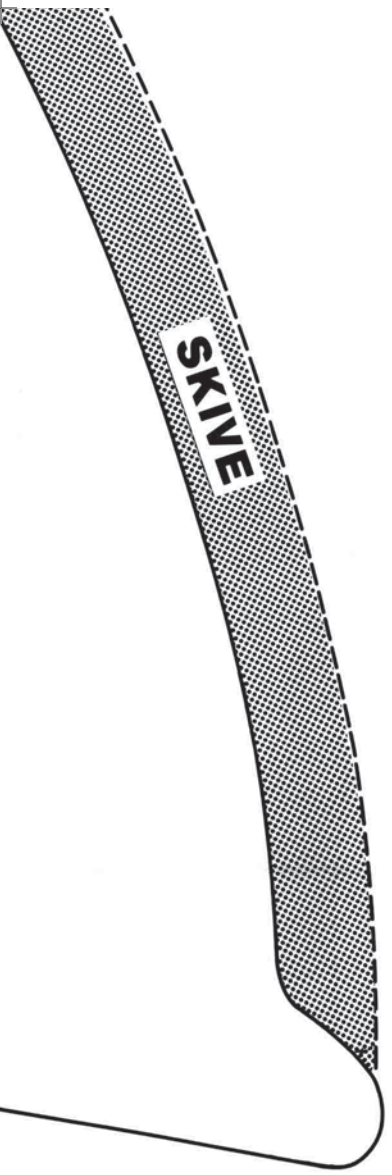
# PHOTOCARVE

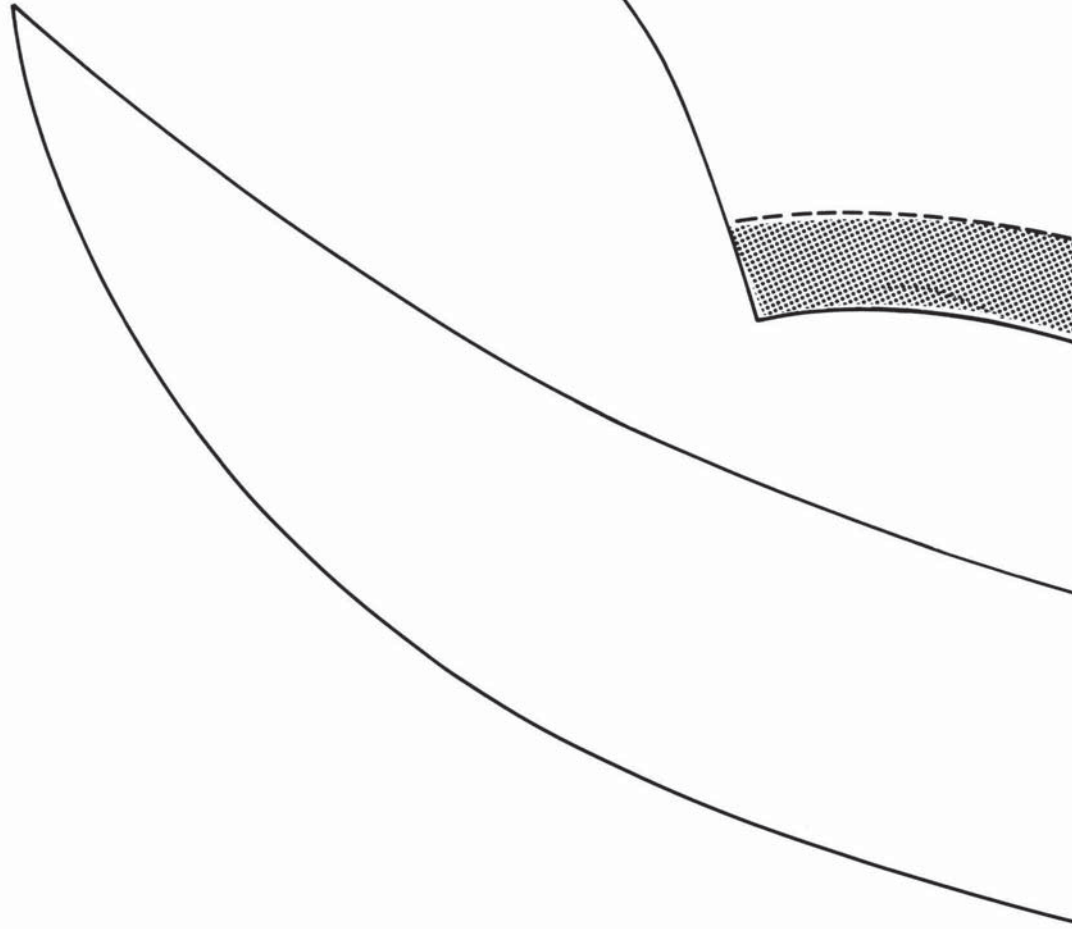




**SKIVE**

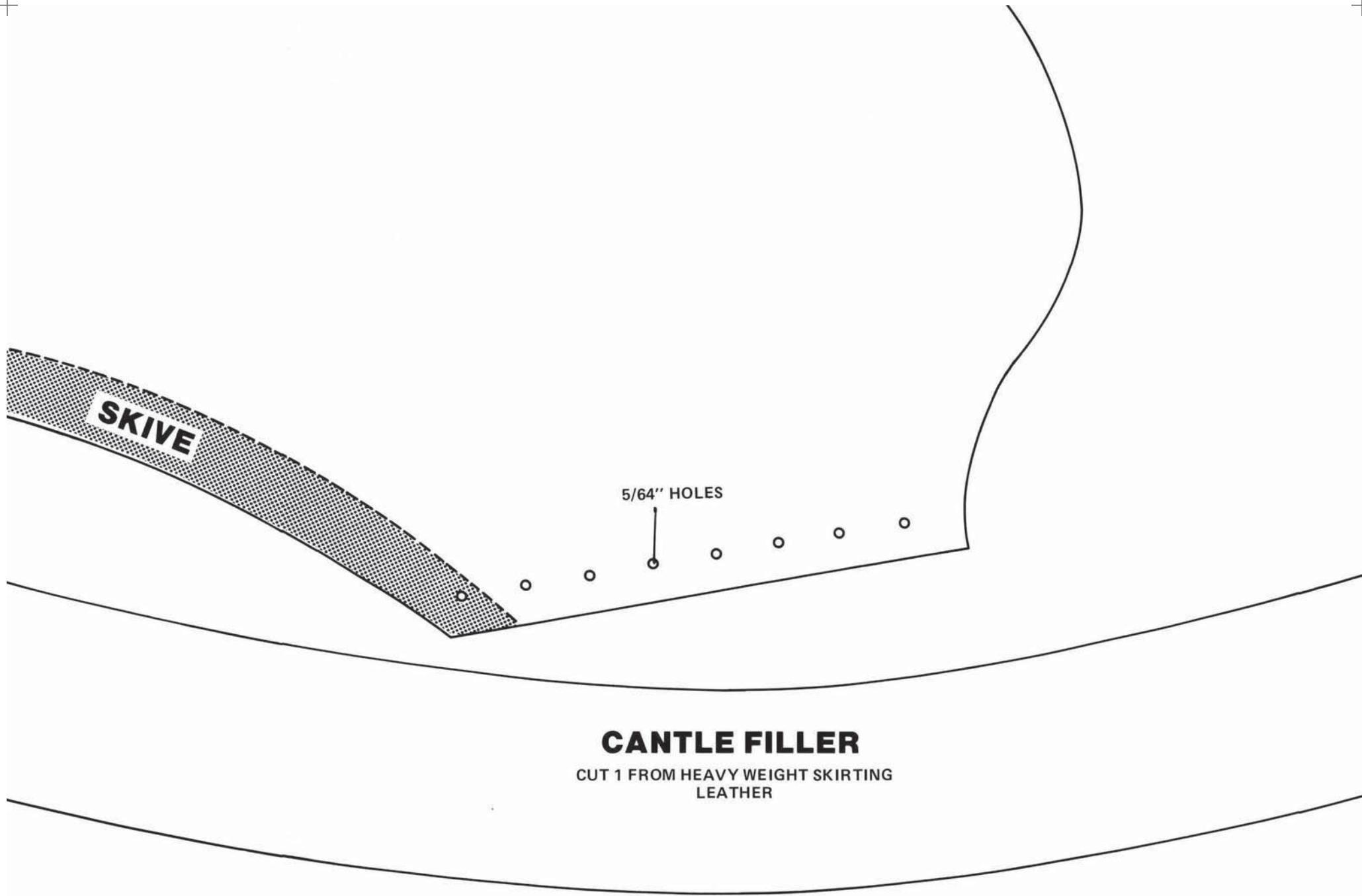
**COVER**  
ETABLE





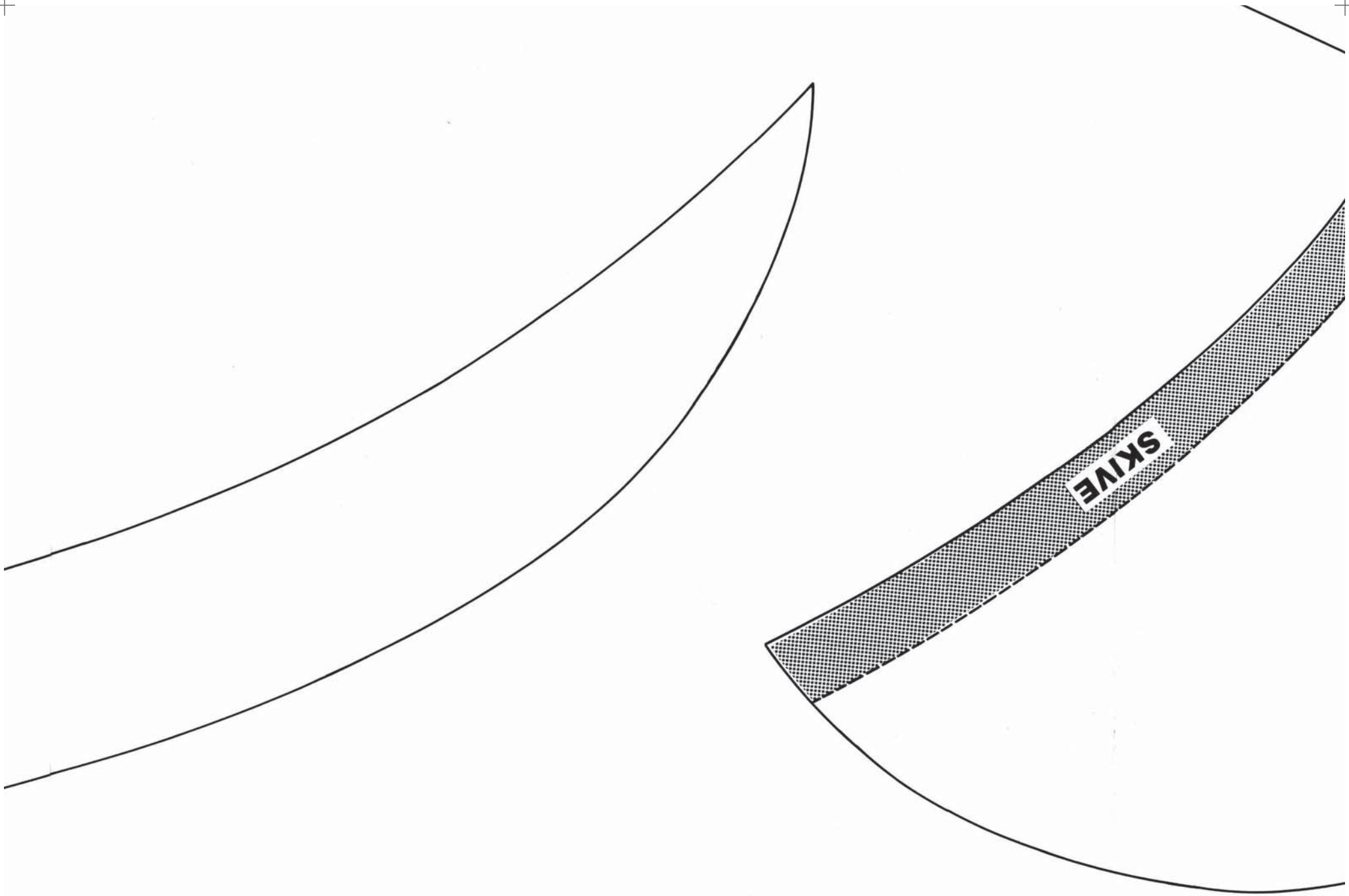
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**CANTLE FILLER**

CUT 1 FROM HEAVY WEIGHT SKIRTING  
LEATHER







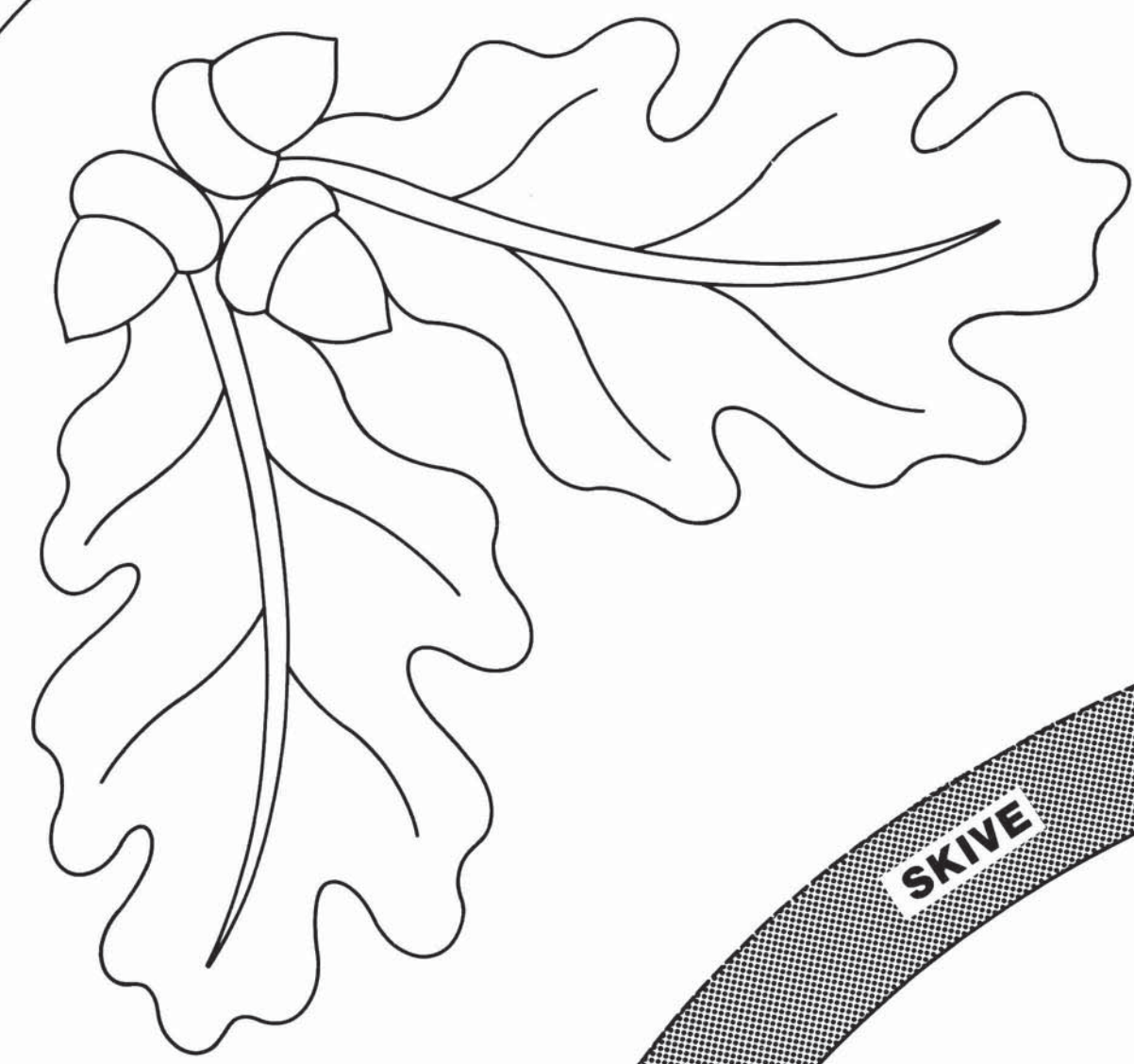
**BACK CANTLE**  
CUT 1 FROM 4-5 OZ. VEG  
TANNED COWHIDE

CENTER MARK



STOCK No. 4822





**BACK JOCKEYS**  
CUT 1 LEFT AND 1 RIGHT  
FROM SADDLE SKIRTING LEATHER

**BACK BAR POCKETS**  
CUT 1 LEFT AND 1 RIGHT FROM  
4.5 OZ. VEGETABLE TANNED COWHIDE

**SKIVE**

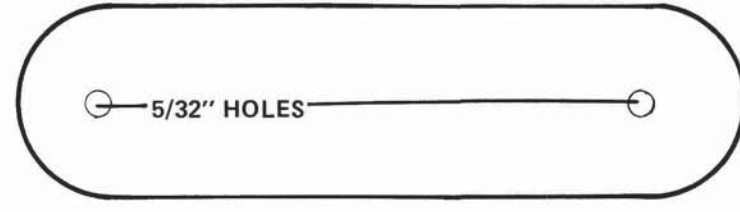
**SKIVE**

**SKIVE**

**SKIVE**

**FRONT JOCKEYS**  
CUT 1 LEFT AND 1 RIGHT  
FROM SADDLE SKIRTING LEATHER

**BACK JOCKEYS  
CONNECTOR**  
CUT 1 FROM 4.5 OZ. VEGETABLE TANNED  
COWHIDE



**DEE HOLDER**  
CUT 2 FROM RAWHIDE

**SKIVE**

5/32" HOLE

**SKIRTS AND SKIRT LINING**  
CUT 1 LEFT AND 1 RIGHT FROM  
SADDLE SKIRTING LEATHER

NOTE: CUT FLEECE LINING SLIGHTLY  
OVERSIZED

POSITION FOR BAR  
POCKETS

1/4" HOLES

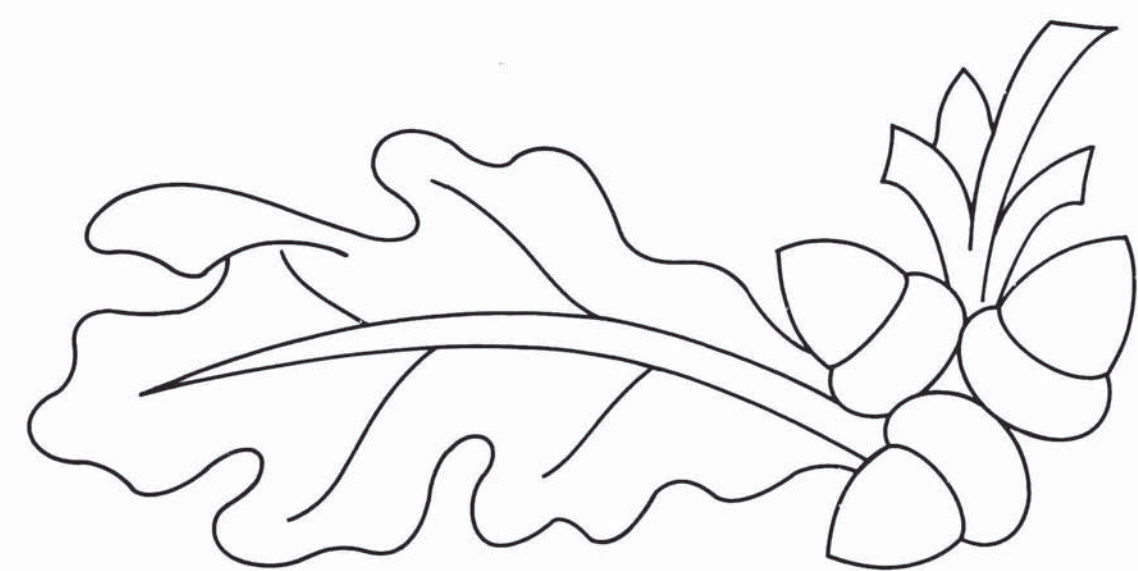
POSITION FOR  
FRONT JOCKEY

POSITION FOR SKIRT SUPPORTS

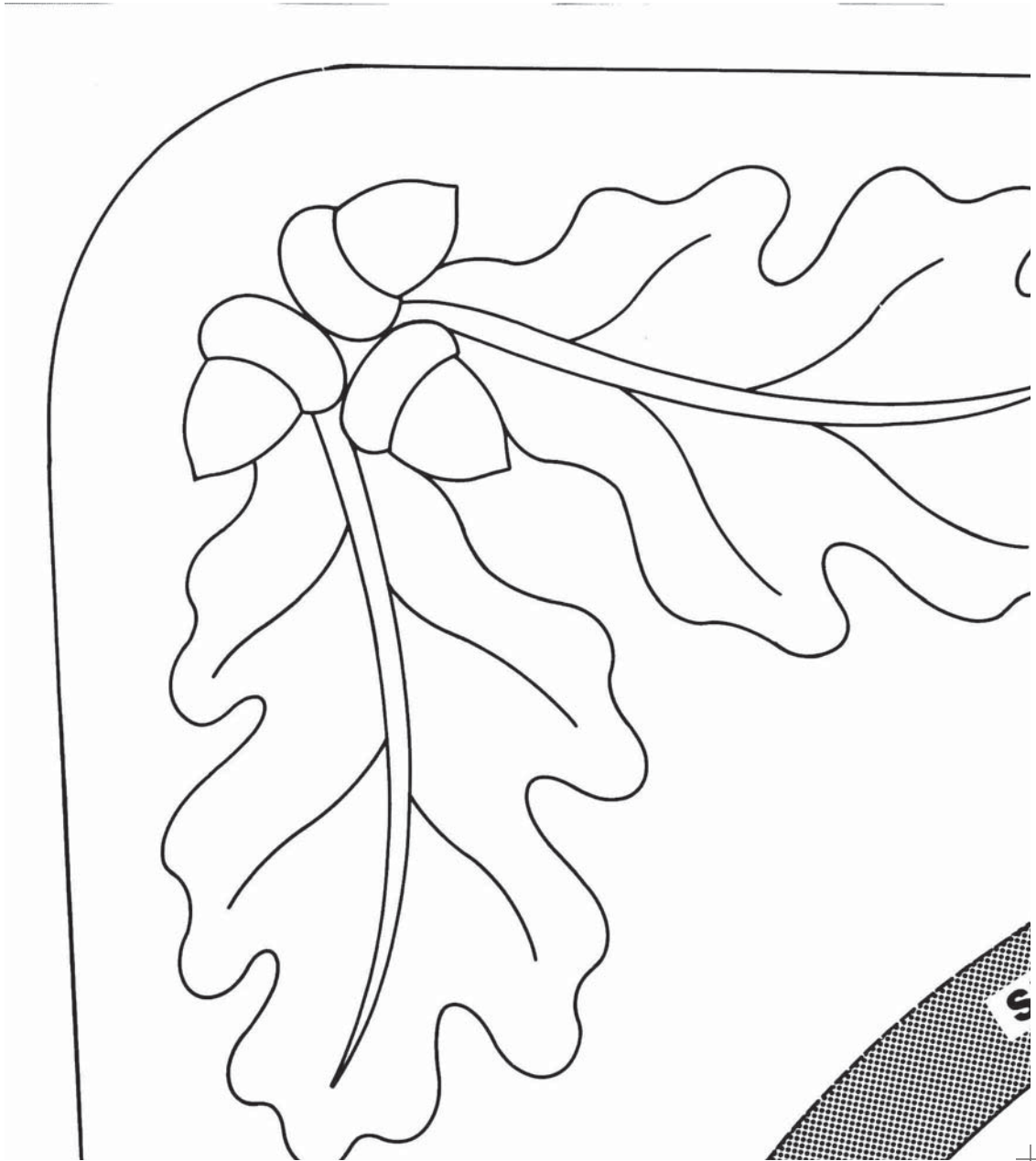
**SKIRT SUPPORTS**  
CUT 1 LEFT AND 1 RIGHT FROM  
SADDLE SKIRTING LEATHER

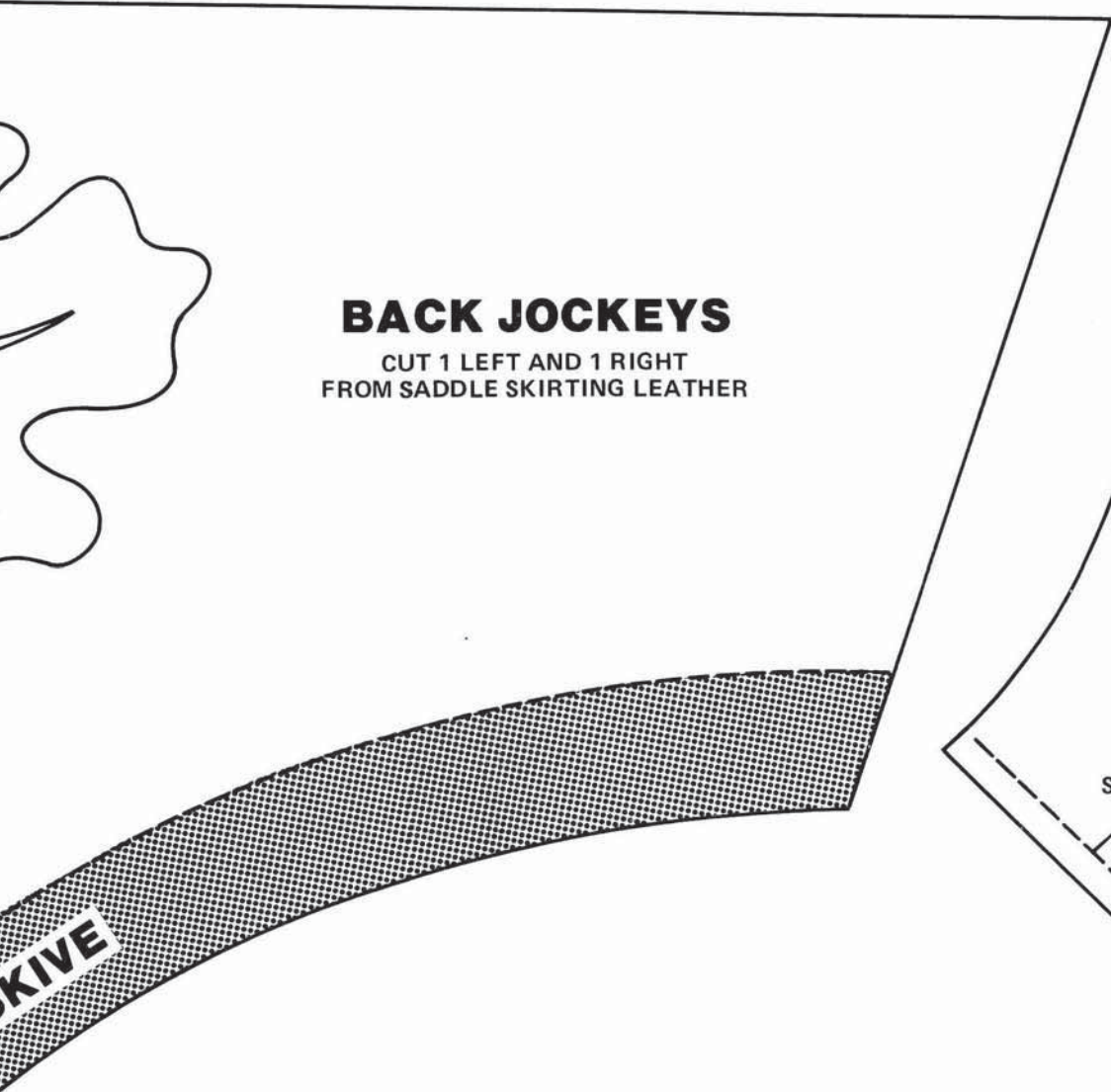
**SKIVE**

**SKIVE**



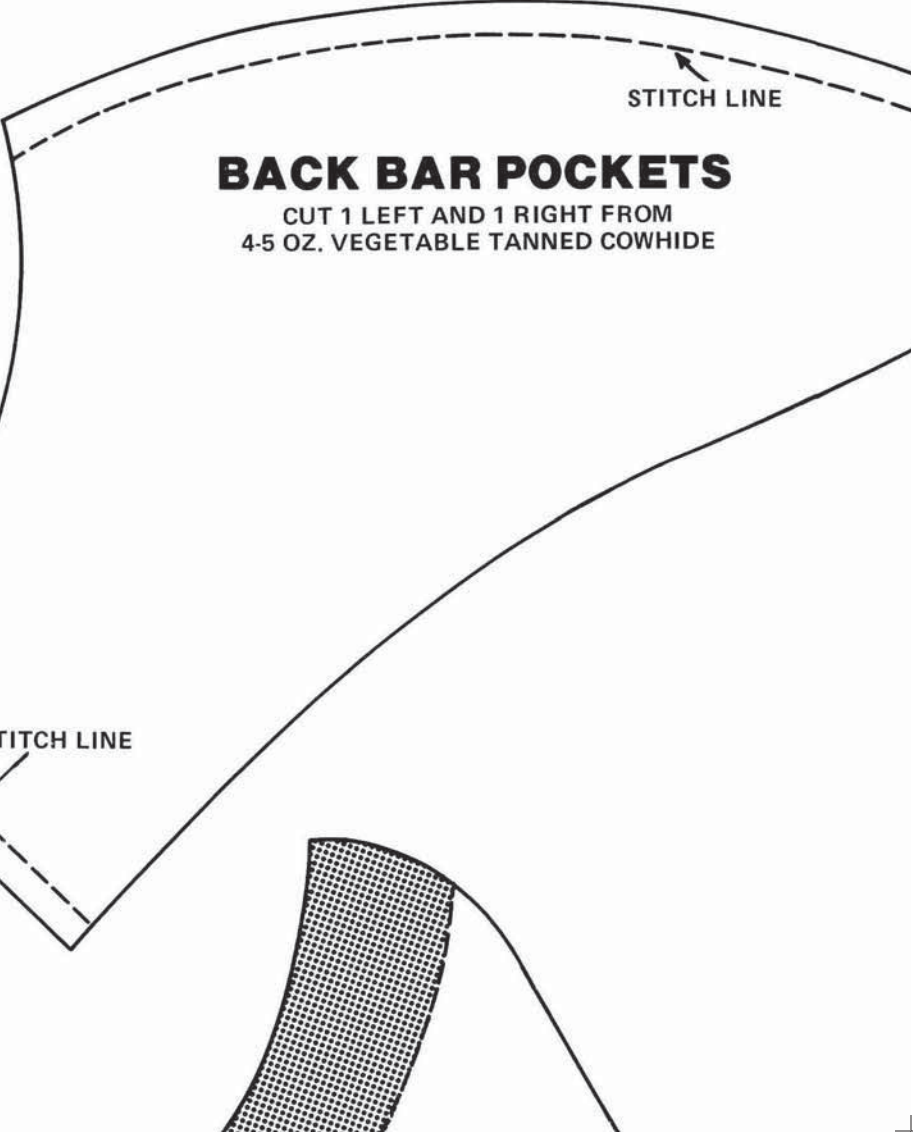






**BACK JOCKEYS**

CUT 1 LEFT AND 1 RIGHT FROM SADDLE SKIRTING LEATHER



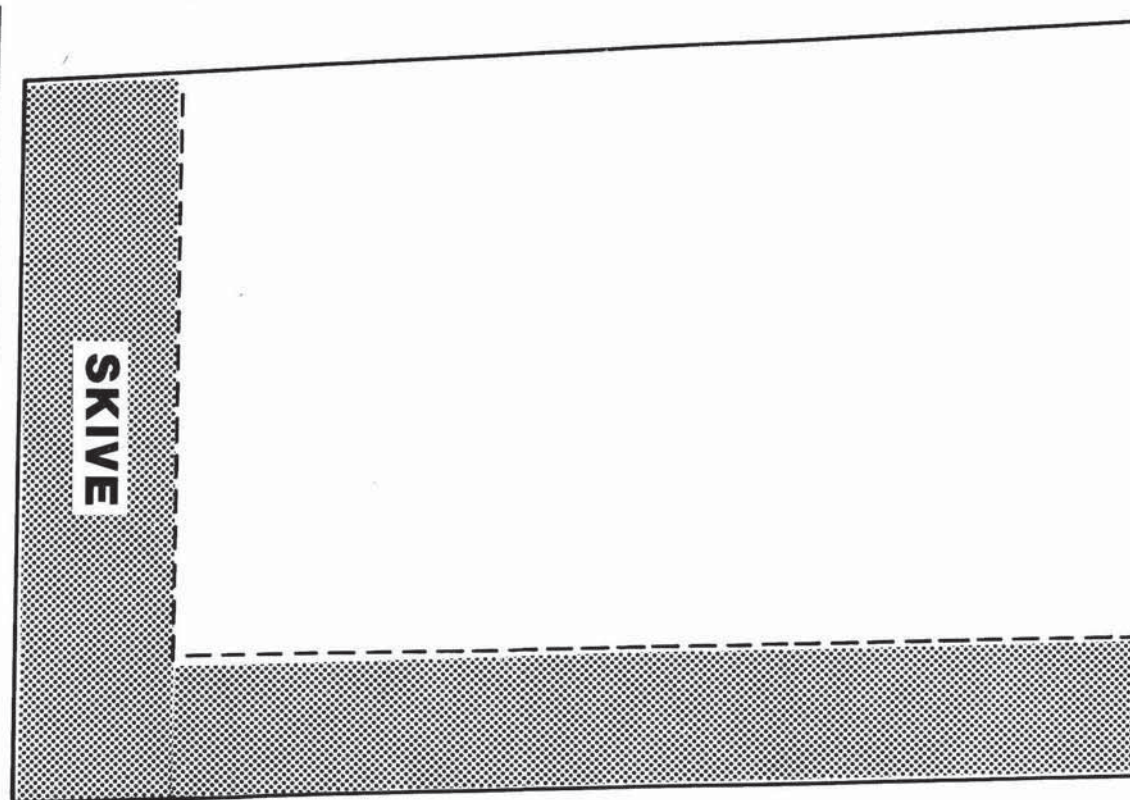
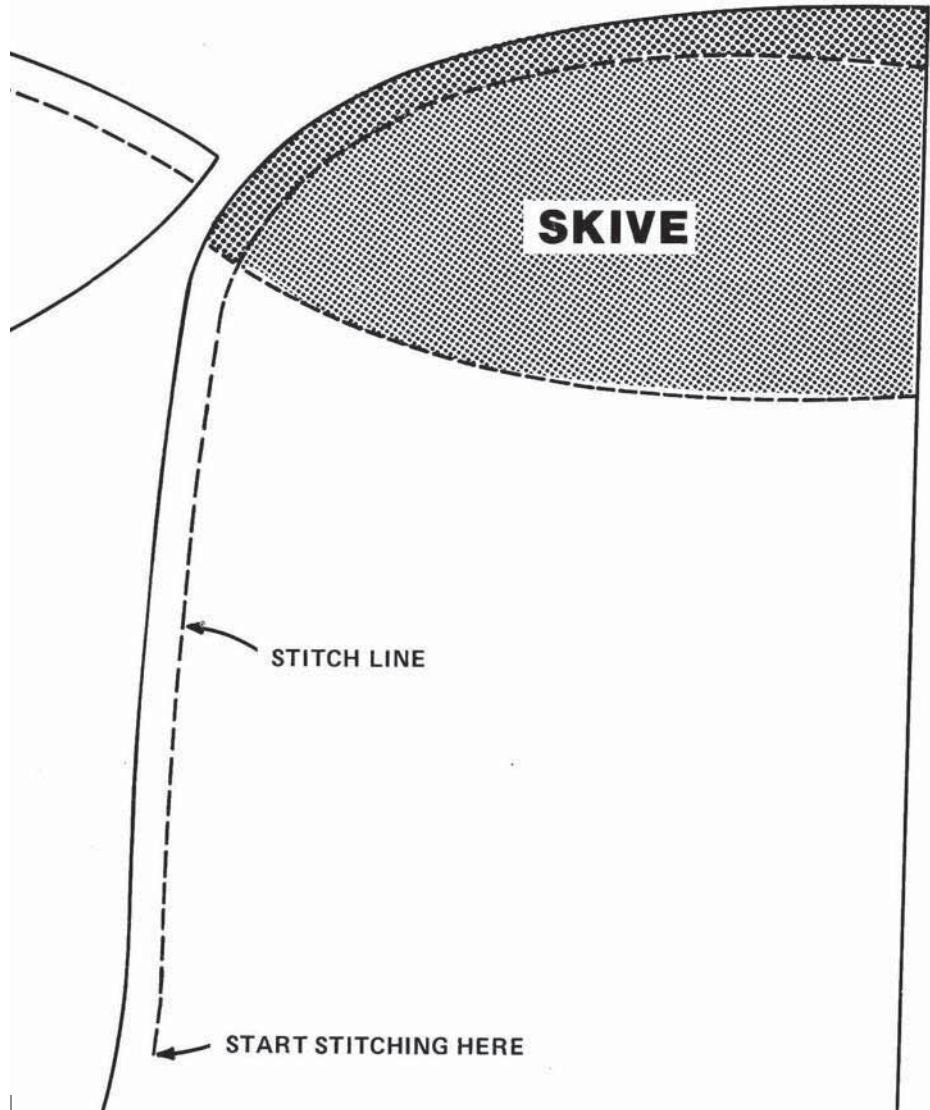
**BACK BAR POCKETS**

CUT 1 LEFT AND 1 RIGHT FROM 4-5 OZ. VEGETABLE TANNED COWHIDE

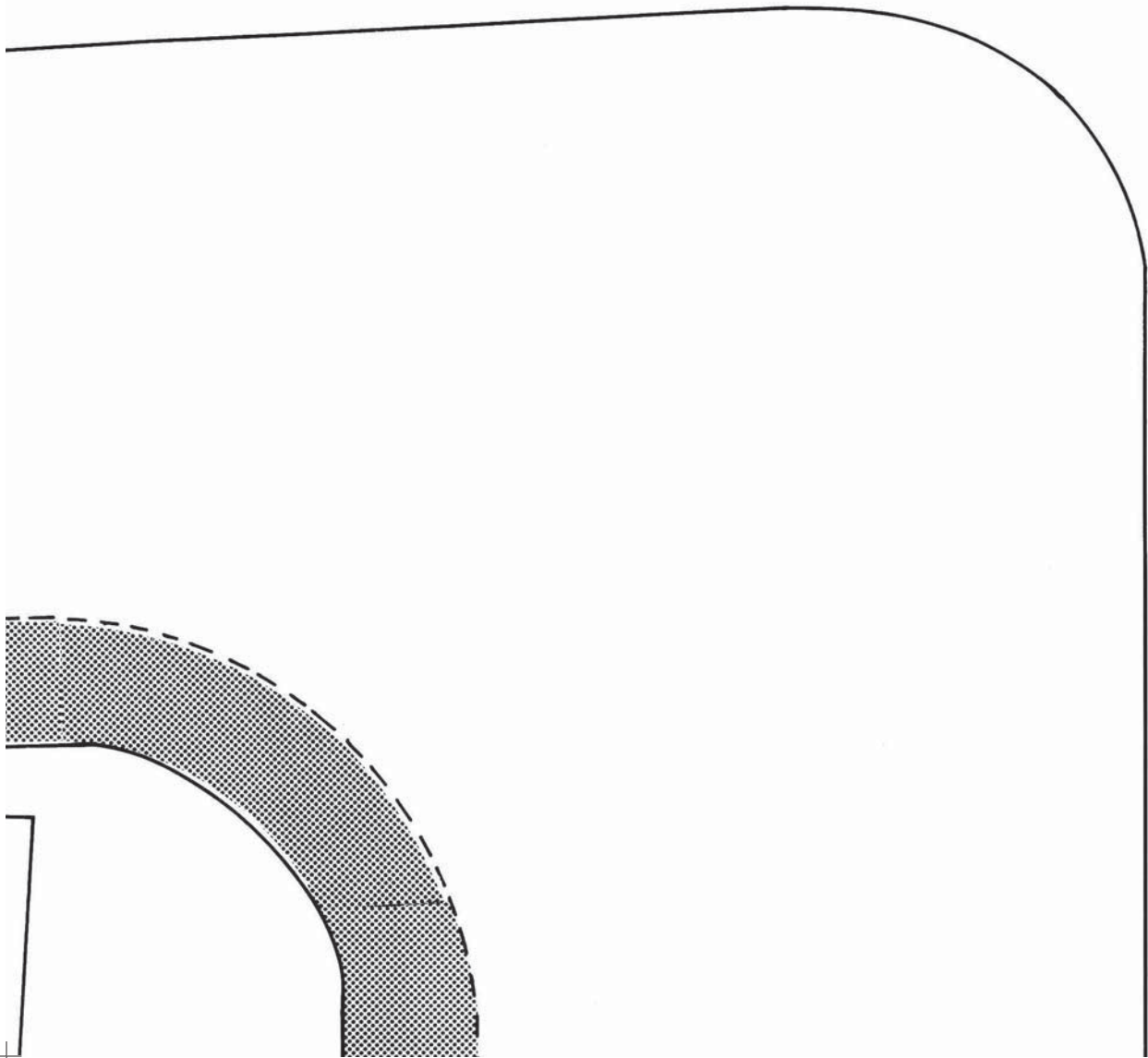
STITCH LINE

STITCH LINE

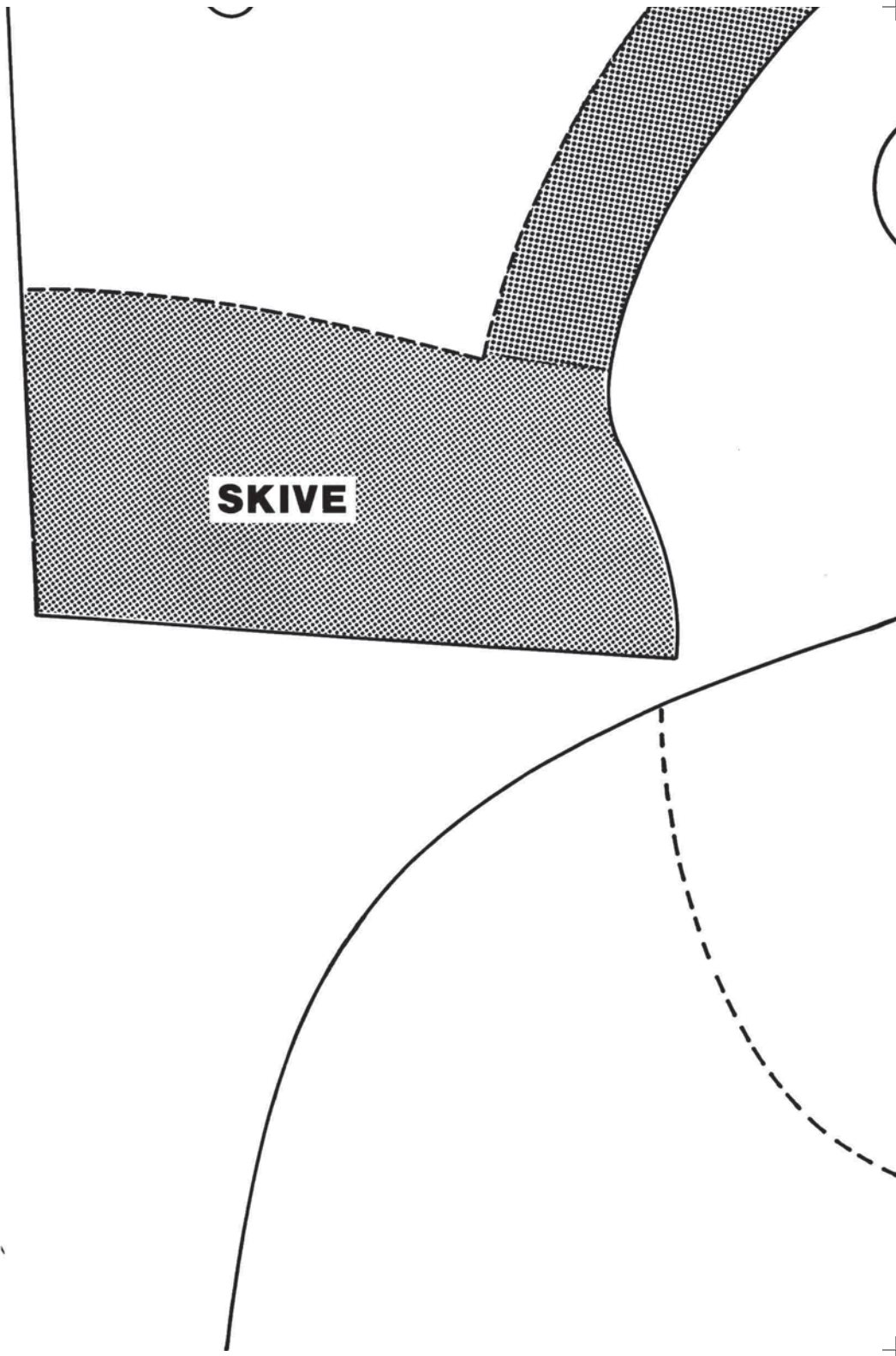


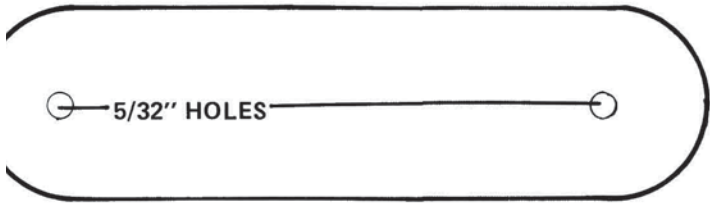


**BACK JOCKEYS  
CONNECTOR**



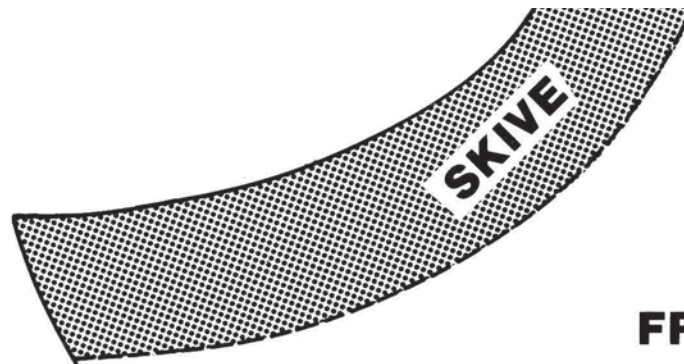






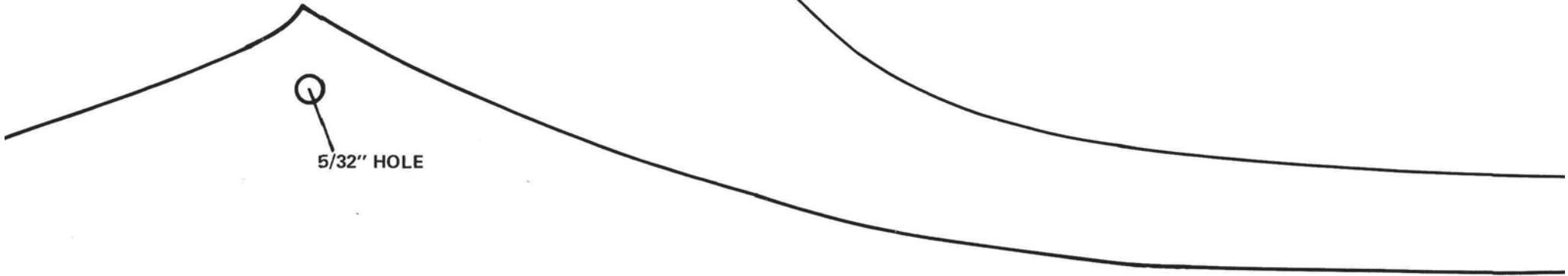
## DEE HOLDER

CUT 2 FROM RAWHIDE



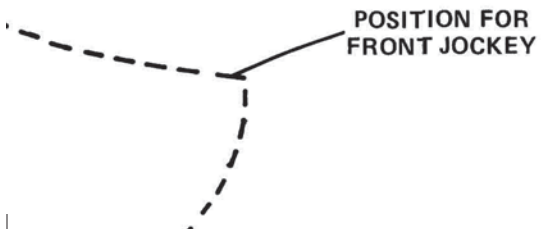
## FRONT JOCKEYS

CUT 1 LEFT AND 1 RIGHT  
FROM SADDLE SKIRTING LEATHER



## SKIRTS AND SKIRT

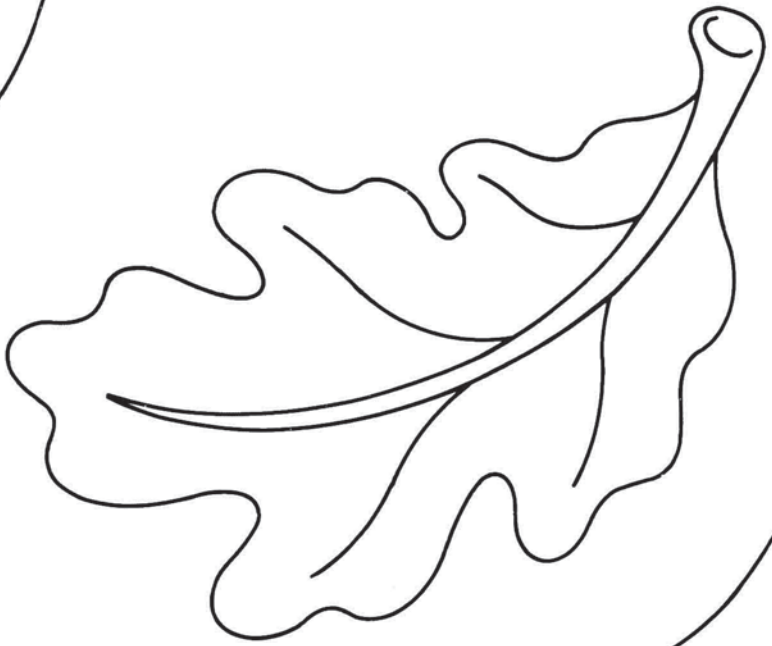
CUT 1 LEFT AND 1 RIGHT  
SADDLE SKIRTING LEATH



NOTE: CUT FLEECE LINING SLIGHTLY  
OVERSIZED

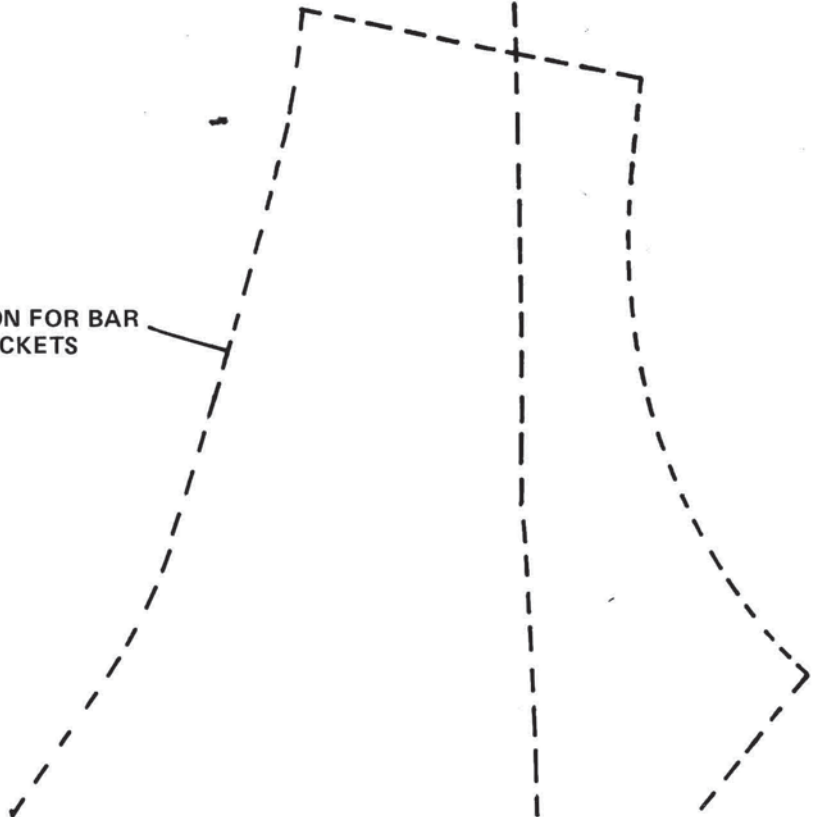


**CONNECTOR**  
CUT 1 FROM 4.5 OZ. VEGETABLE TANNED  
COWHIDE



1/4" HOLES

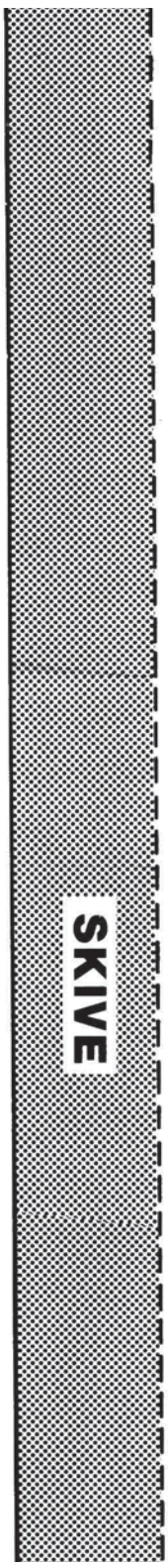
POSITION FOR BAR  
POCKETS



**LINING**

FROM  
HER

ITLY



**SKIVE**

**SKIRT SUPPORTS**

CUT 1 LEFT AND 1 RIGHT FROM  
SADDLE SKIRTING LEATHER

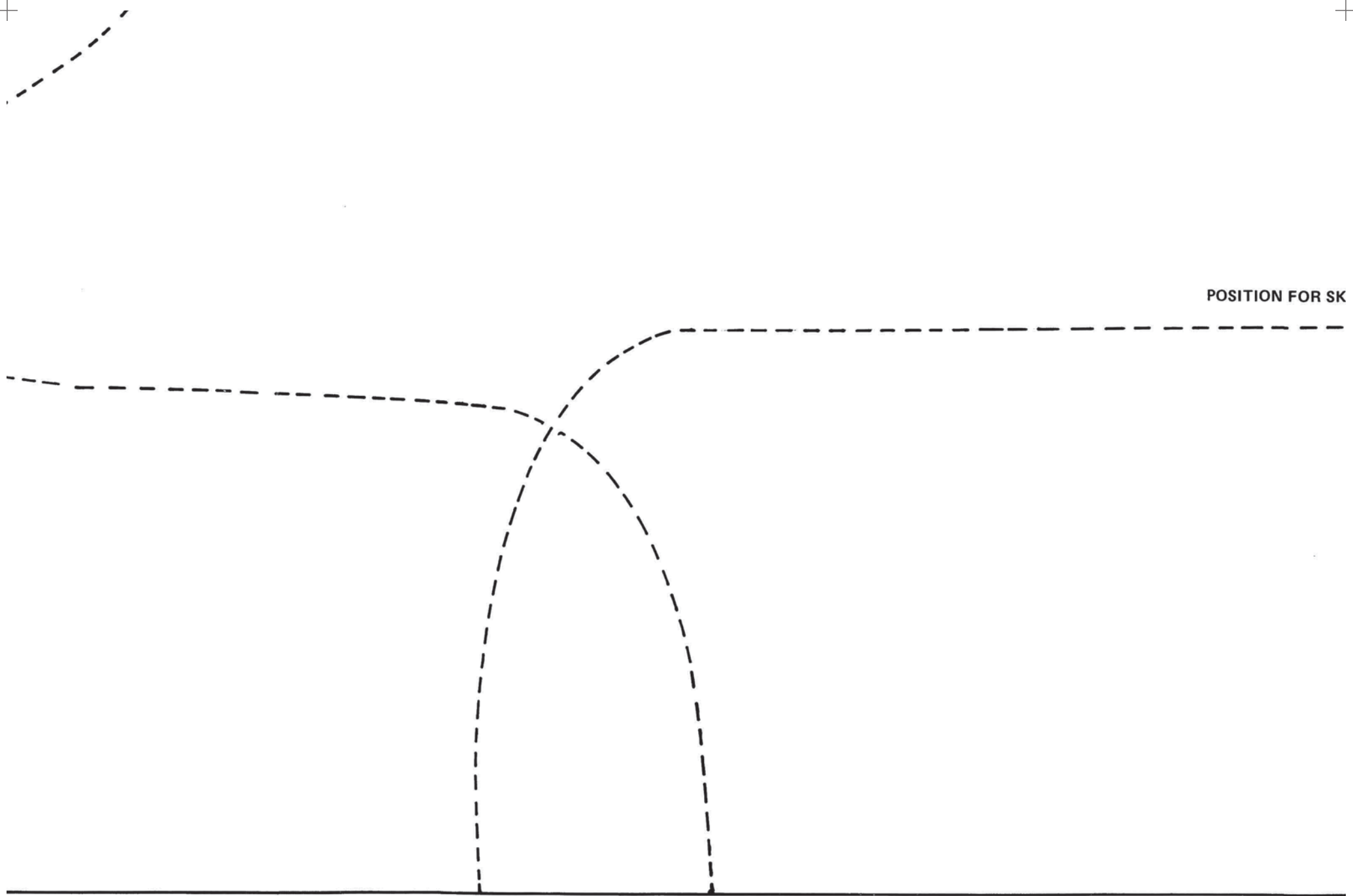






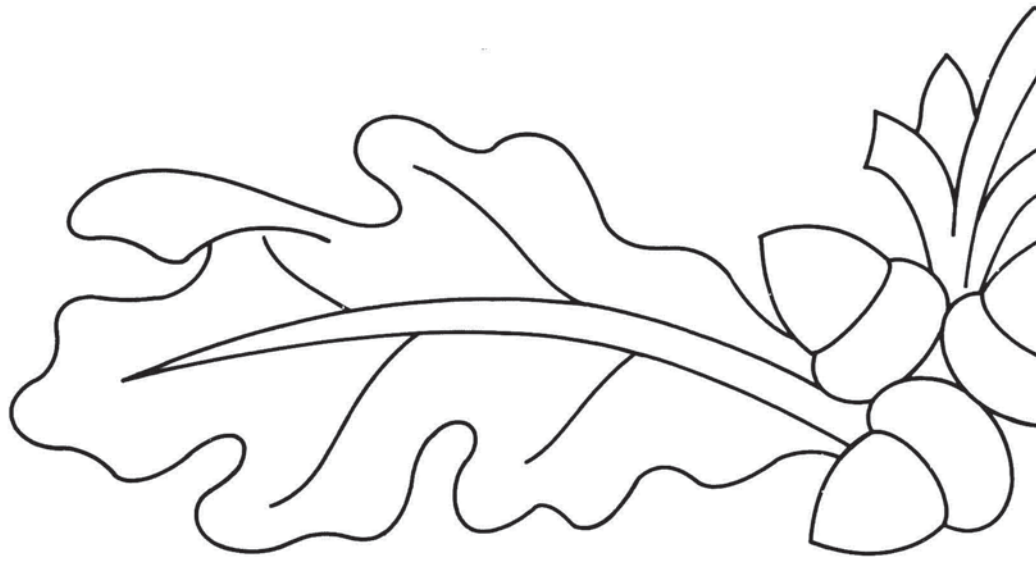
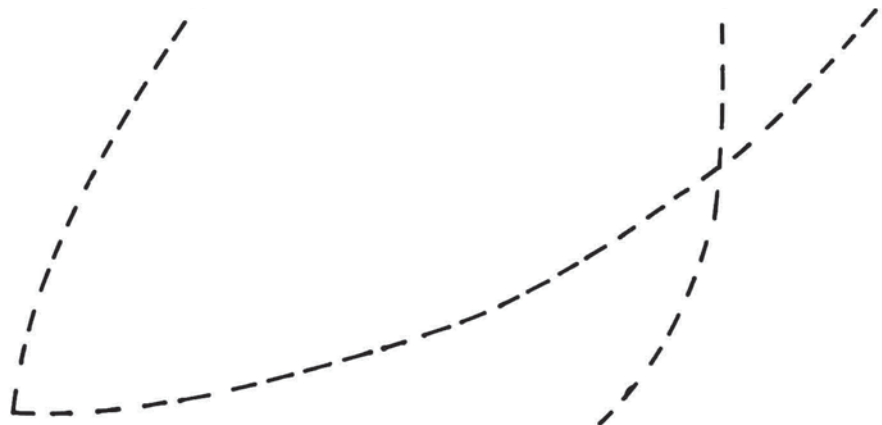
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POSITION FOR SK

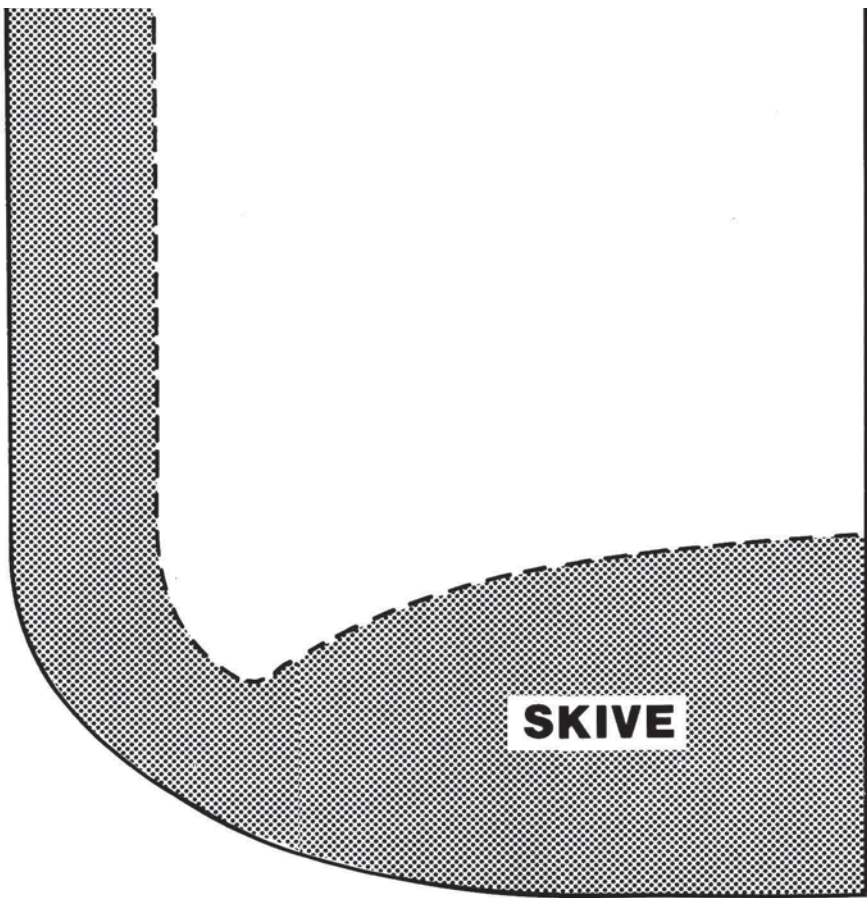




IRT SUPPORTS



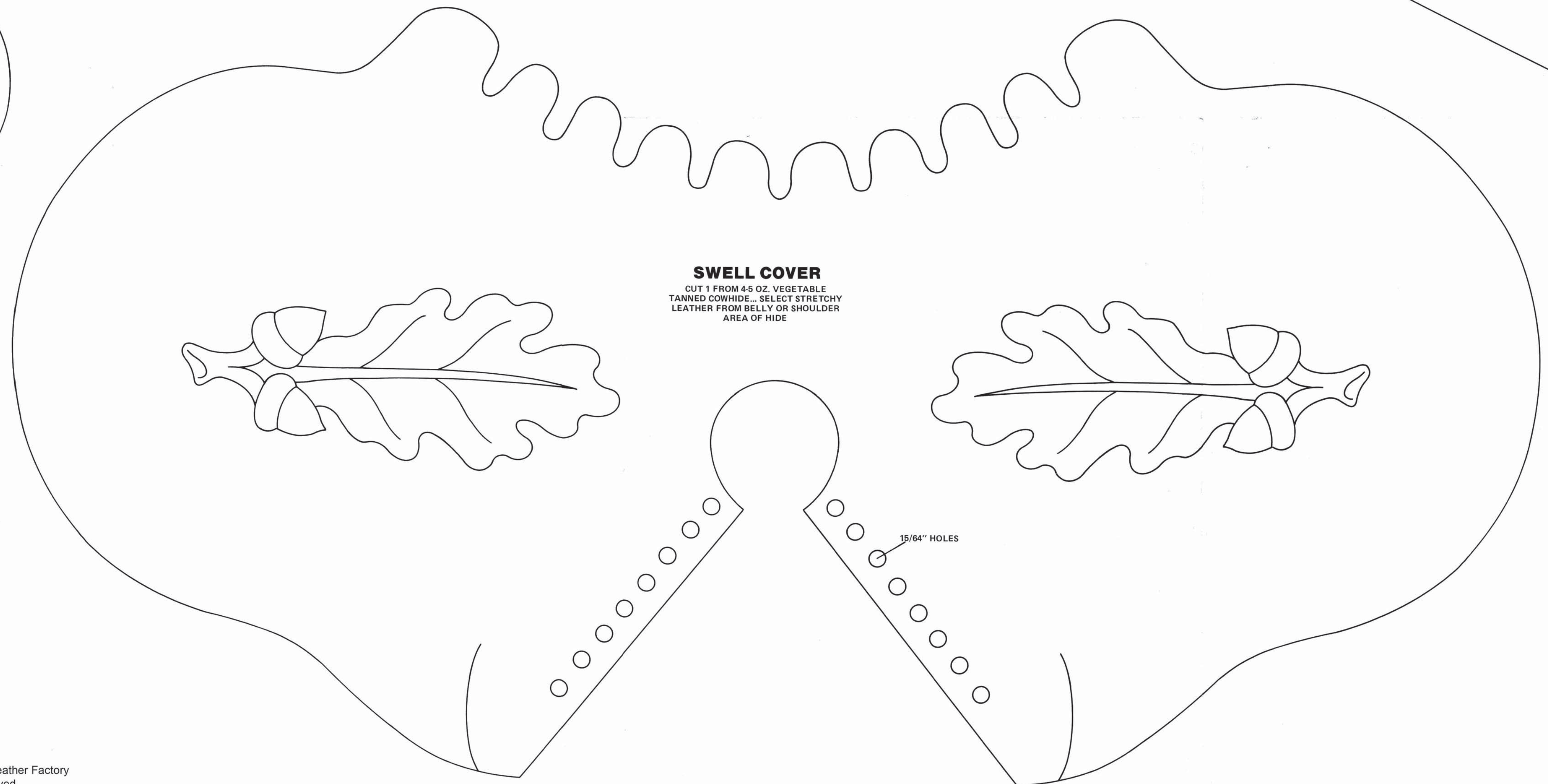
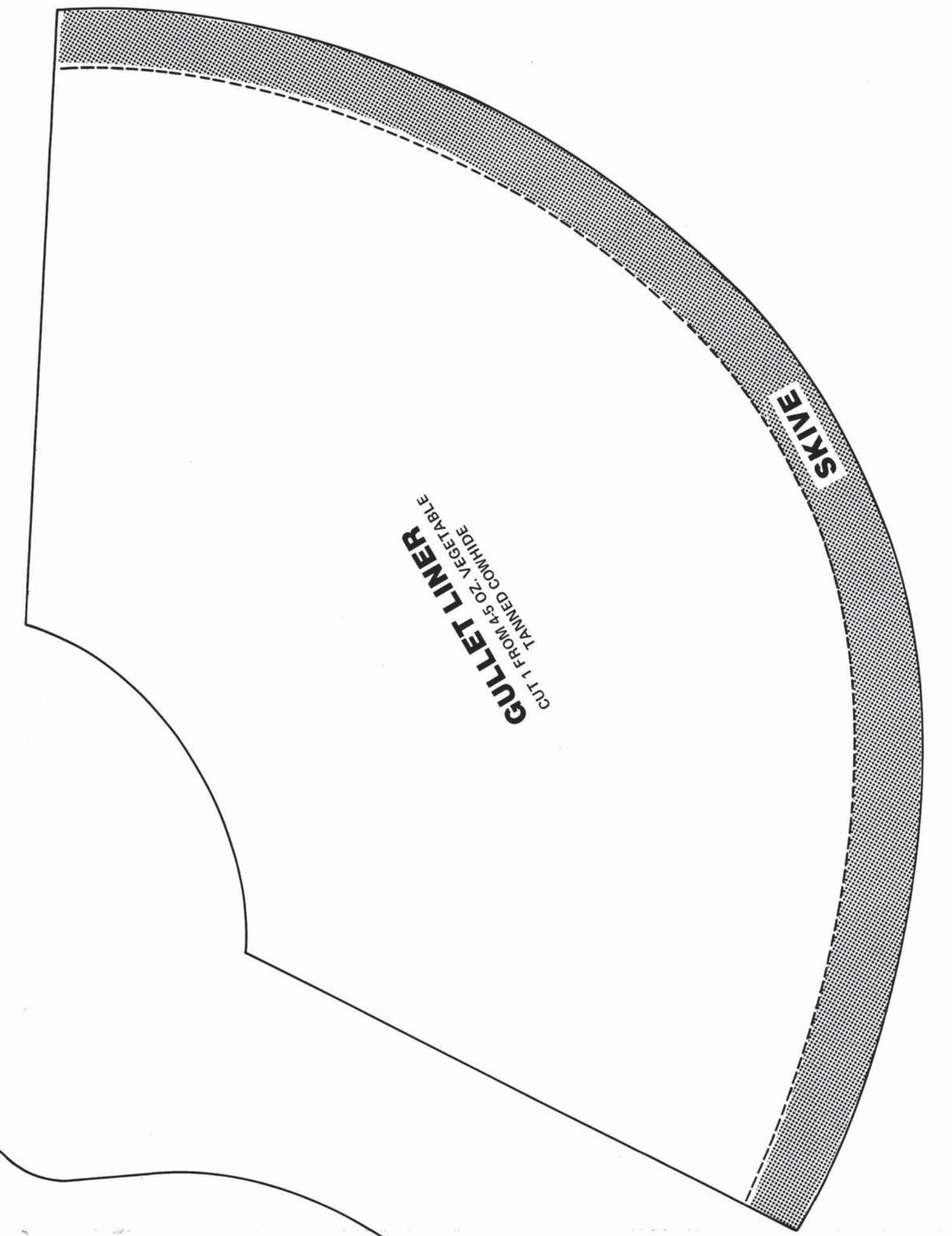
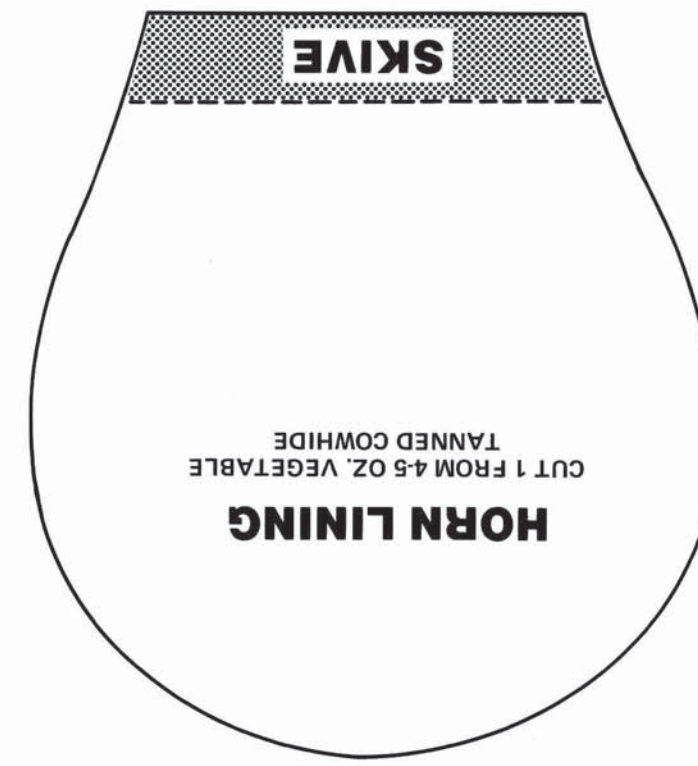
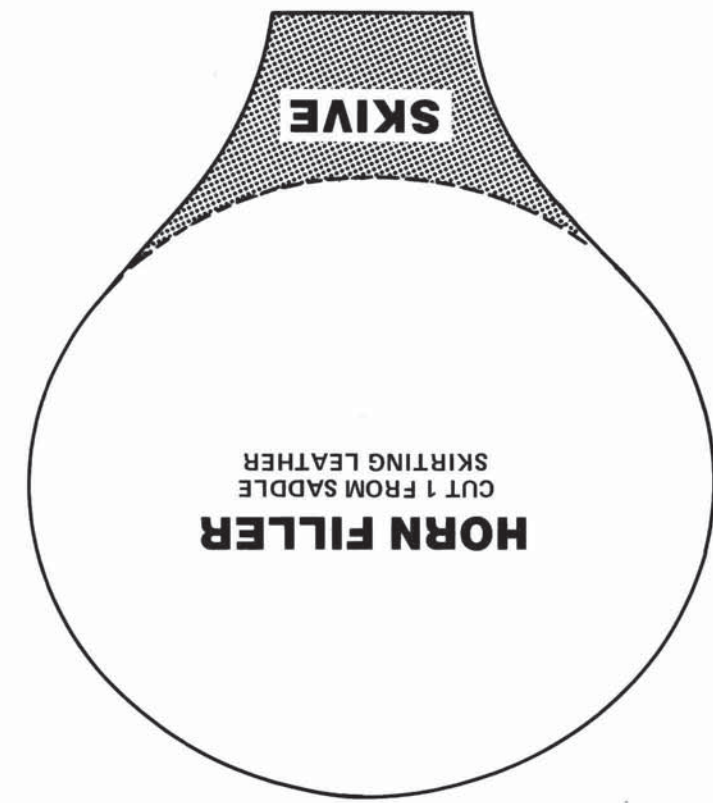
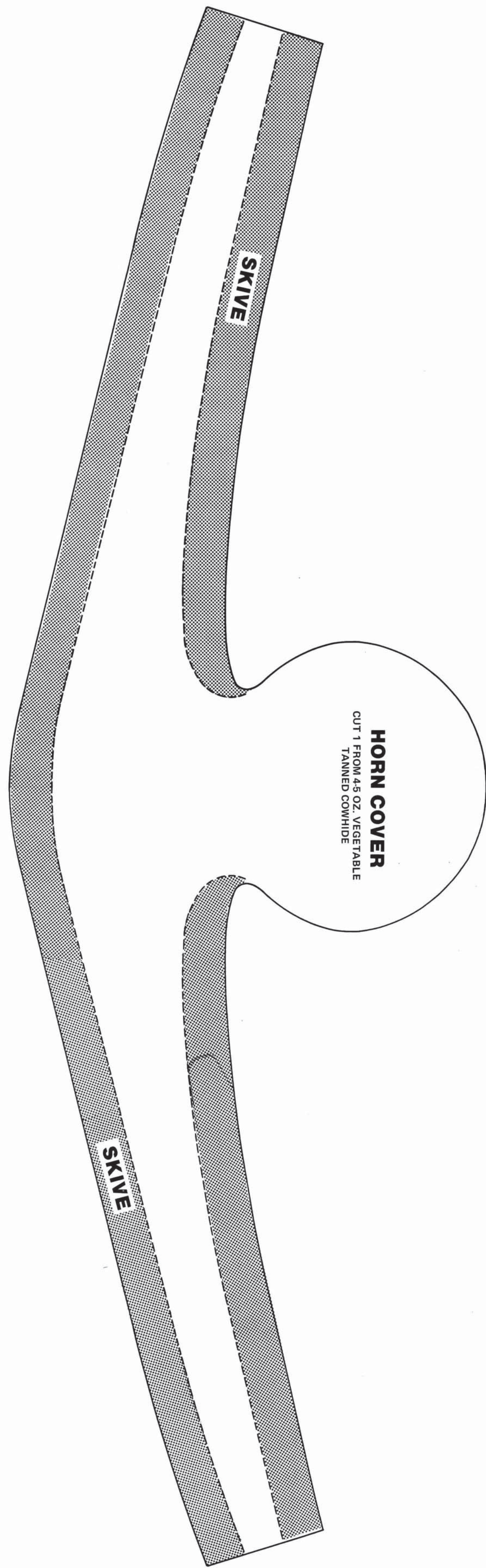
Handwritten scribbles on the left margin.



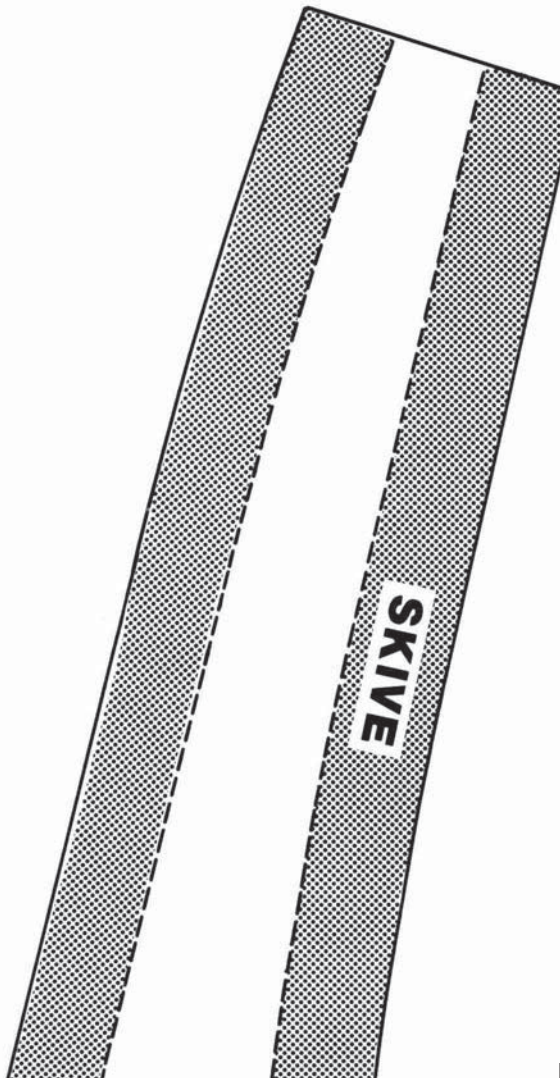
**SKIVE**

STOCK No. 4822



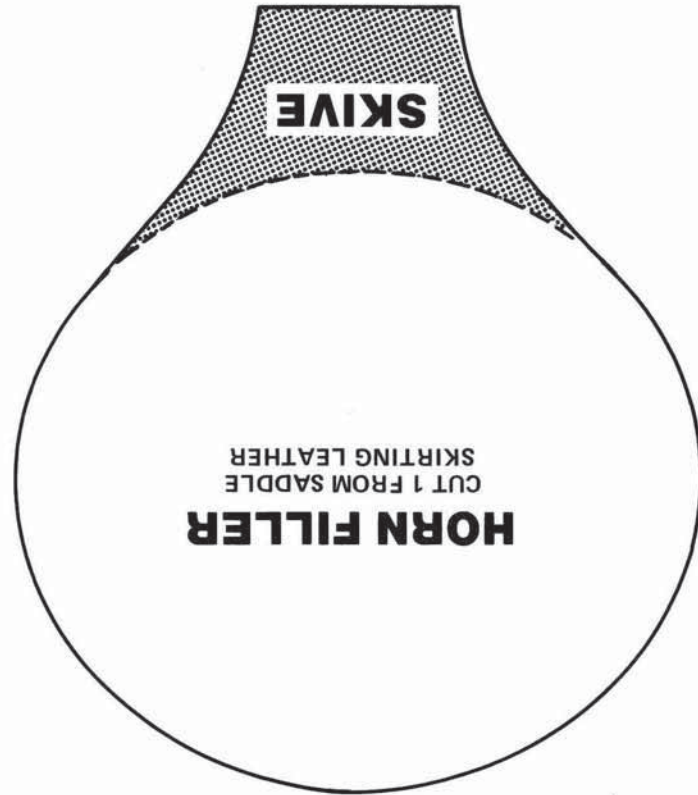






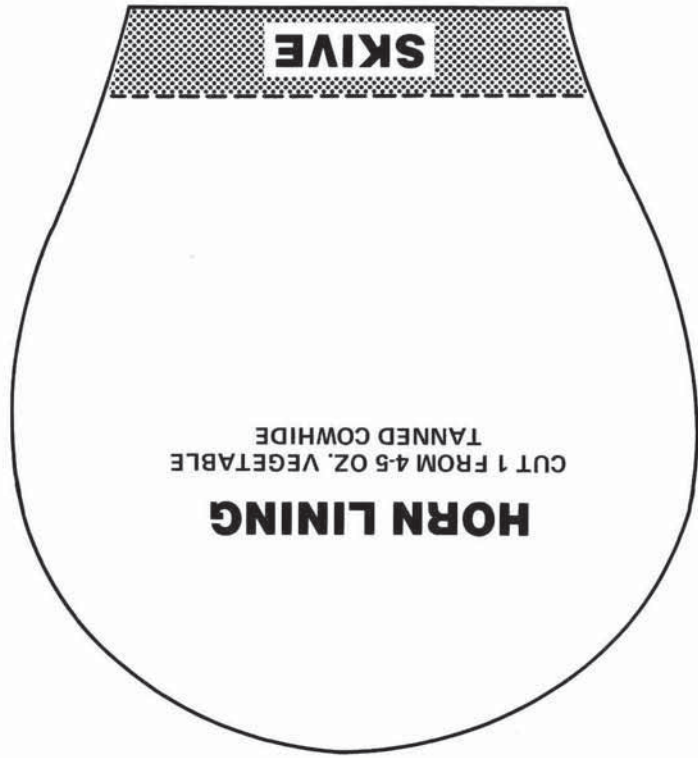
**SKIVE**





**SKIVE**

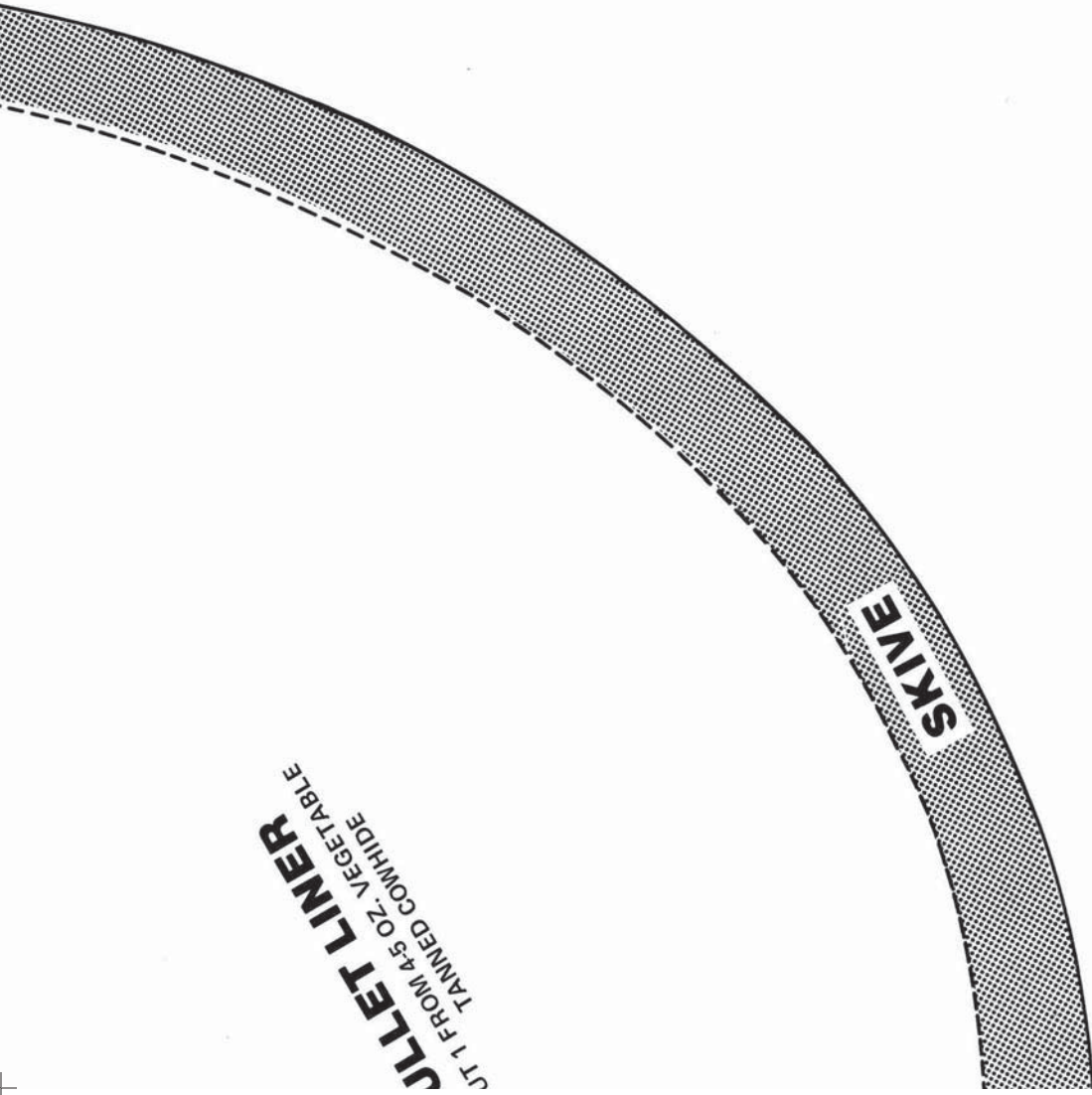
**HORN FILLER**  
CUT 1 FROM SADDLE  
SKIRTING LEATHER

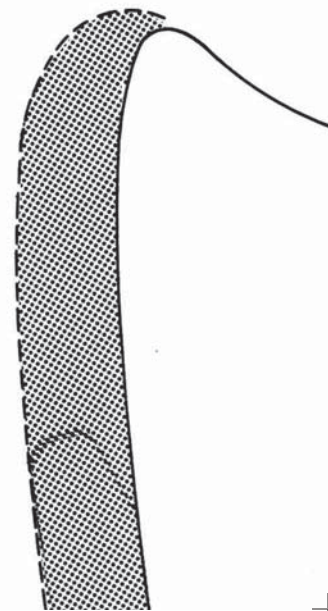
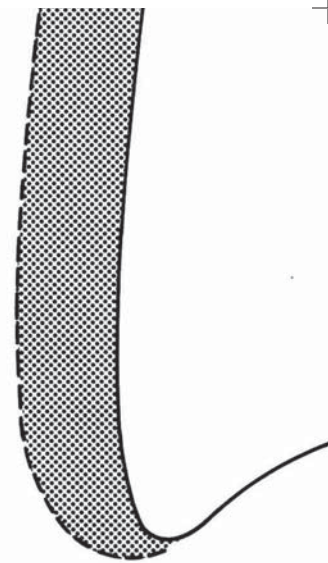
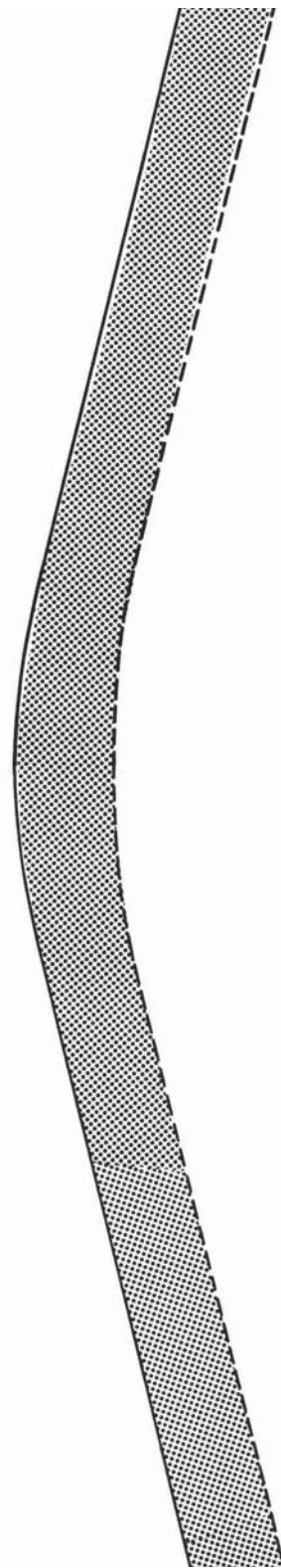




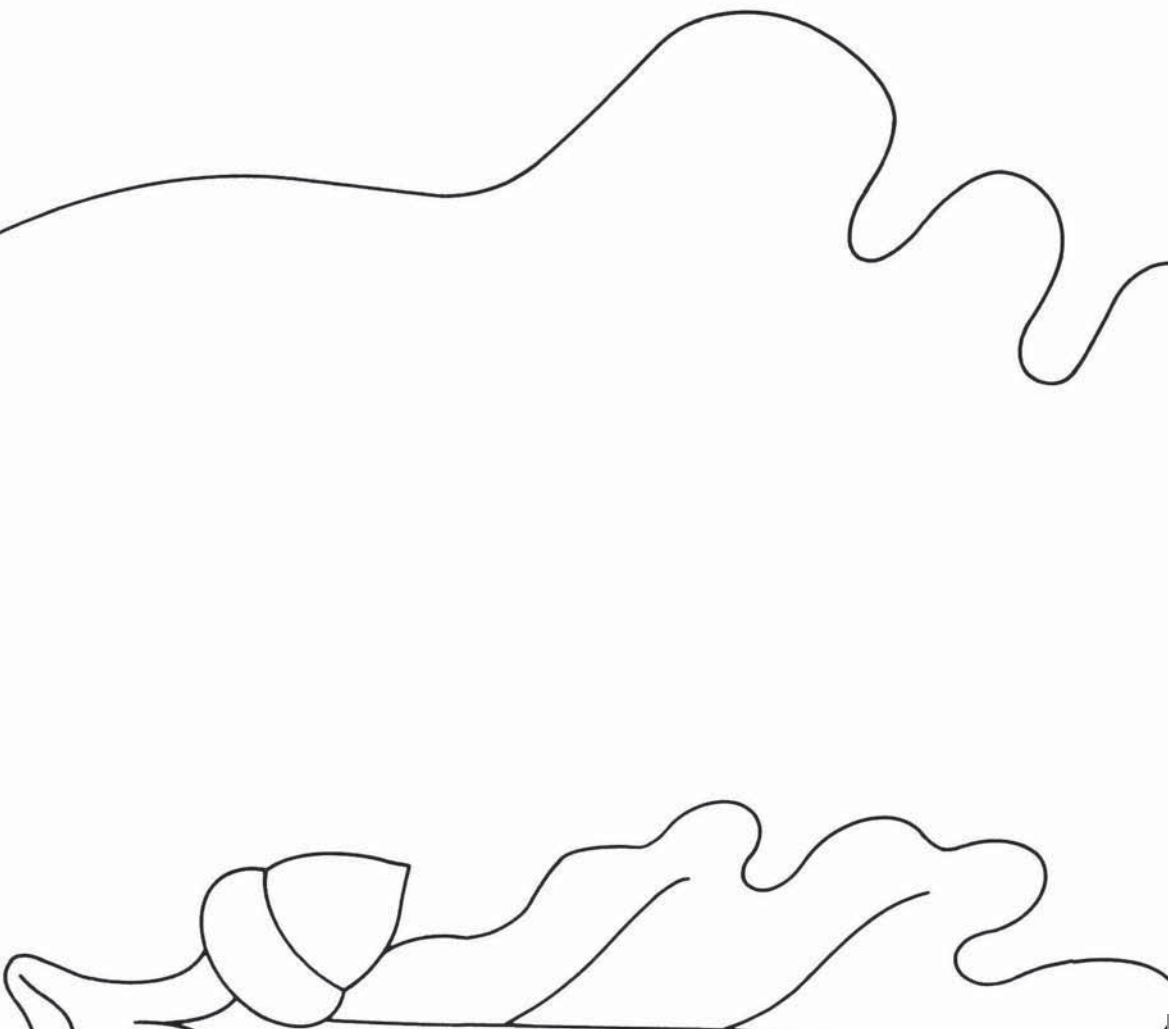
**OLET LINER**  
DT 1 FROM 4.5 OZ. VEGETABLE  
TANNED COMHIDE

**SKIVE**



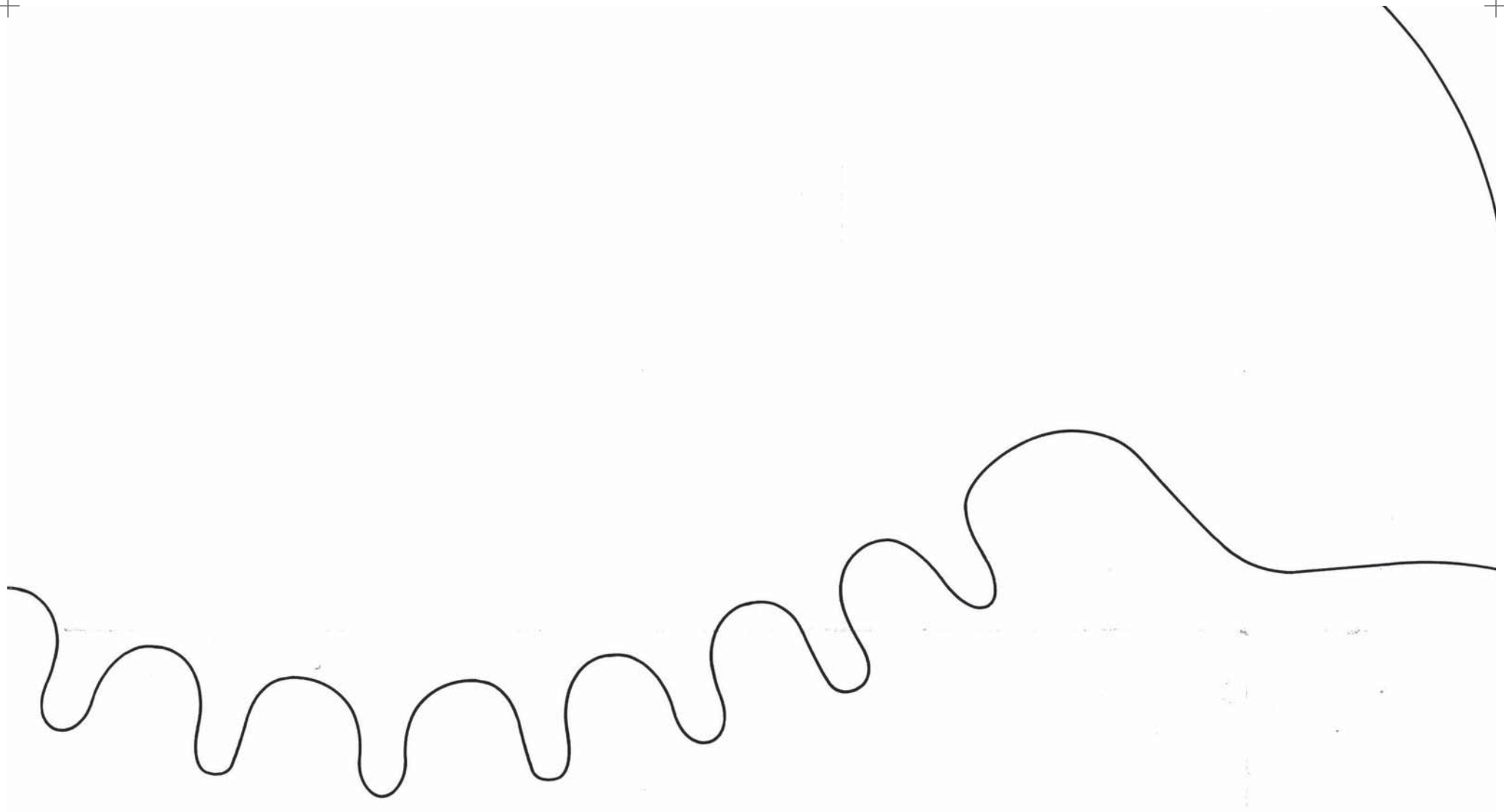






**HORN COVER**

CUT 1 FROM 4.5 OZ. VEGETABLE  
TANNED COWHIDE

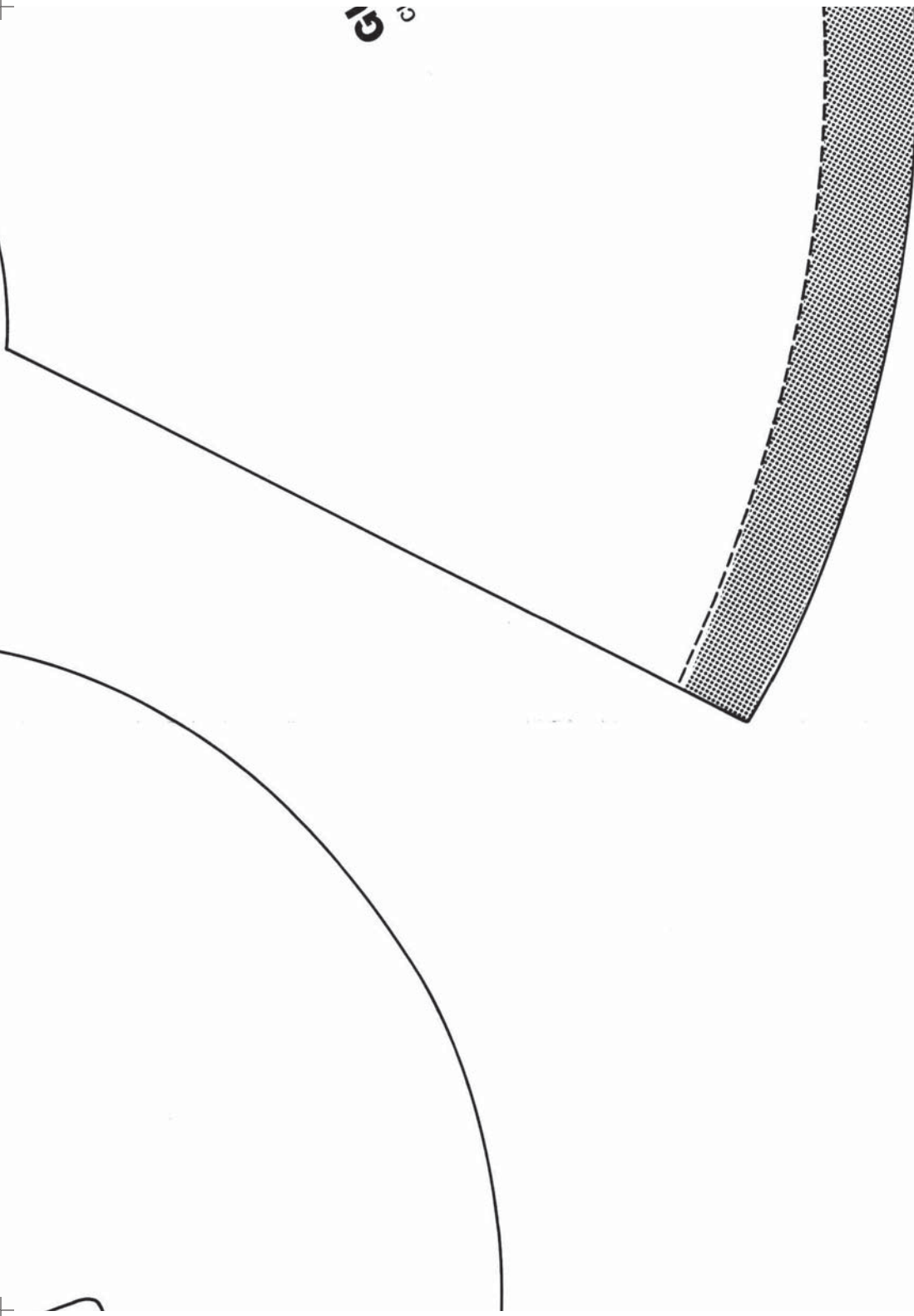


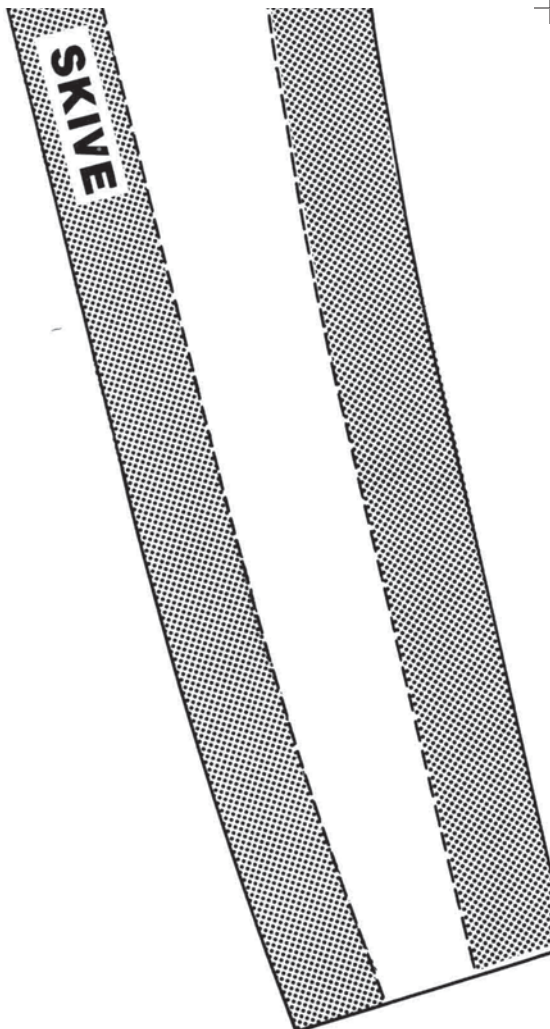
**SWELL COVER**  
CUT 1 FROM 4-5 OZ. VEGETABLE  
TANNED COWHIDE... SELECT STRETCHY  
LEATHER FROM BELLY OR SHOULDER  
AREA OF HIDE





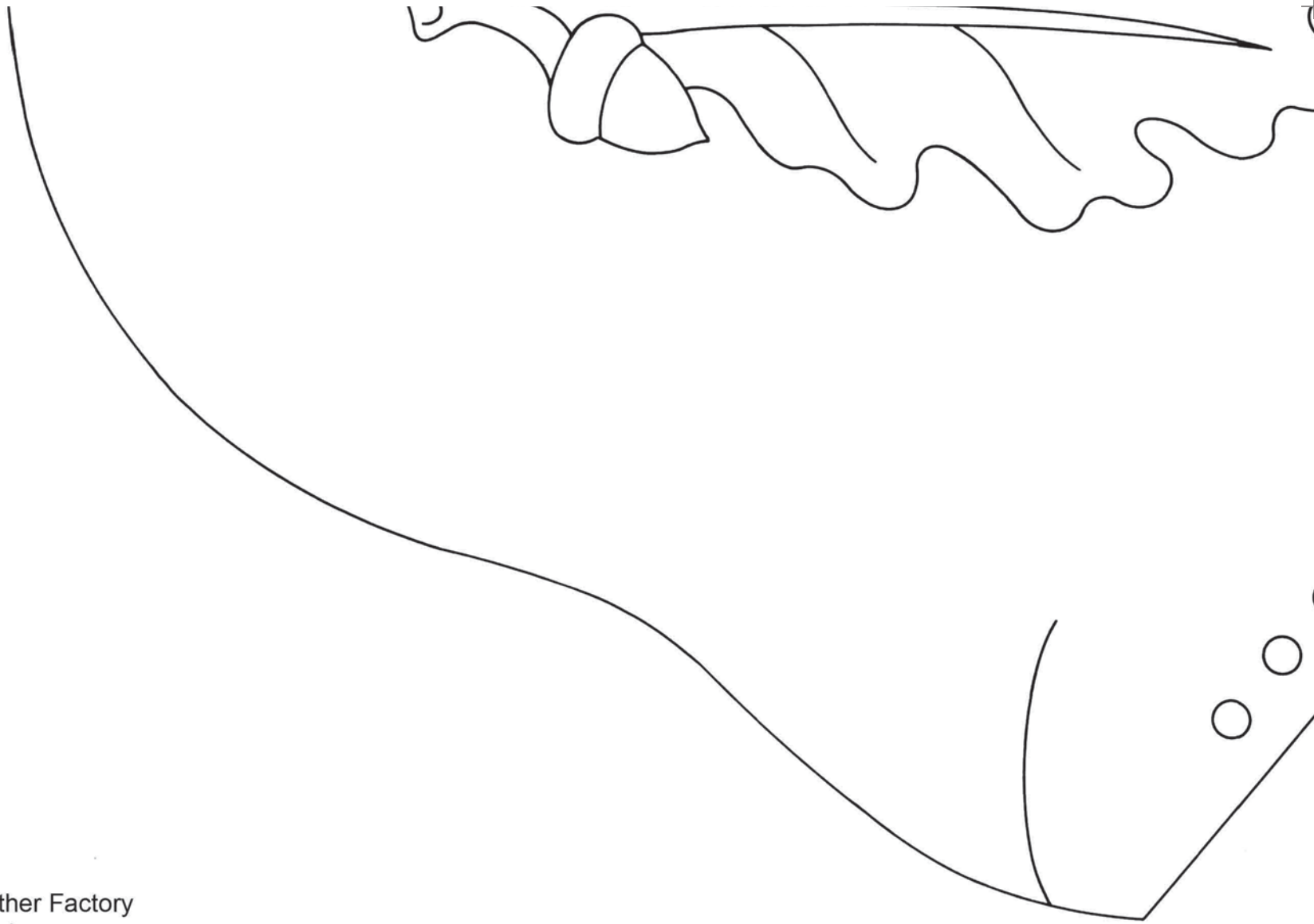
15<sup>o</sup>



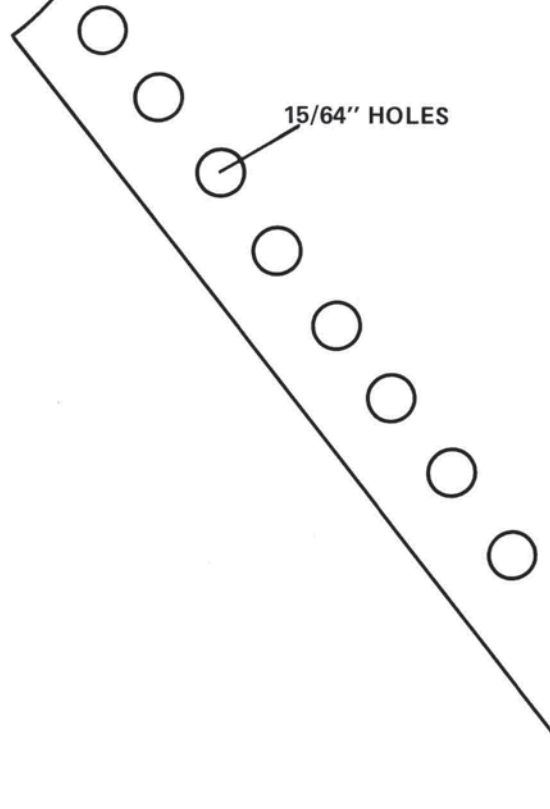
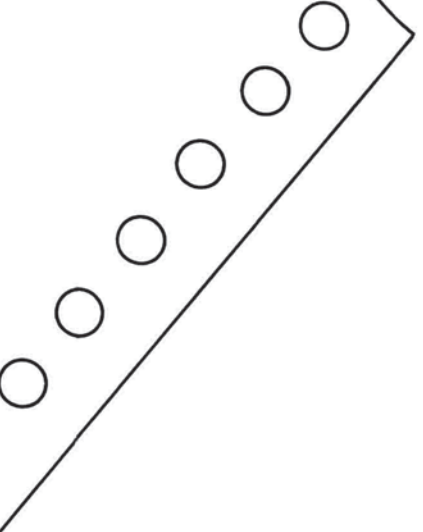
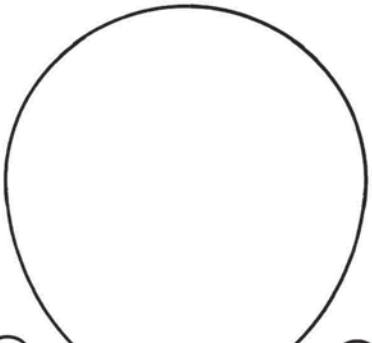


**SKIVE**

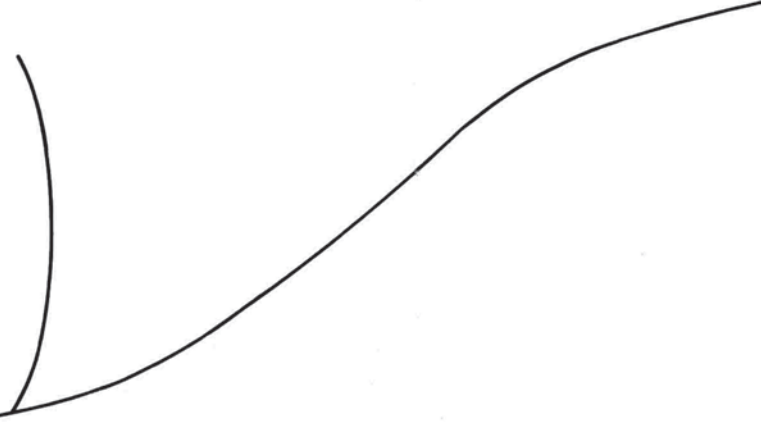
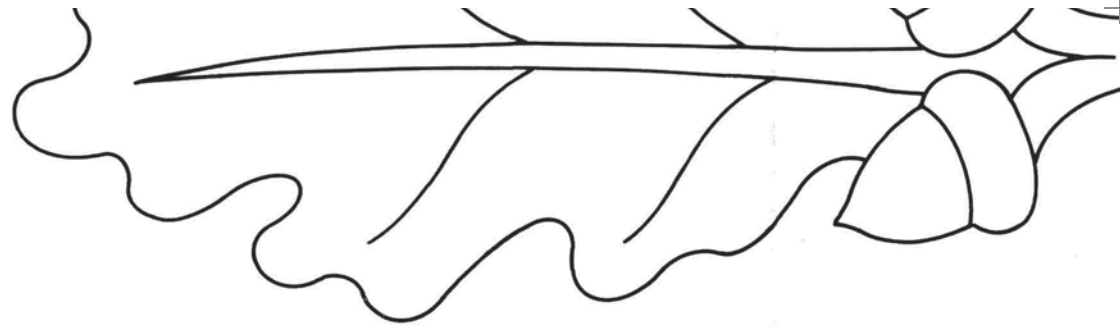




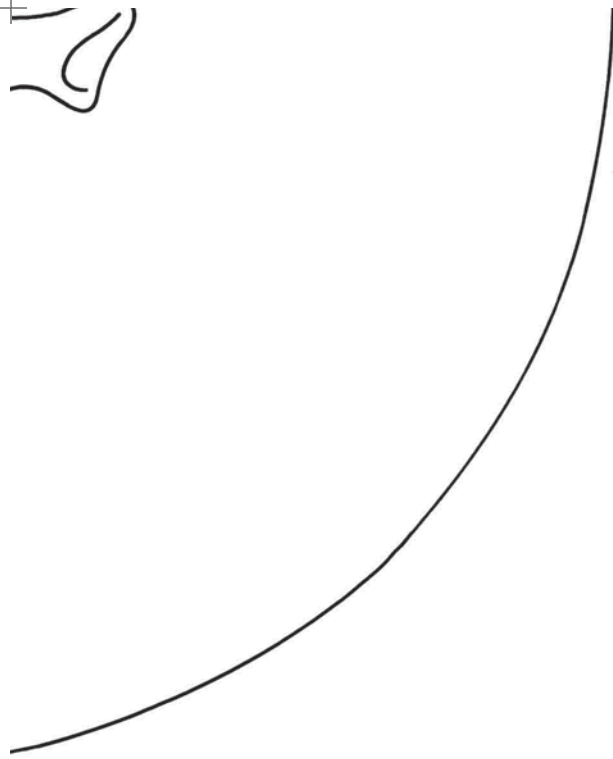
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15/64" HOLES





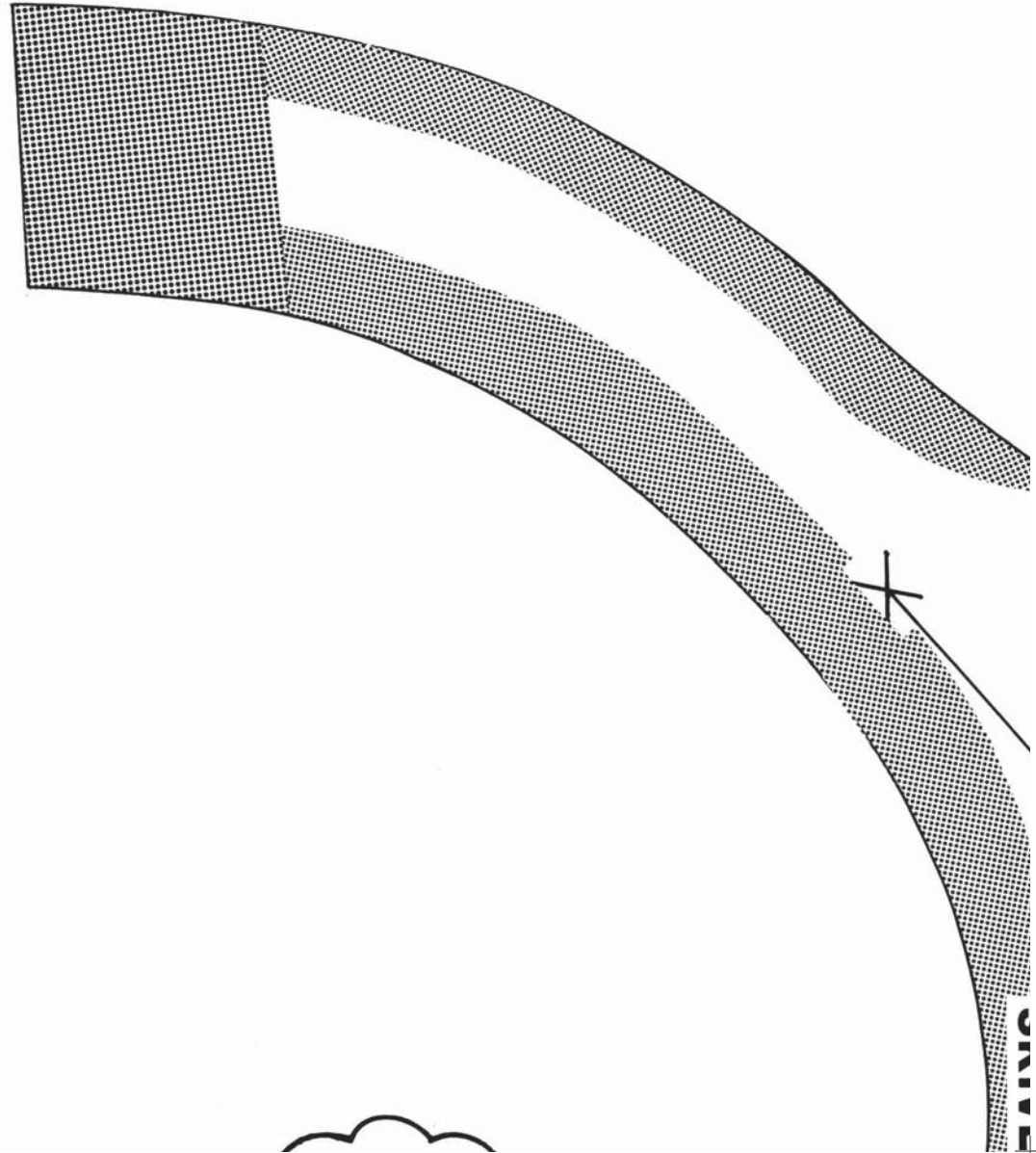


STOCK No. 4822









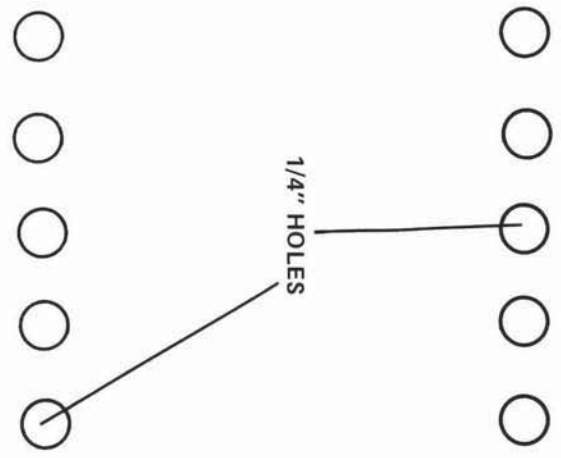
**SKIVE**

**B**

**BACK RIGGING**

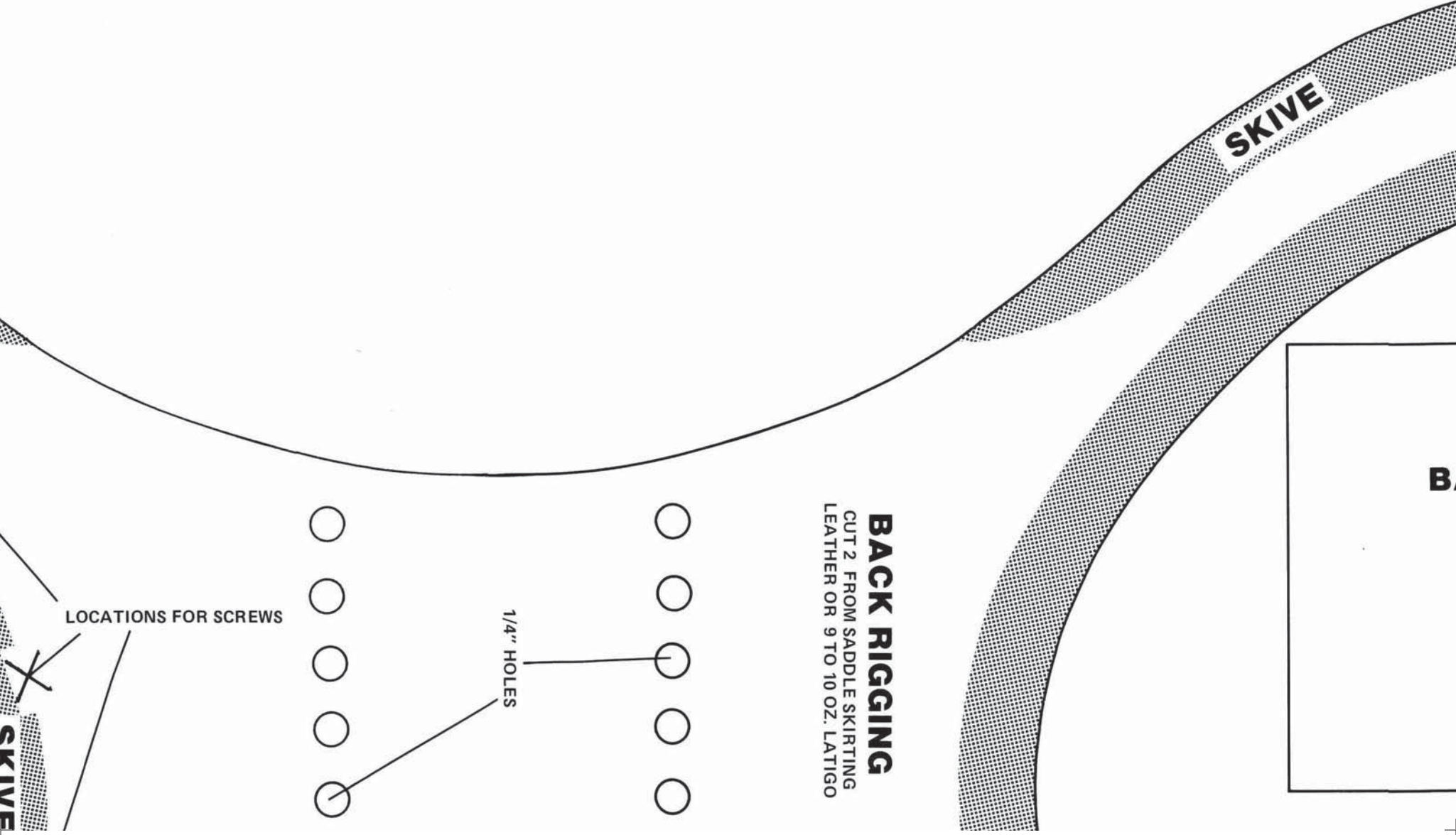
CUT 2 FROM SADDLE SKIRTING  
LEATHER OR 9 TO 10 OZ. LATIGO

1/4" HOLES

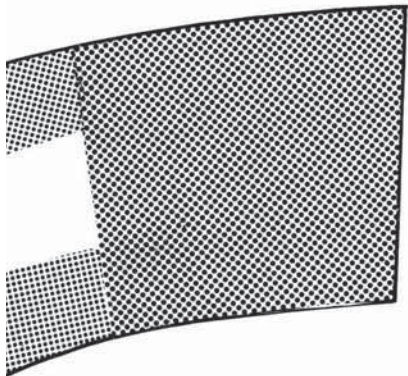


LOCATIONS FOR SCREWS

**SKIVE**

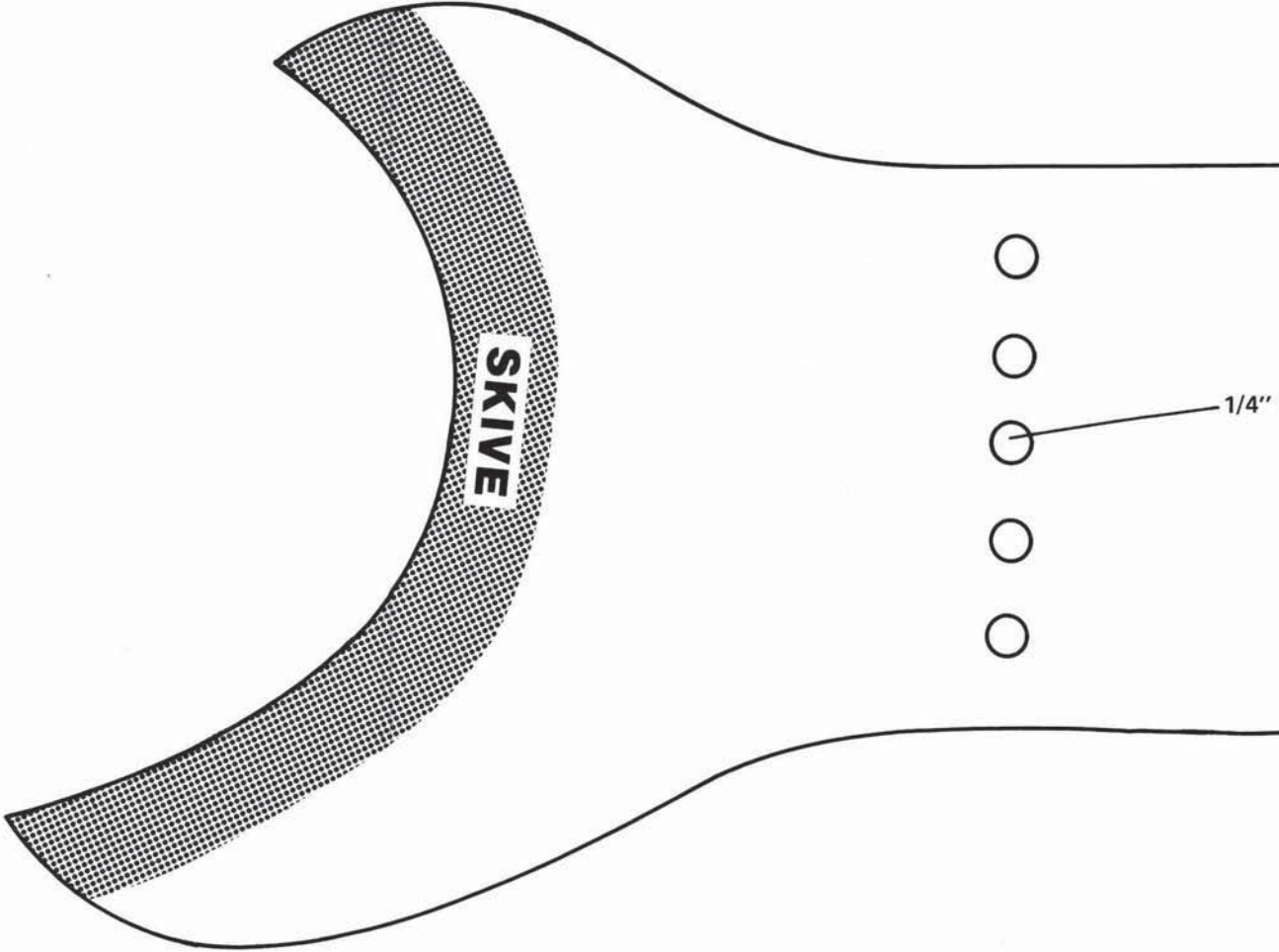






# BACK CINCHA KEEPERS

CUT 2 FROM 6-7 OZ. VEGETABLE  
TANNED COWHIDE



1/4"

# FLANK CINCHA

HOLES



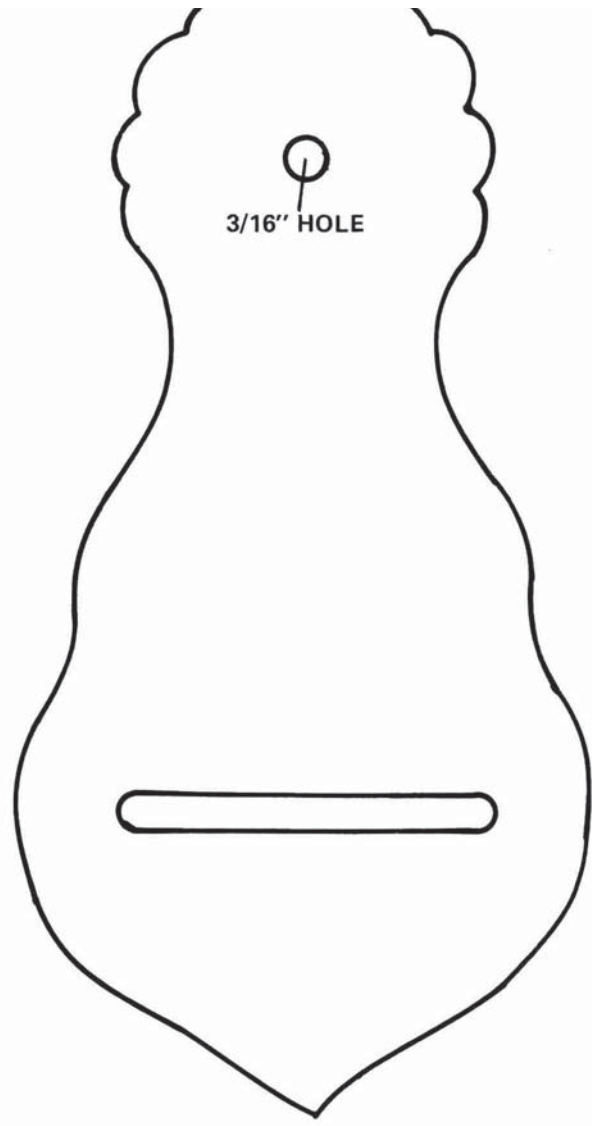
**FRONT RIGGING**

CUT 2 FROM SADDLE  
SKIRTING LEATHER OR  
9 TO 10 OZ. LATIGO

**SKIVE**

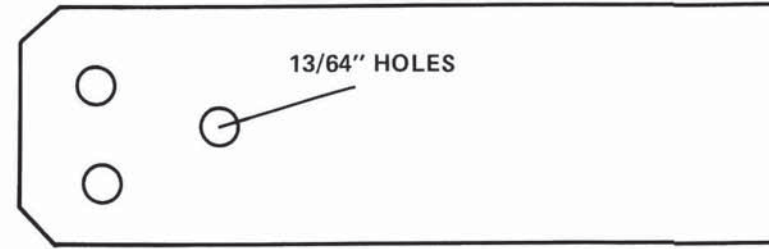
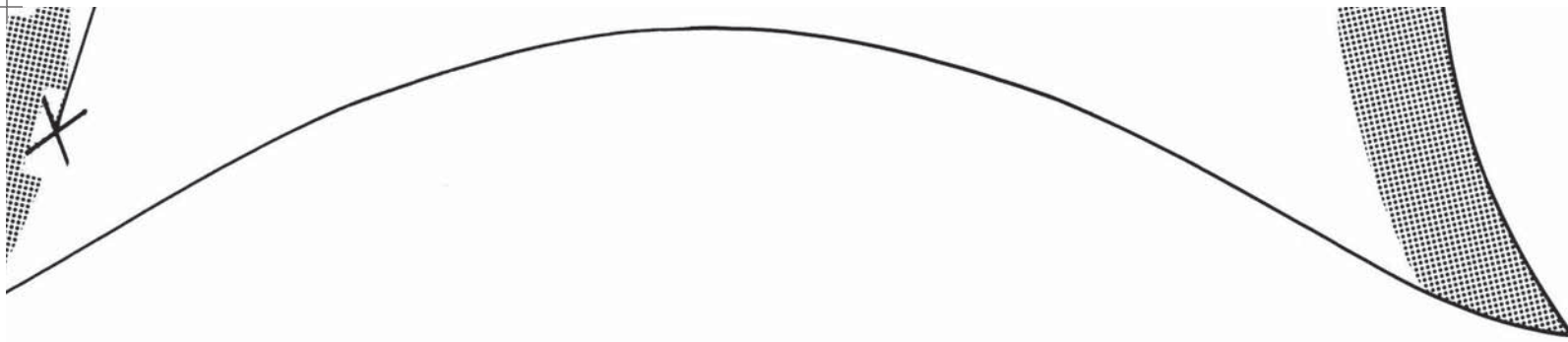
**HA KEEPER STRETCHER**





**STRAP HOLDER**  
CUT 1 FROM SADDLE SKIRTING LEATHER

**NOTE**  
IF A HORN WRAP IS



## CONCHOS

CUT 4 SMALL AND 2 LARGE  
FROM SADDLE SKIRTING LEATHER



## FLANK CINCH

CUT 2 FROM SADDL

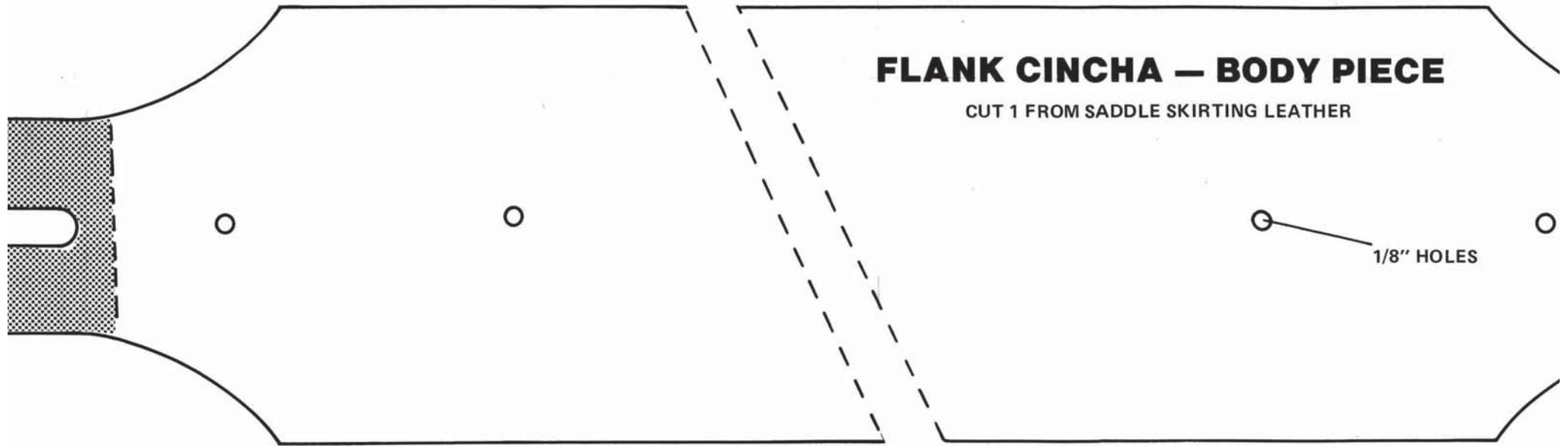




**RIGGING CONNECTOR STRAPS**

CUT 2 FROM FIRM SADDLE SKIRTING  
LEATHER CUT WITH THE GRAIN

**FLANK CINCHA – BODY PIECE** · OVERALL LENGTH 44"



**FLANK CINCHA – BODY PIECE**

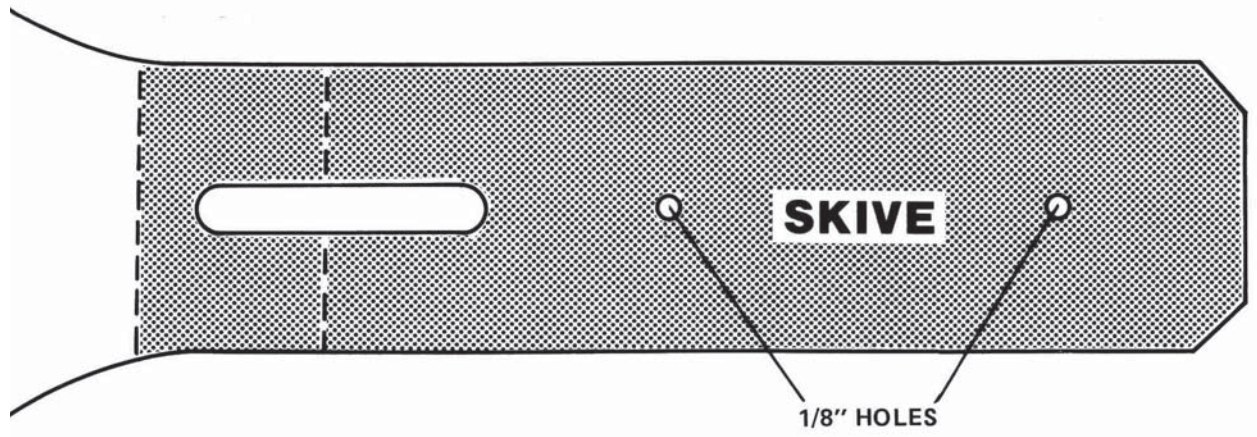
CUT 1 FROM SADDLE SKIRTING LEATHER

1/8" HOLES

**IA - OFF BILLETS**

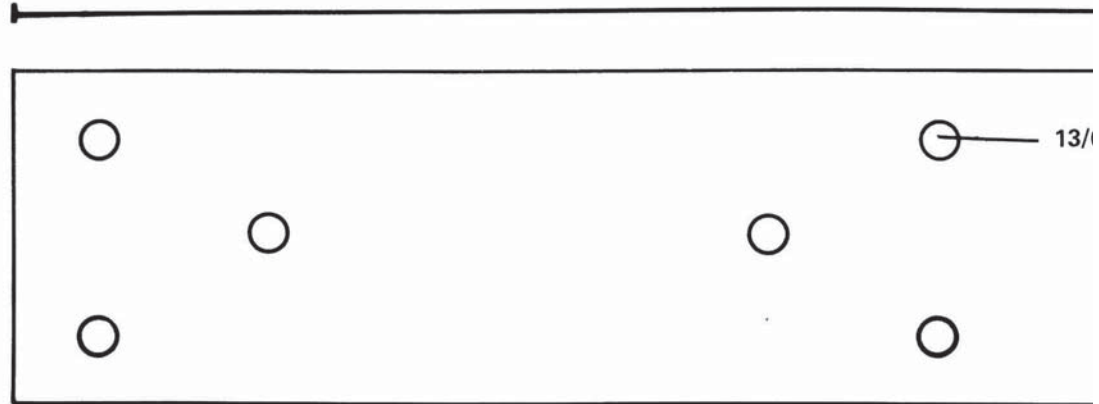
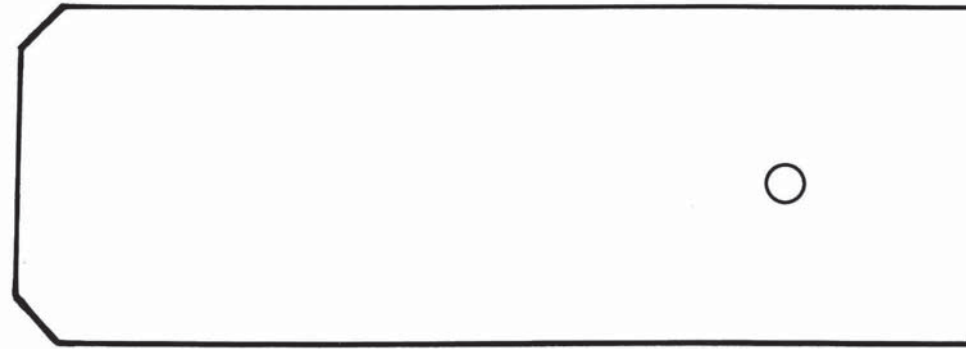
LE SKIRTING LEATHER

JT FROM HEAVY SKIRTING OR  
PLATE FROM WOOD 1/4" THICK





IF A HORN WRAP IS  
DESIRED, CUT 1 FROM  
4-5 OZ. LATIGO 1" X 60"  
AND SKIVE BOTH EDGES.





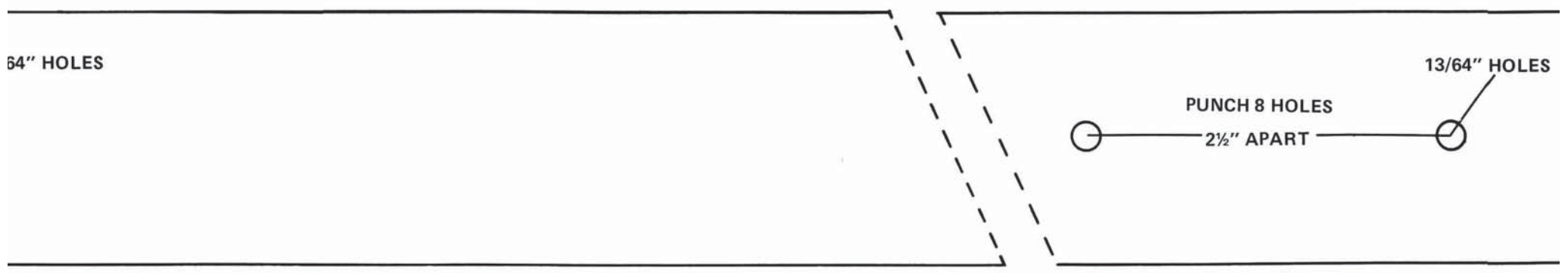
### CONNECTOR STRAP BILLET



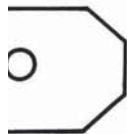
### FRONT OFF BILLET

CUT 1 FROM SADDLE SKIRTING LEATHER

### LATIGO TIE STRAP







**CONNECTOR STRAP**  
CUT FROM 8-9 OZ. VEGETABLE TANNED COWHIDE



**P** OVERALL LENGTH 61"

START 18" FROM END

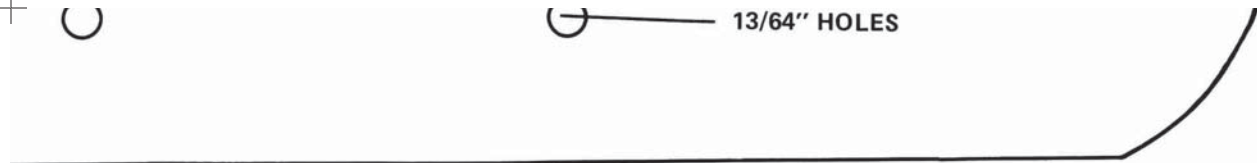


**LATIGO TIE STRAP**

CUT 1 FROM 9-10 OZ. LATIGO



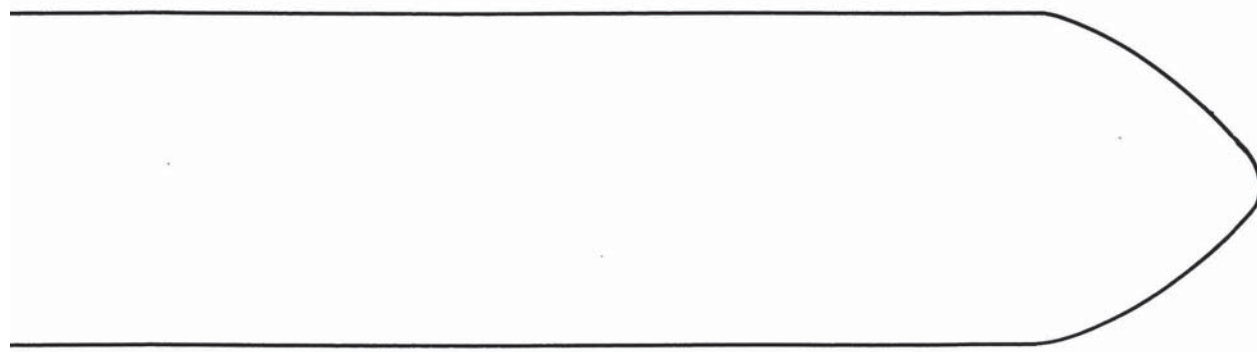
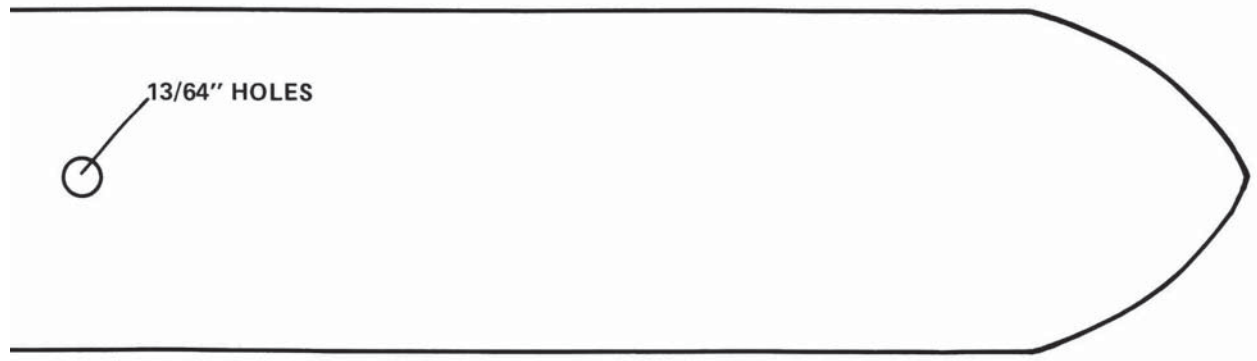
13/64" HOLES



3/16" HOLES

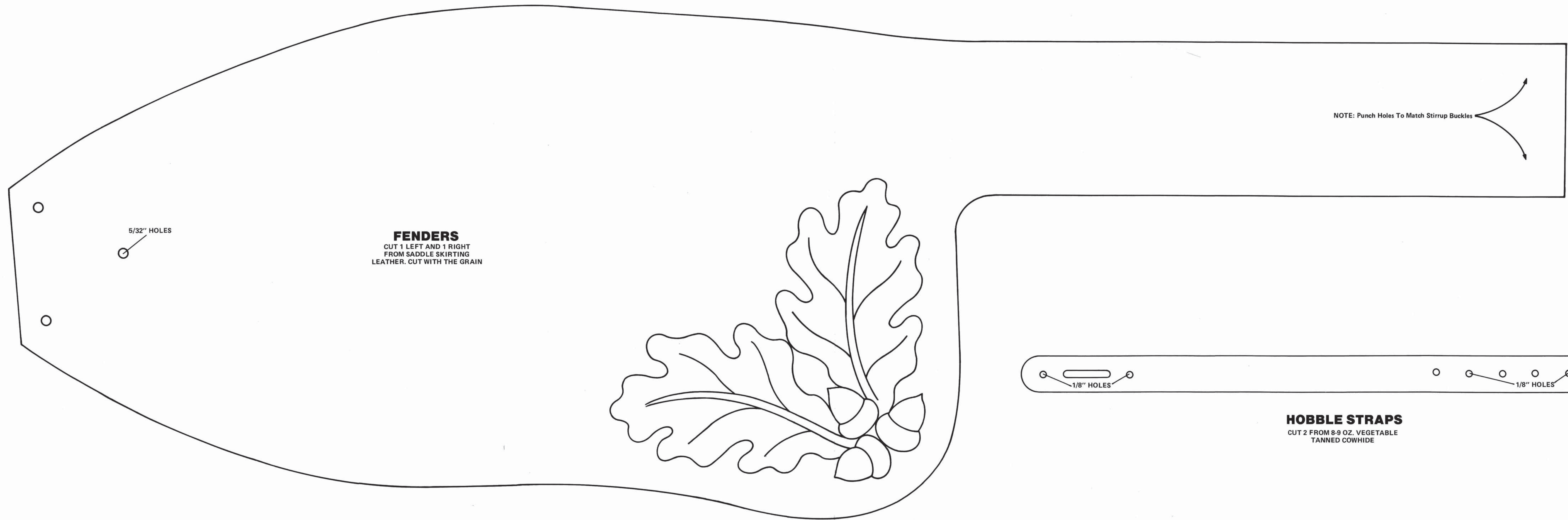


13/64" HOLES



STOCK No. 4822





NOTE: Punch Holes To Match Stirrup Buckles

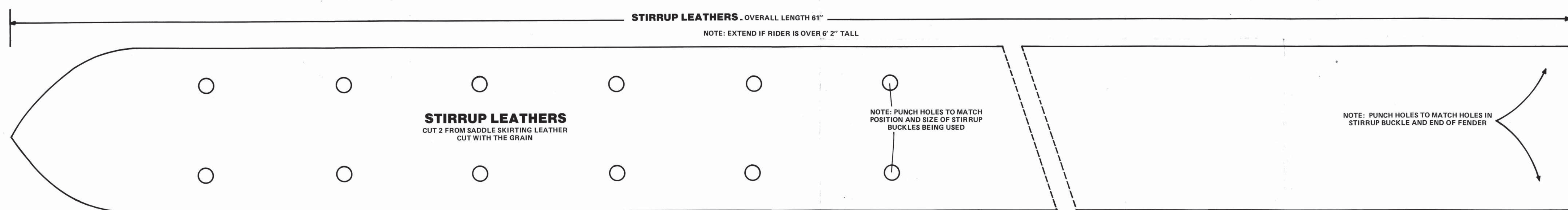
**FENDERS**  
 CUT 1 LEFT AND 1 RIGHT  
 FROM SADDLE SKIRTING  
 LEATHER. CUT WITH THE GRAIN

5/32" HOLES

1/8" HOLES

1/8" HOLES

**HOBBLE STRAPS**  
 CUT 2 FROM 8-9 OZ. VEGETABLE  
 TANNED COWHIDE



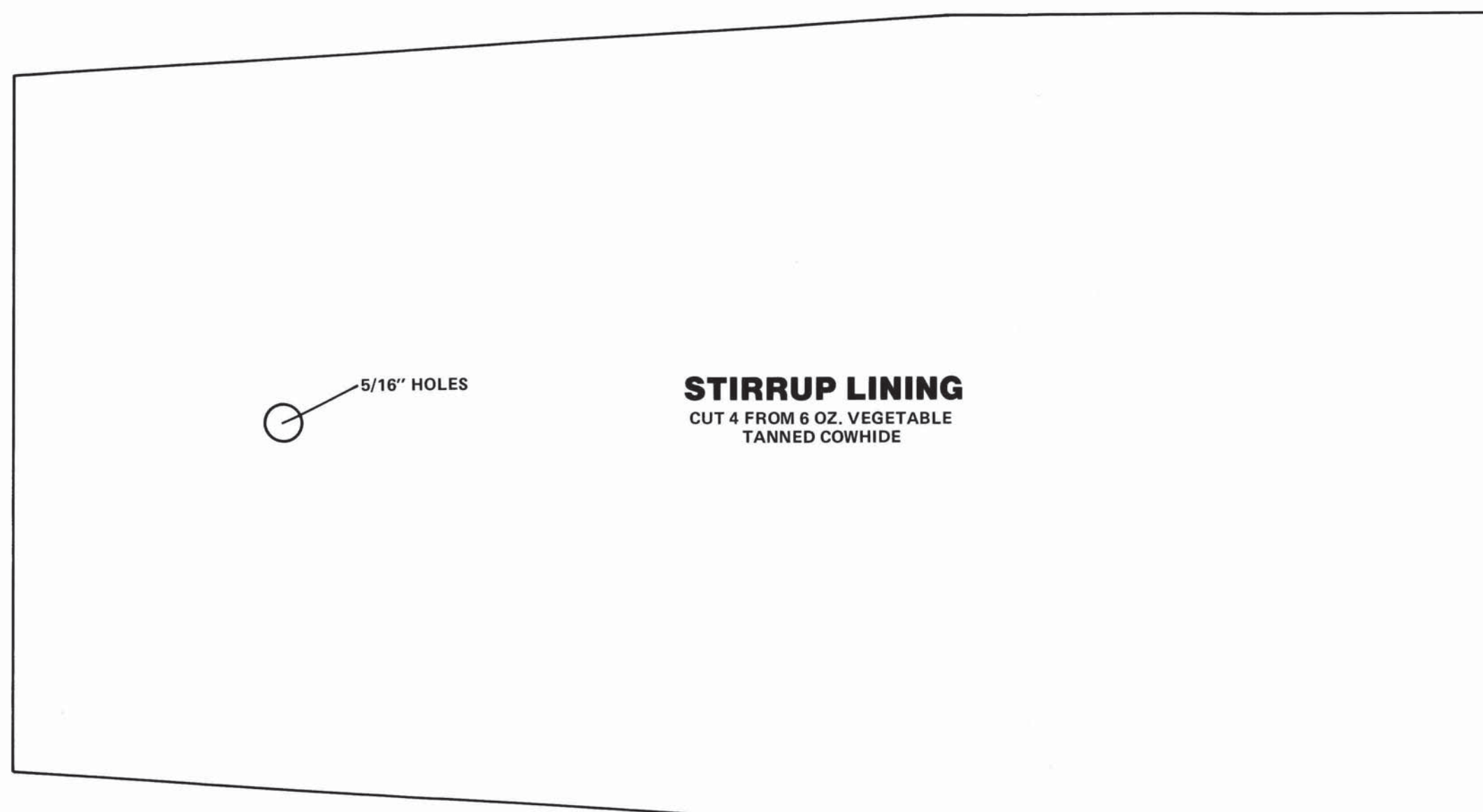
**STIRRUP LEATHERS** - OVERALL LENGTH 61"

NOTE: EXTEND IF RIDER IS OVER 6' 2" TALL

**STIRRUP LEATHERS**  
 CUT 2 FROM SADDLE SKIRTING LEATHER  
 CUT WITH THE GRAIN

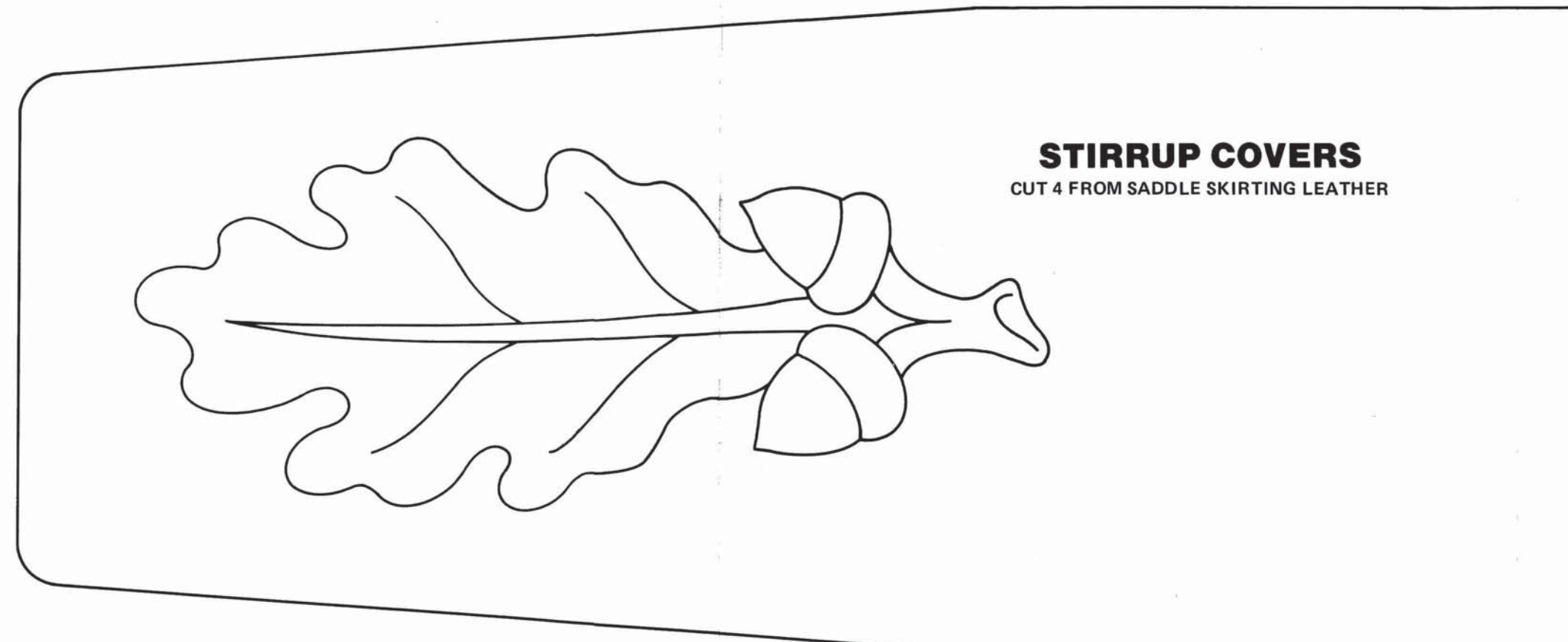
NOTE: PUNCH HOLES TO MATCH  
 POSITION AND SIZE OF STIRRUP  
 BUCKLES BEING USED

NOTE: PUNCH HOLES TO MATCH HOLES IN  
 STIRRUP BUCKLE AND END OF FENDER



**STIRRUP LINING**  
 CUT 4 FROM 6 OZ. VEGETABLE  
 TANNED COWHIDE

5/16" HOLES

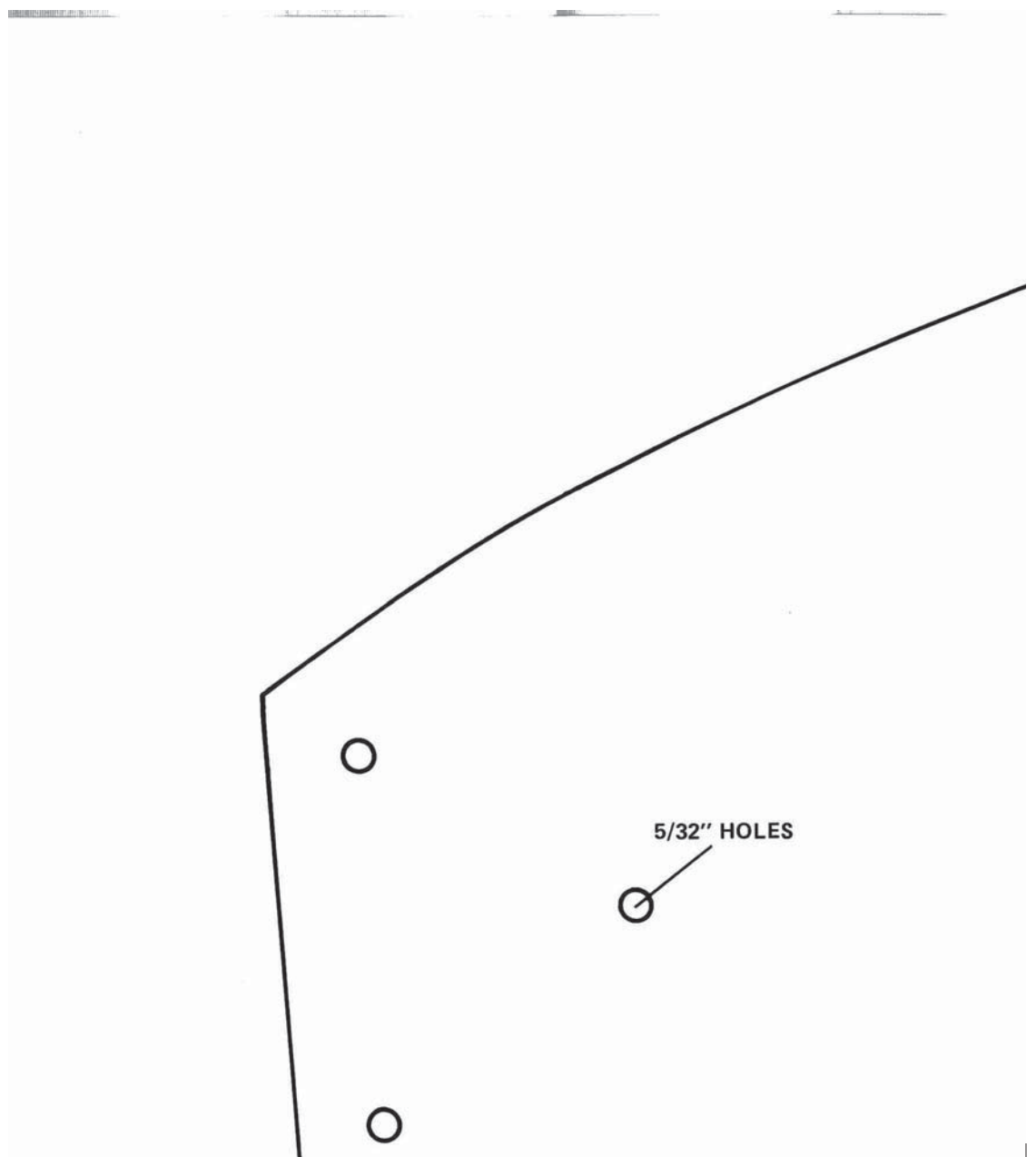


**STIRRUP COVERS**  
 CUT 4 FROM SADDLE SKIRTING LEATHER



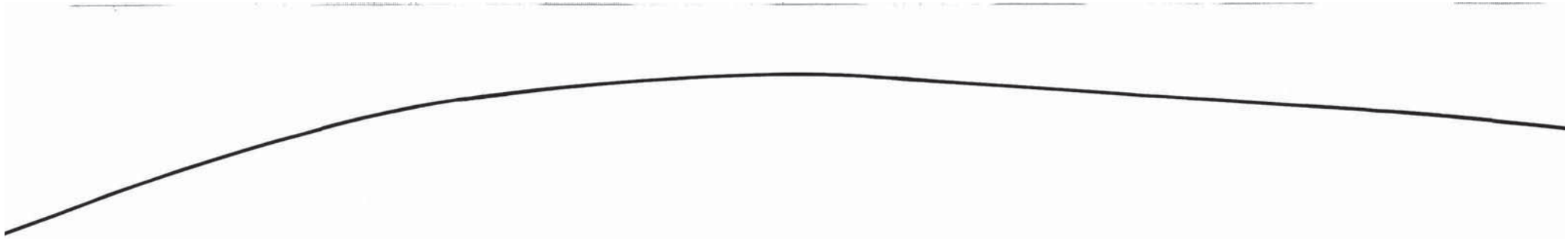
**TREAD COVERS**  
 CUT 2 FROM 8-9 OZ. VEGETABLE  
 TANNED COWHIDE

1/4" HOLES



5/32'' HOLES

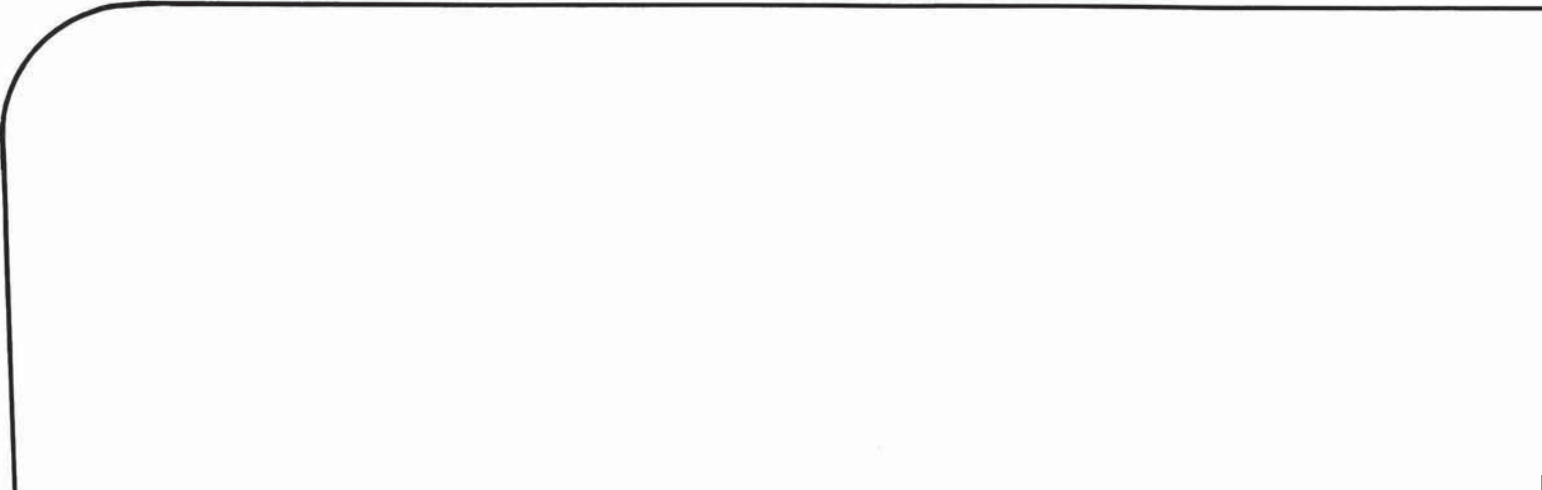




**FENDERS**  
CUT 1 LEFT AND 1 RIGHT  
FROM SADDLE SKIRTING  
LEATHER. CUT WITH THE GRAIN

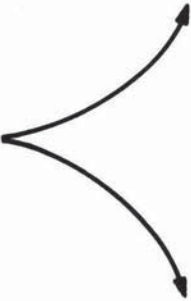


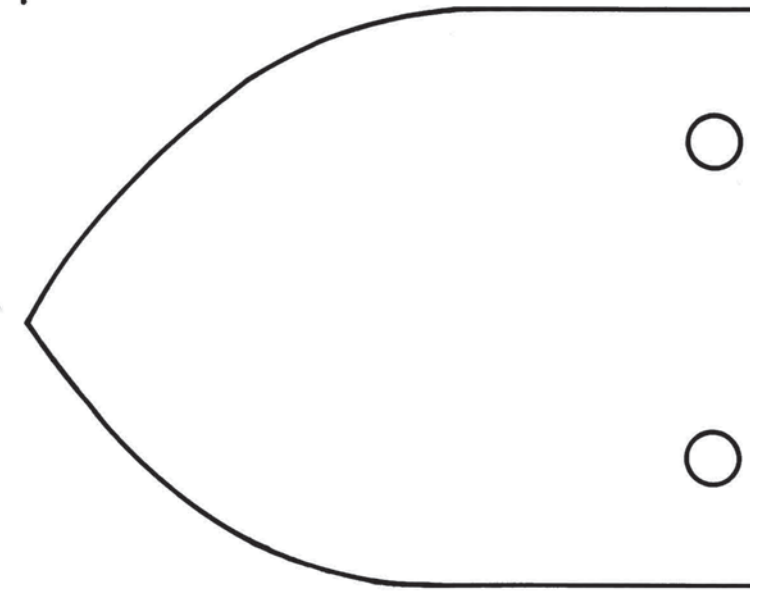
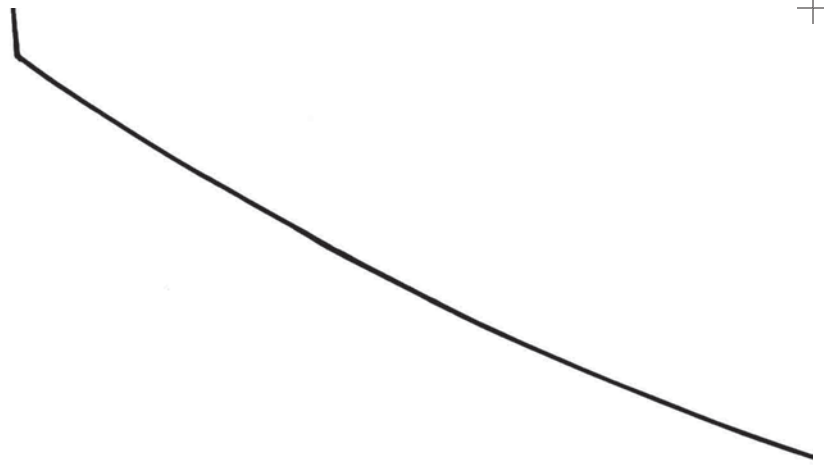
NOTE: Punch H



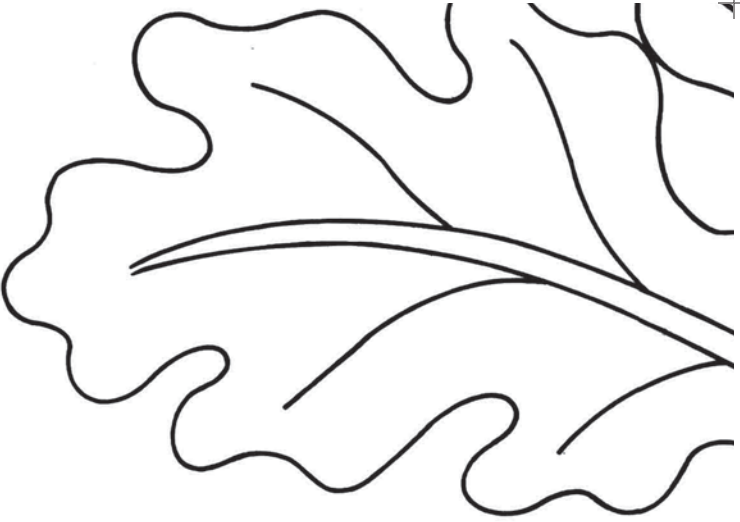


ables To Match Stirrup Buckles









**STIRRUP LEATHERS** . OVERALL LENG

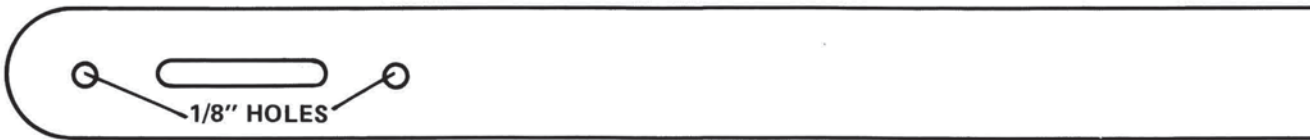
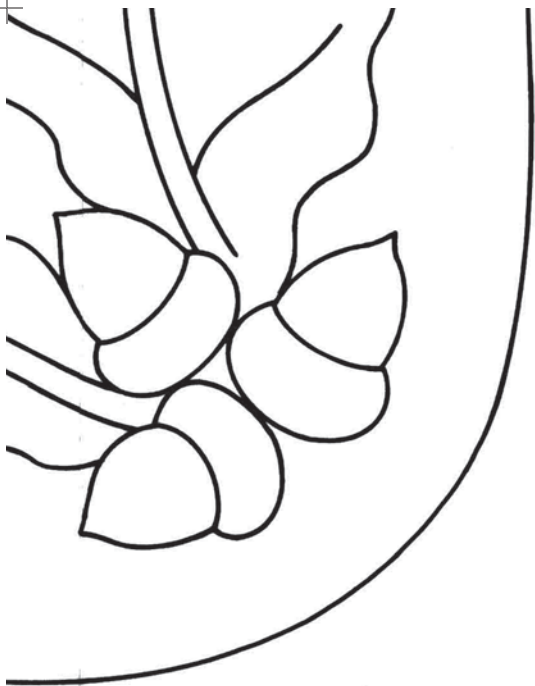
NOTE: EXTEND IF RIDER IS



**STIRRUP LEATHERS**

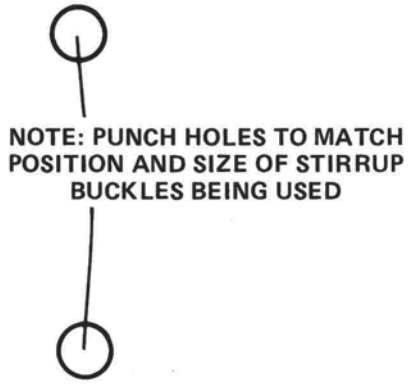
CUT 2 FROM SADDLE SKIRTING LEATHER  
CUT WITH THE GRAIN





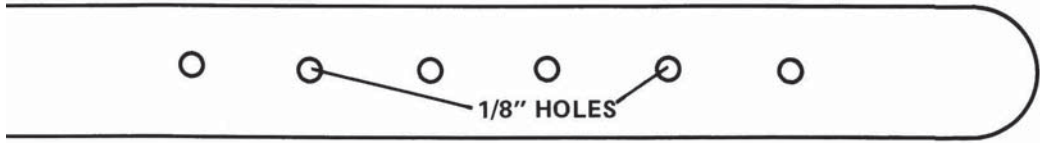
**HOBBLE STRAP**  
CUT 2 FROM 8-9 OZ. VEGETA  
TANNED COWHIDE

WITH 6 1/2"  
OVER 6' 2" TALL

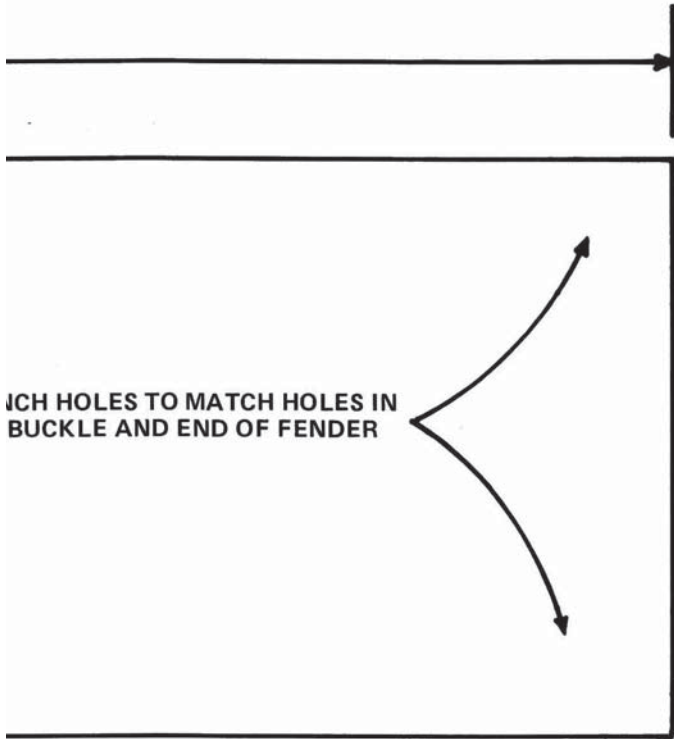


NOTE: PUNCH  
STIRRUP

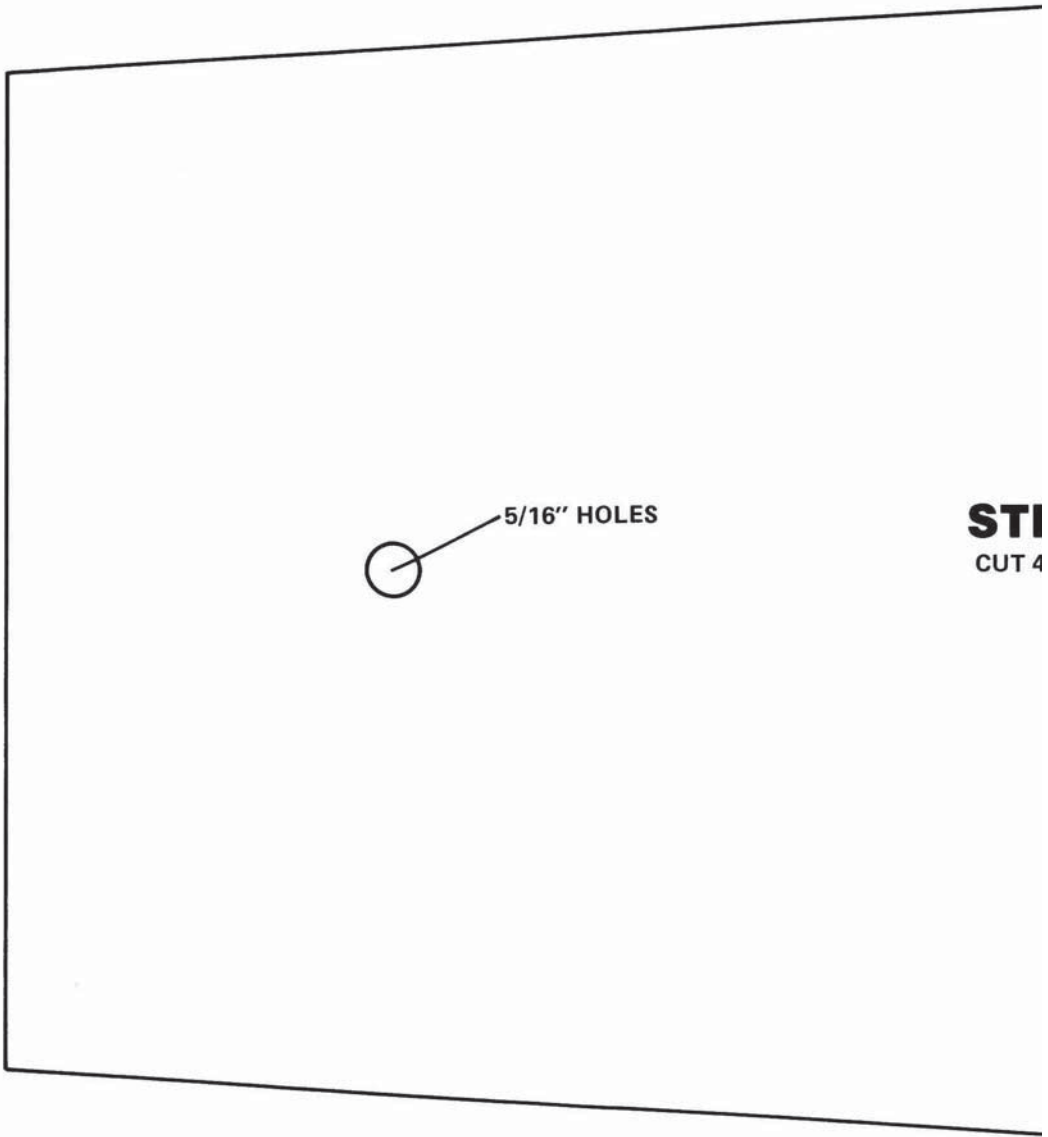




**PS**  
BLE



**MATCH HOLES TO MATCH HOLES IN  
BUCKLE AND END OF FENDER**



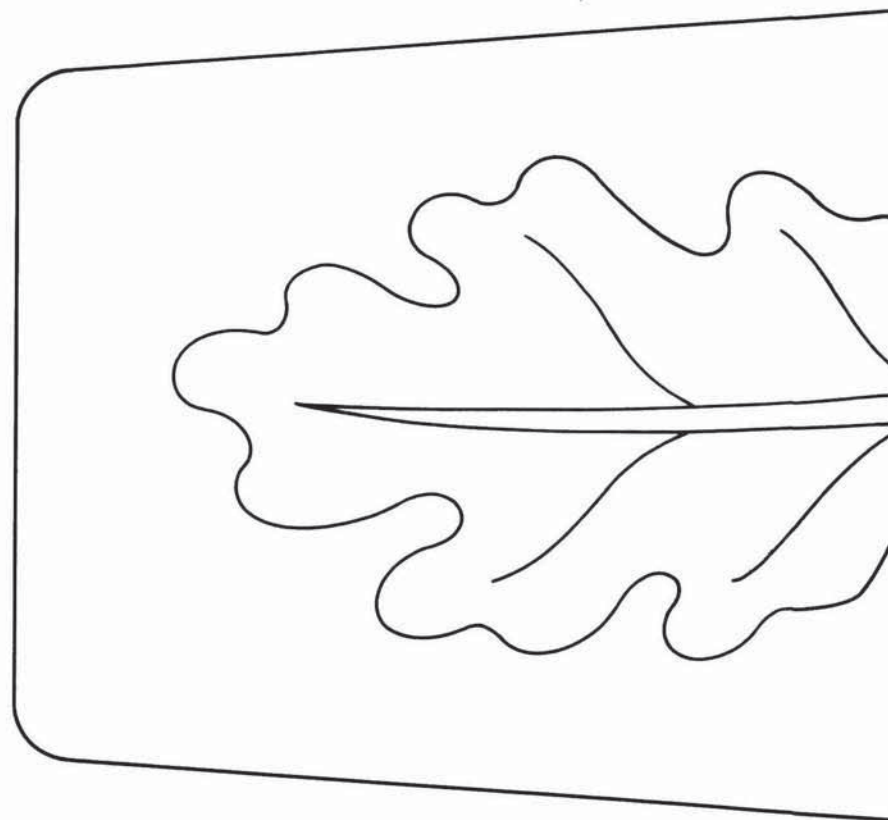
5/16" HOLES

**STI**  
CUT 4



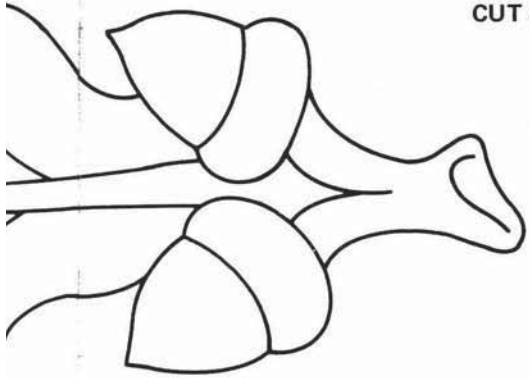
**RRUP LINING**

FROM 6 OZ. VEGETABLE  
TANNED COWHIDE



# STIRRUP COVERS

CUT 4 FROM SADDLE SKIRTING LEATHER



1/4" HOLES



**TREAD COVERS**

CUT 2 FROM 8-9 OZ. VEGETABLE  
TANNED COWHIDE



STOCK No. 4822