

BLACK POWDER BAGS AND POUCHES

BY
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tandy Est. 1919
LEATHER COMPANY®



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THOUGHTS ON HANDWORK

There are many different kinds of shooting gear. There are few patterns for making it. I enjoy making my own gear as well as my own guns. Shooting muzzleloading smoothbores, I found a decided lack of suitable gear. With historic research, available materials and functional purpose, I developed these patterns.

None of these articles are exact copies of original gear. Contemporary needs dictated their design. Any of them, well made, will be considered exceptional at our current rendezvous. All are designed for use in trailwalk or hunting situations.

Everything in this book is handmade. Designed from a time period when everything was made by hand. In earlier times, just as today, there was good craftsmanship and poor. Modern times do not require anything to be handmade. This means our reason for handmaking is not necessity but purpose and hopefully pleasure.

Too often, in historical hobbies, the words crude and authentic seem interchangeable. They are not. Crude goes as far back as mankind. So does quality. The elegance, objective and artistic merit of the Clovis type arrow point is obvious. The only arrowhead I ever found was sandstone and of such poor quality, I threw it away.

In researching gunmaking, many different levels of quality are found; cobbled-up mountain rifles to "best quality" London guns. Most of the really good guns I've examined are still in fair to excellent condition. Many of the military, hardware store and using type guns are in fair to relic condition. There are reasons for this.

Things that are well designed and well made, last. The more one expects to use an object, the more they are willing to invest in it. The more they expect and pay, the more likely it will be well cared for. Good design, quality manufacture, need for function, care and value, these criteria determine longevity. If it's good, it lasts.

The other point is pleasure, an intangible that relates to all of the above. Chances are, the lockmaker, gunstocker and the gentleman who signed his name to that "best quality" gun derived pleasure from it's manufacture. Surely the patron derived pleasure from it's purchase and use. They all contributed and they all enjoyed the quality. If their heirs didn't, chances are someone that did took possession. A long chain of appreciation kept these objects in good condition for our pleasure.

I derived a tremendous amount of pleasure from making these articles, this book, and handmaking this gear, using it and just holding it in the hands that made it. I know it will last at least my lifetime. I would like to believe that when I'm gone, it will wind up in other hands. To be enjoyed for the reasons that have brought people's handmade gear to my collection.

In the flintlock era this stuff was serious business. Your life was on the line. Now it's on the shooting line. We no longer worry about self defence or starvation when shooting our guns and rifles. We do, hopefully, expect the same functional excellence from our guns and gear. If you have shot in competition you have experienced problems with your gear or it's organiza-

tion. Just as if your life was on the line, each of these accoutrements was designed to eliminate or simplify a problem situation. Specialized organization is an ancient as well as modern practice.

Fumbling for a round ball won't cost you your life but it might ruin your day; losing the opportunity for a second shot at a nice buck or blowing your cool and your shot holding up a group on a trailwalk while you search for the knapping hammer. Organizing your gear will leave your mind open for more important things; reloading your fowler while watching the widgeon swing around for another pass, or concentrating on the trigger, sights and target, not wondering where the vent pick is.

Take your time making these projects. Read the instructions and look over the patterns before starting the work. Use your own imagination and modify the patterns to suit your own needs. Don't try to make a project tonight to use in a match tomorrow. That approach rarely works out. Build them in your mind first, it's the most valuable tool you have.

Other special tools and techniques will help tremendously. Dye and apply finish to the leather before assembly to protect it from fingerprints and smudges. Leather Balm is my preferred finish for hard leather. Always pad the bench vise jaws with heavy leather, wet and molded to fit. The bench vise is useful to hold projects when saddle stitching.

Saddle stitching is the best method of sewing and is historically accurate. The subtle decorative effect of uniform stitching will enhance any project. Tandy's Saddle Stitching Kit supplies all the needed tools at a reduced cost. Supplement these with a 1/16" multi-pronged chisel, a single-pronged 1/8" chisel filed down to 1/16" and the awl with interchangeable blades. The awl is the best tool for stitching holes, especially with hard leather. The diamond shaped holes will resist tearing. The multi-pronged tool is best for softer leathers, requiring a lot of stitching. Sharpen your tools when they need it.

Al Stohlman's THE ART OF HAND SEWING LEATHER is a very fine book and well recommended for developing professional sewing techniques.

The pleasure derived from doing professional quality work is well worth the price of the tools. Over the course of a few years and several projects the costs are negligible. When showing your work, don't be surprised if someone asks you to build them a pouch. Quality work draws attention.

This pattern book is new ground for Tandy and myself. It's all mine, good or bad. If you have gripes, praise, comments or suggestions please address them to S. D. Hughes, c/o Patrick Anderson, Tandy Leather Company, P.O. Box 791, Fort Worth, Texas 76101.

I would like to thank my father, Douglas Hughes, for the development of the Wood Spout Ball Bag and the encouragement to pursue quality handwork. I would also like to thank Patrick Anderson and the Tandy Leather Company for the opportunity to craft my imagination into reality.

TABLE OF CONTENTS



FLINT WALLET.....3



PRAIRIE SHOT POUCH.....4



STAND-UP BALL BAG5



WOOD SPOUT BALL BAG.....6



SHOOTING BAG7



ENGLISH SHOT POUCH14



HAMMER & PICK16

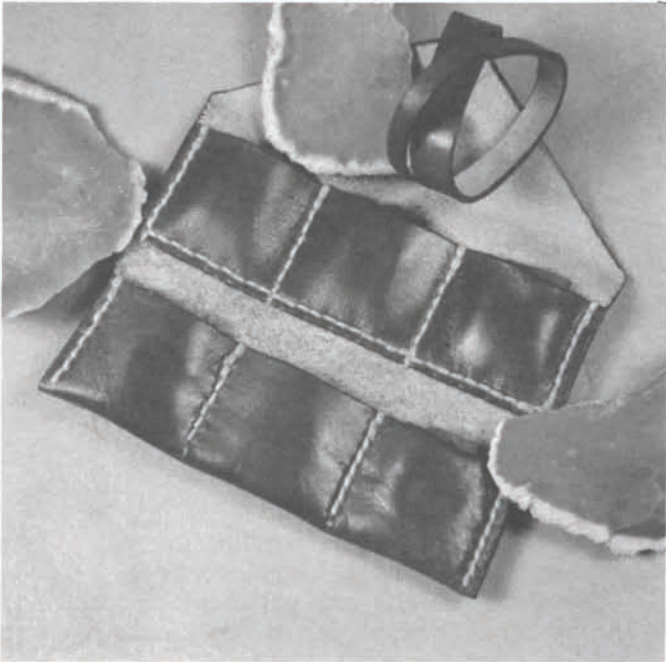
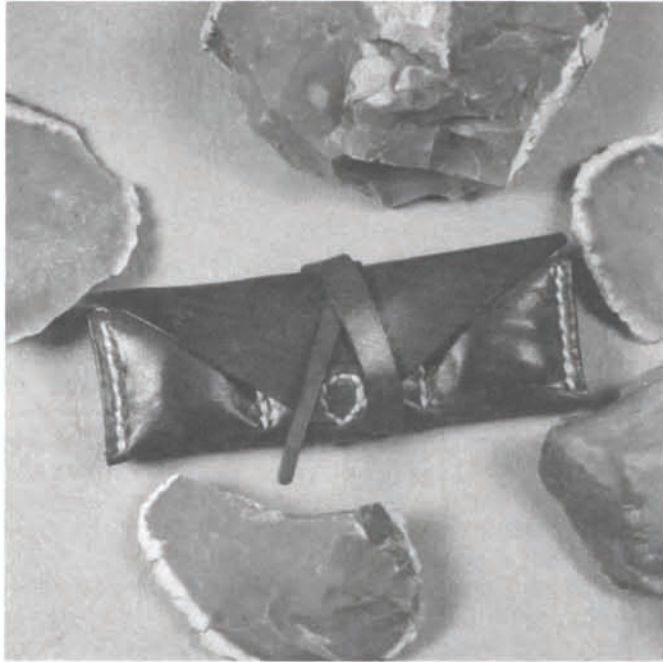
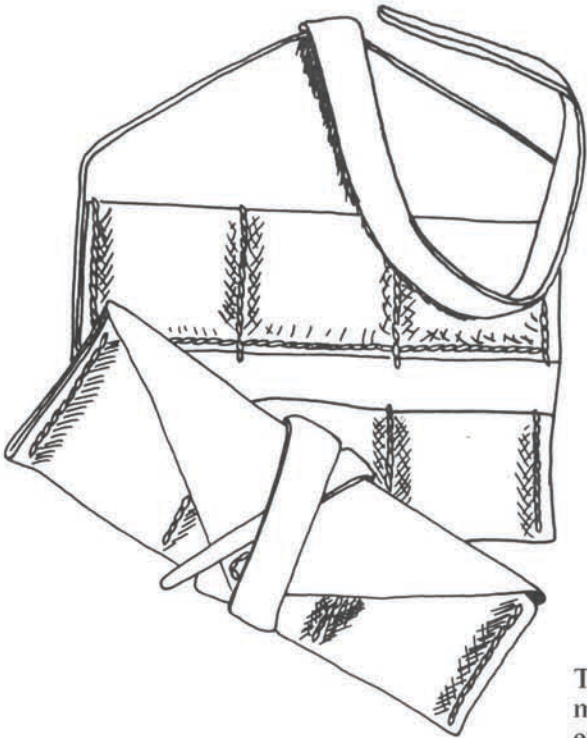


TURNSCREW & PAN BRUSH17



TOOL ROLL.....18

FLINT WALLET



This Flint Wallet is designed from an original, dated about 1790, of English manufacture. The original I used held the finest black English flints I have ever seen. The center, upper pocket held red flint leathers. When fowling afield, British gentlemen carried their flint wallet, turnscrew, priming device, ventpick and brush, powder flask and over the shoulder shot pouch. With some wadding stuffed in the pocket of their swallow tail coat, they were ready for game. This wallet is designed to accommodate up to 7/8" flints . . . allow extra size for musket flints. The closing tie is secured with a simple half hitch and makes a neat, attractive, functional piece of riggin'.

INSTRUCTIONS

TOOLS:
Super Shears or Sharp Knife
Stitching Awl or No. 0 Mini Punch
2 No. 3 Harness Needles
Straight Edge
Mallet
No. 7 Overstitch Wheel
Wing Dividers

MATERIALS:
4-5 oz. Natural Tooling Leather
Craftsman Cement
Linen Thread or Artificial Sinew
Pro Dye
Mink Oil or Lexol
Super Shene or Atom Wax

STEP 1. Transfer patterns to tracing film to preserve the paper patterns. Trace patterns onto leather. Cut out parts with shears or sharp knife.

STEP 2. Dye all parts with Pro Dye and apply Mink Oil or Lexol and rub in well. Apply Super Shene or Atom Wax and let dry.

STEP 3. Moisten fold line on flesh side and score fold line with dull side of knife. Fold over, flesh sides together, and set by tapping flat with a mallet.

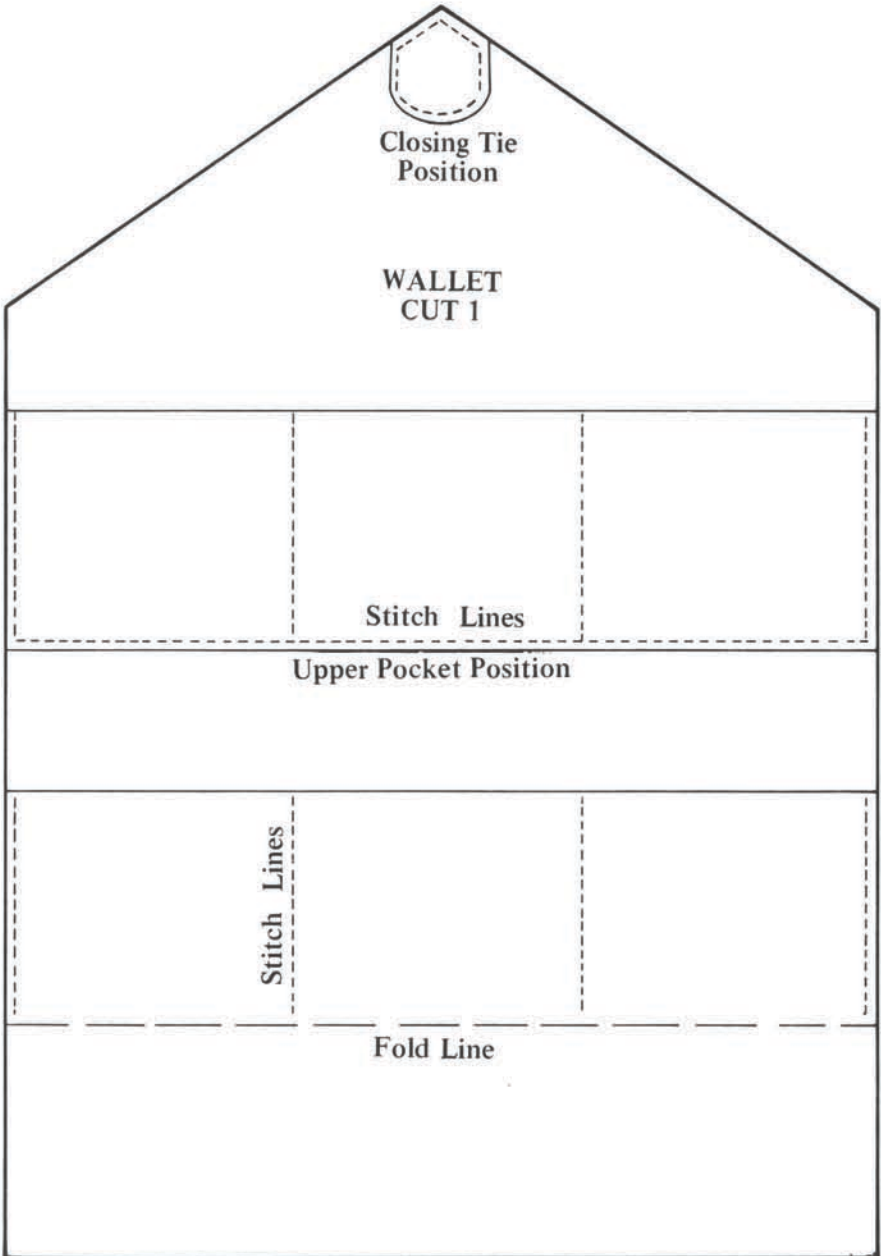
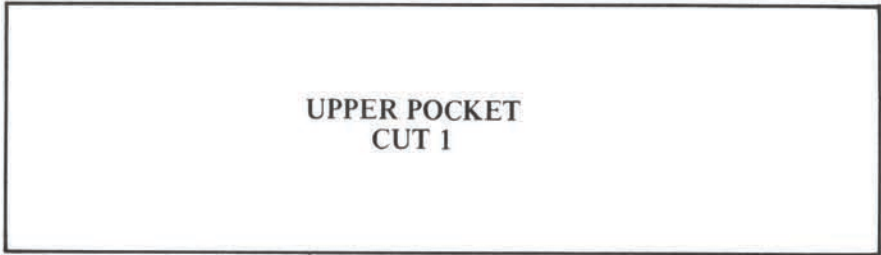
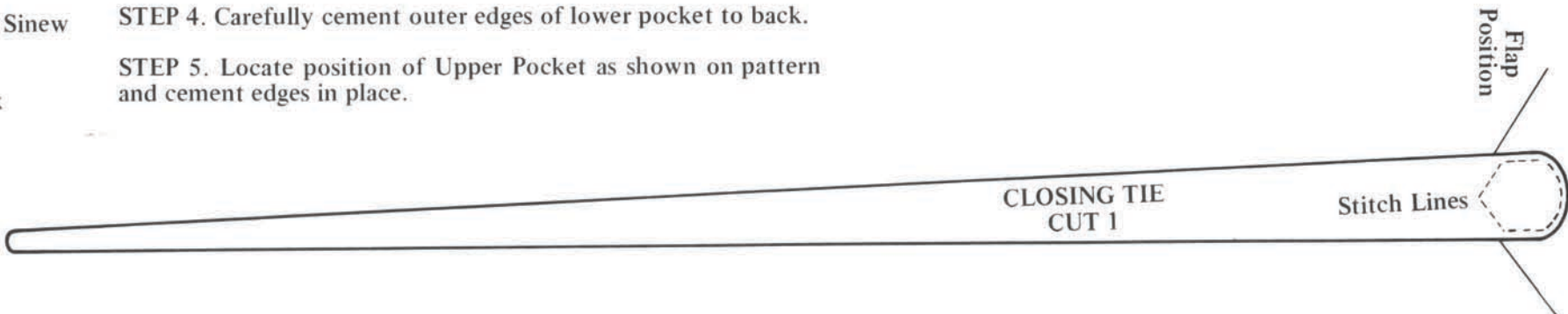
STEP 4. Carefully cement outer edges of lower pocket to back.

STEP 5. Locate position of Upper Pocket as shown on pattern and cement edges in place.

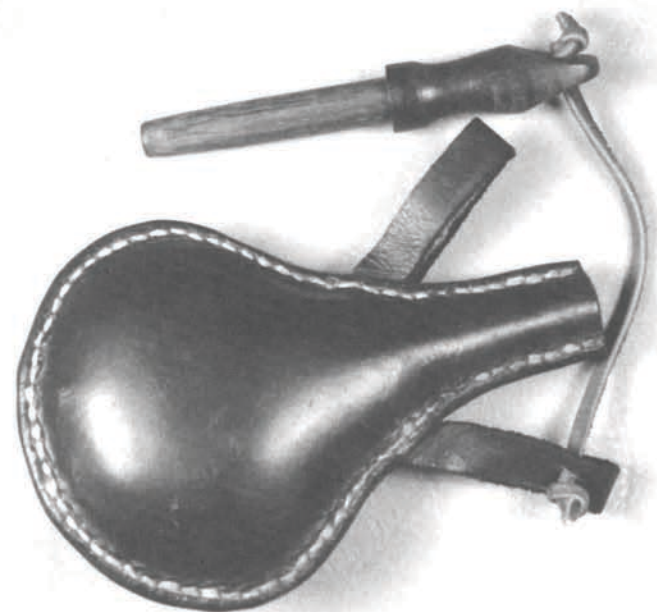
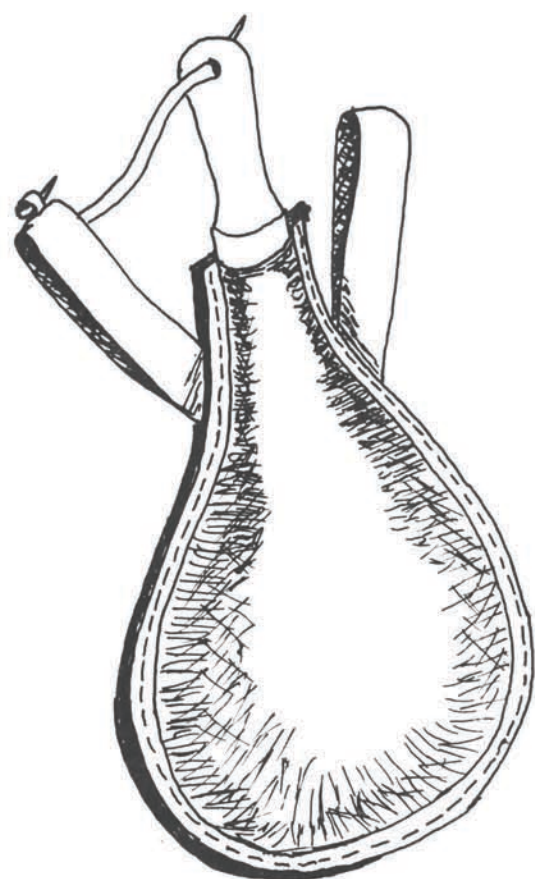
STEP 6. Saddle Stitch pockets in place following stitch lines marked on pattern.

STEP 7. Stitch Closing Tie in place on flap of wallet.

NOTE: Be careful when breaking in the pockets to accept flints. Don't cut the stitching with sharp flints.



PRAIRIE SHOT POUCH



HANGING STRAPS
CUT 2
4-5 oz. Natural Tooling Leather
5" Long
1/2" Wide

All travelers of the western prairies; traders, trappers and immigrants took advantage of abundant small game with smoothbored guns. This authentic style shot pouch is of the type made and used in the West. It is designed to carry a couple of pounds of birdshot, buckshot or small round balls.

Equal volumes of shot and powder was, and is, a rule of thumb for muzzle-loading shotguns. The straps allow convenient tilting, and the small mouth allows easy pouring of shot into your powder measure.

If made of rawhide, the pouch can be decorated with painted Indian designs. Made of hard leather, it can be fairly rough as made in the mountains or finished nicely with beveled, black dyed edges as if by the saddle maker. This authentic pouch works great and takes just a few hours. Be sure to tie the stopper to one of the straps with a thong so you don't lose it.

INSTRUCTIONS

TOOLS:

Super Shears or Sharp Knife
Stitching Awl
1/2" Drill
2 No. 3 Harness Needles
Stitching Groover
No. 7 Overstitch Wheel
3/8" X 8" Dowel

MATERIALS:

8-7 oz Natural Tooling Leather
Rawhide
4-5 oz. Natural Tooling Leather
1/2" X 3" Wooden Dowel
1" Square X 2 1/2" Hardwood
Handle
Artificial Sinew
Craftsman Cement
Pro Dye
Finish

STEP 1. Transfer patterns to tracing film to preserve the paper patterns. Trace patterns onto leather. Cut out parts (as indicated on patterns, two Pouch Bodies from 7-8 oz. leather and two Straps from 4-5 oz. leather) with shears or sharp knife.

STEP 2. Dye all parts with Pro Dye and let dry. Apply finish and let dry.

STEP 3. Apply cement to last 1/2" on each end of each strap, on flesh sides. Fold Straps over, flesh sides together, and adhere, forming two loops.

STEP 4. Apply cement to all edges except top of spout, on flesh sides of Pouch Bodies. Lay cemented ends of Straps in position on flesh side of one Pouch Body as shown on pattern. Adhere the Pouch Bodies together, aligning edges, flesh sides together with Straps in between. Tap all edges with a mallet.

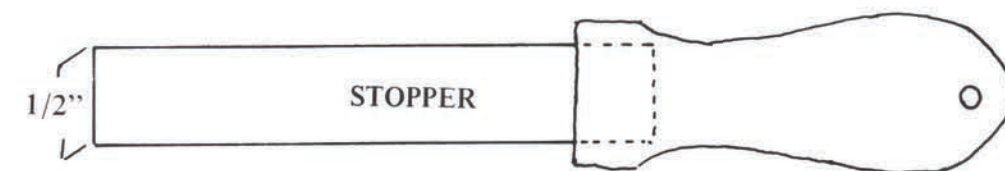
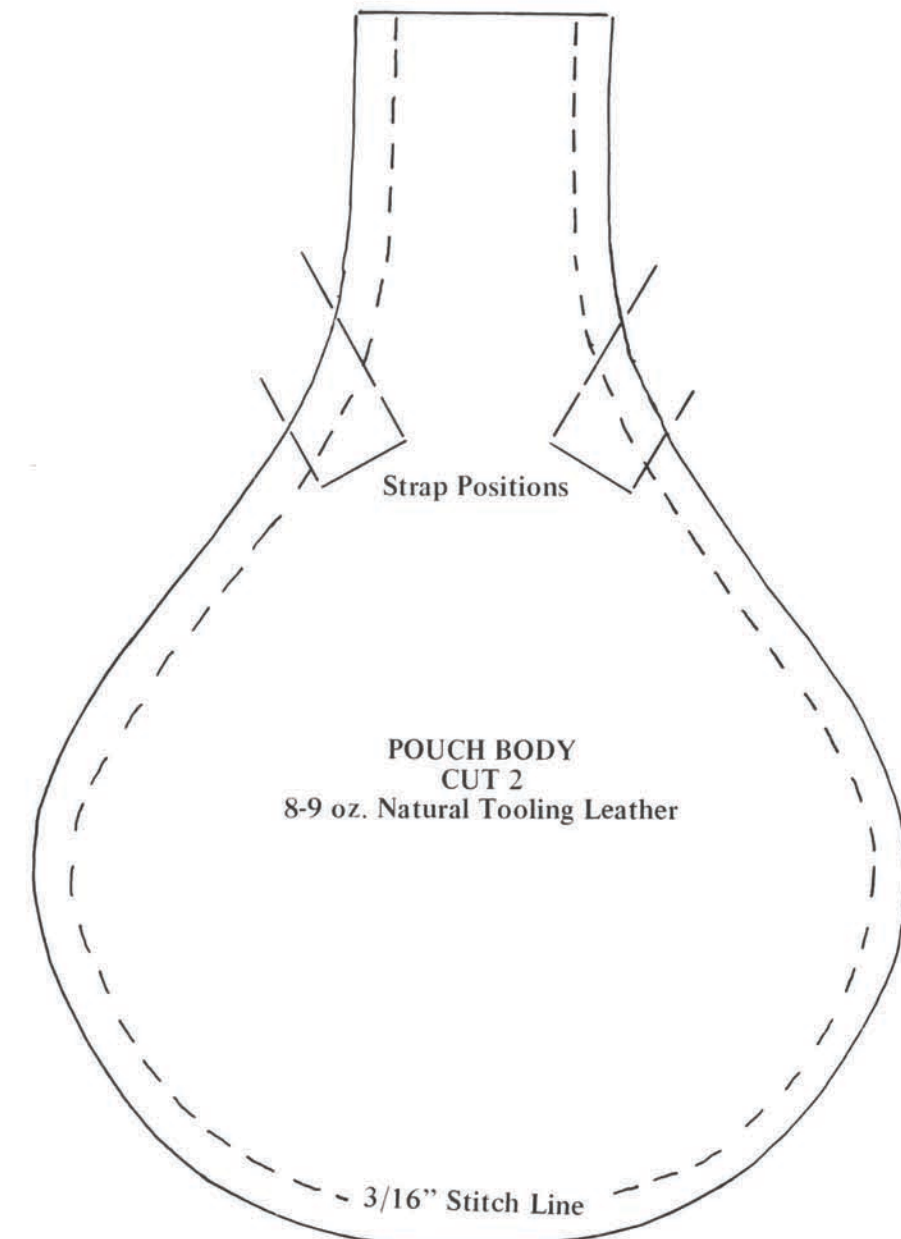
STEP 5. Cut a stitching groove 3/16" from edge around both sides of Pouch Body following stitch line shown on pattern. Saddle Stitch Pouch Body together.

STEP 6. Soak the Pouch in water until the leather is very wet inside and out.

STEP 7. Fill with shot by stuffing the shot in with a 3/8" wooden dowel. Stuff very full, molding a swell in the Pouch with your hands. A funnel makes it easier to fill.

STEP 8. Fit the 1/2" stopper dowel into the open neck and let the Pouch dry for a few hours.

STEP 9. Empty the shot out and let the pouch dry completely so that it hardens and shrinks with the end open.



STOPPER INSTRUCTIONS

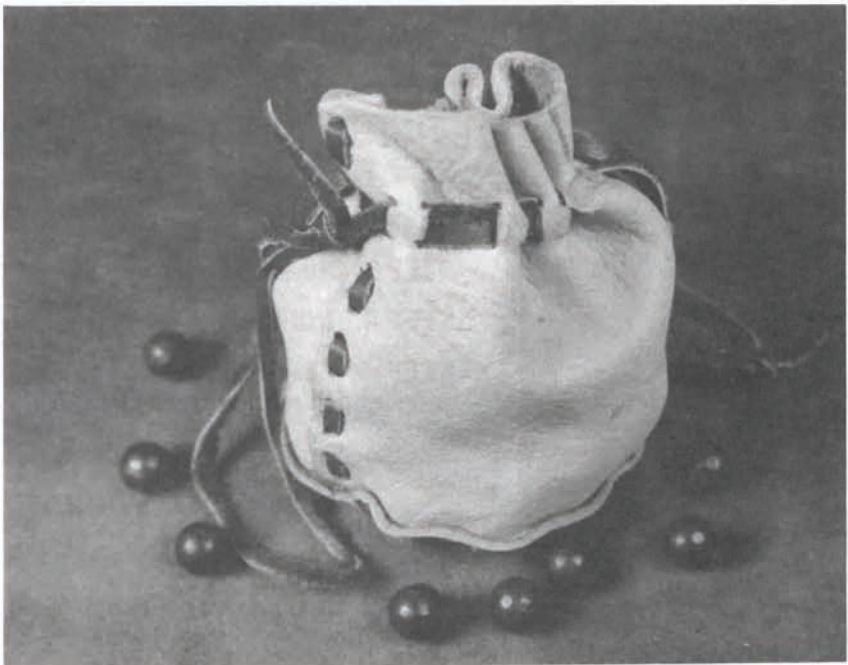
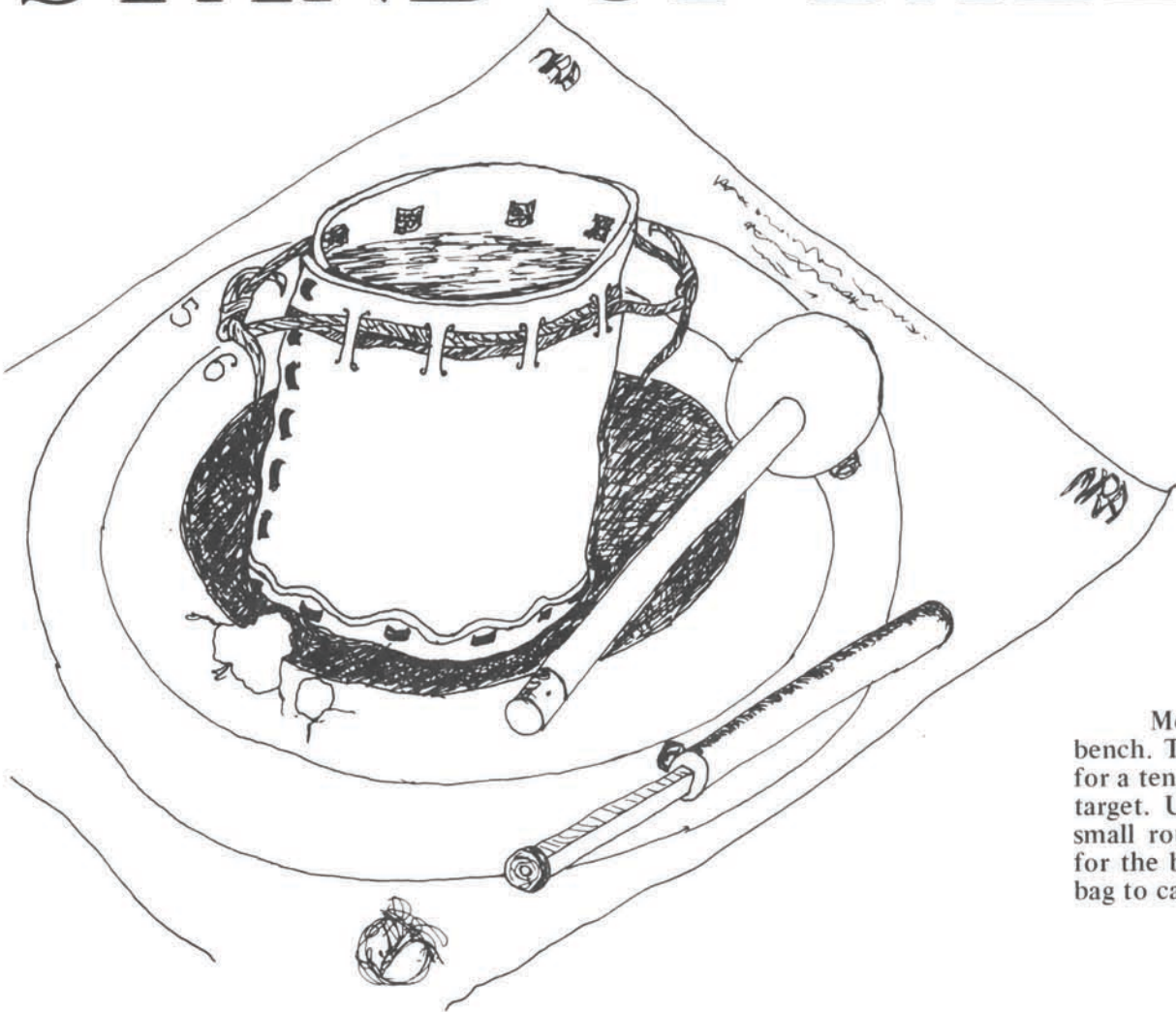
STEP 1. Mark the center of one end of the handle material and drill 1/2" hole, 3/8" deep.

STEP 2. Glue the dowel into the hole in the handle and let glue dry.

STEP 3. Shape the handle with a file by chucking in an electric drill held in a vise and filing as it turns.

STEP 4. Drill thong hole, stain and finish wood.

STAND-UP BALL BAG



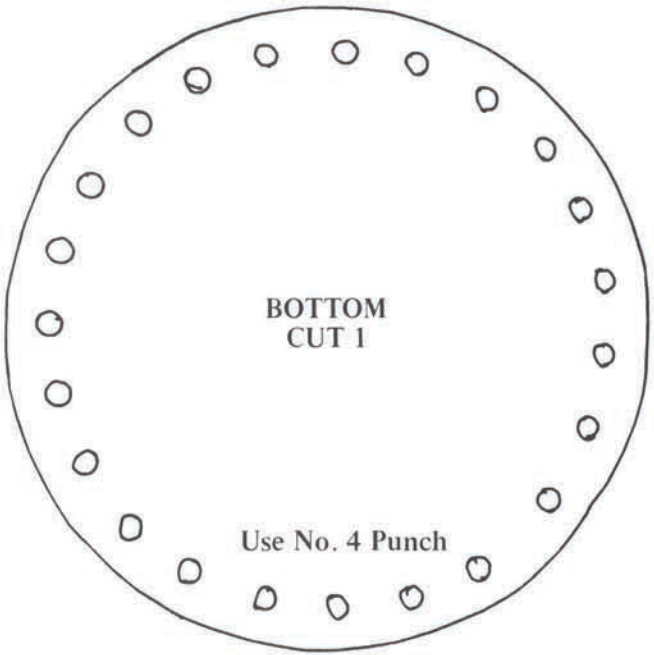
Most of my serious shooting is done at the range, loading from the bench. This bag will stand, open mouthed, for easy access. Ten round balls, for a ten shot match, placed in the bag, will free your mind for the sights and target. Useful and easy to make, the bag draws closed and won't leak even small round balls. I cut all my own lace with a Lace Maker and the circle for the bottom can be the hole you need to start cutting lace. Make an extra bag to carry your gold nuggets in.

INSTRUCTIONS

- TOOLS:**
Super Shears
Sharp Knife
No. 4 and 2 Mini Punches or Rotary Punch
Latigo Life-Eye Needle
- MATERIALS:**
Buckskin Scraps or Other Soft Leather
1 Lace 24" X 3/16"
2 Laces 18" X 3/16"
Craftsman Cement

- STEP 1.** Transfer patterns to tracing film to preserve the paper patterns. Trace patterns onto leather and cut out parts with shears.
- STEP 2.** With No. 4 Punch, punch holes around Bottom and down one long edge of the Bag. There should be 23 holes around the circle and 24 holes in the Bag, (one hole overlaps at seam).
- STEP 3.** Punch drawstring holes with No. 2 punch and cut slits between holes with a sharp knife.
- STEP 4.** Mark 3/8" overlapping seam on one end of the Bag and cement ends together, grain sides up, forming a tube.
- STEP 5.** Mark and punch seam holes in both layers of leather with No. 4 punch.

- STEP 6.** Begin lacing from the inside of the Bag in the second hole from the top. Lace back up through first hole then in and out holes down the side and around the bottom with 24" piece of lace.
- STEP 7.** When you finish the bottom, come back through the seam and tie off on the inside of the Bag.
- STEP 8.** Lace one drawstring (18" laces) through the slits in the top of the Bag all the way around and tie the ends together in a knot. Lace other drawstring through from opposite side and tie ends in a knot.



◊ Overlaps hole "A"

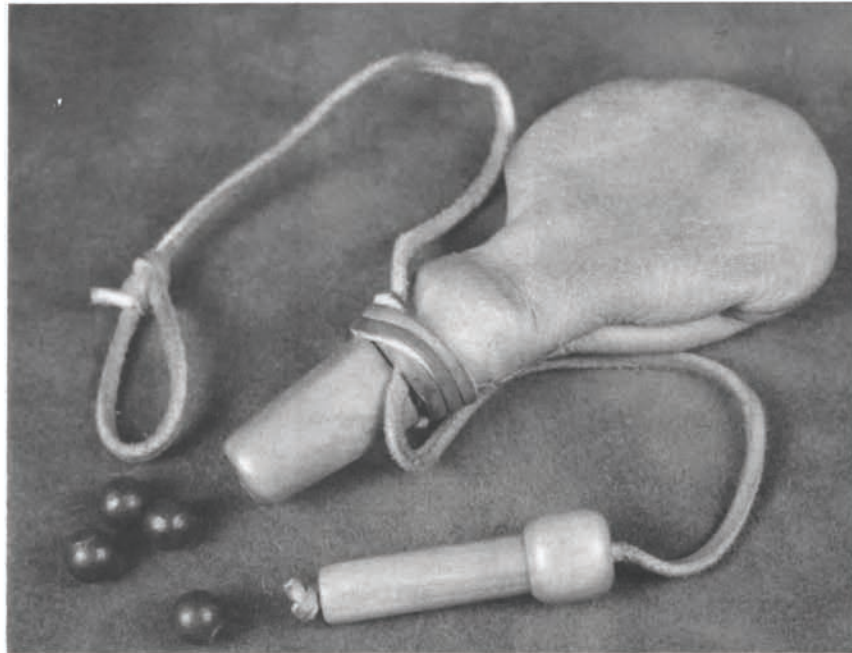
Use No. 4 Punch

BAG BODY
CUT 1

Use No. 2 Punch

◊ Hole "A"

WOOD SPOUT BALL BAG



This unique, handy round ball pouch feeds your ammo one at a time, just as you load your rifle. Designed for .45 caliber or smaller round balls; swaged sprueless .50 calibers will also feed through the spout. Tip the pouch up and out rolls a ball.

Made entirely of scrap materials with hand tools, you might have to buy a thong. Any of the wood parts can easily be lathe turned. You can be proud to show off this pouch on the trailwalk.

TOOLS:

Small Round File
 $\frac{1}{2}$ " Round File
 $\frac{1}{8}$ " Drill
 $\frac{1}{2}$ " Drill
 Hand or Electric Drill
 2 No. 3 Harness Needles or
 Awl for All
 Super Shears

MATERIALS:

Buckskin Scraps
 24" Indian Tan Lace
 $\frac{1}{2}$ " X 2" Wooden Dowel
 (Stopper)
 1" X $2\frac{1}{2}$ " Broomstick
 (Spout)
 $\frac{3}{4}$ " Wood Cube
 (Stopper Top)
 Waxed Thread or Artificial Sinew
 Craftsman Cement
 White Glue or Wood Glue

INSTRUCTIONS FOR STOPPER

- STEP 1. Mark the center of one end of the $\frac{3}{4}$ " cube and drill $\frac{1}{2}$ " hole $\frac{3}{8}$ " deep.
 STEP 2. Drill $\frac{1}{2}$ " dowel through center with $\frac{1}{8}$ " drill.
 STEP 3. Glue cube over one end of the dowel with white glue or wood glue.
 STEP 4. Drill the $\frac{1}{8}$ " hole from Step 2, completely through the cube.
 STEP 5. Shape the top of the stopper into an octagon, then round with a file and smooth while turning in a drill chuck.
 STEP 6. Sand, stain and finish.

INSTRUCTIONS FOR WOOD SPOUT

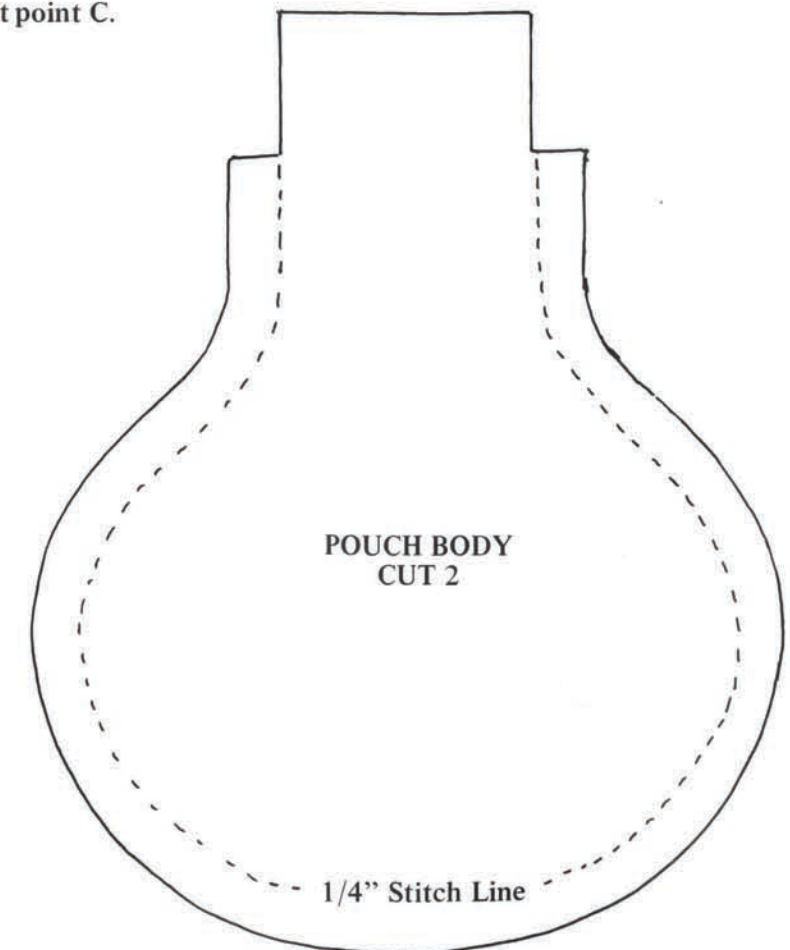
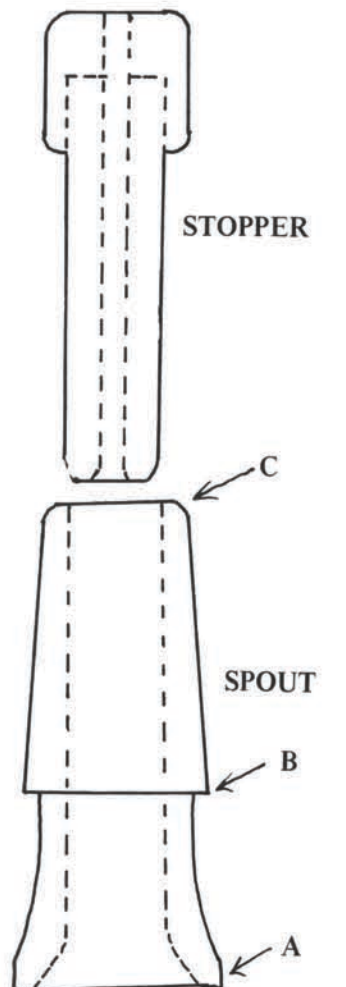
- STEP 1. Square both ends and mark the centers of the $2\frac{1}{2}$ " broomstick.
 STEP 2. Drill halfway through from each end with $\frac{1}{2}$ " drill. Straighten hole with a round file.
 STEP 3. Mark one end with a $\frac{3}{4}$ " circle (point C) and file to a taper from full size at point B. (See illustration at right.)
 STEP 4. Just below point B, file a $\frac{1}{16}$ " shoulder down all the way around.
 STEP 5. Taper shoulder (B) back to full size at point A. (See illustration at right.)
 STEP 6. Bevel inside of spout at point A and round off outside of spout at point C.
 STEP 7. Sand, stain and finish.

INSTRUCTIONS FOR LEATHER POUCH

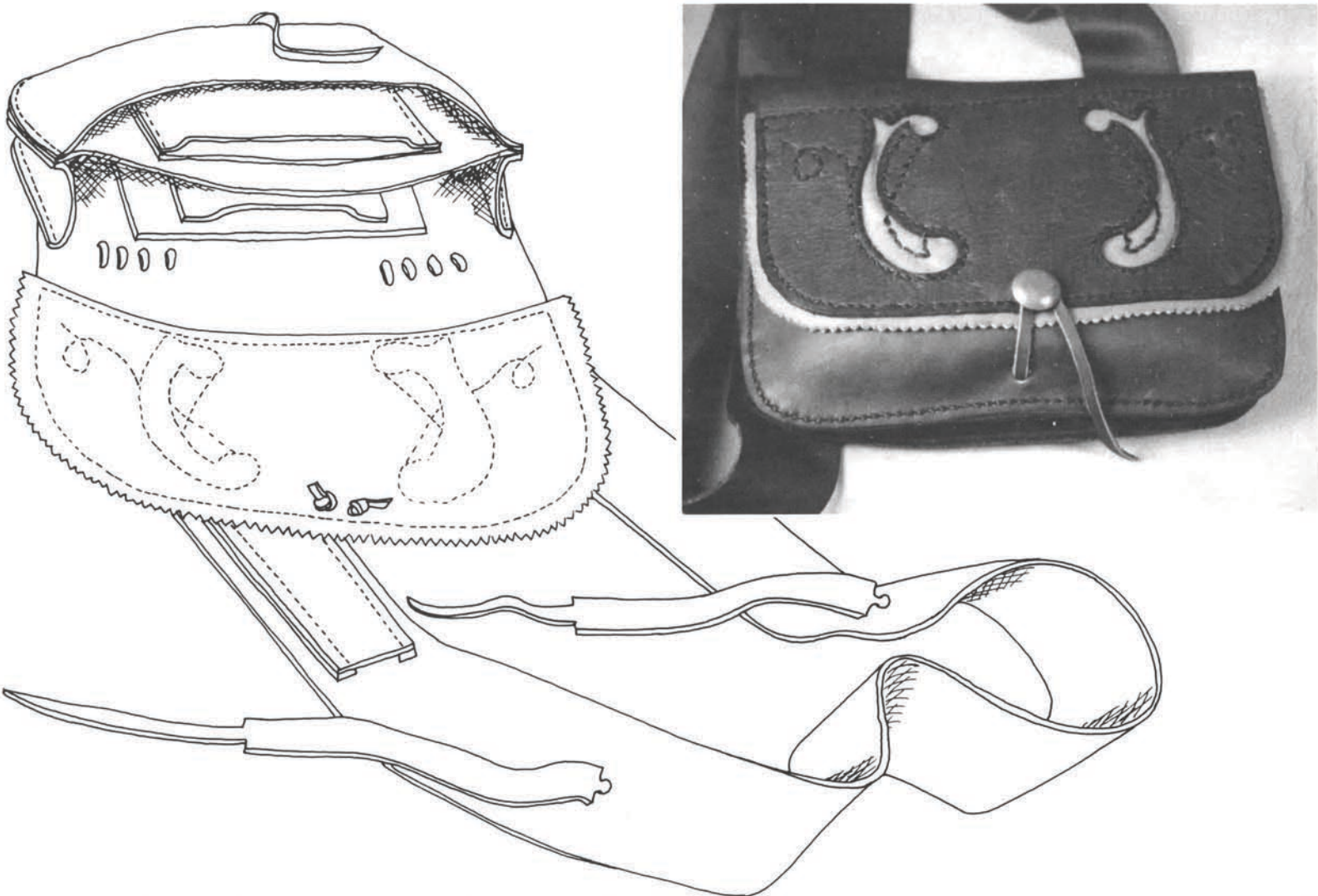
- STEP 1. Trace pattern for body onto tracing film to preserve the paper patterns. Trace the pattern onto buckskin and cut out two.
 STEP 2. Carefully apply cement around the edges of the bottom of the body on grain side. Apply cement only to edges with stitch line shown on pattern. Do not apply cement to top edges of body. Adhere the two body pieces, grain sides together.
 STEP 3. Mark stitch line and sew around the body using a saddle stitch or awl for all. Double stitch the first and last stitches for strength.
 STEP 4. Turn body grain side out using a dowel for a poker. This is pretty tough to do but keep at it and don't rip the seam.

ASSEMBLY INSTRUCTIONS

- STEP 1. Cement leather top of body to tapered end (B to A) of spout.
 STEP 2. Beginning at shoulder, leaving about 12" of thong hanging, wrap thong tightly around leather and spout three times. As you are wrapping catch beginning 12" of thong under the wraps. Thread other end of thong up under wraps and pull tight. (See drawing at left.)
 STEP 3. Thread this end of thong through stopper from top and tie a knot in the end. You can tie a loop in the other end for hanging the pouch from belt or bag.



SHOOTING BAG



This shooting bag is designed with purpose. The maximum amount of usable space with the smallest overall size, made and decorated in a traditional handmade 18th century style.

All outside seams are saddle stitched for durability, rainproofing and decorative appearance. The weight of the flap backing and flap stitching help to keep the flap closed. The thong and button provide a means of locking the flap closed for transporting, rainy weather or crawling through the brush.


The wide strap, with powder horn and knife sheath attached, distributes the weight and keeps all your gear together.

Black powder shotgunning is a great sport and this design allows for loading by feel. The first large compartment is for the bulky cushion wads. The two smaller wad pockets are for overpowder and overshot wads.

The main section of the bag is where I carry my round ball pouch, tool roll, cleaning solvent and other bulky shooting gear. The cap tin pocket is for its namesake or a tin of pre-cut patches as I carry for my flintlock. The tool pocket holds my cleaning jag, ball puller, corkscrew and other needed gear that would be lost in the main section.

Make the copper button by scribing a circle on a piece

of flat copper sheet. Hacksaw and file round. Make a half dome depression in the end grain of a piece of wood with the ball end of a large ball pein hammer. Lay the copper on the depression. Place hammer ball pein on the copper, and strike with another hammer. Solder a bent cotter pin to the inside and polish up the works. (See illustration.)



If you don't need all this storage space inside the bag, leave off the front and wad pockets. I find it more important to divide the gear for easy access.

Two alternate flap designs are offered. Both are historically correct. The single central cut-out designs are easier to make. The star pattern can be made without the wool, using a contrasting shade of leather for the flap backing. This makes a very good looking bag but use fairly heavy leather to give the flap weight and body.

Take your time, practice with the tools and stitching before attempting the more difficult parts. Do a nice job and it will be passed down from generation to generation with your gun.

- TOOLS:**
- Super Shears
 - 4 prong 1/16" Stitching Chisel
 - Single-prong 3/32" Thonging Chisel, filed to 1/16" Width
 - 3 No. 3 Harness Needles
 - Stitching Awl
 - Sharp Knife
 - Long Straight Edge
 - Ball Point Pen
 - No. 2 Mini Punch
 - Wing Dividers
 - Mallet
 - No. 6 Overstitch Wheel
 - Pinking Shears, Optional

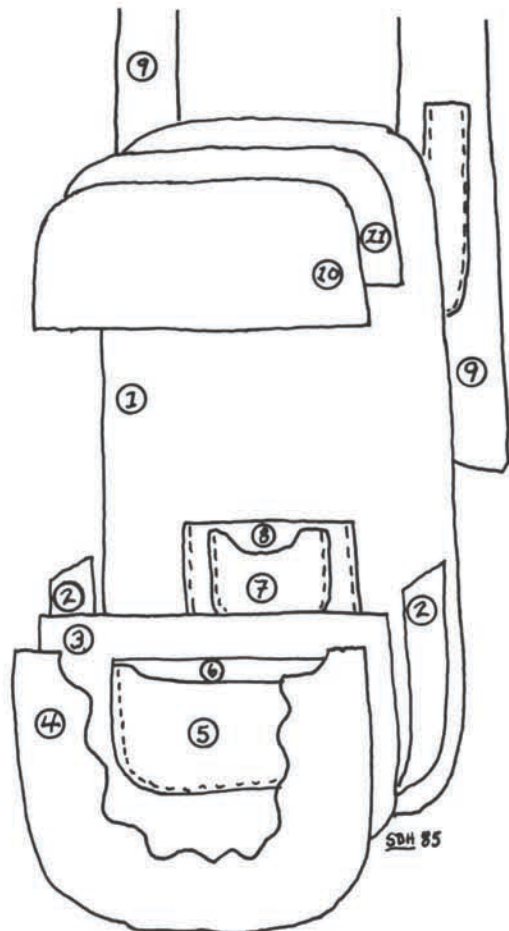
- MATERIALS:**
- 7 to 10 sq. ft., 4-5 oz. Blacksmith Sides
 - 6" X 12" Buckskin
 - 6" X 12" Tight Woven Wool, Bright Color
 - 25 yds. Waxed Thread or Artificial Sinew
 - Black Pro Dye and Felt Dauber
 - Craftsman Cement
 - Copper, Brass or Horn Button

PARTS LIST

- All parts are named and numbered on the patterns on the next several pages. Transfer all patterns to tracing film to preserve the paper pattern before transferring patterns to materials to be cut out. Cut all parts as specified in this list and punch holes where indicated.
- NO. 1 PATTERN, BACK AND FLAP, page 8:**
Layout this pattern on the best part of the Blacksmith leather, for appearance and strength, and cut out with shears. Mark position of Tool Pocket (No. 8). Mark and punch holes with No. 2 Mini Punch.
- NO. 2 PATTERN, GUSSET, page 13:**
Layout with a straight edge, 1 1/4" X 22, on Blacksmith leather. Cut slightly longer than needed for a perfect fit, you can trim excess later. Cut out with shears or a sharp knife and straight edge.
- NO. 3 PATTERN, CENTERPIECE, page 10:**
Cut out of Blacksmith with shears. Mark where Wad Pockets (Nos. 5 & 6) are sewn to the Centerpiece.
- NO. 4 PATTERN, FRONT, page 10:**
Cut out of Blacksmith leather with shears. Mark position of hole for Closure Thong and punch with No. 2 Mini Punch.
- NO. 5 PATTERN, WAD POCKET, page 11:**
Cut out of Blacksmith leather with shears.
- NO. 6 PATTERN, WAD POCKET, page 11:**
Cut out of Blacksmith leather with shears. Same as Wad Pocket No. 5 but with straight top.

- NO. 7 PATTERN, CAP TIN POCKET, page 13:**
Cut out of Blacksmith leather with shears.
- NO. 8 PATTERN, TOOL POCKET, page 13:**
Cut out of Blacksmith leather with shears. Mark position of Cap Tin Pocket (No. 7).
- NO. 9 PATTERN, STRAP, page 13:**
Layout with straight edge along center back of Blacksmith leather, 2" X 52". If leather is not long enough, you may make the strap in two pieces and stitch them together.
- NO. 10 PATTERN, LEATHER FLAP BACKING, page 11:**
Cut out of Buckskin leather with shears.
- NO. 11 PATTERN, WOOL FLAP BACKING, page 11:**
Cut same as Leather Flap Backing (No. 10) out of close woven, bright colored wool.
- NOS. 12 & 13 PATTERNS, POWDER HORN STRAPS, page 13:**
Layout with straight edge, 1/2" X 15" on scrap Blacksmith leather. Cut out with shears or sharp knife and cut 2.
- NO. 14, BUTTON:**
Made from metal or Horn.
- NO. 15, LACE:**
1/4" X 18" cut from Blacksmith leather with shears or lace maker.

PREPARATION FOR ASSEMBLY



STEP 1. DYE ALL EDGES: Cut all parts out as indicated in the Parts List. Dye all edges black with Pro Dye and a felt dauber. Let dry.

STEP 2. CEMENT WAD POCKETS: Apply cement to all edges except the top of the Wad Pocket (No. 5), on flesh side and around corresponding edges of Wad Pocket (No. 6), on grain side. Adhere Wad Pocket (No. 5) to Wad Pocket (No. 6), grain sides up, aligning the edges. With wing dividers, scribe a guide line, 1/8" from the edge, around side and bottom edges of Wad Pocket (No. 5).

STEP 3. ATTACH WAD POCKETS TO CENTERPIECE: Locate position of Wad Pockets (Nos. 5 & 6) on Centerpiece (No. 3) as shown on pattern. Apply cement to all edges except top of Wad Pocket (No. 6), on flesh side. Adhere in place on Centerpiece (No. 3). Punch stitching holes along scribed line on Pocket (No. 5) with multi-prong stitching chisel, using single-prong chisel or awl around corners. Using a running stitch, stitch Pockets (Nos. 5 & 6) to Centerpiece (No. 3). Double stitch first and last stitches for strength.

STEP 4. ATTACH CAP TIN POCKET TO TOOL POCKET: Apply cement to all edges except top of Cap Tin Pocket (No. 7), on flesh side. Locate position of Cap Tin Pocket (No. 7) on Tool Pocket (No. 8) as shown on pattern. Adhere Cap Tin Pocket (No. 7) in place on Tool Pocket (No. 8), grain sides up. Scribe a line around side and bottom edges of Cap Tin Pocket (No. 7), 1/8" in from edges. Punch holes and stitch together as in Step 3.

STEP 5. ATTACH POCKETS TO BACK & FLAP: Apply cement to all edges except top on flesh side of Tool Pocket (No. 8). Locate position of Tool Pocket (No. 8) on Back & Flap (No. 1) as shown on pattern, and adhere in place, flesh sides together. Scribe a line around side and bottom edges of Tool Pocket (No. 8), 1/8" in from edges. Punch holes and stitch together as in Step 3.

STEP 6. CEMENT FRONT TO CENTERPIECE: Apply cement to all edges except top of Front (No. 4), on flesh side, and to corresponding edges on grain side of Centerpiece (No. 3). Adhere Front (No. 4) to Centerpiece (No. 3), grain sides up, aligning edges. Scribe a guide line around side and bottom edges of Front (No. 4), 1/4" in from the edges. Punch stitching holes along guide line, through both layers of leather. Count the number of holes needed to go around the seam; 112 for my bag. You will want the same number of holes on both sides of the Gusset (No. 2) and Back & Flap (No. 1).

STEP 7. PUNCHING HOLES IN BACK & FLAP: Lay Front Assembly (Front & Centerpiece) over back part of Back & Flap (No. 1), flesh sides together, with edges carefully aligned. NOTE: At fold of Back & Flap (No. 1), Back is slightly wider than Front. The stitching holes will be farther in on this part than 1/4"; this makes the bag more rainproof. Carefully keeping the Front and Back edges aligned, place the multi-pronged punch in holes in Front and punch through the Back so that you have the same number of holes in both pieces. Punch all the way around the Front.

STEP 8. PUNCH HOLES IN GUSSET: With wing dividers, scribe a guide line down both long edges of Gusset (No. 2), 1/4" from edges. Starting at one end, punch the same number of holes down both long edges of Gusset (No. 2) as in Front and Back, 112.

STEP 9. STITCH GUSSET TO FRONT ASSEMBLY: Align stitching holes in one end of Gusset (No. 2) with holes in one side of Front Assembly, flesh sides together, and with edges aligned. Using 6 ft. of thread with a needle on each end, begin stitching in second from the top holes, in all three pieces (Front, Centerpiece and Gusset). Pull thread through until you have an equal amount on each side of the hole. Saddle stitch back up through the first hole, then back through the second hole again. Stitch down through the third and on around the Front of the bag. Don't cement this seam. It's easier to align the stitching holes by putting an extra harness needle through matching holes about ten holes ahead as you progress around the seam. Double stitch through last hole. If necessary, trim ends of Gusset off even with the top of the Front and re-dye the edges.

DECORATING THE FLAP

Now all the stitching holes needed for assembly have been punched. Layout, cutting and stitching tools are familiar to you and is well practiced. It's time to try the fancy work. This can be done after the bag is assembled, but it is much easier without maneuvering the bulk of the bag.

STEP 1. CUTTING THE DESIGN IN THE FLAP: Make a tracing of the flap design of your choice (three to choose

from). Transfer the design onto light weight cardboard. Cut out the design with sharp knife or shears. Lay template over Flap and trace off design on the leather. I use a ball point pen and cut away the ink when I cut out the design. Very carefully cut the design out of the leather with a sharp knife and/or shears.

STEP 2. BACKING FOR FLAP: Cement the Leather Flap Backing (No. 10) and Wool Flap Backing (No. 11) together, aligning the edges.

STEP 3. ATTACH FLAP BACKING TO FLAP: Position Flap Backings (Nos. 10 & 11) on flesh side of Flap (No. 1) and mark where the straight, top edge of the Backing falls on the flap. Turn over and lightly mark where cut-out falls on wool. Make sure these marks won't show after assembly. Apply cement to the wool everywhere except areas that will show through the cut-outs. Apply cement to flesh side of Flap (No. 1). Adhere Wool to flesh side of Flap by aligning the straight edge of Backing with line marked on flap. Tap all over with a mallet to assure adherence.

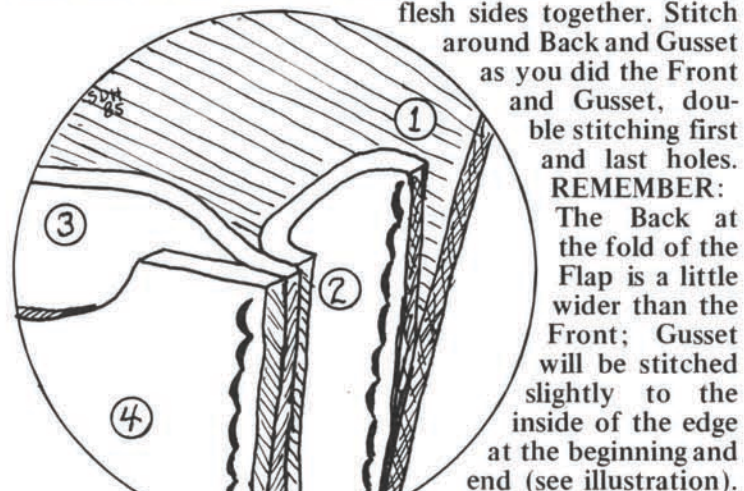
STEP 4. PUNCHING HOLES IN FLAP: Scribe a guide line across straight edge of Backing, 1/8" from edge and beginning and ending 1/4" from edge of Flap (No. 1). Punch stitching holes along this line. Turn Flap, grain side up and scribe a guide line 1/8" from edges around the outside of the Flap, beginning and ending even with punched line of holes. Punch holes around rest of Flap.

STEP 5. STITCHING FLAP: Now scribe a line 1/8" from edges of cut-outs on Flap of bag. Mark stitches with an over stitch wheel. Punch holes with single-prong chisel. Saddle stitch around cut-outs first. Next, saddle stitch around the edge and across top of Flap. Be careful not to pull these stitches too tight as you don't want the edges of the Backings to pucker.

FINAL ASSEMBLY

The two parts of the bag are finished. Now all that's left is to assemble them, attach the strap (with knife sheath), button and powder horn straps.

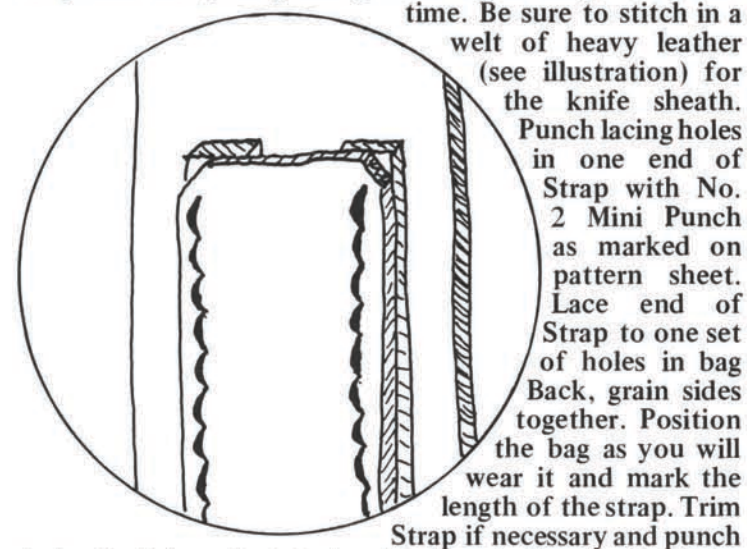
STEP 1. ATTACH BACK TO GUSSET: Align holes in one end of free side of Gusset with first hole in Back, flesh sides together. Stitch around Back and Gusset as you did the Front and Gusset, double stitching first and last holes.



REMEMBER: The Back at the fold of the Flap is a little wider than the Front; Gusset will be stitched slightly to the inside of the edge at the beginning and end (see illustration).

STEP 2. TRIM FLAP BACKING: After assembly, trim the edge of the Flap Backing so that 3/8" is showing around the edge of the Flap. I borrowed a pair of pinking shears from a neighbor who sews a lot. I sharpened them for her in trade for the loan. They needed sharpening to cut the wool and buckskin cleanly. Practice using the pinking shears on some scrap before tackling the finished edge.

STEP 3. STRAP: If you're going to attach a knife sheath or pocket for your priming horn to the strap, now is the time. Be sure to stitch in a welt of heavy leather (see illustration) for the knife sheath.



Punch lacing holes in one end of Strap with No. 2 Mini Punch as marked on pattern sheet. Lace end of Strap to one set of holes in bag Back, grain sides together. Position the bag as you will wear it and mark the length of the strap. Trim Strap if necessary and punch

holes in this end. Attach with lace to bag Back. Note: Be sure the strap is not twisted before attaching it to the bag.

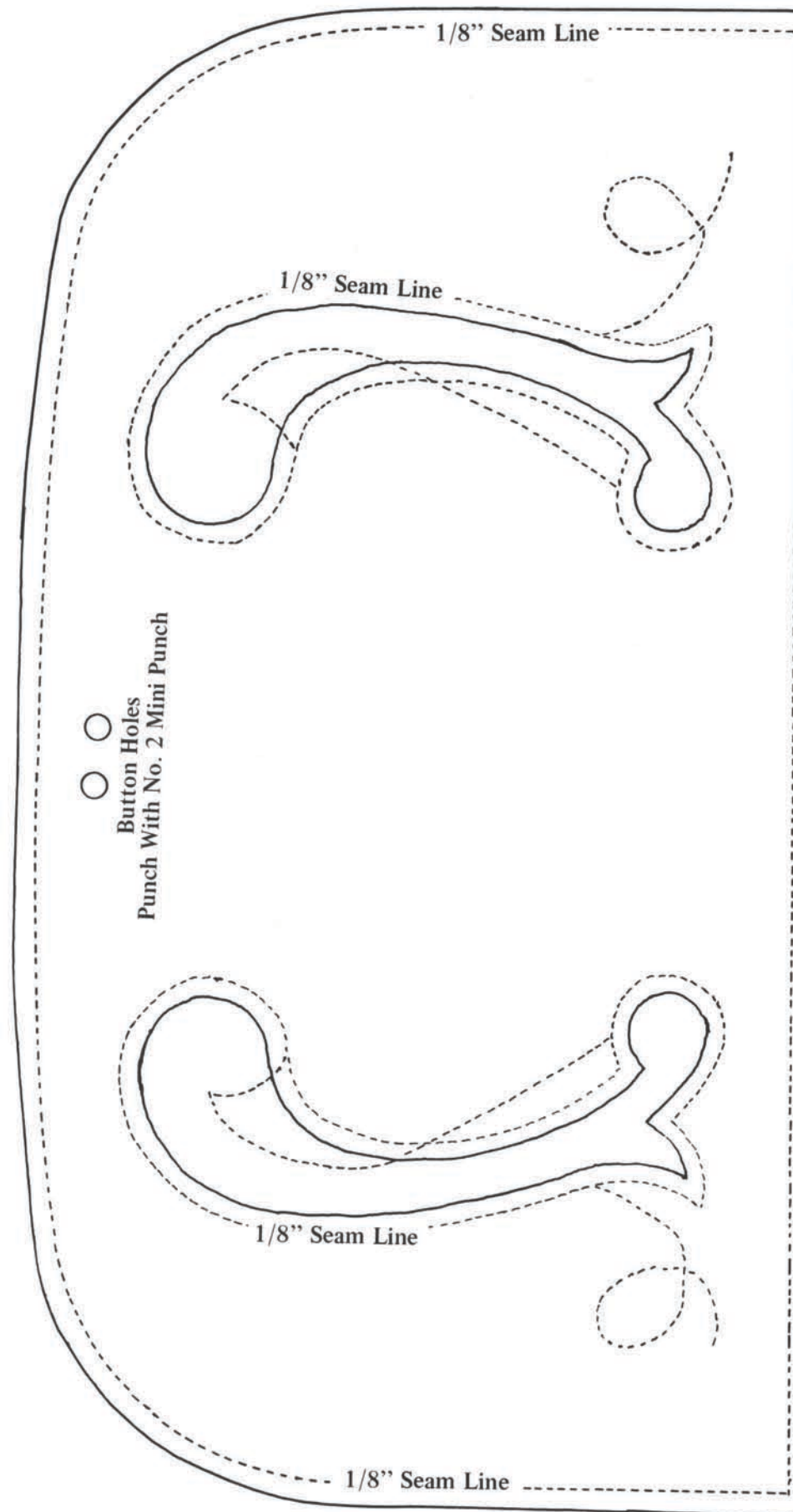
STEP 4. BUTTON: Locate position of holes for button on Flap of bag and punch through all three layers with No. 2 Mini Punch. Attach button to Flap with a piece of 1/4" lace about 3" long. Tie a knot in one end and pass other end through one hole from back side of Flap. Pull through and thread button on lace. Pass end back down through other hole and tie a knot close to the leather. Trim off excess lace.

STEP 5. CLOSURE THONG: Tie a knot in one end of 4" of 1/4" lace. Push it through the hole in the bottom of the Front from the inside of the bag. This thong, wound twice around the button, will hold the Flap securely closed.

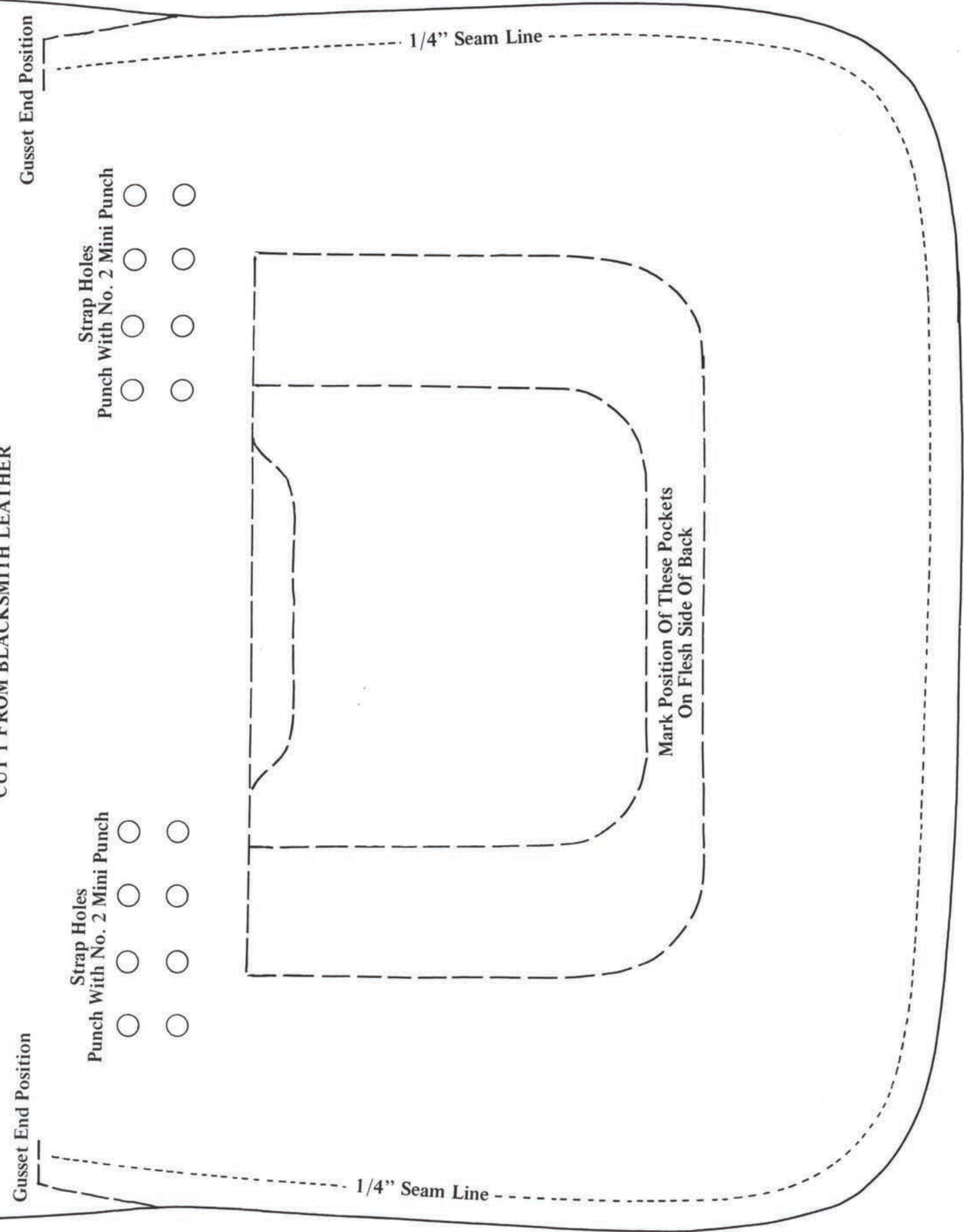


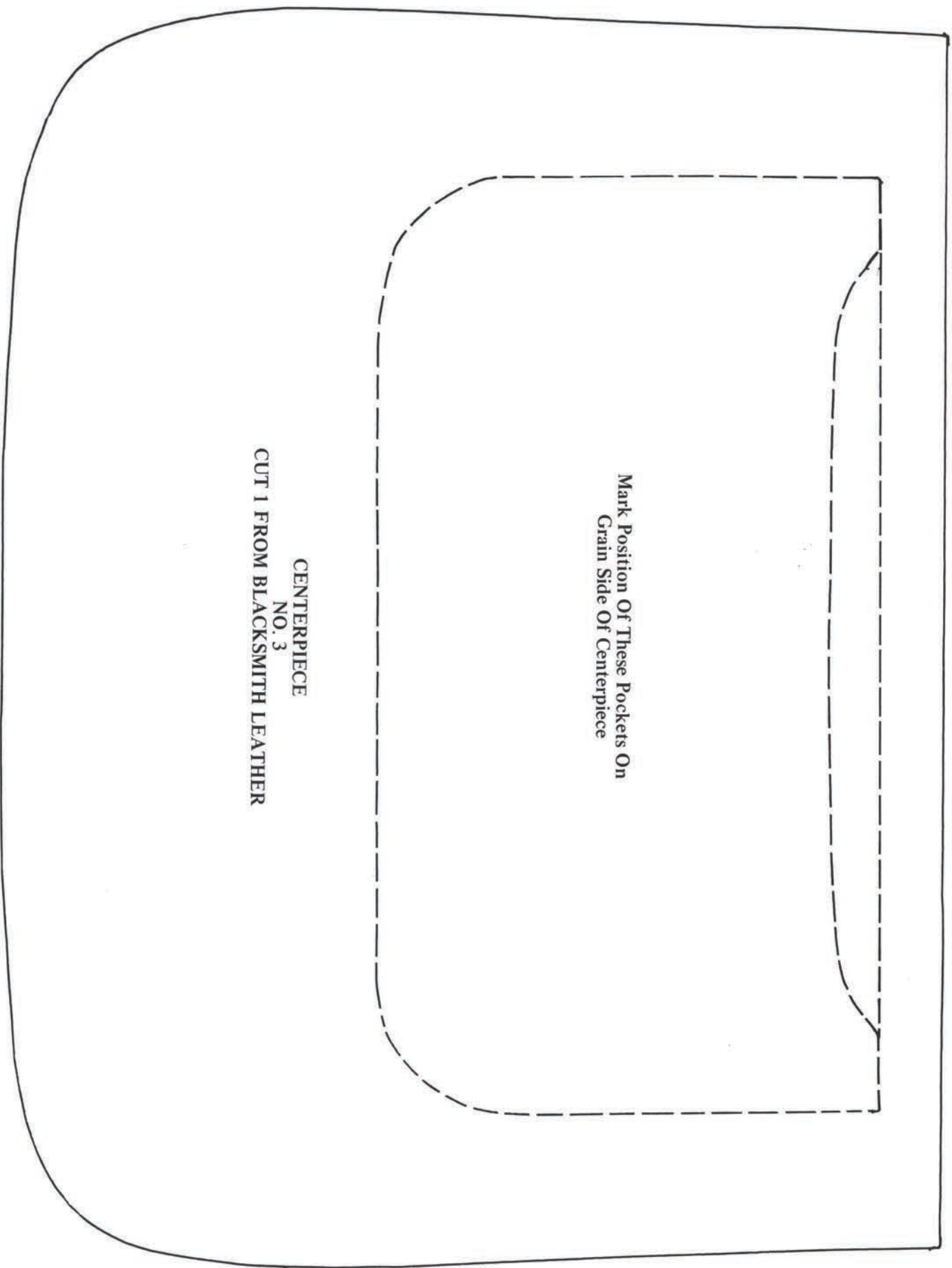
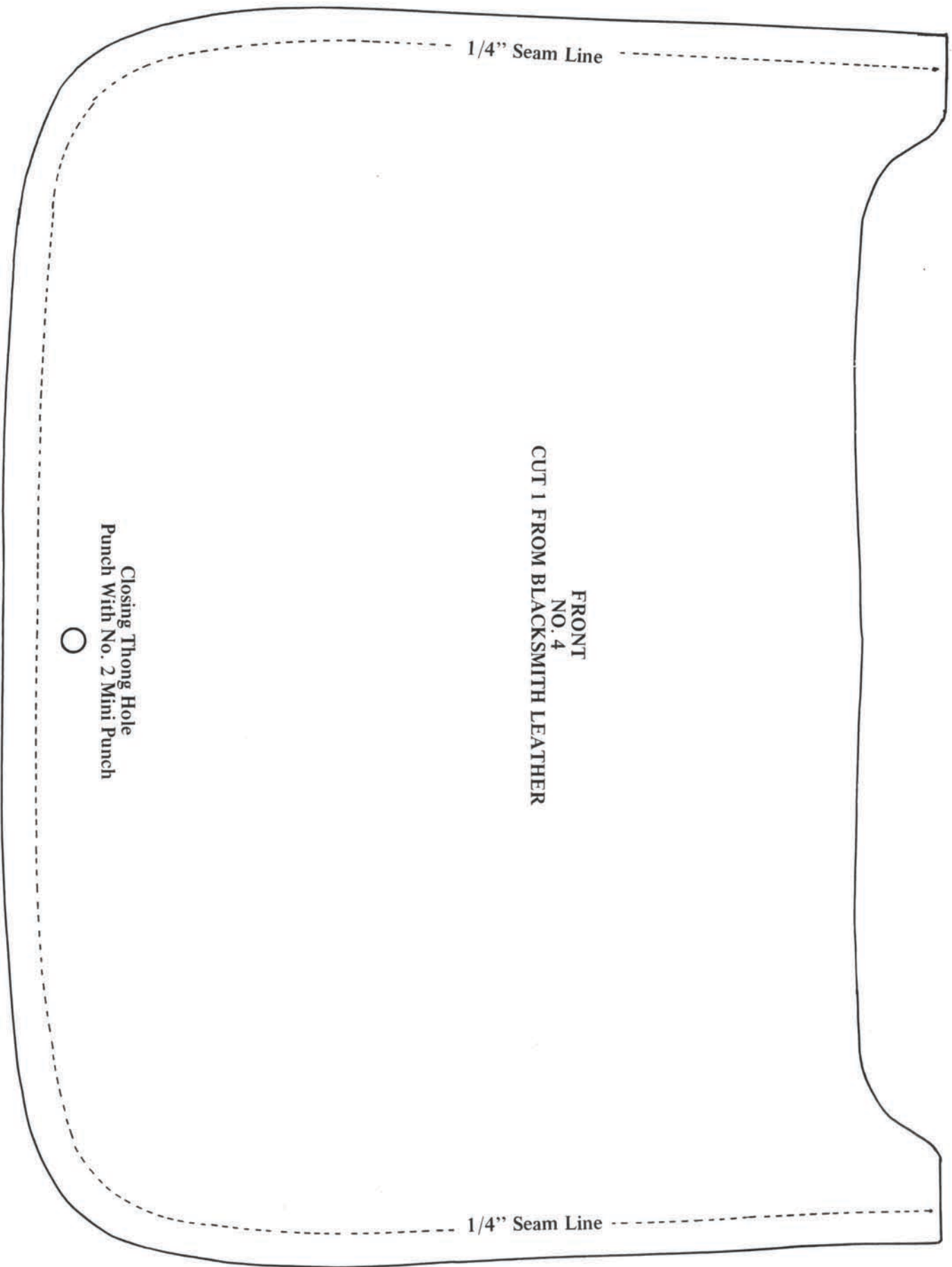
STEP 6. POWDER HORN STRAPS: Punch a hole in each side of the Strap approximately 14" from each end (this measurement may differ depending on where you want your horn to hang), with a No. 2 Mini Punch. Force the ends of the Powder Horn Straps through holes (see illustration).

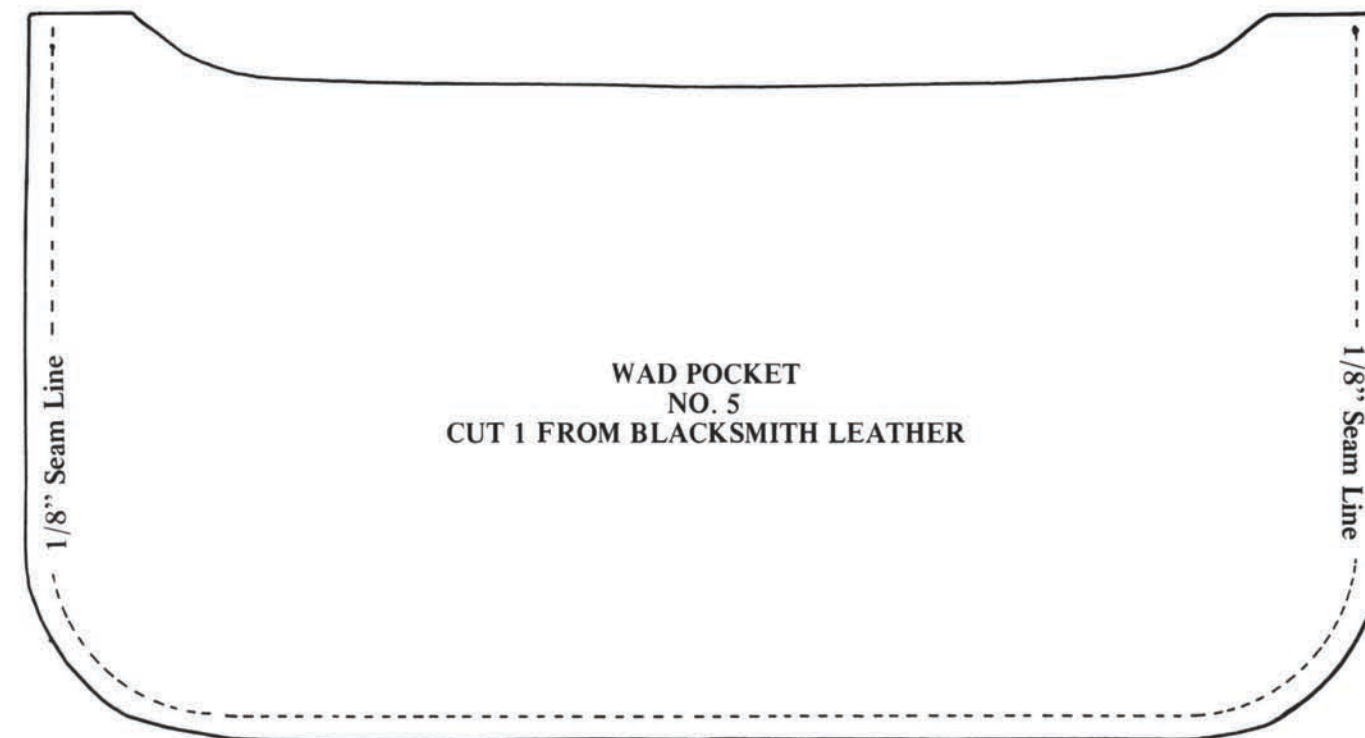
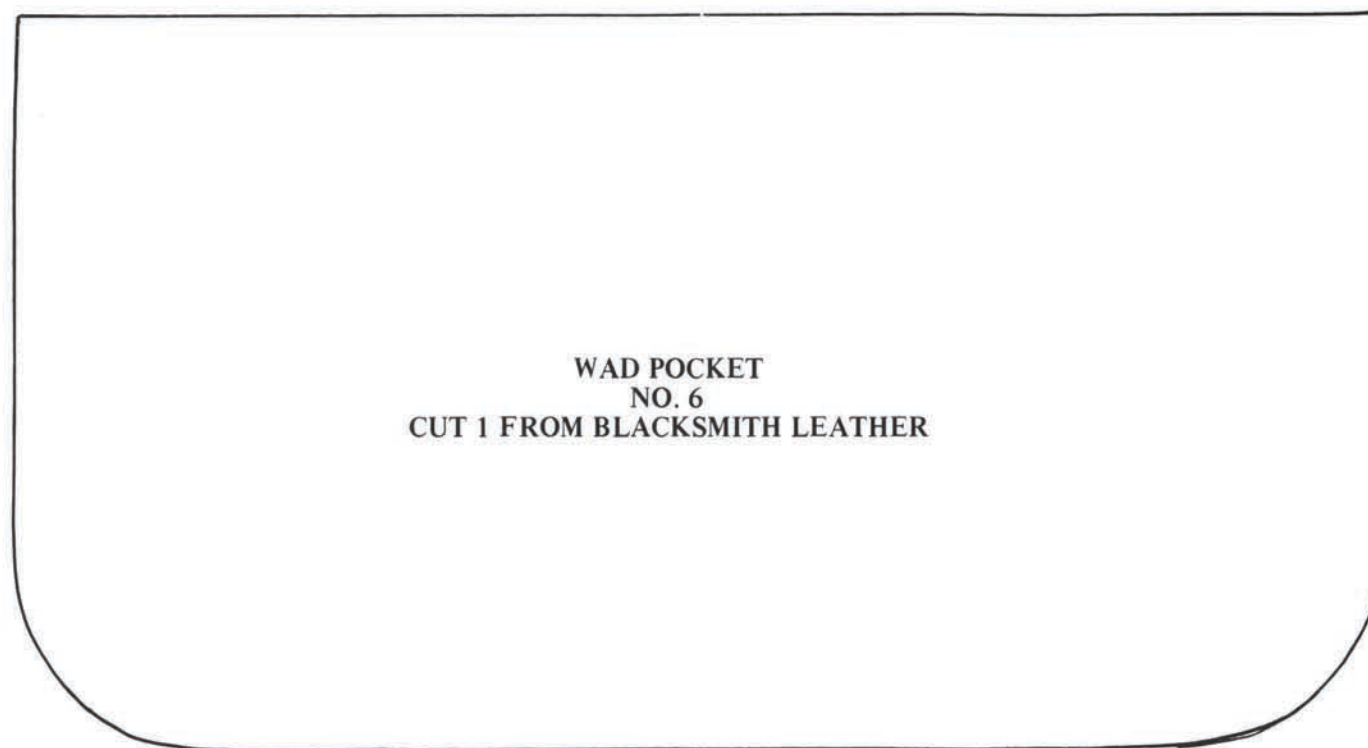
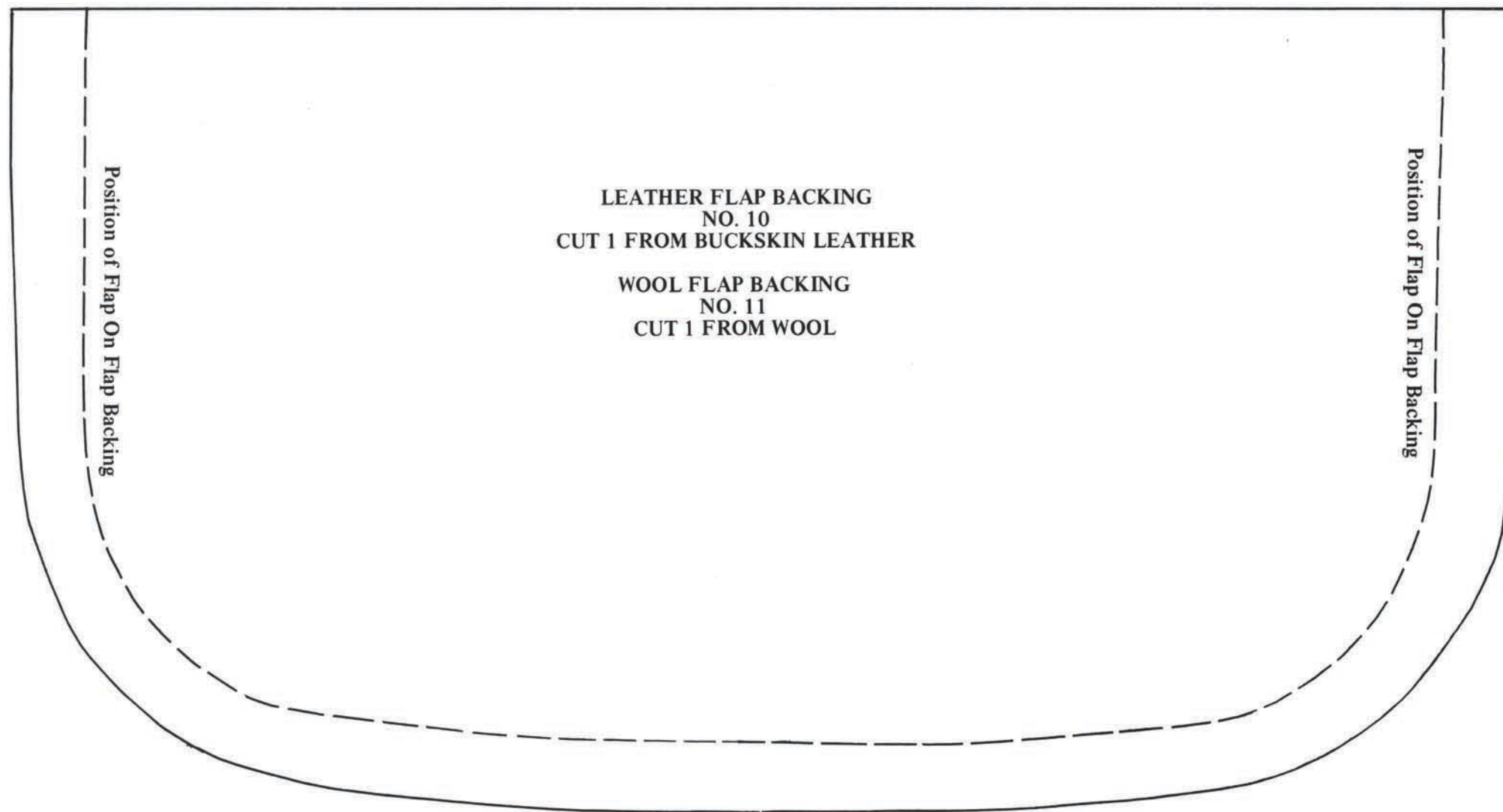
You're done! Because You've taken your time and made a good job of it, be proud of your work and good luck hunting and shooting. Good gear will help you be a better shot. Believe it!

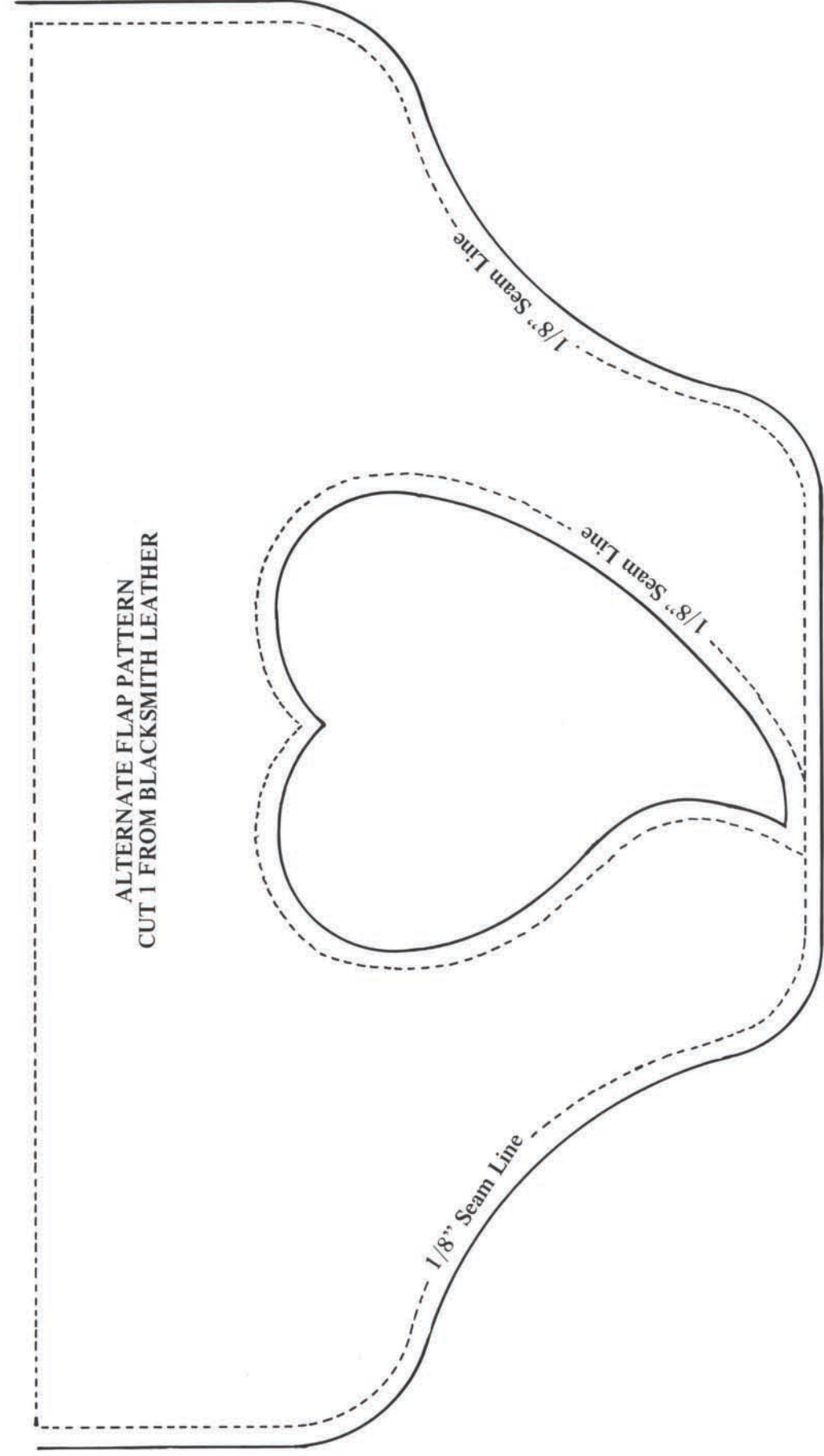
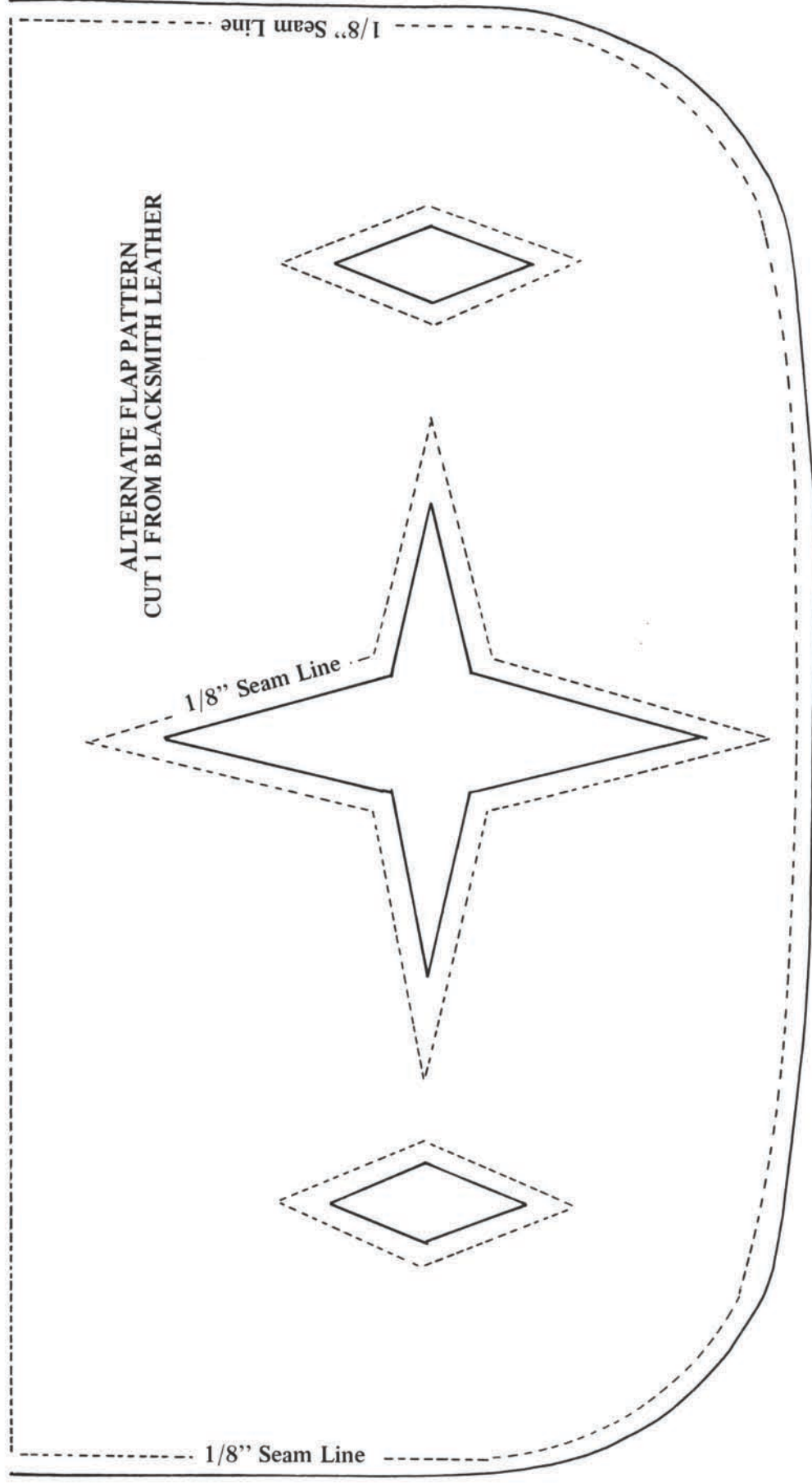


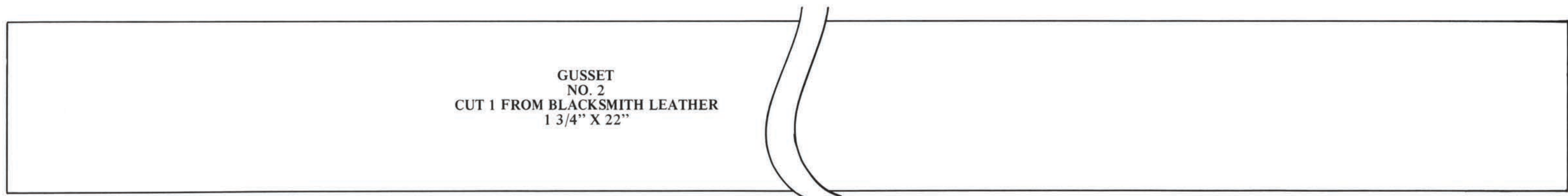
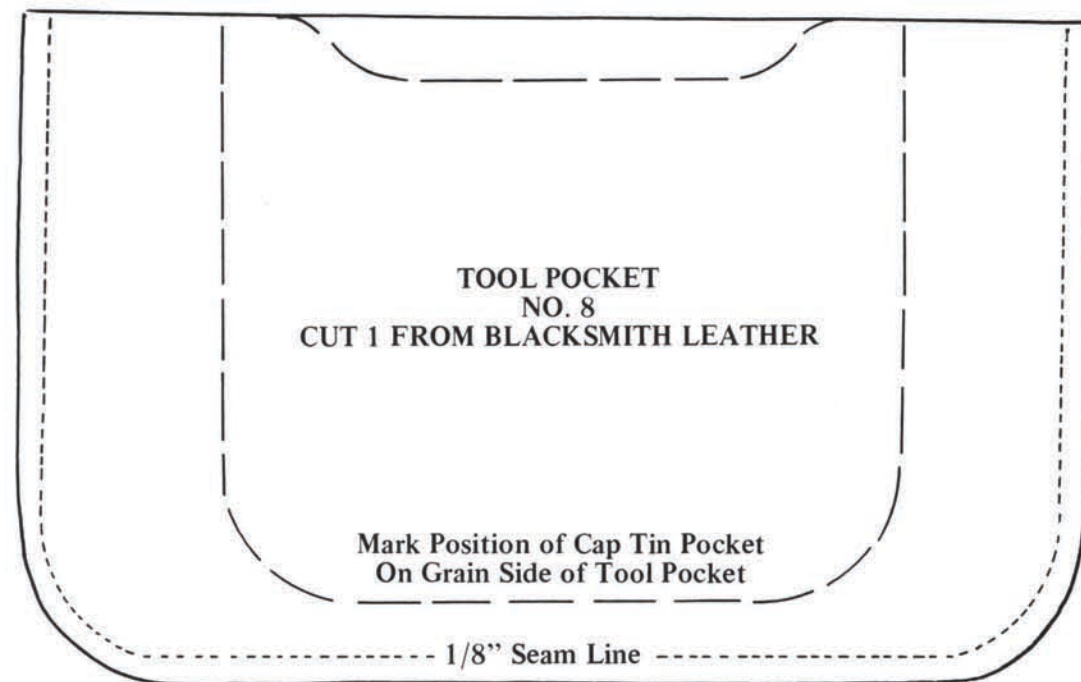
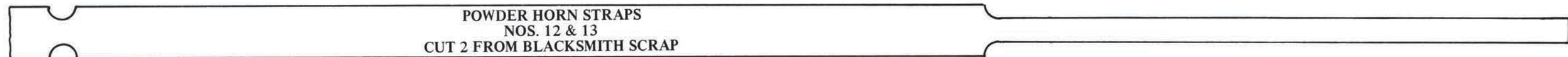
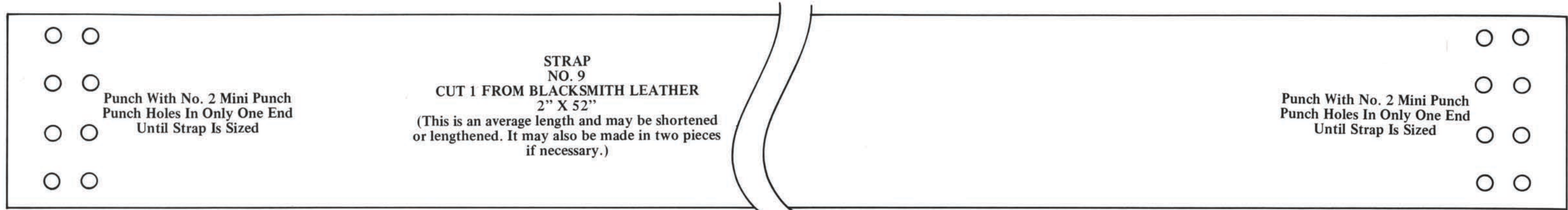
FLAP AND BACK
NO. 1
CUT 1 FROM BLACKSMITH LEATHER



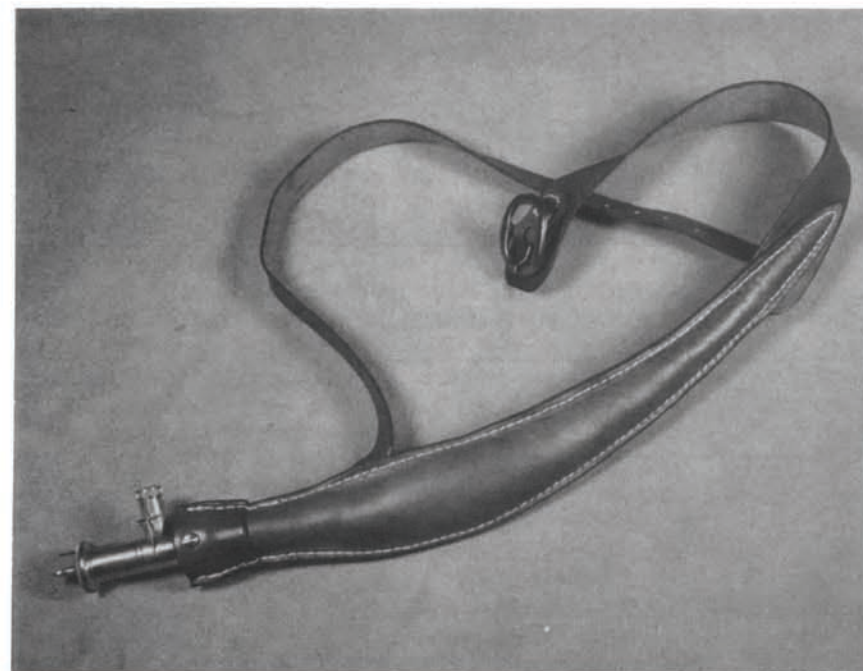
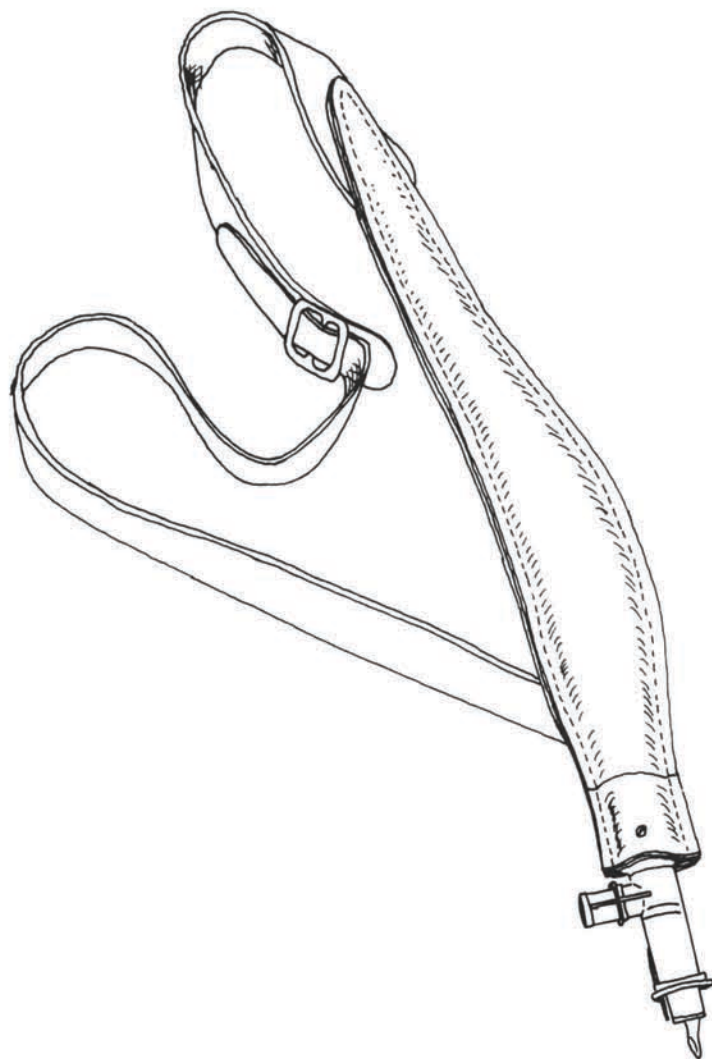








ENGLISH SHOT POUCH



This shot pouch is designed for maximum convenience, carrying 2 pounds of shot in a hunting situation. It will hold about thirty 1 1/8 oz. charges, plenty for a good day of fowling. The use of these bags goes back to the flintlock era and this bag is a composite of originals and paintings I've seen with flint fowlers. It is made to be worn over the left shoulder with the charger at the right hand. It can be made for left hand use by simply reversing all pattern pieces. It is designed to be used with the imported "Irish" style or scoop charger.

INSTRUCTIONS

TOOLS:

Super Shears or Sharp Knife
Stitching Awl or 1/16" Multi-Prong Chisel
2 No. 3 Harness Needles
Long Ruler or Straight Edge
Mallet
Overstitch Wheel
Edge Beveler
Circle Edge Slicker
Wing Dividers
No. 2 Mini Punch

MATERIALS:

4-5 oz. Vegetable Tooling Leather
Craftsman Cement
Waxed Thread or Artificial Sinew
1" Brass Buckle
Irish Charger Head
Pro Dye
Super Shene or Leather Balm

STEP 1. Transfer patterns to tracing film to preserve paper patterns. Transfer patterns to leather and cut out all pieces with super shears or a sharp knife.

STEP 2. Edge bevel, burnish edges, dye and finish all parts.

STEP 3. Cement Small Strap (C) to Pouch Side (B) at angle shown on pattern, grain sides together. Saddle stitch in place, leaving room for edge seam of pouch.

STEP 4. Locate position of Shoulder Strap (D) on Pouch Side (B) as shown on pattern. Cement in place, grain sides together.

STEP 5. Cement one Support Tab (E) to each Pouch Side (A & B), grain sides up as shown on pattern, aligning holes.

STEP 6. Apply cement along all edges (except mouth opening) of Pouch Sides (A & B), on flesh sides. Carefully align the edges and adhere Pouch Sides (A & B), flesh sides together. Trim and re-dye any uneven edges if necessary.

STEP 7. With wing dividers, scribe a light stitch line around Pouch Side (A), 3/16" from edge as marked on pattern. Mark stitching holes with an overstitch wheel along line.

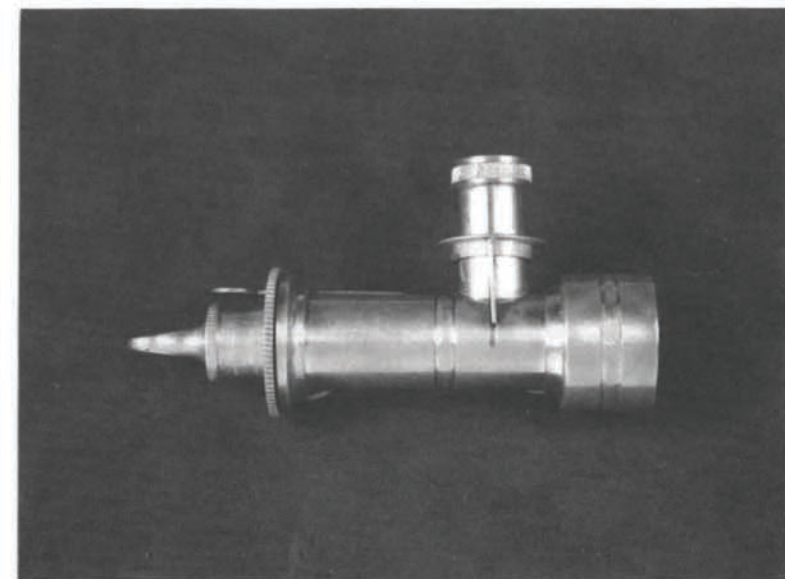
STEP 8. Saddle stitch pouch sides together using about 4 ft. of waxed thread or artificial sinew.

STEP 9. Cut a 3" piece from the end of the Small Strap (C). Round both ends and punch two holes in the center 1/2" apart. Cut out between the holes to form the buckle tongue slot. Thread through the buckle and fold over, aligning ends. Cement and stitch in place on Shoulder Strap (D), as shown on pattern.

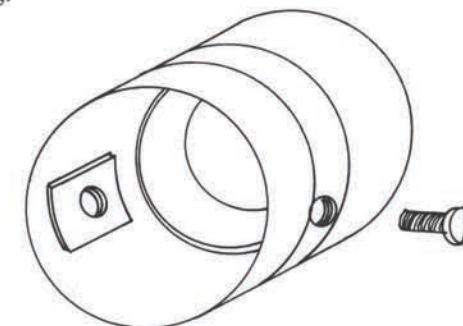
STEP 10. At this point I like to put on another coat of Leather Balm before I soak the pouch in water for molding. Wet the entire pouch and straps, getting the pouch, and particularly the mouth, very wet. Dry off surface water and force fit the mouth of the pouch over the outside of the charger collar. Move the charger head around until it is positioned for convenient use and mark the collar with an awl for hole locations.

IRISH SHOT CHARGER HEAD

Solid Brass Charger has a scoop that automatically cuts off the flow of shot as the scoop is withdrawn. Can also be used for powder. It has three settings for 70, 80 or 90 grains of black powder or 1, 1 1/4 or 1 1/2 oz. of shot. The Charger Head is available from Tandy Leather Fullfilment Center, P.O. Box 791, Fort Worth, Texas 76101 for \$19.95 plus \$1.00 for shipping and handling.



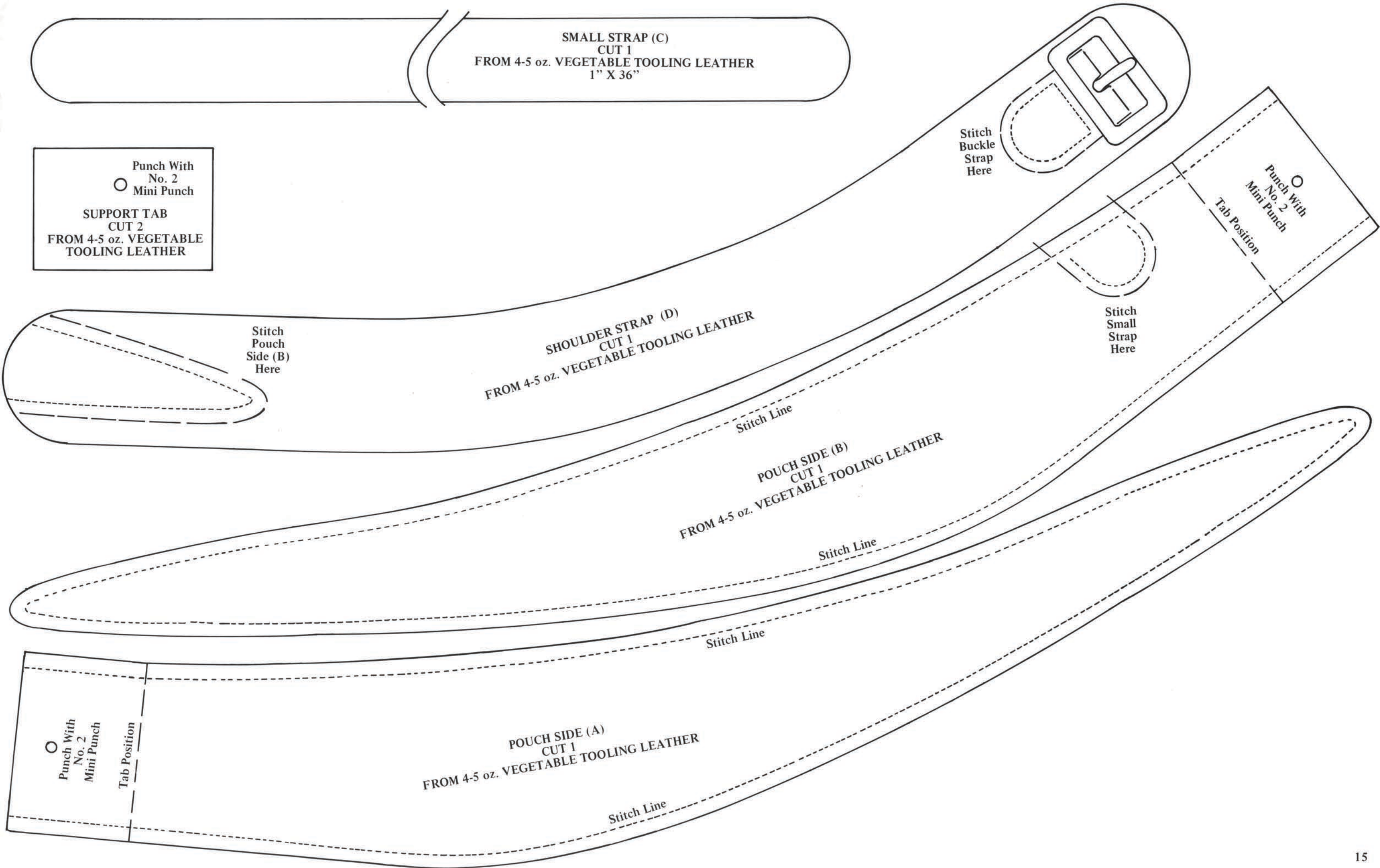
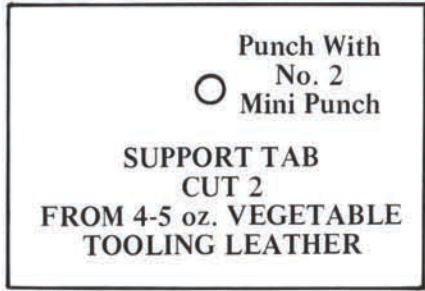
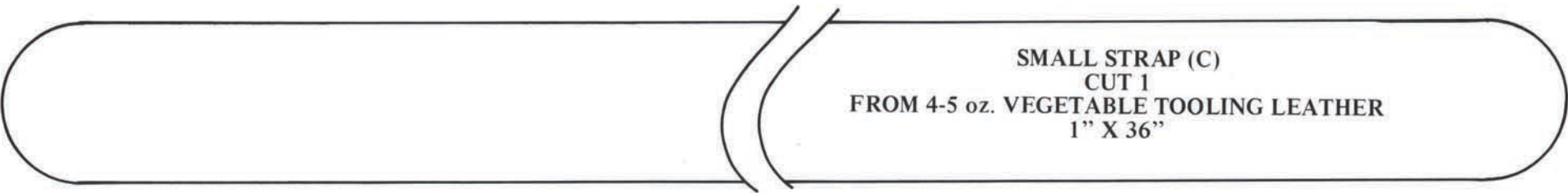
STEP 11. The charger head must be altered to attach with 2-8/32" X 1/4" truss head screws or suitable replacements like cut down lock bolts or hammer screws. Remove inside collar (this can be saved, sawed in half and used as shims), drill (No. (NO. 29) and tap for two 8/32" screws where marked in Step 10. I like to solder two shims inside the collar before drilling to insure more threaded surface. If you have trouble with this, take it to your local gunsmith, with holes marked, for drilling and tapping.



STEP 12. Install charger head with screws.

STEP 13. At this point the pouch should be complete and wet to mold for shot. Poke a smooth 3/8" dowel down into the pouch to open it up and fill with shot. The more you get in the better. When full, punch holes in end of Small Strap (C) for buckle and hang up until dry.

STEP 14. Apply another coat of Leather Balm and good luck hunting.



VENT PICK



ACTUAL SIZE
APPROXIMATELY
2½" LONG

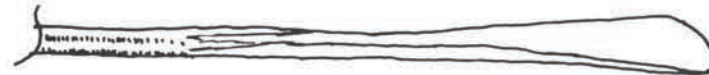


Coat hanger wire will cold forge nearly as easily as hot. Use a fairly heavy hammer, flat faced, and the back of the vise for an anvil. The wire will try to twist so keep straightening when forging. Use a propane torch to heat for scrolling and twisting. Be sure to close the scroll so a thong can be tied to it. The coat hanger is about .090 or 3/32" in diameter. The round using end of the pick should be small enough to enter the touch-hole deeply without contacting the square shank. The idea is to poke not ream the hole as a square pick would do.

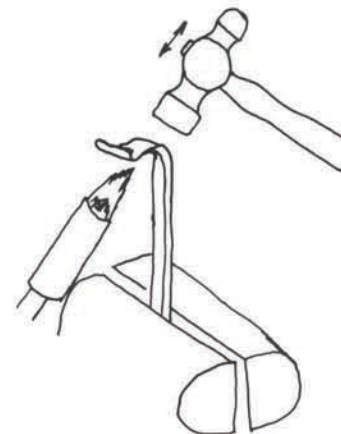
VENT PICK INSTRUCTIONS

STEP 1. Cold forge a 3" piece of coat hanger wire to square.

STEP 2. Forge one end to a flat spoon shape (see illustration below).



STEP 3. Holding wire in the vise, heat spoon end with propane torch and softly forge into a scroll shape (see illustration below).



STEP 4. Place scrolled pick end in vise and again warm with the torch. Twist the square shank with an adjustable wrench for a decorative effect.

STEP 5. File a fine square taper to the other end of the pick. Then file the first 1/2" to a long round taper, smaller than the touchhole.

STEP 6. Heat with torch to blacken.

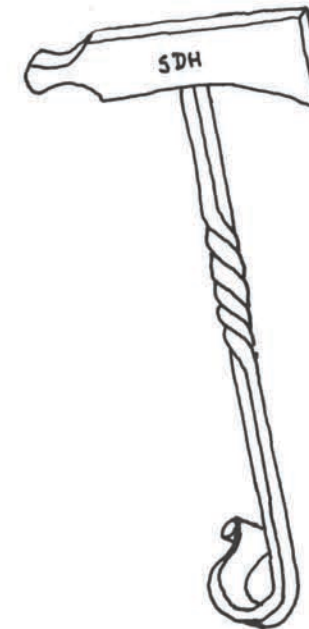
TOOLS:

Hammer
File
Propane Torch
Anvil
Vise
Wrench

MATERIALS:

Coat Hangar

FLINT KNAPPING HAMMER



ACTUAL SIZE
APPROXIMATELY
3" LONG



When making the hammer, drill the head halfway through, carefully. Use 440 solder to join the handle and head. This solder is mostly tin with a slight silver content and is available at welding supply shops. It flows with propane heat. Tin the hammer handle, flux the hole and heat. The face of the hammer can be used to knap a large flint surface. The "pipe bowl" end can be used to remove a small "shiner" from the flint. Use only the best hand knapped English flints.

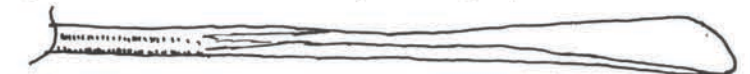
FLINT KNAPPING HAMMER INSTRUCTIONS

STEP 1. Hacksaw and file 1/8" sheet brass to pipe tomahawk shape (see left).

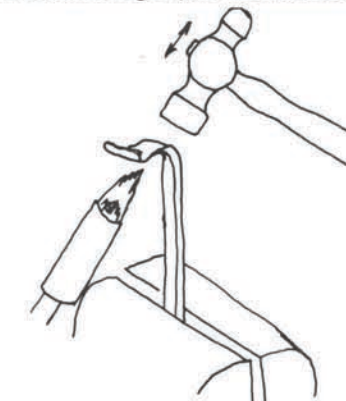
STEP 2. Using a drill the same size as the coat hanger wire, approximately 3/32", drill a hole halfway through tomahawk from the bottom side.

STEP 3. Cold forge a 3" length of coat hanger to square, leaving one end round to fit drilled hole in tomahawk.

STEP 4. Forge the other end to a flat spoon shape (see illustration below).



STEP 5. Holding wire in the vise, heat the spoon end with propane torch and softly forge into a scroll shape (see illustration below).



STEP 6. Place scrolled end in vise and again warm with the torch. Twist the square shank with an adjustable wrench for decorative twist. Reheat to blacken.

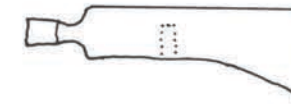
STEP 7. Soft solder handle to tomahawk.

TOOLS:

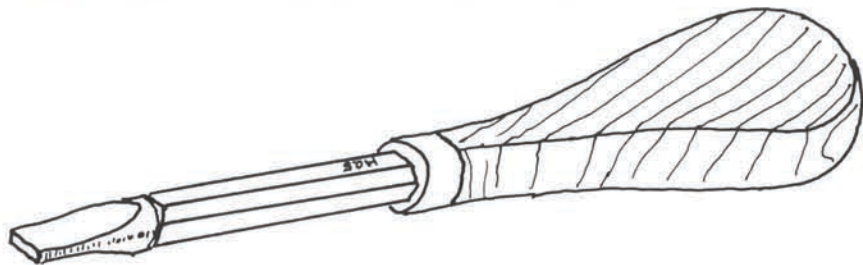
Hammer
3/32" Drill and Bit
File
Hacksaw
Propane Torch
Anvil
Vise
Wrench

MATERIALS:

Coat Hangar
1/8" Brass Sheet
440 Silver or Soft Solder



TURNSCREW



TOOLS:

Electric Drill
1/4" Drill Bit
Fine Square File
Half-round File
Cross-cut Saw
Coping Saw
Compass
Hacksaw
Mallet
Scribe

MATERIALS:

Brass Tubing for Ferrule
Hardwood Scraps
1/4" Hexagon Drill Rod
(Oil Hardening)
Epoxy
Sandpaper
Emery Paper
Motor Oil (For Quenching)
Wood Finish

"Turnscrew" is proper British for screwdriver. Necessary tools for changing flints and lock removal. This one is very small and flat to fit in the tool roll.

The blade or screw is .040 thick, hollow ground and fit to the top jaw screw and lock bolt (side nails in British) of my flintlock. Find a screwdriver that fits the appropriate screws and make your turnscrew blade the same.

Hexagon (six sided) and round drill rod is available at steel suppliers of machine shops. Get oil hardening steel. Most all steel available is No. 1095 and is easily heat treated. You will need oxy-acetylene or coal forge heat to harden the steel. The hardened steel will be a flat grey and impossible to cut with a file. I draw the temper with a torch to bright blue. It will come out of an oven a yellow color, hard enough to hold its edge but not easily broken. If you're going to pin the shank to the handle, drill the pin hole before hardening.

The local hobby shop carries 13/32" diameter (3/8" inside diameter) brass tubing for the ferrule. Or use an appropriate size cartridge case.

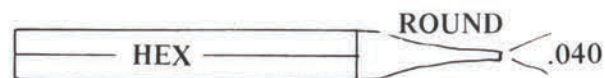
I've been using a set of these turnscrews daily for ten years.

TURNSCREW BLADE INSTRUCTIONS

STEP 1. With hacksaw, cut off 2 1/2" length of 1/4" hexagon drill rod. File one end flat and smooth.

STEP 2. With a 3/8" electric drill held in padded vise, chuck the shank in the drill. While drill is turning, file first 3/4" of hexagon shank until it is round.

STEP 3. Coat round section with layout fluid or cold blue. Layout shape of blade so that the flat of the blade is aligned with two flats of the hexagon shank.



STEP 4. Starting 5/8" from tip, file hollow grind down to blade layout lines. File evenly on both sides. A six inch half-round file is the best tool for this job.

STEP 5. Polish all surfaces with emery paper.

STEP 6. Heat the first one inch of the blade end, cherry red and quench in oil. Hold with pliers. De-grease with alcohol and re-polish bright.

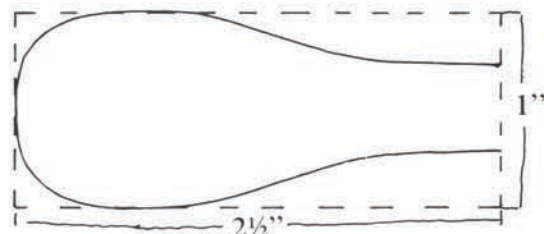
STEP 7. Draw temper by placing shank in oven pre-heated to 475 degrees for one hour. Let cool in oven.

WOODEN HANDLE & FERRULE INSTRUCTIONS

STEP 1. With cross-cut or other saw, cut out a 1/2" X 1" X 2 1/2" rectangular block of fancy hardwood, keeping it squared-up on all sides. Mark center of one end and with compass draw a 3/8" circle on end.

STEP 2. Drill a 1/4" hole in center of end, 3/4" deep. Be sure to keep drill straight. Check by tapping shank into hole. If shank is straight with handle, remove by tapping handle off of shank.

STEP 3. Draw handle outline (see drawing) on block and cut out with a coping saw. File to near perfect shape.



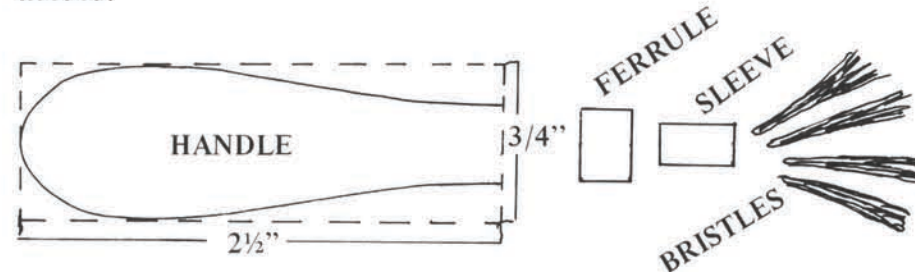
STEP 4. With hacksaw, cut off a 3/8" section of 3/8" (inside diameter) brass tubing. I used a section of 30/40 Krag cartridge case. File ends square and de-burr inside and outside edges.

PAN BRUSH



Boar bristles would be authentic for duplicating original work. The brass sleeve that holds the bristles would be crimped on the inside. I've chosen to use nylon bristles pulled in clumps from my hair brush and a .22 shell for the sleeve.. These are epoxied into the brass sleeve and the sleeve and ferrule epoxied to the handle. Pick the bunches for length and evenness. This makes for a useful and permanent brush with bristles that are stiff and easy to clean. Use 3/8" brass tubing (from the hobby shop) for the ferrule or as I did, an appropriate size cartridge case. The handle was not lathe turned but could be. Careful layout and an eye for uniformity will lead folks to imagine it lathe turned and professionally made.

This pan brush is as necessary as the vent pick to keep your flintlock surefire. Brush the pan after each shot and lightly pick the touchhole as needed.



TOOLS:

Electric Drill
15/64" or No. 1 Drill Bit
Fine Square File
Half-round File
Cross-cut Saw
Coping Saw
Hacksaw
Compass
Mallet

MATERIALS:

Brass Tubing For Ferrule
Hardwood Scraps
Brush Bristles
.22 cal. Cartridge Case (Fired)
Epoxy
Sandpaper
Emery Paper
Wood Finish

BRUSH INSTRUCTIONS

STEP 1. With cross-cut or other saw, cut out a 1/2" X 3/4" X 2 1/2" rectangular block of fancy hardwood, keeping it squared-up on all sides.

STEP 2. Square and smooth one end. Mark center of this end and with compass, draw a circle equal to the inside diameter of the ferrule.

STEP 3. Drill end 3/8" deep to accept a .22 caliber cartridge case (15/64" or No. 1 bit).

STEP 4. With hacksaw, cut off a 1/4" section of 3/8" brass tubing. File ends square and de-burr the inside and outside edges.

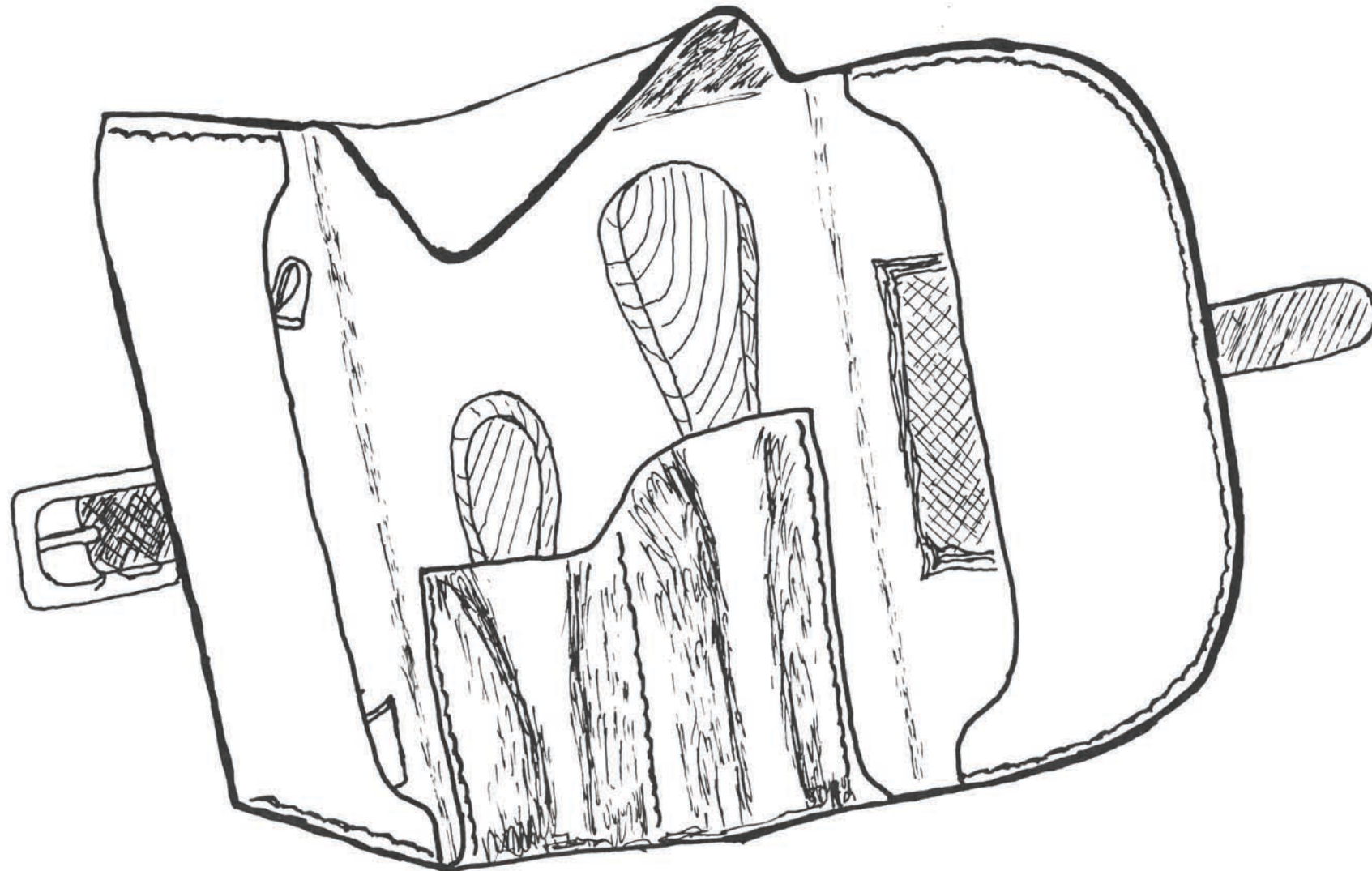
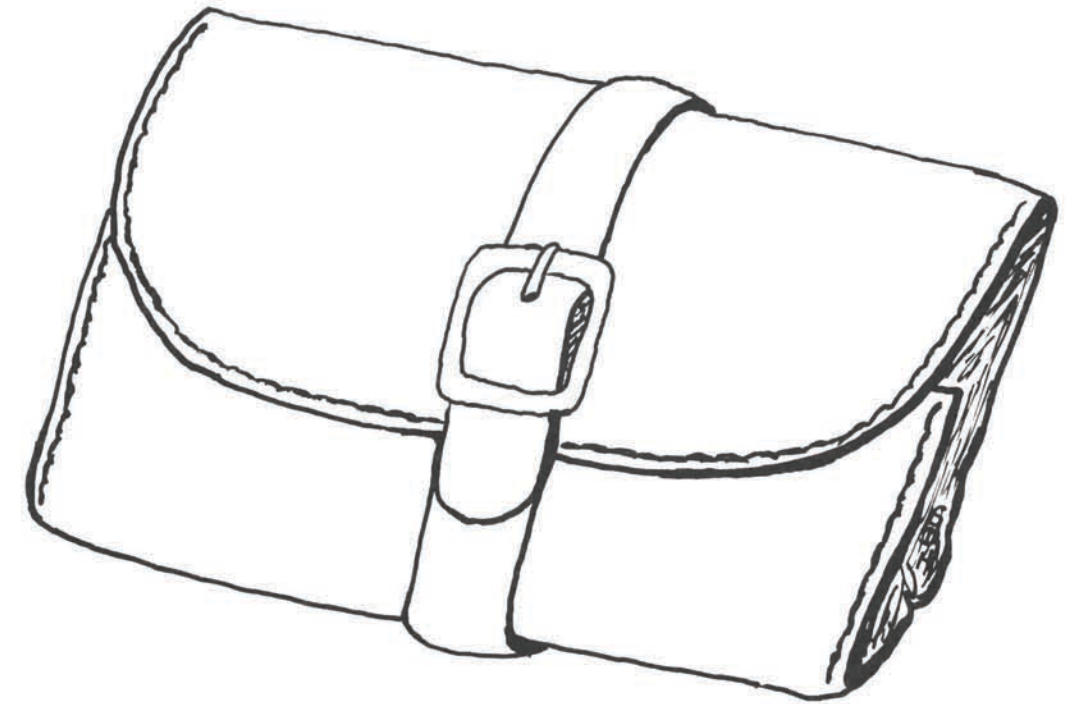
STEP 5. Fit ferrule as described in Steps 5 & 6 of Turnscrew Instructions.

STEP 6. Carefully hacksaw off a 3/8" length of .22 caliber case. With pliers, pull bristles in clumps from hair brush. Stack in sleeve.

STEP 7. Epoxy ferrule and sleeve with bristles to end of handle.

STEP 8. Cut out, shape and finish handle same as in Steps 8 through 11 of Turnscrew Instructions.

TOOL ROLL



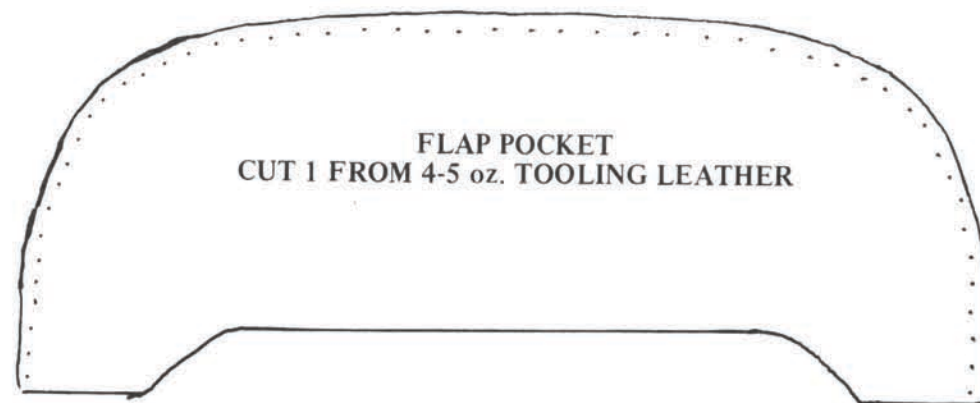
This tool roll carries a turnscrew, pan brush, vent pick, flint knapping hammer, and cleaning patches. One convenient case for the necessary flint shooting tools. Keeps the tools together in your hunting bag or pocket. This type of tool roll hasn't been traced back to the flintlock era but is often found in cased sets with late percussion and early breechloading guns. A nipple wrench or cleaning jag can be substituted for the pan brush. The flap pocket is for cleaning patches. Make all the tools first so you can modify the tool roll as necessary.

TOOLS:

- Awl
- Overstitch Wheel
- Super Shears or Knife
- Edge Beveler
- Circle Edge Slicker
- Harness Needles
- Adjustable Gouge

MATERIALS:

- 4-5 oz. Vegetable Tanned Tooling Leather
- One Square Foot
- 5/8" Brass Buckle
- Pro Dye
- Super Shene or Atom Wax
- Waxed Thread
- Craftsman Cement



TOOL ROLL INSTRUCTIONS

STEP 1. Transfer paper patterns to tracing film to preserve the paper patterns. Transfer patterns to leather. With super shears or sharp knife, cut out Main Body, Flap Pocket and Closing Strap.

STEP 2. Dye and finish all three pieces.

STEP 3. With adjustable gouge, cut a groove down all fold lines. Cut only through one half the thickness of the leather.

STEP 4. Locate position of Center Strap on back of Main Body as shown on patterns. Saddle stitch Strap in place, grain sides up.

STEP 5. Lightly moisten Pick Pocket Fold groove and fold over. Tap fold with a mallet to set the fold. Apply cement to edges of pocket and adhere together.

STEP 6. Cut a groove along stitch lines of pocket with gouge, mark stitches with overstretch wheel and saddle stitch both sides of pocket.

STEP 7. Cement Flap Pocket in place on Flap, flesh sides together. Cut a groove around stitch line as shown on pattern, mark stitches with overstretch wheel and saddle stitch in place.

STEP 8. Lightly moisten Tool Pocket Fold groove and fold over. Tap fold with a mallet to set the fold. Apply cement to edges of pocket and adhere together. Cut groove along stitch lines, mark stitches with overstretch wheel and saddle stitch.

STEP 9. Stitch middle seam of Tool Pocket to Main Body exactly between the side rows of stitches of Tool Pocket.

STEP 10. Bevel and slick all edges and carefully re-dye the edges or use edge coat.

STEP 11. Slip buckle over buckle end of Closing Strap. Fold end of strap around buckle and stitch.

STEP 12. Lightly moisten inside of Tool Pocket and all fold lines. Mold the pockets to fit the tools. Roll up with tools in place and let the leather dry completely.

STEP 13. Pull Closing Strap around Tool Roll, snugly, and mark position of buckle tongue hole on Strap. Punch hole with awl or punch.

STEP 14. When Tool Roll is completely dry, soften leather with neatsfoot oil if desired.

