

Custom-Made **SADDLE BAGS**

by Al & Ann Stohlman



- Full Size Patterns • 36 Page Instruction Book
 - Fitting Patterns to Individual Saddles
- Special Instructions for Forming Accordion Gussets
- Complete Step-By-Step Instructions for Making and Assembling the Saddle Bags

Stock No. 61959-00

Custom-Made SADDLE BAGS

by *Al & Ann Stohlman*



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BAGS for
SADDLE
No.1



BAGS for
SADDLE
No.2



BAGS for
SADDLE
No.3



BAGS for
SADDLE
No.4



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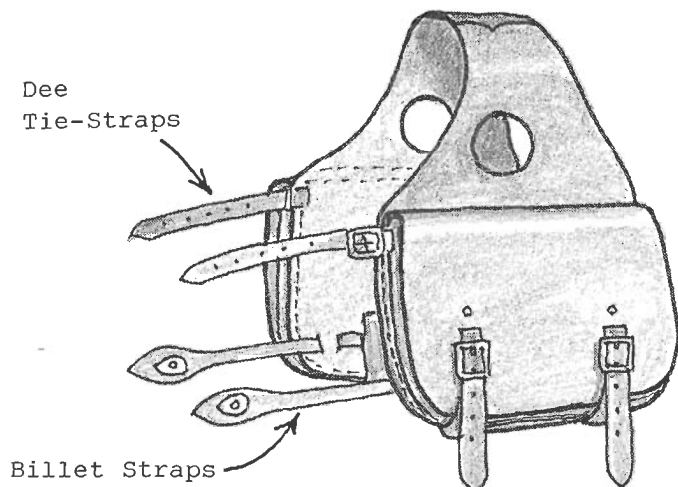
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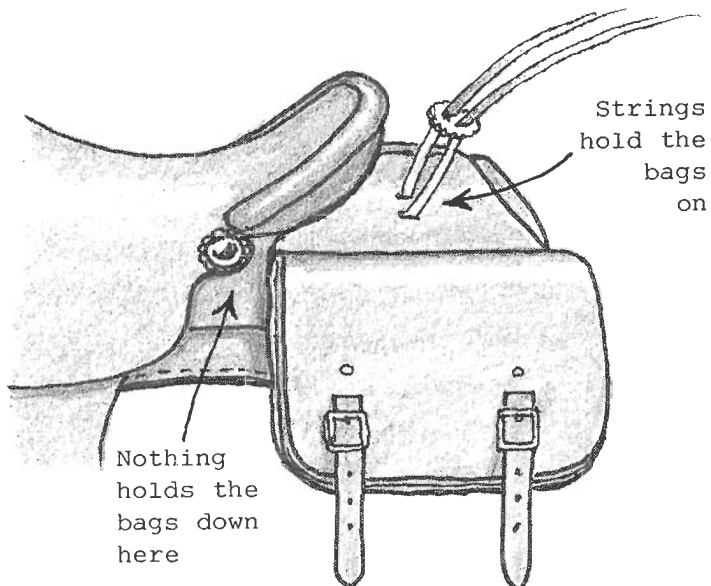
INTRODUCTION

by Al & Ann Stohlman

The main feature of our Saddle Bags is the method of attaching them to the saddle. They are simply buckled on...in two places...with an additional strap that snaps around each flank cinch billet, to keep the bags from flopping. Dozens of years ago, flopping saddle bags caused me to get bucked off of some horses. So this was my answer. See page 37.



I never liked the old-style of attaching bags to saddles. Usually the saddle strings had to be loosened at the jockey rosettes. Holes were then punched in the saddle bags to correspond, and then the strings were run up through these holes, the rosettes replaced, and the strings tied again. This is fine...but it more or less makes for a permanent attachment as one is not likely to keep loosening the saddle strings just to remove the saddle bags. See below.



With our method, the bags are buckled to saddle bag dees that are mounted on the jockeys. Straps (lower down) are snapped around the flank cinch billets to keep the bags from flopping. The saddle strings do not play any part in attaching the bags. To remove them, simply unsnap the billet straps and unbuckle the straps at the dees...as simple as that!

Another feature of our bags is the holes cut in the upper side pieces large enough to accommodate the rosettes and strings of the jockeys. By cutting these holes (in the correct places) the strings are pulled up through them, creating no bulges. Everything lays flat. The strings are available for tying on Jackets, etc. The holes could be omitted and an extra set of strings could be fastened to the bag. However, this adds more bulk to the unit and also a bit more to the weight. With our method, everything lays flat and there is no excessive bulk.

We have been making our bags like this for decades. Strangely, in all these years we have never seen other saddlers or saddle bag makers use our method. Of course, each of our bags is custom-fitted to each saddle for them to fit properly. All of the bags made for our four saddles were custom-fitted to each one.

For every saddle we make, we make bag patterns for each one of them whether the customer wants saddle bags (at the time) or not. Then we can make the bags anytime later to fit the saddle, without having to have the saddle. All of the bags for our four saddles were made for them after the saddles were out of our possession.

On the following pages we will give you patterns and complete instructions for fitting the saddle bag side pieces to any saddle. You can alter the size or shape of your bags in any way you wish. However, the general shape of the upper part of the side piece should be maintained. The pocket pattern should be of the same size and contour as the bottom part of the side piece pattern. Gussets should be formed to fit these areas. We have special instructions coming up to show you how to smoothly form the difficult corner areas of the accordion gussets.

ATTACHING the SADDLE BAGS

The photos on this page show how the saddle bags are attached. All saddles, using our method of attachment, must have dees installed on the jockeys near the base of the cantle. These are usually put on before final assembly of the saddle.

See pages in our *"Stohlman ENCYCLOPEDIA of SADDLE MAKING"* for making and installing the saddle bag dee assemblies: Patterns and preparations for making the saddle bag dee units are on page 195, Vol. ONE. Instructions for installing the dees are on page 603, Vol. THREE.

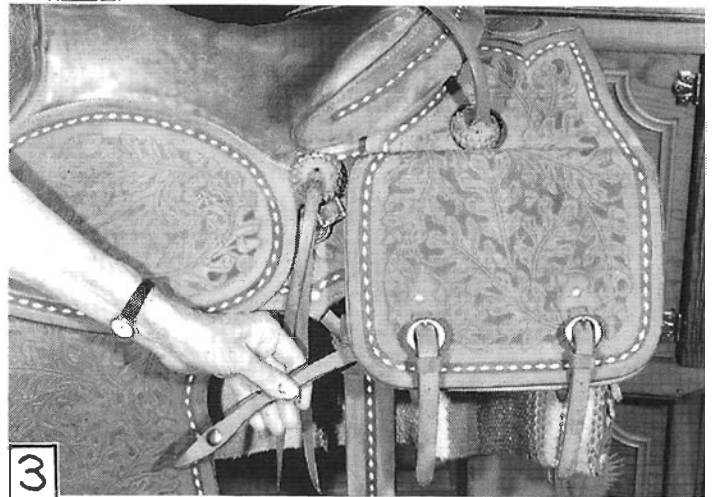
See additional instructions beginning on page 3 of this book, you're reading now.



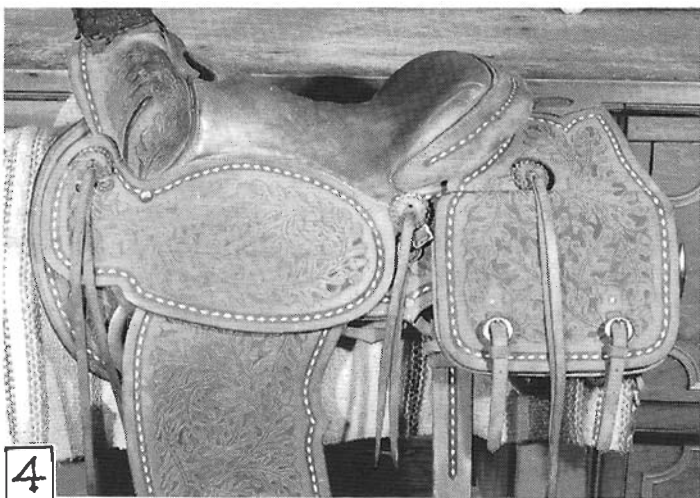
1 Place saddle bags in position. Pull strings up through the holes as shown above.



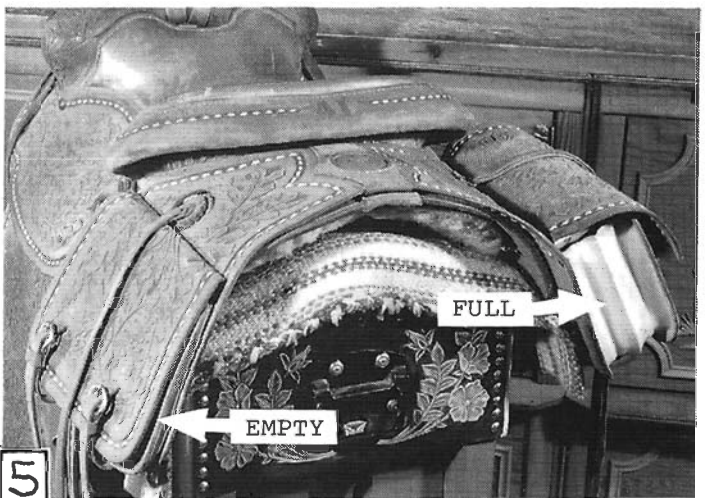
2 Pull the tie-strap through the dee. Pull up tight and buckle in place. Do both sides.



3 Now fold the billet strap around billet; snap to inside of bag. Do both sides.



4 Here the saddle bags are shown securely in place. To remove them unsnap billet straps & unbuckle the dee tie-straps.

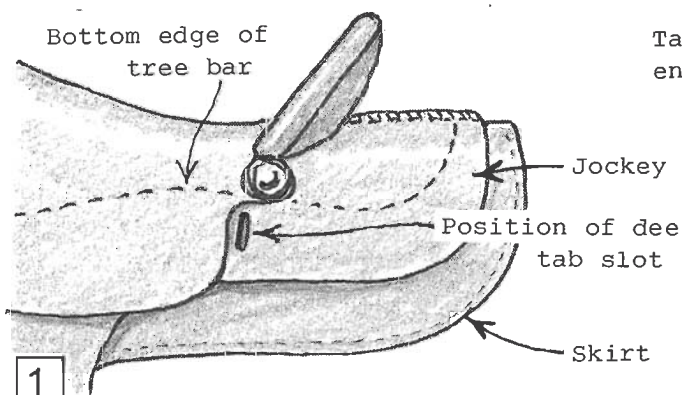


5 Here our accordian-style gussets show the carrying capacity of the bags when full, and the bulkless profile when empty.

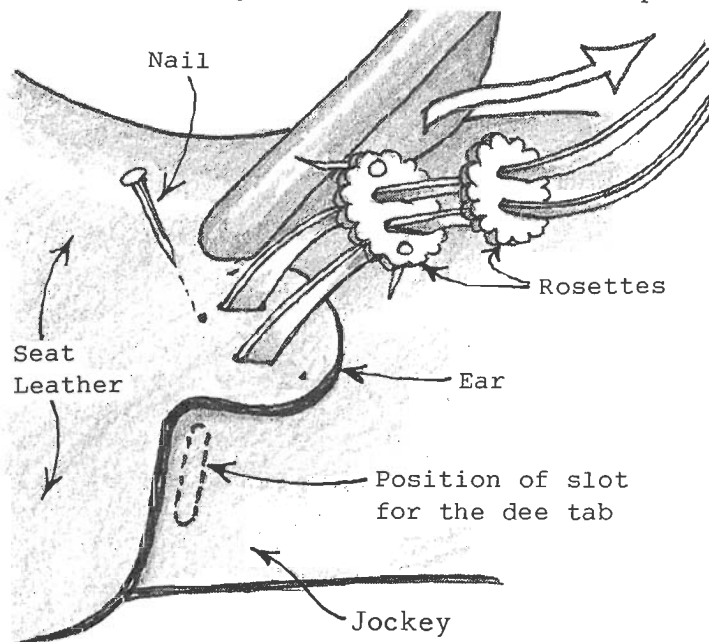
Adding SADDLE BAG DEES to a saddle without removing the Jockeys

Saddle bag dees are usually installed in the jockeys before the saddle is completed (see page 603, Vol. III, of our *Encyclopedia of Saddle Making* for position and installation of the dees). If your saddle is completed, without these dees, the following instructions will show you how to install the dees without removing the jockeys.

We usually put saddle bag dees on all of our saddles whether a customer wants saddle bags or not, at the time. Later on, we can make the bags without having the saddle...since we have already made patterns for the bags for that particular saddle. We have installed saddle bag dees on our Saddles No.3 & No.4, but deliberately left them off of Saddles No.1 & No.2, so we could show you how they can be added to a completed saddle without having to take it apart.



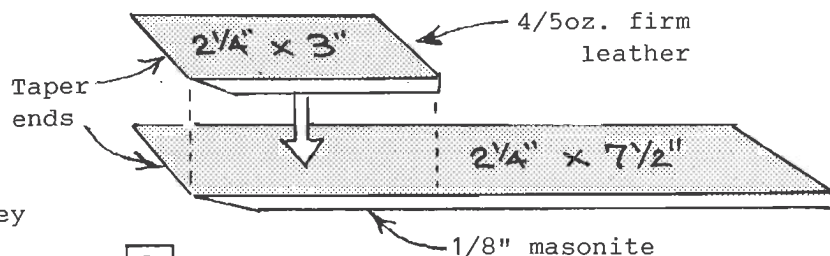
Since the position of the saddle bag dee slot is below the edge of the tree bar... there is no firm surface to pound against when punching out the slot. Go to step 2.



Since we usually rivet our jockeys to the rigging leather (see step 32, page 421 of Vol. TWO) it is a bit more difficult to install the saddle bag dee tabs because of the tight fitting jockeys. But we will show you how to do it.

In some cases, it may be necessary to remove the rivet that is holding the jockey down...to have more working room when installing the dee tab. However, with both of our saddles, we did not have to remove the rivet.

Most saddlers do not rivet their jockeys down. If you have such a saddle, then installing the dees in the jockeys will be much easier than the coming instructions.



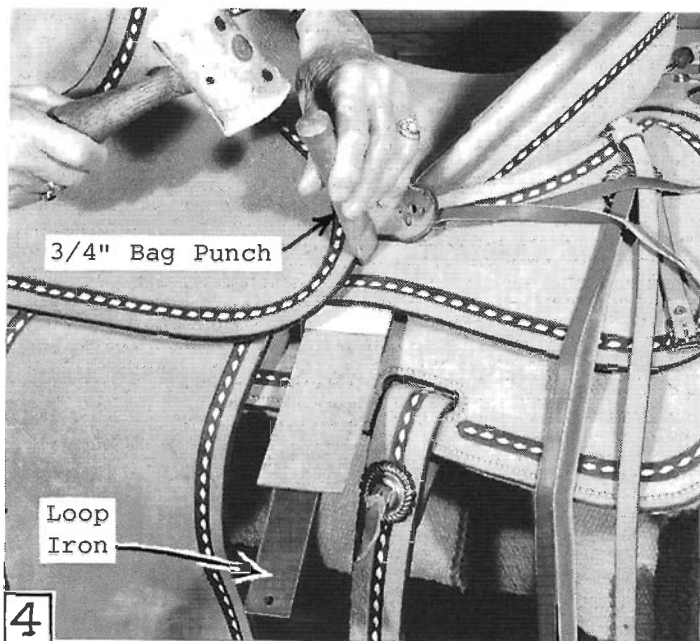
So, cut a piece of masonite to assist in making a firmer surface when punching the slots or holes. Glue a piece of leather on the end to protect the cutting edge of the punches (see sketch above). Taper the ends by skiving the leather with a knife. Use a wood rasp on the masonite.

Untie the saddle strings and remove the rosettes from the strings. Remove any nails from the ear of the saddle seat. Then pull the strings out of the slots in the ear.

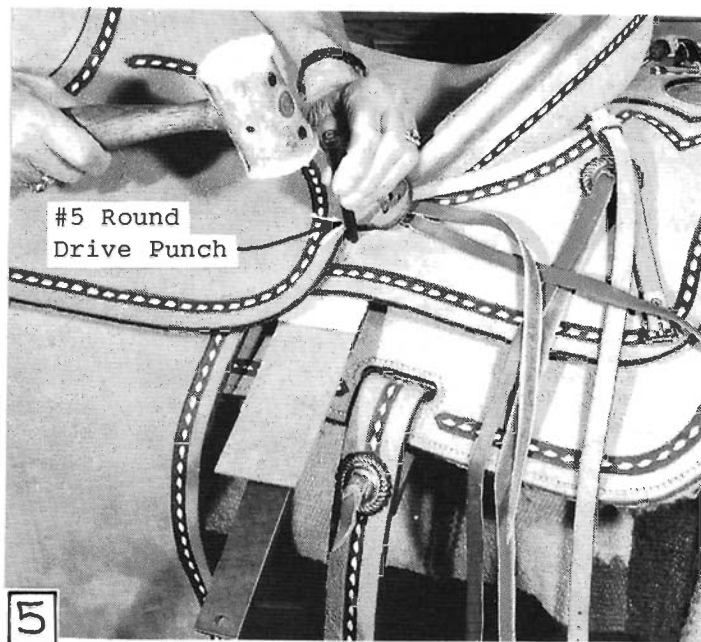
If your saddle only has a rosette and a silver screw concho at the ear, remove them. Also remove any nails holding the ear down. The ear must be loose to be lifted up out of the way when working the dee tab into the slot in the jockey.

(continued)

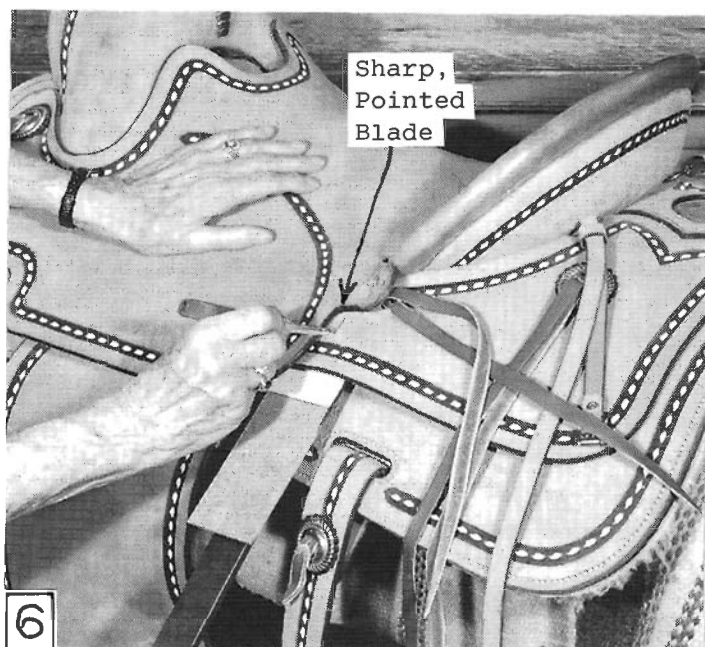
SADDLE No.2



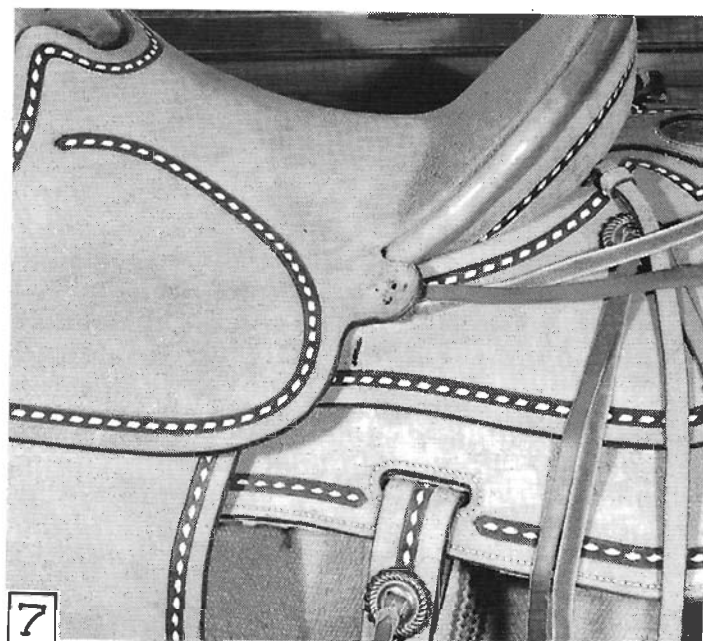
Push the wood and leather unit under the jockey and up as far as it will go. Also slide a loop iron under the wooden unit to create a firmer punching surface. Hold the bag punch in position and strike it hard with the mallet! You may need an assistant for this operation.



If the bag punch resists going through the jockey, it will have at least marked the position of the slot. Then use a #5 drive punch to punch out the ends of the slot. Be sure the wood and leather unit and the loop iron are still in their proper positions. Observe the photo above.

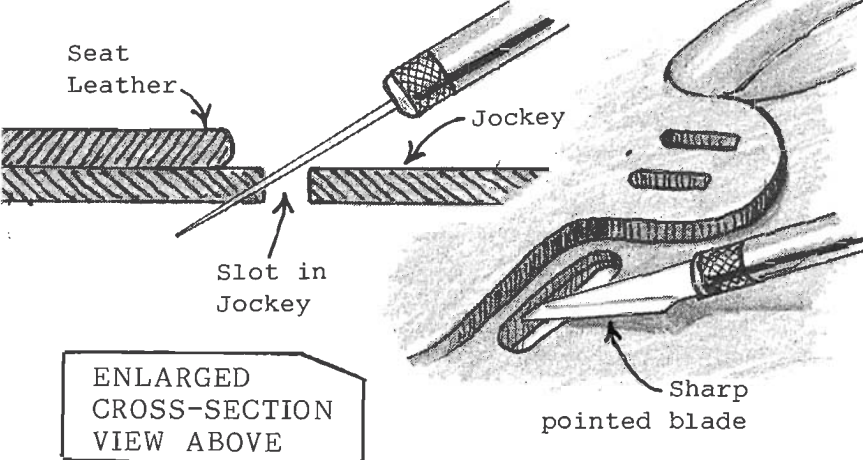


Now use a sharp, pointed blade and cut out the sides of the slot. Be sure you do not cut beyond the round punched holes, at top and bottom. If you feel it necessary, remove the wood and leather unit so you can lift the jockey a bit, to aid in cutting out the slot.



Here the slot is shown cut out. Repeat steps 3 through 6 to cut out the slot on the opposite side.

Pay careful attention to the instructions that follow, as more work must be done on the slot...see step 8.



Skive ends to a feather

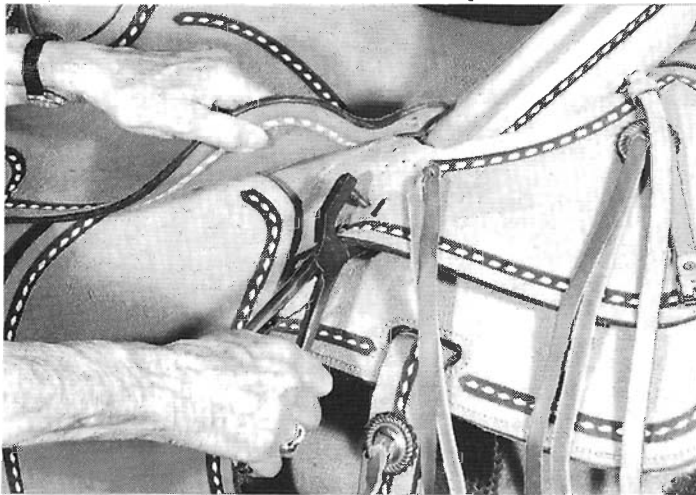
SADDLE BAG DEE ASSEMBLY

MAKE TWO

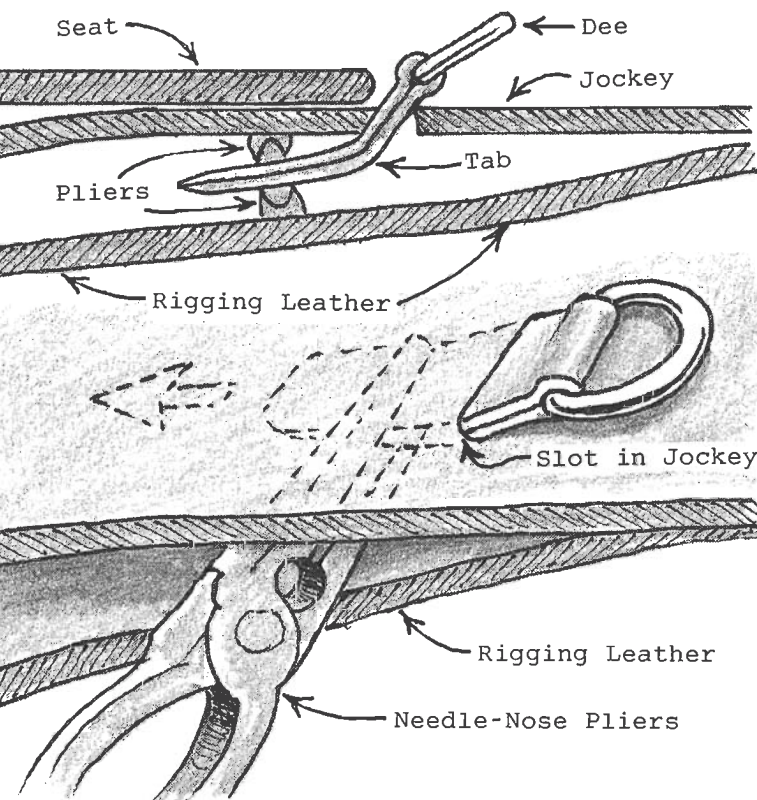
Glue together with contact cement

3/4" dee

8 Now trim off the bottom edge of the slot (at the front) as shown above. This is to make insertion of the saddle bag dee tab easier...and to make it lay a bit flatter in the slot.



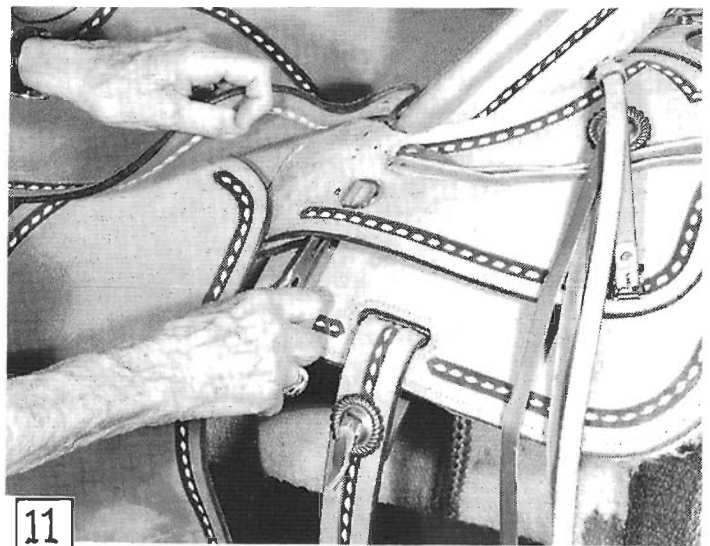
CROSS-SECTION VIEW BELOW



9 Make two saddle bag dee assemblies as shown above. Cut the tabs 3/4" x 3-1/4" from firm 4/5oz. latigo or oil-tanned leather. Rawhide is not recommended as the working area here is too confined. It could be used but would have to be put in while the rawhide was still damp and pliable. You would have to work quickly and get the rivet set before it dried out.

10

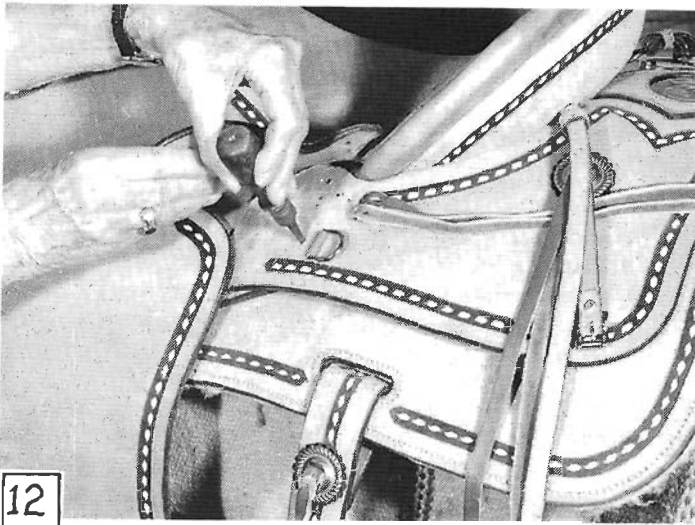
Fold the ear and bottom of the seat up out of the way and punch a hole (centered) 1/2" ahead of the slot, through the jockey, as shown at left. Use a #3 round punch. Note: If your hand punch will not reach in far enough, use a round drive punch & mallet with the wood & leather unit underneath to punch into.



11

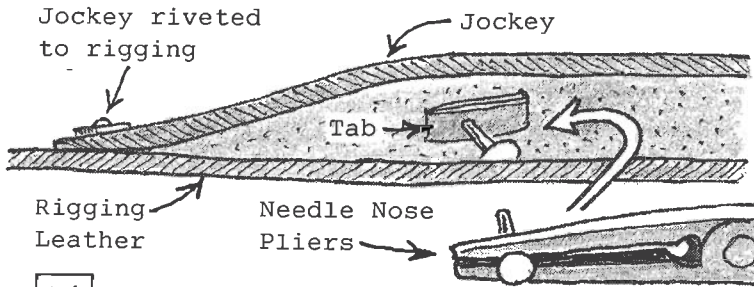
Now insert the dee tab in the slot in the jockey. Grasp the tab with a needle-nose pliers (just under the jockey) and begin pulling the tab forward. Observe sketch and photo above. Lift the jockey up off the rigging leather as much as possible.

(continued)



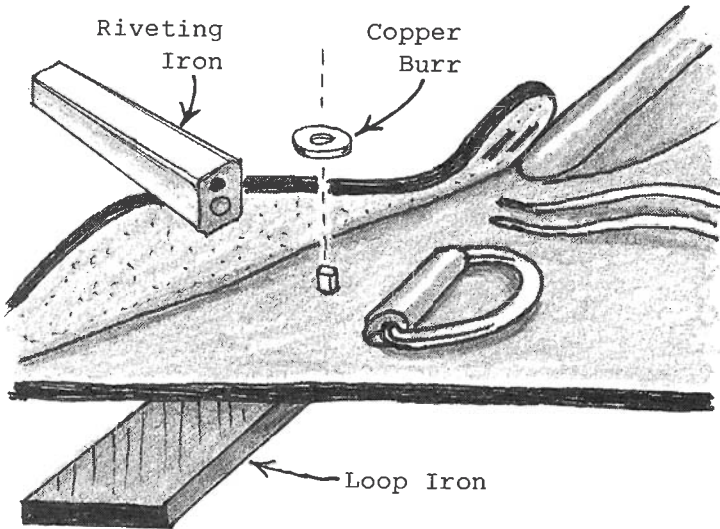
12

Pull the tab tightly into the slot, as far as it will go. Remove the pliers. Hold the seat out of the way and stab an awl into the hole to mark the hole's position onto the tab of the dee.



14

Put the dee tab back in place, as in steps 11 & 12. Hold the rivet in the pliers and push it through the holes in the tab and jockey, from the bottom. See sketch



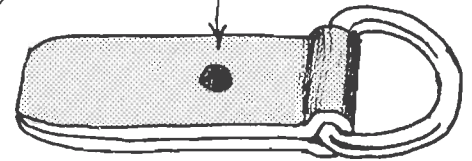
15

When you have the rivet in position, slide a loop iron underneath, between the jockey and the rigging. "Set" the copper burr in place.

Copper Rivet and Burr

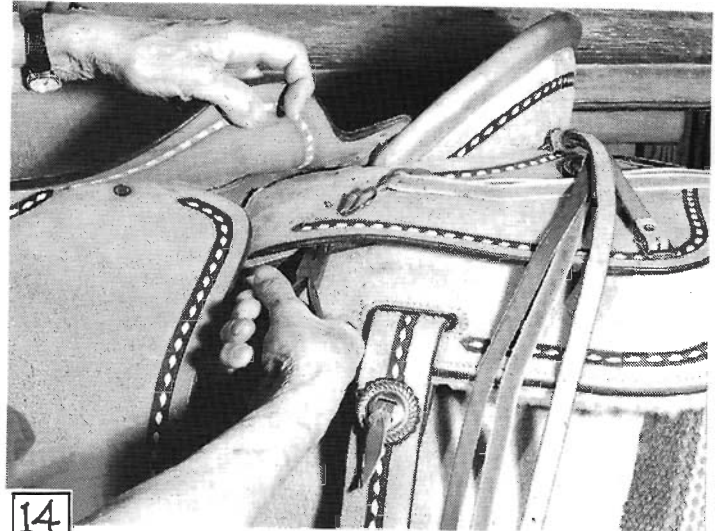


#3 hole



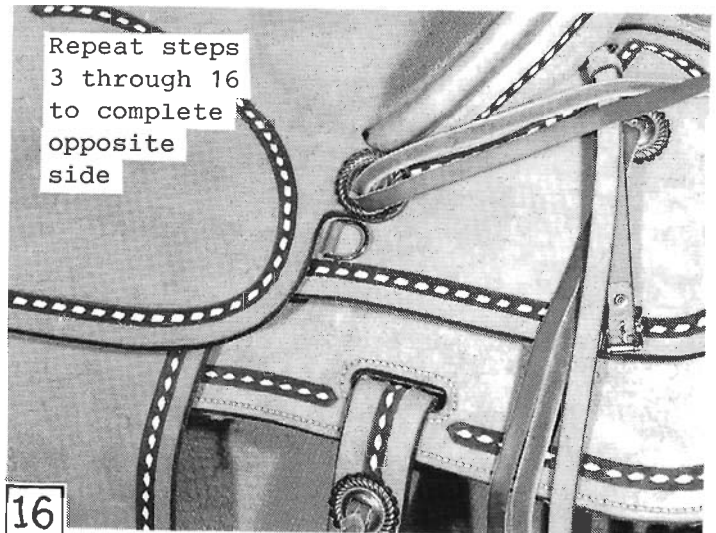
13

Remove the dee assembly and punch a hole through the tab, at the mark made in step 12. You will need a #12 copper rivet (1/2" long) and a copper burr.



14

and photo above. Since our jockey is riveted to the rigging...there is very little room to work with. With patience you'll be able to work the rivet into the holes. If the jockey was not riveted to the rigging, it would be no problem.



16

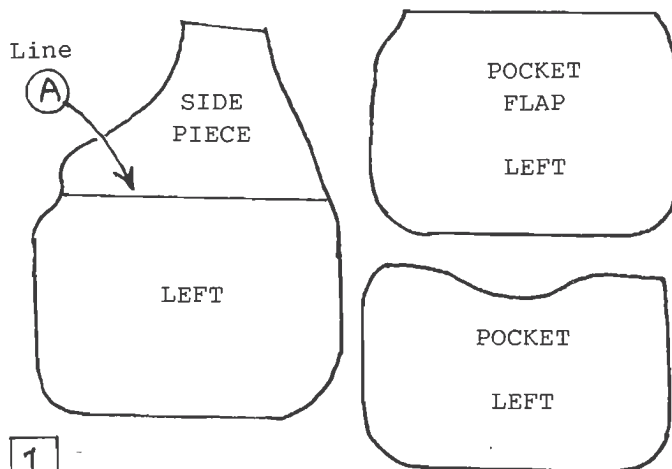
Pull the saddle strings back through the ear & rosettes. Return all nails to their former positions. Retie the strings. The saddle is ready for the saddle bags.

MAKE the SADDLE BAG PATTERNS

Study the patterns that we have presented. You will notice the shape of the side piece (at bottom), pocket & flap are the same on Saddles No.2 & No.4...but are different on Saddles No.1 & No.3. This must be taken into account when making the patterns. We'll begin with Saddle No.1. Carefully follow all instructions below.

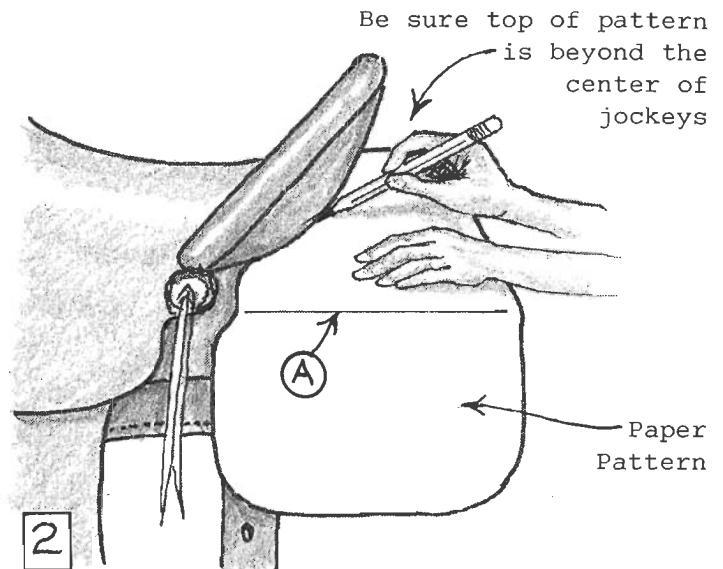
FITTING the PATTERN on SADDLE No.1

PAPER PATTERNS



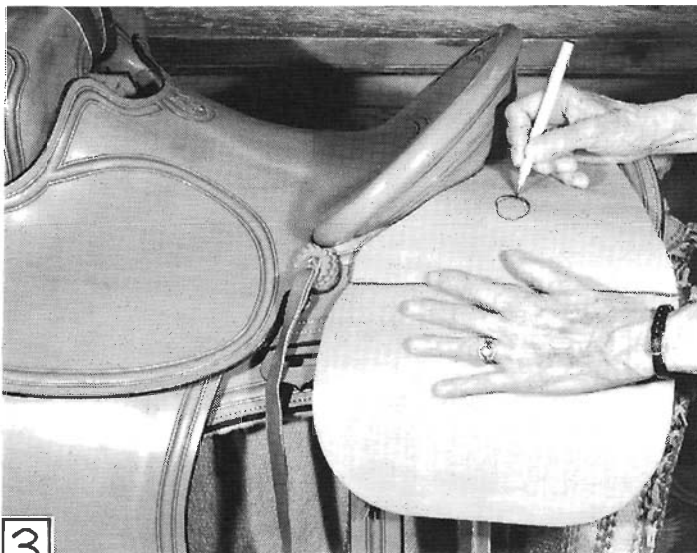
1

Transfer the patterns to heavy wrapping paper. This can be done by using the graph or by tracing over pattern lines with carbon paper underneath. Or...by running an overstitch wheel over the lines, transferring the wheel marks to the wrapping paper underneath. Be sure to mark the bag parts as shown above. Carefully cut out the parts. Draw line (A) on **both** sides of the pattern!



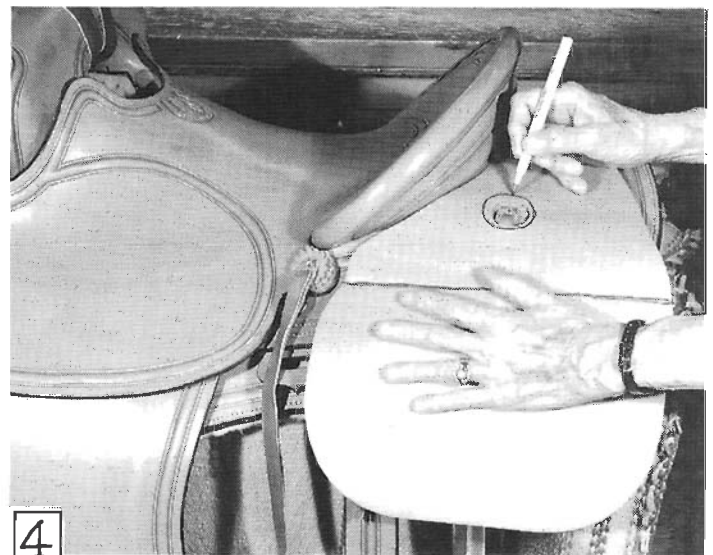
2

Now fit the side piece pattern in place, behind the cantle. The position of line (A) should be at about the center of the ear, or near its lower edge. Also...line (A) should be horizontal as shown in sketch above. Mark behind the cantle for any trimming required to make the pattern fit snugly at the cantle.



3

Trim the pattern from step 2, if necessary. Fit back in place. Hold the pattern securely and draw a small circle above the rosettes, but not as large as the rosettes.

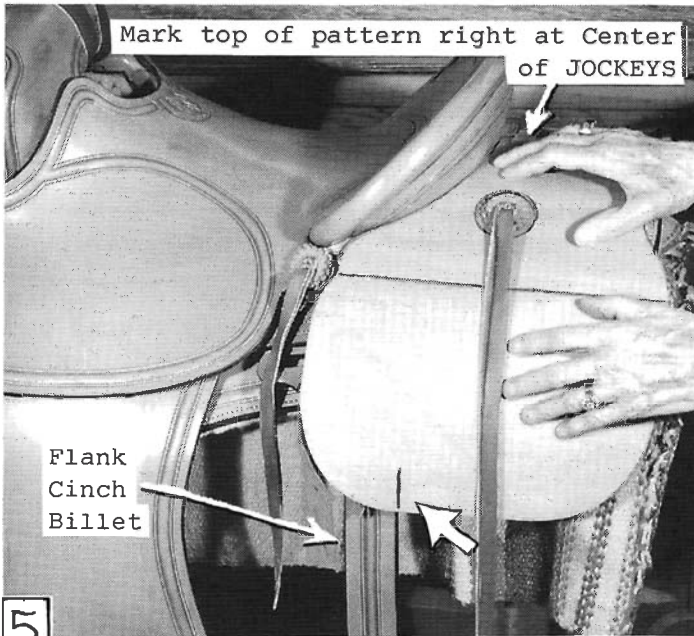


4

Remove the pattern. Cut out the circle made in step 3. Fit back in place. Now you can see the rosettes. Enlarge the circle so it will fit around the rosettes. Cut out the enlarged circle.

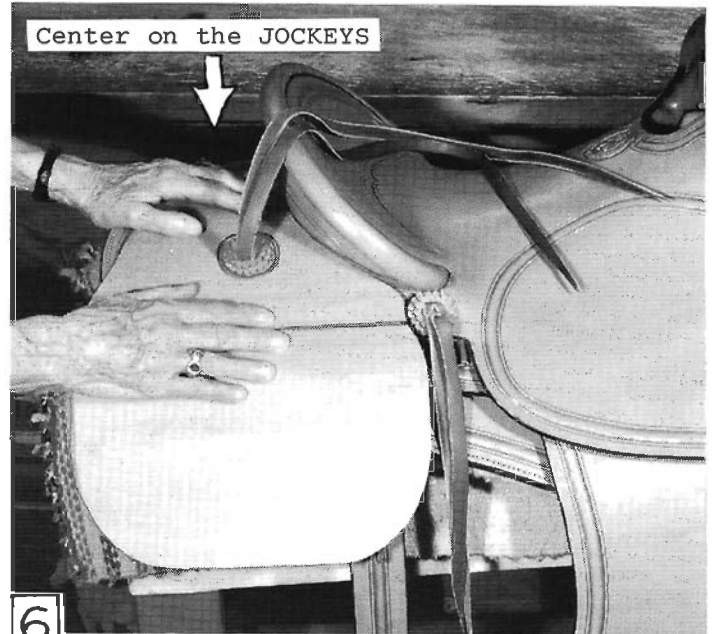
(continued)

FITTING the PATTERN...continued



5

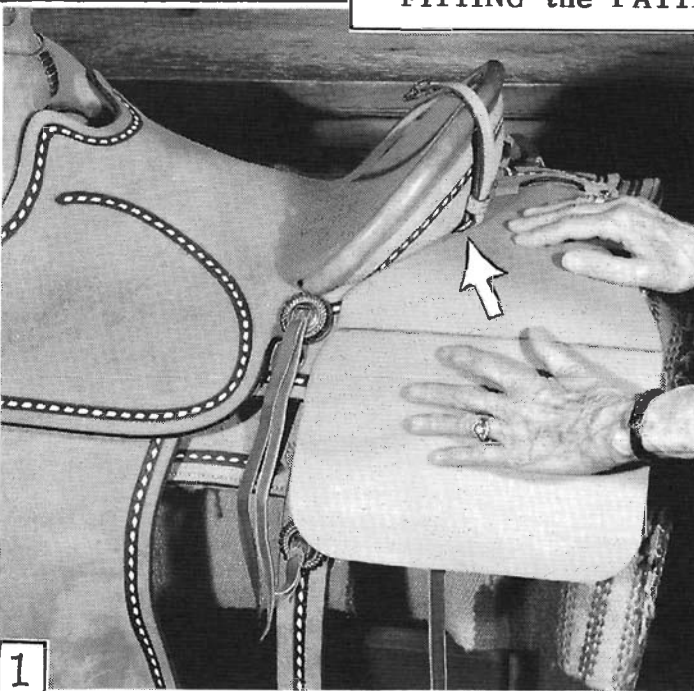
Replace the pattern. Pull saddle strings through the hole; fit back in place as in photo above. Trim more, if necessary, so the hole fits evenly around the rosettes with about 1/4" clearance. Put a mark on the pattern (arrow) to indicate the back edge of the flank cinch billet. The importance of this mark will be shown later in the instructions, on page 24.



6

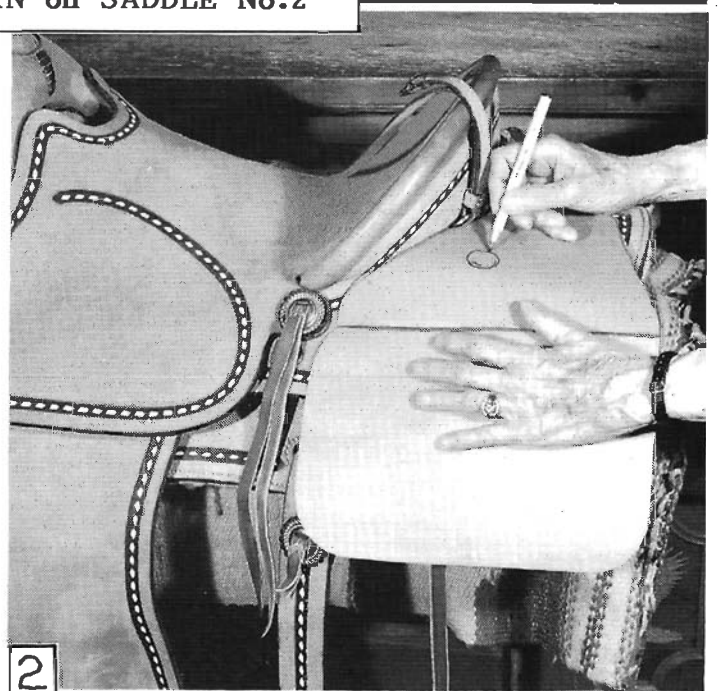
Make all necessary trimmings on the pattern (from step 5). Now flop the pattern and fit it on the opposite side. The top (arrow) should be at the center of the jockeys. Check hole around the rosettes, it may differ a bit and must be marked for any changes on the **right** side. Here, it is shown correctly fitted and no changes are needed from that of the left side.

FITTING the PATTERN on SADDLE No.2



1

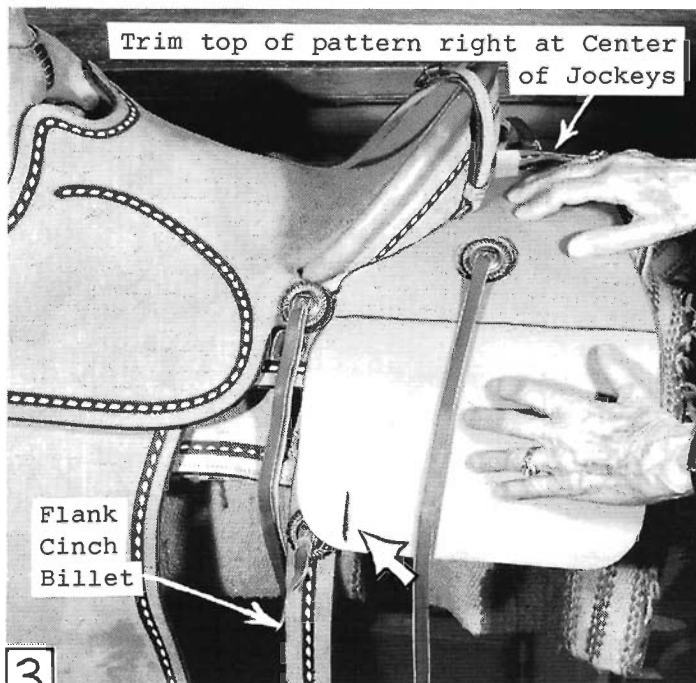
With this saddle, the pattern must trim out to fit around the cantle-back dees and straps (at arrow) so it will fit against the back of the cantle.



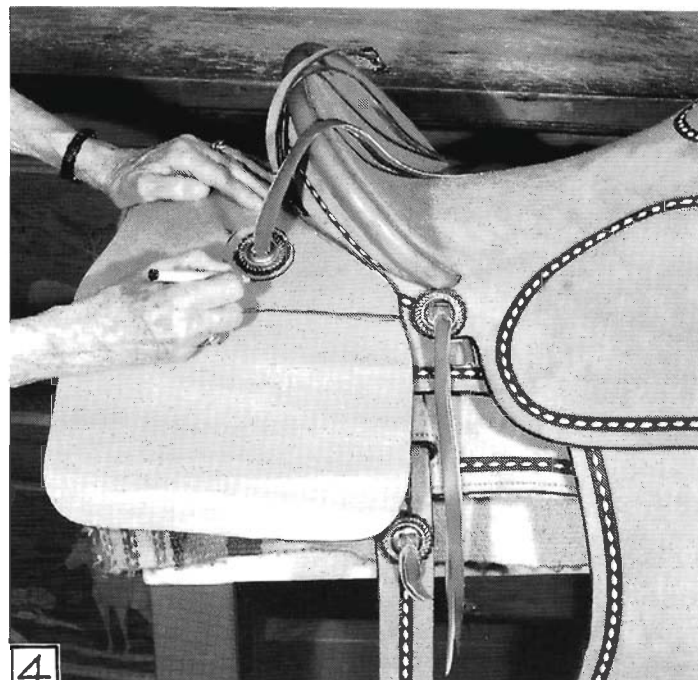
2

After trimming, fit back in place and mark the position of the rosettes, same as in step 3 for our Saddle No.1.

(continued)

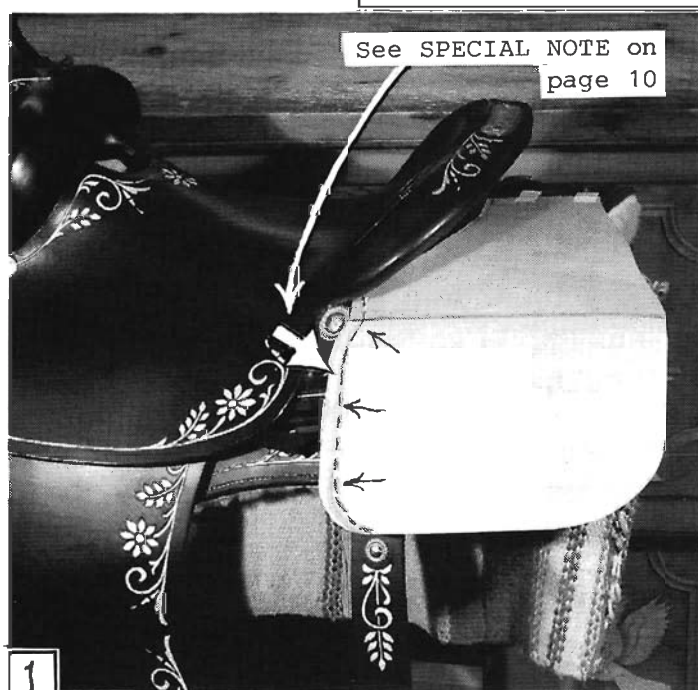


Now follow steps 4 & 5 of Saddle No.1. This will have the left side fitted properly. Be sure to mark the top, centered on the jockeys. Again, mark the pattern to indicate the back edge of the flank cinch billet.



Fit the pattern on the right side, same as in step 6 with Saddle No.1. Here, the pattern is not exactly fitting over the rosettes. Mark pattern for altering the position of the hole on the RIGHT side, to fit evenly around the rosettes.

FITTING the PATTERN on SADDLE No.3

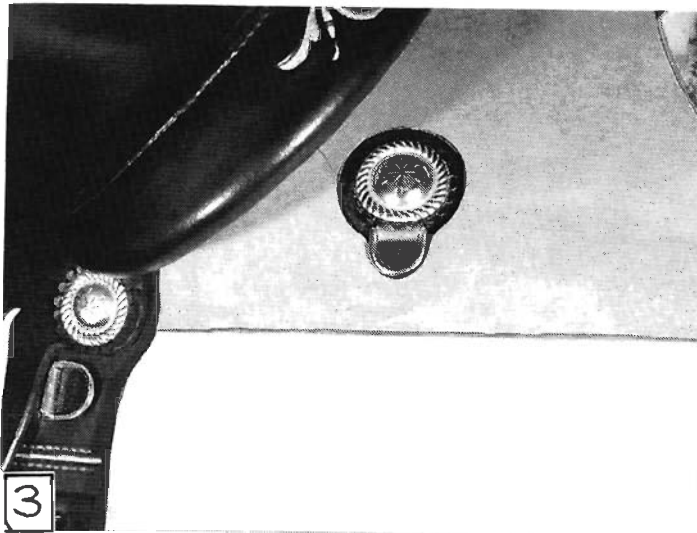


Fit the pattern as previously instructed. Here, after trimming and fitting against the cantle, the front part of the pattern is too far forward (large arrow). There would not be enough room for buckling on the bag. Mark it for trimming...shown by the broken line.

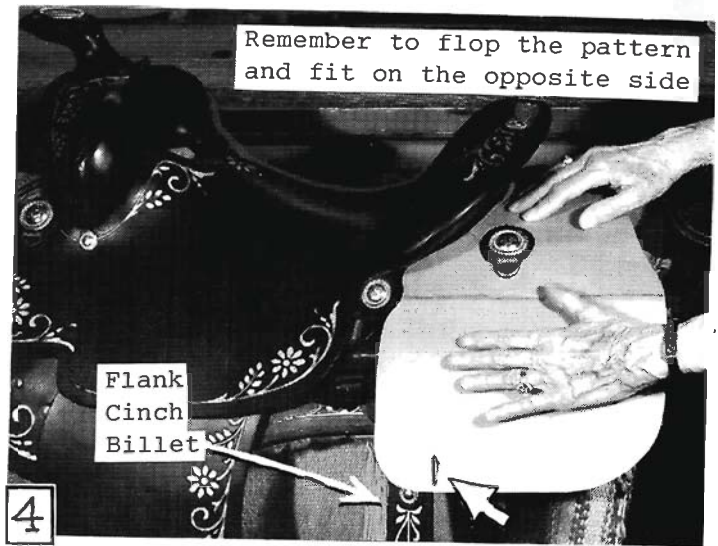


Trim off the front. Cut the hole for the rosette as instructed in steps 3, 4, 5, for Saddle No.1. This rosette has a saddle string dee assembly that will have to be allowed for. See the next step.

(continued)

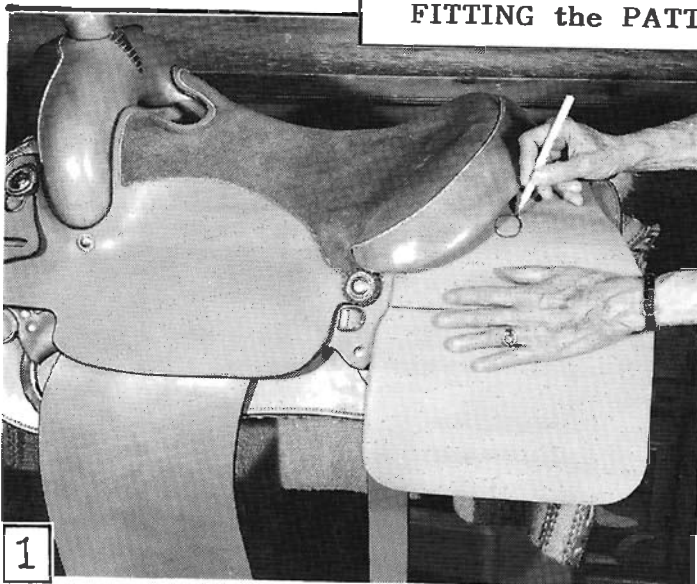


With the hole properly fitted over the rosette, mark the pattern to fit around the dee. Remove the pattern and cut out for the dee. Refit as shown above.

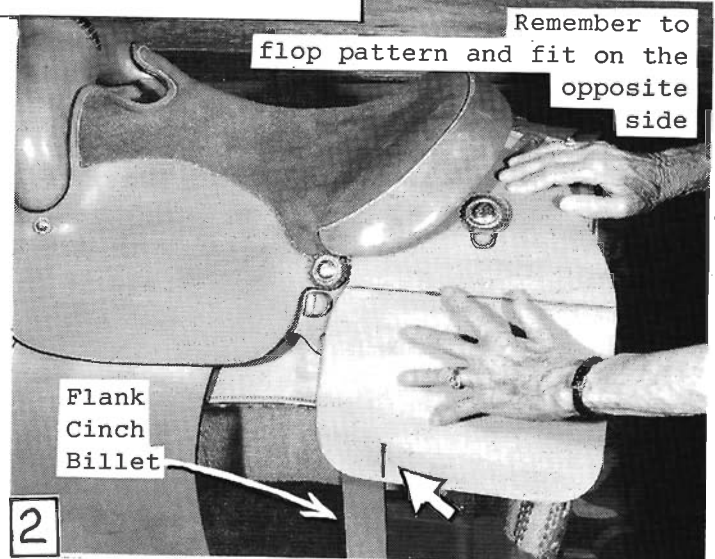


With the pattern in place, mark it at the back edge of the flank cinch billet (large arrow) as you have done before.

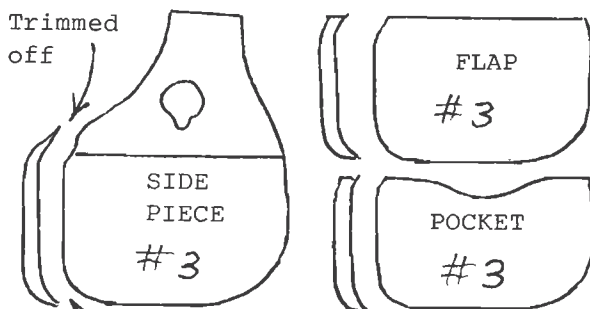
FITTING the PATTERNS on SADDLE No.4



Again, fit the pattern and trim to fit the cantle. Begin marking for the hole for the rosette.



Follow all previous instructions. This pattern is also cut out for saddle string dees, same as with Saddle No.3.

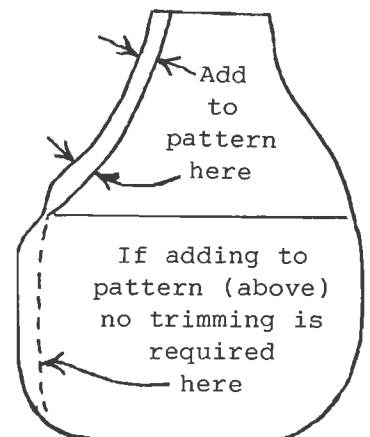


See step 1, page 9. Pocket and Flap must also be trimmed an equal amount.

SPECIAL NOTE:

Illustration at left shows how width of Flap and Pocket is shortened because Side Piece was shortened.

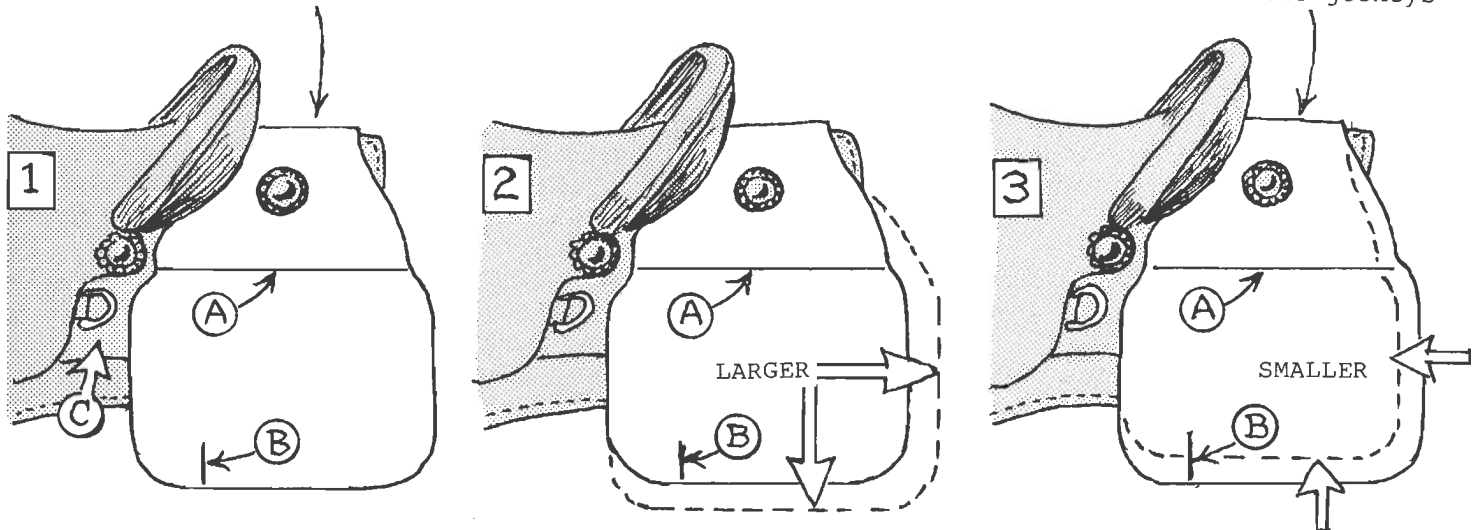
This can be avoided by adding to the pattern, behind the cantle, as shown at right. Then, trimming is not required on side piece.



IN REVIEW

Remember to flop the pattern to fit the opposite side

Be sure the top of the pattern is centered on the jockeys



We have shown you how to fit the SIDE PIECE patterns to our 4 different saddles and how small variations occur.

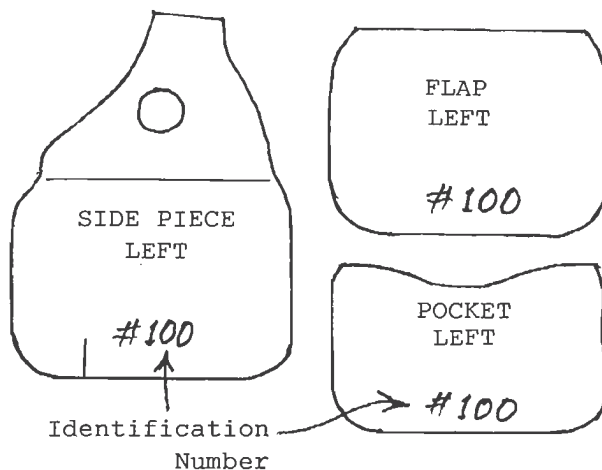
[1] Be sure line (A) is horizontal. Mark it on both sides. Line (B) only needs to be on the left side. How this line is used will be explained later. The space at (C) is needed to properly buckle the saddle bags on tightly.

[2] If you want larger pockets, extend the pattern to the broken line. The pocket flap and pocket patterns will also have to be extended here.

[3] If you want smaller pockets, reduce the patterns to the broken line. You can make the pockets any size you desire. However we feel the size of our pockets are most practical for every day use.

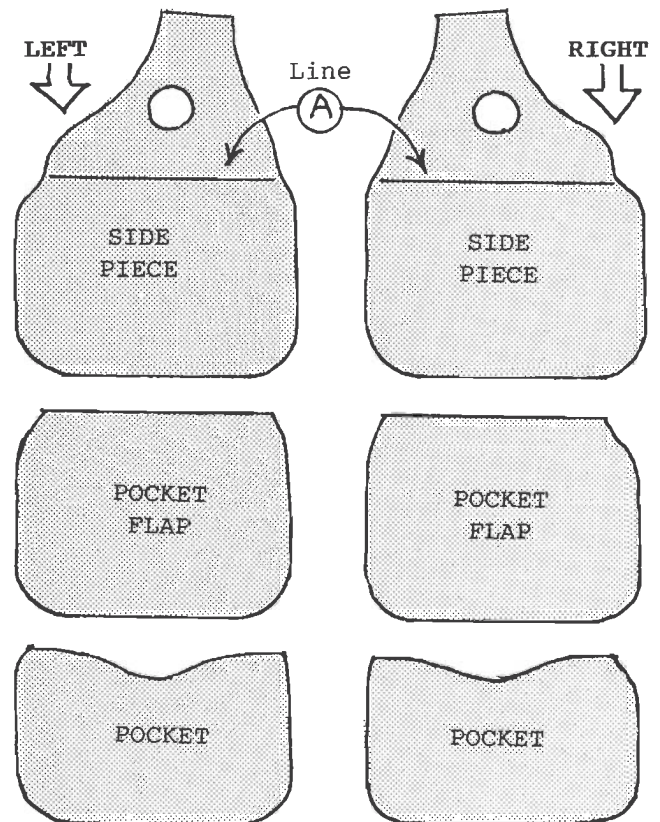
MAKE your own BAG PATTERNS

PAPER PATTERNS



Make the patterns for your own saddle from previous instructions. Mark each piece as shown. Put a number or name on each piece to identify the patterns with your customer's name or saddle that the bags are being made for.

CUT OUT the MAIN BAG PARTS



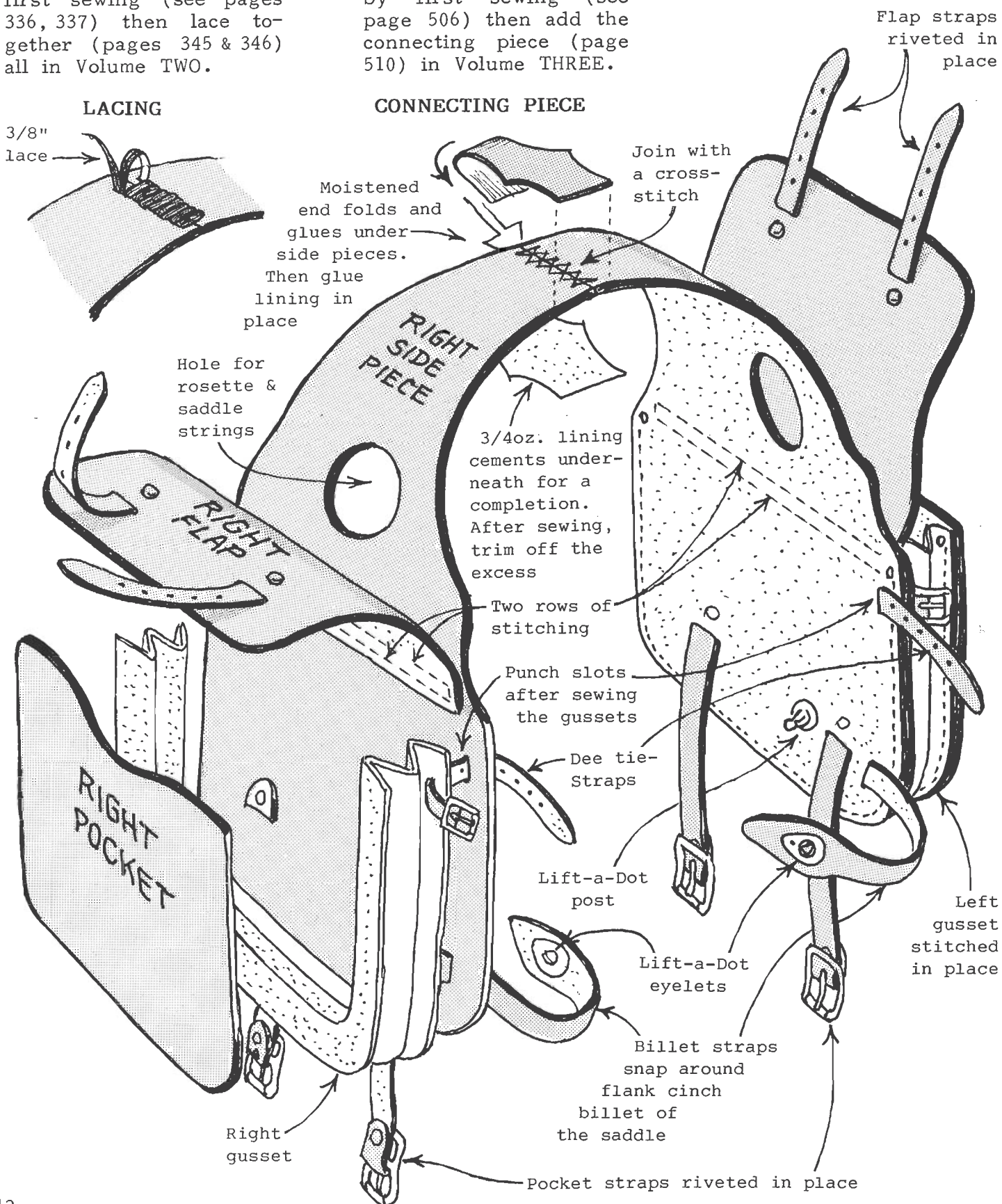
Cut these parts out of firm 7/8oz. cow-hide. Mark line (A) on each side piece. Make one **LEFT** and one **RIGHT** of each piece.

SEMI-EXPLODED VIEW OF THE SADDLE BAGS

OPTIONAL METHODS OF JOINING THE SADDLE BAGS

LACED: Join the pieces by first sewing (see pages 336, 337) then lace together (pages 345 & 346) all in Volume TWO.

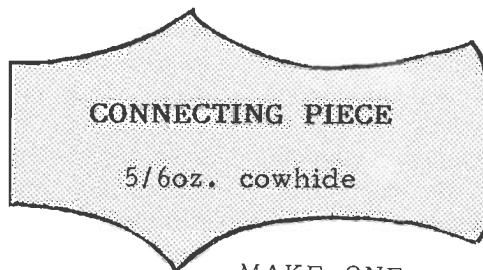
SEWN: Join the pieces by first sewing (see page 506) then add the connecting piece (page 510) in Volume THREE.



ADDITIONAL PATTERNS for the SADDLE BAGS

Note:

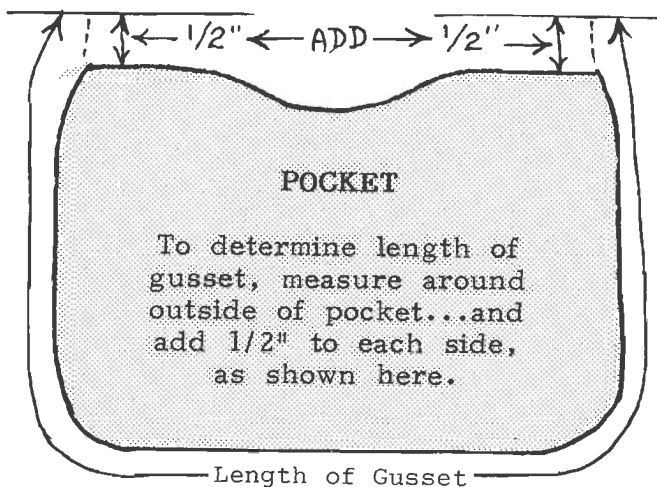
Full Size Patterns for the additional parts shown on this page are in the Pattern Section. Instructions for their installation and uses will be found throughout the pages in this book.



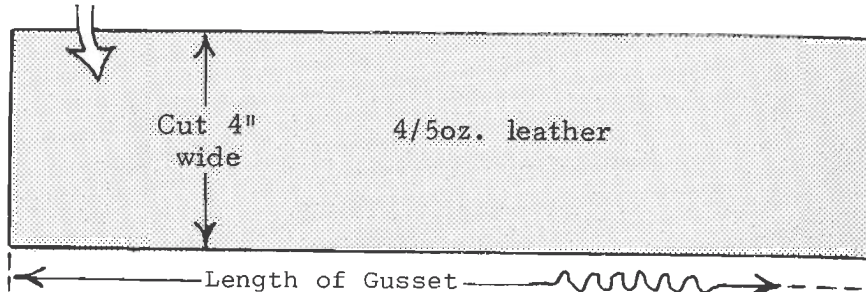
MAKE ONE



MAKE ONE



GUSSET - MAKE TWO



Do not cut the gussets from oil-tanned leather. They must be able to absorb water so they can be formed to fit around the pockets.

BILLET STRAP - MAKE TWO

6oz. cowhide



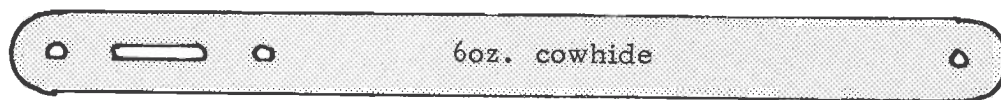
This strap tapers toward end. Dimensions are given on full size pattern.

POCKET STRAP - MAKE FOUR

3/4"
roller
buckle



-(4 required)-



FLAP STRAP - MAKE FOUR

6oz. cowhide



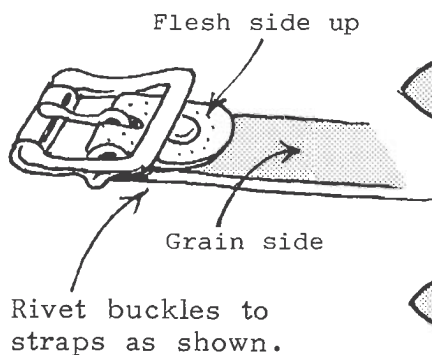
DEE TIE-STRAP - MAKE TWO

4oz. leather



1/2"
roller
buckle

-(2 required)-



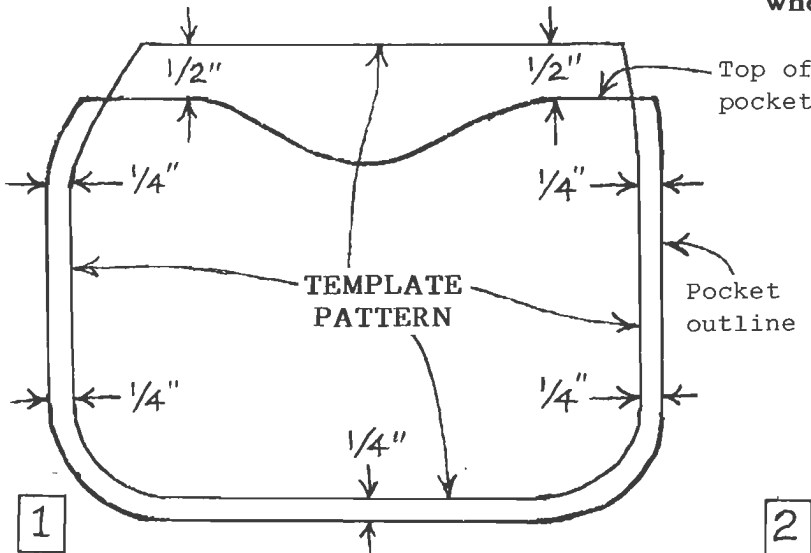
Note:

See **FULL SIZE PATTERN** sheet for widths & lengths of straps, positions of slots, holes, areas to skive, etc.

FORMING the GUSSETS

To form the gusset leathers they must be very well "cased". Cut the gusset leathers to proper length & width as instructed on page 13. Thoroughly soak them in warm water and place in a clear plastic bag. Set it aside and allow it to "case" overnight. Accordion-style gussets are the most ideal for saddle bags. They will ex-

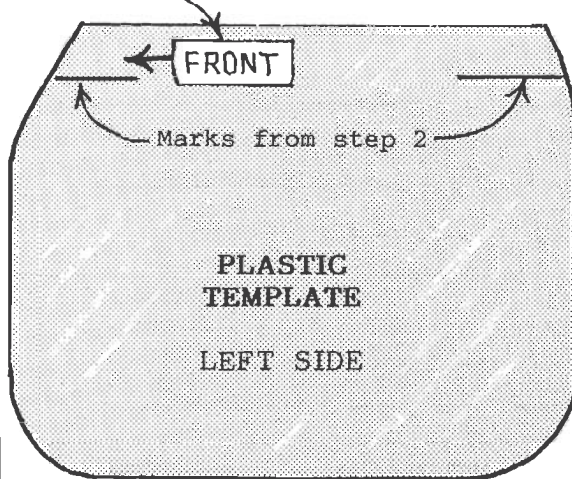
pand to varying thicknesses of materials without excessive expansion, yet will lay very flat when the bags are empty. Anything you tie on a saddle should lay flat and as bulkless as possible. This aids in reducing damage to items when riding in dense brush & trees as well as possibly spooking your horse into unwanted actions when bags are banged against trees, etc.



1

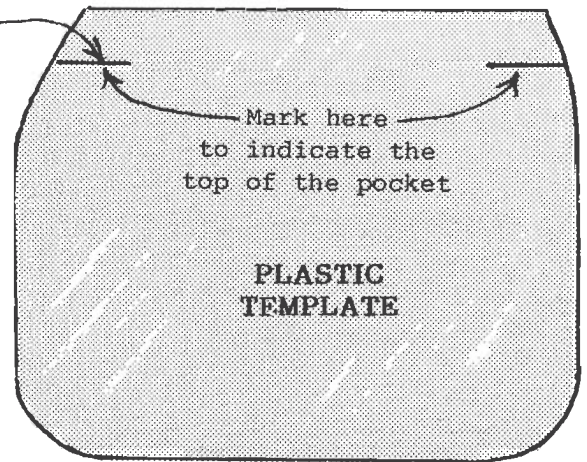
To properly form the gussets, especially at the corners, a template must be made. Make a pattern to the dimensions shown above. It should be 1/4" smaller than the pocket all around, and 1/2" longer at the top. Observe the sketch.

Mark "FRONT"



3

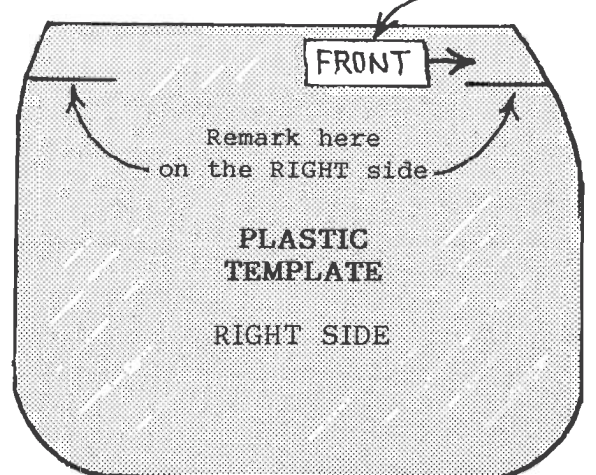
To help identify the gussets, after they have been formed, put a piece of masking tape on the template in position shown. Mark it (as shown) to indicate the **front** of the gusset. Gussets can be put on LEFT or RIGHT pockets as long as the **front** is to the **front** of the pocket.



2

Use your template pattern and mark around it to the template material. Templates can be made out of heavy plastic, sheet metal, formica or similar material. It is best to be around 1/32" in thickness. Be sure the material is not fragile. We have used clear plastic for our template.

Mark "FRONT"

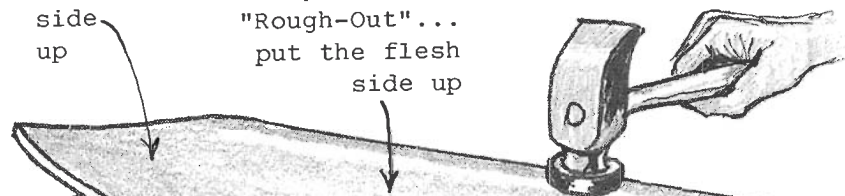


4

Turn the template over. Put another piece of masking tape over the one in step 3. Mark this one to indicate this is **still** the **front** of the gusset. After the gusset has been formed, mark **front** on its top to insure it will be fitted at the **front** of the pocket; be it LEFT or RIGHT.

Grain
side
up

If you want a
"Rough-Out"...
put the flesh
side up



5 While making your template pattern, take one gusset out of the casing bag. Lay it on your bench, grain side up, and allow the moisture to begin evaporating.

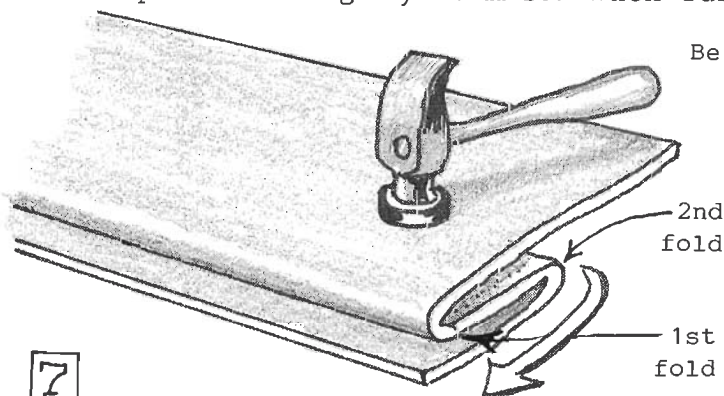
Align edges

Fold
in half

1st
fold

6

When the moisture content of your gusset leather is "just right" (you will learn this only through experience) place it on your marble. (See page 3 of Vol. ONE of our *Making Leather Cases* book for more "casing" information.) Fold the leather in half and tap the fold lightly at first. When sure the fold is centered, tap it firmly!



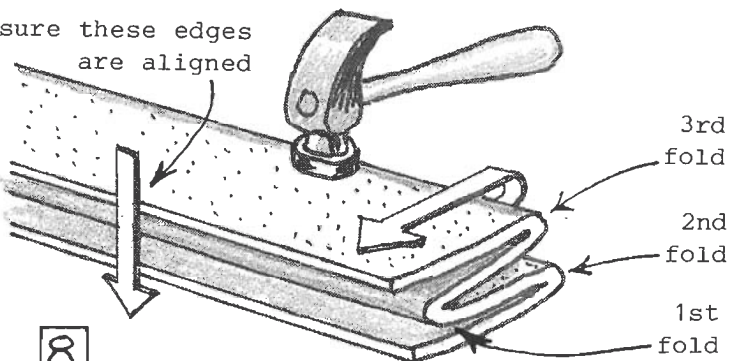
Be sure these edges
are aligned

2nd
fold

1st
fold

8

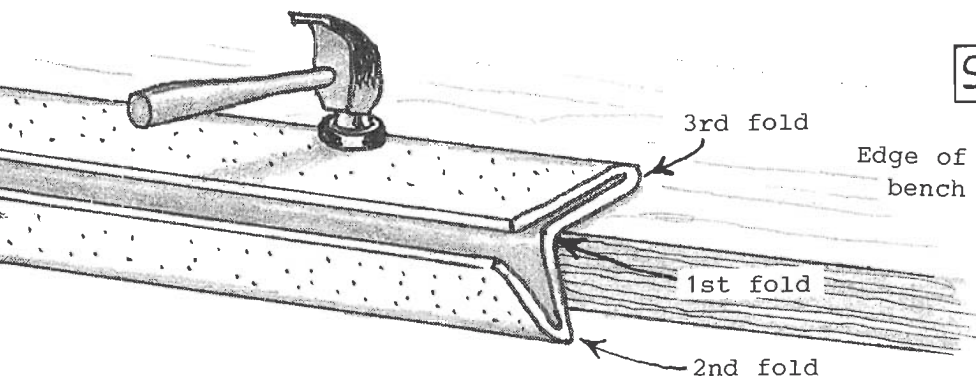
Now fold the top forward to form a 3rd fold, which should be even with the 2nd fold. The top edge should extend 1/4" beyond the 1st fold, and be aligned with the edge at the bottom. When alignment is correct, tap 3rd & 2nd folds firmly.



3rd
fold

2nd
fold

1st
fold



3rd fold

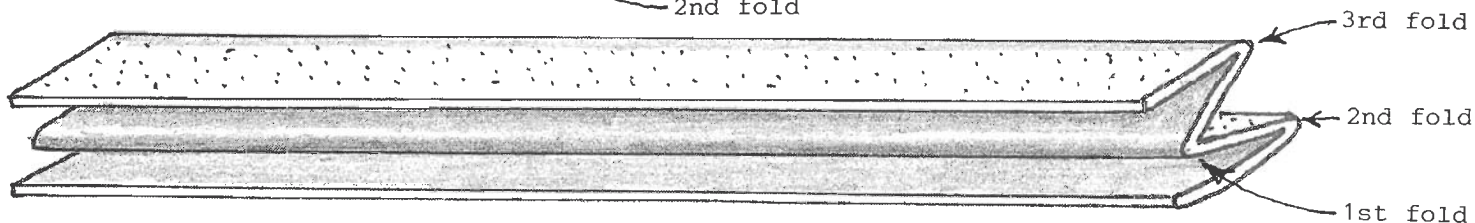
Edge of
bench

1st fold

2nd fold

9

After step 8, open the gusset in the middle, on 1st fold. Place it on the edge of your bench as shown at left. Now firmly tap the 3rd fold down. Turn it over and repeat with the 2nd fold. This will establish sharply defined folds.



3rd fold

2nd fold

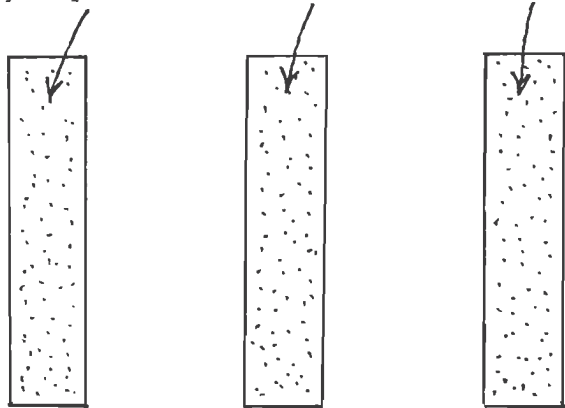
1st fold

10

You now have an "M"-shaped gusset like the sketch above. Check the moisture content. If it feels like the leather is "willing" to form, you are ready to continue. If feeling too dry; add a bit of moisture with a sponge. Do not get it too wet! Do not let it dry out!

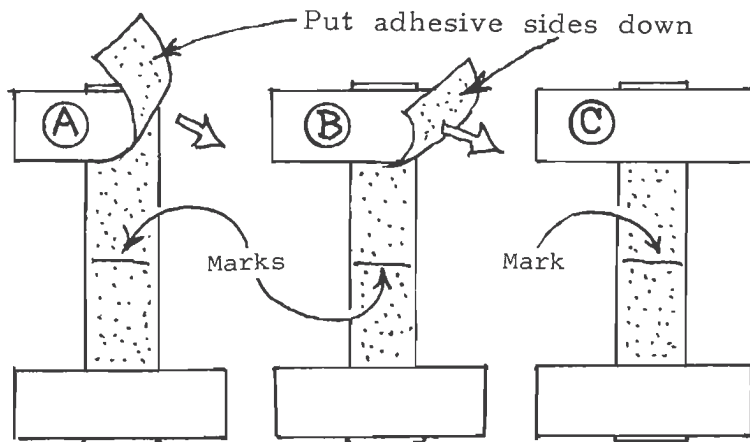
(continued)

Lay tape down with **adhesive sides up!**

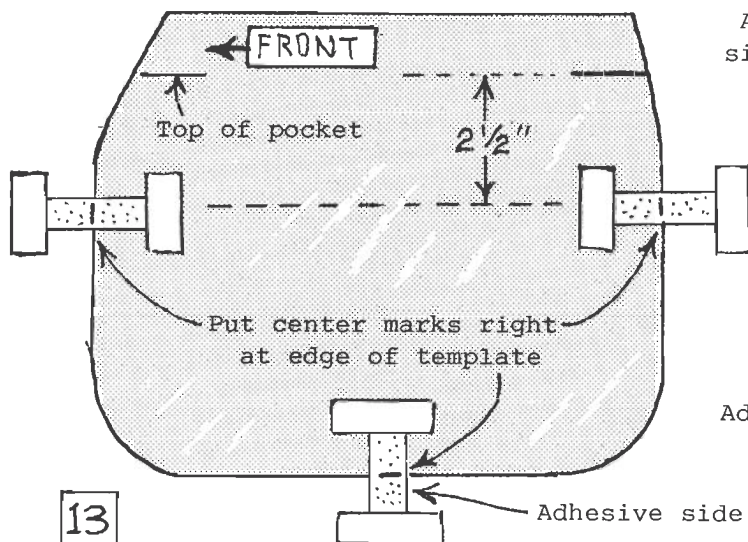


11 Now cut three pieces of 3/4" masking tape 3" long. Lay them out on a piece of wax-paper...in preparation for the next step. The purpose of the wax-paper is so the masking tape can be easily removed.

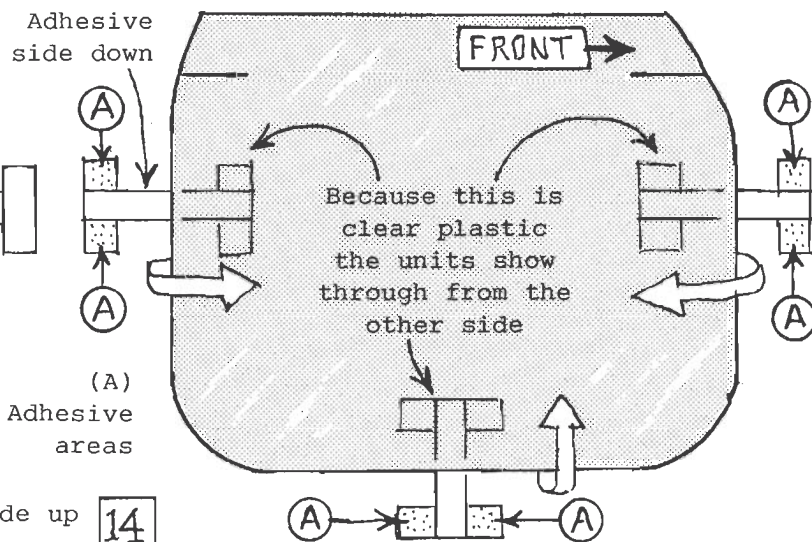
Put adhesive sides down



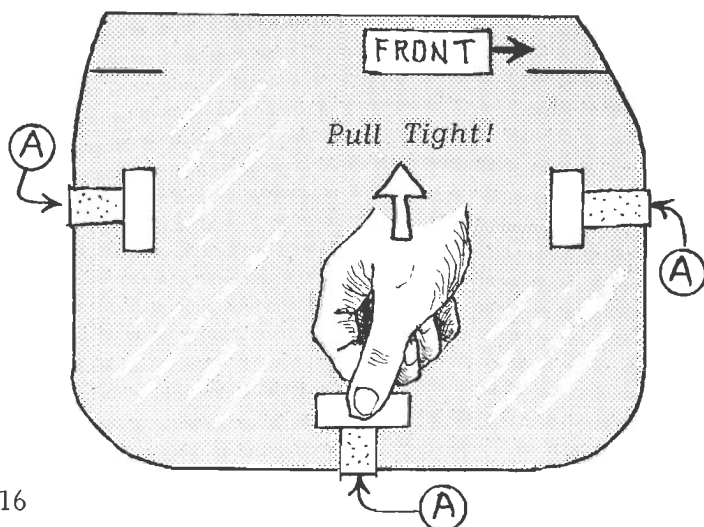
12 Cut six pieces of 3/4" masking tape about 1-3/4" long. Carefully lay them on the ends of the vertical pieces, as above. Draw marks on the center of the vertical pieces. These marks are explained below.



13 Tape each unit in place on the template as shown above; the top ones about 2½" down from the marks on the template that indicate the top of the pocket. The bottom unit tapes at the center of the template.



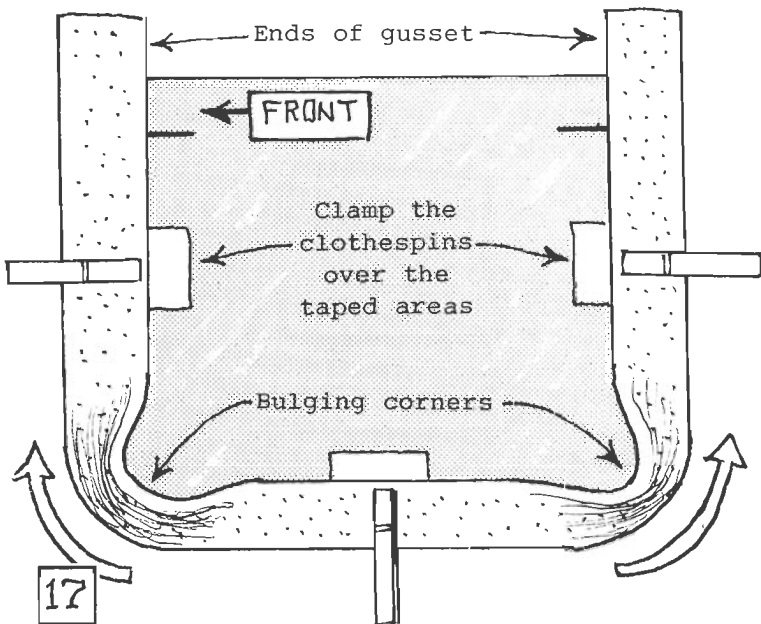
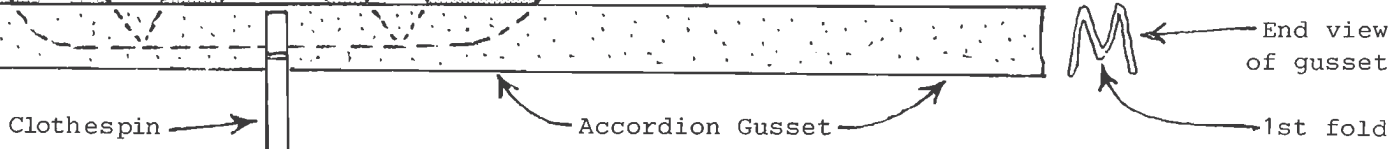
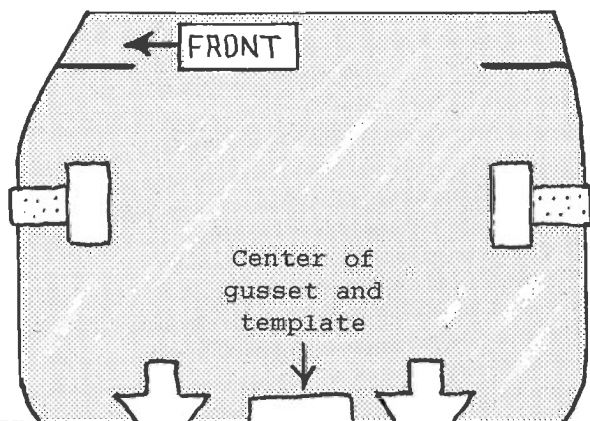
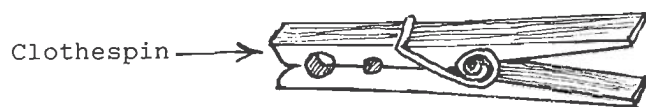
14 Now turn the template over. The vertical pieces (of steps 11 & 12) will have the adhesive sides down. The units will fold up (arrows) and the adhesive areas (A) will adhere to this side of the template.



15 Fold the units up over the top side of the template and adhere in place as shown in the sketch at left. Pull them tight over the edge of the template. The adhesive sides (A) are out at each side of the template. These adhesive sides will create a gripping surface on the gusset leather as it is formed around the template. This will assist in the operation.

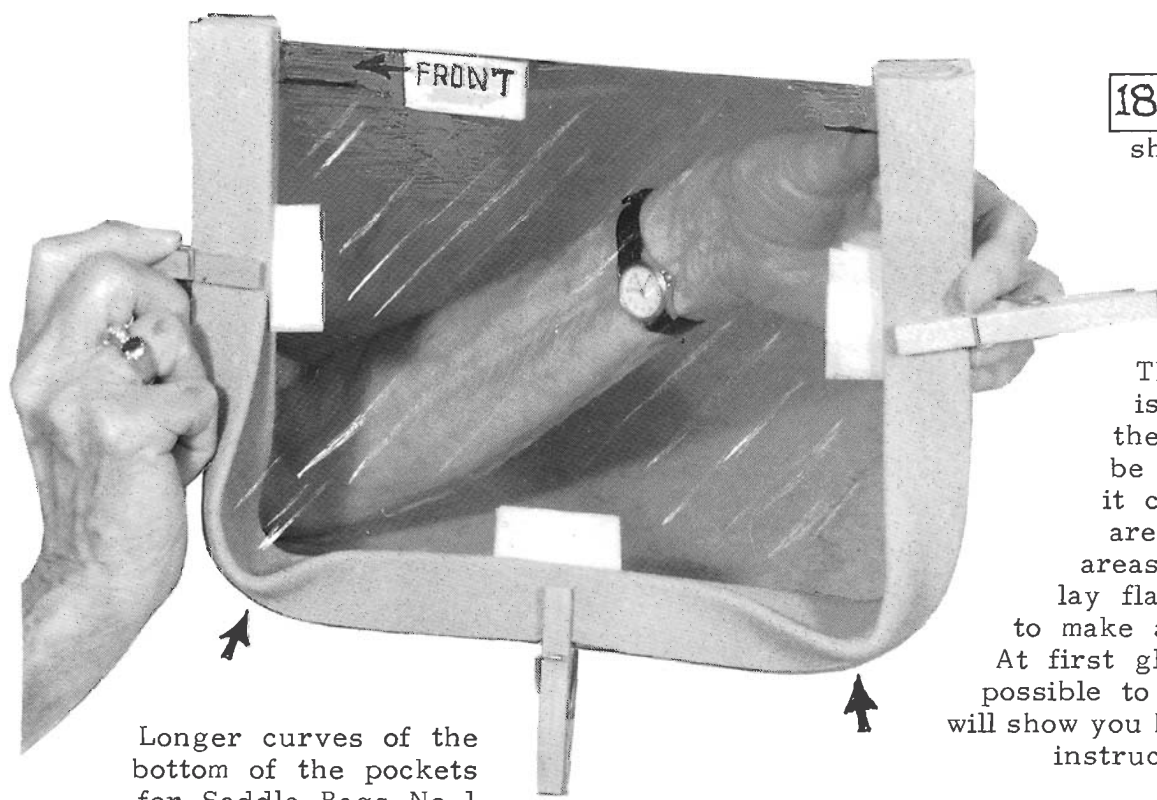
(continued)

16 Now take your gusset that was formed in step 10. Be sure to check its moisture content so that it is still pliable enough for forming. Locate its center. Push the bottom of the template down into the 1st fold of the gusset as far as it will go. Be sure it is centered. Now put a clothespin over the gusset, directly over the vertical tape, to hold the gusset leather in this position. Each clothespin acts as another set of fingers to assist in the operation.



17

Fold the sides up, one at a time, tight against the edge of the template, being sure the edge of the template is down in the 1st fold of the gusset. The corners will be bulged out but do not be concerned about it at this time. Put a clothespin over each side, as shown above. Be sure the ends of the gusset extend above the top of the template (as in sketch).



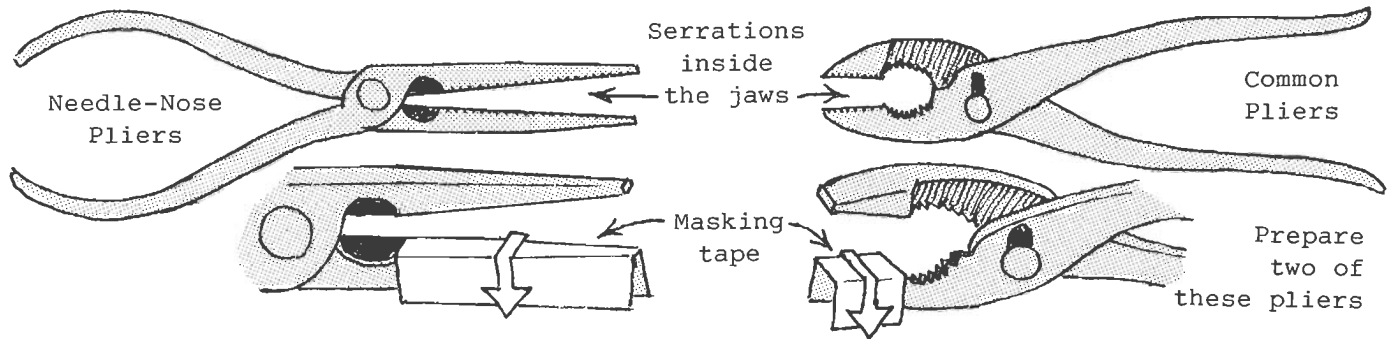
Longer curves of the bottom of the pockets for Saddle Bags No.1 are easier to form.

18

The photo at left shows how the gusset bulges out at the corners because of the small curves at the bottom of the template (large arrows).

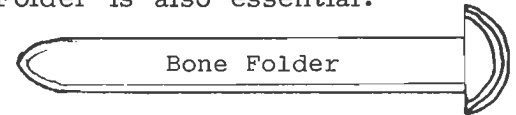
This is because there is excess leather in these areas that must be compressed before it can lay flat. These are the most difficult areas to work down and lay flat without wrinkles to make a professional job. At first glance, it looks impossible to get them flat. We will show you how in the following instructions. (continued)

TOOLS USED to ASSIST in FORMING the GUSSETS

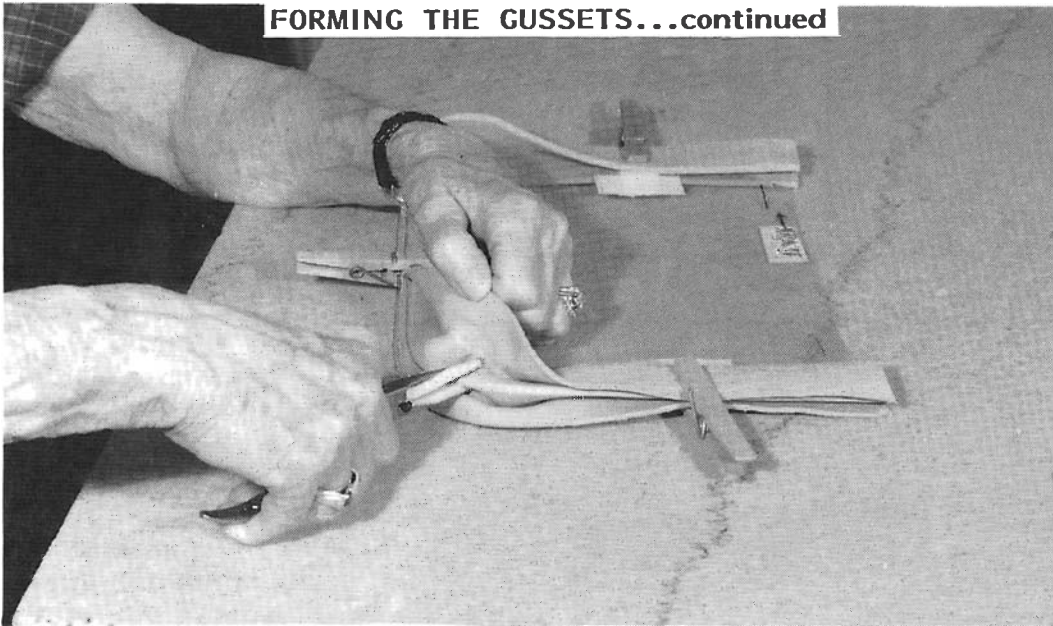


Use pliers shown to assist in forming the corners. Put masking tape over the serrations (both lower & upper jaws) to prevent marking the leather. Trim

off the excess tape where it will wrap around the jaws. See sketch above. A Bone Folder is also essential.

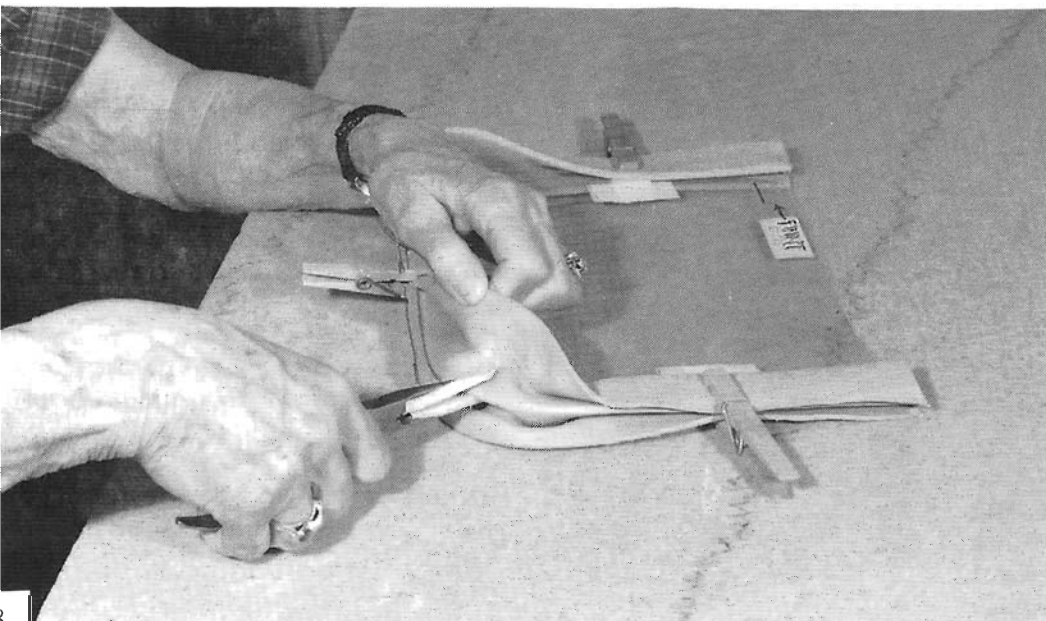


FORMING THE GUSSETS...continued



19

Lay the unit on your bench and pull the corner leathers out as shown. Use your needle-nose pliers and begin pinching the bulged area together to compress the leathers. Push the point of your pliers up to the 2nd and 3rd folds of the gusset.

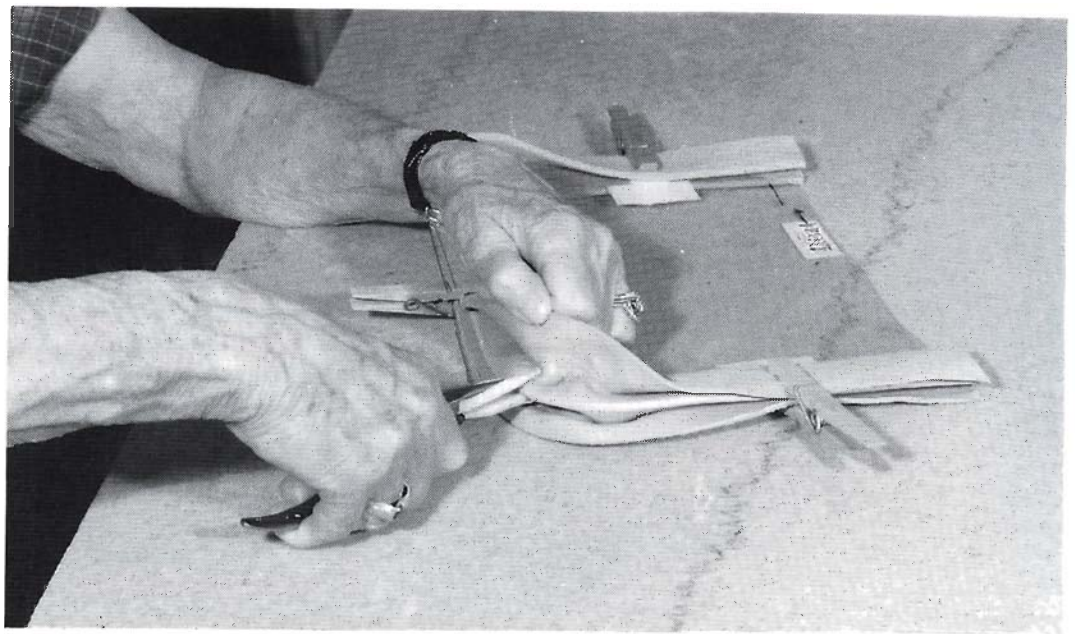


20

Move the pliers over and continue pinching the bulged areas. This will move the bulges around, but with continued effort you will notice that the leather will begin to compress and the bulges will gradually diminish.

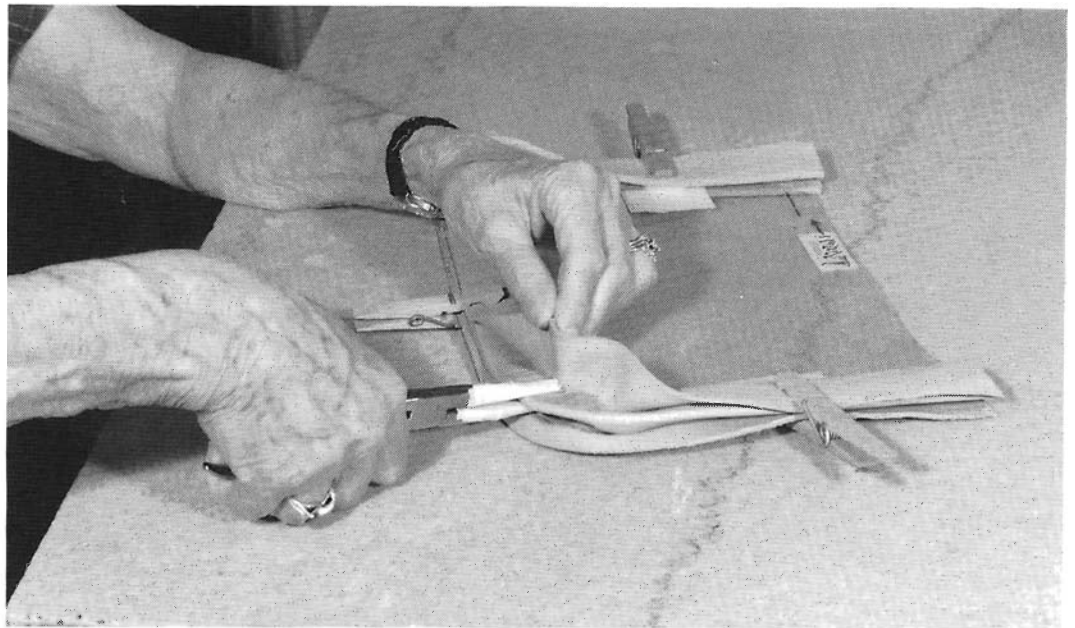
21

Continue pinching with the pliers all around the curved area to the left and to the right. You will notice less resistance as you work. Use the fingers of the left hand to help establish the position of the 2nd and 3rd folds.



22

Here you will see how the curved area is beginning to compress more smoothly. More work needs to be done to the right.



23

Now use the Bone Folder to smooth around the curved area. When the moisture content is "just right" you will see how easily the leather is formed without any wrinkles. You will learn this only through experience.



24

When the leathers are beginning to smooth out...tap the areas of the 2nd and 3rd folds.

Be sure the fold lines are smooth.

Turn the unit if required for better tapping position. Study the photo.

25

Turn the unit over so the area that was the bottom, is now on the top. Repeat steps 19 to 23 on this side. Here you will see that the Bone Folder is smoothing the area, as in step 23.

26

Again, tap around the 2nd & 3rd fold lines, as in step 24. Notice now how smooth and compressed the center section of the gusset is...in the curved area.

27

Now...the outside leathers of the gusset need to be stretched as much as possible, at the corners. Grip the leather with the common pliers, as shown in the photo. Pull in opposite directions as hard as you can! Re-grip in other areas and pull, to get the leather to stretch as much as possible.



28

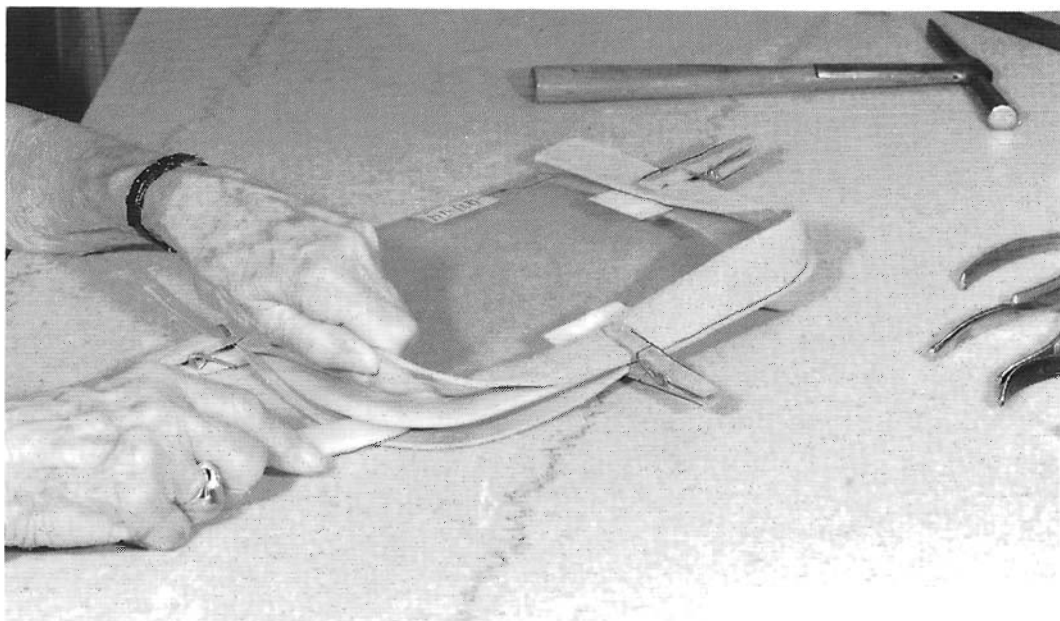
Then grip the bottom leather, at the corners, and get as much stretch in it as you can. This will make the gusset easier to fit around the bottom corners of the pocket and the side piece.

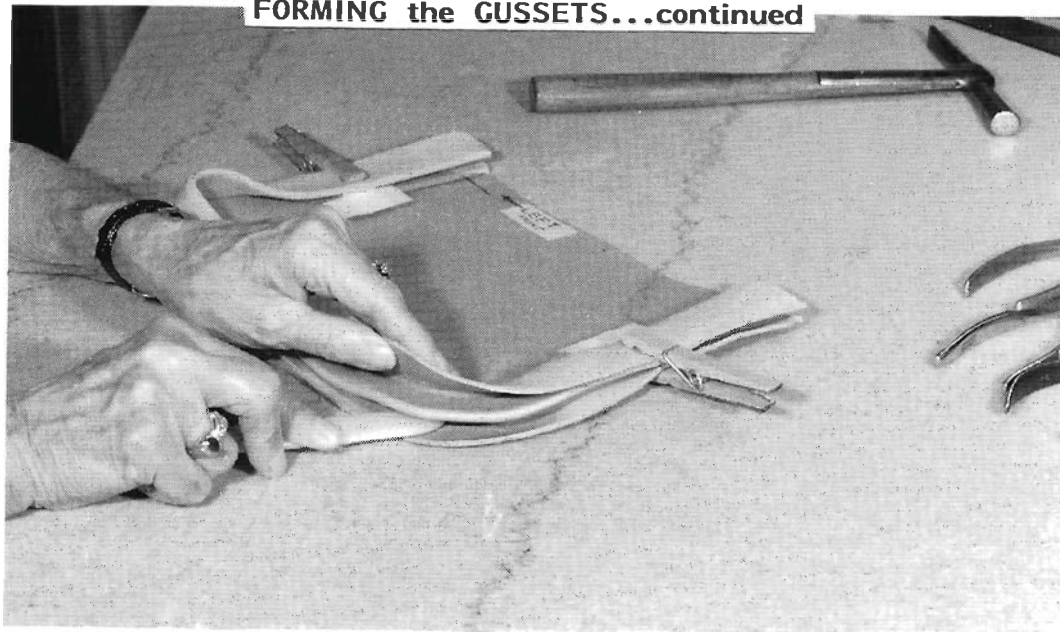


29

Now use the Bone Folder to smooth the leather you have just stretched in step 28. Note how well the corner is taking shape now.

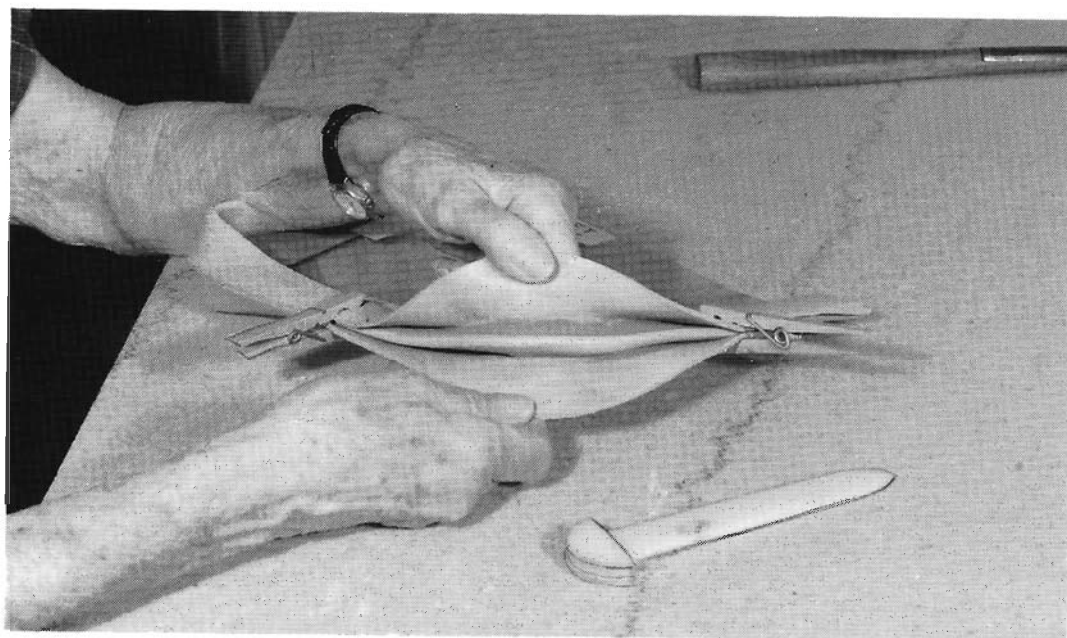
(continued)





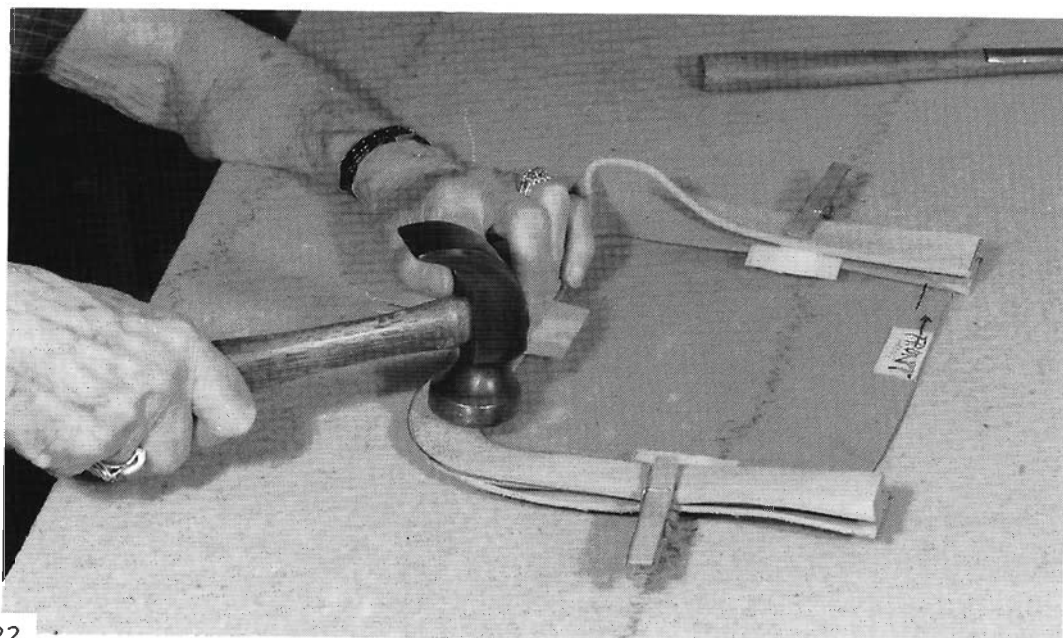
30

Now flop the unit over and smooth the opposite side of the gusset with a Bone Folder, the same as you have done in step 29.



31

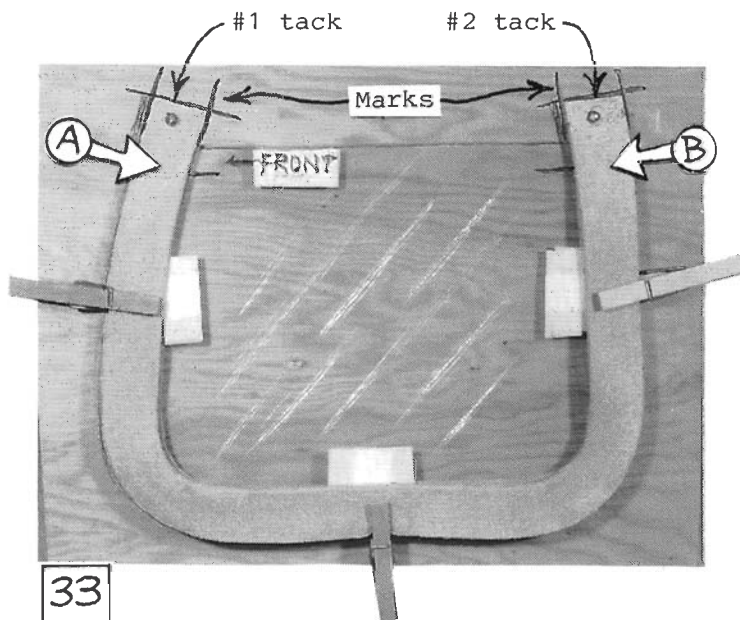
Here we are pulling the leathers apart to show you how all of the leathers in the gusset have been compressed and smoothed, at the corners, and are wrinkle free!



32

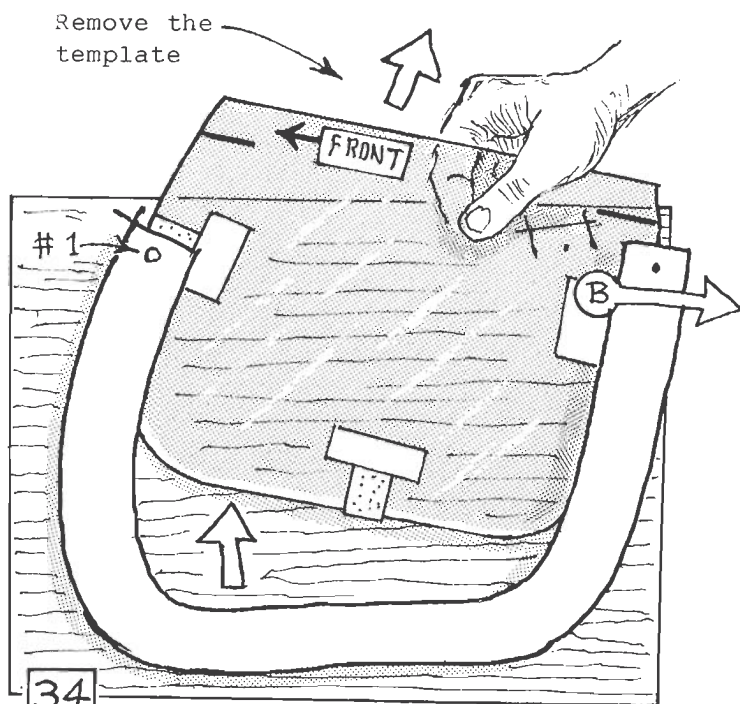
Again...use your hammer and tap the 2nd and 3rd folds flat. You have completed forming one of the corners of the gusset.

Now...form the other corner of the gusset by following steps 19 to 32.
(continued)



33

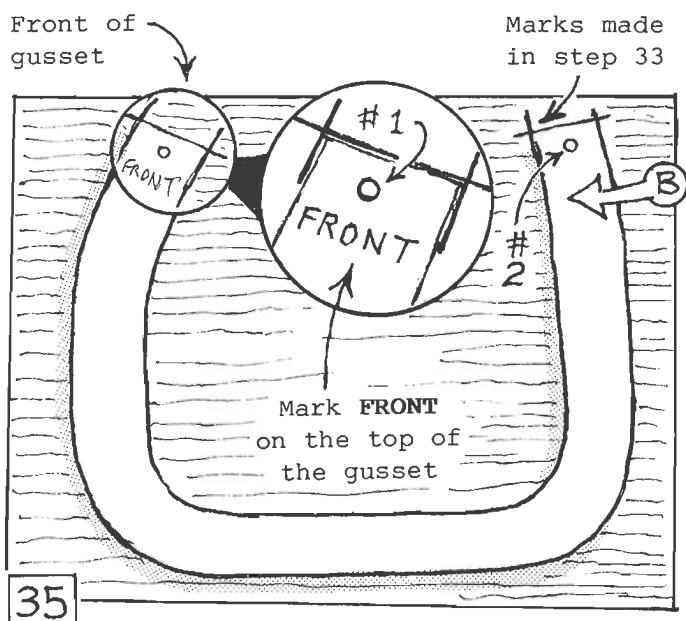
After the gusset has been formed, lay it on your bench or a board, as shown above. The top of the template curves in a bit on each side; more on the front than the back. So push the gusset in (A) up against the template. Hold all in place and drive the #1 tack through the gusset and into the board. Use #3 Hand Shoe Tacks. Repeat the operation with edge (B); tack it in place. Draw marks around the top ends of the gusset onto the board, so you will know they belong in these locations.



34

Now remove the clothes pins. Pull the #2 tack out and push the top of the gusset (B) out, so you can remove the template. Remove the template by lifting up and back. Hold the rest of the gusset in place while you are doing this.

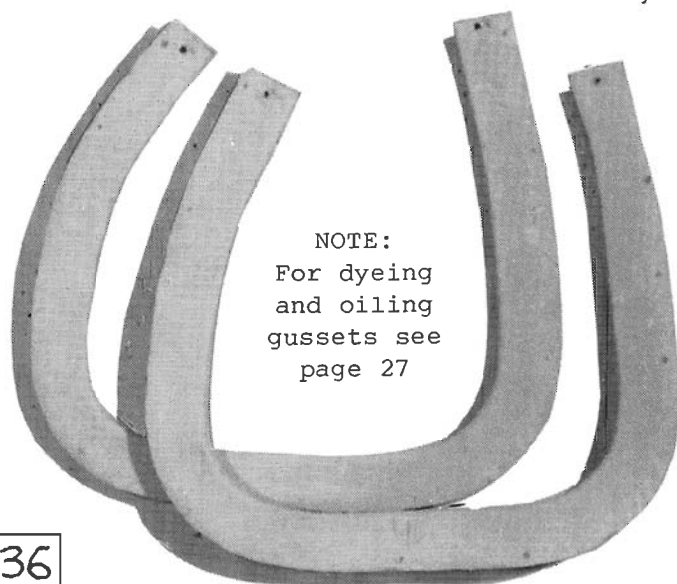
Now the template can be used to form the other gusset.



35

After the template has been removed, carefully push the top end (B) of the gusset back to its position on the board between the marks. Return tack #2. Mark **FRONT** on top of the gusset leather as shown in the enlarged view above. This will insure that you have the **front** of the gusset to the **front** of the pocket, during assembly.

Step 35 continued — Check with your template to be sure the **FRONT** is properly marked. Tap around the folds again to be sure all is laying flat on the board. Lay a clean sheet of paper over the gusset and weight it down with books. Allow to dry.

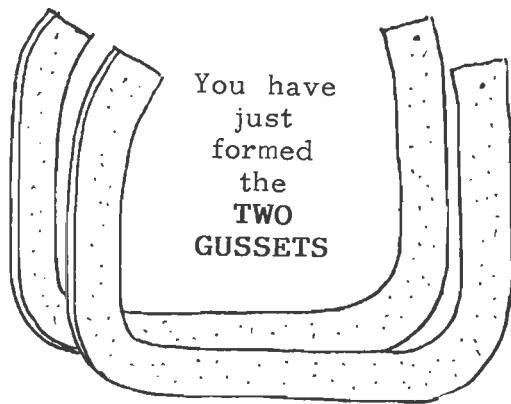


36

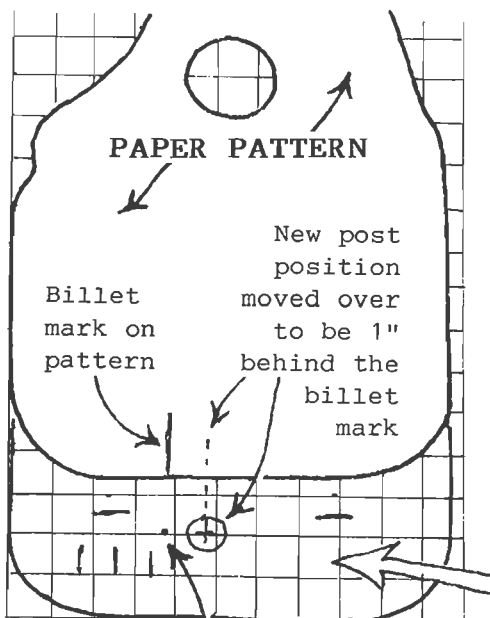
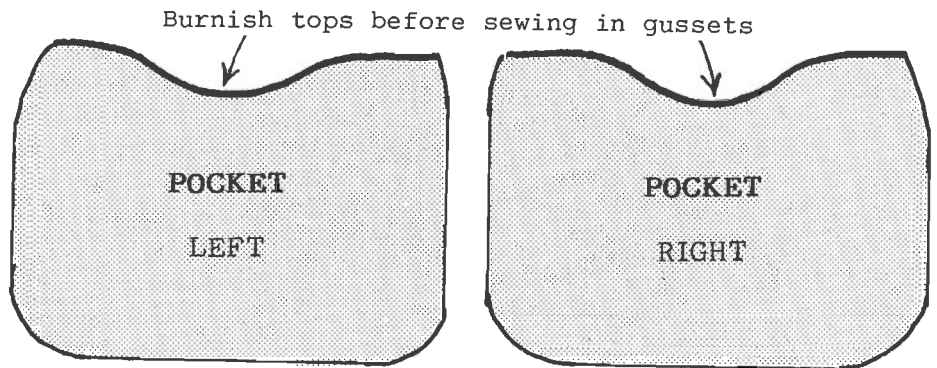
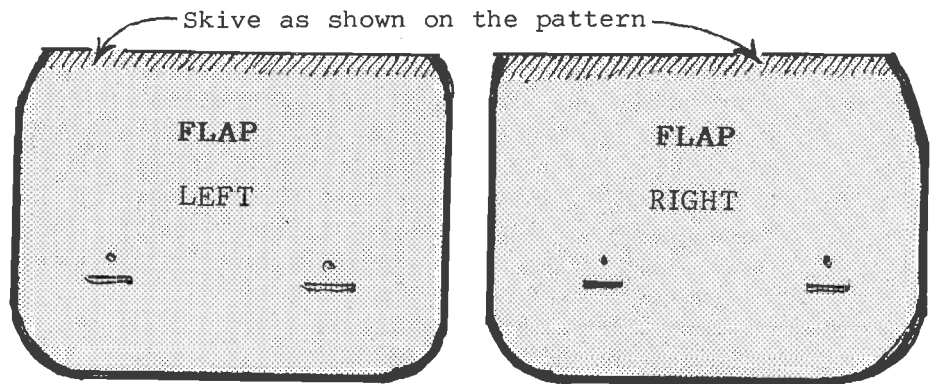
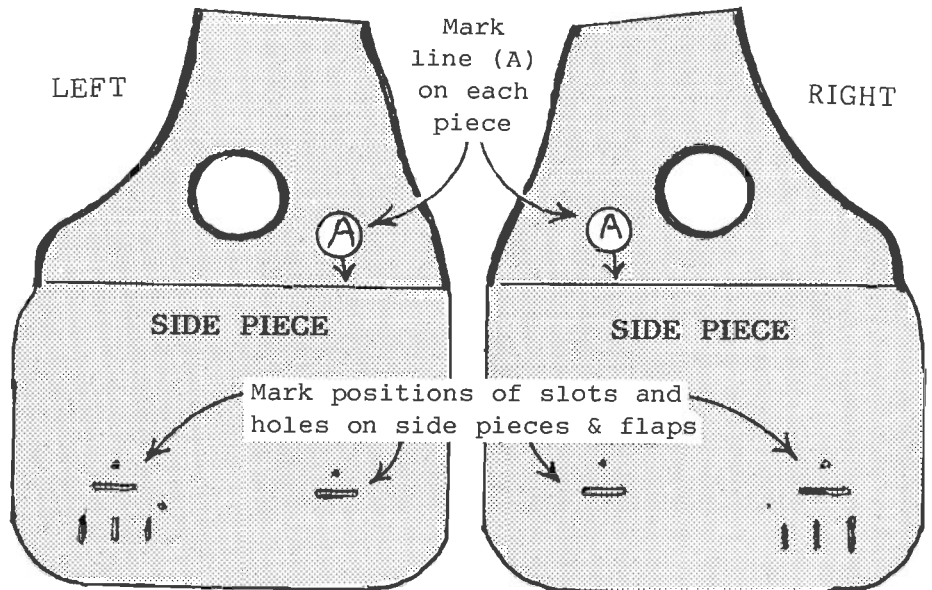
Form the other gusset following all of the previous instructions.

NOTE:
For dyeing
and oiling
gussets see
page 27

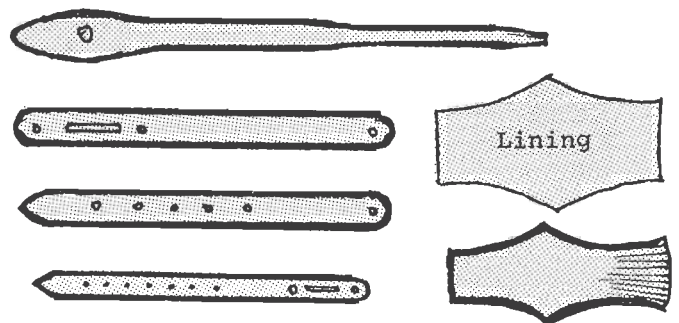
CUTTING OUT and PREPARING all of the SADDLE BAG PARTS



The main bag parts, at right, were cut out on page 11. Edge and burnish all edges shown by heavy lines on drawings. Edges where gussets fit are not edged or burnished until after gussets are sewn.



Note: As long as the billet mark is 1" (or more) to the LEFT of the post position, then the post does not have to change. Install it in the position shown on pattern.



Cut out the remaining parts from the full size pattern sheet. It shows the number of parts required, where you should skive, punch holes, slots, etc., and suggested leathers to use.

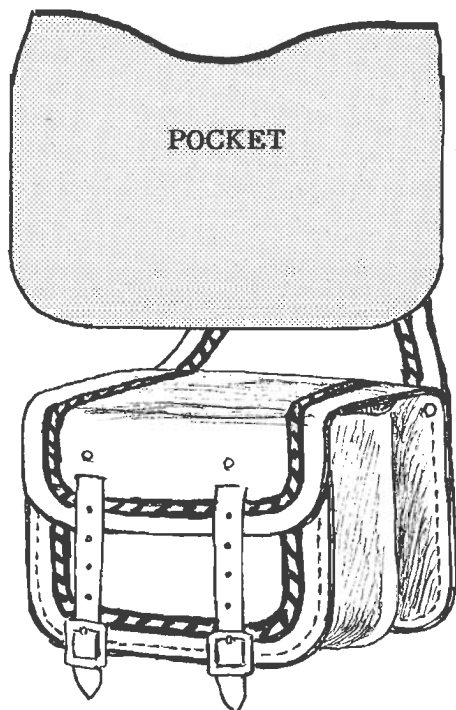
Lift-a-Dot post position on full size pattern sheet.

DECORATING the SADDLE BAG PARTS

If you are going to decorate or dye the bag parts, do so now before assembly. The illustrations here show a buckstitched border design as was used on the Saddle Bags for our Saddle No.2.

See note (above right) concerning the design when using the Connecting Piece.

Punch the slots and holes in their proper locations. Be sure the Lift-a-Dot post is in its proper location. Review page 24 if necessary. Mark the position but do not punch any holes for the post.

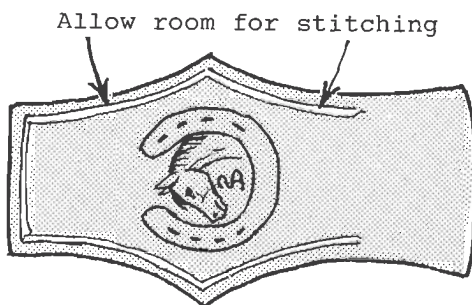


POCKET

FLAP

FLAP

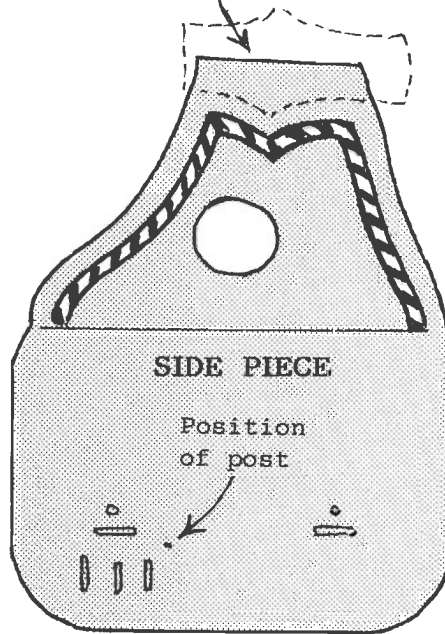
Normally, the pockets are not decorated as the flaps cover them when the bags are empty. However, when the bags are full, about 1/2 of the lower part of the pockets will be exposed. Therefore, if desired, you can decorate these areas as shown in the sketch at left.



CONNECTING PIECE

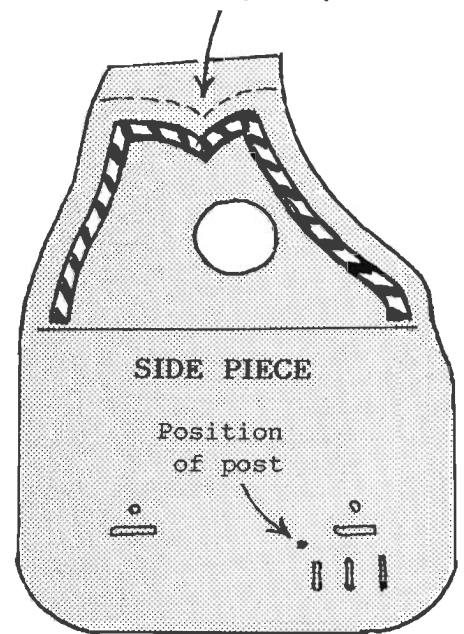
Before assembly, carve or stamp your name, initials or logo on the Connecting Piece, if desired.

Note: If you are going to use the Connecting Piece, allow for it with your design layout.



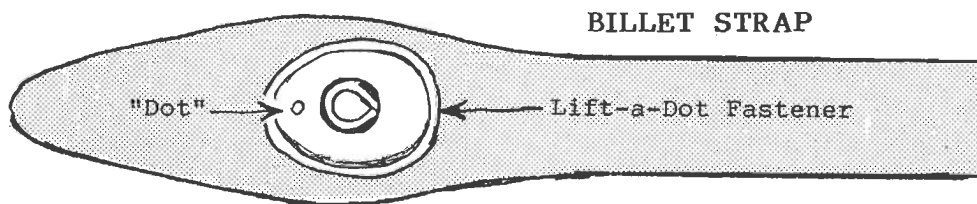
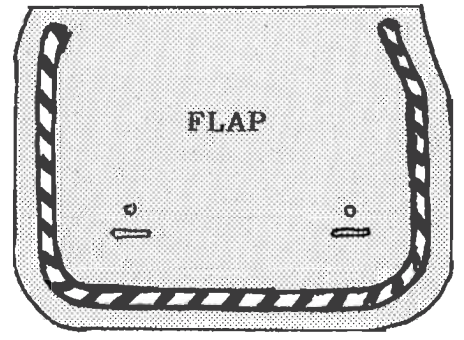
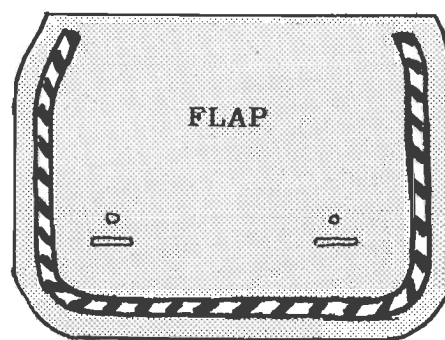
SIDE PIECE

Position of post



SIDE PIECE

Position of post



BILLET STRAP

"Dot"

Lift-a-Dot Fastener

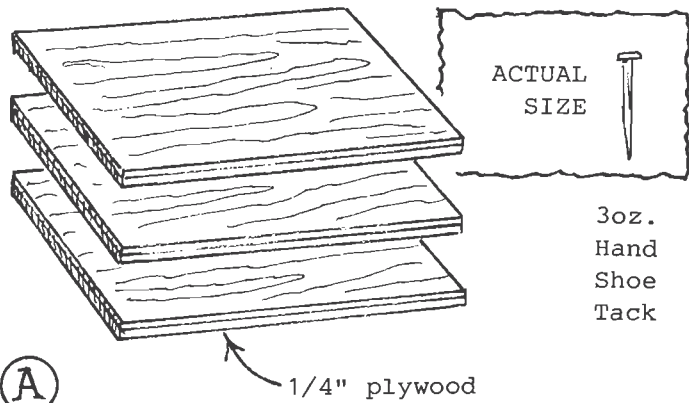
Before continuing...go over all of the other parts. All parts should be oiled (neatsfoot oil) before assembly. Be sure all edges are burnished and all of the holes and slots have been punched. Also, be sure to have the "dot" of the fastener in position shown above. Rivet (or sew) buckles to the straps.

See our book: *Leathercraft Tools* for instructions on installing all types of fasteners.

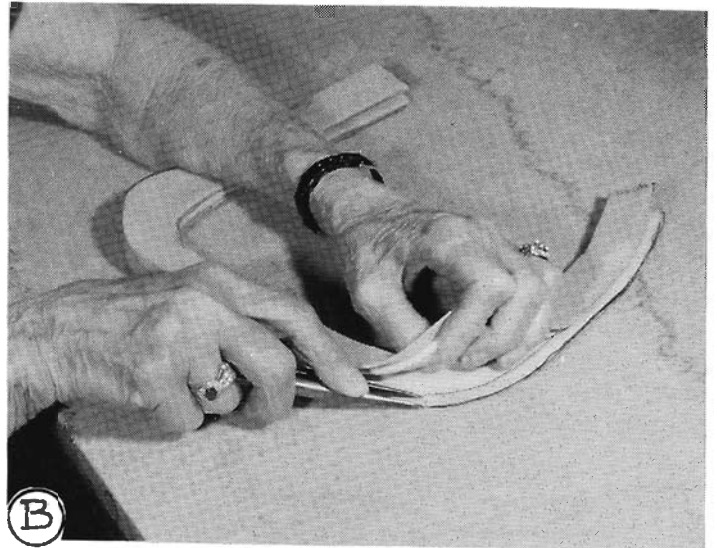
HOW to DYE and OIL the GUSSETS

After the gussets have been formed and are dry, they would be difficult to dye or oil without assistance, as they resist

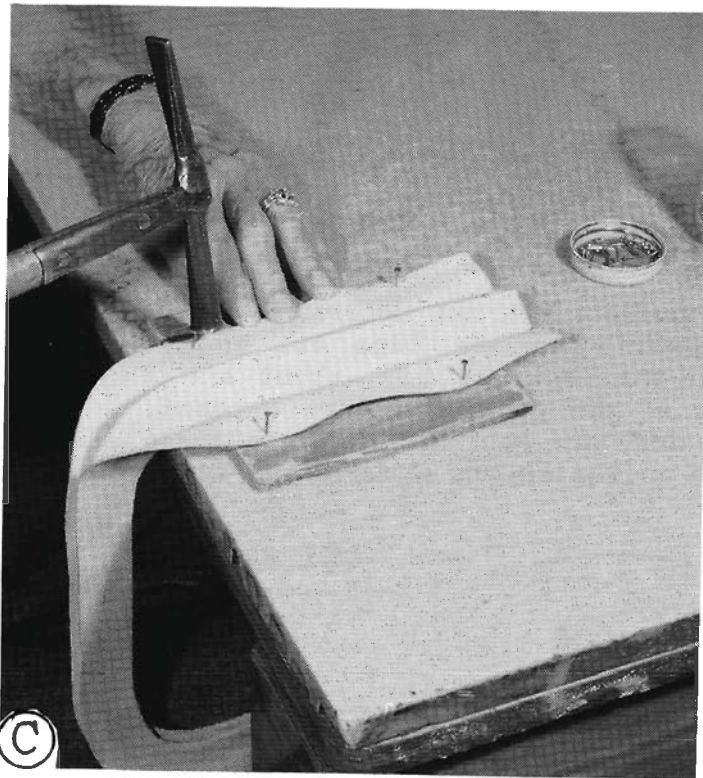
being spread apart. However, the following instructions show how you can do this by yourself without any help.



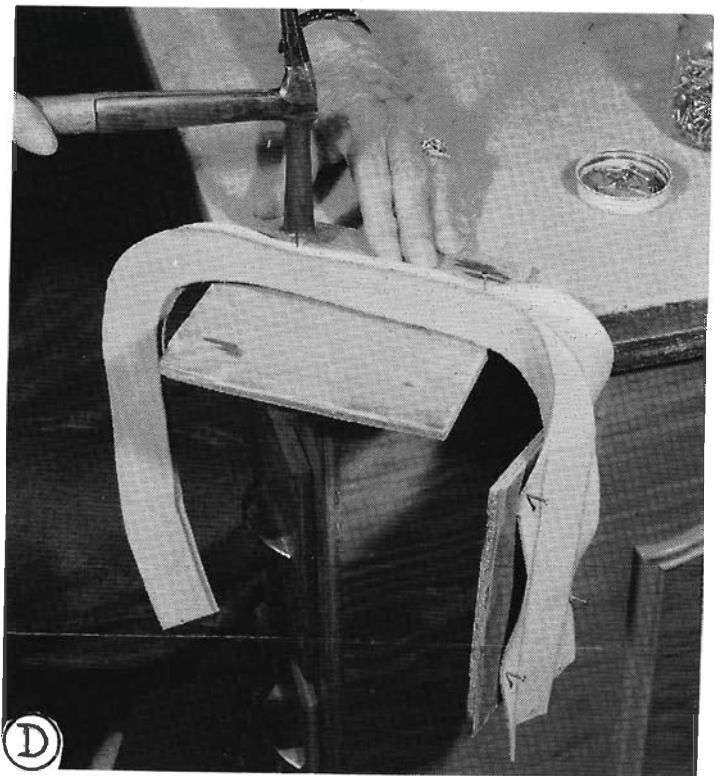
Cut three pieces of plywood about 5-1/2" x 5-1/2". Have some 3oz. Hand Shoe Tacks handy for use.



After the gussets are dry, scribe a light line 3/16" from the edges...all around both sides. Be sure edges are laying flat.

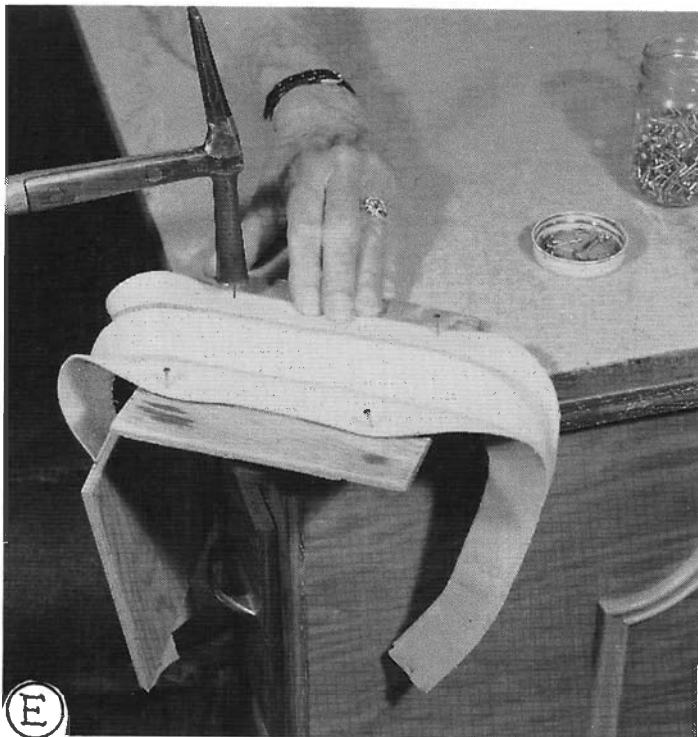


Sit at your bench (or table). Put a piece of plywood near the edge. Tack one side on the scribed line, then spread the gusset out and tack the other side. More tacks could be used if desired. Tack on the line. The lower end of the gusset must go under the bench as shown.

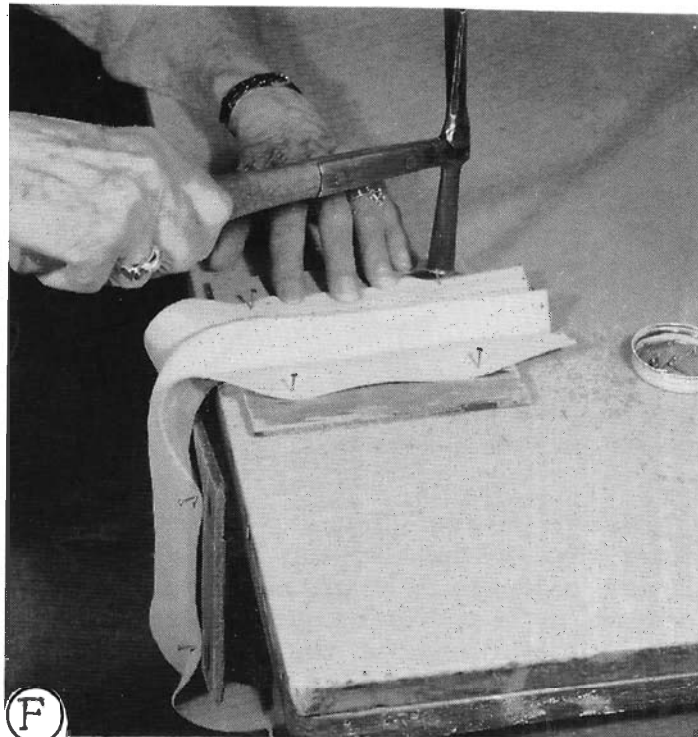


Now place a board over the corner of your bench. Put the gusset in place allowing the ends to hang down. Tack one edge of the gusset as shown in the photo above.

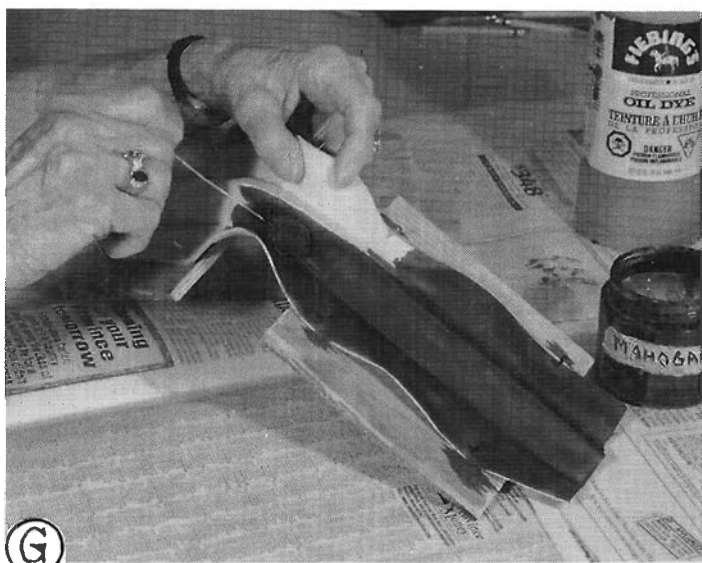
(continued)



Turn the board around so you can tack the other side of the gusset. Spread the gusset out and tack the other edge. Be sure to put the tacks on the light guide line.



Now follow step (C) to tack the 2nd end to the 3rd board. Notice that the lower end goes under, the bench. Now the gusset can be dyed and oiled.

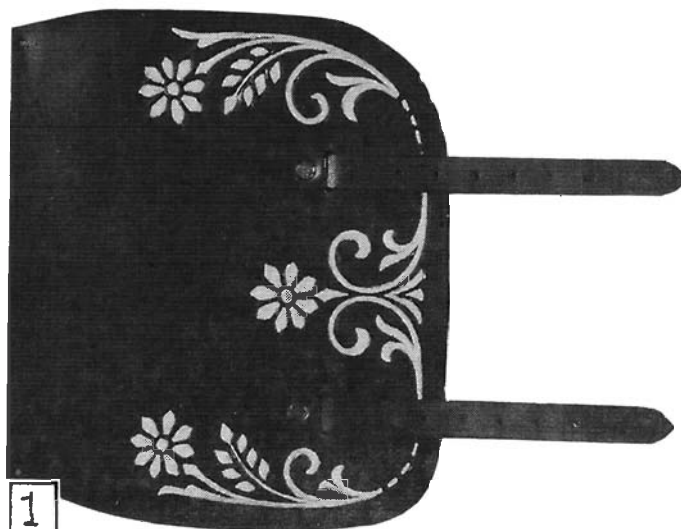


Before dyeing or oiling, be sure to put a lot of newspapers over your bench. Here, we are dyeing the gusset a mahogany color so the saddle bags will match our saddle No.3. At the curved areas use your fingers to spread the leathers apart to make dyeing easier. Use a dauber or a soft, flat brush. Apply two coats of dye. After the dye has dried, apply a light coating of oil. Allow to set a few hours before removing the gusset from the boards.

TIP: To speed up the work, cut 6 boards as in step (A) so both gussets can be set up to dye or oil at the same time.

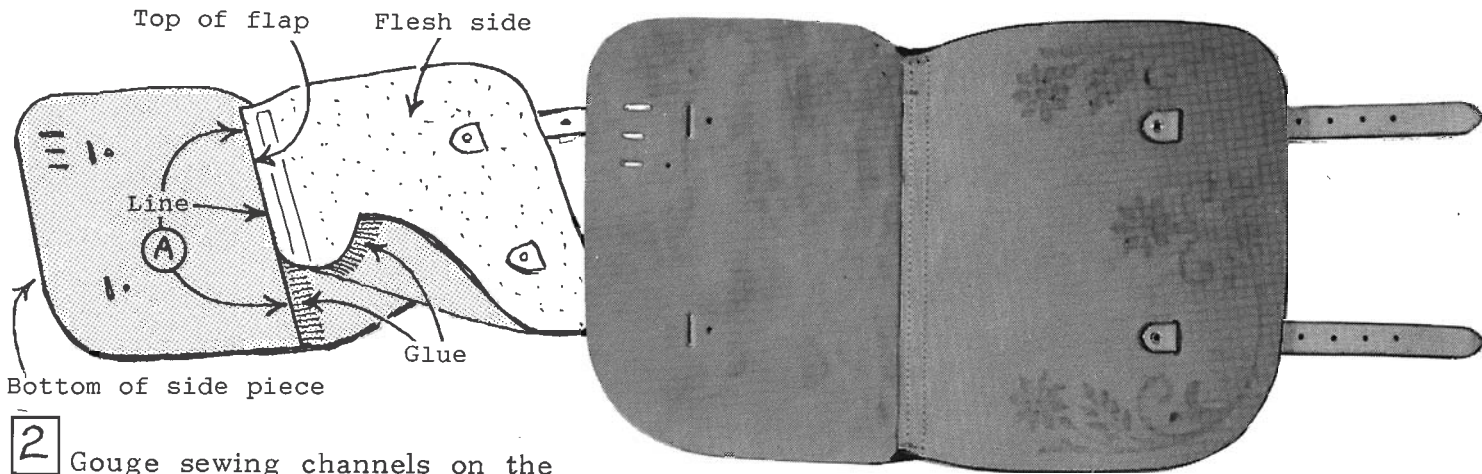
ASSEMBLING the SADDLE BAGS

We have chosen the No.3 saddle bags to assemble here, as they match our saddle No.3 and include some decorative work and dyeing. Assembly procedures are the same for all bags. We want to remind you to be aware of the **LEFT** and **RIGHT** parts of the bags so you will be sure to get all pieces in their proper locations and positions.



Push the straps through the slots in the flap; rivet in place. (continued)

ASSEMBLING the SADDLE BAGS...continued

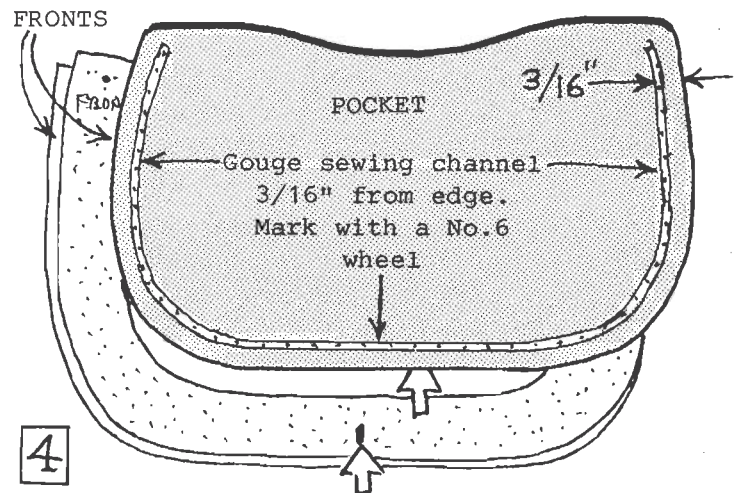


- 2** Gouge sewing channels on the flesh side of the flap top (see pattern). If the bag will be "ruff-out", then gouge channels on the grain side. Apply contact cement to areas to be glued (see sketch). Adhere the flap to the side piece as shown. Put the top edge of the flap right on line (A) of the side piece. Moisten the sewing channels and mark them with a No.6 overstitch wheel.

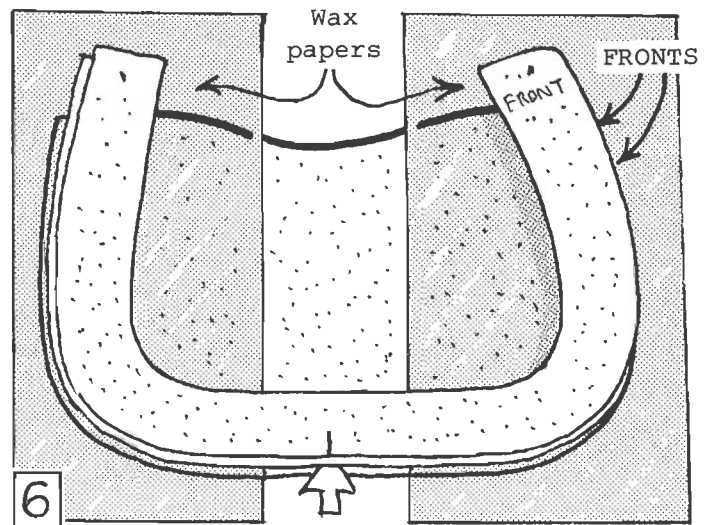


- 3** Clamp in stitching horse; sew together.

- 5** RIGHT: Apply contact cement to the edges of the pocket & gusset where they will adhere. Allow to dry. Remember...be sure the **front** of the gusset is at the **front** of the pocket! Lay the pocket down with flesh side up. The cemented edge will be up where it can contact the cemented edge of the gusset. Put wax papers over the pocket to prevent premature adhesion. Now...carefully place the gusset in position over the pocket and wax papers as shown in the sketch at right.



- 4** Gouge sewing channel on pocket as shown. Mark center of pocket & center of gusset, at bottom, indicated by large arrows.

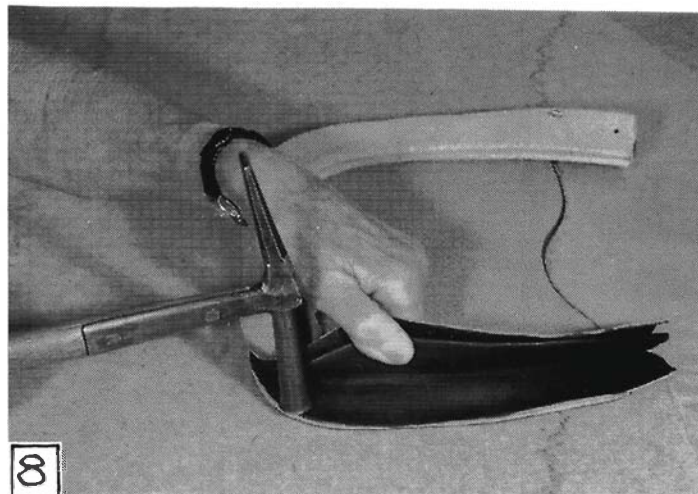


- 6** Align edges and begin adhering the gusset to the pocket on the center marks.



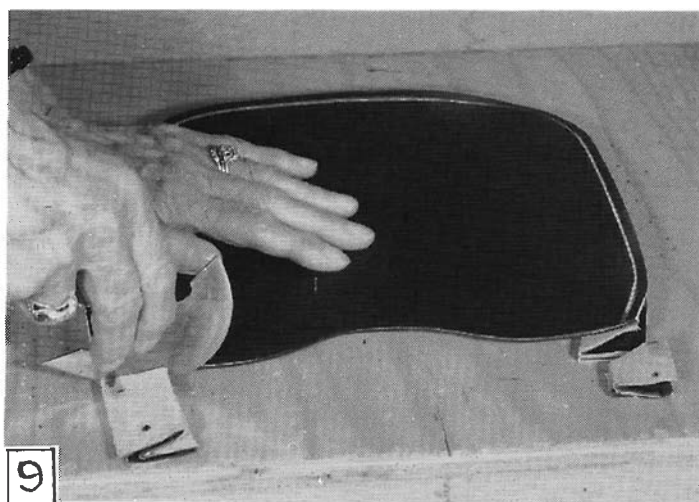
7

Begin adhering the gusset, working to the corner. Keep moving wax paper back, a bit at a time. Keep edges aligned.



8

The corners require special attention to make them fit. When edges are aligned, tap with hammer to insure adhesion.



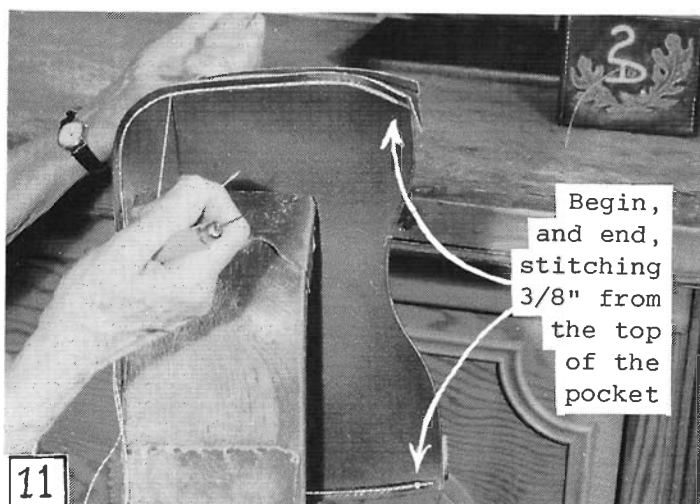
9

Turn the unit over. Hold down tight to the bench and trim the ends of the gusset off flush with the top of the pocket. Check all around the cemented edges to be sure the cement is holding good.



10

Trim off any excess gusset that is protruding beyond the edge of the pocket. Turn the unit over & gouge a sewing channel, lightly, around the gusset 3/16" from the edge, as shown in the photo above.



11

Begin,
and end,
stitching
3/8" from
the top
of the
pocket

Now put the unit in your stitching horse and sew the parts together. Be sure the stitches come out in the sewing groove of the gusset.

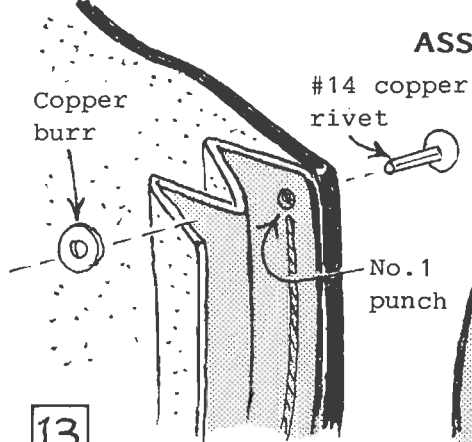


12

After sewing, use broken glass to smooth edges of gusset and pocket. Edge and burnish all around the sewn edge.

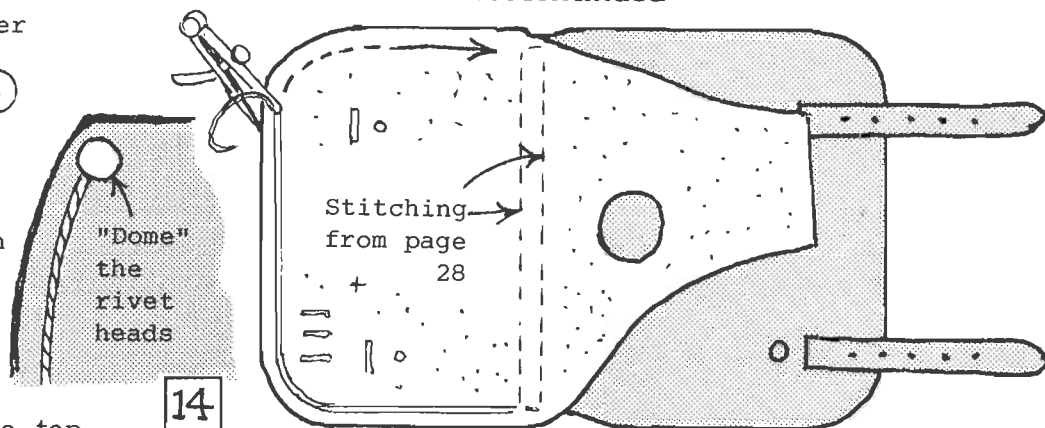
(continued)

ASSEMBLING the SADDLE BAGS...continued



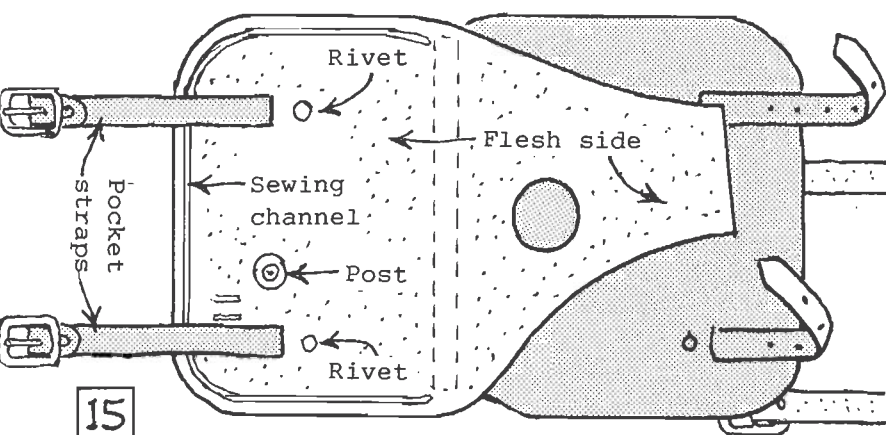
13

Now punch a hole near the top of the threads, through pocket and gusset, on each side. "Set" a rivet in each hole. This prevents the stitching from ever being torn loose.



14

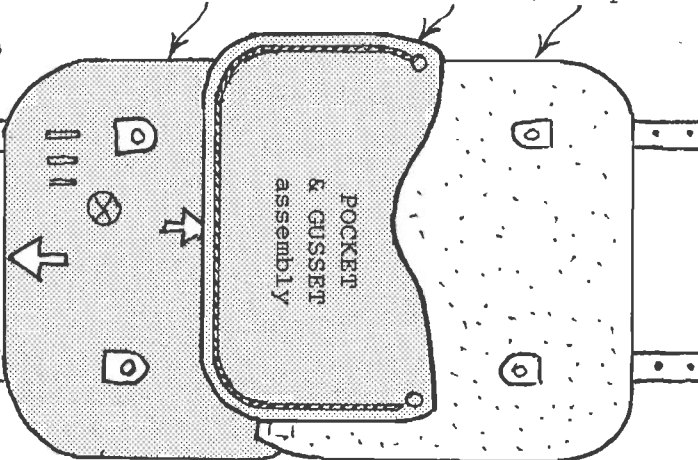
Now gouge a sewing channel, 3/16" from the edge, all around the bottom of the side piece. Make the gouge on the flesh side. Begin and end the gouge at the stitching in the flap. Do not "wheel" for the stitching in this channel.



15

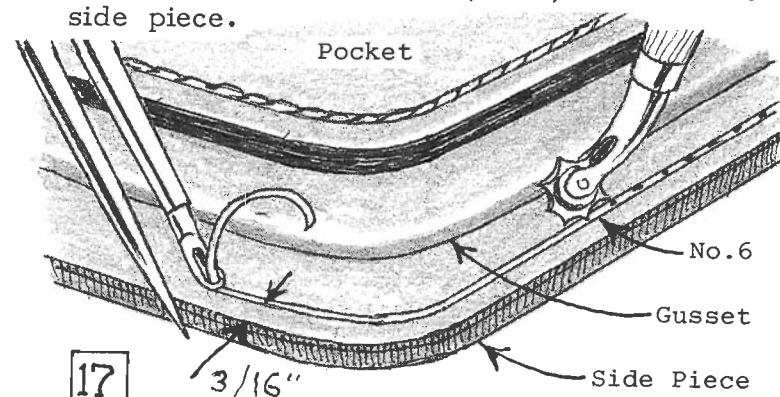
Before the pocket assembly is cemented to the side piece, rivet the pocket straps in place. Use #12 copper rivets. Install the Lift-a-Dot post (above). Note: The "post" should be on the flesh (back) side of the side piece.

FRONT...of Inside Piece; Pocket; Flap



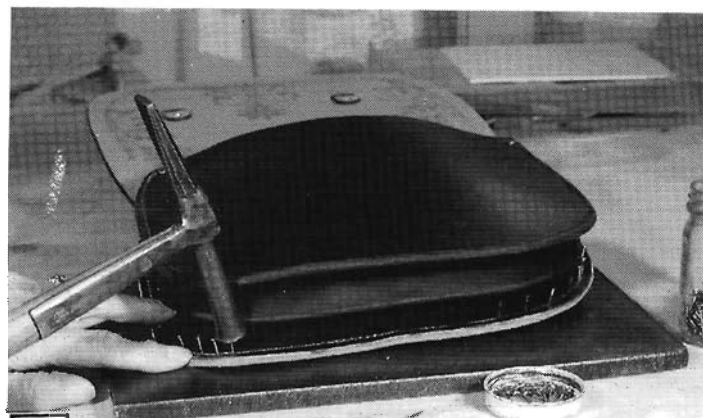
16

Flop the unit over. Mark the center of bottom and center of gusset (sewn to the pocket) indicated by arrows above. Begin adhering at the center marks.



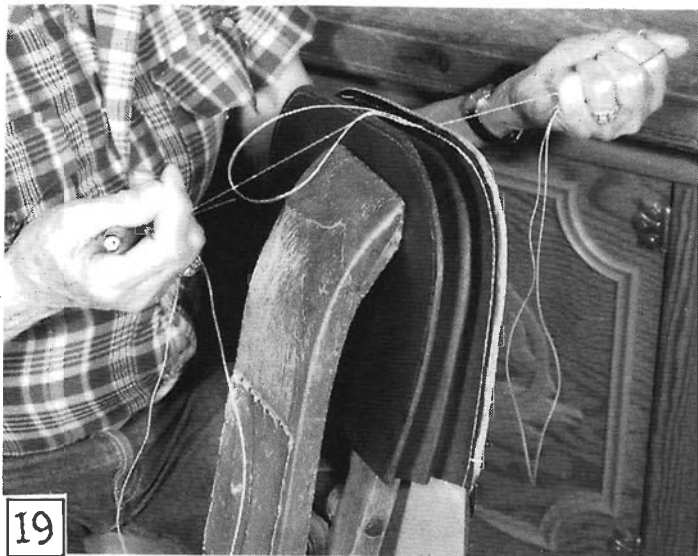
17

Adhere the gusset/pocket assembly to the side piece following instructions given on pages 28 & 29. To keep all edges flat, fold the straps out of the way or lay the units on the edge of your bench. When adhered, trim off any excess gusset leather around the side piece. Gouge a light sewing channel around the gusset and "wheel" with a No. 6 over stitch wheel.



18

If you are apprehensive about the glue holding leathers together at the corners, tack these areas with 3oz. hand shoe tacks (above). Put them in the wheel marks made in step 17.



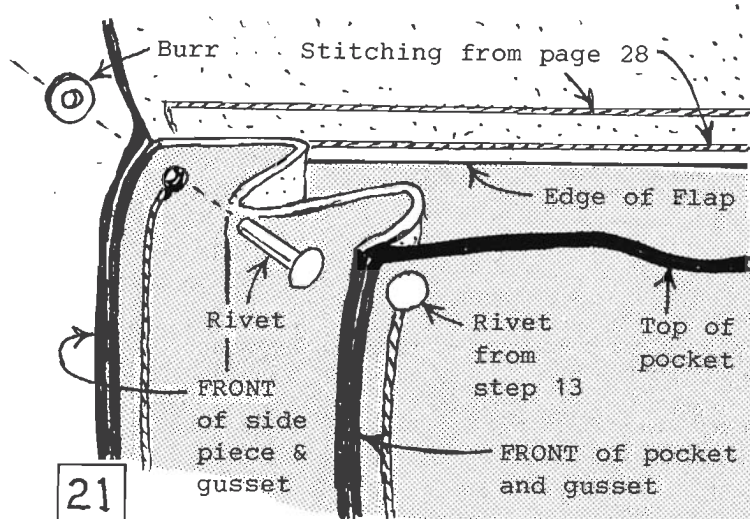
19

Put the unit in your stitching horse and sew together. Begin and end stitching 3/8" from the top of the gusset.



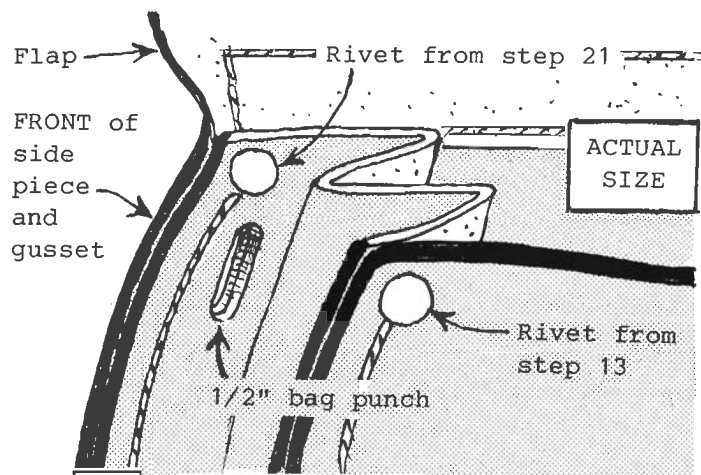
20

After sewing, smooth the edges and edge and burnish as instructed in step 12, page 29. Fold the straps out of the way.



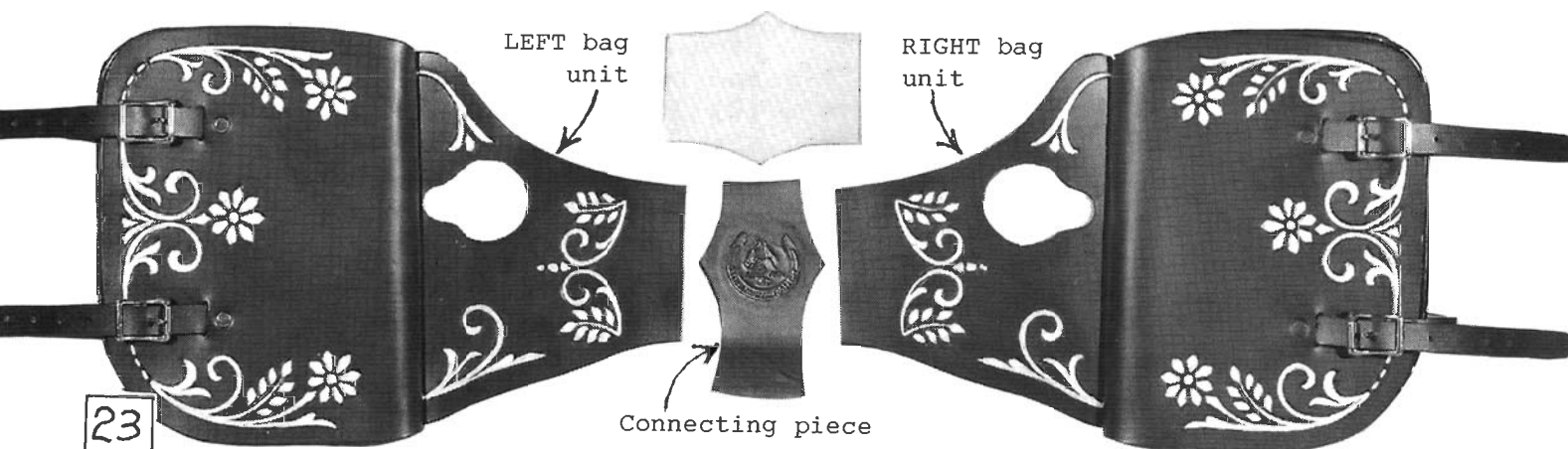
21

Now put a #14 copper rivet through the top of each gusset end and the side piece, as shown above. Note, here, the rivet enters from the gusset side.



22

Now punch a 1/2" slot through the gusset and side piece in the location shown. This is for the Dee Tie-Strap. This slot is punched only in the front of the LEFT side piece and in the front of the RIGHT side piece.



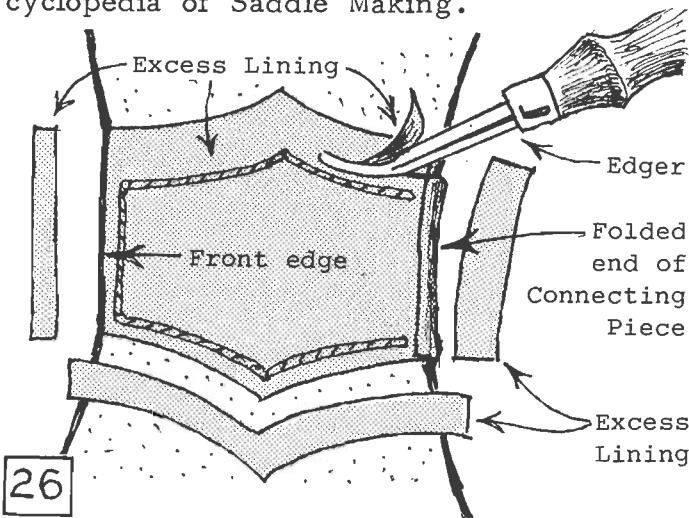
23

After completing the LEFT bag unit (from step 22) make the RIGHT bag unit...by following all previous instructions. With a sponge, apply some moisture (to the flesh side) to the top of the flaps. Fold them over and buckle in place. The photos above show both bag units, connecting piece & lining, ready for assembly. (cont.)

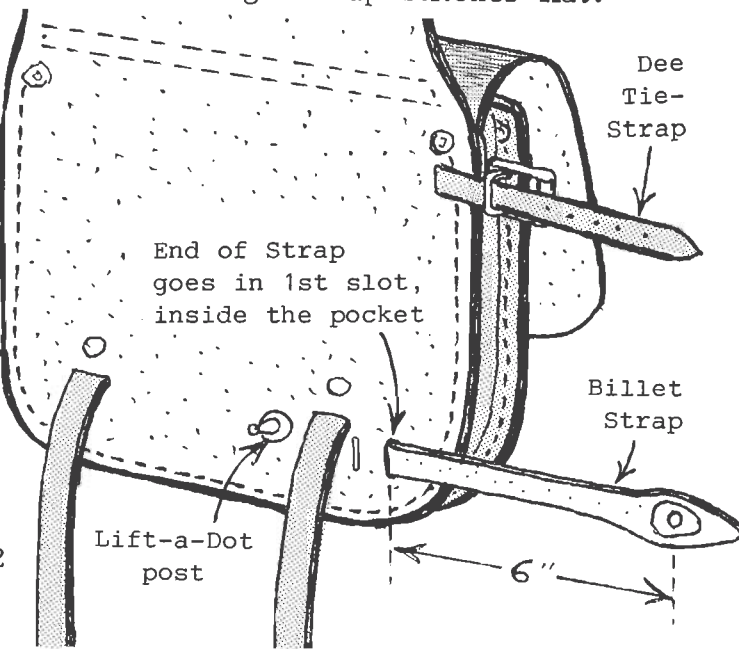
Sew the Two Bag Units together



24 Now sew the Two Bag Units together. Follow the instructions in step 8, page 506, In Volume THREE of our Encyclopedia of Saddle Making.



26 Sew through all pieces. You'll notice the Connecting Piece is squared off at front, unlike the jockeys on page 510 of Vol. III. The folded end is not sewn across. Turn over and trim off Excess Lining leather with a No.3 edger. Tap stitches flat.

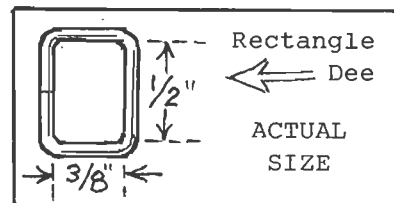


See the Semi-Exploded View on page 12



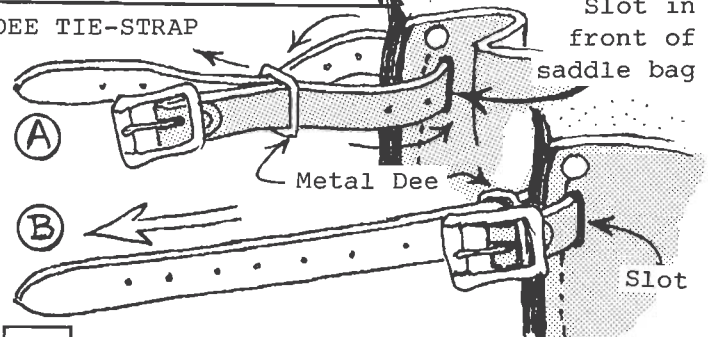
25 Connecting Piece & Lining

Glue the Connecting Piece in place. Gouge a sewing channel around it and mark with a No.6 wheel (above). See page 510 of our Volume III. Glue the Lining underneath. It extends beyond the sewing lines.



These metal Dees are used to hold Dee Tie-Straps in the slots in the saddle bag

DEE TIE-STRAP



27 (A) Slide the metal Dee on the Tie-Strap. Push the strap through the slot and back through the metal Dee. (B) Pull strap tight, so buckle is tight against the slot. The metal Dee will hold it in this position and prevent the strap from accidentally coming loose.

28 The Billet Straps are the final installation. They snap around the saddle's flank cinch billets to keep the bags from flopping. Insert the end of the strap in the 1st slot (left). From inside of the pocket, pull the strap through the slot to about the dimensions shown at left in the sketch.

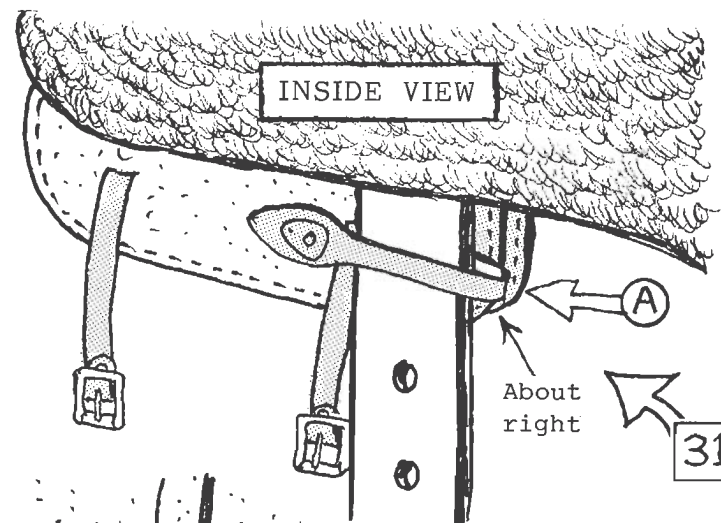
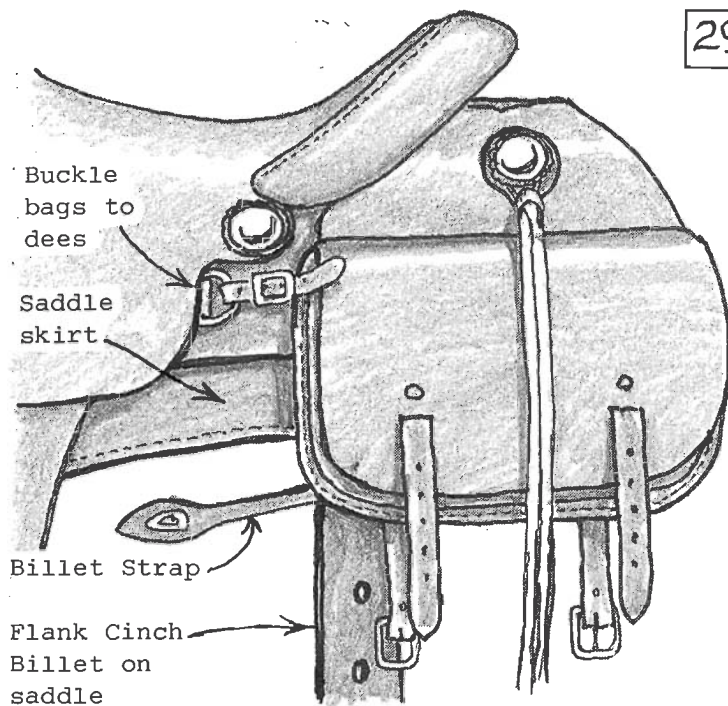
Adjusting instructions begin on the next page.

ADJUSTING the BILLET STRAPS

29

To properly adjust the Billet Straps, the saddle bags should be fitted on the saddle for which they were made. If your customer has already picked up his saddle, and you have no access to it, make copies of these instructions and send them along with the saddle bags to your customer so he will know how to make the adjustments on the Billet Straps.

If you are in possession of the saddle, fit the bags in place and buckle them up snug to the dees on the saddle, as shown in the sketch at left. Buckle both sides.



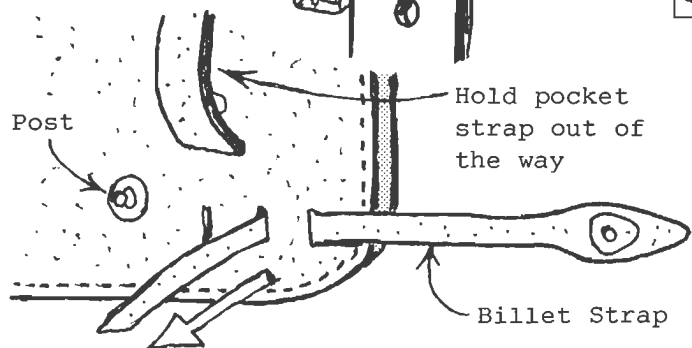
30

INSIDE VIEW:

Fold Billet Strap around the cinch billet of the saddle; snap in place. Here you'll notice the strap is a bit loose. Follow the next step.

31

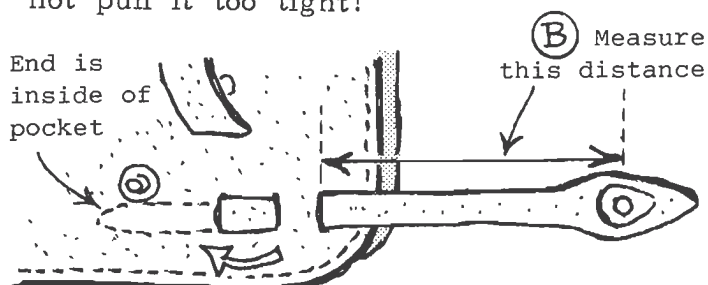
Reach inside of the bag and grab the end of the Billet Strap. Pull on it to take out some slack (see (A) in sketch; left). Do not pull it too tight!



32

Now unsnap the Billet Strap and take the bags off of the saddle. From inside the pocket...push the end of the Billet Strap through the 2nd slot (above). Pull out all slack between the 1st and the 2nd slots.

Special Note: If for some reason, later on, the Billet Straps need re-adjustment, repeat steps 28 through 33.



33

Now push the end of the strap into the 3rd slot. From inside the pocket...pull all slack out as shown. This locks the Billet Strap in place. Measure distance (B). Put the strap (on the opposite bag) through the 1st slot to this measurement. Repeat steps 32 & 33 to lock it in place.

The BAGS are complete.

The COMPLETED SADDLE BAGS

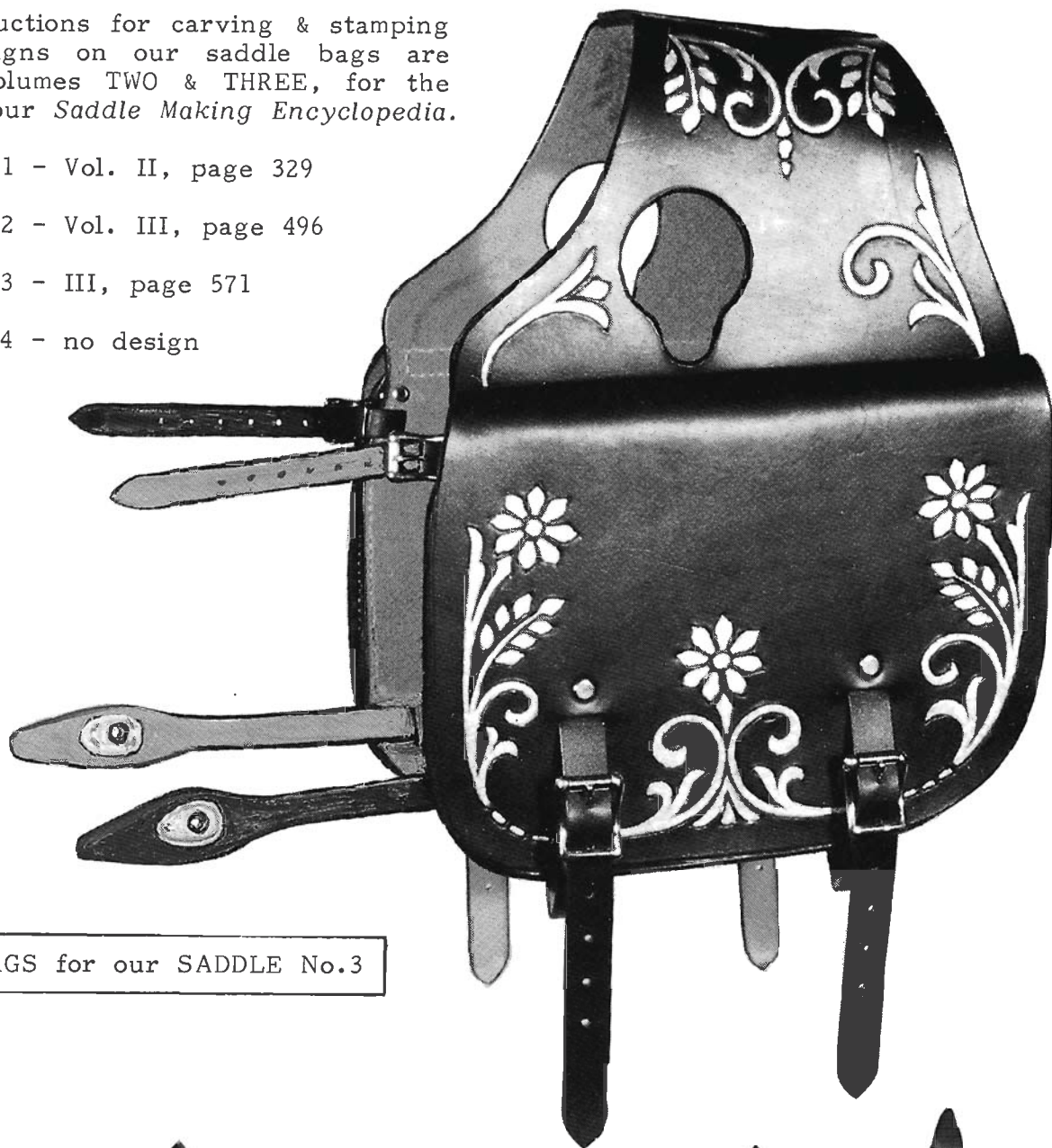
Note: Instructions for carving & stamping border designs on our saddle bags are given in Volumes TWO & THREE, for the saddles in our *Saddle Making Encyclopedia*.

SADDLE No.1 - Vol. II, page 329

SADDLE No.2 - Vol. III, page 496

SADDLE No.3 - III, page 571

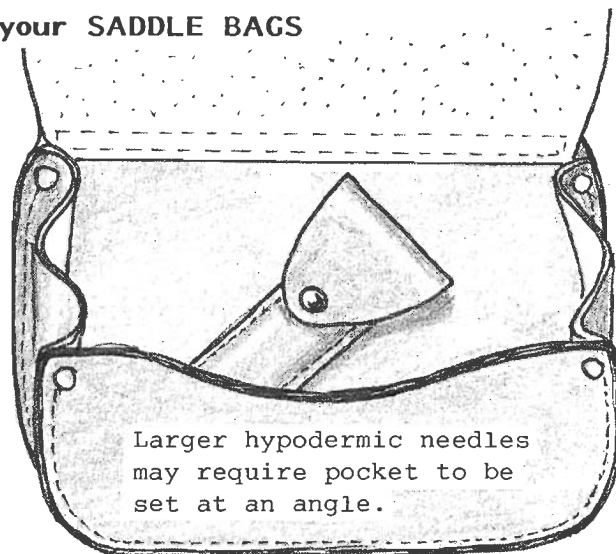
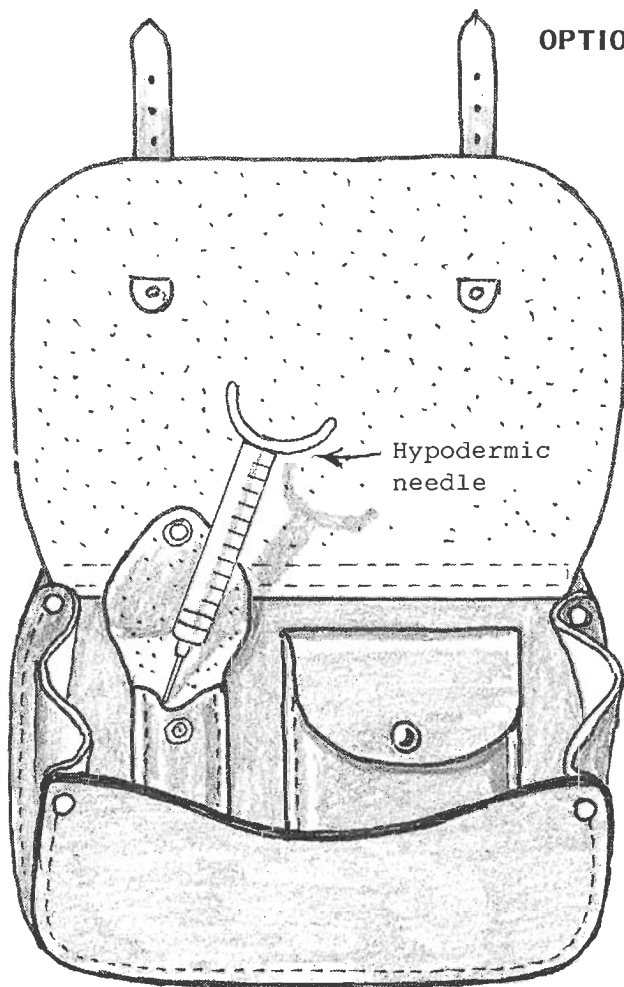
SADDLE No.4 - no design



SADDLE BAGS for our SADDLE No.3

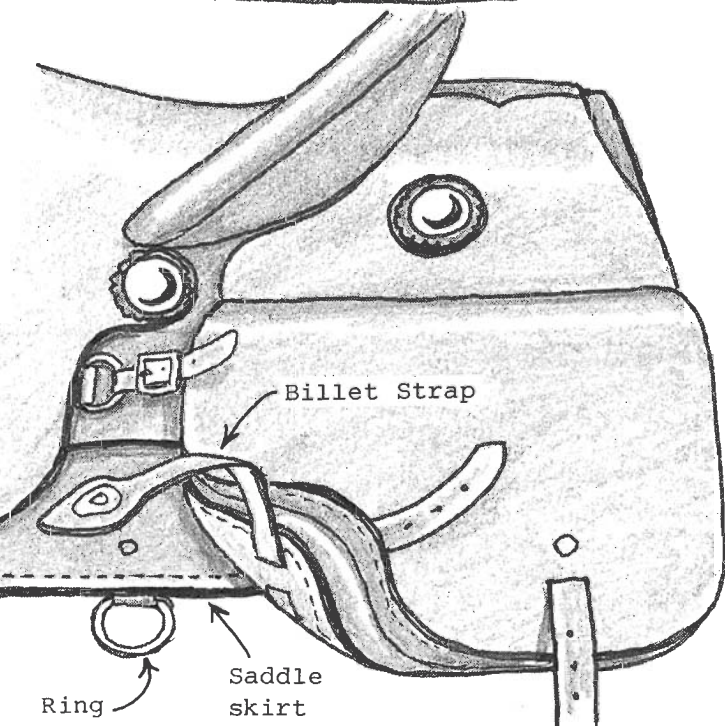


OPTIONS for your SADDLE BAGS

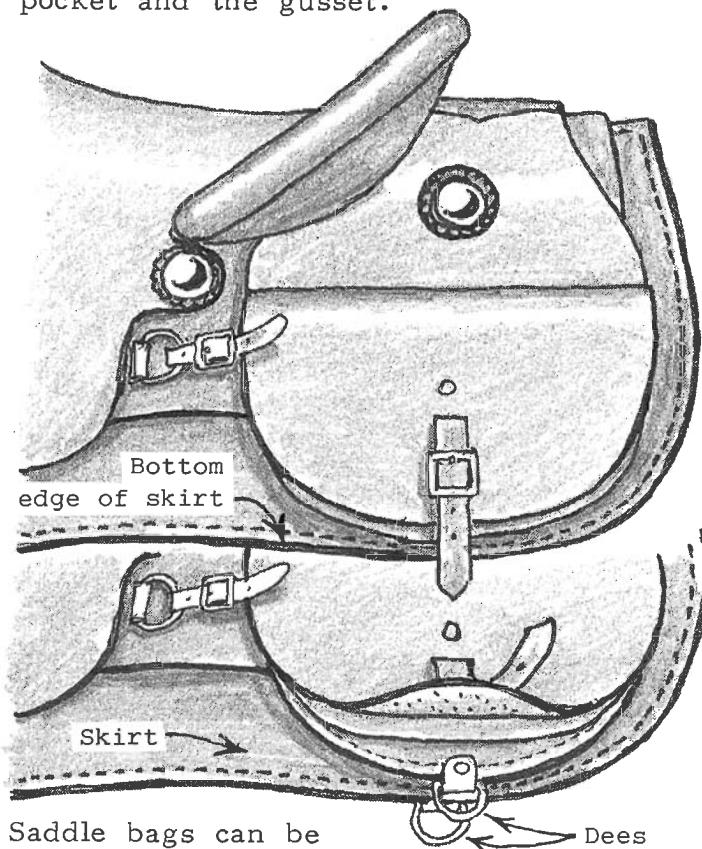


Additional Pockets can be put inside your saddle bags to hold a multitude of objects. The sketches show pockets for a hypodermic needle and vials of medicines, fence staples, etc. Hypodermic needles are used by ranchers and cowboys to doctor cattle when riding on the open range. The saddle bags are a handy place to carry these items.

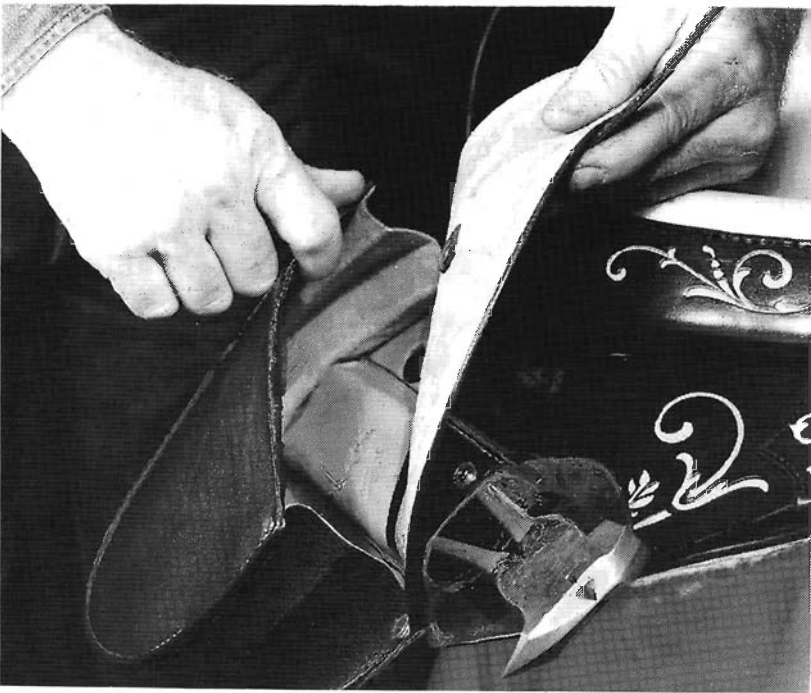
These pockets will have to be sewn to the side piece before installing the outside pocket and the gusset.



On saddles with no flank cinch, or flank cinch billet, there is nothing to wrap the Billet Strap around. This can be offset by installing a ring in the skirt (between leather & woolskin). See sketch above. The Billet Strap can then go through the ring and snap in place to keep the saddle bags from flopping. Adjust straps as required.

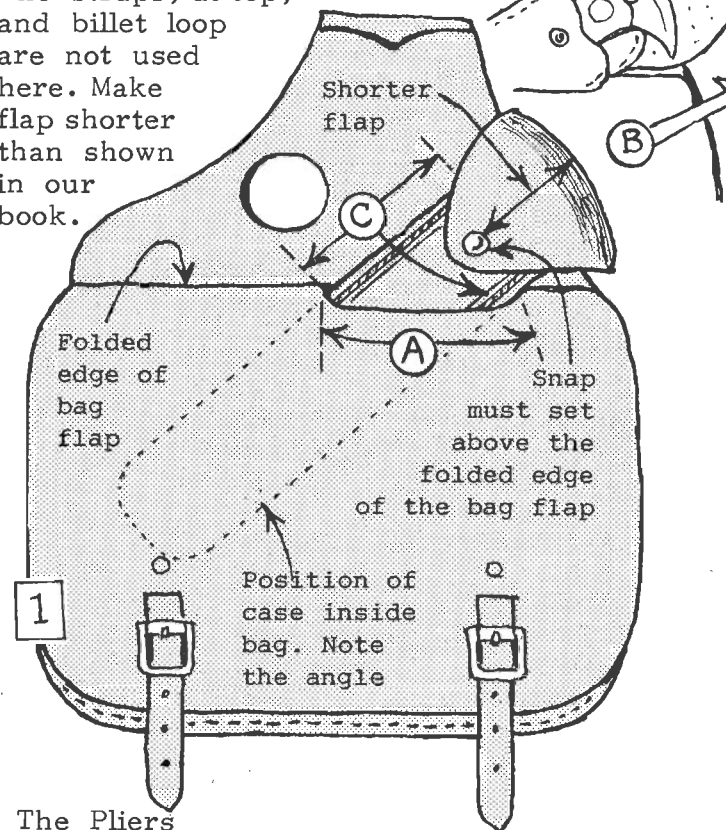


Saddle bags can be made in any size or style desired. If they do not hang below the bottom of the skirt, install 1/2" dees in the bags and skirt (above). Tie the dees together with a thong to keep the saddle bags from flopping.



Fence Pliers Case added to the saddle bag. Form the case as instructed in our book: *Making Leather Cases*. Attach the flap and glue the pocket to a back piece of 6/7oz. leather. Trim to size. Gouge a sewing channel around the pocket. Wheel for sewing, but do not sew yet. See **SKETCH [1]**.

To make the Fence Pliers Case, follow instructions on page 119 in Vol. ONE of our book: *Making Leather Cases*. The straps, at top, and billet loop are not used here. Make flap shorter than shown in our book.



The Pliers

Case is shown fitted in the bag. A hole must be cut in the flap of the bag (A) to accommodate the Pliers Case. First cut the hole in scrap leathers until you have it correct. Pliers are removed (B) without opening the bag. Edge of case is sewn at (C) after removing from bag. It is not sewn to the side piece of the bag here.

SKETCH [2]: Cut the hole in the flap and sew the flap to the bag's side piece.

SKETCH [3]: Put the Pliers Case in the flap hole. Hold it in correct position. Mark around it, then glue in place. Sew to the side piece...all around edge (D).

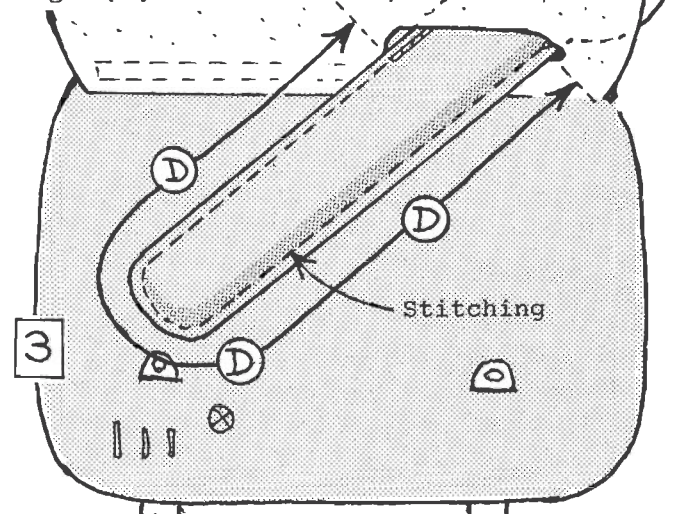
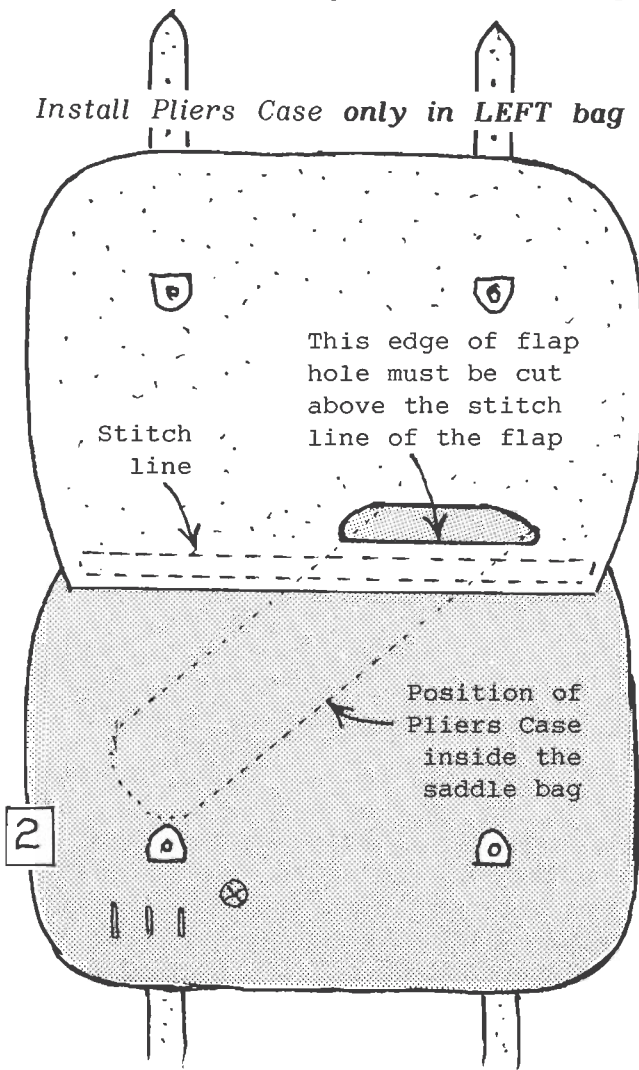
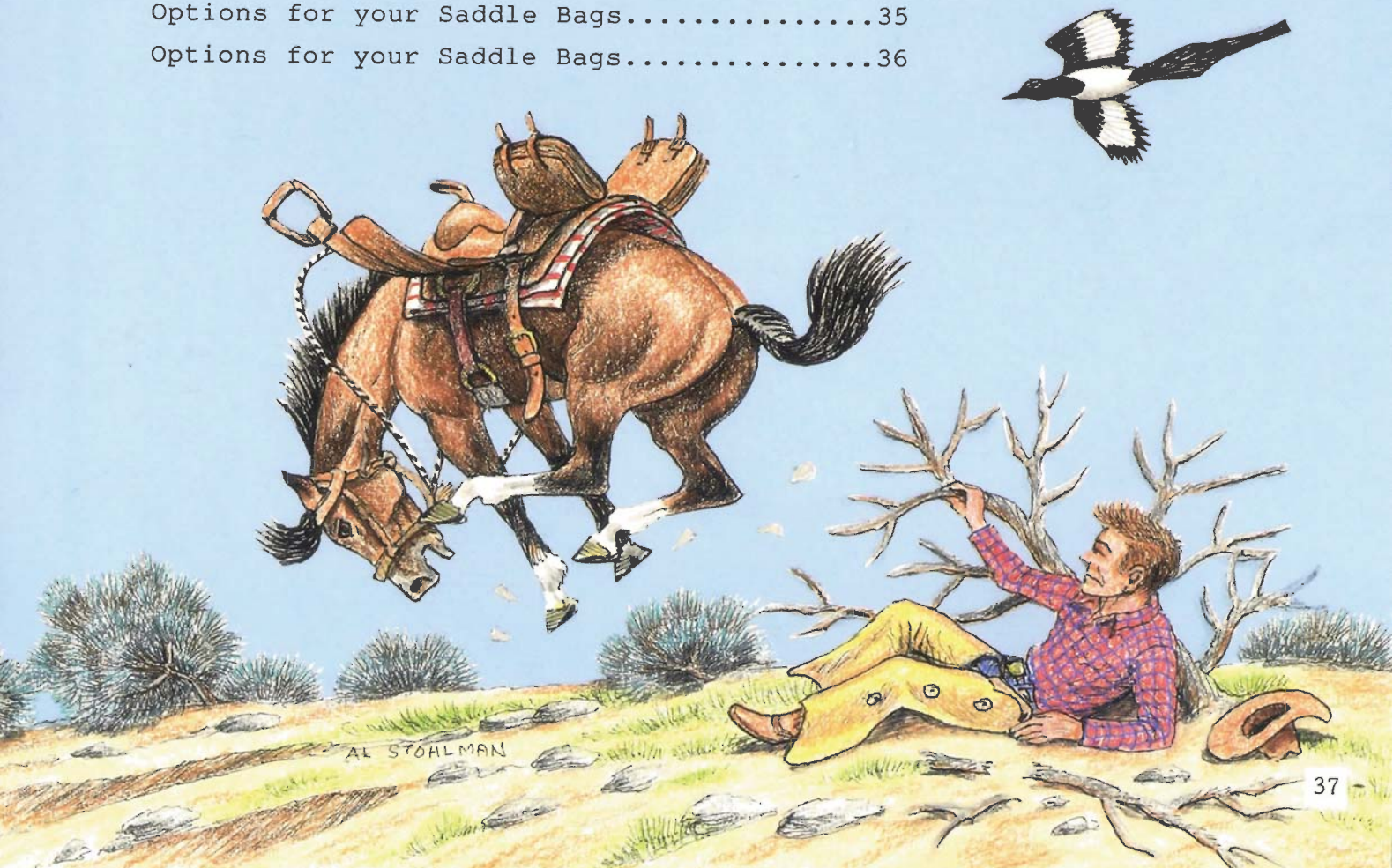


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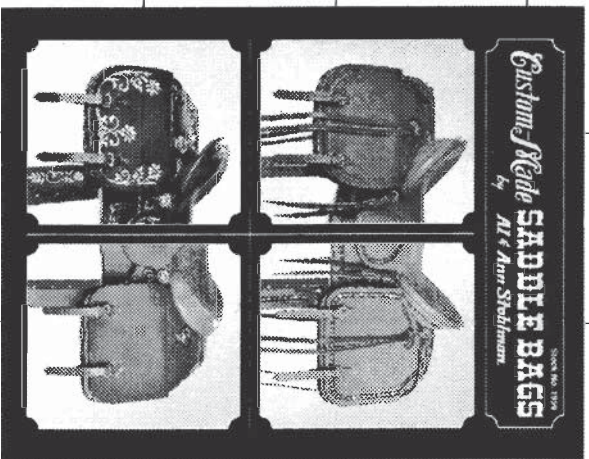
COMPLETED SADDLE BAGS

No.1

No.2

No.3

No.4



Skive 1/2 thickness off of this edge. Always skive on flesh side.

After skiving, gouge sewing channels in locations shown.

LEFT FLAP

Make ONE LEFT: ONE RIGHT

Cut from firm 7/8oz. cowhide

This book contains all of the instructions for making and assembling the saddle bags.

①

②

③

④

○

Rivet hole

3/4" slots for the Flap Straps

See SIDE PIECE PATTERN for explanation of circled numbers

○

Rivet hole

①

②

③

④

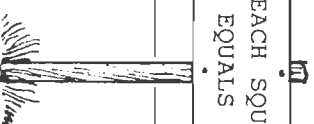
FULL SIZE PATTERNS

LEFT POCKET

Make ONE LEFT: ONE RIGHT

Cut from firm 7/8oz. cowhide

EACH SQUARE
EQUALS 1"



Custom Made SADDLE BAGS

by Al & Ann Stohman

①

②

③

④

See SIDE PIECE PATTERN for explanation of circled numbers

①

②

③

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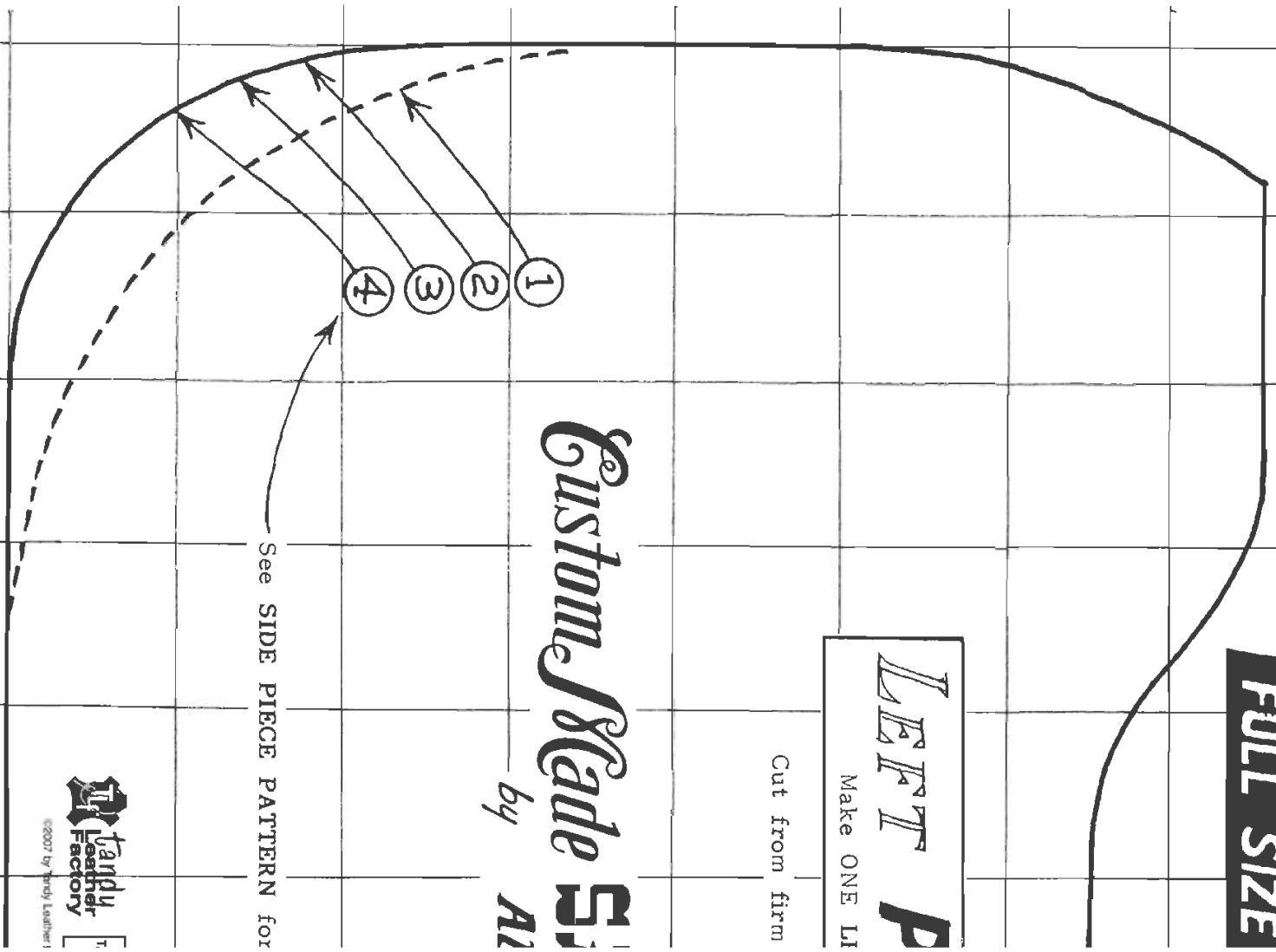
FULL SIZE

LEFT P
Make ONE LI

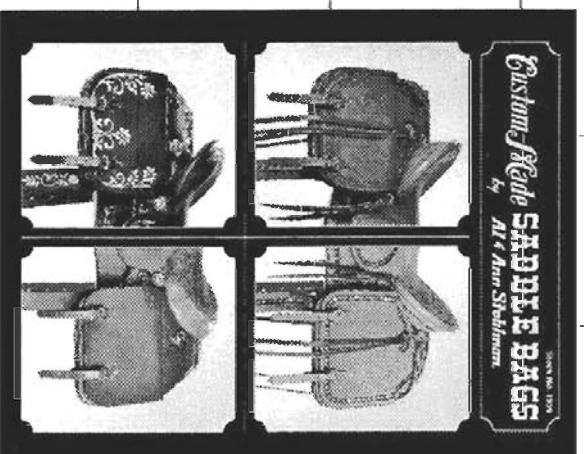
Cut from firm

Custom Made S
by *AL*

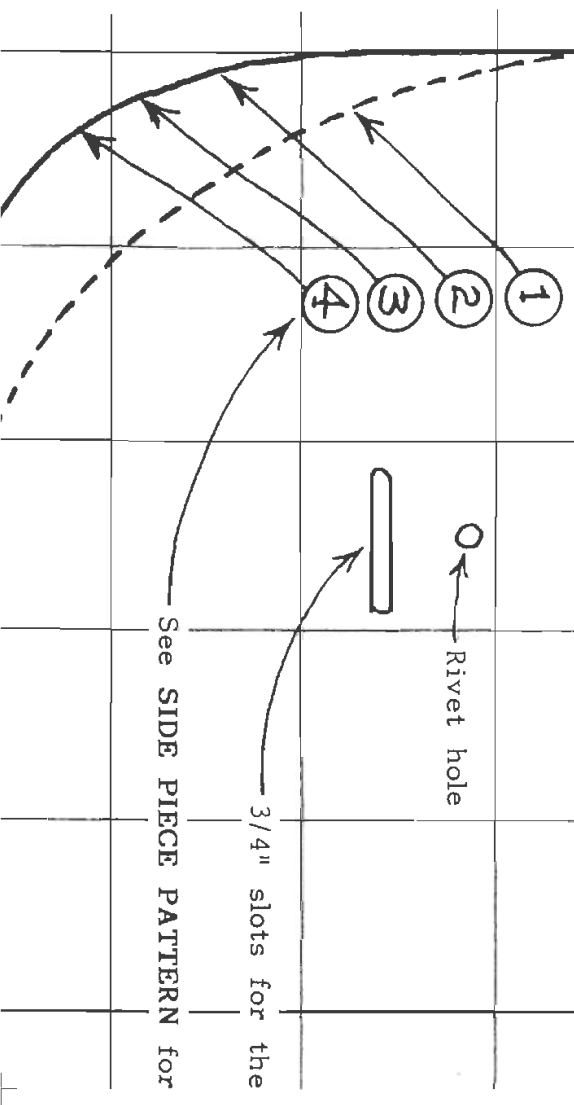
See SIDE PIECE PATTERN for



Skive 1/2 thickness
of this edge. Alw
skive on flesh si



This book contains all of the
instructions for making and
assembling the saddle bags.



PATTERNS

EACH SQUARE
EQUALS 1"

POCKET

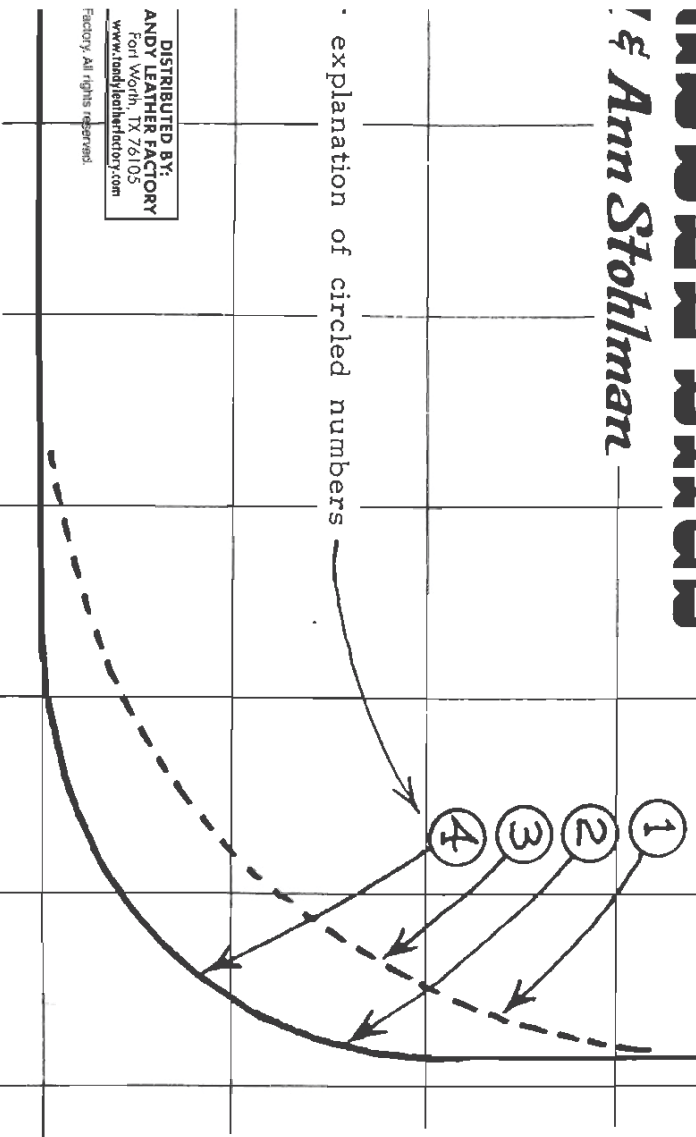
EFT: ONE RIGHT

7/8oz. cowhide

ADDLE BAGS

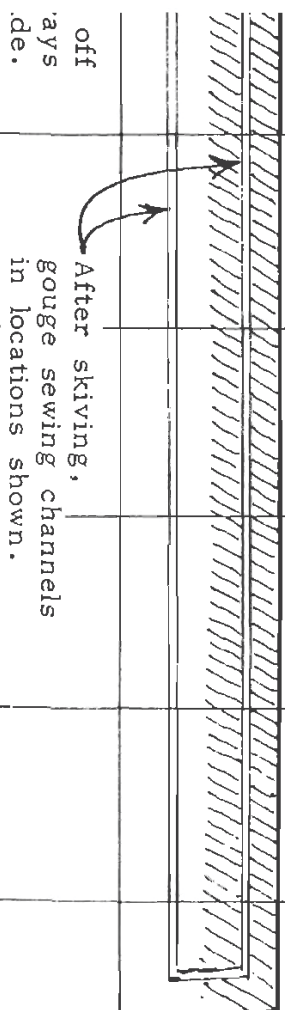
by Ann Stohlman

• explanation of circled numbers



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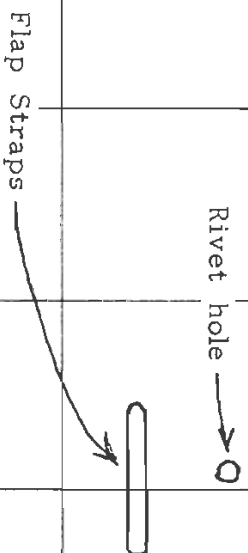


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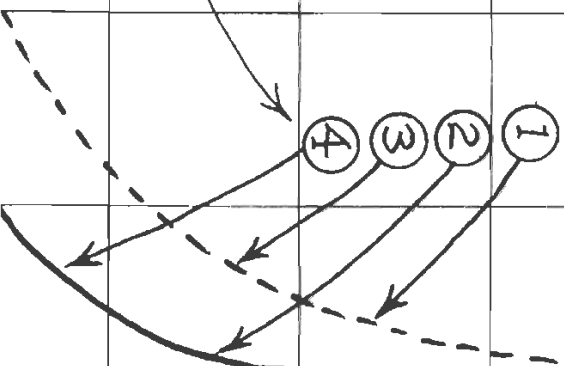
LEFT FLAP

Make ONE LEFT: ONE RIGHT

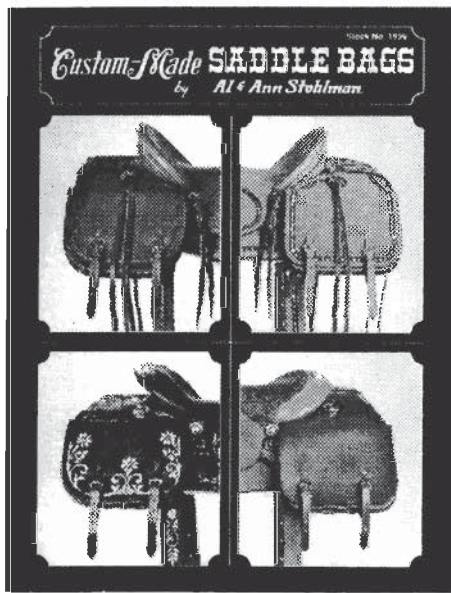
Cut from firm 7/8oz. cowhide



1
2
3
4

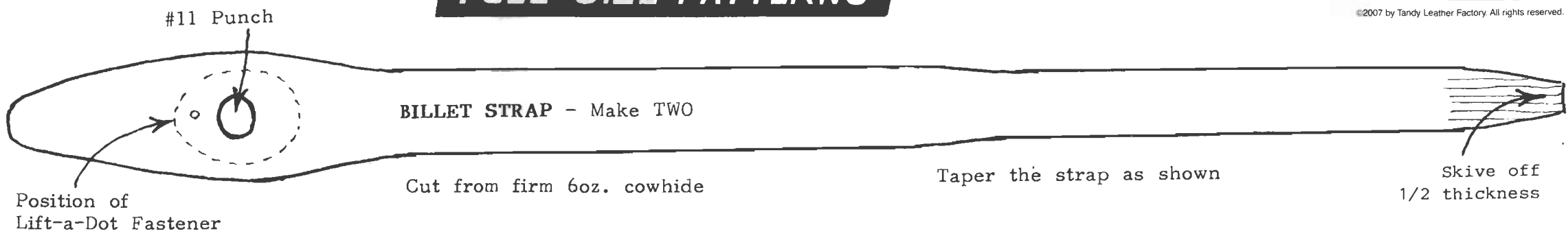


explanation of circled numbers

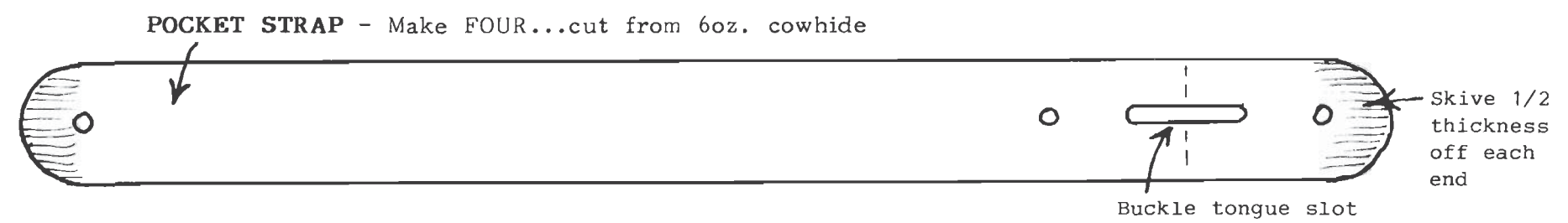
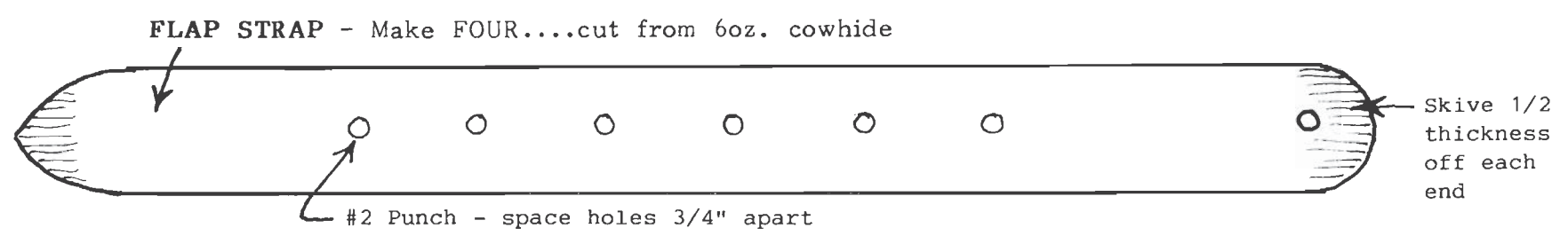
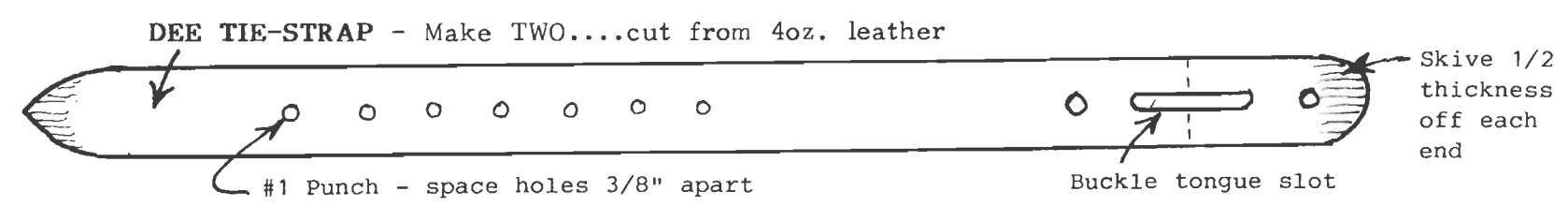
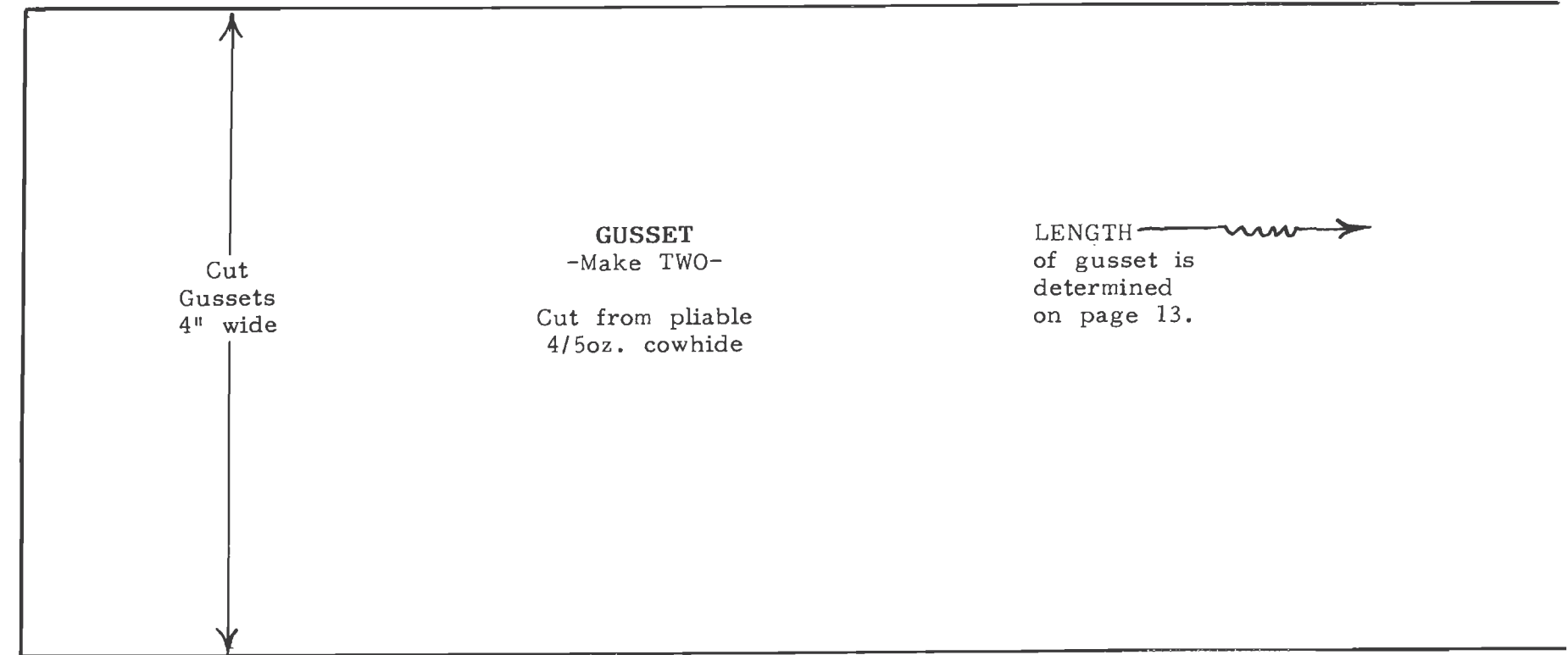
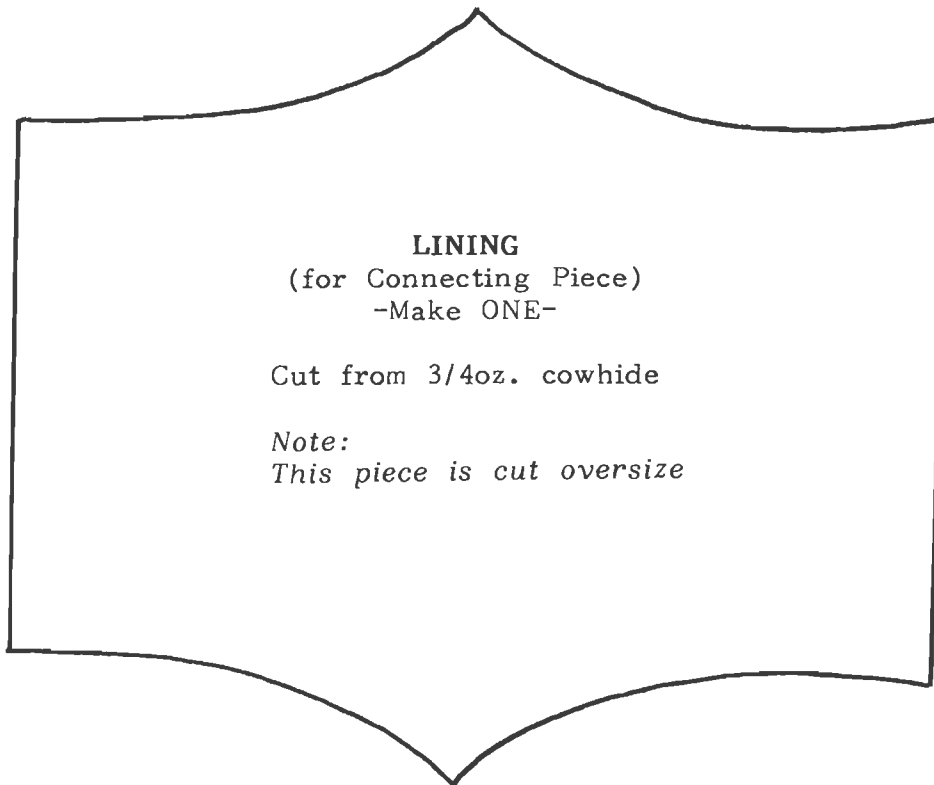
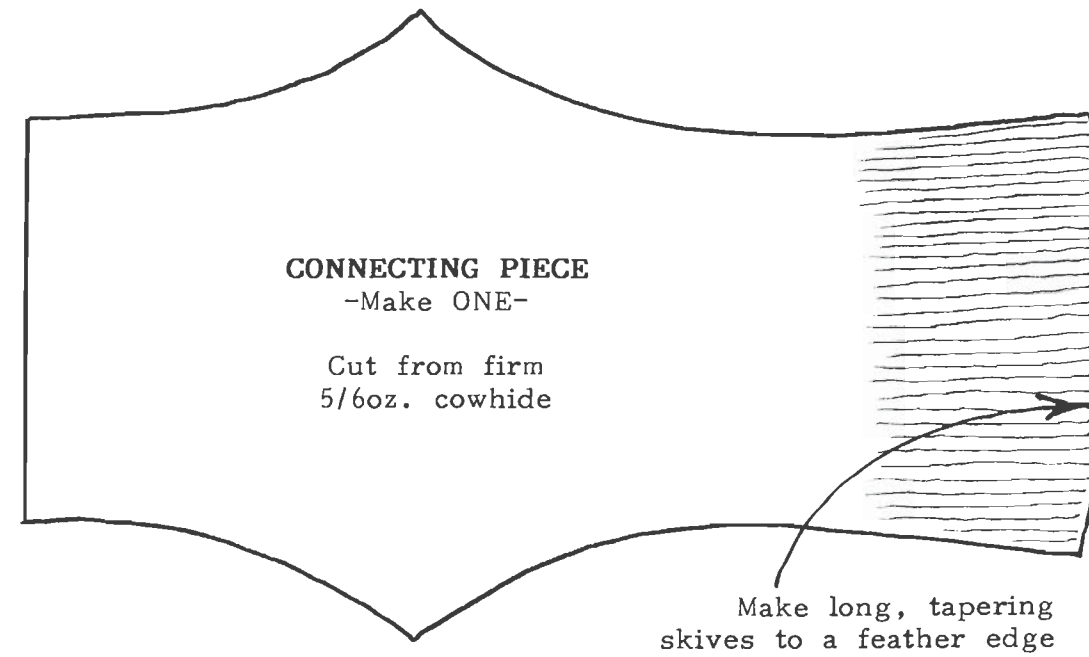


Custom-Made SADDLE BAGS by Al & Ann Stohlman

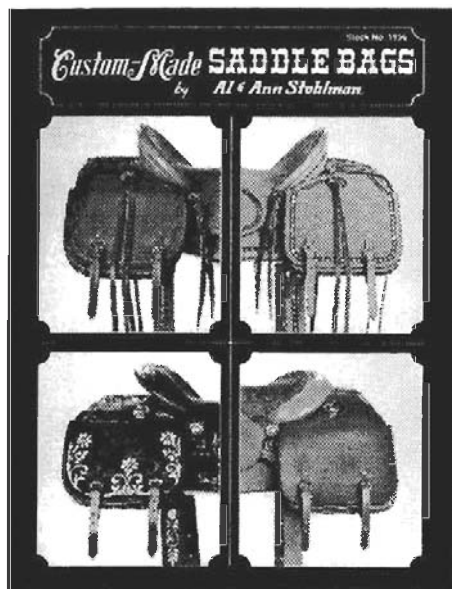
This book contains all necessary information for making and assembling the saddle bags. Be sure you read all of the pages & understand them, before beginning to make your bags.



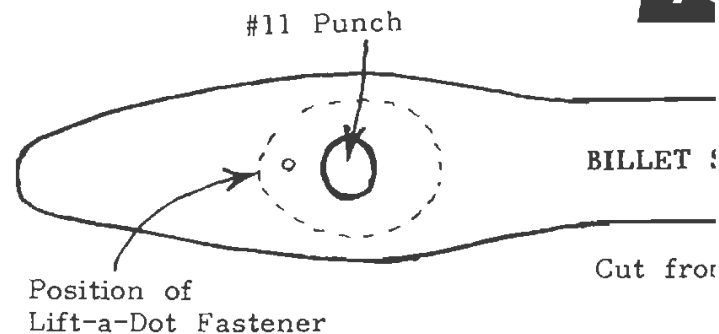
Note:
see our book:
LEATHERCRAFT TOOLS
for instructions on
installing all types
of Fasteners.



Note: All straps should be Edged & Burnished before assembly.



This book contains all necessary information for making and assembling the saddle bags. Be sure you read all of the pages & understand them, before beginning to make your bags.

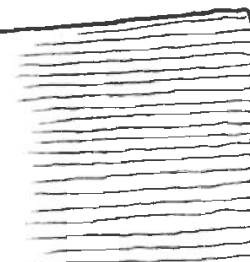


Note:
see our book:
LEATHERCRAFT TOOLS
for instructions on
installing all types
of Fasteners.

BAGS
ian

CONNECTING PIECE
-Make ONE-

Cut from firm



FULL SIZE PATTERNS



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STRAP - Make TWO

in firm 6oz. cowhide

Taper the strap as shown

Skive off
1/2 thickness

Cut
Gussets
4" wide

GUSSET
-Make TWO-

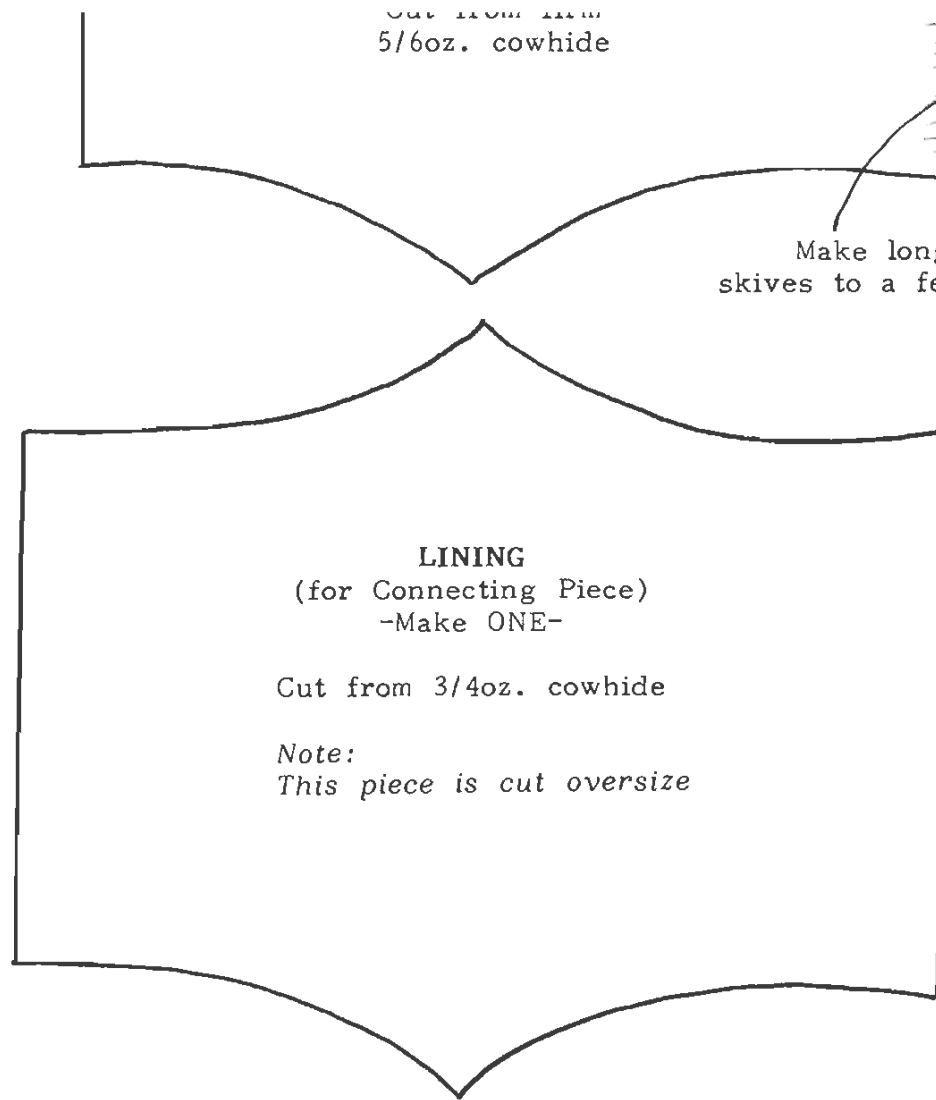
Cut from pliable
4/5oz. cowhide

LENGTH →
of gusset is
determined
on page 13.

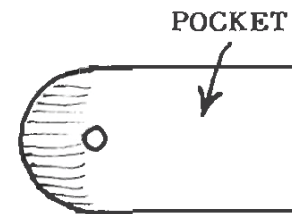
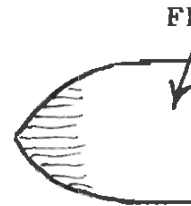
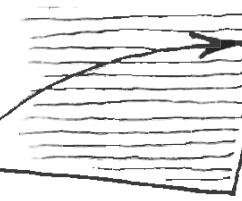
Custom Saddle

by AL & Ann Stohlm

Cut from 1 1/2 oz.
5/6oz. cowhide

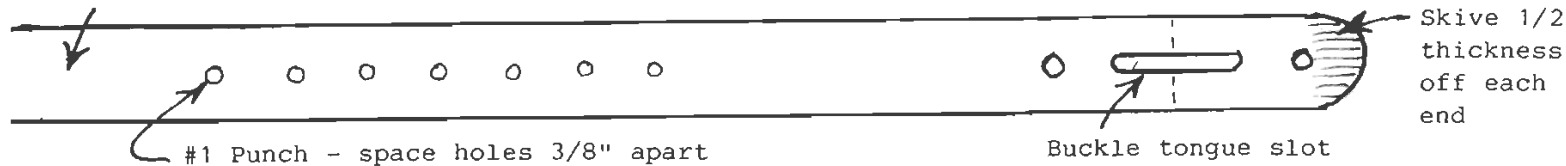


Make long, tapering
skives to a feather edge

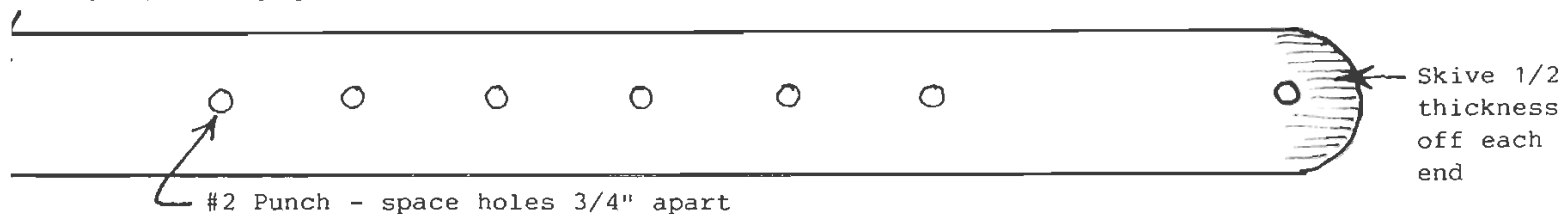


Note: All s

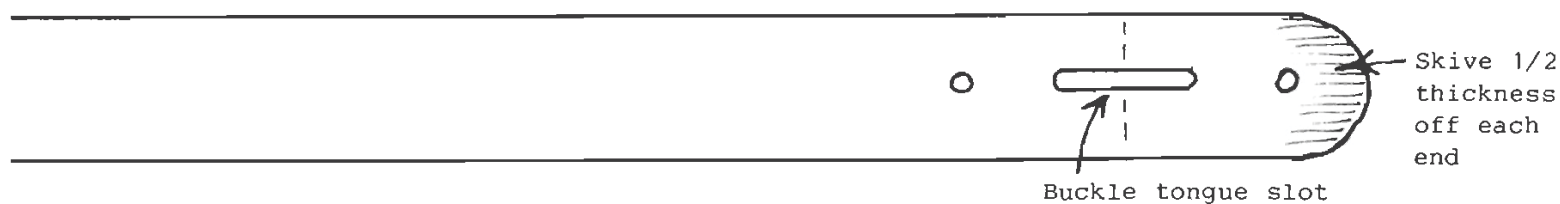
DEE TIE-STRAP - Make TWO....cut from 4oz. leather



LAP STRAP - Make FOUR....cut from 6oz. cowhide



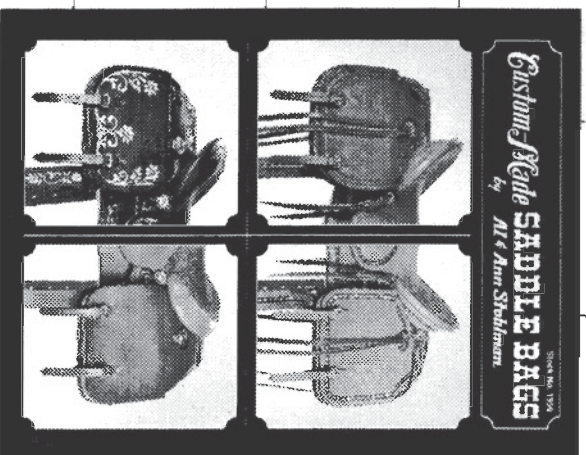
STRAP - Make FOUR...cut from 6oz. cowhide



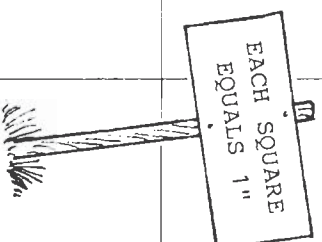
straps should be Edged & Burnished before assembly.

Custom Made SADDLE BAGS

by **Al & Ann Stohlman**



This book contains all necessary information for making and assembling the saddle bags. Be sure you read all of the pages & understand them, before beginning to make your bags.



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LEFT SIDE PIECE

Make ONE LEFT: ONE RIGHT

Cut from firm 7/8oz. cowhide

The edge of the Flap fits on this line. See step 2 on page 28.

A Clearly draw this line on your paper pattern.

FULL SIZE PATTERN

Approximate position of 1/2" slot for the Dee Tie-Strap. See page 31 of the instruction book shown above.

Note: The numbered circles indicate lines to cut for:
(1) Saddle Bag No.1 - (2) Saddle Bag No.2 - (3) Saddle Bag No.3 - (4) Saddle Bag No.4.
Cut on these same lines for the FLAPS and the POCKETS.

Rivet hole

3/4" slots for Pocket Straps

Position of Lift-a-Dot Post. Review page 24.

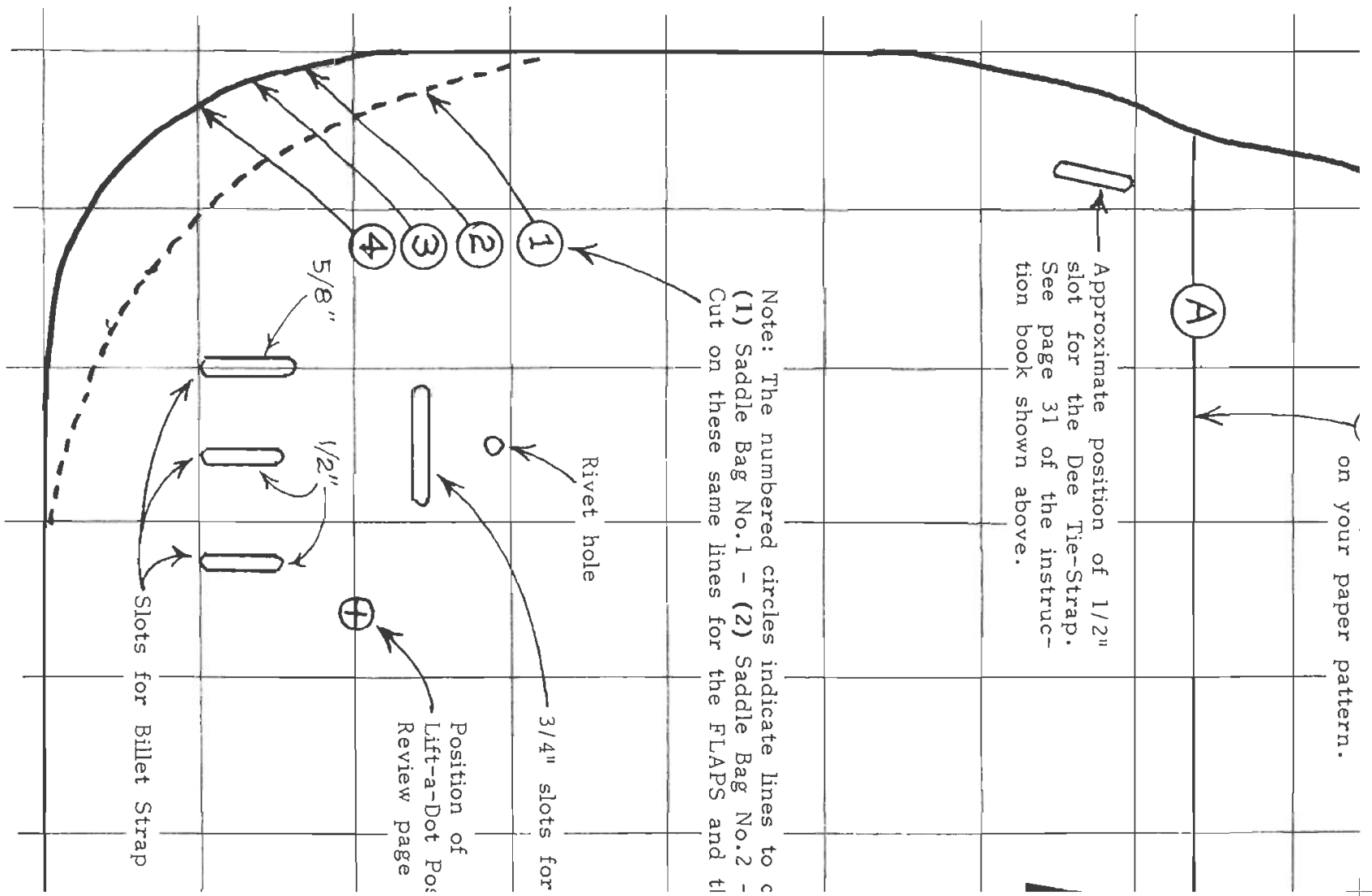
5/8"

1/2"

Slots for Billet Strap

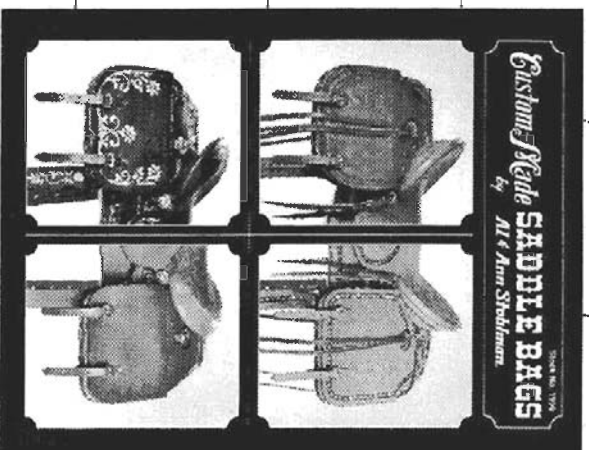
on your paper pattern.

→ Approximate position of 1/2" slot for the Dee Tie-Strap. See page 31 of the instruction book shown above.



Custom Made

by



This book contains all necessary information for making and assembling the saddle bags. Be sure you read all of the pages & understand them, before beginning to make your bags.

LET

Ca

(A) Clearly draw this line



A

FULL SIZE PATTERN

cut for:

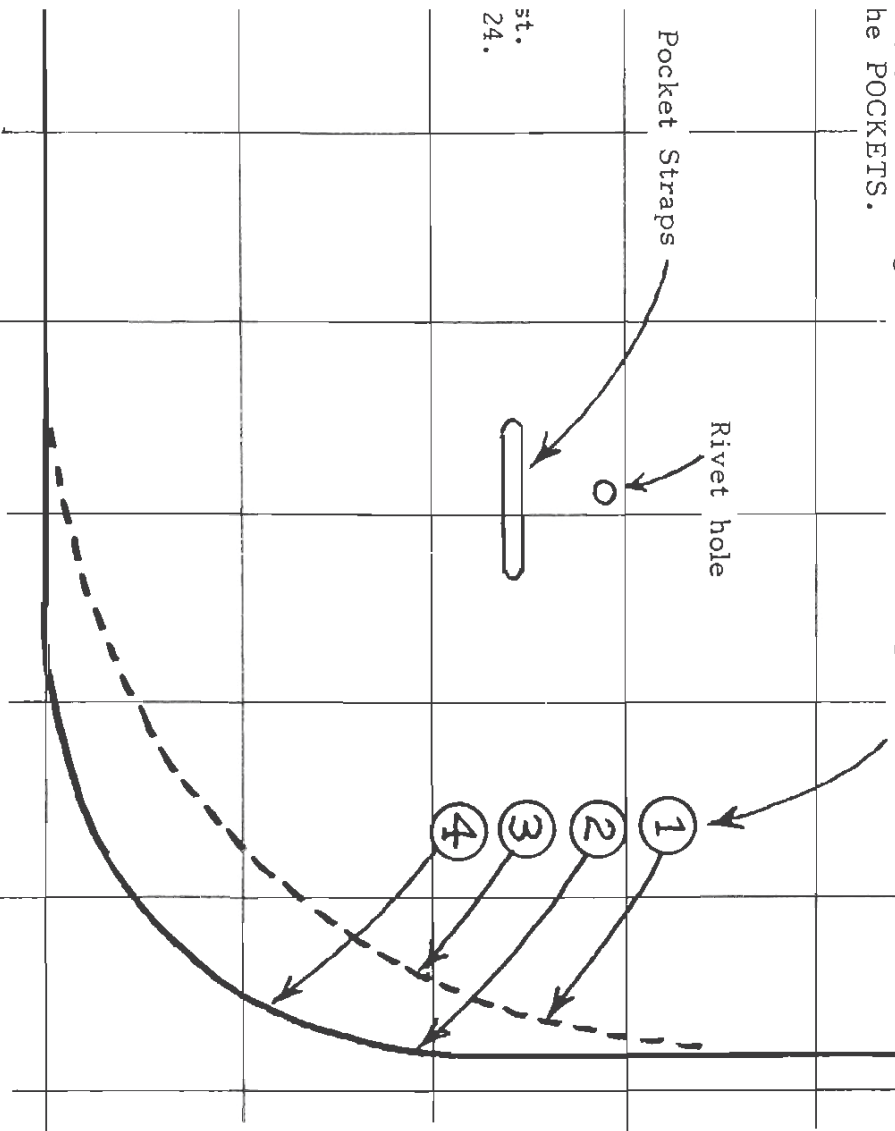
- (3) Saddle Bag No.3 - (4) Saddle Bag No.4.
the POCKETS.

Pocket Straps

Rivet hole



st.
24.



HAIRBAGS

AL & Ann Stohlman



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EACH SQUARE
EQUALS 1"



T SIDE PIECE

Make ONE LEFT: ONE RIGHT

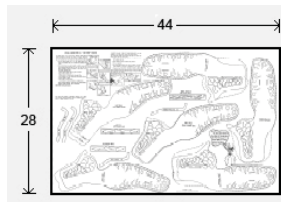
1" from firm 7/8oz. cowhide

✓ The edge of the Flap fits
the 1" seam



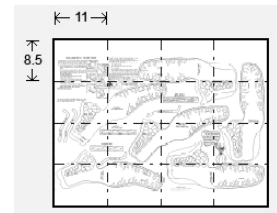
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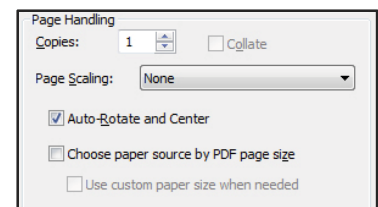
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