SAGE CREEK STOCK SADDLE CO.

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™

ORDER OF FITTING AND CONSTRUCTING THE SADDLE
IN-SKIRT AND HUBBARD RIGGINGS

GROUNDWORK AND FITTING

* **Cut** all parts.

* **Skive stirrup leather riser blanks.**

* **Cut stirrup leather plugs** out of stirrup leather riser blanks.

* Place **stirrup leather plugs** against the front edge of the slot on the underside of the tree, aligned with lower edge of bars. These are held in place with two 3/4" nails near lower edge of the tree bars

* Install the **front stirrup leather slot risers** to make front edge of stirrup leather slots.

* Install the **rear stirrup leather slot risers** to make rear edge of stirrup leather slots.

* Skive and install **gullet cover**. If it is to be stamped do so now after fitting and trimming.

* **Line seat tin**.

* Install **strainer** and first **ground seat** pieces.

* Install the **top ground seat** piece, wet with the grain side up.

* **Carve ground seat** to final shape.

* Cut out **hand hole**.

* **Bind** front edge of **hand hole**.

* Cover **horn**.

* Fit **cantle cover**.

* Fit and assemble **fork cover**. It will be installed later, after rigging.

* **Stitch skirts** together at back with heavy waxed thread.

* Fit **skirts** to tree, **block to bars**, **mark for trimming** and let them dry in place.

* Locate **rigging location** front and back on near side skirt.

* **Trim skirts** and re-attach to tree.
* Fit the **rigging to the skirt** and trim where necessary. **For Hubbard skirts**, fit up tops starting at the cantle back first, forks second, stirrup leather slots third, then the front and rear rigging plates.
* **Trace** outline of **skirts** onto underside of tops.
* Fit **rear housings**. Omit this step if the skirts are to be Hubbard style.
* **Fit seat**.
* If through saddle strings are to be used, **drill holes** now. Also locate holes for skirt lugs if fitting *standard* in skirt rigging.
* If saddle is to be stamped, **tool** the fork, cantle back, tops, rigging panels, flank cinch, flank billets, fenders, and seat.

Preliminary Assembly

* **Install cantle cover now for Hubbard skirts**.
* For Hubbard or other in-skirt types of rigging, **assemble skirts to rigging** panels, including hardware (rigging rings, plates, breast strap dees, etc.). Where possible rigging panels should be lined to skirts and stitched before the hardware is installed and riveted into place, leaving openings in the stitching for hardware to slip in. **Edge and polish leather** before installing hardware. Some stitching will likely need to be done after hardware is in place.
* Install **saddle strings**, and if **skirt lugs** are to be used to hold skirts to bars around the edges they are installed now.
* **Line skirts**.
* **Lace skirts** together at back.
* **Lace Hubbard jockeys** together.
* **Install rigging and skirts**. **Fasten rigging** with four screws. Fastening of skirts, under cantle, in gullet, at the hand hole, and in front will follow.
* For *standard* **in skirt rigging install cantle cover** now.
* **Install and stamp fork cover**.
* Install the seat and **bind the cantle.**
* **Install rear housings** when used.

* Assemble **stirrup leathers, and fenders**.
* Assemble **flank cinch buckles & lining**.
* Assemble **flank billets& linings**.
* **Stitch** stirrup leathers & fenders, flank cinch, billets.
* **Install billet keepers** on flank cinch, & stitch.
* **Install and rivet stirrup leather buckles.**
* **Twist** and wrap stirrup leathers.
* Make **connector, and hobble straps**.
* **Cover Stirrups**.
* **Oil** all parts.

Final Assembly

* Install **stirrup leathers** and fenders.
* Pull up **skirts at the hand hole** with pincers and fasten with one screw on each side.
* Run **strings** through seat, and screw seat to forks at sides of swells.
* Install **latigo minders, conchos, etc.**
* Install **flank billets**.
* **Finish** fastening **skirts** under cantle, in gullet, and in front.
* Tie **bleeder knots**.
* **Install stirrups**.
* **Set stirrup leathers**.
* **Install rope strap**

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* The fork can be covered and stamped before the skirts and rigging is installed. However the rigging will not be able to be tucked under the fork cover.