



# ORDER OF FITTING AND CONSTRUCTING THE SADDLE IN-SKIRT 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** On top of the bars with front edges aligned with the front edge of the slot on the underside of the tree, and 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 back**.
- \* **Remove cantle cover, and stamp it** if called for. Use trimmed top edge to locate top border line using dividers. Take care to locate border line the same distance below the planned for cantle binding edge which is found 1/4"+- below the stitch line which will be slightly above the cantle rim line, roughly 1/4". The cantle

binding line will be tickled in later when the seat is installed. It should be at the cantle rim or just slightly below it.

- \* Install **cantle back, and Cheyenne roll** underside if applicable.
- \* Fit assemble and install **fork cover**.
- \* Fit up **skirt top/rigging panels** to tree. Locate **rigging hardware** and mark location.
- \* Remove **skirt top/rigging panels** and trim to final shape, including any trimming for rigging hardware. Reattach **skirt top/rigging panels** to mark out the outline of the rigging tab recesses behind the stirrup leather slots in the ground seat. Mark the outline by cutting it in tightly with either a sharp pointed straight knife or a round knife
- \* Stamp the **skirt top/rigging panels** and while the tops are off carve out the inlay recess for the rigging tabs in the area behind the stirrup leather tunnels in the ground seat.
- \* Refasten **skirt top/rigging panels** to tree. Temporarily glue the rigging tabs in place in their recesses, and finish carving the tabs and ground seat to be flush and blended into the ground seat all around.
- \* Slide near side oversized skirt under tree to position such that extra leather shows all around **skirt top/rigging panels**, and there is plenty of material for skirt back around rear tree bars. Do the same for the off side, and carefully locate center line for skirt join in rear. Be sure there is extra material here, as the center line will be established after skirts are blocked to the bars.
- \* Fasten **skirts** to tree with one nail in each of the front and rear pads of the tree bars. With skirt top/rigging removed **Block skirts to bars** nailing as you go.
- \* Re-attach **skirt top/rigging panels** and leave all to dry.
- \* If top-side **skirt stiffener plugs** are preferred for the rear portion of the skirts around the tree bars, proceed to find their shapes by fitting a piece of leather for each of these under the rear of each rigging which is large enough to completely cover the rear portion of each skirt from the rear end of the rigging leather behind the flank billet attachment, around the skirt edge to the center of the cantle back.

- \* Scribe off the **front line of the stiffeners** from the rear edge of the rigging panels and the tree bars. Skive on the under side of stiffeners from previously scribed line and feathering to edges. This skived section will dive under the rigging over the bars behind the cantle.
- \* Stamp the **stiffener plugs**.
- \* Glue the **stiffener plugs** in place along with the in **skirt top/rigging panels, with the stiffeners butted up** tightly to the rigging panels where they meet along the lower skirt edge.
- \* Fit **rear housings** to cantle back.
- \* Fit **seat**.
- \* If through saddle strings are to be used, **drill holes** now. Otherwise locate the holes for the strings to pass through all top pieces.
- \* **Install fork cover**.
- \* If saddle is to be stamped, **tool** the fork, flank cinch, flank billets, fenders, and seat.

## Preliminary Assembly

- \* **Trim skirts.**
- \* Stitch **skirts to rigging** panels, install hardware (rigging rings, plates, breast strap D's, etc.). *Where possible rigging panels should be stitched to the skirts 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 (if through tree option is used)**, 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.
- \* If strings are to be simply screwed to tree, run them through holes in skirt top/rigging panels now.

*Note: The next two steps may be reversed. But the binding lays down on the rigging top at the cantle corners easier if done in this order.*

- \* **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 later.
- \* Install the seat and **bind the cantle.**
- \* **Finish fitting rear housings** around skirt edges.
- \* Trim and stamp **rear housings.**
- \* **Install rear housings.**
- \* 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.
- \* If **strings** are simply **screwed** to tree do so now.
- \* 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.**
- \* **Wrap horn**
- \* **Install rope strap**