



# ORDER OF FITTING AND CONSTRUCTING THE SADDLE

## DROP-PLATE RIGGING

### 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.
- \* Cover underside of **strainer plate** and install on tree.
- \* **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, blending at stirrup slots.
- \* Cut out **hand hole**.
- \* **Bind** front edge of **hand hole**.
- \* Cover **horn**.
- \* Fit **fork cover**.
- \* Fit the **cantle back cover** and mark line around cantle rim. With dividers set to 1/2" over size strike the cut off, or trimming, line for the cover, up from the cantle rim onto the tree side of the cantle back cover.
- \* **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.

- \* Fit **riggings** by fitting near side to tree, and using as pattern for off side.
- \* **Trim skirts** and re-attach to tree.
- \* Fit **rear jockeys to cantle back only** with cantle back covering in place.
- \* **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.

*Note: Stamping may be delayed till later and done with the bulk of the stamping as described below.*

- \* With rear jockeys in place over cut down false cantle cover which does not cover above the cantle rim, **fit seat**.
- \* **Re-place cantle cover and jockeys.**
- \* Locate **holes for saddle strings, and drill.**
- \* **Mark holes** in skirts for **lugs along rear edge of tree bars.**
- \* If rigging is to be stamped, **stamp now.**
- \* **Line and stitch** drop plate **riggings** now. Where possible rigging panels should be lined and stitched before the hardware is installed and riveted into place, leaving openings in the stitching for hardware to slip in. **Trim and polish edges** before installing hardware. Some stitching will likely need to be done after hardware is in place.
- \* **Install riggings.**
- \* Assemble, and **install fork cover.**
- \* If saddle is to be **stamped, tool** the forks, cantle cover, seat, skirts, flank cinch, flank billets, and fenders now.
- \* **For Cheyenne roll**, carve or **stamp cantle cover** after fitting up to cantle, but before forming the roll. See "Constructing the Cheyenne Roll"

## **Remaining Fitting and Preliminary Assembly**

- \* Fit skirts with **skirt filler plugs**. Glue plugs in. Trim and polish edges.
- \* Install **saddle strings**, and **skirt lugs**.
- \* **Line skirts**.
- \* 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, wrap and stretch stirrup leathers.
- \* **Cover Stirrups**.
- \* Make **connector, and hobble straps**.
- \* **Lace skirts** together with latigo lace.

### **Final Assembly**

- \* **Install seat** with glue in the dish only.
- \* **Bind the cantle**.
- \* **Oil** all parts.
- \* **Install skirts** now with the saddle strings and skirt lugs.
- \* **Position rear jockeys** in place over skirts and scribe outside edges using skirts as a guide. **Remove and trim then stamp**.
- \* **Lace rear jockeys** together.
- \* **Install rear jockeys**.
- \* Install **stirrup leathers** and fenders.
- \* **Glue** the rest of the **seat down**.
- \* Run **strings** through seat, and **screw seat to forks** at sides of swells.
- \* Install **latigo minders, conchos, etc**.
- \* **Install stirrups**.
- \* Install **flank billets**.
- \* Tie **bleeder knots**.
- \* **Finish** fastening **skirts** at underside of cantle, in front and in the hand hole.