

**TM 10-430**

**Technical Manual The Saddler**

**March 27, 1942**

14. Modifying McClellan saddles.-a. *General.*-(1) *Parts to be removed.*

Straps, quarter side.

Safes, quarter strap, with cincha tie straps.

Cinchas.

Halter squares from ends of quarter straps, both pommel and cantle.

(2) *Parts needed for one saddle.*

1 pair skirts.

1 girth.

1 piece of web, right, with leather billets attached.

1 piece of web, left, with leather billets attached.

4 screws, 7/8-inch, No. 6 wood, round head, brass, bronze finish.

4 nails, saddle, with 1/2 inch bronze heads.

4 filler pieces (leather).

2 pieces 1/4-inch woven felt cut to fit side bars according to size of saddle (to be ordered, 11, 11 1/2, or 12, according to size of saddle).

4 No. 8 burs, brass; bronze, finish.

If felt linings are needed to replace the worn sheepskin with wool, the number of saddles of each size should be given.

*b. Method.*-(1) Remove halter squares from end of quarter straps, both pommel and cantle, by cutting stitching in laps, then cut off ends of straps even with the bottom edge of side bar.

(2) Rip stitching the full length of lower part of side bar and continue around each end for approximately 3 inches.

(3) Use a stitching awl for removing the stitches from the parts cut open.

(4) Turn saddle bottom side up, fold cover of side bar bottom toward center of saddle, and secure it there temporarily by placing three large tacks through leather of cacti side into tree.

(5) Take web with leather billets attached (right and left web can be determined by the diagonal cut), place same on bottom of side bar, and locate them, leather billets upward or toward the saddle scat, with the center billet directly over the stirrup strap loop, and with the diagonal edge of web flush with top edge of side bar.

(6) Secure web to tree by using numerous long, large-headed tacks.

(7) Take the filler pieces and place one on each side of web; having the beveled edge pointing away from web.

(8) Secure with several small tacks.

(9) Place skirt, grain side out, with the beveled edge on top of side bar, in such position that girth billets will be under skirt when saddle is in use.

(10) Secure to the tree with enough tacks to keep same in place until stitching

is completed.

(11) Return side bar cover to its original position, thus having the skirt and web between the top and bottom cover of side bar.

(12) Tack temporarily all three pieces together.

(13) Sew with 3-cord No. 10, wax end, using care to stitch in the old holes.

(14) After stitching is completed, secure the ends of straps, quarter, pommel and cantle, with a 7/8-inch No. 6 round wood screw, using a bur under the head.

(15) place a saddle nail at lower extreme ends of both cantle and pommel cover where these parts join side bar cover.

(16) Should it be desired to cover under part of side bars with felt, place the proper size felt on bars, using a good grade of glue, and place several tacks through felt into tree temporarily, after stretching felt tight in all directions.

(17) The same stitching that secures skirt and web will also secure felt to that part of saddle which has been cut open; the balance of sewing being done with one needle, with stitches approximately 1/4-inch long.

(18) Great care should be taken to remove all tacks from felt after saddle is completed.

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By ORDER OF THE SECRETARY OF WAR:

G. C. MARSHALL,

*Chief of Staff.*