

Stack

Horsemanship & Packing Clinic

Working Safely with Horses & Mules

USDA Forest Service
Region One
Ninemile Ranger Station
Lolo National Forest
1985

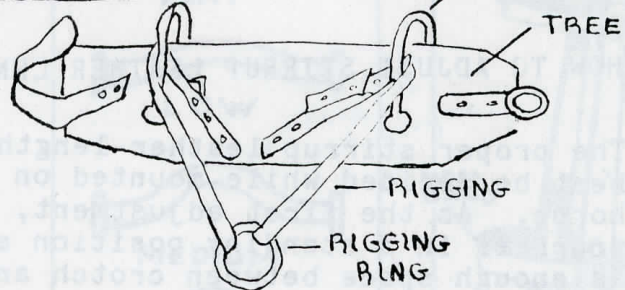
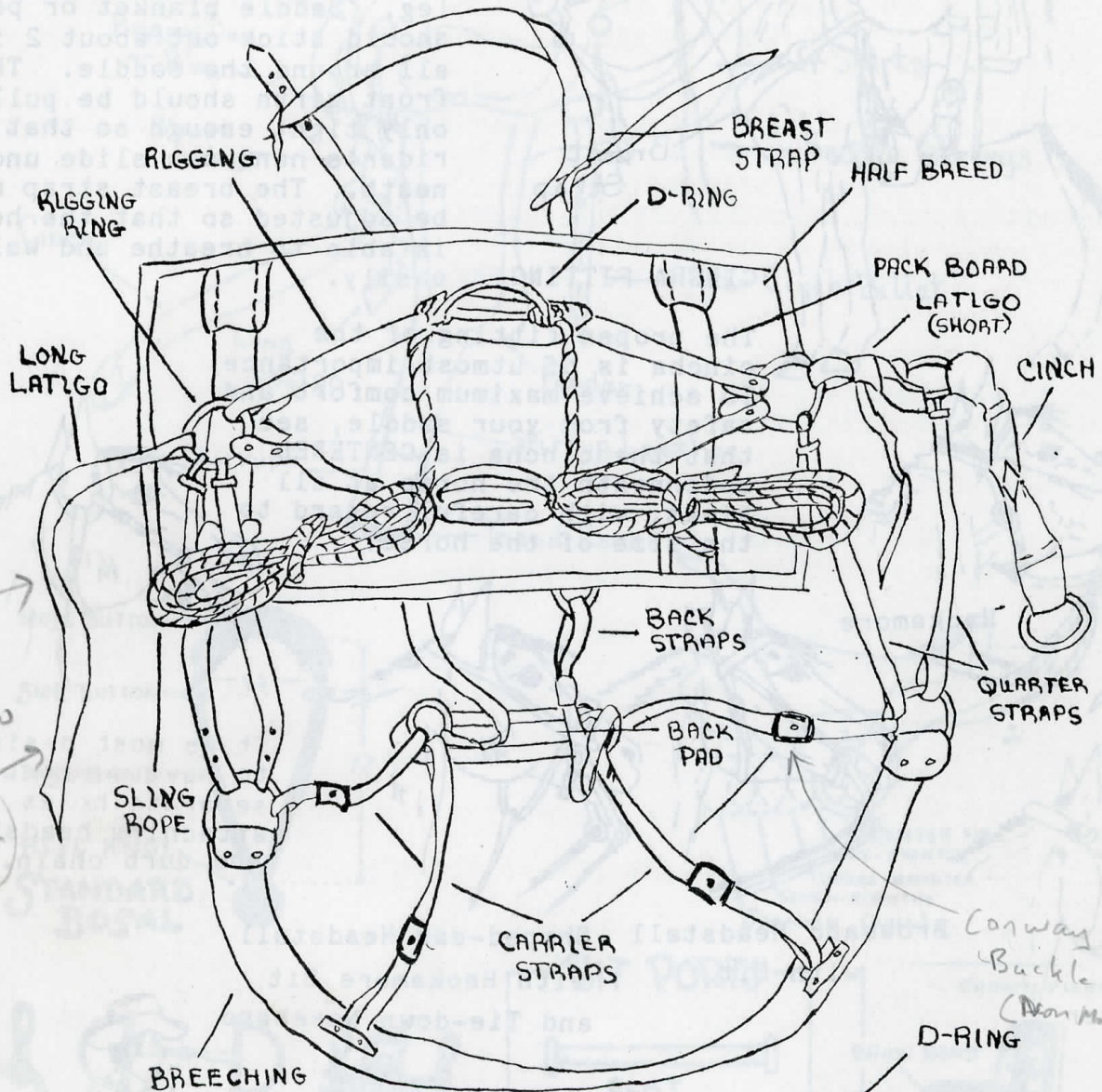


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DECKER PACK SADDLE



Adjustable Rigging

U.S. DEPARTMENT OF AGRICULTURE-FOREST SERVICE

SPECIFICATION NO. MSF-307

DECKER PACK SADDLE

Revised March 1937

General Information:

A substantial type of pack saddle suitable for use on either horses or mules, and for exceptionally heavy duty.

DETAILED SPECIFICATIONS

TREE --

Material - The saddle bars shall be constructed of well-seasoned cottonwood, free from knots, checks, and other defects. The iron forks shall be forged from mild steel.

Dimensions - Shall be as shown on detailed drawing attached hereto and made a part of this specification.

Workmanship - The saddle bars may be rough-shaped with a bandsaw, but due to their curved and peculiar shape, handwork is necessary when finishing them. The iron forks shall be hand forged to the shape shown on the drawing and securely riveted to the bars. A soft iron 7/16-inch carriage rivet having a 1-inch or larger head shall be used. The rivet head shall be countersunk in the saddle bars approximately 3/8 of an inch below the surface of the tree. The countersunk holes shall then be filled over the heads of the rivets with a plastic wood filler. The saddle bars shall then be dressed smooth and treated with two coats of spar varnish or boiled linseed oil to prevent checking.

RIGGING -

Material - The rigging consists of all the strap work with the exception of the latigos and shall be constructed from No. 1 grade black harness leather, conforming to Federal Specification No. KK-L-171, heavy, 14/64 of an inch thick, Class II backs. Heavy black japanned harness hardware shall be used. Thread used shall be not less than No. 6 Irish flax harness thread.

Dimensions - All rigging dimensions shall be as shown on detailed drawing.

Workmanship - All points of fastening shall be hand-riveted using No. 9 copper harness rivets and all rivet heads which may come in contact with the animal shall be smooth and well set into the leather. The hip pad assembly, Parts Nos. 10, 12, and 13 shall be either hand or machine stitched with heavy waxed harness thread approximately seven stitches to the inch and shall also be reinforced with No. 9 copper rivets.

The breast collar billets, Part No. 2, shall also be sewed and riveted in the same manner as the hip pad assembly. The ring, No. 16, is sewed and riveted in the billet on the off side of the breast collar while on the near side the snap, No. 15, is in the billet. The billets, No. 11, are made from No. 1 grade latigo leather reinforced with a piece of harness leather. It is important that latigo leather be used at these points to prevent the dee rings from chafing through. The latigo leather billet and reinforcing piece are riveted together and the whole is securely fastened to the saddle bar with not less than four No. 9 round head, blued, wood screws. The length of the screws should be such that they do not quite penetrate through the thickness of the saddle bars. The piece of reinforcing leather should be large enough to permit spacing the screws far enough apart so that they will not split the wood of the saddle bars.

Billets No. 6 are shaped from harness leather in the manner shown in drawing. The buckles, No. 20, are fastened to the billets with two No. 9 copper rivets. The assembly is secured to the saddle bar with two No. 9 round head, blued, wood screws.

All rigging shall be edged and blacked in workmanlike manner.

LATIGOS -

Material - Shall be made from No. 1 grade latigo leather, 3/32 of an inch in thickness.

Dimensions - 1 3/4 inches wide by 5 feet long and taped to 7/16 of an inch at outer end.

CINCH -

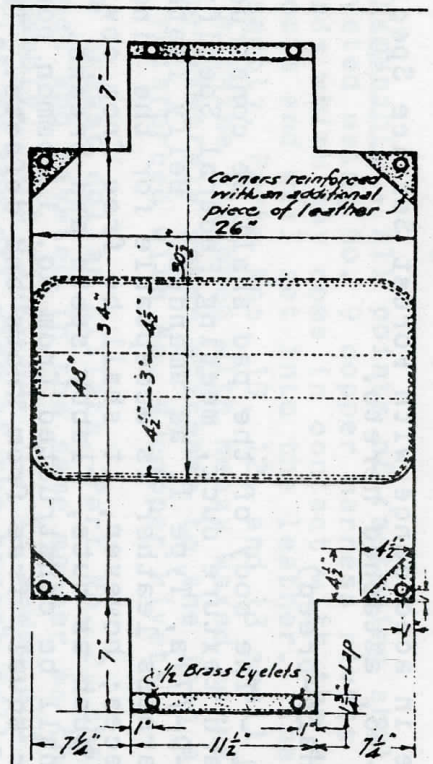
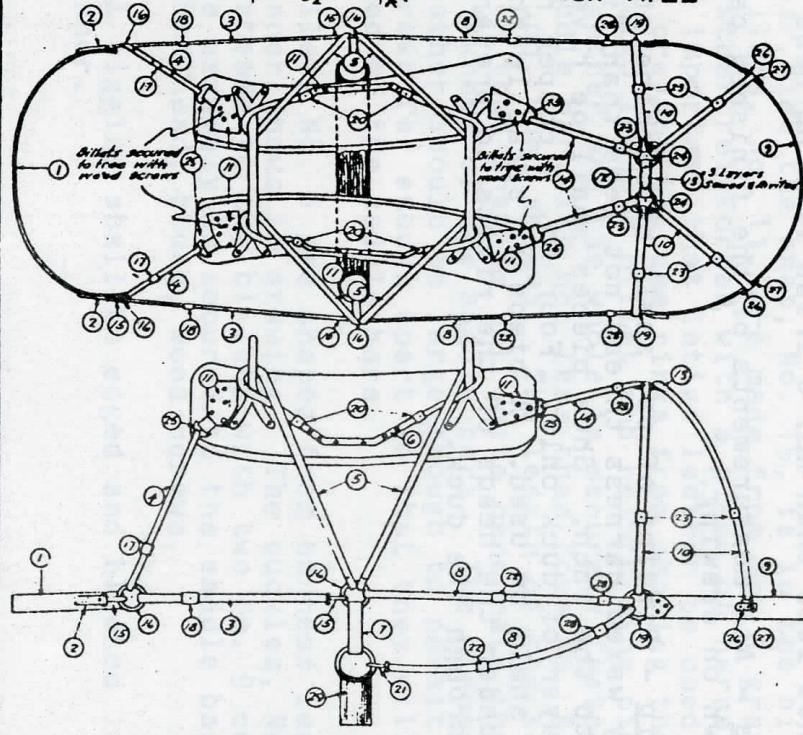
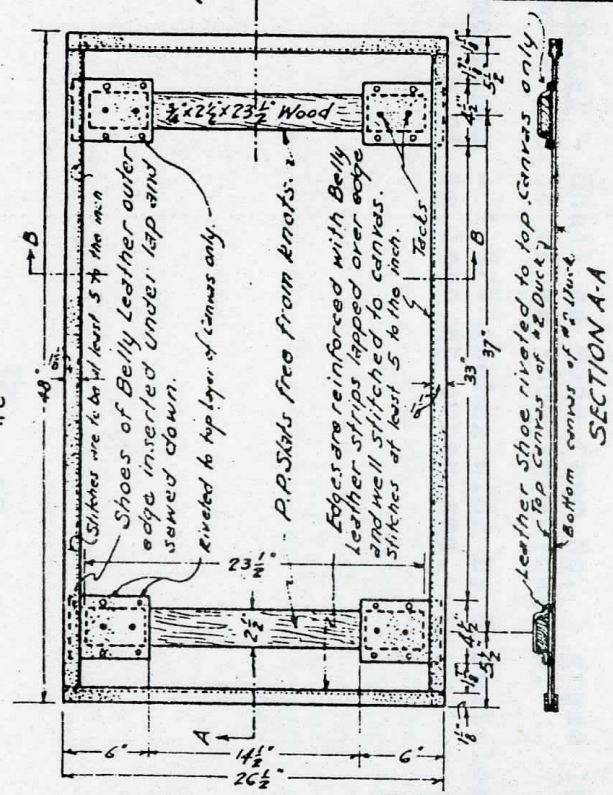
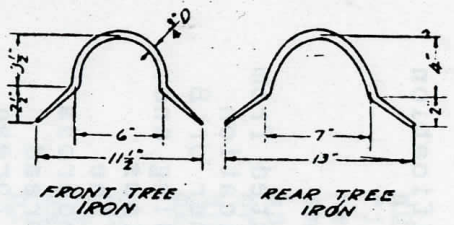
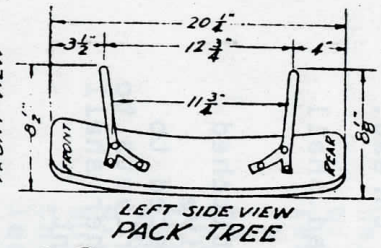
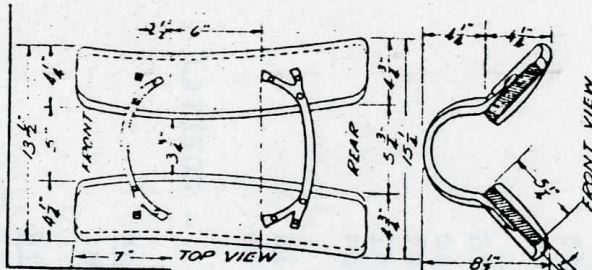
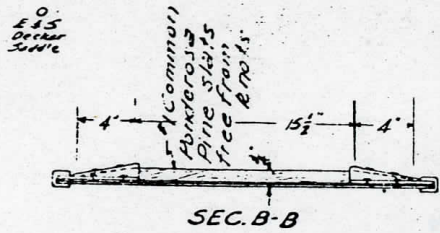
Shall be in accordance with Forest Service Specification No. MSF-98, attached hereto.

APARAJO PAD - (Half-breed)

Material - The body of the pad shall be constructed from No. 2 hard texture duck, meeting Federal Specification No. CCC-D-771a, Type I, as amended. Belly leather or B grade harness leather is acceptable for the binding and shoe pieces; however, it shall be free from obvious defects such as cuts, flabby spots and breaks. The slats shall be constructed from No. 1 common ponderosa pine, or equal, free from knots and defects. Thread shall be not less than No. 6 Irish flax harness thread.

Dimensions - All measurements of the finished pad shall be as shown on drawing.

Workmanship - Binding of pad shall be machine stitched with heavy waxed harness thread not less than five stitches to the inch. Shoe pieces shall be riveted to the top layer of duck only. Four No. 9 copper rivets to each shoe shall be used. A piece of scrap leather shall be sewed under the heads of the rivets to prevent pulling through the duck.



APARAJO PAD
Scale $\frac{1}{8}$ " = 1"

- ① Breast Collar $2\frac{1}{2} \times 31$ "
- ② Billet Strap $1\frac{1}{2} \times 10$ "
- ③ Front Quarter Strap $1\frac{1}{2} \times 31$ "
- ④ Breast Strap $1\frac{1}{2} \times 26$ "
- ⑤ Latigo Ring Billet $1\frac{1}{2} \times 27$ "
- ⑥ Billet Strap $1\frac{1}{2} \times 16$ "
- ⑦ Latigo Strap
- ⑧ Rear Quarter Strap 1×63 "
- ⑨ Breeching 3×22 "
- ⑩ Hip Straps 1×30 "
- ⑪ Billet Strap
- ⑫ Hip Pad $3\frac{1}{2} \times 9\frac{1}{2}$ "
- ⑬ Billet Strap $1\frac{1}{2} \times 14$ "
- ⑭ Lazy Strap 1×30 "
- ⑮ $1\frac{1}{2}$ " Snap
- ⑯ 3" Ring
- ⑰ $1\frac{1}{2}$ " Conway Buckle
- ⑱ $1\frac{1}{2}$ " Conway Buckle
- ⑲ 3" Dee Ring
- ⑳ $1\frac{1}{2}$ " Plain Harness Buckle
- ㉑ 1" Snap
- ㉒ Leather Keeper
- ㉓ 1" Conway Buckles
- ㉔ 2" Ring
- ㉕ $1\frac{1}{2}$ " Dee Ring
- ㉖ Billet $1\frac{1}{2} \times 4$ "
- ㉗ $1\frac{1}{2}$ " Layer Loop
- ㉘ 1" Loop and Roller Buckles
- ㉙ Girth

U.S. DEPARTMENT OF AGRICULTURE
FOREST SERVICE
Specification No. MSF-307
Written specifications to accompany
DECKER PACKSADDLE
Designed: 1920 Revised: 3/10/37